



PRODUCT STANDARD

TC 5 6216

INDUSTRIAL TURBINES & COMPRESSORS

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NIPPOLET (M 20 X 1.5 L)

1.0 SCOPE

THIS STANDARD COVERS REQUIREMENTS OF NIPPOLET FOR TURBINE AND COMPRESSORS PROJECTS. THESE ARE WELDED ON TO THE PIPE LINES FOR PROVIDING TAPPING CONNECTIONS FOR INSTRUMENTS.

2.0 MATERIAL SPECIFICATIONS

THE RAW MATERIAL SPECIFICATION SHALL BE AS PER ENQUIRY WHICH CAN BE ANY ONE OF FOLLOWING.

2.1 ASTM A 105 (C.S) (CARBON SHALL BE RESTRICTED TO 0.25% MAX.)

2.2 ASTM A 182 F 321 (S.S)

3.0 SIZES AND DIMENSIONS

AS INDICATED IN THE DRAWING

4.0 PROCESS

THESE ITEMS SHALL BE FORGED TO SHAPE. MACHINING FROM ROUNDS IS NOT PERMISSIBLE.

5.0 TESTS AND HEAT TREATMENT

TESTS AND HEAT TREATMENT SHALL BE AS PER RELEVANT MATL. STDS. ACCEPTANCE TO ANY DEVIATIONS / OPTIONS SHALL BE OBTAINED FROM PURCHASER.

6.0 THREADING

THREADING SHALL BE AS PER ISO METRIC (LEFT HAND THREAD)

7.0 INSPECTION

THESE ITEMS SHALL BE INSPECTED FOR EXTERNAL DIMENSIONS AND MANUFACTURING DEFECTS BY M/s LLOYDS/M/s IIR

8.0 TEST CERTIFICATES

TEST CERTIFICATES SHALL BE SUPPLIED ALONG WITH SUPPLIES IN TRIPPLICATE WITH ONE REPRODUCIBLE COPY WITH M/s LLOYDS / M/s IIR ATTESTATION

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Concured:
STANDARDS

Revision:

01

Date:

02-09-1992

STD COPIED ON CAD

Drawn:

BEC (INDUSTRIAL TURBINES & COMPRESSORS)
HYDERABAD

Prepared:

SBB

Approved:

BEC

Date:

02-09-1992



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REV 01

NIPPOLET (M 20 X 1.5 L)

9.0 DESIGNATION

9.1 NAME OF THE PART SHALL BE AS: C.S. NIPPOLET M20 X 1.5L

9.2 MATL. SPN. SHALL BE "TC 5 6216 VAR. NO.1"

10.0 MARKING

EACH ITEM SHALL BE MARKED (BY PUNCH MARKING) GIVING THE FOLLOWING DETAILS

10.1 MANUFACTURERS TRADE MARK

10.2 TITLE AS "NIPPOLET M20 X 1.5L"

10.3

10.4

10.5 TC 5 6216

10.6 VAR. NO. XX

10.7 MATERIAL SPECIFICATION

10.8 COMPONENT CODE

10.9 INSPECTION AUTHORITY MARKING

11.0 PROTECTION

ITEMS SHALL BE PROTECTED FROM RUST PREFERBLY TREATED WITH PLASTIC COATING PEEL-OFF TYPE

12.0 PACKING AND DISPATCH

ALL ITEMS SHALL BE PACKED PROPERLY TO PROTECT FROM MECHANICAL DAMAGE DURING TRANSPORT AND STORAGE

13.0 REFERENCE DRAWINGS

4C-47-9220

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No:

TD-106-1 REV.1

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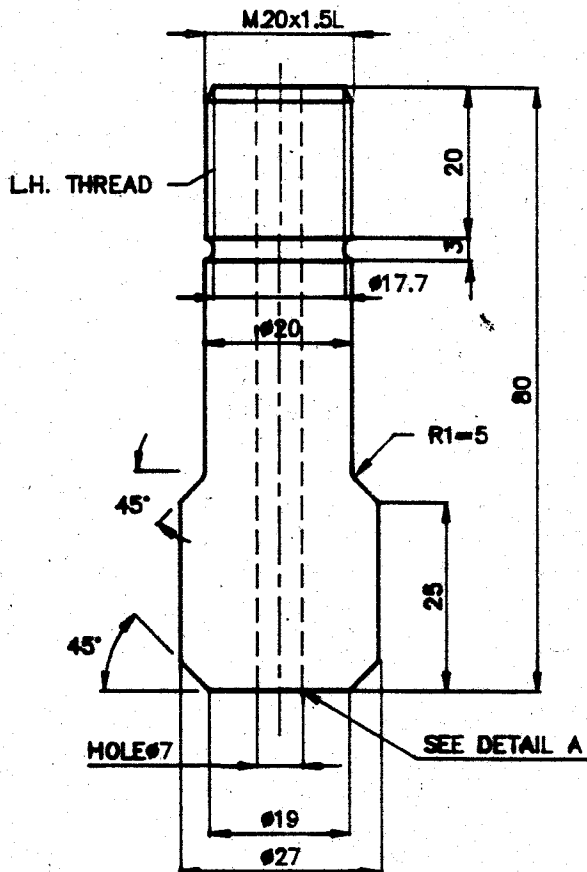
Item No:

TD-106-1 REV.1

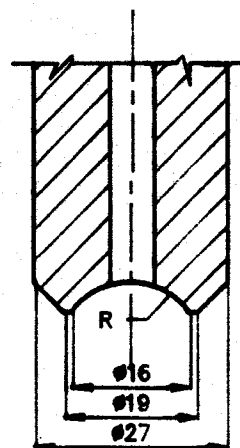
Ref. Doc:

REV 01

NIPPOLET (M 20 X 1.5 L)



DETAIL-A



ALL DIMENSIONS IN MM

R - SHALL BE
 SUITABLE FOR BASE
 PIPE Ø2 TO Ø 24

WT IN KGS

VAR. No.	MATL SPN	Wt/ Pc	COMPONENT CODE
			OLD CODE
01	A105	0.18	TC 9756 216 018
			N 47 11 804 30
02	A182F321	0.18	TC 9756 216 018
			N 47 11 804 30

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STANDARDS

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