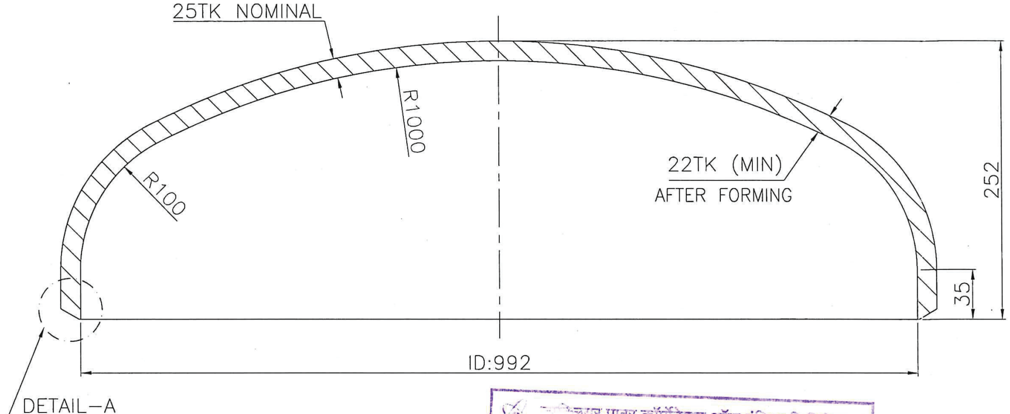
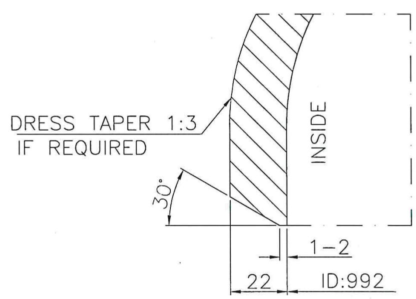
FIRST ANGLE PROJECTION

ALL DIMENSIONS ARE IN mm

DRG. NO. 2-16503-40497





EDGE PREP. DETAIL

DETAIL-A

TECHNICAL REQUIREMENTS (TR) :-

1. SHAPE OF DISHED END : TORISPHERICAL
2. DISHED ENDS SHALL BE MANUFACTURED AS PER ND-4200 OF ASME SECTION-III ND AND NPCIL APPROVED TECHNICAL SPECIFICATION NO : BHEL/NPCIL/30599/CS DISHED ENDS/CDE-19-3425.
3. FORMING PROCEDURE QUALIFICATION TEST TO BE CONDUCTED ON TEST COUPONS AS PER CLAUSE NO-8 OF SPECIFICATION NO : BHEL/NPCIL/30599/CS DISHED ENDS/CDE-19-3425.
4. PLATE MATERIAL TO BE USED FOR FORMING SHALL BE IN NORMALISED CONDITION & ULTRASONICALLY EXAMINED AS PER SA 578 LEVEL-B.
5. AFTER FORMING COMPLETE DISH END (INSIDE & OUTSIDE) INCLUDING KNUCKLE PORTION & EDGE PREPARED ENDS SHALL BE CHECKED BY LIQUID PENETRATION EXAMINATION AS PER SPECIFICATION NO : BHEL/NPCIL/30599/CS DISHED ENDS/CDE-19-3425 CLAUSE NO.11.
6. TOLERANCE ON FORMING : AS PER CLAUSE ND-4222 OF ASME SECTION-III ND, UNLESS OTHERWISE SPECIFIED.
7. PRESSING TO BE DONE FROM SINGLE PIECE BLANK.
8. HEAT TREATMENT(HT) - AS PER SPECIFICATION NO. BHEL/NPCIL/30599/ CS DISHED ENDS/CDE-19-3425.

न्यूक्लियर पावर कॉर्पोरेशन ऑफ इंडिया लिमिटेड
Nuclear Power Corporation of India Limited
अनुमोदित / APPROVED
टिप्पणी के अनुसार अनुमोदित / APPROVED AS NOTED
संविरचन को आगे बढ़ाएं / रोकें / PROCEED WITH/HOLD FABRICATION
अंतिम ट्रान्सपेरेन्सी एवं प्रिंट्स भेजें / SEND FINAL TRANSPARENCY & PRINTS
संशोधित करें एवं अनुमोदन हेतु पुनः प्रस्तुत करें REVISE & RESUBMIT FOR APPROVAL
जाँचकर्ता / CHECKED BY | APPROVED BY
2.5.19 | 2/5/19 | 2/5/19
This approval of the work to be done does not relieve the supplier of responsibility of supply according to specifications.

QTY. VAR00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	IT.NO. / VAR.	MATL. CODE / MATL. SPCN.	A C UNIT	UNIT WT. / QTY.	GS ZONE
01	BLANK Ø1220		01	DISHED END 25 TK.				B.O. SA516Gr70		222.0 R/M-229.0	

28 —— CARD TYPE-3 · 28 —— CARD TYPE-1 · 28 —— CARD TYPE-2

DO NOT SCALE THE DRAWING.
UNLESS OTHERWISE STATED:-
ALL DIMENSIONS ARE IN mm.
MACHINE ALL OVER.
SURFACE FINISH TO BE 12.5 OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS AND EDGES BY CHAMFERING TO $0.15 \atop 0.40$ x 45°.
ROUND ALL INTERNAL CORNERS AND EDGES TO R $0.15 \atop 0.40$.
TOLERANCES ON RADII AND CHAMFERS (IS : 2102)

REDII AND CHAMFERS	0.5-3	3-6	6-30
TOLERANCES	±0.2	±0.5	±1.0

TOLERANCE ON LINEAR DIMENSIONS (IS:2102)

DIMENSIONS	TOL.	DIMENSIONS	TOL.
UP TO 6	±0.1	315 -1000	±0.8
6 - 30	±0.2	1000-2000	±1.2
30 - 120	±0.3	2000-4000	±2.0
120 - 315	±0.5	4000-8000	±3.0

TOLERANCE ON LINEAR DIMENSIONS

SPECIFIED DIMENSIONS	TOLERANCE
XX	± 0 . 40
XX.X	± 0 . 40
XX.XX	± 0 . 25

TOLERANCE ON ANGULAR DIMENSIONS : 0°-0.5°

ADDITIONAL INFORMATION
DRG. LIST : 4-16503-40359
STATUS OF DRAWING
W/O. NO. : 18085/86-W-04801
DISTRIBUTION OF PRINTS
CDE-1 HCM-1
FBM-1

REV.	DATE		
01	18.04.19	ALTERED	राधाकान्त मेहेर
		CHECKED	नागेन्द्र सिंह
		APPROVED	ए.के.माहौर

DRG. REVISED AS PER NPCIL COMMENTS DTD 26.03.19.

NUCLEAR POWER CORPORATION OF INDIA LIMITED
(A GOVERNMENT OF INDIA ENTERPRISE)
PROJECT : GORAKHPUR HARIYANA ANU VIDHYUT PARIYOJANA 1&2 (700 MWe)
NPCIL PURCHASE ORDER NO. : CMM/FTP/10-33-1-1149/e-PO/30599, DATED 25.01.2019
NPCIL DRAWING NO : GHAVP-1&2/33411/2007,2008/DD REV.00

उत्पाद का प्रकार या ग्राहक/परियोजना का नाम
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT
SHUT DOWN COOLER

भारत हेवी इलेक्ट्रिकल्स लिमिटेड भोपाल
BHARAT HEAVY ELECTRICALS LTD. BHOPAL

	नाम/NAME	हस्ता./SIGN.	दिनांक/DATE
DRN.	विजय कुमार कुशवाहा		07/03/2019
CKD.	नागेन्द्र सिंह / अरुण कुमार सिंह		07/03/2019
APPD.	ए.के.माहौर		07/03/2019

DEPT CDE · CODE 411 · UNTOL DIMS GR M · AA 0230205 · SCALE – · WEIGHT (K.G.) 222.0
REF. TO ASSY. DRG. 1-16503-40867 · ITEM NO. – · NO. OF ITEM – · NO. OF VAR. –

शीर्षक/TITLE
CS DISHED END
(SHUT DOWN COOLER)

ड्राइंग सं./DRAWING NO. 2-16503-40497 · पुन/REV. 01

पृष्ठ सं./SHT. NO. · पृष्ठों की संख्या/NO. OF SHT.

A2

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REF. DRG. NO. · SIGN AND DATE · INVENTORY NO.