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DRG.NO. 2 180 421 5078

NOTE TO SUPPLIER:

1. TECHNICAL DELIVERY CONDITIONS SHALL BE AS PER HY19593.
2. ADDITIONAL QUALITY REQUIREMENTS SHALL BE AS PER FP60291.
3. STRESS RELIEVING SHALL BE DONE AFTER ANY WELDING WITHIN -20°C OF TEMPERING TEMPERATURE.
4. MANUFACTURE THE CASING IN ACCORDANCE WITH THE FOLLOWING DRAWINGS.

DESCRIPTION	BHEL DRG.NO.	
1ST VOLUTE AND CROSSOVER DRAWING	01804214676	CORE
STD VOLUTE AND SHORT CROSSOVER DRAWING	01804214677	
LONG CROSSOVER DRAWING	01804214678	
SUC.VOLUTE DRAWING	01804214679	
DISCH.VOLUTE DRAWING	01804214680	
COUP SIDE DRAWING	01804214681	OUTLINE MOULD
END SIDE DRAWING	01804214682	
LONGITUDINAL SECTIONAL DRAWING	01804214683	
MATING FACE DRAWING	01804214684	
OUTLINE DRAWING	01804214685	

NOTE TO MACHINE SHOP:

1. MACHINE THE CASING IN ACCORDANCE WITH THE FOLLOWING DRAWINGS.


DESCRIPTION	BHEL DRG.NO.
COUP SIDE DRAWING	01804214681
END SIDE DRAWING	01804214682
LONGITUDINAL SECTIONAL DRAWING	01804214683
MATING FACE DRAWING	01804214684
OUTLINE DRAWING	01804214685
ADDL MACHINING DRAWING (tapping)	01804214686 Var-00 2nd stg tap Var-01 3rd stg tap
ADDL MACHINING DRAWING FOR VOLUTE EDGE(2ND TO 6TH STAGES)	21804215076
IMPELLER&INNER CASING POLISHING PROCEDURE THE WATER PASSAGE	FP60291
INNER CASING ASSY.	01804214687 Var-00 2nd stg tap Var-01 3rd stg tap

2. STRESS RELIEVING SHALL BE DONE AFTER ROUGH MACHINING AND WELDING AS PER HY0640261, TEMPERATURE SHALL BE WITHIN -20°C OF TEMPERING TEMPERATURE.
3. LPI SHALL BE DONE AFTER ROUGH MACHINING AND AFTER FINAL MACHINING, AS PER AA0850131, ACCEPTANCE AS PER AA0850132, LEVEL-II.

VARIANT TABLE :

VAR.NO.	DESCRIPTION	REMARKS	MATL.NO.
00	INNER CASING M/C	2nd STAGE TAP	21804215078-00
01	INNER CASING M/C	3rd STAGE TAP	21804215078-01

ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT.	GROSS WT.
					FP9219306182	1640	1720
					HY19593		1

<p>THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED...</p> <ol style="list-style-type: none"> 1. REF.TO HY0230261 FOR UNSPECIFIED TOLERANCES. 2. CHAMFER M/CD SHARP EDGES 1.2 TO 1.0 AT 45°. 3. INTERNAL M/CD CORNER RADII 1 TO 0.7. 4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE BACK SLASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG. 		<p>TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT</p> <p>MDG406</p>																									
 <p>भारत हेवी इलेक्ट्रिकल्स लिमिटेड HYDERABAD</p>		<table border="1"> <thead> <tr> <th>NAME</th> <th>SIGN.</th> <th>DATE</th> <th>NO.OF VAR.</th> </tr> </thead> <tbody> <tr> <td>AS KALYAN</td> <td></td> <td>05.06.20</td> <td></td> </tr> <tr> <td>AS KALYAN</td> <td></td> <td>05.06.20</td> <td>NA</td> </tr> <tr> <td>M.S.RAM</td> <td></td> <td>05.06.20</td> <td></td> </tr> </tbody> </table>		NAME	SIGN.	DATE	NO.OF VAR.	AS KALYAN		05.06.20		AS KALYAN		05.06.20	NA	M.S.RAM		05.06.20									
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PUMPS	NTS	NA	NA	NA	NA																						
<p>TITLE</p> <p>INNER CASING M/C (UPPER & LOWER HALVES)</p>		<p>DRAWING NO.</p> <p>2 180 42 1 5078 02</p>																									
<p>SHEET NO. 01</p>		<p>NO OF SHEETS 01</p>																									

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