FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG. NO. 1-332-10-01032 SH. 1 OF 1

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG. NO RD DG 1 TM 13 600. SH. OF

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GENERAL DIMENSIONAL LIMITS,FITS & TOLERANCES AS PER HY0230261

RECOVER FROM THIS RING A TEST PIECE ACCORDING TO FIGURE-E AND PRESERVE THE REMAINING MATERIAL FOR FURTHER TESTS.

GROOVE FOR LOCATING ON 5-AXIS MACHINE

GROOVE DETAIL

FIG-A

FIG-B

FIG-C

FIG-E

SEC.W-W

MAX DEVIATION PERMISIBLE ON PLANARITY IS ±0.1MM (MEASURED IN BETWEEN VANES AT MID PORTION)

FOR ALL STEP DIAMETERS

R0.5 FOR ALL STEP DIAMETERS

SECTION P-P

NO. 17 BLADES EQUIDISTANT TOLERANCE ON PITCH OF THE VANES = ± 0.5

FOR BLADE CO-ORDINATES REFER SOLID MODEL NO. RD-RM-450-TM14-06

DIRECTION OF ROTATION

VIEW-M

NOTE

1. DETAILS OF BLADE PROFILE REFER SOLID MODEL FURNISHED
2. MATERIAL IS ASTM A182 F22
3. PERFORM OVERSPEED TEST OF THE IMPELLER AT10213 RPM AND CHECK THE DIAMETERS BEFORE AND AFTER THE TEST.
4. HEAT TREAT THE MATERIAL SO AS TO ATTAIN AN YIELD STRENGTH OF 65-75 KG/mm2 AND AN IMPACT STRENGTH OF MIN 20 JOULES AT SPECIFIED TEMPERATURE (CHARPY 5mm 'U' NOTCH)
5. DYE PENETRANT TEST SHALL BE CONDUCTED AT SPECIFIED STAGES OF MANUFACTURE AS SPECIFIED IN TECHNOLOGICAL PROCESS
6. DYNAMIC BALANCING OF IMPELLER AS PER Gr.2 OF ISO 1940-1 EDITION-2003.
7. SEQUENCE OF OPERATION FOR PRODUCTION AND INSPECTION OF THE IMPELLER AS PER PROCESS CHART
8. IMPELLER BALANCING AND OVERSPEEDING AS PER TECHNOLOGICAL PROCESS.
9. GEOMETRIC TOLERANCES ARE THE MAX. READ ON THE COMPARATOR.
10. THE ALLOWED RUN OUT OF THE STEPPED SEAL POSITION SHOULD NOT EXIT 0.02 MM.

NAME OF PROJECT OR NAME OF CUSTOMER/PROJECT: PIPE LINE COMPRESSOR / BHEL R & D

BHARAT HEAVY ELECTRICALS LTD. CORP. R&D DIVISION HYDERABAD-500 093

	NAME	SIGN.	DATE	NO.OF VAR
DRN	VINAY		14 11 13	
CHD.	ARINDAM	-----	-----	
APPD.	N.K. SINGH	-----	-----	

DEPT. CODE	UNTOL DIMS. GR.	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG	ITEM NO.	NO.OF ITEMS
44		NTS	40.0	-N.A.-	-N.A.-	-N.A.-

TITLE: 3D IMPELLER ø 450 CCW BT4_6

CARD CODE: N.A. DRAWING NO. RD DG 3 TM 13 600 REV. SHT. No 1. NO. OF SHT. 1.

SIZE A1

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: BHEL R&D

BHARAT HEAVY ELECTRICALS LTD. HYDERABAD

	NAME	SIGN.	DATE	NO.OF VAR.
DRN.	HARI		28.02.14	
CHD.	SDR		01.03.14	N.A.-
APPD.	PNR		01.03.14	

DEPT. COMPR. CODE. 420	UNTOL. DIMS. GR.	SCALE NTS	WEIGHT (KG) 40.0	REF. TO ASSY. DRG.	ITEM NO -N.A.-	NO.OF ITEMS -N.A.-

TITLE: 3D IMPELLER ø450 CCW BT4-6 SCOOP MILLING

CARD CODE N.A. DRAWING NO. 1-332-10-01032 REV. 01 SHT. No 1 NO. OF SHT. 1

ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED
CHD/APPD	ZONE		CHD/APPD	ZONE		CHD/APPD	ZONE		CHD/APPD	ZONE		CHD/APPD	ZONE		CHD/APPD	ZONE		CHD/APPD	ZONE		CHD/APPD	ZONE		CHD/APPD	ZONE		CHD/APPD

REV.	DATE	ALTERED
01	12.03.14	HARI / PNR

1 SOLID MODEL NO INDICATED
2. IMPELLER BORE AND HUB DIMENSIONS ARE MODIFIED

JCS

INVENTORY NO | SIGN. AND DATE | REF. DRG. NO. | COMPUTER FILE NAME