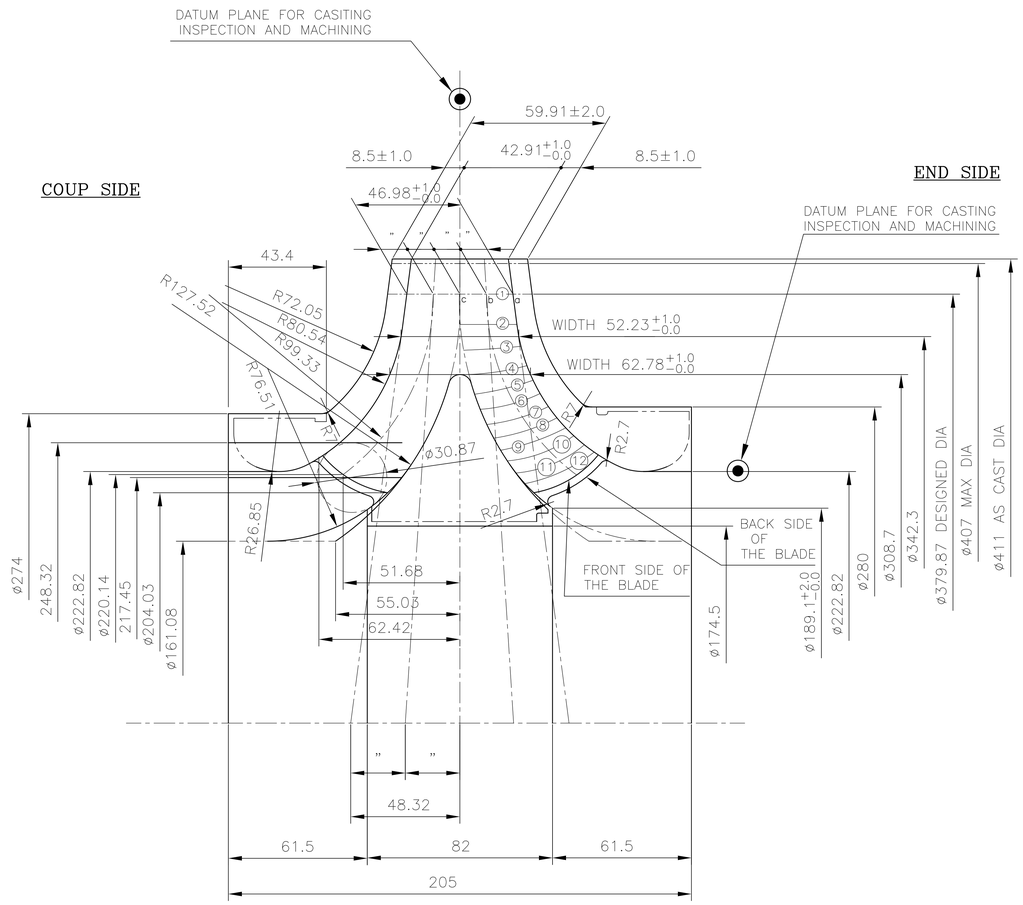
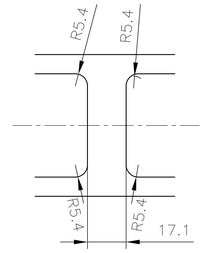
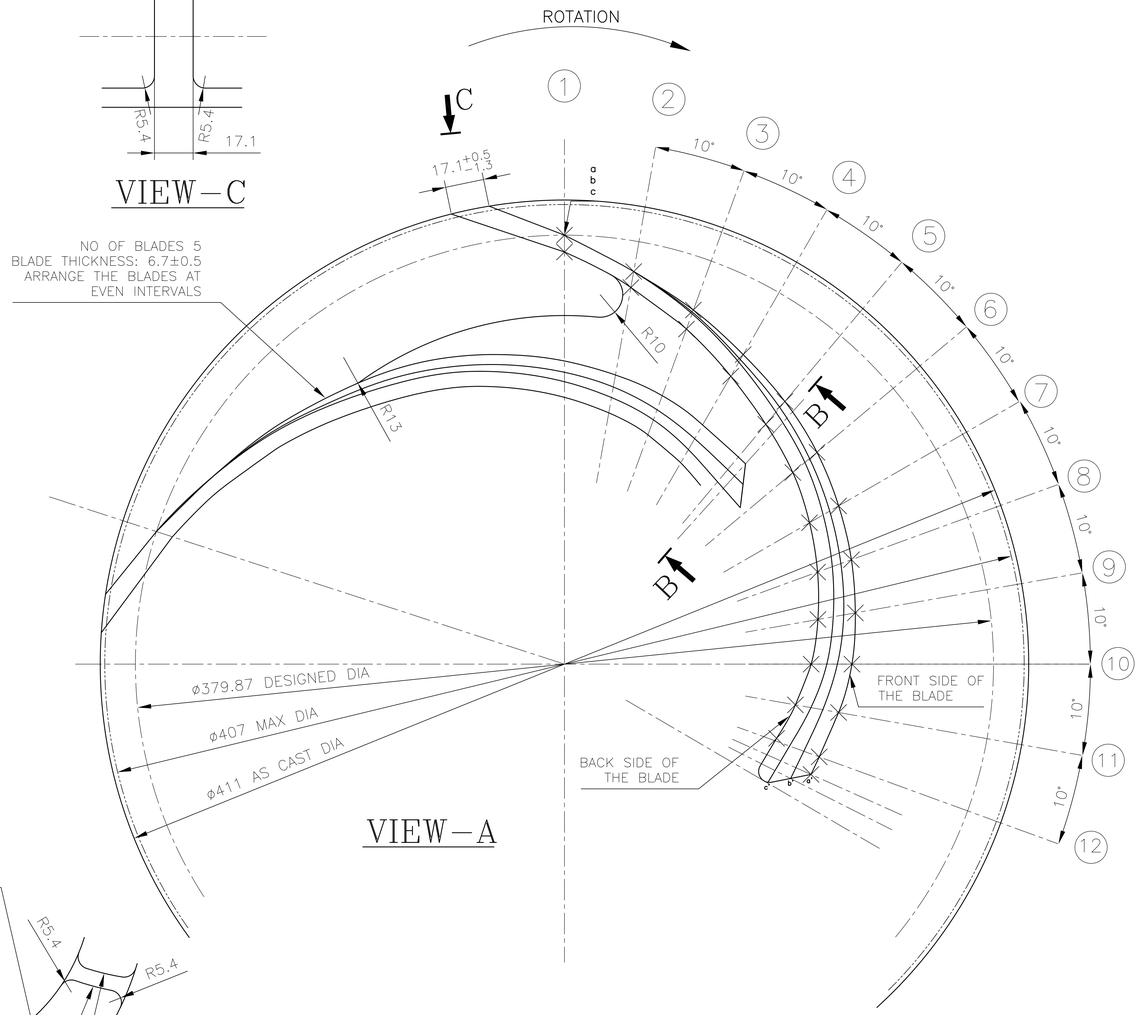
DRG. NO. 0 180 40 2 4641

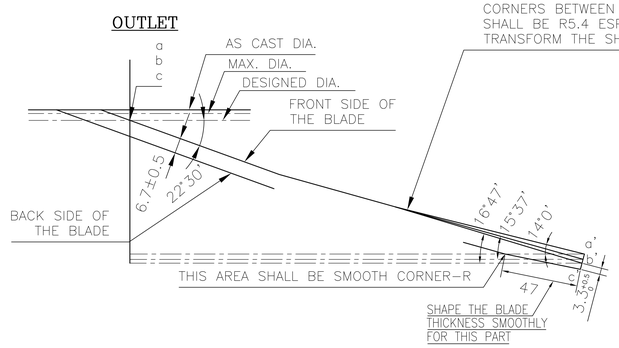




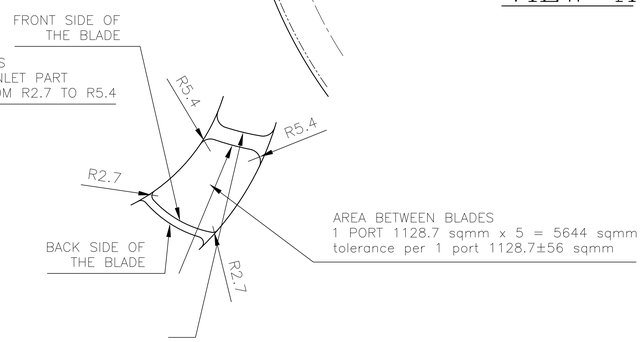
VIEW–C



VIEW–A



BLADE DEVELOPMENT



SECTION–BB

NOTE TO SUPPLIER:

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.

RADIUS RADIAL COORDINATE (AT THE FRONT SIDE OF THE BLADE)

	1	2	3	4	5	6	7	8	9	10	11	12
	0°	10°	20°	30°	40°	50°	60°	70°	80°	90°	100°	110°
a–a'	189.935	176.51	166.85	158.26	151.81	145.91	140.14	135.17	130.74	127.25	123.22	120.00
b–b'	189.935	176.51	165.77	155.71	148.32	141.61	135.57	130.20	125.51	120.81	116.11	112.75
c–c'	189.935	176.51	165.10	154.36	145.64	138.93	132.22	126.18	120.81	111.61	110.74	106.04

ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE / MATERIAL SPECN.	NET WT.	GROSS WT. / QUANTITY

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED

1. REF.TO HY0230261 FOR UNS. TOLERANCES.
2. CHAMFER M/CD SHARP EDGE 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 OR NAME OF CUSTOMER/PROJECT: MDG455–NSS

भारत हेवी इलेक्ट्रिकल्स लिमिटेड हैदराबाद
BHARAT HEAVY ELECTRICALS LTD. HYDERABAD

	NAME	SIGN.	DATE	NO.OF VAR.
DRN.	K.K.CHAITANYA		04.03.15	NA
CHD.	A.S.KAN		04.03.15	
APPD.	M.S.RAM		04.03.15	

DEPT.	PUMPS	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO.OF ITEMS
CODE	410	NTS	45.7	NA	NA	NA

TITLE: IMPELLER 1ST STAGE (CASTING)

DRAWING NO. 0 180 40 2 4641 REV. 01

SHEET NO. 01 NO OF SHEETS 01

REV.	DATE	ALTERED	CHECKED	APPD.
01	10.05.19	MSIRAM	KHRK	KHRK

Note to supplier revised. Dimensions revised as per MHI as built drg.no. P1–CA502–R0.

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CHAPTER FILE NAME: FP0180124641-01

REF. DRG. NO.: P1–CA502–R0

INVENTORY NO SIGN. AND DATE

This Drawing is printed from Engineering Digital Archive System (EDAS). Therefore signatures are not seen and required.