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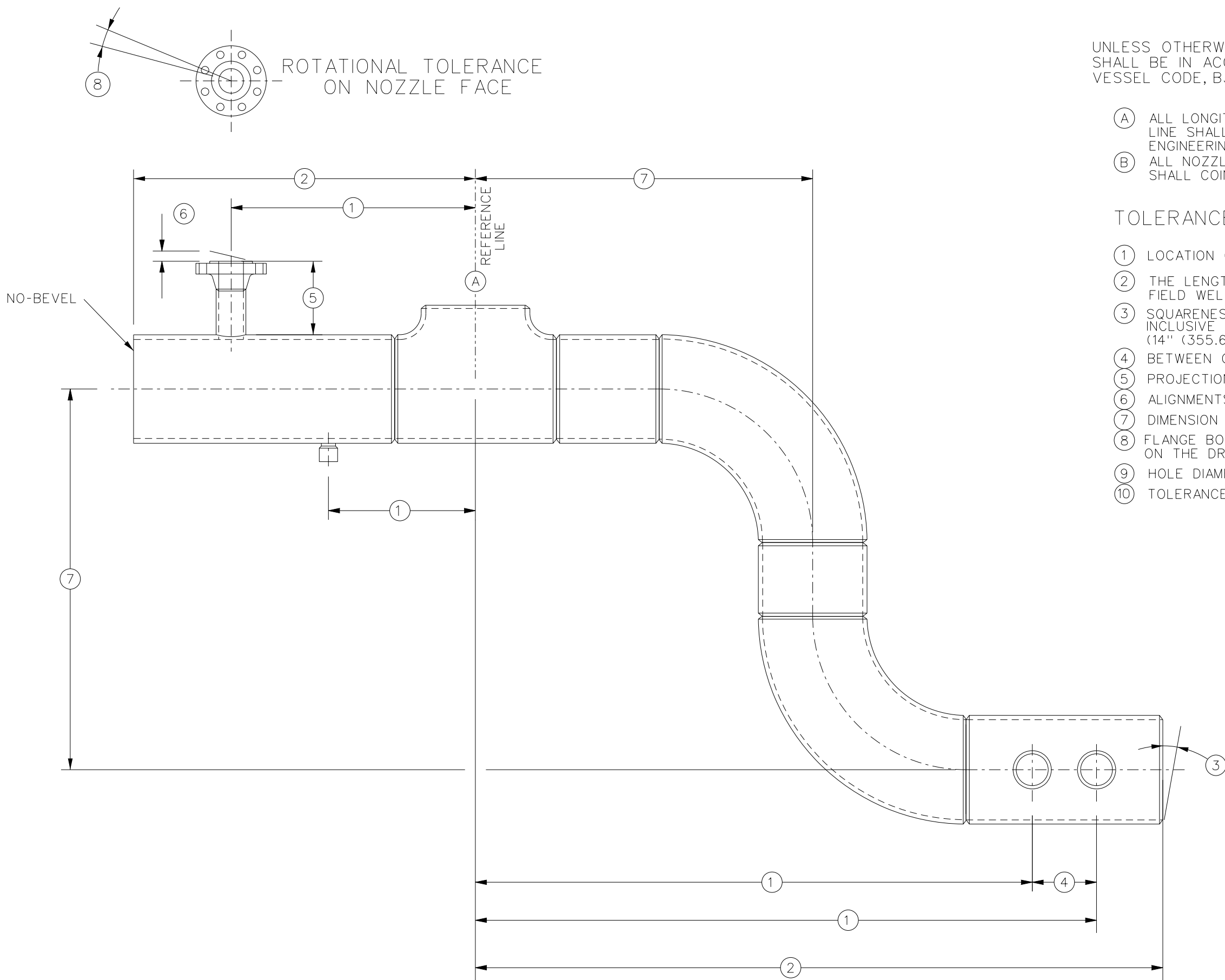
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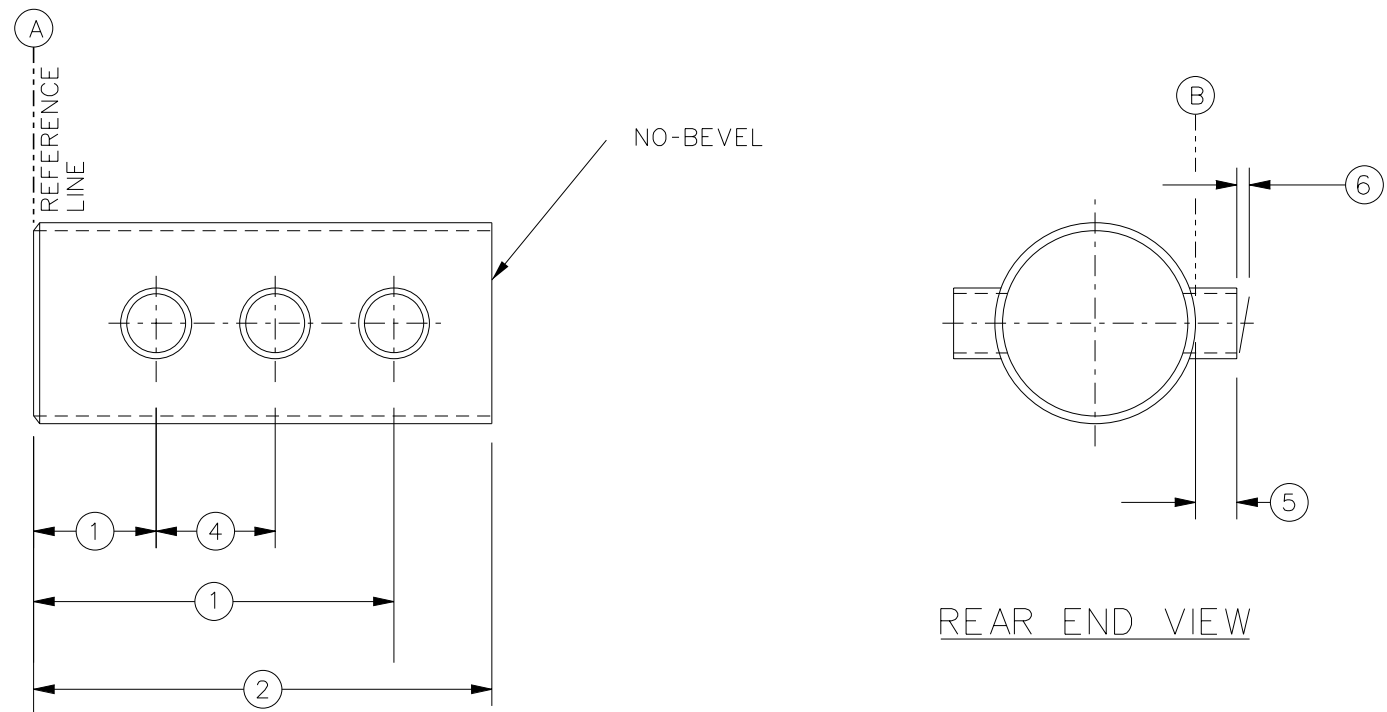


UNLESS OTHERWISE SPECIFIED FOR A PARTICULAR SECTION OF SHOP ASSEMBLED PIPING, TOLERANCES SHALL BE IN ACCORDANCE WITH THE LATEST ADDENDA OF THE ASME/ANSI SECTION 1 BLR AND PRESSURE VESSEL CODE, B31.1 POWER PIPING AND THE REQUIREMENTS LISTED BELOW.

- (A) ALL LONGITUDINAL LOCATING DIMENSIONS SHALL BE MEASURED FROM A REFERENCE LINE. THE REFERENCE LINE SHALL COINCIDE WITH A CONNECTION CENTERLINE OR WITH THE BEVELED END OF A SECTION OF PIPE. ENGINEERING FABRICATION DRAWING TO ESTABLISH THE LOCATION OF REFERENCE LINE.
- (B) ALL NOZZLE HEIGHT PROJECTIONS SHALL BE MEASURED FROM A REFERENCE LINE. THE REFERENCE LINE SHALL COINCIDE WITH THE OUTSIDE SURFACE OF THE PIPE.

TOLERANCES

- (1) LOCATION OF NOZZLES & CONNECTIONS FROM REFERENCE LINE $\pm 1/8"$ ($\pm 3.2\text{mm}$).
- (2) THE LENGTH OF A PIPE SECTION SHALL BE WITHIN $\pm 1/8"$ ($\pm 3.2\text{mm}$) OF THE SPECIFIED DIMINSON WHEN BEVELED FOR FIELD WELDING, AND $\pm 1/2"$ ($\pm 12.7\text{mm}$) WHEN SQUARE CUT.
- (3) SQUARENESS OF BEVELED PIPE END TO BE (2" (50.8mm) - 5" (127mm) INCLUSIVE $\pm 1/16"$ ($\pm 1.6\text{mm}$)), (6" (152.4mm)-12" (304.8mm) INCLUSIVE $\pm 3/32"$ ($\pm 2.4\text{mm}$)), (14" (355.6mm) AND ABOVE $\pm 1/8"$ ($\pm 3.2\text{mm}$)).
- (4) BETWEEN CENTERLINES OF NOZZLES $\pm 1/8"$ ($\pm 3.2\text{mm}$).
- (5) PROJECTION OF NOZZLE FACE FROM THE SURFACE OF THE PIPE $\pm 1/16"$ ($\pm 1.6\text{mm}$).
- (6) ALIGNMENTS OF FACES OF NOZZLES AND CONNECTIONS $\pm 1/16"$ ($\pm 1.6\text{mm}$).
- (7) DIMENSION FROM CENTERLINE TO CENTERLINE OF PARALLEL RUNS OF PIPE $\pm 1/8"$ ($\pm 3.2\text{mm}$).
- (8) FLANGE BOLT HOLES $\pm 1^\circ$ MAX. OUT OF POSITION (ROTATION). UNLESS OTHERWISE SPECIFIED ON THE DRAWING, ALL FLANGE BOLT HOLES TO STRADDLE NORMAL PIPING CENTERLINES.
- (9) HOLE DIAMETER TOLERANCES $+ 1/16"$ ($+ 1.6\text{mm}$), $-0"$ (-0mm).
- (10) TOLERANCE ON ANY DIMENSION NOT SPECIFIED ABOVE OR IN THE CODE SHALL BE $\pm 1/8"$ ($\pm 3.2\text{mm}$).



NOTE:
TOLERANCES ARE FOR FINISHED WELDED PRODUCT WHICH MAY NOT BE APPLICABLE FOR FIT-UP TOLERANCES PRIOR TO WELDING.

00	FIRST ISSUE	22-SEP-15	SP	REEVES		FRY
Rev.	Description	Date	Drawn	Chkd. 1	Chkd. 2	Appr.

Revisions

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MIDDLETOWN ENERGY CENTER
and
KINGS MOUNTAIN ENERGY CENTER
for
NTE ENERGY and GEMMA POWER SYSTEMS
VOGT POWER PROJECTS V17494 & V17495

3rd ANGLE PROJECTION
Scale:
NONE

Title
STANDARD FABRICATION TOLERANCES
FOR
SHOP ASSEMBLED PIPING

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Internal Drawing Status FOR RECORD	Size C	Drawing No. V17494-EBND-0107	Rev. 00
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APPLIES TO:
V17494 MIDDLETOWN PROJECT
V17495 KINGS MOUNTAIN PROJECT