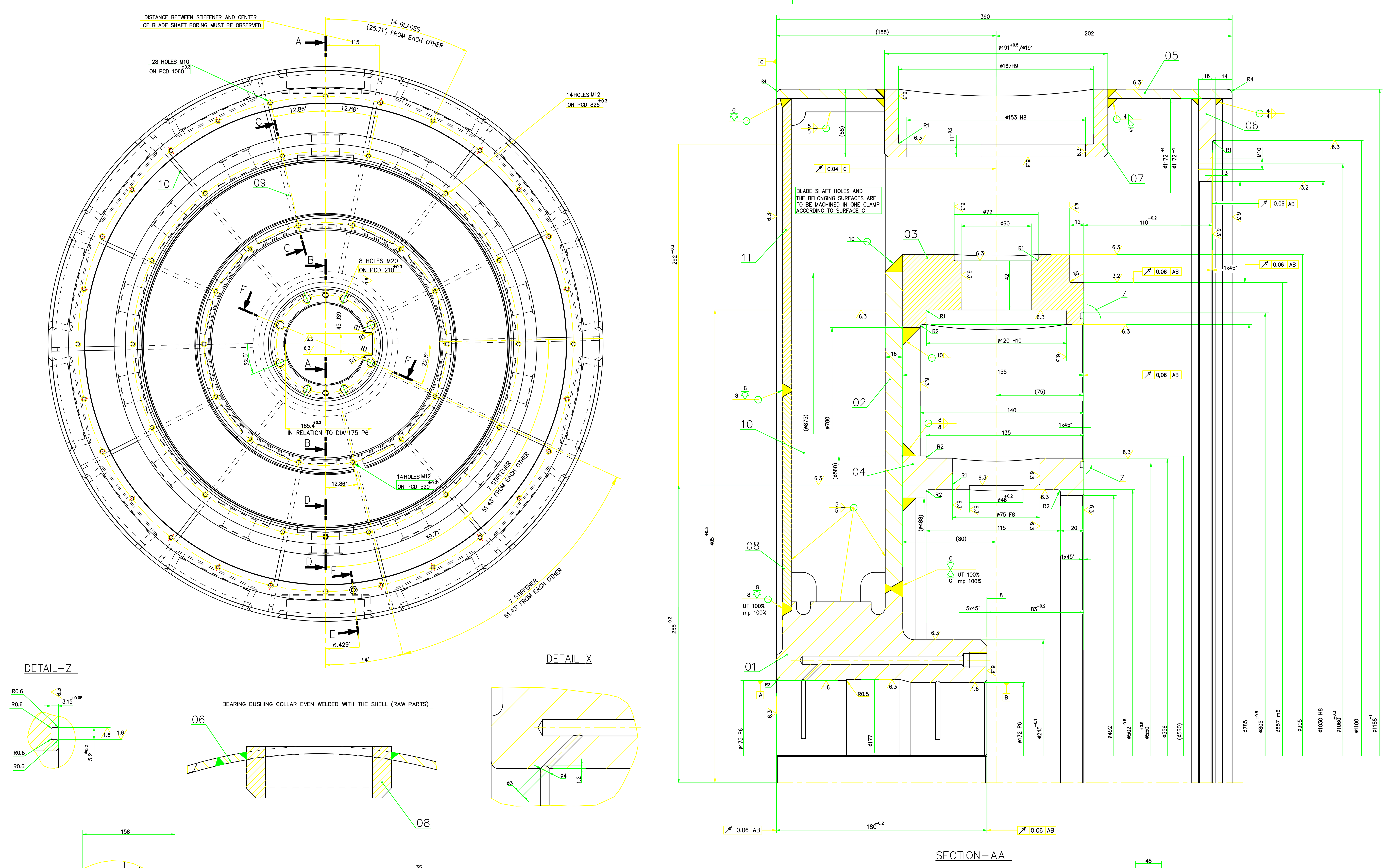
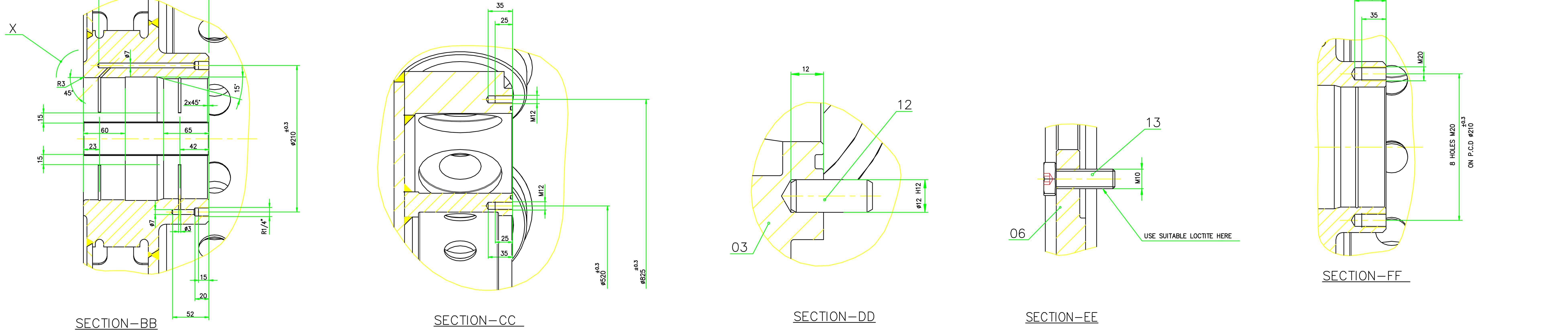
ALL DIMENSIONS ARE IN MILLIMETRES

FOR PRODUCTION
REF. PR:QA:590 FOR PAINTING
REF. PR:QA:500 FOR UNTOL. DIMNS.
REF. APPLICABLE GMS FOR MATCODE&SPEC.





DIMENSION	TOLERANCE
ø1030H8	+0.165 0.000
ø857m6	+0.090 +0.034
ø175 P6	−0.036 −0.061
ø172 P6	−0.036 −0.061
ø167 H9	+0.100 0.000
ø153 H8	+0.063 0.000
ø120 H10	+0.140 0.000
ø75 F8	+0.076 +0.030
45 JS9	+0.031 −0.031

STRESS–FREE ANNEALING:

01. HOLDING TEMPERATURE: 580–620°C
02. HOLDING TIME: 45 min
03. HEATING RATE: 40–50°C/H
05. COOLING RATE: MAX.80°C/H

NOTES

01. NON DIMENSIONED EDGES ARE TO BE CHAMFERED BY 0.5X45°
02. NON DIMENSIONED FILLETS ARE TO BE ROUNDED TO R0.5
03. 100% US–TESTING IS TO BE DONE BEFORE STRESS FREE ANNEALING
04. 100% MP–INSPECTION IS TO BE DONE AFTER STRESS FREE ANNEALING
05. QUALITY OF THE WELDING IS ACCORDING TO "DIN 856.3 QUALITY GROUP B"
06. IF NO QUALITY GROUP IS INDICATED IT MUST BE DESIGNED ACCORDING TO EN 25817, ATLEAST QUALITY GROUP B
07. PART TO PART WELD IS 4 ◺ / 4 ⊸ UNLESS OTHER WISE SPECIFIED
08. ASSEMBLY AND WELDING SEQUENCES ARE ACCORDING TO : SV002.

DATA FOR BALANCING ACCORDING TO KM 007:

01. MAX.OPERATING SPEED N=990 $(min)^{-1}$
02. ADMISSIBLE RESIDUAL UNBALANCE ACC.TO Q1.6= 4308 (gmm) PER PLANE
03. IMPELLER WEIGHT G=558.361(Kg)
04. RADIUS OF THE BALANCING WEIGHTS R=586(mm) (RADIUS OF UNBALANCED WEIGHTS)
05. UNBALANCED WEIGHT PER PLANE U= 8 (g)
06. ADMISSIBLE THICKNESS OF THE BALANCING WEIGHTS D= 10(mm)
07. CONDITION OF BALANCING: ASSEMBLY STATUS

VAR NO	ITEM NO	DESCRIPTION	CAT	DRAWING No.	ITEM NO / VAR NO	MATL CODE / MATL SPECN	APC	UNIT / DI	UNIT WT / QTY
	13	SCRU CAP SOC GR A8.8 M10X20							0.030 / 1
	12	LOCATING PIN 12X30							0.024 / 1
	11	BOTTOM DISC–II							44.000 / 1
	10	LONG RIB							2.085 / 7
	09	SHORT RIB							1.660 / 7
	08	BOTTOM DISC–I							17.300 / 1
	07	IMPELLER BUSHING							3.178 / 14
	06	FLANGE							28.000 / 1
	05	SHELL							84.600 / 1
	04	SUPPORT RING–II							45.900 / 1
	03	SUPPORT RING–I (FORGING)							155.300 / 1
	02	LOAD RING							60.100 / 1
	01	HUB (FORGED)							52.400 / 1

N.T.S

WT(Kg) 560.000

TITLE: IMPELLER HUB ASSY

CARD / DRAWING NO.: TE–SKT–0–0219

Size A0