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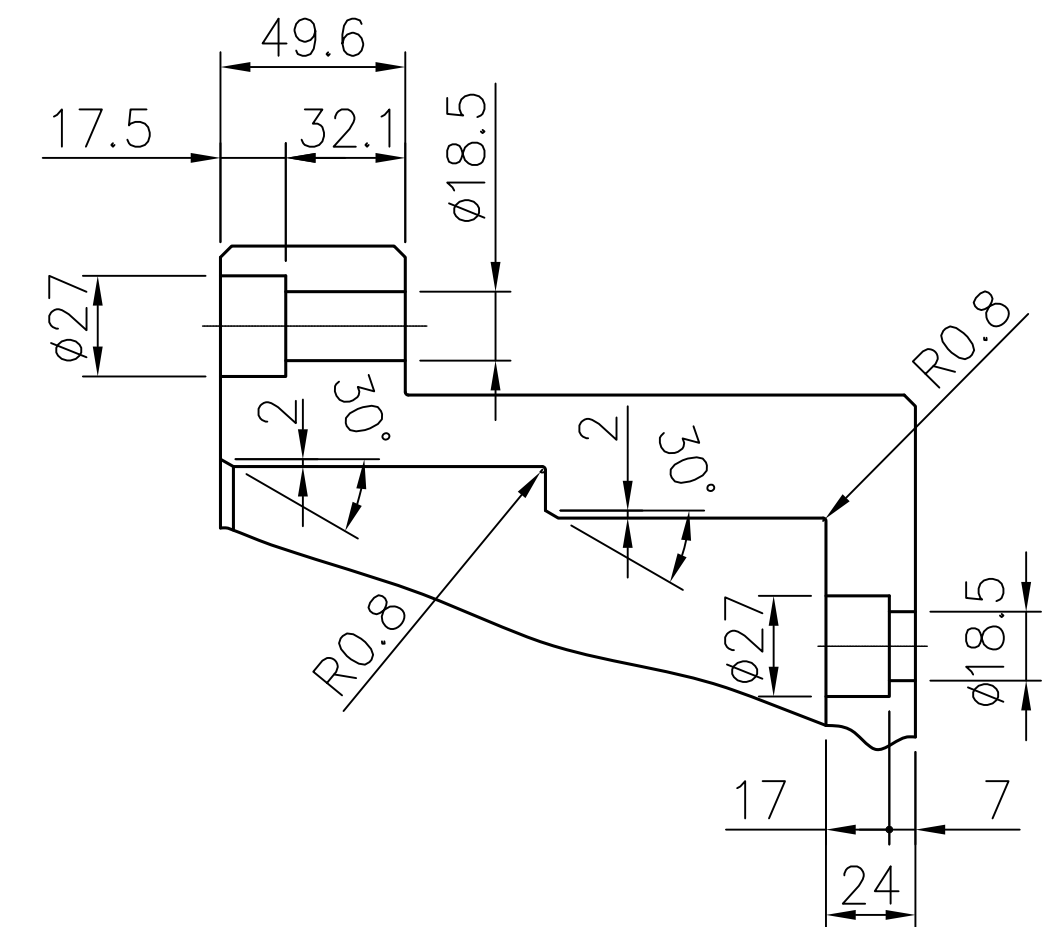
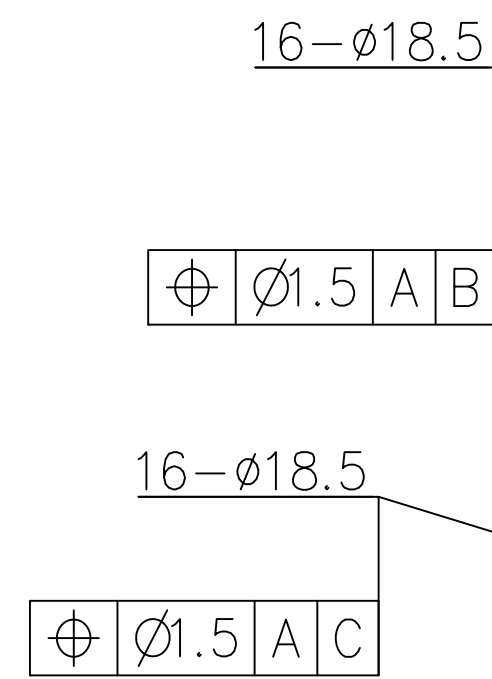
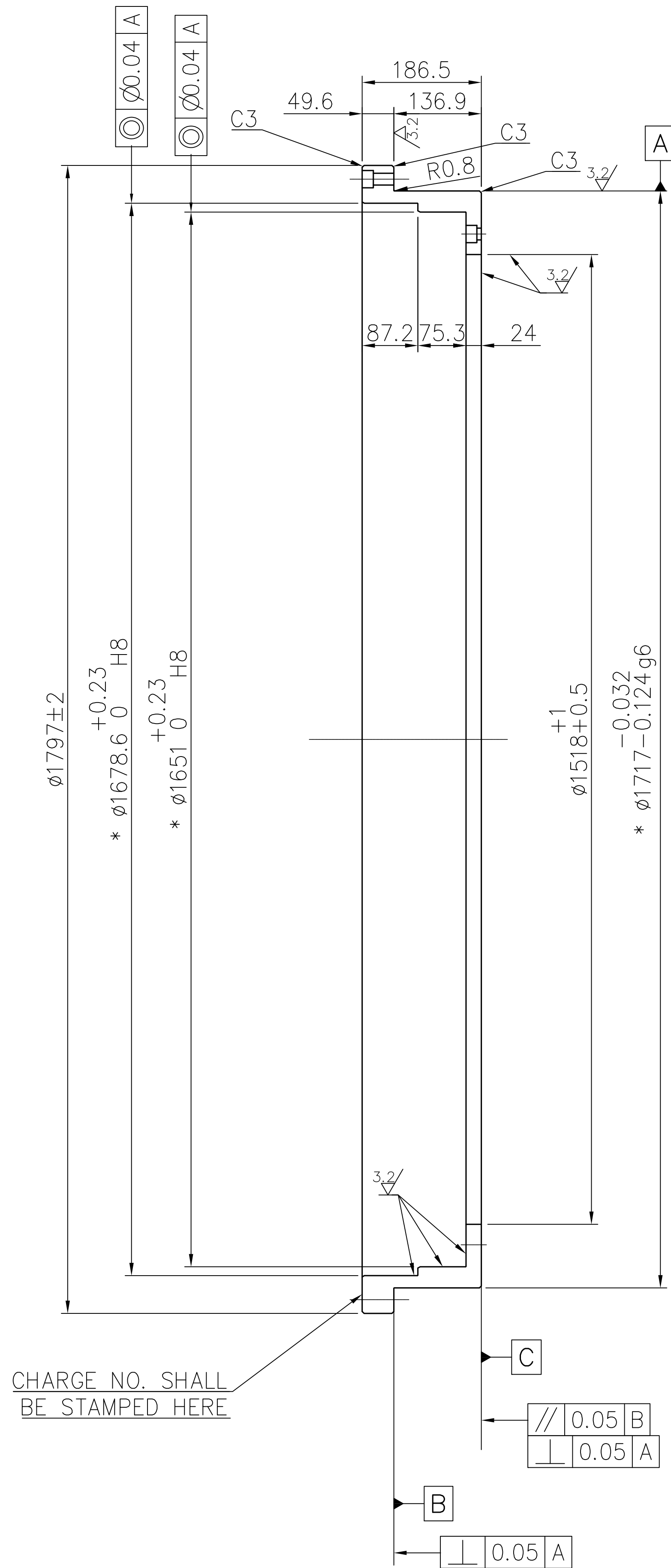
INVENTORY NO. SIGN. AND DATE REF. DRG. NO. COMPUTER FILE NAME :  
1 182 65 1 0031 300 B00

DRG. NO. 1 182 65 1 0031

FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

12.5/3.2



### NOTES

- 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  $-20^{\circ}\text{C}$  FOLLOWED BY COOLING AT THE AMBIENT TEMP. IS REQUIRED TO MITIGATE STRAIN. TEMP. CHART TO BE SUBMITTED.
- STRAIN DURING MACHINING SHALL BE PAID ATTENTION.
- IMPELLER WEAR RING  $\phi 1673.6$ , CLEARANCE  $5.00 \sim 5.46$  ON DIA. IMPELLER WEAR RING  $\phi 1646$ , CLEARANCE  $5.00 \sim 5.46$  ON DIA.
- PERMISSIBLE DIMENSION OF \* MARKED DIMENSIONS IS AT  $20^{\circ}\text{C}$ .
- 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

4-M20 FOR EYEBOLT  
(AFTER ASSEMBLY, FILLER(TB#1212)  
SHALL BE FILLED UP  
B

| 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 |       |

| ITEM NO. | DESCRIPTION | DRAWING NO. | VAR. NO. | RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO. | MATERIAL CODE    | NET WT.  | GROSS WT. |
|----------|-------------|-------------|----------|---------------------------------------------------------|------------------|----------|-----------|
|          |             |             |          |                                                         | FP9716611102     | 356      |           |
|          |             |             |          |                                                         | 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.                                                                                                                           |  |  |  | MKSVP 220C CONCRETE VOLUTE PUMP             |  |  |  |
| 2. CHAMFER M/CD SHARP ED 1.2 TO 1.0 AT 45°.                                                                                                                      |  |  |  | BHARAT HEAVY ELECTRICALS LTD. HYDERABAD     |  |  |  |
| 3. INTERNAL M/CD CORNER RADI 1 TO 0.7.                                                                                                                           |  |  |  | DEPT. PUMPS                                 |  |  |  |
| 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. |  |  |  | SCALE N.T.S                                 |  |  |  |

|       |         |    |          |            |
|-------|---------|----|----------|------------|
| DRN.  | SUDHEER | SD | 30.11.18 | NO.OF VAR. |
| CHD.  | MSRAM   | SD | 30.11.18 |            |
| APPD. | K.H.R.K | SD | 30.11.18 |            |

|       |       |       |             |                   |          |             |
|-------|-------|-------|-------------|-------------------|----------|-------------|
| DEPT. | PUMPS | SCALE | WEIGHT (KG) | REF. TO ASSY DRG. | ITEM NO. | NO.OF ITEMS |
| CODE  | 410   | N.T.S | 356         | -NA-              | -NA-     | -NA-        |

|                          |  |                 |  |      |  |
|--------------------------|--|-----------------|--|------|--|
| TITLE                    |  | DRAWING NO.     |  | REV. |  |
| CASING WEAR RING: CV-CWP |  | 1 182 65 1 0031 |  | 00   |  |
| SHEET NO. 01             |  | NO OF SHEETS 01 |  |      |  |