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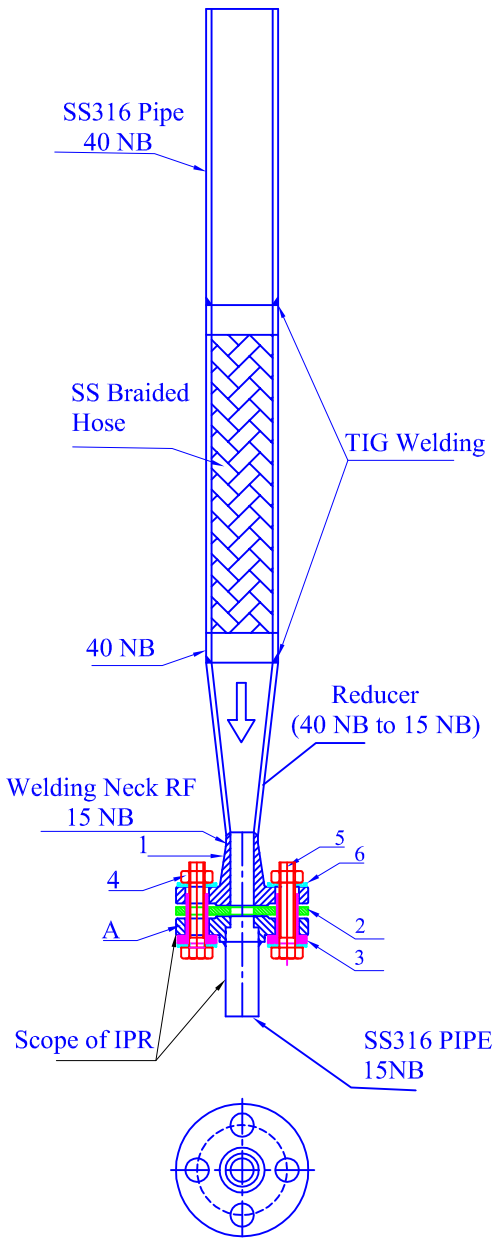
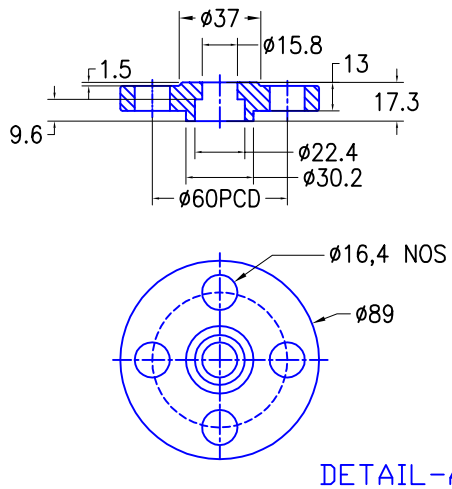
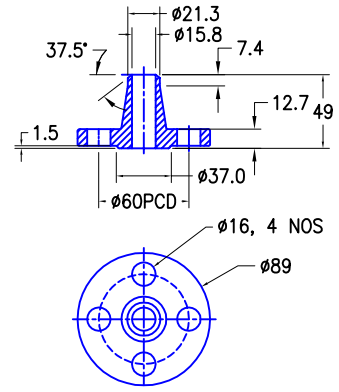


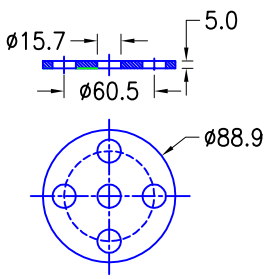
Assembly of CWS CONNECTION SCHEME
(1) PRE DUCT SCRAPER (PRS)
(2) SHINE THROUGH (ST)



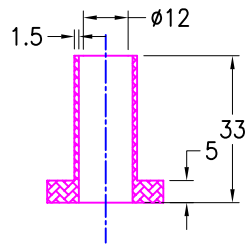
DETAIL-A
SOKET WELDING RF
ANSI B16.5,CLASS150,
15NB FLANGE

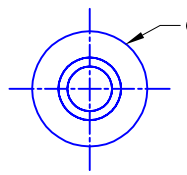


DETAIL-1
WELDING NECK RF
ANSI B16.5,CLASS150,
15NB FLANGE

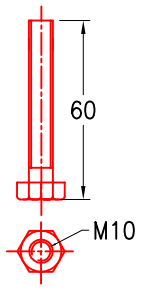


DETAIL-2
TEFLON FLANGE

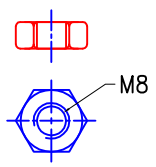




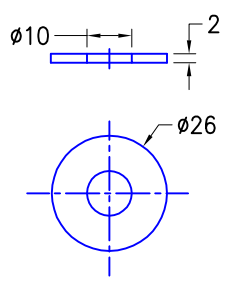
DETAIL-3
BUSH



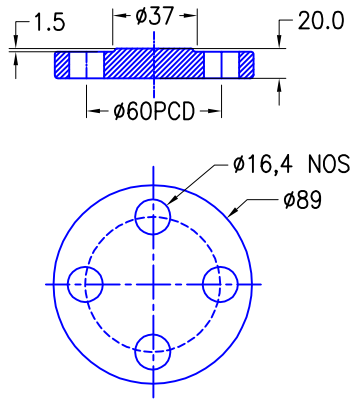
DETAIL-5
M10 BOLT



DETAIL-4
M10 NUT



DETAIL-6
M10 WASHER



SORF BLANK FLANGE (SS316)
(Needed for pressure test)

NO	NAME	QUANTITY	MATERIAL	RIVISION
9	SORF BLANK FLANGE	2	SS316	
8	REDUCER(40NB TO 15NB)	1	SS316	
7	SS BRAIDED HOSE	1	SS316	
6	M10 WASHER	8	SS316	
5	M10 BOLT	4	SS316	
4	M10 NUT	4	SS316	
3	BUSH	4	FRP(G10)	
2	TEFLON FLANGE	1	TEFLON	
1	WELDING NECK RF FLANGE 15NB	1	SS316	

DRG.NO	▽ 8–25	▽▽ 1.6–8	▽▽▽ 0.025–1.6	▽▽▽▽ < 0.025
CO–ORDINATED BY				

MACHINING DEVIATIONS FOR NON–TOLERANCED DIMENSIONS									
LENGTH IN mm OF SHORTER SIDE OF ANGLES				LENGTH OR DIA	UPTO 6	6–30	30–120	120–315
UPTO 10	10–50	50–120	OVER 120–400					
±1°	±0°–30'	±0°–20'	±0°–10'		±0.1	±0.2	±0.3	±0.5

REVISION COLUMN					
REV	ZONE	DESCRIPTION	DATE	REMARKS	APPROVED BY

ASS'Y GROUP:		
ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED		
SCALE	1:1	DATE
DRAWN	SACHIN	21/5/15
CHECKED	M.R.JANA	
APPROVED		

INSTITUTE FOR PLASMA RESEARCH
BHAT, GANDHINAGAR–382 428.

TITLE **NBI CWS CONNETION SIDE PRE DUCT SCRCPER (PDS) SHINE THROUGH (ST)**

REF DRG NO: | REV

DRG.NO **SST–1/NBI/CWS/Flange Connection** | SHEET 5 OF 6