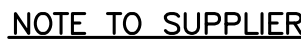
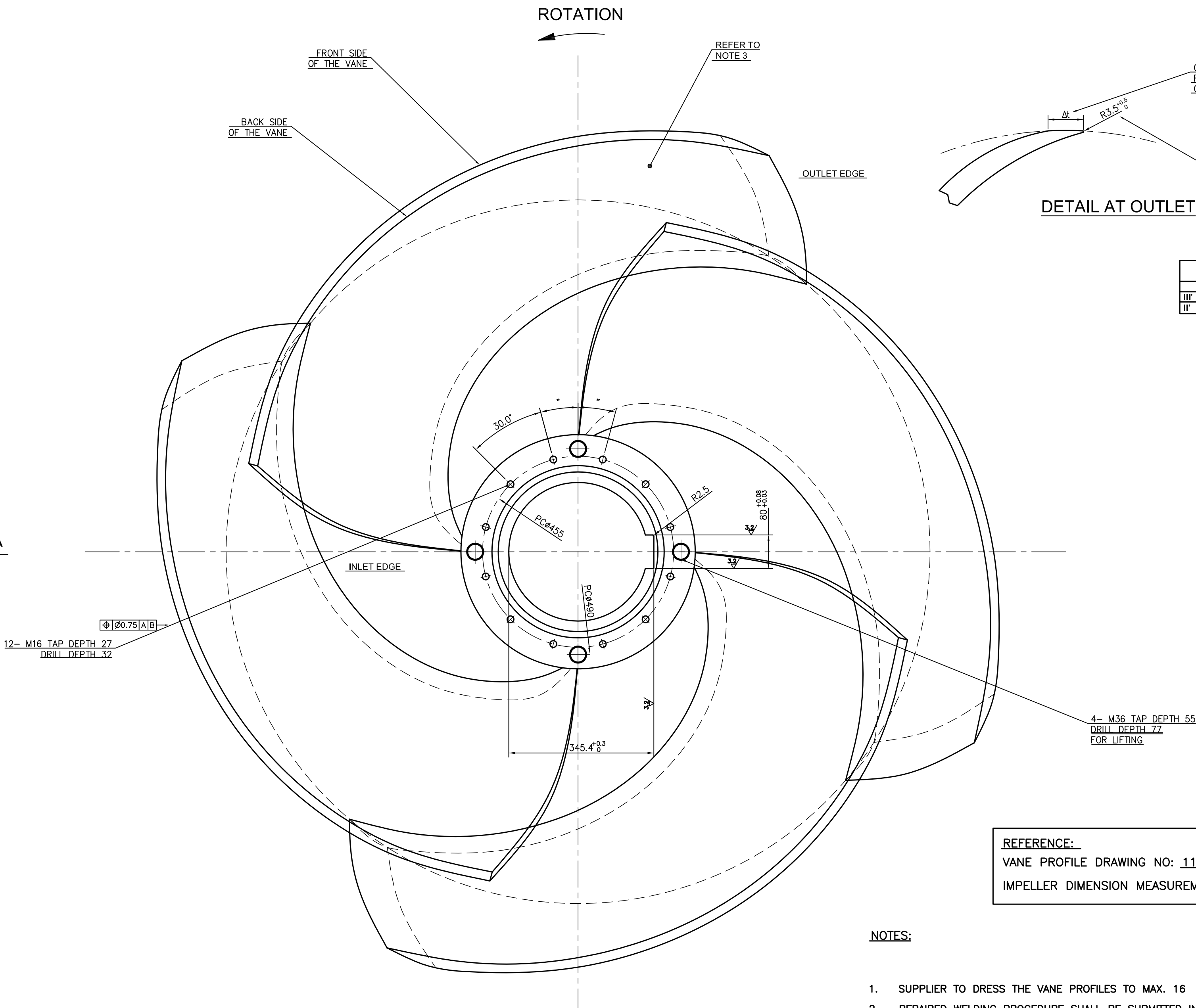


INVENTORY NO	SIGN. AND DATE	REF. DRG. NO.	COMPUTER FILE NAME :
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1. SUITABLE TEMPLATE OF ALL SECTIONS (SUCTION FACE AND PRESSURE FACE) SHALL BE PREPARED AS PER HYDRAULIC DETAIL DRAWING FOR CHECKING THE VANE PROFILE OF THE PATTERN
2. VANE DIAMETER CHECKING TEMPLATE SHALL BE PREPARED WITH 5 MM METAL SHEET BY SUPPLIER AS PER HYDRAULIC DETAIL DRAWING AND SAME SHALL BE CHECKED BY BHEL THE FINISH MACHINED IMPELLERS SHALL BE CHECKED BY BHEL AT VENDOR WORKS BY USING VANE DIAMETER CHECKING TEMPLATE BEFORE SENDING THEM TO BHEL. THIS HAS TO BE SPECIFICALLY RECORDED IN THE INSPECTION SHEETS.
3. ALL THE TESTS SHALL BE WITNESSED BY BHEL/BHEL NOMINATED AGENCY

CASTING IDENTIFICATION:

1. BY HEAT / CAST NUMBER
2. MANUFACTURER'S EMBLEM, DRAWING No. AND PATTERN No. TO BE STAMPED ON CASTING

PACKING & DESPATCH:

TO BE PROPERLY PACKED AND DESPATCHED SUCH THAT NO DAMAGE
IS CAUSED DURING HANDLING AND TRANSIT

TESTS TO BE CARRIED OUT AND CERTIFICATES TO BE FURNISHED TO BHEL

1. DIMENSIONAL CHECK ON PATTERN SHOULD BE WITNESSED BY BHEL PRIOR TO POURING
2. MECHANICAL PROPERTIES, CHEMICAL PROPERTIES, TDC SHALL BE AS PER FP50692_VAR 01
3. VISUAL EXAMINATION AS PER MSS SP 55, QUANTUM OF CHECK 100%
4. RADIOGRAPHY TEST SHALL BE CARRIED OUT ABOUT ROOT AREA OF VANES
5. ALL DIMENSIONS INCLUDING VANE EDGE, REFERENCE DIMENSIONS SHALL BE CHECKED AND WITNESSED
6. STATIC BALANCING AS PER ISO 1940 . ACCEPTANCE AS PER GRADE 2.5
ADDITION OF BALANCING MASS IS NOT PERMITTED
7. DESIGN SPEED OF IMPELLER IS 297 RPM.

REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED		SUDHEER	
		CHECKED	APPD.			CHECKED	APPD.			CHECKED	APPD.			CHECKED	APPD.			CHECKED	APPD.	01	20.10.19	CHECKED	SATISH	APPD.	H.R.K.
ZONE				ZONE				ZONE				ZONE				ZONE				ZONE				Revised based on change in scale factor from 1.01 to 1.0	

01	IMPELLER	11823617129	00		FP9713211014	2972	2972
					FP50692	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
					MATERIAL SPECN.	QUANTITY	

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED 1. REF. TO HY0230261 FOR UN TOLERANCES. 2. CHAMFER M/CD SHARP ED 1.2 TO 1.0 AT 45°. 3. INTERNAL M/CD CORNER RADI 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. DRG. NO. 210C SAP HYDRO-PUMP	TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		MKSVC 210C							
	भारत हीवी इलेक्ट्रिकल्स लिमिटेड BHEL भारत हीवी इलेक्ट्रिकल्स लिमिटेड HYDERABAD		NAME SIGN. DATE							
	DRN. SUDHEER		—sd—		30.11.18					
	CHD. SATISH		—sd—		30.11.18					
	APPD. K.H.R.K		—sd—		30.11.18					
	DEPT. PUMPS				SCALE WEIGHT (KG)		REF. TO ASSY DRG. ITEM NO.		NO.OF ITEMS NO.OF SHEETS	
	CODE 410		N.T.S		2972		—NA—		REV. 01	
TITLE		IMPELLER		DRAWING NO.						
				1 182 36 1 7129						
				SHEET NO.		NO OF SHEETS				

REFERENCE:
VANE PROFILE DRAWING NO: 11823617128
IMPELLER DIMENSION MEASUREMENT PROCEDURE : FP13580

NOTES:

1. SUPPLIER TO DRESS THE VANE PROFILES TO MAX. 16 MICRONS SURFACE ROUGHNESS
2. REPAIRED WELDING PROCEDURE SHALL BE SUBMITTED IN ADVANCE. REPAIR OF LARGE DEFECT SHALL BE DONE AFTER APPROVAL FROM BHEL
AFTER WELDING, ADEQUATE HEAT TREATMENT SHALL BE DONE.
3. "LARGE DEFECT" IS DEFINED THAT THICKNESS OF DEFECT IS 20% OR MORE OF TOTAL THICKNESS, OR 25MM OR MORE, OR REMOVED AREA IS 65MM OR MORE.

TOLERANCE ON DIMENSIONS (NOT TOLERANCED IN DRAWING)
AS CAST DIMENSIONS AS PER AA0230402 CLASS 3 & MACHINED DIMENSIONS
AS PER AA0230208 MEDIUM CLASS. CASTING SHALL NOT HAVE ANY SHARP CORNERS.

THE FOLLOWING CONDITIONS APPLY
EXCEPT OTHERWISE STATED.

1. REF. TO HY0230261 FOR UN TOLERANCES.
2. CHAMFER M/CD SHARP ED 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.

TYPE OF PRODUCT

NAME OF CUSTOMER/PROJECT

	भारत हेवी इलेक्ट्रिकल्स लिमिटेड हैदराबाद		NAME	SIGN.	DATE	NO. OF VAR.	
	BHARAT HEAVY ELECTRICALS LTD. HYDERABAD		DRN.	SUDHEER	-sd-		30.11.18
			CHD.	SATISH	-sd-		30.11.18
			APPD.	K.H.R.K	-sd-		30.11.18

DEPT. PUMPS

CODE 410

CODE 410

TITLE

IMPE

	DRAWING NO.
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IMBELLED	1 182 36 1
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IMPELLER

SHEET NO.	
10	11