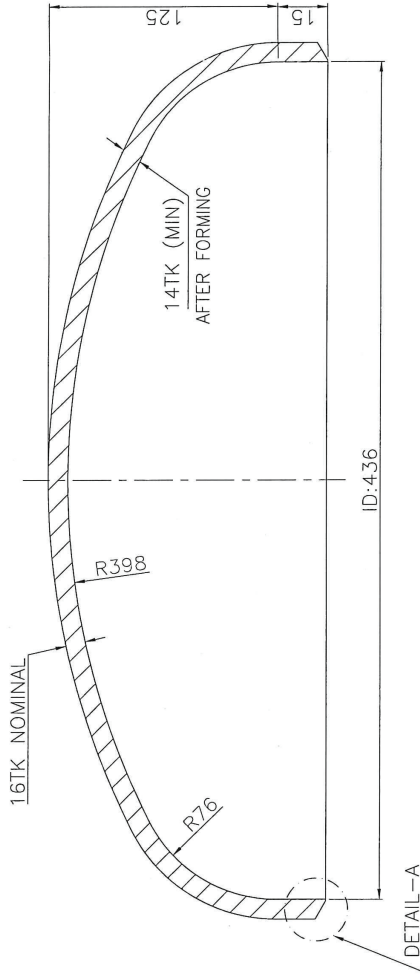
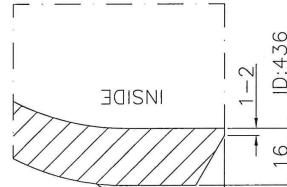


66*04-30591-2 ON DRG



भारतीय पवर कॉर्पोरेशन ऑफ इंडिया लिमिटेड Nuclear Power Corporation of India Limited	
<input checked="" type="checkbox"/> अनुमोदित / APPROVED <input type="checkbox"/> डिजाइन के अनुसार अनुमोदित / APPROVED AS NOTED <input type="checkbox"/> खींचने को अनुमोदित / OK! <input type="checkbox"/> PROCEED WITH/HOLD FABRICATION <input type="checkbox"/> औरीम ट्रांसमिशन के अनुमोदित / OK! <input type="checkbox"/> SEND FINAL TRANSMISSION LINES PRINTS <input type="checkbox"/> अनुमोदित करने के बाद प्रोसेस कर लेना है प्रोसेस करें REVISE & RESUBMIT FOR APPROVAL	अनुमोदित कर / CHECKED BY 25.05.19 अनुमोदित कर / APPROVED BY 25.05.19

DRESS TAPER 1:3
IF REQUIRED

EDGE PREP. DETAIL DETAIL-A

TECHNICAL REQUIREMENTS (TR) :-

- SHAPE OF DISHED END : TORISPHERICAL
- 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.
- 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.
- 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 : BHEL/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. BHEL/NPCIL/30599/CS DISHED ENDS/CDE-19-3425.

QTY.	BLANK #580	01	DISHED END	30.0
VAR. NO.	75 78 79 25	27	16 TK.	R/M-33.0
REMARKS	DRAWING NO. 58 59 60			
	DESCRIPTION			
	VAR. 32 33 46 MATL. SPCL. 34 C 15 16			

DO NOT SCALE THE DRAWING.
UNLESS OTHERWISE STATED:-
ALL DIMENSIONS ARE IN mm.
SURFACE FINISH TO BE \sqrt{R} OR BETTER.
REMOVE ALL BURS.
REMOVE ALL EXTERNAL SHARP CORNERS
AND EDGES BY CHAMFERING TO $\pm 0.4 \pm 0.2$
ROUND ALL INTERNAL CORNERS AND
EDGES TO R 2.0.
CHAMFERED ON RADI AND CHAMFERS
(AS : 2102)
TOLERANCES ± 0.2 ± 0.3 ± 1.0

TOLERANCE ON LINEAR DIMENSIONS (IS:2102)

TOLERANCE ON LINEAR DIMENSIONS (32:2102)			
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