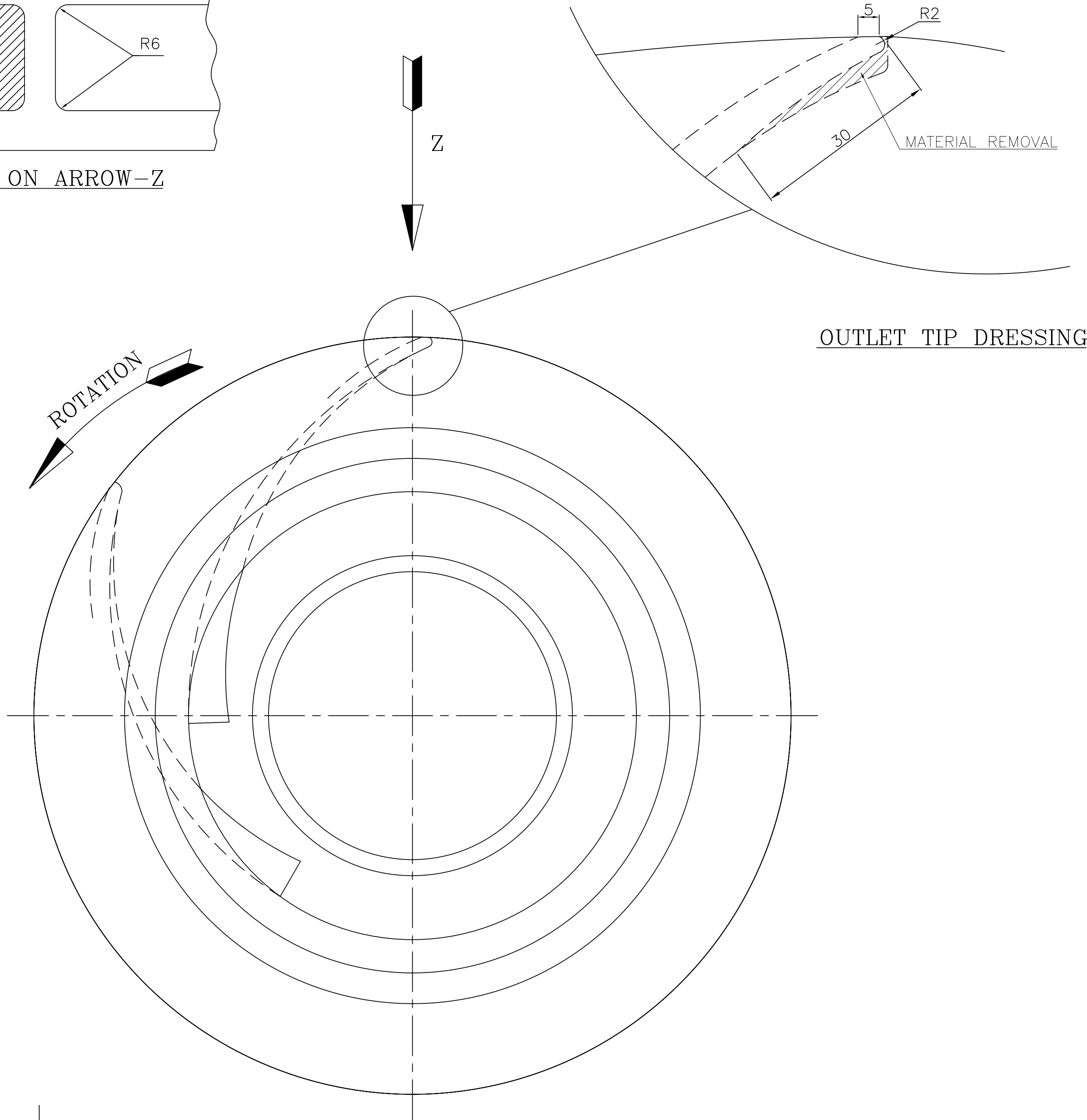
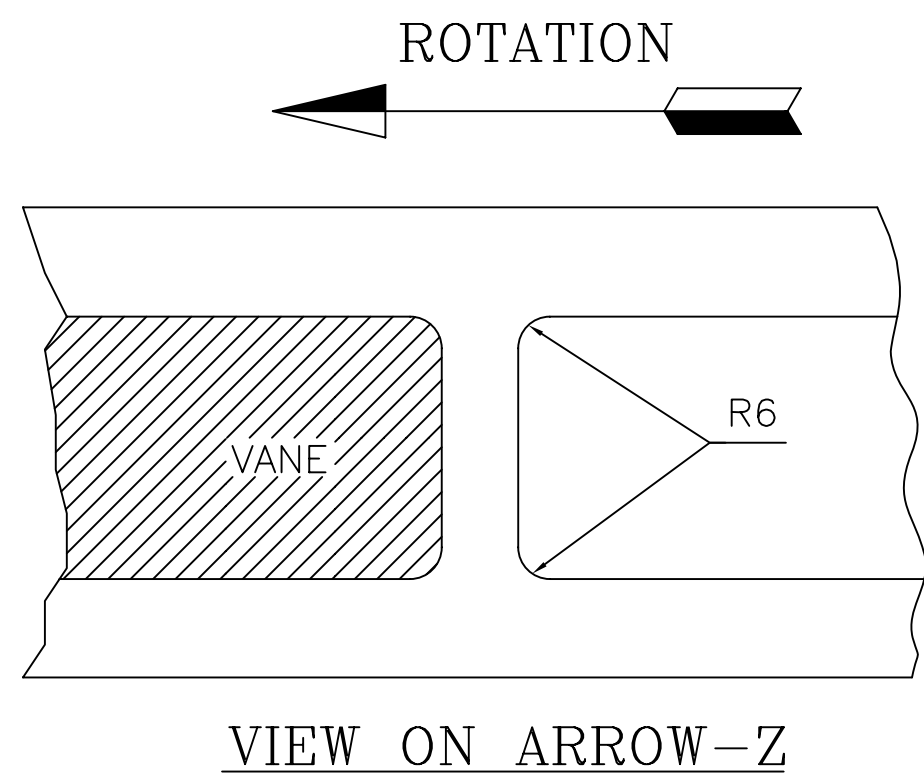




NOTE TO M/C SHOP:-

1. REFER DRG.NO. 1180 40 2 3282 FOR PROOF M/C DETAILS.
2. REFER DRG.NO. 0 180 40 2 3239 FOR HYDRAULIC DETAILS.
3. REFER DRG.NO. 0 180 40 1 3237 FOR ASSLY & FINAL M/C.
4. LPI TO BE DONE ON ALL ACCESSIBLE AREAS AS PER AA0850131 AND ACCEPTANCE AS PER AA0850132, LEVEL-II.
5. TRANSFER HEAT NO / MELT NO IF MACHINED DURING M/C
 ® PLACE FOR HEAT NO/MELT NO

(+ +) POLISH BLADE INLETS
TO CLASS DI, ON FACE
OF BLADES OVER FIRST
30MM
AS PER CSD 1046 (FP70034)

				CASTING M-180-0928	FP9219324059 BS 1504-425-C11	20.00	22.0
ITEM NO.	DESCRIPTION	DRAWING NO.	VAR NO.	RAW MATERIAL SIZE OR CASTING DRG. NO. OR FORGING DRG. NO.	MATERIAL SPEC.	UNIT WT.	GROSS WT
					QUANTITY		

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED.				TYPE OF PRODUCT NAME OF CUSTOMER/PROJECT				FK4E36																	
1. REF. TO HY022641 FOR UNSPECIFIED TOLERANCES.				BHARAT HEAVY ELECTRICALS LIMITED HYDERABAD				NAME		SIGN.		DATE		NO. VAR.											
2. CHAMFER W/COD. SHARP EDGES 1.2 TO 1.0 AT 45°.								DRN.		ACAD				22.06.84											
3. INTERNAL W/COD. CORNER RADI 1 TO 0.7								CHD.		T.S.R.				22.06.84		NA									
4. THE SURFACE ROUGHNESS WHERE-I-NOT SHOWN SHALL BE TAKEN FROM THE SURFACE RECOMMENDATION STATE SIZE THE BACK SLASH GIVEN OR THE TOP MOST RIGHT CORNER OF THE DRG.								APPD.		J.G.C.				22.06.84											
DEPT.		PUMPS				SCALE		WEIGHT (KG)		REF. TO ASSY. DRG.				ITEM NO.		NO. OF ITEMS									
CODE		410		1:1		20.00		0				R1804013237				15/1		REV.							
TITLE				IMPELLER, 1st STAGE MACHINING										DRAWING NO.				0 180 40 1 3238				06			
4				3				2				1				SHEET NO. 01				NO OF SHEETS				01	

