

GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261	3	4
--	---	---

LIBRARY NO	SIGNATURE
------------	-----------

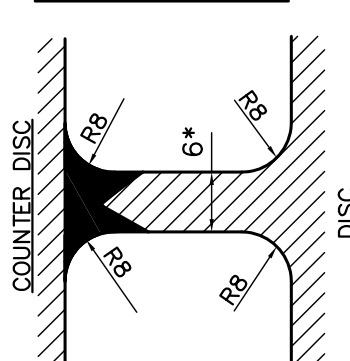
GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261	3	4
--	---	---

DETAIL-X

Detail-X



SECTION W-W



DETAILS OF PREPERATION AND
WELDING AS PER TC 72022

* MAINTAIN A POSITIVE ALLOWANCE OF 0.5mm AFTER MILLING OF BLADES i.e 6^{+0.5}/_{-0.8}TO COMPENSATE FOR BLADE THICKNESS REDUCTION DURING HEAT TREATMENT AND GRINDING.

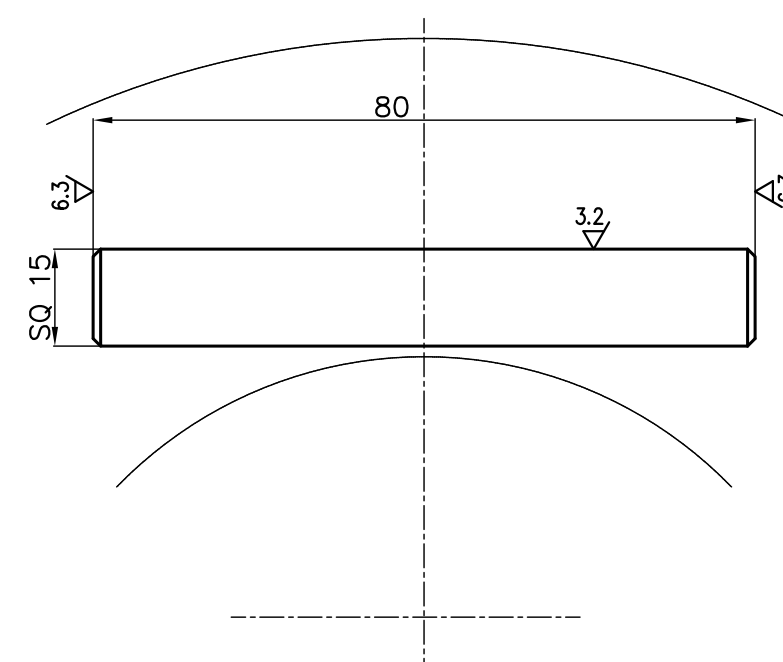


FIG-E

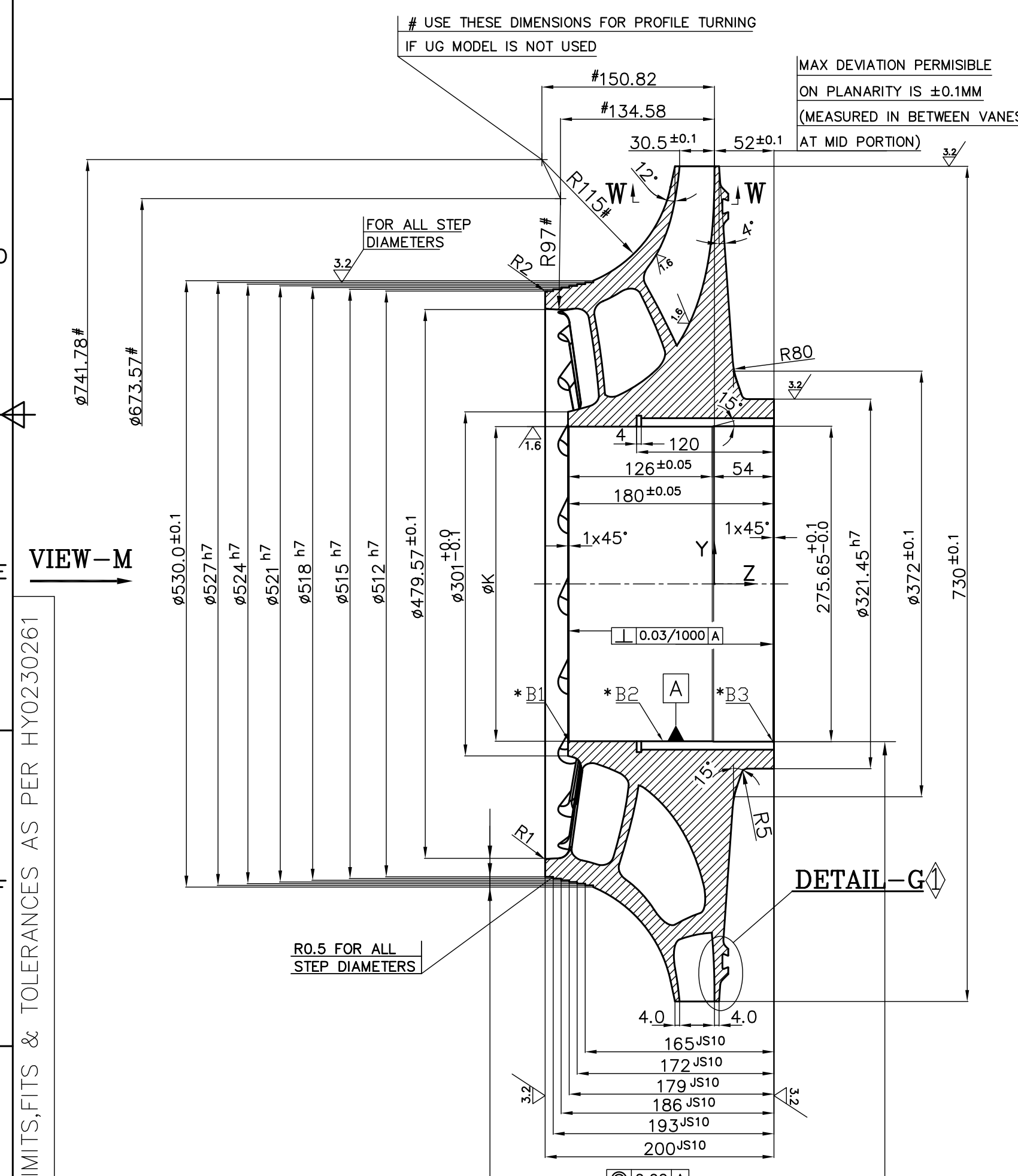
VAR. NO.	MATERIAL	YIELD STRENGTH	WPS. NO.	ØK
01	HY 19395	68-80 Kg/mm ²	WE-137	Ø275H7
02	HY 19395	85-105 Kg/mm ²	WE-138	Ø275H7
03	HY 19395	80-95 Kg/mm ²	WE-162	Ø275H7
04	HY 19395	>105 Kg/mm ²	WE-139	Ø275H7

NOTE

1. FOR BLADE PROFILE REFERENCE THE UG MODEL PROVIDED. ALSO REFER TC92961
2. PERFORM OVERSPEED TEST OF THE IMPELLER AS PER INSPECTION AND TESTING DOC AND CHECK THE DIAMETERS BEFORE AND AFTER THE TEST.
3. REFER INSPECTION AND TESTING DOC FOR HEAT TREAT THE MATERIAL SO AS TO ATTAIN REQUIRED YIELD STRENGTH (KG/mm²) AND AN IMPACT STRENGTH (KG-m/cm²) AT SPECIFIED TEMPERATURE (CHARPY 'U' NOTCH)
4. DYE PENETRANT TEST SHALL BE CONDUCTED AT SPECIFIED STAGES OF MANUFACTURE AS SPECIFIED IN TECHNOLOGICAL PROCESS
5. DYNAMIC BALANCING OF IMPELLER TO BE PERFORMED.
6. SEQUENCE OF OPERATION FOR PRODUCTION AND INSPECTION OF THE IMPELLER AS PER TECHNOLOGICAL PROCESS
7. STAGE INSPECTION/TEST AS PER TECHNOLOGICAL PROCESS.
8. GEOMETRIC TOLERANCES ARE THE MAX. READ ON THE COMPARATOR.
9. THE K VALUES MUST BE INSIDE TOLERANCE LIMITS AFTER OVER SPEED TEST.
10. DIMENSIONS TO BE TAKEN ON ØK IN THE AREAS
 - * B1 - GAS ENTRANCE
 - * B2 - CENTRAL
 - * B3 - OPPOSITE TO GAS ENTRANCE
11. TWO MILLINGS DIAMETRICALLY OPPOSITE TO FACILITATE BALANCING WEIGHTS ASSEMBLY, THE MILLINGS SHALL BE AT 90° W.R.T IMPELLER KEYWAYS, SLOT MILLING SHALL BE CARRIED OUT AFTER KEYWAY MILLING.

CAUTION

INTERCHANGEABLE JOB
NO DEVIATION PERMITTED



SECTION P-F

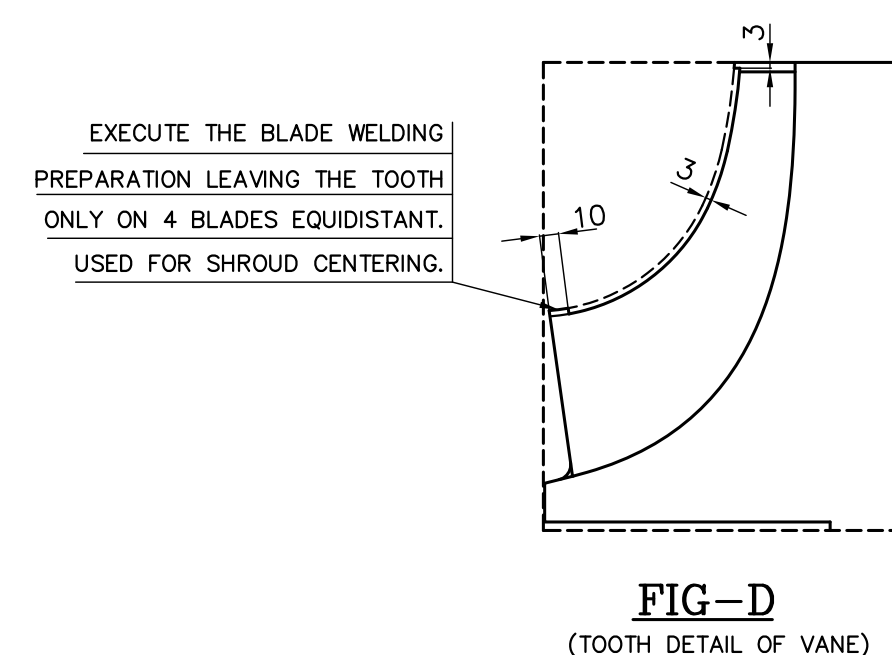
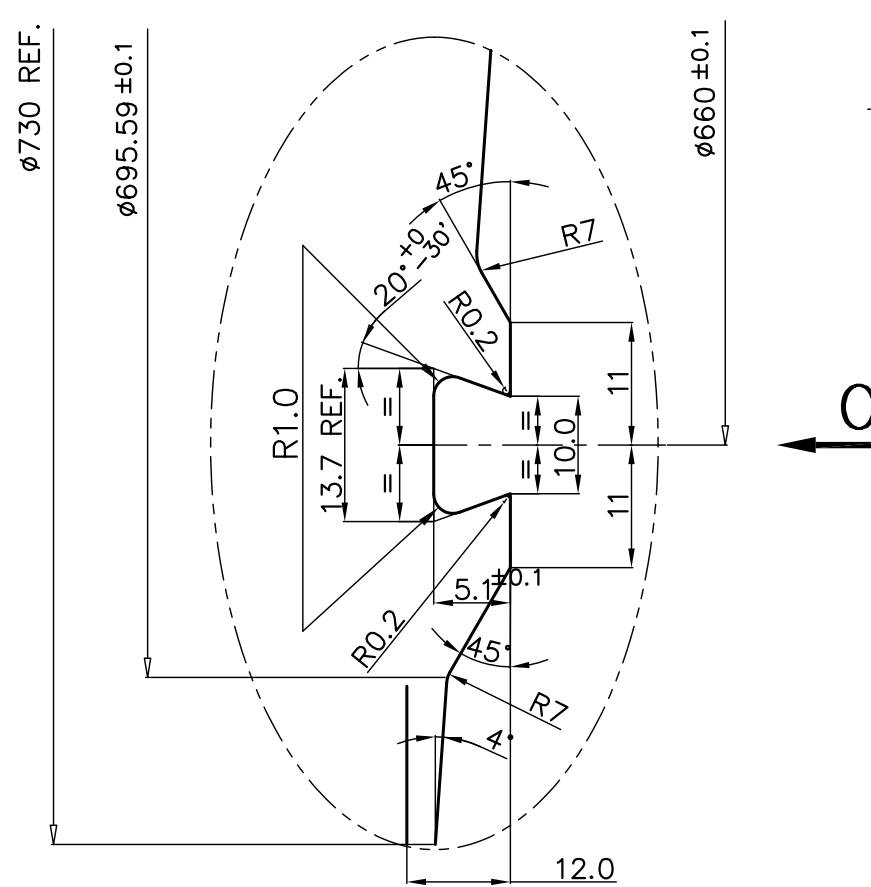
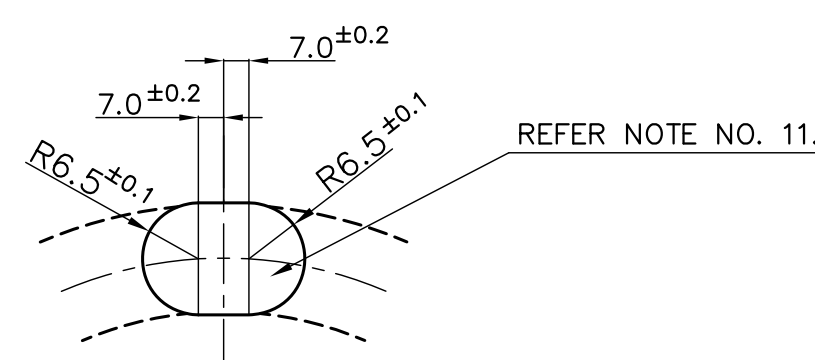


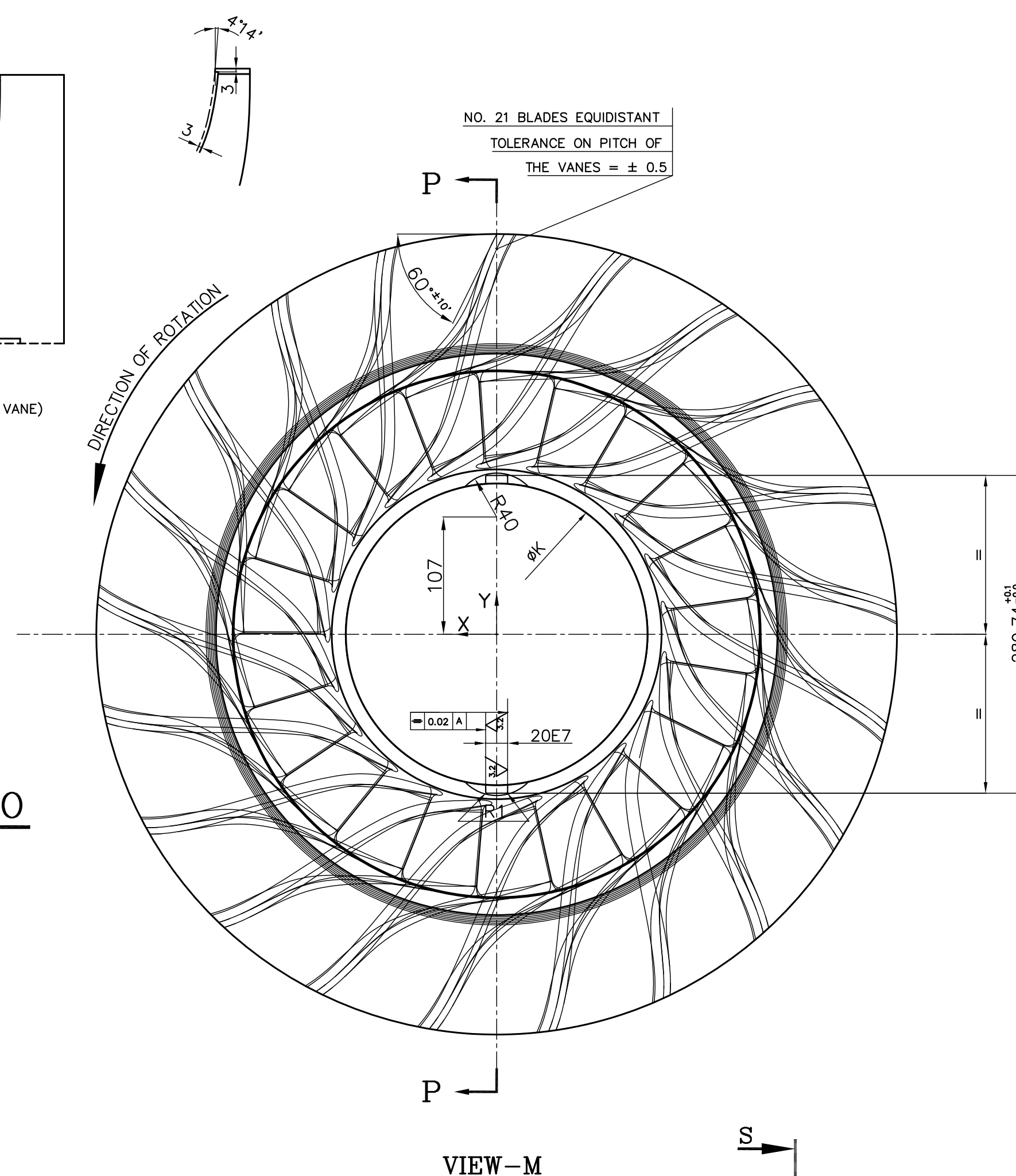
FIG-D
BOTH DETAIL OF VANE



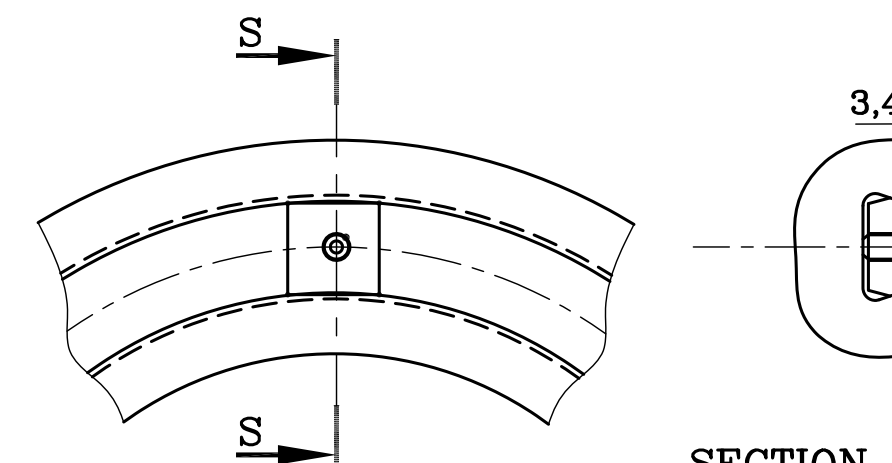
DETAIL-G



VIEW-0 ①







VIEW—M



SECTION S-S

 DETAILS OF BALANCING BLOCKS
(REFER TC72071 FOR PROCEDURE FOR ADDING BALANCING WEIGHTS)

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT					NAME		SIGNATURE	DATE	NO. OF VAR.
 BHARAT HEAVY ELECTRICALS LTD. HYDERABAD					DRN.	HARI		22.07.16	
					CHD.	YVRL		17.10.16	
					APPD.	SDR		17.10.16	
DEPT. COMPR	UNTOL. DIMS. GR.		SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEMS		
CODE.			NTS	150			—N.A.—		
420									
TITLE <u>IMPELLER T60 Ø730 CCW</u> <u>(FOR HY19395)</u>					CARD NO.	DRAWING NO. 1-332-10-01049		REV. 01	