

PURCHASE ORDER NO : NA

CAST BASALT LINED PIPE DIMENSIONS – 300 NB PIPE

MATERIAL CODE	DRG.NO	TAG.NO	SN.	CB ID (ØD1)	MS OD (ØD2)	RADIUS (R)	ANGLE (Q°)	QTY. IN NO
-	A	CBB 300/90D	001	303	380	900	90°	06

FIXED FLANGES 'A' DIMENSIONS

NB	ID	OD	PCD	N/H<O/F CTR.>	ØH	THK.	QTY
300	383	525	480	16	26	25	02/NO

MATCHING FLANGES 'M' DIMENSIONS

NB	ID	OD	PCD	N/H<O/F CTR.>	ØH	THK.	QTY
300	327	525	480	16	26	25	02/NO

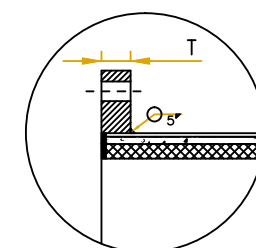
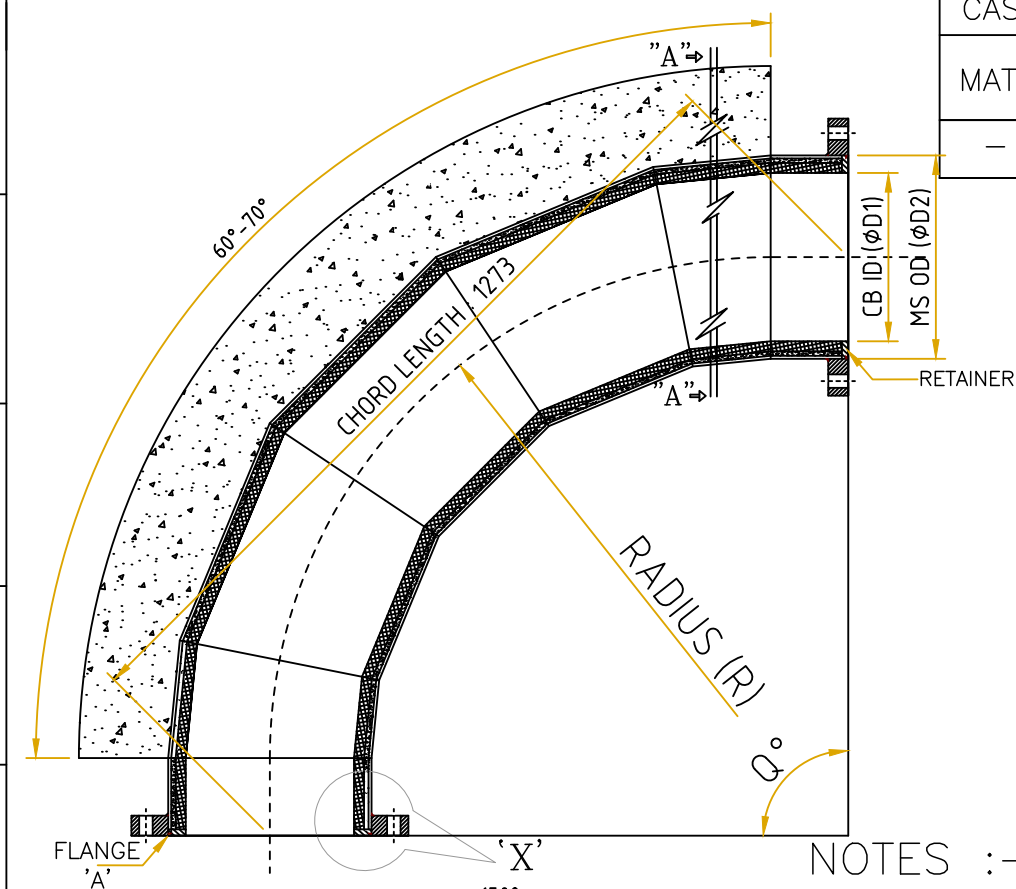
FASTENERS DETAIL(32 SETS/BEND): HEXAGONAL TYP.

1SET=1BOLT+1NUT:GR.4.6&4 AS PER IS1364NORMAL/BLACK

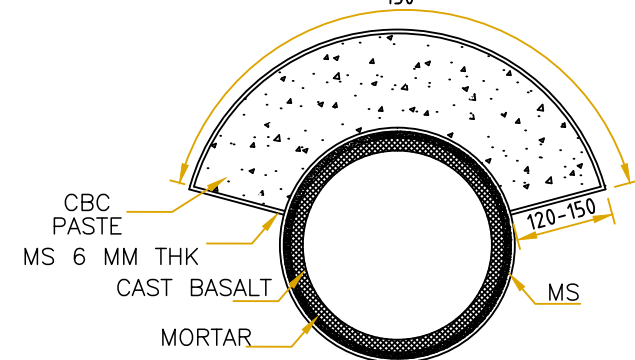
DIA	LENGTH	THREADED TYPE
M24	100	HALF/FULL THREADED

RETAINER 'R' DIMENSIONS

NB	ID	OD	THK	QTY
300	303	375	6	02/NO



DETAIL 'X' : FIXED FLANGE WELDING DETAIL



DETAIL : SECTION A-A

NOTES :-

- 1) ALL DIMENSIONS ARE IN MM. UNLESS NOTED
- 2) MS CASING PLATE MATERIAL 6 MM THK AS PER IS:2062 /EQUI. MATERIAL.MS CASING SHALL BE FABRICATED AS PER IS 2062 TOL. AS PER IS 3589. MAKE : REPUTED MANUFACTURER.
- 3) MITTER SHOWN IN DRAWING IS FOR REFERENCE PURPOSE ONLY. NO OF MITERS SHALL BE AS PER GCE DESIGN.
- 4) FLANGE FITTING TYPE : AS PER DRAWING.
- 5) PAINTING : TWO COATS OF RED OXIDE PRIMER
- 6) MOC OF FLANGE: IS 2062
- 7) HYDRO TESTING PRESSURE : BEFORE LINING BY MANUFACTURER @ 20 KG/SQ.CM
- 8) SUITABLE LIFTING LUGS SHALL BE PROVIDED FOR LIFTING

PROPERTIES OF CAST BASALT		
SR.NO	PROPERTIES	VALUE
1	DENSITY	2.8 TO 3.1 gm/Cu.cm
2	COMPRESSION STRENGTH	4500 KG/Sq.cm(min)
3	HARDNESS	8 MOH'S (min)
4	BENDING STRENGTH	300 Kg/Sq.cm (min)

REVISION CHART		
SN.	DATED	REVISION MARK
01		
02		

LEGENDS :

- 1) CAST BASALT : 20 MM THK
- 2) MS CASING : 6 MM THK
- 3) MORTAR : AS PER GCE STAND

GENERAL TOLERANCE FOR LINED EQUIPMENTS

CAST BASALT	
ID	±3
LINING THK.	±2
RADIUS	±5
ANGLES	±0.5
LENGTH	±5 MIN
CASING OD	±3 MIN

* ALL DIMENSIONS ARE IN MM.

CLIENT: OPGCL
 PROJECT: ASH SLURRY LNE
 TITLE: CAST BASALT LINED BENDS & FITTINGS 300 NB

DRN.	CHECKED_BY	APPROVED _BY	DATE	SCALE	DRG NO.	REV.

GENERAL TOLERANCES

DIMN		FABRICATION		MACHINING	
0-10	±0.5	±0.5	±0.1	±0.1	±0.8
11-50	±0.5	±0.5	±0.2	±0.2	±1.2
51-100	±1.5	±1.5	±0.3	±0.3	±2.0
101-500	±2.0	±2.0	±0.5	±0.5	±2.0
DIMN		FABRICATION		MACHINING	
501-1000		±3.0			
1001-3000		±4.0			
ABOVE 3000		±6.0			