



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.

BLADE DEVELOPMENT

RADIAL COORDINATE (AT THE BACK SIDE OF THE BLADE)

04	IMPELLER 6TH STG				FP9219324606	31.2	
					HY19593		
03	IMPELLER 4TH STG AND 5TH STG				FP9219324792	26.9	
					HY19593		
02	IMPELLER 3RD STG				FP9219324784	31.2	
					HY19593		
01	IMPELLER 2ND STG				FP9219324776	26.9	
					HY19593		
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/PROJECT	MDG366N
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NAME OF CUSTOMER/PROJECT		NAME	SIGN.	DATE	NO. OF VAR.
	भारत भारी इलेक्ट्रिकल्स लिमिटेड हदरबाद	DRN.	J.NAGAMANI	22.11.18	
	BHARAT HEAVY ELECTRICALS LTD. HYDERABAD	CHD.	M.S.RAM	22.11.18	
		APPD.	M.S.RAM	22.11.18	NA

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.		REV.
				0 180 40 2 4671		00
				SHEET NO. 01	NO. OF SHEETS 01	