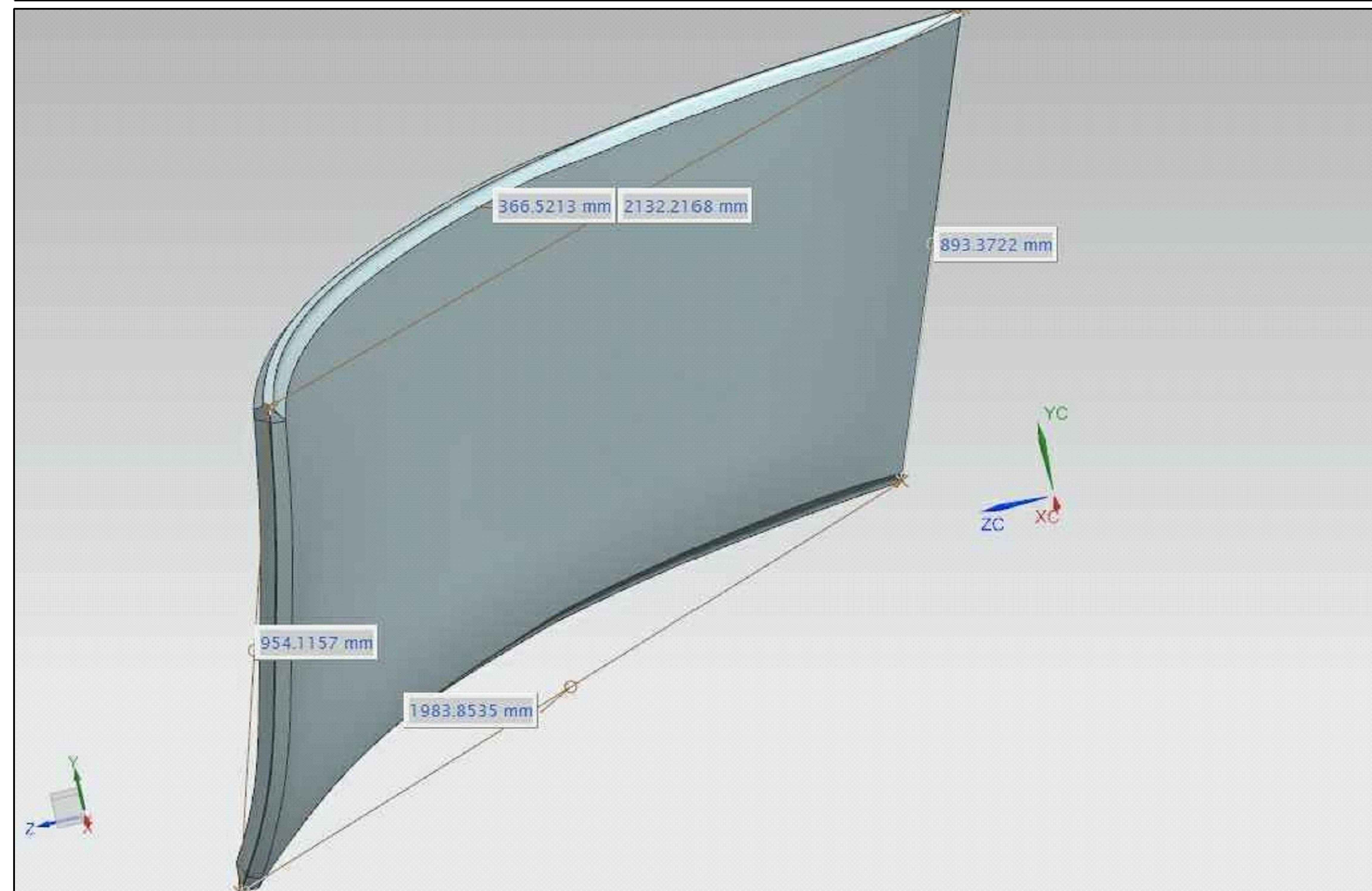
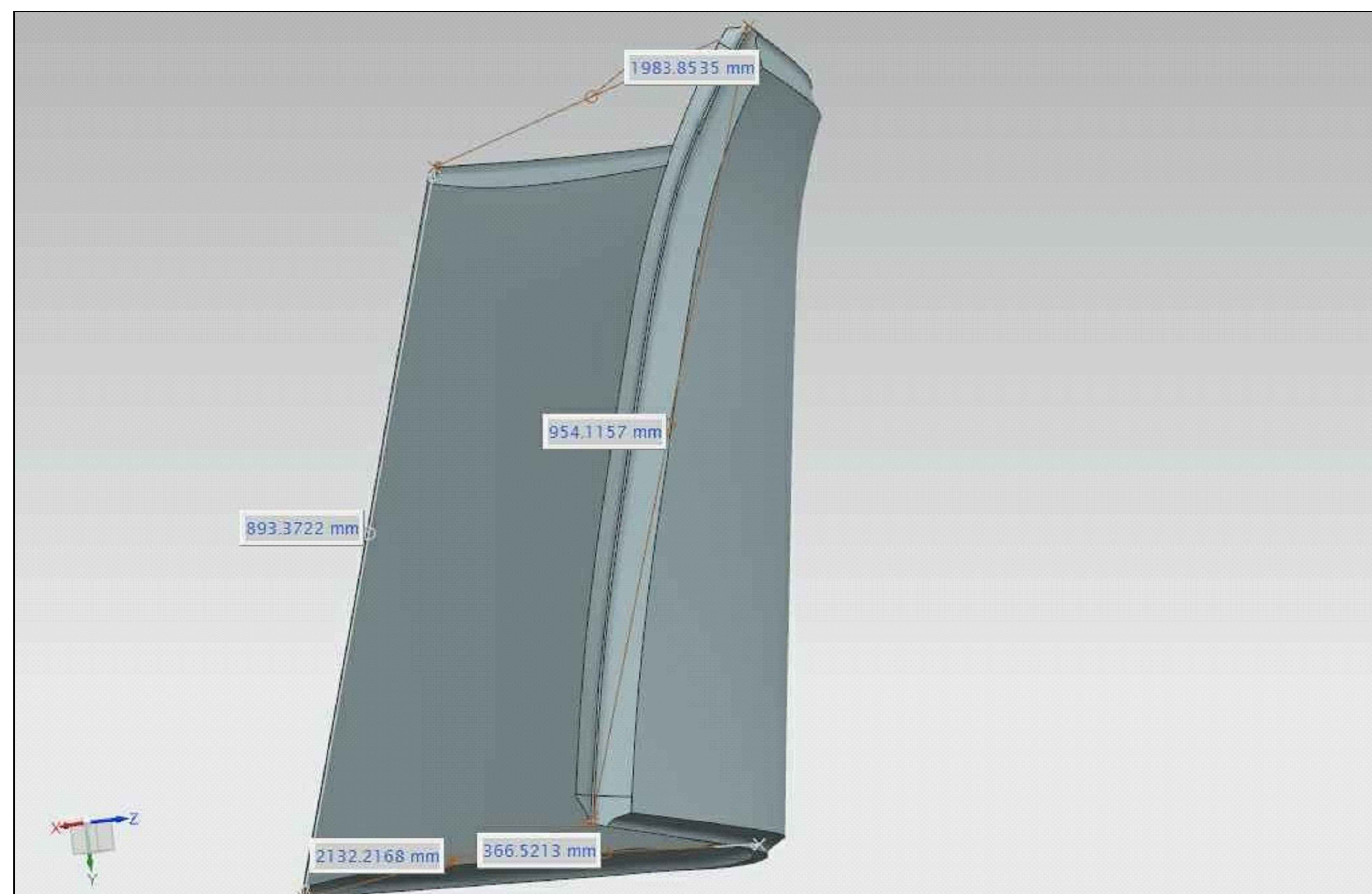
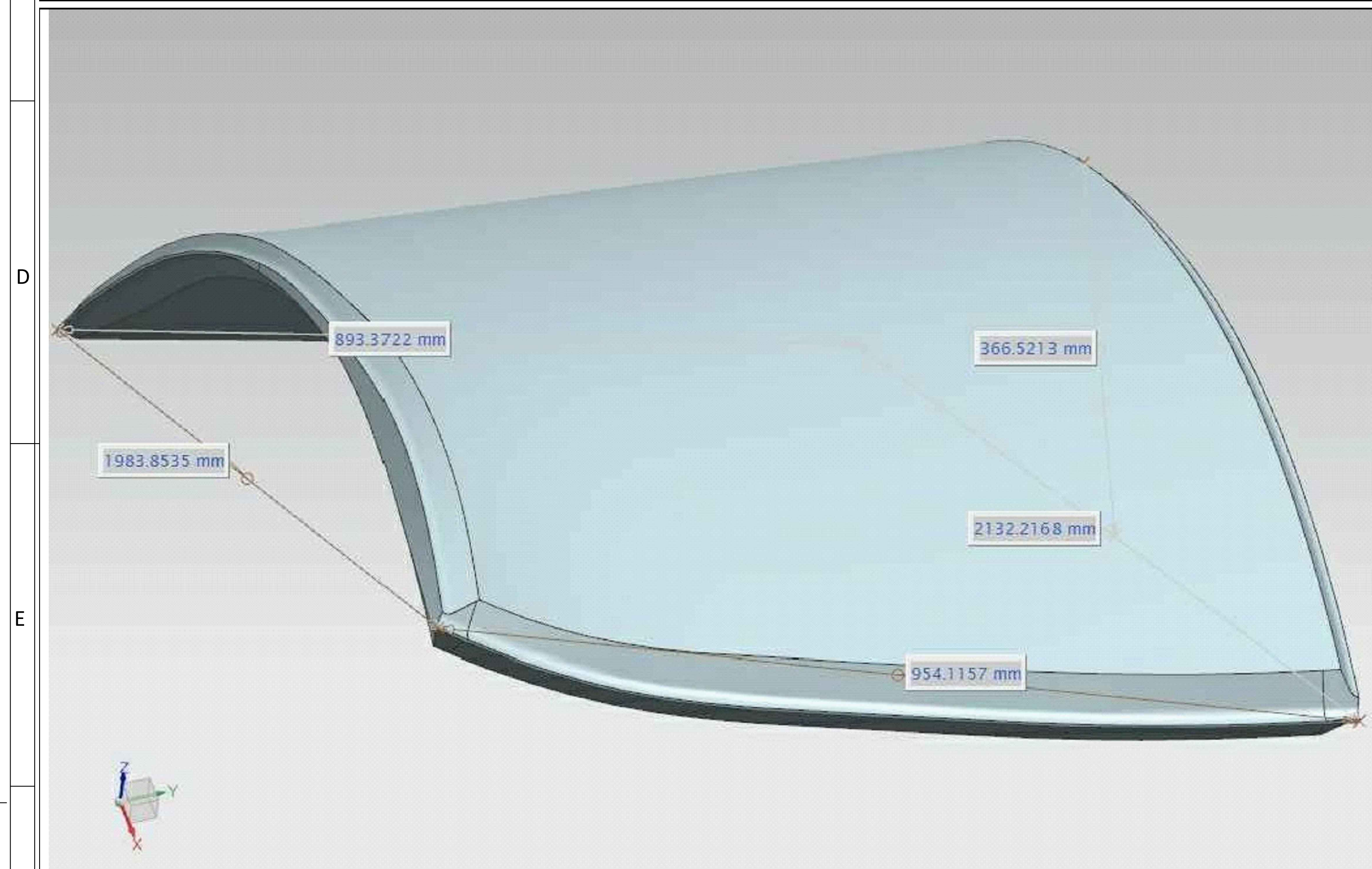
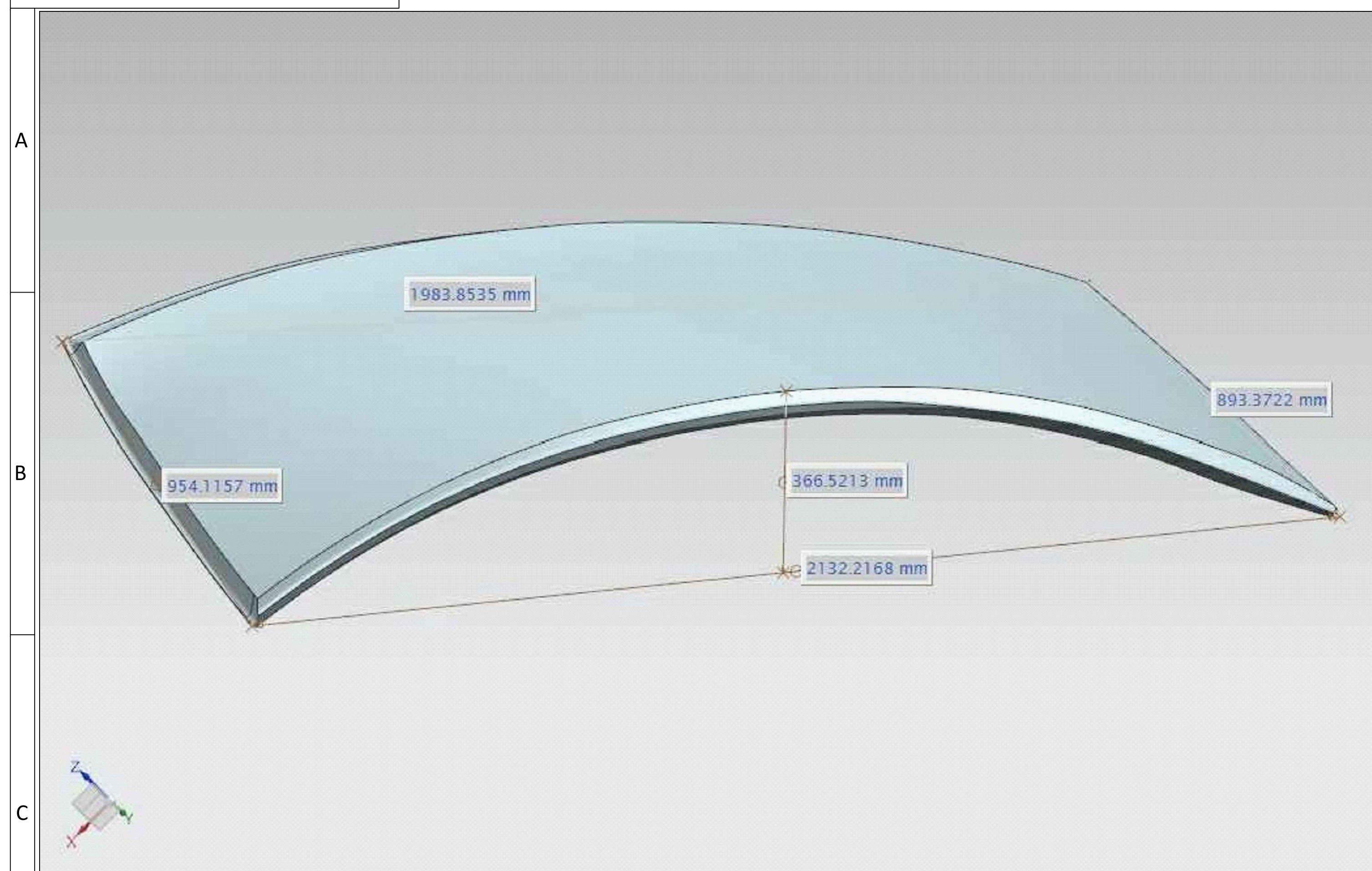


DRG. NO. 1 204 07 21201



1. MATERIAL – IMPELLER BLADE IS OF STAINLESS STEEL CASTING (13% CR-4% NI) TO ASTM A743 CA6NM.
2. CONDITION OF DELIVERY FROM CASTING SUPPLIER –
 - a. IMPELLER BLADE SHALL BE SPLIT AND SUPPLIED IN TWO PARTS .
 - b. IMPELLER BLADE CASTINGS SHALL BE FURNISHED FOR MACHINING IN HEAT TREATED & ROUGH GROUND CONDITION HAVING APPROX. 19–21 MM MATERIAL ALL AROUND.
3. DELIVERY CONDITION FOR MACHINING SUPPLIER –
 - a. FINISH MACHINED PROFILE & THICKNESS OF BLADE SHALL BE IN LINE WITH PROFILE DRAWING NO. 02040070301 REV 01.
 - b. EDGE PREPARATIONS FOR WELDING WITH CROWN & SKIRT ARE TO BE MACHINED AS PER SECTIONS P1P1, P2P2 & Q1Q1, Q2Q2 RESPECTIVELY.
 - c. EDGE PREPARATIONS FOR WELDING AT SPLIT FACE ARE TO BE MACHINED AS PER SECTION ZZ.
 - d. MACHINING SHALL BE CARRIED OUT ON ALL SURFACES.
 - e. SURFACE FINISH OF FINISH M/C BLADE SHALL BE 3.2 OR BETTER.
 - f. VENDOR SHALL MANUFACTURE THREE SETS OF TEMPLATES. ONE SET OF TEMPLATES SHALL BE USED BY VENDOR FOR CHECKING THE PROFILE AT HIS WORKS (AS PER INSPECTION SHEET). OTHER TWO SET SHALL BE SUPPLIED TO BHEL–BHOPAL ALONG WITH FIRST SET OF BLADES.
4. INSPECTION–
 - a. INSPECTION SHALL BE CARRIED OUT AS PER INSPECTION SHEET & SCHEME APPROVED BY BHEL.
 - b. NUMBER OF TEMPLATES SHALL BE MANUFACTURED AS PER INSPECTION SHEET.
 - c. TEMPLATE SHALL BE PUNCHED MARKED WITH DRAWING NO., PRESSURE SIDE/SUCTION SIDE, SECTION NO. ETC.
 - d. TEMPLATES FOR NOSES, SUCTION & PRESSURE SIDE OF FINISH BLADE SHALL BE GENERATED BY MANUFACTURER & GOT VERIFIED BY BHEL BEFORE INSPECTION.
 - e. CO–ORDINATE POINTS OF THE BLADE SHALL BE MEASURED FOR BOTH PRESSURE & SUCTION SIDE (TOLERANCE $\pm 1\text{MM}$)
 - f. LINES ALONG INSPECTION/REFERENCE SECTIONS ON BOTH SURFACES SHALL BE MARKED AT MACHINING STAGE IN THE SAME SETTING BEFORE UNLOADING BLADE SEGMENT.
 - g. REFERENCE POINTS OR LINES ON EDGE SURFACES CORRESPONDING TO CROWN & SKIRT SIDES SHALL BE MARKED.
 - h. EDGE TO EDGE DIMENSION & DIAGONALS OF BLADES SHALL BE MEASURED & RECORDED.
 - i. FINISH MACHINED BLADES SHALL NOT HAVE ANY MARKS OF LIFTING/HANDLING/SLING.

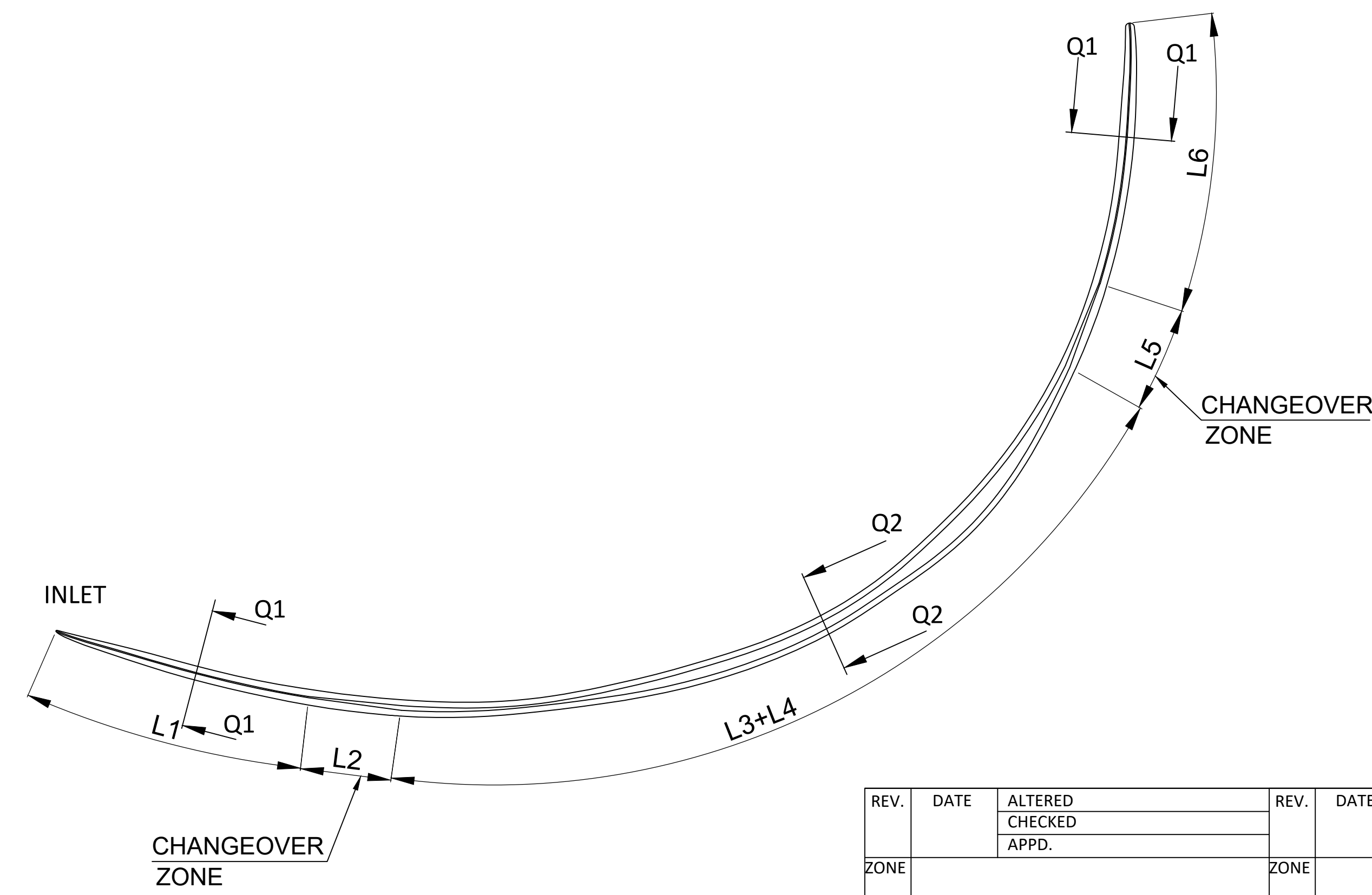
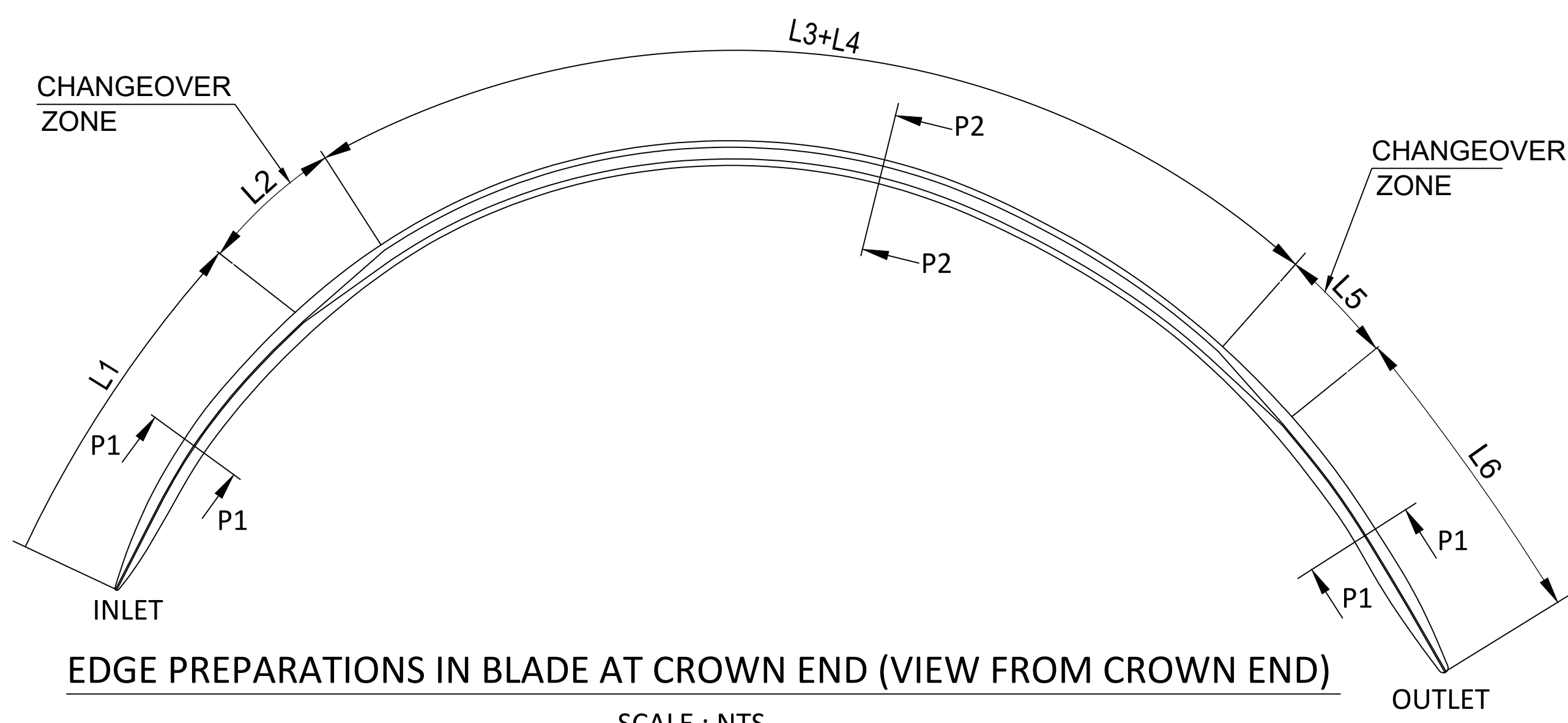
APPROX. CASTING WEIGHT OF PART-1 =1490 kg APPROX
MACHINED WEIGHT OF PART-1 =781 kg
TOTAL SURFACE AREA OF BLADE PART 1IN FINISH MACHINED CODITION = 3.933 SQ. M

APPROX. CASTING WEIGHT OF PART-2 =2020 kg APPROX
MACHINED WEIGHT OF PART-2 =1082 kg
TOTAL SURFACE AREA OF BLADE PART 2 IN FINISH MACHINED CODITION = 5.346 SQ.M

REFERENCE DRAWING FOR CASTING – 02040721203

BLADE PART-I

OUTLET



INLET	L1	L2	L3+L4	L5	L6	TOTAL
CROWN	900	150	2035	150	825	4060
SKIRT	1000	150	2450	150	825	4575

WELDING GROOVE AND LENGTH OF WELD SEAM

SCALE-NTS

[illegible]

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