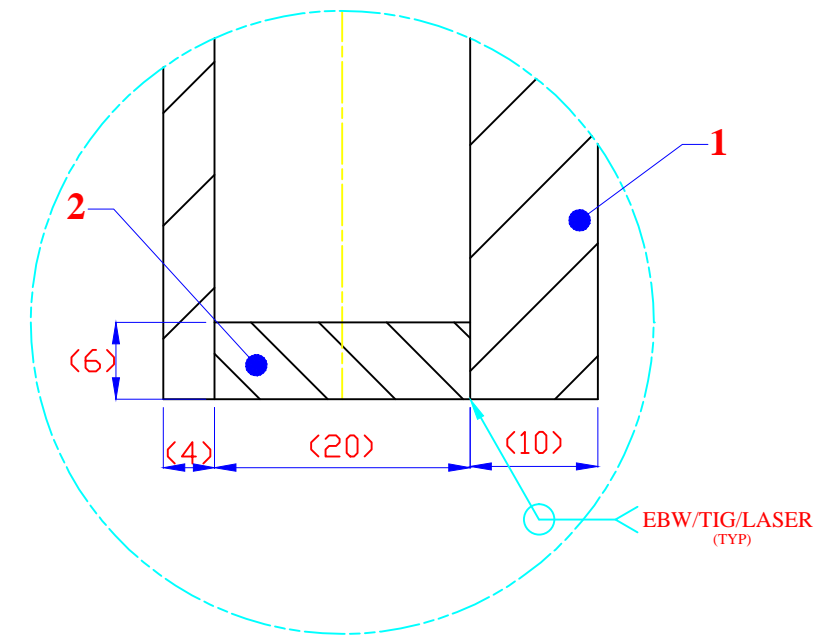


SECTION A-A



DETAIL C

PART NO.	PART NAME	QUANTITY	MATERIAL
FWA_IPR_01_2	PLUG	20	ASTM-387 GR.91 CLASS 2
FWA_IPR_01_1	U-SHAPED 10 CHANNELS FIRST WALL	1	ASTM-387 GR.91 CLASS 2

**BILL OF MATERIAL**

1. THE PLATES USED SHALL BE AS PER ASTM A387/ASME SA 387 GRADE 91 CLASS 2 STEEL.
2. THE PLATES SHALL BE PRE-MACHINED TO ACHIEVE DIMENSIONAL ACCURACY
3. INSIDE SURFACE FINISH SHALL BE 1.6-2.0 MICRONS RMS OR BETTER. CORNERS SHALL BE ROUNDED BY 2MM AS SHOWN IN DRAWING.
- 60EGP VGT'F KUVCEG'DGVY GGP 'UWEEGUUK'GEJ CPPGNU'UJ CNN'DG'MGRV'CV'470'0'20800
- 70VJ G'DGP F R I 'UJ CNN'DG'F QP G'CV'922/972AE0XGF QT'UJ CNN'HZ'VJ G'QRVIO WO 'VGO RGT'CVWTG0
- VJ G'IQD'UJ CNN'DG'P QTO CNK GF 'CP F 'VGO RGT'GF 'HMGRV'HQT'O QTG'VJ CP '52'O R WGU'CV'972AE0
6. DIE IMPRESSION ON PLATE IS NOT PERMISSIBLE AFTER BENDING
7. MATERIAL SPRINGBACK SHALL BE CONSIDERED WHILE BENDING AT HIGH TEMPERATURE. BENDING SHALL BE DONE STEPWISE IN SEQUENCE OF "L". DIRECT "U" BENDING IS NOT PERMITTED.
8. OUTSIDE SURFACE SHALL BE 0.8 MICRON RMS OR BETTER. IT SHALL BE SUITABLE FOR PHASED ARRAY ULTRASONIC TEST.
9. THE BEND PORTION SHALL BE X-RAY RADIOGRAPHED WITH 2-2t IQL (SEE SPECIFICATION)
10. REPAIR OF ANY DEFECT BY WELDING IS NOT PERMITTED.
11. HELIUM LEAK TEST SHALL BE CARRIED OUT AS PER SPECIFICATIONS BETWEEN CHANNELS AFTER BENDING.
12. SUITABLE GO & NO-GO GAUGE SHALL BE MADE FOR DIMENSIONAL INSPECTION.
13. THE VENDOR SHALL DEVELOP SUITABLE MACHINES INCLUDING SPM FOR THE JOB
14. DESCALING AND SURFACE CLEANING SHALL BE AS PER ASTM A 380
15. STAGE WISE INSPECTION PLAN SHALL BE SUBMITTED TO IPR BY THE VENDOR IN THE EVENT OF ORDER
- 380I GP GTCN'VQNGTCEG'QH020800 'HFP QV'O GP VQPG F 0

ASS'Y GROUP:			INSTITUTE FOR PLASMA RESEARCH		
ALL DIMENSIONS ARE IN 'mm' UNLESS OTHERWISE STATED			BHAT, GANDHINAGAR-382 428.		
SCALE	NTS	DATE		TITLE	
DRAWN	ATIK	20-01-2015		U-SHAPED 10 CHANNELS FIRST WALL AND PLUG ASSEMBLY MOCK UP	
CHECKED	ATIK	20-01-2015	REF DRG NO:		REV 0
APPROVED			DRG.NO	FWA_IPR_01	SHEET OF 1/3