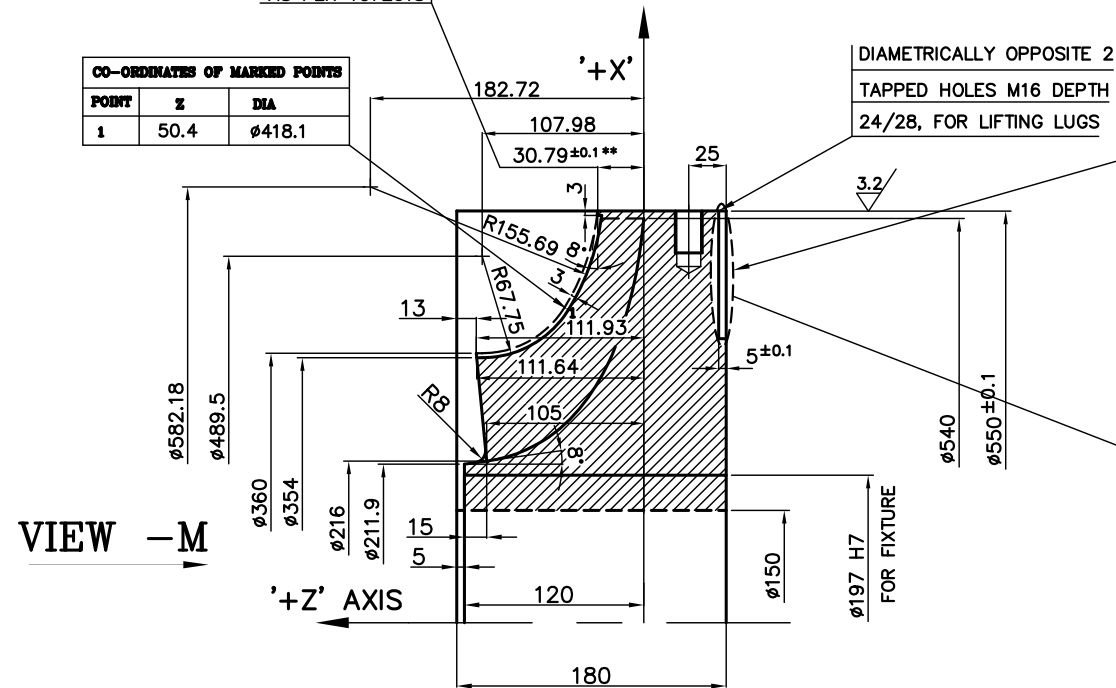


DRG. NO. 3-332-10-00013

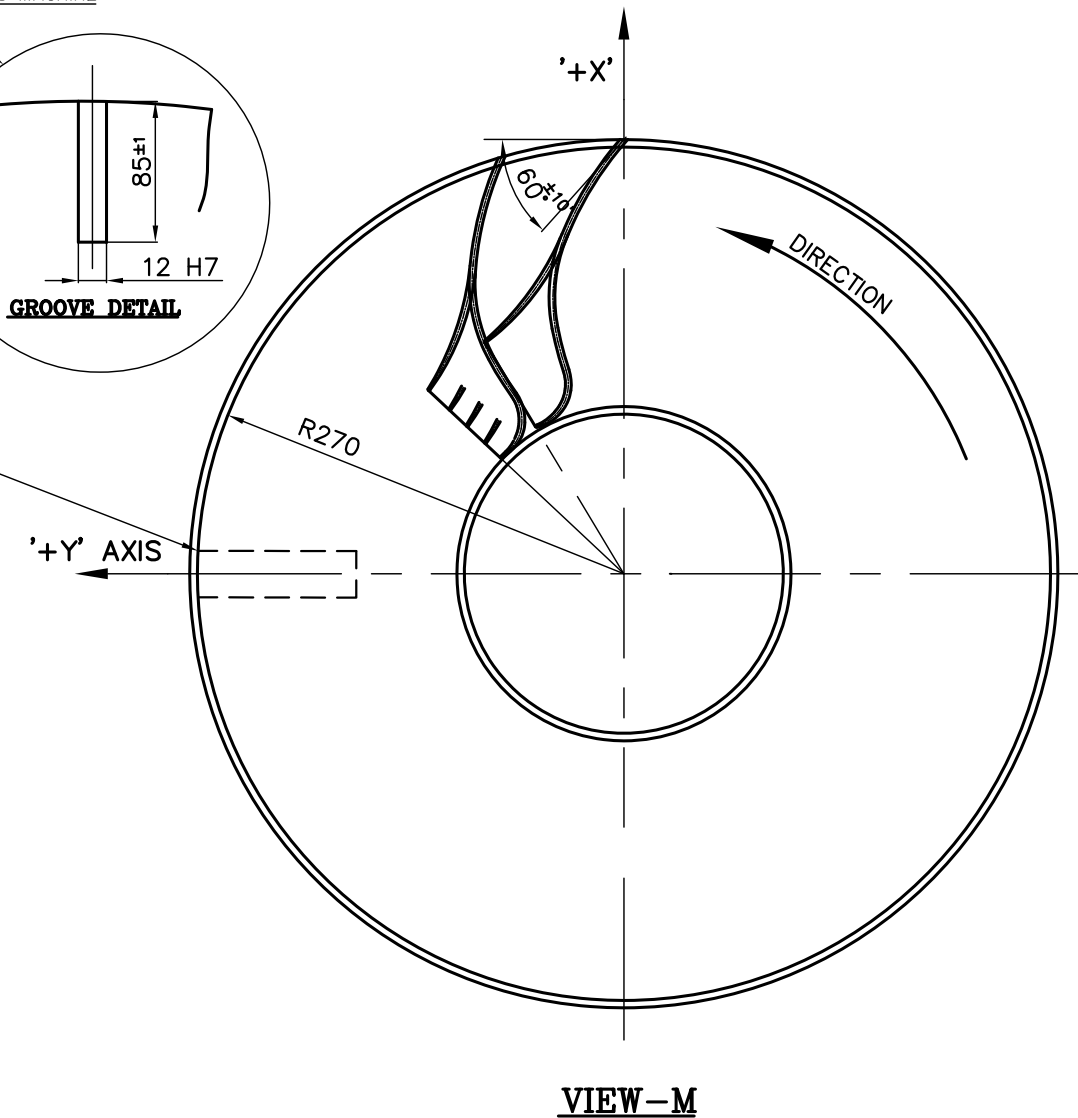
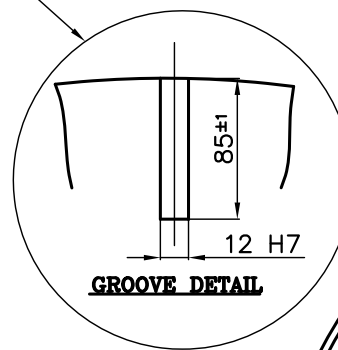
SH' DF

INCLUDING SHRINKAGE ALLOWANCE OF 0.5mm
AS PER TC72018

| CO-ORDINATES OF MARKED POINTS | | |
|-------------------------------|------|--------|
| POINT | Z | DIA |
| 1 | 50.4 | ø418.1 |



GROOVE FOR
LOCATING ON
5-AXIS MACHINE



NOTE:


1. FOR VANE MILLING OPERATION REFERENCE AXES ARE MARKED ON THE DRAWING. DIMENSION MARKED ** SHOWS POSITION OF X-Y PLANE. THIS DIMENSION SHALL BE MAINTAINED.
2. USE THIS DRAWING FOR MOCK UP MILLING OF ONE SET OF BLADES ON A C.S PLATE TO PROVE 3D BLADE MILLING PROGRAME BEFORE TAKING UP ACTUAL JOB.
3. BLADE GEOMETRY IS AS PER THE UG MODEL PROVIDED ALSO REFER JOE
4. REFER DRAWING 13320804701 FOR JOB IMPELLER DETAILS

| | |
|--------------------------|----------------|
| TYPE OF PRODUCT OR | 2MCL 527 |
| NAME OF CUSTOMER/PROJECT | M/S HPCL VIZAC |



BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

| | NAME | SIGN. | DATE | NO.OF VAR. |
|-------|------|-------|----------|---------------|
| DRN. | HARI | | 18.02.17 | |
| CHD. | YVRL | | 18.02.17 | |
| APPD. | SDR | | 18.02.17 | -N.A.- |

| | | | | | | | |
|-----------------|--|---|----------------|--------------------|------------------------------|---|--------------------------|
| DEPT. COMPR. | UNTOL. DIMS. GR. C/M/F |  | SCALE N.T.S | WEIGHT (KG) 310 | REF. TO ASSY. DRG. -N.A.- | ITEM NO. -N.A.- | NO.OF ITEMS -N.A.- |
| CODE 420 | TITLE <u>MOCK UP 3D IMPELLER</u> <u>Ø540 T60 CCW</u> | | | | CARD CODE N.A. | DRAWING NO. 3-332-10-00013 REV. 00 | |
| | | | | | SHT. No 01 | NO. OF SHT. 01 | |