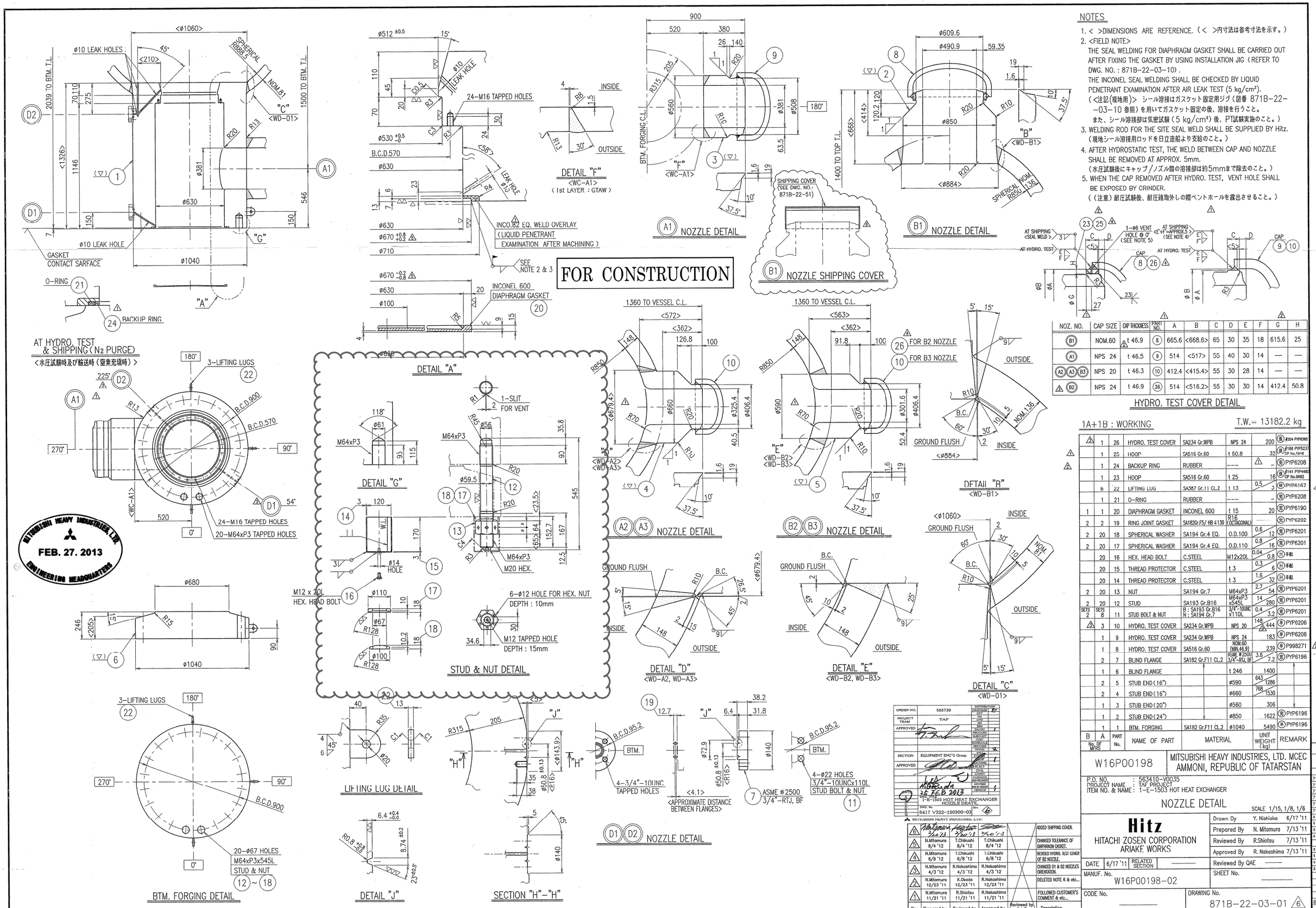

NOTES

1. < >DIMENSIONS ARE REFERENCE. (< >内寸法は参考寸法を示す。)
2. <FIELD NOTE>
   THE SEAL WELDING FOR DIAPHRAGM GASKET SHALL BE CARRIED OUT AFTER FIXING THE GASKET BY USING INSTALLATION JIG (REFER TO DWG. NO.: 871B-22-03-10).
   THE INCONEL SEAL WELDING SHALL BE CHECKED BY LIQUID PENETRANT EXAMINATION AFTER AIR LEAK TEST (5 kg/cm²).
   (<注記(現地用)> シール溶接はガスケット固定用ジグ(図番 871B-22--03-10 参照)を用いてガスケット固定の後、溶接を行うこと。
   また、シール溶接部は気密試験(5 kg/cm²)後、PT試験実施のこと。)
3. WELDING ROD FOR THE SITE SEAL WELD SHALL BE SUPPLIED BY Hitz.
   (現地シール溶接用ロッドを日立造船より支給のこと。)
4. AFTER HYDROSTATIC TEST, THE WELD BETWEEN CAP AND NOZZLE SHALL BE REMOVED AT APPROX. 5mm.
   (水圧試験後にキャップ/ノズル間の溶接部は約5mmまで除去のこと。)
5. WHEN THE CAP REMOVED AFTER HYDRO. TEST, VENT HOLE SHALL BE EXPOSED BY GRINDER.
   ((注意)耐圧試験後、耐圧鏡取外しの際ベントホールを露出させること。)

NOZ. NO.	CAP SIZE	CAP THICKNESS	PART NO.	A	B	C	D	E	F	G	H
B1	NOM.60	t 46.9	8	665.6	<668.6>	65	30	35	18	615.6	25
A1	NPS 24	t 46.5	9	514	<517>	55	40	30	14	—	—
A2 A3 B3	NPS 20	t 46.3	10	412.4	<415.4>	55	30	28	14	—	—
B2	NPS 24	t 46.9	26	514	<516.2>	55	30	30	14	412.4	50.8

1A+1B : WORKING — T.W.= 13182.2 kg

B	A	PART No.	NAME OF PART	MATERIAL	UNIT WEIGHT (kg)	REMARK
	1	26	HYDRO. TEST COVER	SA234 Gr.WPB	NPS 24 / 200	⑧ #204 PYP6365
	1	25	HOOP	SA516 Gr.60	t 50.8 / 32	⑧ #166 PYP5237 CP No.1916
	1	24	BACKUP RING	RUBBER	---- / –	⑧ PYP6208
	1	23	HOOP	SA516 Gr.60	t 25 / 16	⑧ #141 PYP4482 CP No.9692
	6	22	LIFTING LUG	SA387 Gr.11 CL.2	t 13 / 0.5 3	⑩ PYP6167
	1	21	O-RING	RUBBER	---- / –	⑧ PYP6208
1	1	20	DIAPHRAGM GASKET	INCONEL 600	t 15 / 20	⑧ PYP6190
2	2	19	RING JOINT GASKET	SA182Gr.F5/ HB ≤130	R16 (OCTAGONAL) / —	⑧ PYP6202
2	20	18	SPHERICAL WASHER	SA194 Gr.4 EQ.	O.D.100 / 0.6 12	⑧ PYP6201
2	20	17	SPHERICAL WASHER	SA194 Gr.4 EQ.	O.D.110 / 0.8 16	⑧ PYP6201
	20	16	HEX. HEAD BOLT	C.STEEL	M12x20L / 0.04 0.8	⑪ 手配
	20	15	THREAD PROTECTOR	C.STEEL	t 3 / 0.3 6	⑪ 手配
	20	14	THREAD PROTECTOR	C.STEEL	t 3 / 1.6 32	⑪ 手配
2	20	13	NUT	SA194 Gr.7	M64xP3 / 2.7 54	⑧ PYP6201
2	20	12	STUD	SA193 Gr.B16	M64xP3 x545L / 14 280	⑧ PYP6201
SETS 2	SETS 8	11	STUD BOLT & NUT	B : SA193 Gr.B16 N : SA194 Gr.7	3/4"-10UNC x110L / 0.4 3.2	⑧ PYP6201
	3	10	HYDRO. TEST COVER	SA234 Gr.WPB	NPS 20 / 148 444	⑧ PYP6206
	1	9	HYDRO. TEST COVER	SA234 Gr.WPB	NPS 24 / 183	⑧ PYP6206
	1	8	HYDRO. TEST COVER	SA516 Gr.60	NOM.60 (MIN.46.9) / 239	⑧ P998271
	2	7	BLIND FLANGE	SA182 Gr.F11 CL.2	ASME #2500 3/4"-RTJ, BF / 3.6 7.2	⑧ PYP6196
	1	6	BLIND FLANGE		t 246 / 1400	
	2	5	STUB END(16")		ø590 / 643 1286	
	2	4	STUB END(16")		ø660 / 768 1530	
	1	3	STUB END(20")		ø560 / 306	
	1	2	STUB END(24")		ø850 / 1622	⑧ PYP6196
	1	1	BTM. FORGING	SA182 Gr.F11 CL.2	ø1040 / 5490	⑧ PYP6196

W16P00198	MITSUBISHI HEAVY INDUSTRIES, LTD. MCEC AMMONI, REPUBLIC OF TATARSTAN

P.O. NO. : 563410-V0035
PROJECT NAME : TAF PROJECT
ITEM NO. & NAME : 1-E-1503 HOT HEAT EXCHANGER

NOZZLE DETAIL

SCALE 1/15, 1/8, 1/6

Hitz
HITACHI ZOSEN CORPORATION
ARIAKE WORKS

Drawn By	Y. Nishioka	6/17 '11
Prepared By	N. Mitamura	7/13 '11
Reviewed By	R.Shiotsu	7/13 '11
Approved By	R. Nakashima	7/13 '11
Reviewed By QAE		

DATE 6/17 '11 — RELATED SECTION — MANUF. No. W16P00198-02 — SHEET No. — CODE No. — DRAWING No. 871B-22-03-01 (6)

ORDER NO.	565739
PROJECT TEAM	TAF
APPROVED	
SECTION	EQUIPMENT ENG'G Group
APPROVED	
DWG. TITLE	1-E-1503 HOT HEAT EXCHANGER NOZZLE DETAIL
DWG. No.	6417 V322-150300-03

DISTRIBUTION: CONSTRUCT, CCT, PM, CEM, ME, BM, DA/QC, PROCUREMENT, SUBCONT, COST, SCHEDULE, PROCESS, PIPING, EQUIPMENT, STRUCTURE, ELECTRICAL, CIVIL, CONST, FURNACE, INSTRUMENT, REFRIGERANT, MHI-SERVICE, VENDOR

MITSUBISHI HEAVY INDUSTRIES, LTD.

Rev.	Prepared by	Reviewed by	Approved by	Reviewed by Q.A.E.	Description
5	7/20/13	7/20/13	7/20/13		ADDED SHIPPING COVER.
4	N.Mitamura 8/4 '12	T.Chikushi 8/4 '12	T.Chikushi 8/4 '12		CHANGED TOLERANCE OF DIAPHRAGM GASKET.
3	N.Mitamura 6/8 '12	T.Chikushi 6/8 '12	T.Chikushi 6/8 '12		REVISED HYDRO. TEST COVER OF B2 NOZZLE.
2	N.Mitamura 4/3 '12	R.Nakashima 4/3 '12	R.Nakashima 4/3 '12		CHANGED D1 & D2 NOZZLES ORIENTATION.
1	N.Mitamura 12/23 '11	K.Okada 12/23 '11	R.Nakashima 12/23 '11		DELETED NOTE 6 & etc...
0	N.Mitamura 11/21 '11	R.Shiotsu 11/21 '11	R.Nakashima 11/21 '11		FOLLOWED CUSTOMER'S COMMENT & etc...

配布先	A	F
現場	3C ±1R+1R	3C
フリシ	1	1
フリシ1(CP)	1	1
フリヒ	1	1
フリヒ(NDE)	2	2
フリコ(1)	1	1
フリコ	2	2
ﾓﾄﾅｶ(1)	1	1
ﾓﾄｾ	1	1
ﾓﾄｾ(1C)	1	1
ﾓﾄｾ(1H)	1	1
ﾓﾄｾ(K1)	3	3
ﾓﾄｾ(K2)	1	1
ﾓﾄｾ(G1)	3	5
ﾓﾄｾ(G3)	1	1
追加	1	1
計	21+3C	23+3C ±1R