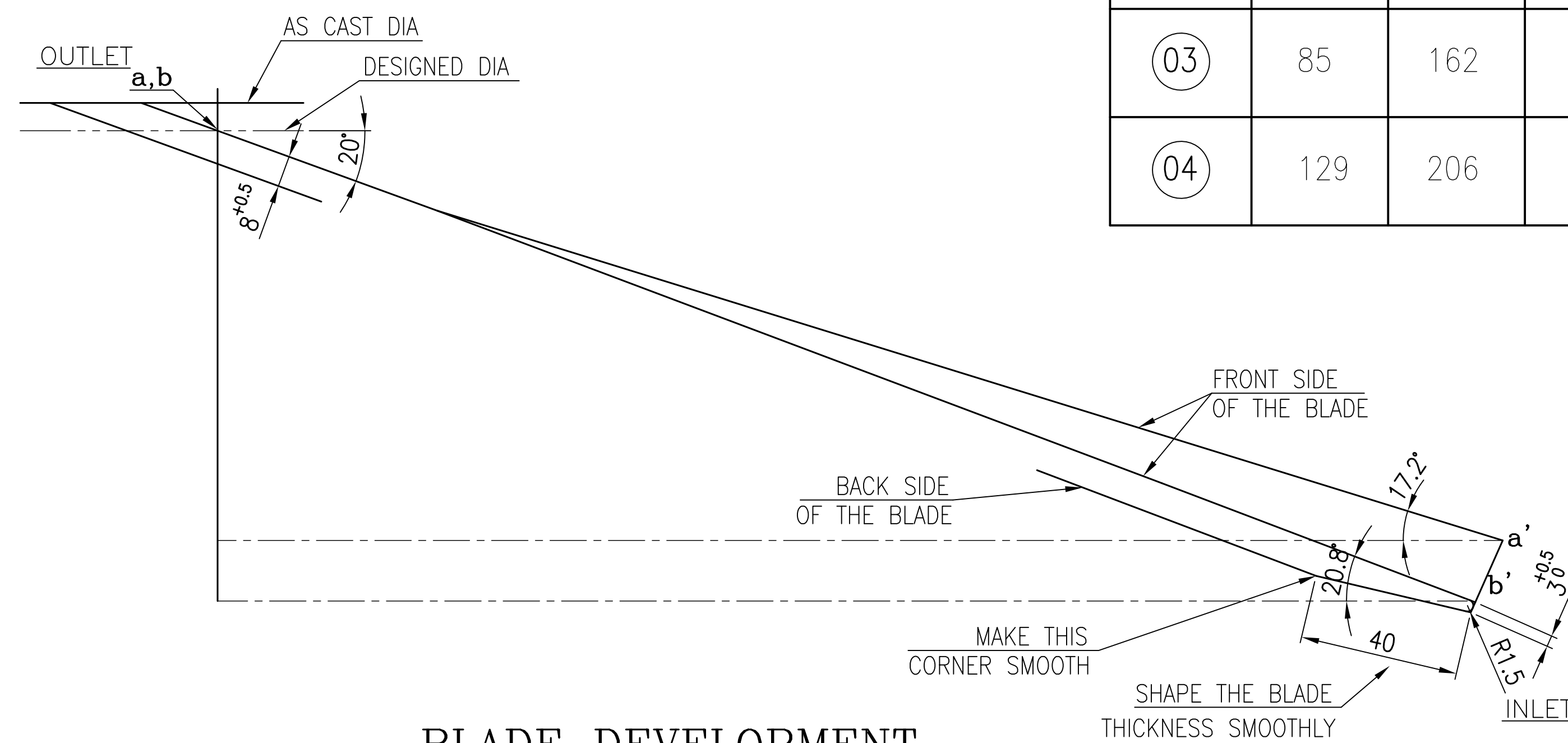
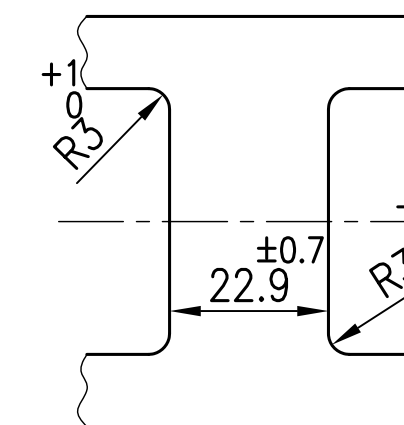




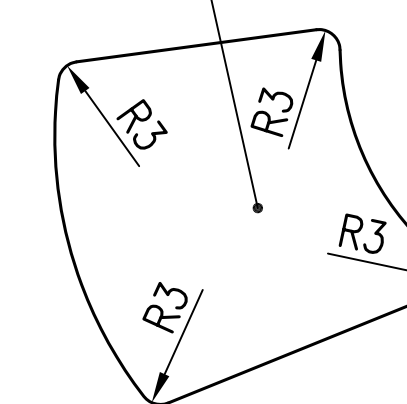
DIMENSIONS TABLE AND REMARKS				
MARK	L	M	ROTATIVE DIRECTION (VIEWED FROM SUCTION NOZZLE)	No. OF STAGE
①	85	162	C.W	2ND STAGE
②	129	206	C.W	3RD STAGE
③	85	162	C.C.W	4TH STAGE
④	129	206	C.C.W	5TH STAGE

	①	②	③	④	⑤	⑥	⑦	⑧	⑨	⑩	⑪	⑫	
a-a'	222.00	208.35	196.24	185.72	175.95	166.70	157.95	149.70	142.07	135.20	129.65	125.91	124.33
b-b'	222.00	208.33	195.28	182.78	171.06	160.09	149.82	140.24	131.34	123.23	115.95	109.47	101.50



$$\frac{\text{AREA BETWEEN BLADES}}{1 \text{ PORT } 2154.6\text{mm}^2 \times 5 = 10773\text{mm}^2}$$

$$\frac{\text{TOLERANCE PER 1PORT } 1467 \pm 108\text{mm}^2}{}$$



SECTION-ZZ

1. CASTING SHALL BE SUPPLIED IN ROUGH MACHINED CONDITION AS PER THIS DRAWING DIMENSIONS.
2. THE CHAIN DOUBLE-DASHED LINE INDICATES THE FINAL DIMENSIONS TO BE MACHINED. THE FINISHING ALLOWANCE IS ABOUT 2MM.
3. SURFACE ROUGHNESS OF MACHINED SURFACES SHALL BE NOT OVER 6.3 MICRONS. SURFACE ROUGHNESS OF VANE&FLOW PASSAGE SHALL BE NOT OVER 5 MICRONS.
4. BEWARE OF THE MISALIGNMENT OF THE BLADE PITCH AND DIMENSIONS AND CAST THE IMPELLER SO THAT THE CENTER OF MASS SHALL BE CLOSE TO THE CENTER OF FIGURE, IN ORDER TO MAKE THE RESIDUAL UNBALANCE SMALLER.
5. MANUFACTURE THIS IMPELLER BY PRECISION CASTING WITH THE GIVEN 3D-DATA.
6. 100% MPI ON CASTING SHALL BE DONE AS PER STD AA0850133 AND ACCEPTANCE AS PER AA0850134 LEVEL-II.
7. RADIOGRAPHY TEST SHALL BE CONDUCTED AS PER ASTM E142 AND ACCEPTANCE NORMS AS PER ASTM E446 LEVEL-II.
8. ADDITIONAL QUALITY REQUIREMENTS SHALL BE AS PER FP60288.

	IMPELLER 5TH STAGE		04		FP9219324547	45.6	
					HY19593		1
	IMPELLER 4TH STAGE		03		FP9219324539	40.2	
					HY19593		1
	IMPELLER 3RD STAGE		02		FP9219324520	45.6	
					HY19593		1
	IMPELLER 2ND STAGE		01		FP9219324512	40.2	
					HY19593		1
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

TYPE OF PRODUCT OR NAME OF CUSTOMER (DD FORM 1)	MDG455
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NAME OF CUSTOMER/PROJECT		NAME	SGN.	DATE	NO. OF VAR.
	भारत हीवी इलेक्ट्रिकल्स लिमिटेड हैदराबाद	DRN.	AS KALYAN	03.04.13	—NA—
	BHARAT HEAVY ELECTRICALS LTD. HYDERABAD	CHD.	M.S.RAM	03.04.13	
		APPD.	M.S.RAM	03.04.13	

DEPT.	PUMPS		SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO.OF ITEMS
CODE	410		NTS	-NA-	-NA-	-NA-	-NA-

TITLE IMPELLER INTER STAGE (CASTING)	DRAWING NO. 0 180 40 2 4605		REV. 01
	SHEET NO. 01	NO. OF SHEETS 01	

4		15		16	
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Therefore signatures are not essentially required