

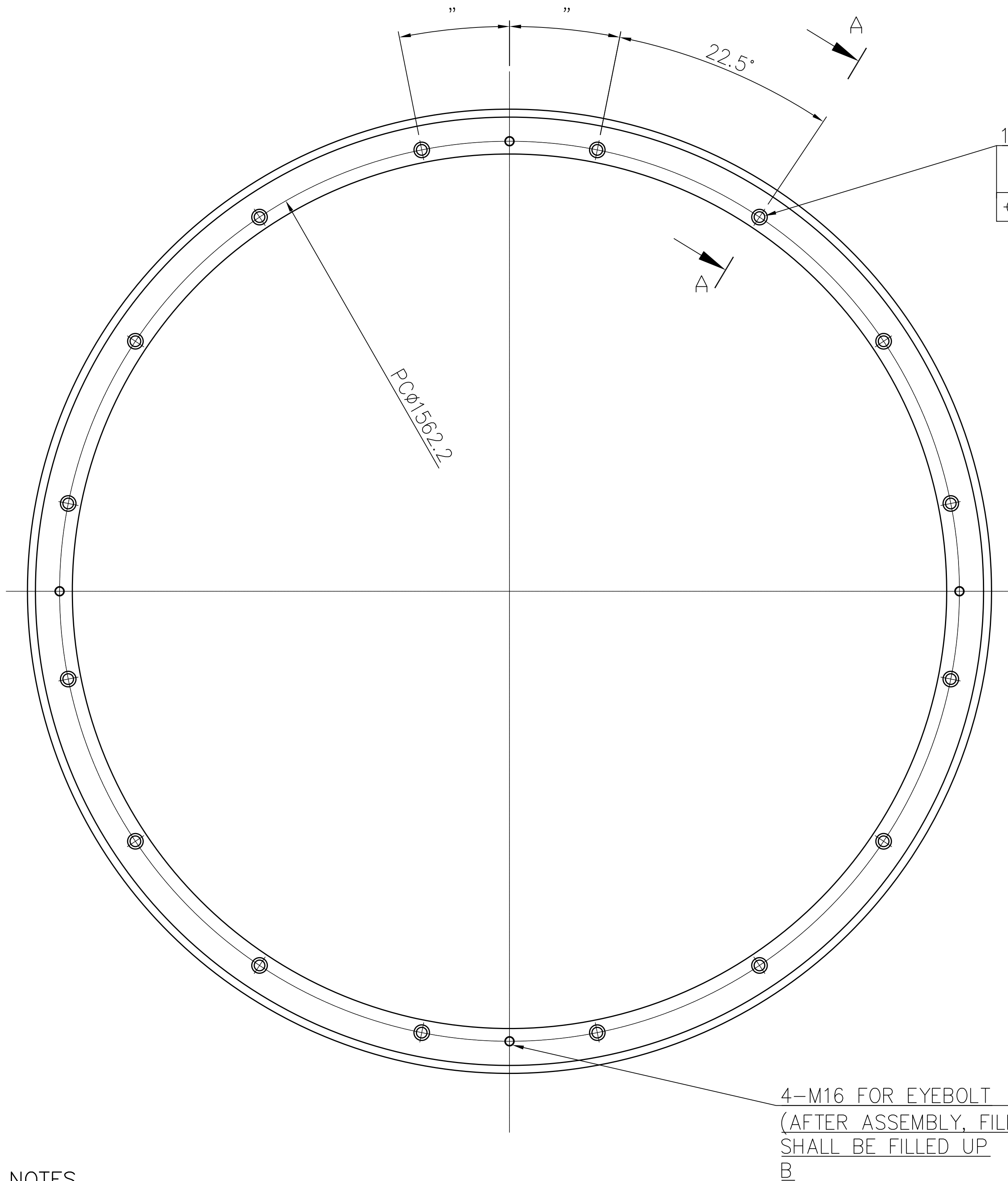
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INVENTORY NO. 182 36 1 7136 00
SIGN. AND DATE REF. DRG. NO. COMPUTER FILE NAME : 1 182 36 1 7136 00 000

DRG. NO. 1 182 36 1 7136

FIRST ANGLE PROJECTION

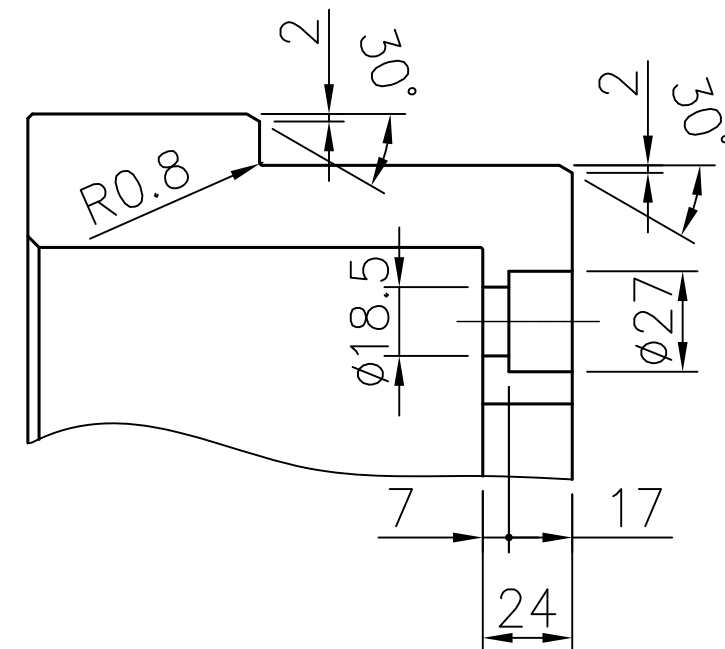
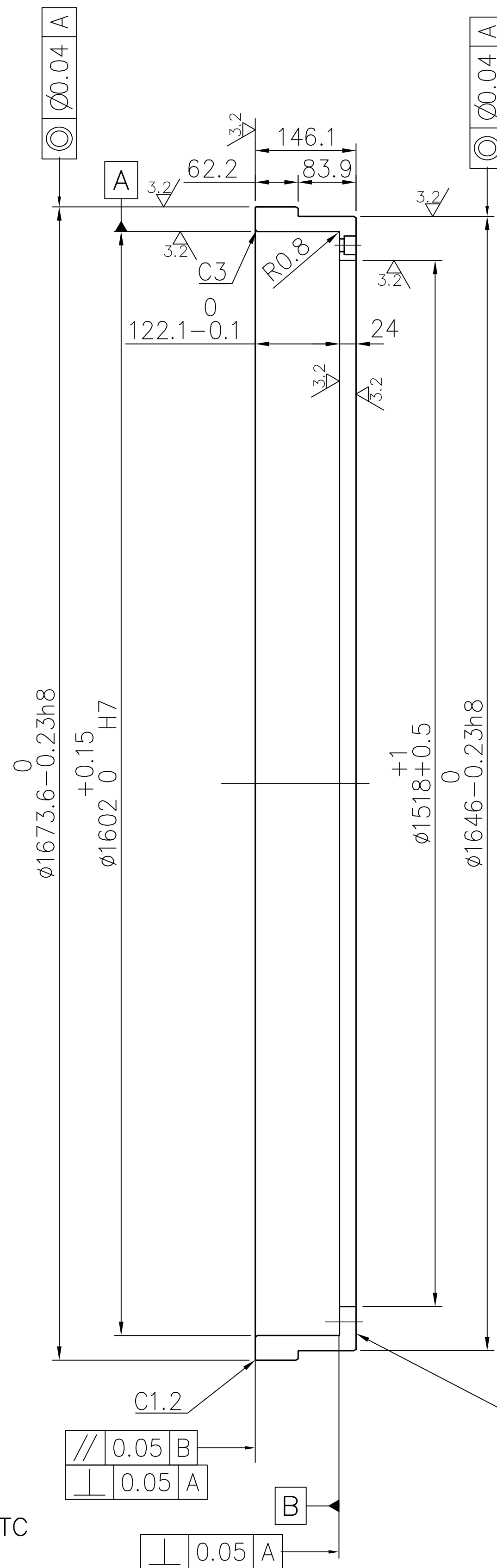
(ALL DIMENSIONS ARE IN mm)



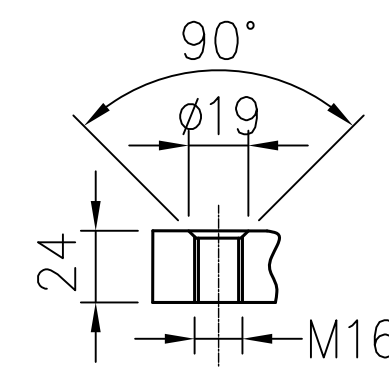
NOTES

1. THE SHAFT RUN-OUT OF FORGED RAW MATERIAL MAY BE CORRECTED BY PRESSING, HEATING, HAMMERING ETC AFTER QUENCHING AND TEMPERING. HOWEVER, IN CASE SUCH CORRECTION IS DONE, ANNEALING AT -20°C FOLLOWED BY COOLING AT THE AMBIENT TEMP. IS REQUIRED TO MITIGATE STRAIN. TEMP. CHART TO BE SUBMITTED.
2. STRAIN DURING MACHINING SHALL BE PAID ATTENTION.
3. CASING WEAR RING $\phi 1678.6$, CLEARANCE $5.00 \sim 5.46$ ON DIA. CASING WEAR RING $\phi 1651$, CLEARANCE $5.00 \sim 5.46$ ON DIA.
4. PERMISSIBLE DIMENSION OF * MARKED DIMENSIONS IS AT 20°C .
5. LPI SHALL BE CARRIED OUT ON ALL MACHINED SURFACES. TEST PROCEDURE IS AS PER ASME SEC.V ARTICLE 6 & 24. ACCEPTANCE CRITERIA IS AS PER ASME SEC.VIII DIV. 1 APPENDIX 7

REV.	DATE	ALTERED	APPD.	REV.	DATE	ALTERED	APPD.	REV.	DATE	ALTERED	APPD.	REV.	DATE	ALTERED	APPD.	REV.	DATE	ALTERED	APPD.	REV.	DATE	ALTERED	APPD.
ZONE		CHECKED		ZONE		CHECKED		ZONE		CHECKED		ZONE		CHECKED		ZONE		CHECKED		ZONE		CHECKED	



SECTION AA



DETAIL-B

ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT.	GROSS WT.
					FP9716611099	204.4	
					ASTM A182 S31603	1	
					MATERIAL SPECN.	QUANTITY	

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED				TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT			
1. REF. TO HY0230261 FOR UN TOLERANCES.				MKS V 220C CONCRETE VOLUTE PUMP			
2. CHAMFER M/CD SHARP ED 1.2 TO 1.0 AT 45° .				DRN. SUDHEER SD 30.11.18 NO. OF VAR.			
3. INTERNAL M/CD CORNER RADII 1 TO 0.7.				CHD. MSRAM SD 30.11.18			
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.				APPD. K.H.R.K SD 30.11.18			

DEPT. PUMPS	SCALE N.T.S	WEIGHT (KG) 204.4	REF. TO ASSY DRG. -NA-	ITEM NO. -NA-	NO. OF ITEMS -NA-
TITLE IMPELLER WEAR RING: CV-CWP			DRAWING NO. 1 182 36 1 7136 REV. 00		
SHEET NO. 01			NO OF SHEETS 01		