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REF. DRG.NO.

SIGN. &

INVENTORY NO.

REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED	
		CHECKED				CHECKED				CHECKED	
		APPROVED				APPROVED				APPROVED	

DISCHARGE BOWL DIMENSION MEASUREMENT PROCEDURE (AFTER FINAL MACHINING)

TYPE OF PRODUCT		CW PUMP					
	BHARAT HEAVY ELECTRICALS LTD. HYDERABAD			NAME	SIGN	DATE	NO. OF VAR.
			DRN.	SATISH	SD/-	01.10.2018	
			CHD.	SATISH	SD/-	01.10.2018	
			APPD.	K.H.R.K	SD/-	01.10.2018	NA
DEPARTMENT	PUMPS ENGG.	SCALE	WEIGHT (KG)		REF. TO ASSY DRG.	ITEM NO.	NO. OF ITEMS
CODE	410	NA	NA		NA	NA	NA
TITLE DISCHARGE BOWL DIMENSION MEASUREMENT PROCEDURE (AFTER FINAL MACHINING)			DRAWING NO.				REV.
			FP13573				00
			SHEET NO.	01	NO. OF SHEETS		05



 BHEL HYDERABAD	PRODUCT STANDARD PUMPS HYDERABAD	FP13573	
		Rev	00
		Page	2 of 5
1.0	INTRODUCTION: The document shows the dimensional inspection procedure of CW Pump Discharge bowl after final machining.		
2.0	REFERENCE DRAWINGS:		
	a) Discharge bowl		
	b) Discharge bowl vane profile		
3.0	SCOPE:		
	All finish machined discharge bowls shall be measured based on this document.		
4.0	GENERAL:		
	a) Dimensional check shall be carried out on each discharge bowl.		
	b) Vendor shall mandatorily submit each discharge bowl dimensional report along with the dispatch of discharge bowl.		
	c) BHEL / BHEL nominated inspection agency shall ensure the same before clearing the material for dispatch from vendor works.		

TD-106-2 Rev.5 Form No.		PRODUCT STANDARD PUMPS HYDERABAD				FP 13573																																				
						Rev. No. 00																																				
						PAGE 3 OF 5																																				
MEASURING POINTS AND CRITERIA:																																										
<table border="1"> <thead> <tr> <th rowspan="2">SNO.</th> <th rowspan="2">MEASURING POINTS</th> <th rowspan="2">MARK</th> <th rowspan="2">DESIGN</th> <th colspan="2">CRITERIA</th> <th rowspan="2">REMARKS</th> </tr> <tr> <th>(%)</th> <th>(mm)</th> </tr> </thead> <tbody> <tr> <td rowspan="2">1</td> <td rowspan="2">INLET DIAMETER</td> <td>b1</td> <td>1681.8</td> <td rowspan="2">±1</td> <td>1699 s 1665</td> <td rowspan="4"> MEASURE IN TWO CROSS SECTIONS RECORD FORMAT NO.1 </td> </tr> <tr> <td>b2</td> <td>1237.4</td> <td>1250 s 1225</td> </tr> <tr> <td rowspan="2">2</td> <td rowspan="2">OUTLET DIAMETER</td> <td>b3</td> <td>1169.2</td> <td>±1</td> <td>1181 s 1157</td> </tr> <tr> <td>b4</td> <td>497.8</td> <td>±10 MM</td> <td>507 s 487</td> </tr> <tr> <td>3</td> <td>INLET PITCH</td> <td>P1</td> <td>REFER FORMAT-2</td> <td>REFER NOTE-4</td> <td>REFER FORMAT-2</td> <td>INLET PITCH SHALL BE MEASURED AT ø1456.8</td> </tr> </tbody> </table>							SNO.	MEASURING POINTS	MARK	DESIGN	CRITERIA		REMARKS	(%)	(mm)	1	INLET DIAMETER	b1	1681.8	±1	1699 s 1665	MEASURE IN TWO CROSS SECTIONS RECORD FORMAT NO.1	b2	1237.4	1250 s 1225	2	OUTLET DIAMETER	b3	1169.2	±1	1181 s 1157	b4	497.8	±10 MM	507 s 487	3	INLET PITCH	P1	REFER FORMAT-2	REFER NOTE-4	REFER FORMAT-2	INLET PITCH SHALL BE MEASURED AT ø1456.8
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NOTES:																																										
1) DESIGN VALUE DEPENDS ON THE DISCHARGE BOWL DRAWING																																										
2) NUMBER OF VANES = 7																																										
3) VANE PROFILE SHALL BE AS PER DISCHARGE BOWL VANE PROFILE DRAWING 11823647123																																										
4) CRITERIA SHALL BE ±1.5% OR ±6MM IF CALCULATED VALUE BECOMES SMALLER THAN ±6MM																																										
Ref. Doc.	COMP.FILE NAME																																									



PRODUCT STANDARD

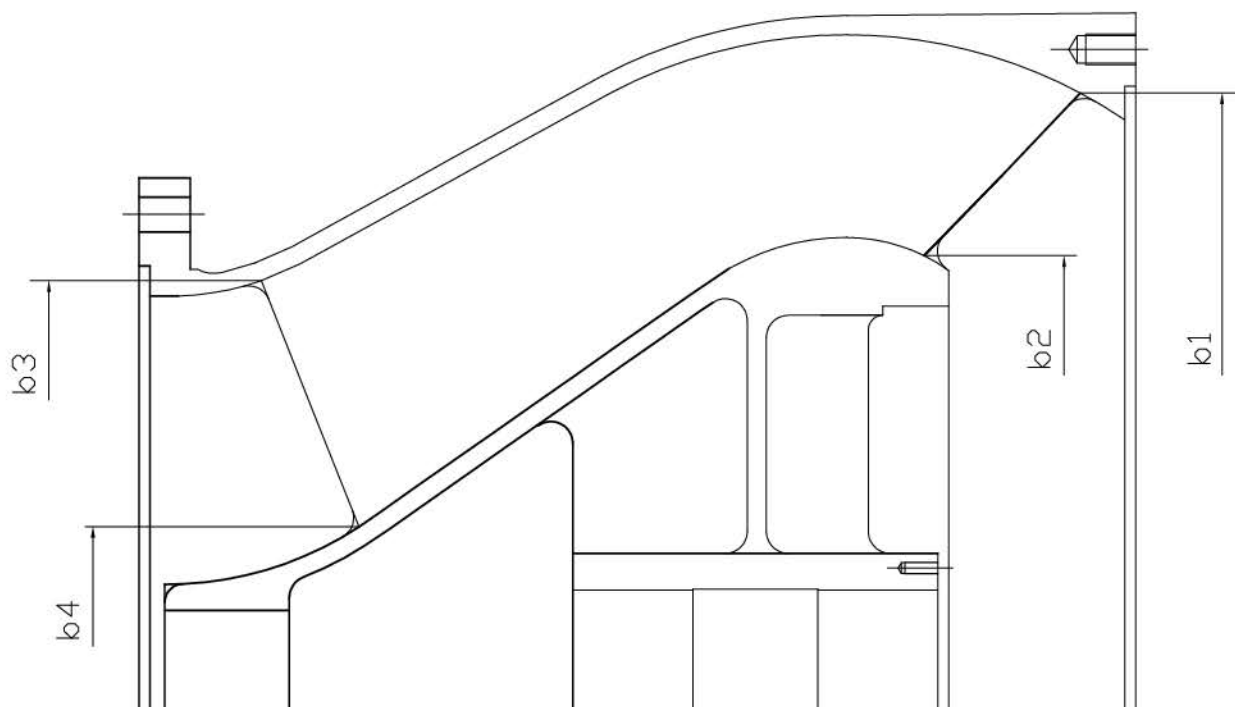
PUMPS

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RECORD FORMAT NO.1INLET DIAMETER, OUTLET DIAMETER

TO BE MEASURED IN TWO CROSS SECTIONS

SNO.	PARAMETER	MARK	X-X	Y-Y	RESULT
1	INLET DIAMETER	b1			
		b2			
2	OUTLET DIAMETER	b3			
		b4			

NOTES:

AVERAGE RESULTS SHALL BE COMPARED WITH DESIGN VALUE

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PRODUCT STANDARD

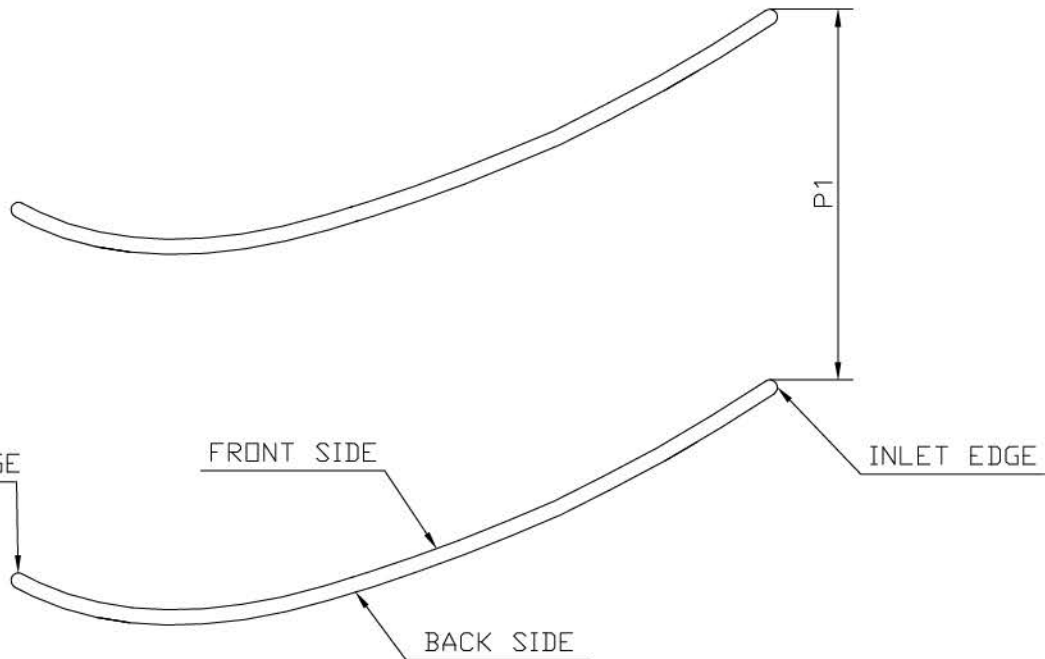
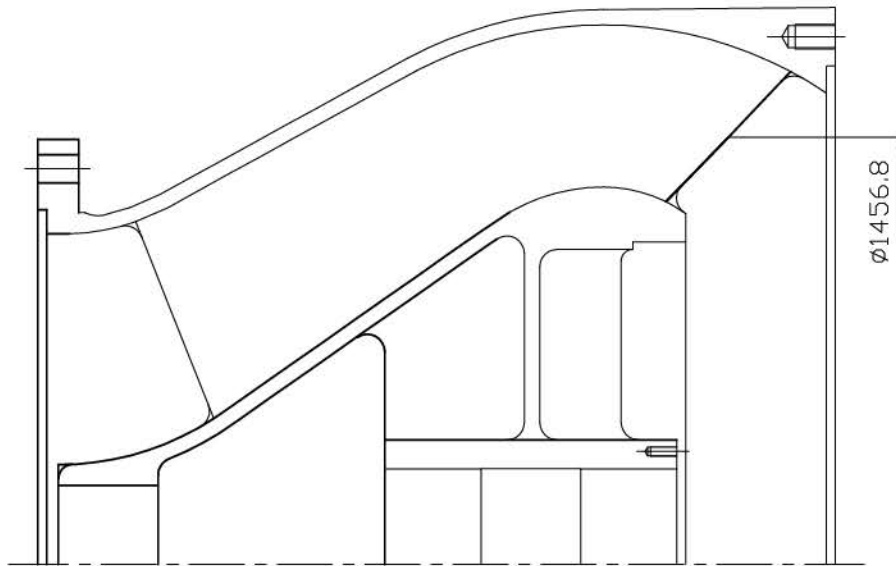
PUMPS

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RECORD FORMAT NO.2INLET PITCH

SNO.	PARAMETER	MARK	DESIGN (MM)	CRITERIA	
				(%)	(MM)
1	INLET PITCH	P1	632.1	±1.5%	642 ~ 622

NOTES:

AVERAGE RESULTS SHALL BE COMPARED WITH DESIGN VALUE

SNO.	PARAMETER	MARK	INLET PITCH (P1)							AVERAGE	RESULT
			1-2	2-3	3-4	4-5	5-6	6-7	7-1		
1	INLET PITCH	P1									

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