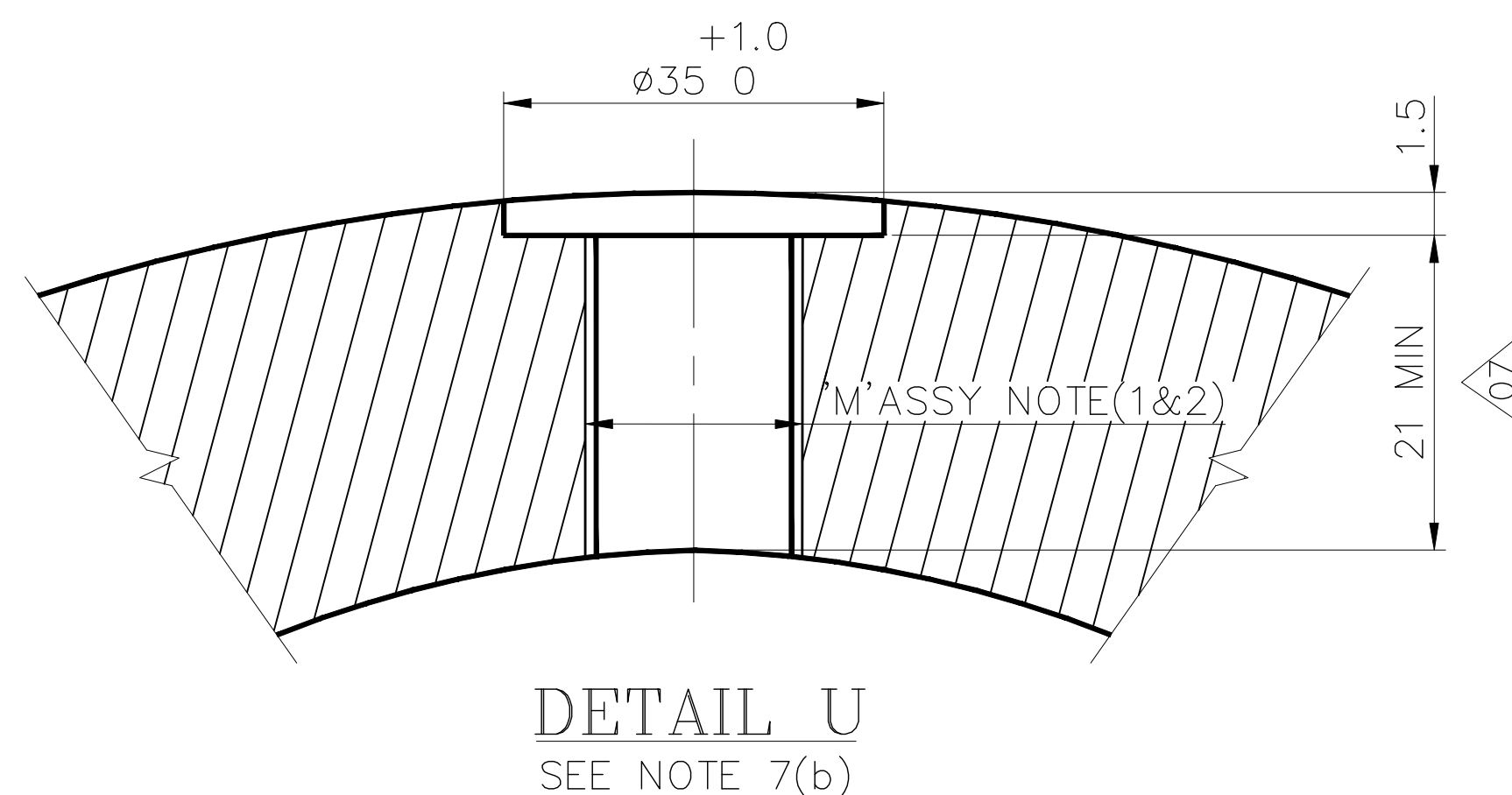
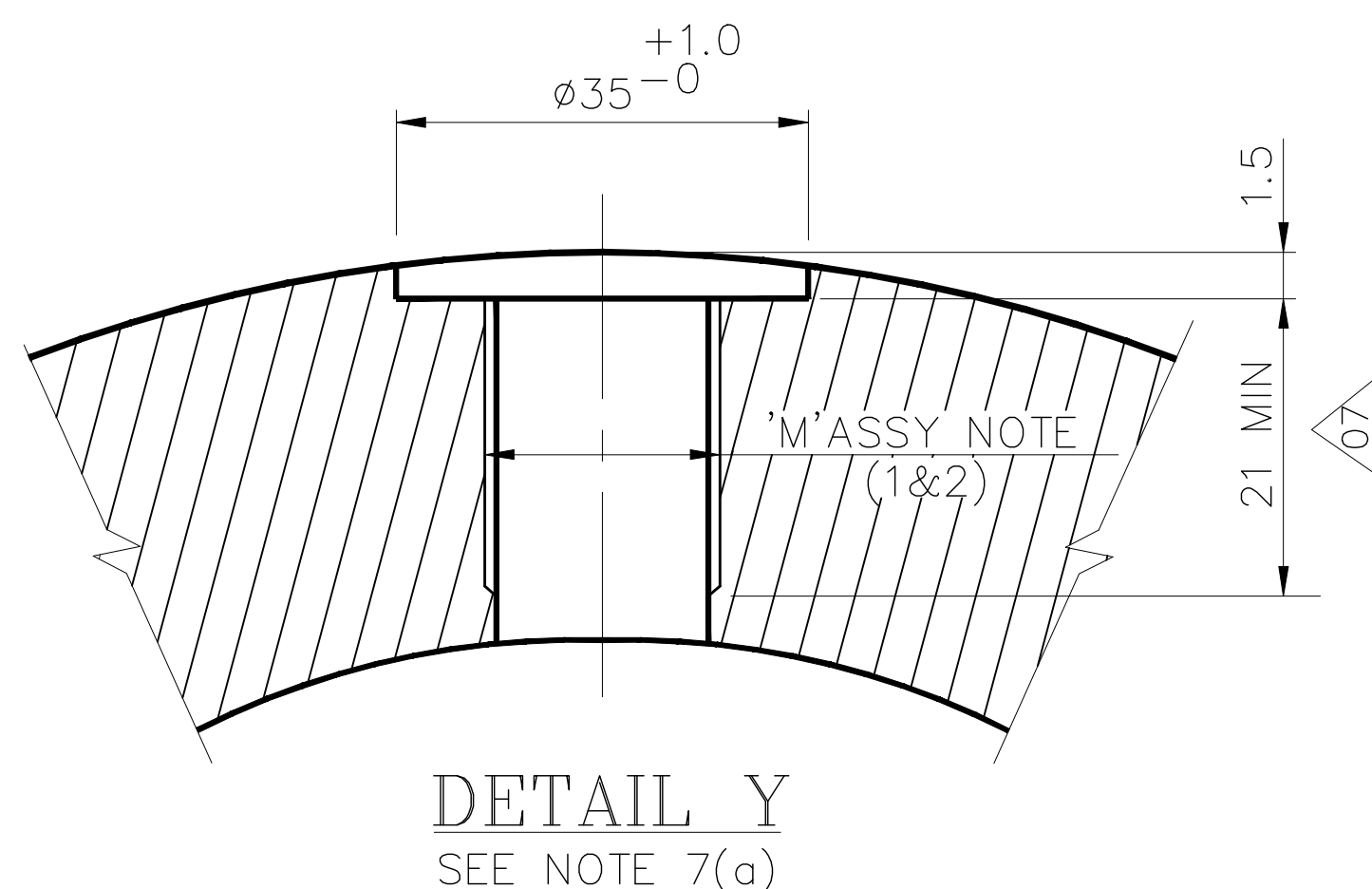




△06 6. ENSURE ENGAGEMENT OF MINIMUM 7 THREADS

(7) (a) WHEN $t_n > 22.5$ mm, THE DETAIL-'Y' TO BE FOLLOWED.

 (b) WHEN $t_n = 22.5$ mm, THE DETAIL-'U' TO BE FOLLOWED
NO WELD BUILD UP REQUIRED.

 (c) WHEN $t_n < 22.5$ mm, SEE SHOP GUIDE LINES.
WHERE t_n IS THE MINIMUM WALL THICKNESS OF HEADER/PIPE

SHOP GUIDELINES IN CONTINUATION OF DESIGN GUIDELINES-7(C)

SHOP SHOULD MEASURE THE ACTUAL WALL THICKNESS OF THE
HEADER/PIPE. IF THE ACTUAL WALL THICKNESS IS LESS THAN
22.5 mm ADDITIONAL MATERIAL SHALL BE ADDED BY SHOP
AS PER DETAIL-'Z'.

8. AFTER RADIOGRAPHY, SCREW UP PLUG TIGHTLY PRIOR TO SEAL WELDING

9. AFTER THE SHOP RADIOGRAPHIC TEST OVER, THIS SEAL WELD IS TO BE
DONE WITH MINIMUM TWO PASSES.

10. AFTER THE SITE RADIOGRAPHIC TEST OVER, THIS SEAL WELD IS TO BE
DONE WITH MINIMUM TWO PASSES.

1. THREADS ON PLUG AND HEADER/PIPE SHOULD CONFORM TO COARSE SERIES OF CORPORATE STD AA 0230202 (BPS-412513)
2. TOLERANCE CLASS FOR EXTERNAL THREADS ON PLUG SHOULD BE AS PER 89 OF CORPORATE STD AA 0231816 (BPS-412515)
3. THE VARIATION IN THREAD SIZE IS TO IDENTIFY CARBON AND ALLOY STEEL PLUGS SEPERATELY.
4. MARK THE BPS CODE AND MATERIAL CODE
5. CE REF. INDEX No. 12.9, 3.8, STD No. 23-63-22, DRG No. D980-0103-4
6. FOR DESIGN PRESSURE AND DESIGN TEMPERATURE REFER RELEVANT PRODUCT DRAWINGS.
7. DESIGN, MANUFACTURING AND INSPECTION AS PER IBR-1950
8. R.G. PLUG IS TO BE PROVIDED AT ANY CIRCUMFERENTIAL LOCATION AND AT ANY DISTANCE IN BETWEEN 90 MM AND 150 MM FROM PIPE CIRCUMFERENTIAL JOINT.

CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.	TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT									
	 355-054		Bharat Heavy Electricals Ltd UNIT: HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI – 620014				DRN	NAME	SIGNATURE	DATE
							CHD	G.U.		05/84
							APPD	S.V.		05/84
	DEPT	PP	ALL DIMENSIONS ARE IN MM		SCALE	WEIGHT (Kg)	REF TO ASSY / OLD DWG			
CODE	121	N.T.S								
TITLE							DRAWING NO :			REV
PLUG FOR RADIOGRAPHIC TEST ACCESS HOLE							6108-0022			08

REV 08	DATE 03.06.09	ALTERED : CHD & APPD : R.T.	JERIN	REV 07	DATE 19.10.06	ALTERED : CHD & APPD : R.T.	GEETHA	REV 06	DATE 03.02.05	ALTERED : P.S. CHD & APPD : R.T.	REV 05	DATE 03.01.04	ALTERED : CHD & APPD :	REV 04	DATE 23.04.01	ALTERED : CHD & APPD :	REV 03	DATE 26.09.82	ALTERED : CHD & APPD :				
ZONE	NOTE-8 REVISED			ZONE	MIN. THREAD LENGTH REVISED FROM 29 TO 21 mm IN DETAILS U, Y & Z. ASSY. NOTE-7 REVISED TO CHANGE DIMN. FROM 30.5 TO 22.5.			ZONE	DRG. RETRACED. NOTE NoS. 6 & 7 REVISED IN LINE WITH IBR REG. 367 AMENDMENT Dt. 09.04.2002			ZONE	NOTE-8 ADDED			ZONE	NOTE No. 6 & 7 ADDED. IN BOM DIAMETER 'd', THICK 't' ADDED FOR VAR.No. 01 & 02			ZONE	RETRACED. NOTE ALTERED. MATERIAL CODE ADDED. A SLOT GIVEN IN THE HEAD OF THE PLUG		

