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	ITEM	NO PART	NAME				MATERIAL	DESC	RIPTIC)N	QTY	ITEM	NO PAR		-		M	ATERIAL		D	ESCRIPTION	(AT Y	
4	01	BASE	PLATE 0	<u></u>			AS PER D	NG. DRG.	#19020	0003	01	29				4				1	9030020)2	4
	02	BASE	PLATE-2	2			AS PER D	NG. DKG.	#19020	004	00	30		PLATE	COVER-	· I				1	9030023			
	03	STEM-	· I				AS PER D		#19020	007	00	20	10P		COVER-	2				1	9030024		2	
	04	STEM-	3				AS FER D		#19020	0000	02	32			рт					1	9030025		1	
	05				110 6)		AS FER D		#19020	0009 0011 TO	02	24				т				1	0020020			
					110 0)			DRG.	#19020	0016				50 VA							3030027			
	07	HOR.	ROD RIG	HT SEGMENT	(1TO 6)		AS PER D	NG. DRG. DRG.	#19020 #19020	0017 TO 0022	06	35	DN	75 RF	PORT					1	9030028)1	
	08	VER.	ROD LOW	/ER SEGMENT	(1 T06)		AS PER D	NG. DRG. DRG.	#19020 #19020	0023 TO	06 9	36	KF4	0 PORT	Γ					1	9030029	()1	
	09	VER.	ROD UPP	PER SEGMENT	(1 T06)		AS PER D	NG. DRG.	#19020	030 TO	06	37	CF6	3 PORT	Г					1	9030030	()1	
	10	VER.	ROD LOW	/ER SEGMENT	5-PROTOT	YPE	AS PER D	WG. DRG.	#19020	028	01	38	1/4 B0L	"-19 E T,WASH	3SP x35L IER	ALLEN	S	\$ 304		F	OR BASE PLATE TO V ESSEL BOTTOM PLATE		210	
ო	11	VER.	ROD UPP	PER SEGMENT	5-PROTOT	YPE	AS PER D	WG. DRG.	#19020	0035	01	39	1/8 BOL	"-28 E T,WASH	3SPx25L IER	ALLEN	S	S 304		F	OR BASE PLATE TO S	STEM 2	280	3
	12	END F	LANGE - 1				AS PER D	WG. DRG.	#19030	0005	03	40	M5x	35L E	BOLT,WAS	SHER	S	S 304		F	OR BASE PLATE TO S	STEM '	100	
	13	END F	LANGE - 2	2			AS PER D	NG. DRG.	#19030	0006	01	41	M5x	50L AL	LEN BOL	T,WASHE	R S	S 304		F	OR ROD TO STEM		100	
	14	END F	LANGE C	OVER-1			AS PER D	NG. DRG.	#19030	0007	01	42	Ø 5	DOWEL	PIN		S	S 304		F	OR STEM TO BASE F	PLATE	30	
	15	END F	LANGE C	OVER-2			AS PER D	NG. DRG.	#19030	8000	01	43	Ø 5	DOWEL	PIN		S	S 304		F	OR ROD TO STEM	Ę	55	
	16	END F	LANGE C	OVER-3-PROT	OTYPE		AS PER D	NG. DRG.	#19030	0014	01	44	M12	x75L E ASHER	BOLT WIT	H DUAL	NUT S	S 304		F	OR FLANGE TO FLANG	βE [·]	125	
	17	0-RIN	IG - 1				AS PER D	WG. DRG.	#19030	0009	03	45	1/4 WAS	"-19 E HER	3SP x35L	BOLT	NITH S	S 304		F P	OR TOP PLATE COVER	R TO TOP	160	
	18	0-RIN	IG-2				AS PER D	NG. DRG.	#19030	0010	02	46	DOU	BTY SE	AL		V	ITON WI	TH SS	RING F	OR STEM TO VANE	į	50	
	19	0-RIN	IG-3				AS PER D	WG. DRG.	#19030	0011	01	47	C00 T0	LING A	ARRANGEN	IENT OF I YPE	ROD C	OPPER 0	HFC	1	9020038	()1	
	20	0-RIN	IG - 4				AS PER D	NG. DRG.	#19030	0031	01	48	C00 T0	LING A STEM-1	ARRANGEN	IENT OF I YPE	ROD C	OPPER 0	HFC	1	9020039	(01	
N	21	0-RIN	IG-5				AS PER D	NG. DRG.	#19020	0005	08	49	END	PLUG	FOR VAN	IES	C	OPPER 0	HFC	1	9020037			2
	22	0-RIN	IG - 6				AS PER D	NG. DRG.	#19020	0006	04	50	STE PRO	M SLOT TOTYPE	COVER	FOR	C	OPPER 0	HFC	1	9020040)2	
	23	BOTTO	M PLATE	- 1			AS PER D	WG. DRG.	#19030	0012	01	51	HEL	ICOFLE	X SEAL	FOR 40C	F A	S PER S	TD	T	OP PLATE TO 40CF F	PORT)1	
	24	BOTTO	M PLATE	-2			AS PER D	WG. DRG.	#19030	0013	01	52	HEL	ICOFLE	X SEAL	FOR 63C	F A	S PER S	TD	E P	ND COVER PLATE TO	63 CF ()1	
	25	SIDE	PLATE-1				AS PER D	NG. DRG.	#19030	0015	01	53	HEL	ICOFLE	X SEAL	FOR 75C	F A	S PER S	TD	S	IDE PLATE TO 75CF	PORT	01	
	26	SIDE	PLATE-2	2			AS PER D	WG. DRG.	#19030	0016	01	54	HEL	ICOFLE	X SEAL	FOR 250	CF A	S PER S	TD	S	IDE PLATE TO 250 (CF PORT	03	
	27	SIDE	PLATE-3	3			AS PER D	NG. DRG.	#19030	0018	01													
	28	SIDE	PLATE-4	•			AS PER D	WG. DRG.	#19030	0019	01													
ŀ	DRG.NO		▼ 8-2	25 ₩ 1.6-8		0.025	-1.6 VVV	⊽< 0.025				REVISI	ON COLUMN				RFQ GROU	JP:			Institute for Plas	ma Res	earch	
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-	Ν	MACHINING [DEVIATIONS	S FOR NON-TOLE	RANCED DIM	ENSIO	I I										SCALE	1:1	DATE	@ <i>_</i>				1
	LENGTH I	N mm OF SHO	ORTER SIDE	E OF ANGLES	LENGTH	UPTO 6	6-30 30-1	20 120-315									DRAWN	K.R.R.	10.01.18					
	UPTO 10	10-50	50-120	OVER 120-400	OR DIA	+0.1	+0.2 +0	3 +0.5	1	$\left \right $							CHECKED	РКС		REF DRG	G NO:		REV C)
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MA BOTTOM PLATE-1 AL SIDE PLATE-1 AL SIDE PLATE-2 AL AL AL SS DN250 VACUUM PORT AL TOP PLATE COVER AL VI VI END FLANGE COVER-1 AL SS DN75 RF PORT SS VI SS STI M12-LIFITING BOLTS BOLTS AND NUTS SS3

01. ENOUGH CARE SHALL BE TAKEN TO AVOID DAY HANDLING AND STORING OF RAW MATERIAL, SH

EXAMINATION ETC., SHALL BE AS PER RELEVAN 03.ABRASIVE CLEANING OF THE SURFACE EXPOSE

04. AFTER SUCCESSFULL ASSEMBLY, ACCEPTANCE

05.ALL SHARP CORNER SHALL BE ROUNDED OFF. 06.USE FIXTURES DURING WELDING, MACHINING AN

07.EDGE PREARATION OF WELD JOINT BETWEEN EN 08.AFTER SUCESSFUL TRAIL ASSEMBLY, ACCEPTANC

ASSEMBLY, THE REFERENCE POINT, CO-ORDINATE VACUUM VESSEL SHALL BE DONE AS REFERENCE



Section view C

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	DRG.NO			8-25	₩ 1.6-8		0.025	-1.6	<	0.025			REVIS	ION COLUMN				RFQ GROUP	P:		
	CO-ORDI	INATED BY									REV	ZONE	DESCRIPTION		DATE	REMARKS	APPROVED	ALL DIMENSI UNLESS OTHE	IONS ARE IN RWISE STAT	I`mm' ⊺ED	
[Ν	MACHINING	DEVIATI	CONS FO	OR NON-TOLER	ANCED DI	MENSIO	NS										SCALE	1:1	DATE	
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IENIAL	DESCRIPTION QTT		
6061-T6	DRG.#19030012 01		
6061-T6	DRG.#19030015 01		
6061-T6	DRG.#19030016 01	-	4
6061-T6	DRG.#19030020 01		
6061-T6	DRG.#19030005 02	-	
304L	DRG.#19030027 02	-	
6061 TE	DRG.#19030025 01		
	DRG #19030009 02		
TON	DRG_#19030011 01		
6061-T6	DRG.#19030007 01		
304L	DRG.#19030026 01		
304L	DRG.#19030028 01		
TON	DRG.#19030010 01		
304L	DRG.#19030029 01		
D	04		
304	DRG.#19010003 AS PER BOM		
MAGE (DENT EMI FINISH ON REQUIRE NT APPROVE D TO VACUU TESTS SHAL ND HEAT TF ND FLANGE	T AND SCRATCHES) DURING HED PRODUCT AND FINISHED PRODUCTS. EMENTS,TESTING AND ED SPECIFICATIONS. JM IS NOT ALLOWED. LL BE CARRIED AS PER APPROVED REATMENT. AND SIDE PLATE,TOP PLATE,BOTTOM PLA	TE.	3
	ARKING BETWEEN VANE, STEM, BASE PLATE ASSEMBLY.	AND	2
- C	a 65	<u>ch</u>	
R	गाउ॥।।।।।। ।।। नावआगत स्टड्येति प्लाज़्मा अनुसंधान संस्थान Bhat. Near Indira Bridge Gandbinagar 382428 Gui	arat (India)	
	TITLE	(
@€]	VACUUM VESSEL-1 ASSEN	IBLY	
REF DRG NO):	rev O	
DRG.NO	IPR/17/A3/RFQ/19030002	SHEET 1 OF 1	
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	Ν	MACHINING	DEVIAT	IONS	FOR NON-TOLERA	NCED DI	MENSIO	NS										SCALE	1:1	DATE
	LENGTH I	N mm OF S	HORTER	SIDE	OF ANGLES		UPT0	6-30	30-120	120-315								DRAWN	K.R.R.	01/12/17
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05.ALL SHARP CORNER SHALL BE ROUNDED OFF. 06.USE FIXTURES DURING WELDING, MACHINING AND HEAT 07.EDGE PREARATION OF WELD JOINT BETWEEN END FLAM 08.AFTER SUCESSFUL TRAIL ASSEMBLY, ACCEPTANCE TEST ASSEMBLY, THE REFERENCE POINT, CO-ORDINATES, MATO VACUUM VESSEL SHALL BE DONE AS REFERENCE FOR S

10

04. AFTER SUCCESSFULL ASSEMBLY, ACCEPTANCE TESTS PROCEDURE.

02.MATERIALS,WELDING PROCEDUES,QUALIFICATION REQ EXAMINATION ETC.,SHALL BE AS PER RELEVANT APP 03.ABRASIVE CLEANING OF THE SURFACE EXPOSED TO V

ASSEMBLY NOTES: -01. ENOUGH CARE SHALL BE TAKEN TO AVOID DAMAGE (I HANDLING AND STORING OF RAW MATERIAL, SEMI FI

ITEM

NO. 01

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PART NAME

BOTTOM PLATE-2

SIDE PLATE-3

SIDE PLATE-4

TOP PLATE-2

END FLANGE-2

END FLANGE-1

KF25 PORT

0-RING-1

0-RING-3

0-RING-2

DN63CF PORT

BOLTS AND NUTS

M12-LIFTING LUGS

DN250CF VACUUM PORT

TOP PLATE COVER-2

END FLANGE COVER-2



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MATERIAL DESCRIPTION QTY AL6061-T6 DRG.#19030013 01 AL6061-T6 DRG.#19030017 01 AL6061-T6 DRG.#19030021 01 AL6061-T6 DRG.#19030027 01 AL6061-T6 DRG.#19030025 01 AL6061-T6 DRG.#19030024 01 AL6061-T6 DRG.#19030009 01 AL6061-T6 DRG.#19030005 01 VITON DRG.#190300005 01 VITON DRG.#19030003 01 SS304L DRG.#19030003 01 AL6061-T6 DRG.#19030003 01 S304L DRG.#19030030 01 S304L DRG.#19030030 01 S304L DRG.#19010003 AS PER BOM STD 04 3 (DENT AND SCRATCHES) DURING BOM NIFHED PRODUCT AND FINISHED PRODUCTS. JUIREMENTS, TESTING AND NOVED SPECIFICATIONS. ////////////////////////////////////									
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4	NOTE:- 7 01. ALL SHARP CORNERS SHALL BE ROUNDED OFF. 02. THE FINISH MACHINED/GROUND SURFACES SHALL BE PRESERVED AND PROTECTED SUITABLY TO AVOID ANY DAMAGE DURING HANDLING TRANSIT AND ASEMBLY 03. USE DRILL JIG FOR DRILLING OF HOLES. 04. THREADING SHALL BE AS PER IS4218 05. AFTER MACHINING THE COMPONENT SHALL BE SUBJECTED TO SOLUTION CLEANING OR ULTRASONIC CLEANING AS PER APPROVED PROCEDURE										
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