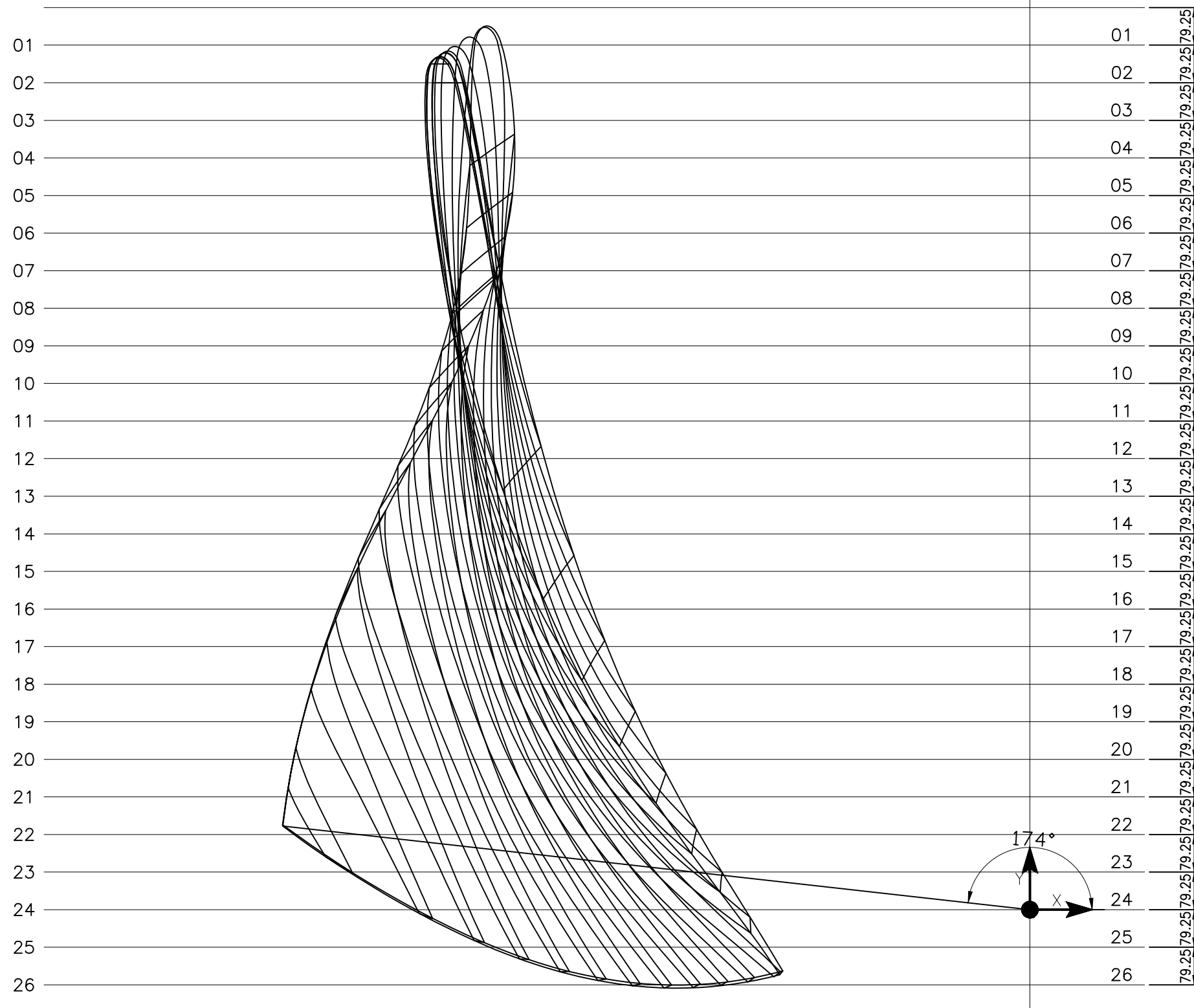
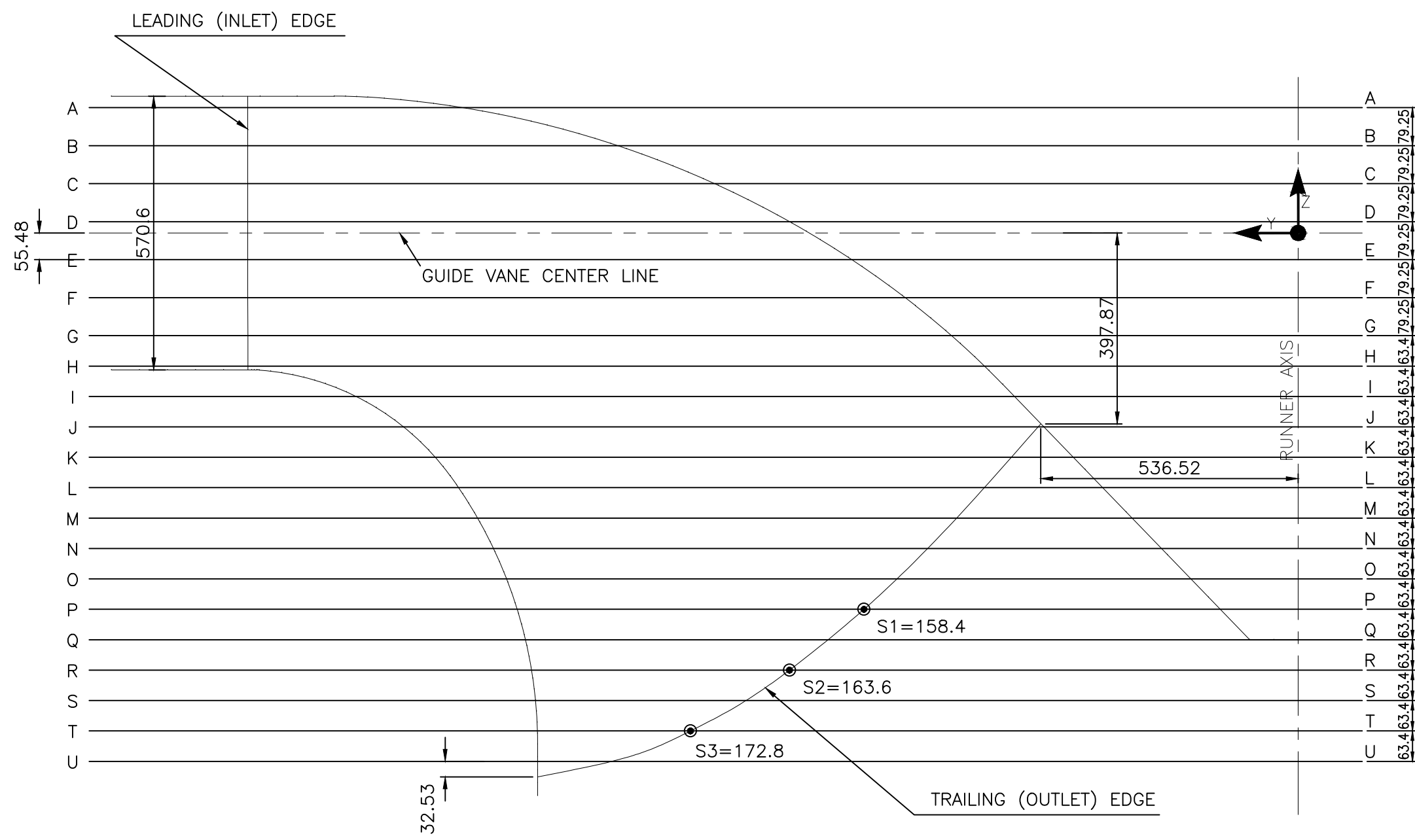


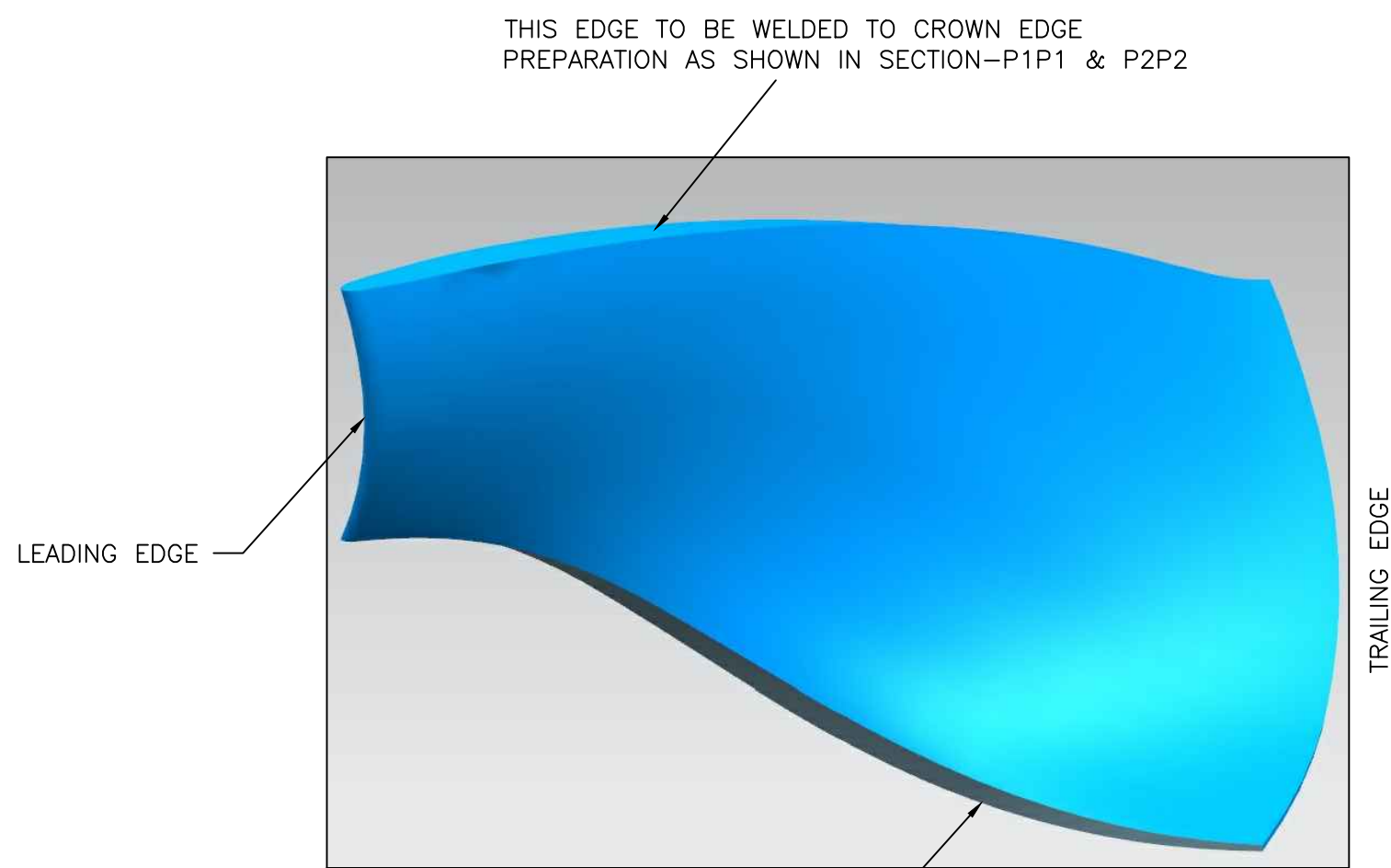
DRG. NO. 1 20407 20503



PLAN VIEW
(FOR DIMENSIONS REFER DRAWING NO. - 02040070901)



MERIDIONAL VIEW

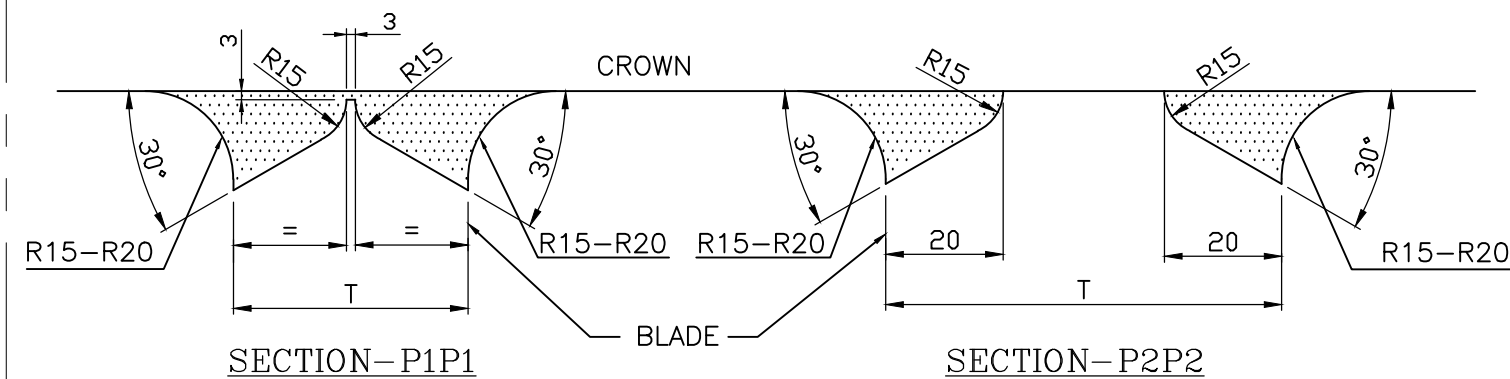


THIS EDGE TO BE WELDED TO SKIRT EDGE
PREPARATION AS SHOWN IN SECTION-Q1Q1 & Q2Q2

3D VIEW OF RUNNER BLADE

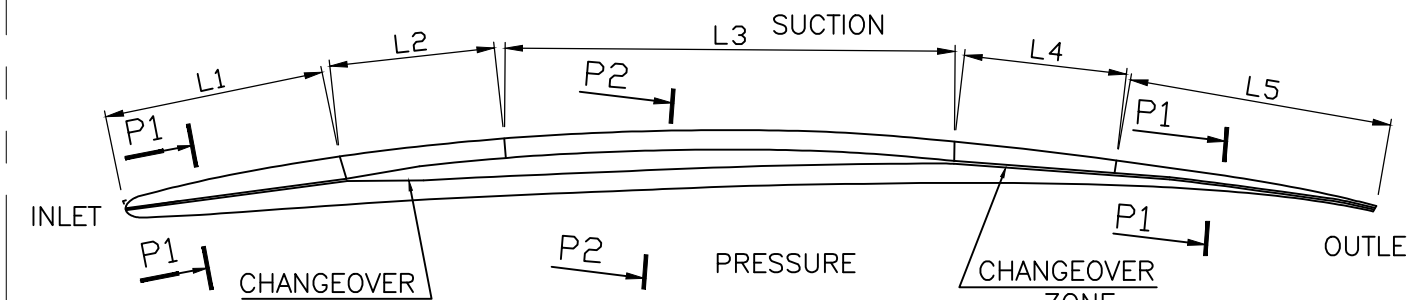
TECHNICAL REQUIREMENTS

- MATERIAL OF RUNNER BLADE IS STAINLESS STEEL (13% Cr 4% Ni) TO ASTM A743 CA6 NM.
- FOR RUNNER BLADE PROFILE REFER DRAWING No. 02040070901.
- RUNNER BLADE CASTINGS ARE IN HEAT TREATED & ROUGH GROUND CONDITION HAVING 6mm TO 8mm MATERIAL ON BOTH PRESSURE SIDE & SUCTION SIDE. FINISH MACHINED PROFILE & THICKNESS OF BLADE SHALL BE IN LINE WITH PROFILE DRAWING NO. 02040070901.
- EDGE PREPARATIONS FOR WELDING WITH CROWN & SKIRT ARE TO BE MACHINED AS PER SECTIONS P1P1, P2P2 & Q1Q1, Q2Q2 RESPECTIVELY.
- MACHINING SHALL BE CARRIED OUT ON ALL SURFACES.
- SURFACE FINISH OF FINISH M/C BLADE SHALL BE 3.2 OR BETTER.
- INSPECTION**- (i) INSPECTION SHALL BE CARRIED OUT AS PER INSPECTION SHEET & SCHEME APPROVED BY BHEL.
(ii) CO-ORDINATE POINTS OF THE BLADE SHALL BE MEASURED FOR BOTH PRESSURE & SUCTION SIDE (TOLERANCE $\pm 1\text{mm}$) TEMPLATES FOR NOSES, SUCTION & PRESSURE SIDE OF FINISH BLADE SHALL BE GENERATED BY MANUFACTURER & GOT VERIFIED BY BHEL BEFORE INSPECTION.
(iii). LINES ALONG INSPECTION SECTIONS SHALL BE DRAWN ON BLADE SURFACES & EDGE SURFACES OF CROWN & SKIRT.
(iv). REFERENCE POINTS OR LINES ON EDGE SURFACES OF CROWN & BAND SHALL BE MARKED.
(v). EDGE TO EDGE DIMENSION & DIAGONALS OF BLADES SHALL BE MEASURED & RECORDED.
- (i) ALL FINISH MACHINED BLADES SHALL BE CHECKED WITH TEMPLATES AT MANUFACTURER'S WORKS FOR VERIFYING PROFILE. TEMPLATES SHALL BE SUPPLIED BY THE MANUFACTURER AS PER SCHEME APPROVED BY BHEL.
(ii) VENDOR SHALL MANUFACTURE TWO SETS OF TEMPLATES. ONE SET OF TEMPLATES SHALL BE USED BY VENDOR FOR CHECKING THE PROFILE AT HIS WORKS (AS PER INSPECTION SHEET). OTHER SET SHALL BE SUPPLIED TO BHEL-BHOPAL ALONG WITH FIRST BLADE.
(iii) NUMBER OF TEMPLATES SHALL BE MANUFACTURED AS PER INSPECTION SHEET.
(iv) TEMPLATE SHALL BE PUNCHED MARKED WITH (a) DRAWING NO. (b) PRESSURE SIDE/SUCTION SIDE (c) SECTION NO.
- PERMISSIBLE VARIATION IN THICKNESS OF FINISH M/C'INED BLADE IS $\pm 0.5\text{mm}$.

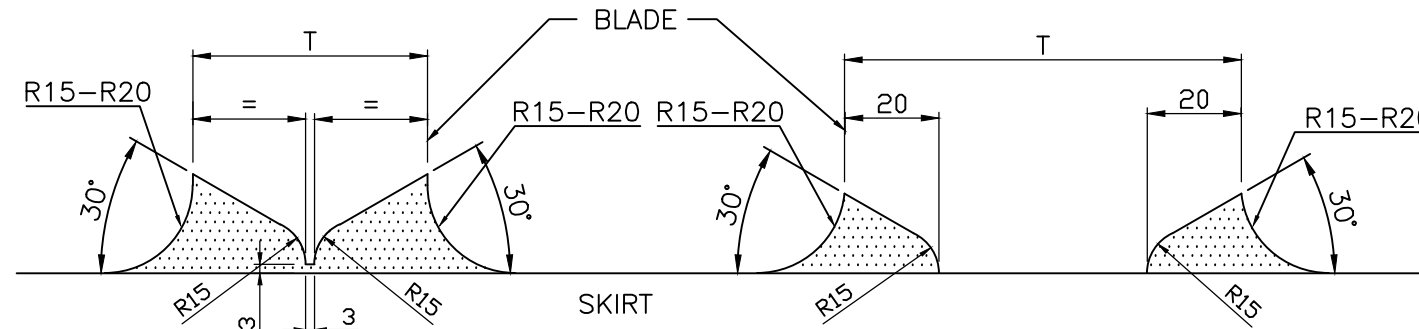


INLET	L1	L2	L3	L4	L5	TOTAL
CROWN	550	100	980	100	550	2280

LENGTH OF EDGE PREPARATION SEAM

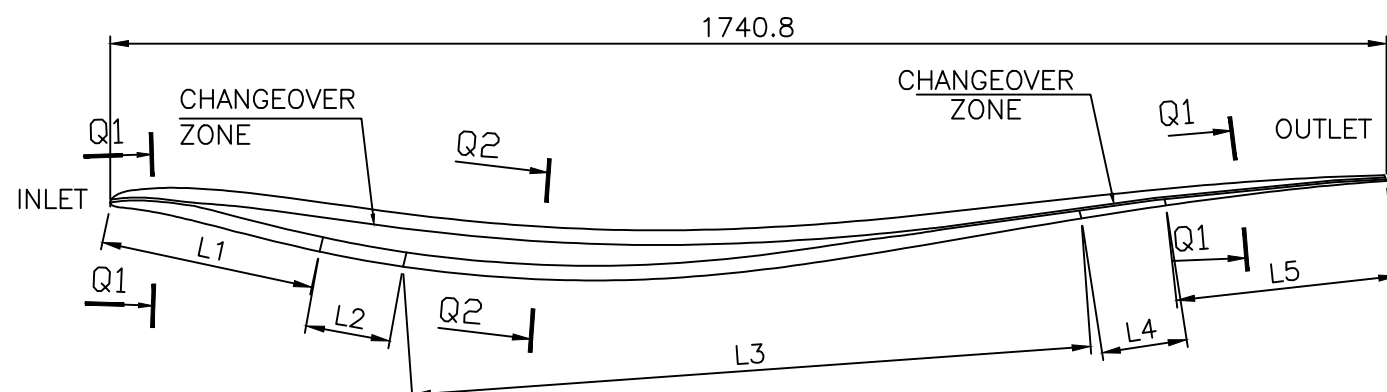


EDGE PREPARATIONS & GRINDING OF
WELDS BETWEEN CROWN & BLADE



INLET	L1	L2	L3	L4	L5	TOTAL
SKIRT	500	100	820	100	500	2020

LENGTH OF EDGE PREPARATION WELD SEAM



EDGE PREPARATIONS & GRINDING OF
WELDS BETWEEN BLADE AND SKIRT

BEFORE START OF MACHINING VENDOR TO OBTAIN THE LATEST
REVISION OF DRAWING CONFIRMED FROM BHEL-BHOPAL

59	VAR.00	64	65	75	76	77	78	79	25	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100																										
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VAR.00										REMARKS										DESCRIPTION										DRAWING NO.										28 31 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100																																																																					
28 -- CARD TYPE-3										28 -- CARD TYPE-1										28 -- CARD TYPE-2										28 -- CARD TYPE-3										28 -- CARD TYPE-1										28 -- CARD TYPE-2																																																											
ADDITIONAL INFORMATION										STATUS OF DRAWING										DISTRIBUTION OF PRINTS										TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT										ARUN-III HEP																																																																					
HTE-2										WTM-5										FGM-5										THX-1										NAME										SIGN										DATE										NO. OF VAR.																																							
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