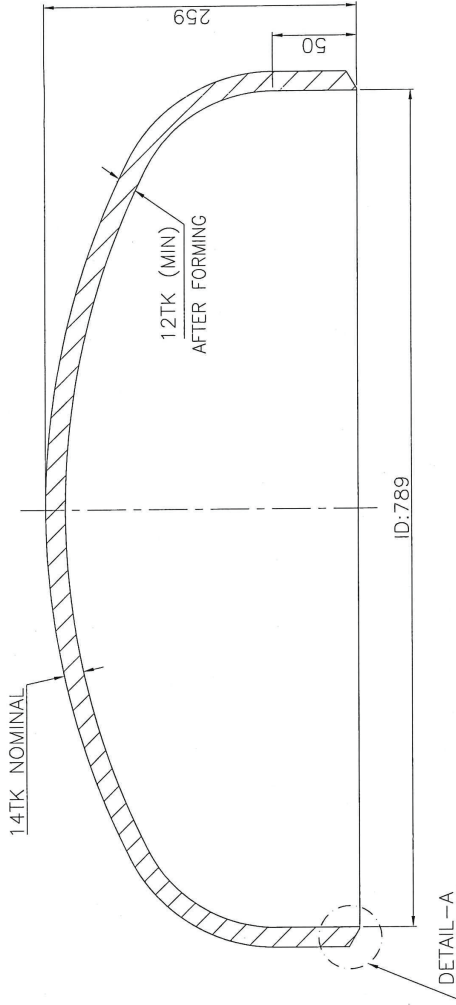
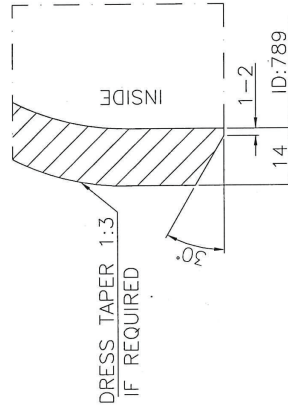


DRG. NO. 2-16503-40498



Nuclear Power Corporation of India Limited	
APPROVED	
DESIGNED BY: [Signature]	
CHECKED BY: [Signature]	
DATE: 2.10.19	
PROJECT NO. 16503-40498	
REVISIONS: [Table with 2 columns: No., Description]	



EDGE PREP. DETAIL DETAIL-A

TECHNICAL REQUIREMENTS (TR) :-

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

DO NOT SCALE THE DRAWING.
UNLESS OTHERWISE STATED:-
ALL DIMENSIONS ARE IN mm.
MACHINE ALL DIMENSIONS TO BE ± 0.1 OR BETTER.
REMOVE ALL BURRS.
REMOVE ALL EXTERNAL SHARP CORNERS AND EDGES BY CHAMFERING TO $R4 \times 45^\circ$.
ROUND ALL INTERNAL CORNERS AND CHAMFERS TO $R4$.
TOLERANCES ON RADI AND CHAMFERS (IS : 2102)
REDI AND CHAMFERS: 0.5-3 3-6 6-20
TOLERANCES: ± 0.2 ± 0.3 ± 1.0

TOLERANCE ON LINEAR DIMENSIONS (IS:2102)			
DIMENSIONS	TOL.	DIMENSIONS	TOL.
UP TO 6	± 0.1	315 - 1000	± 0.8
6 - 30	± 0.1	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		