

RADIUS RADIAL COORDINATE (AT FRONT SIDE OF BLADE)

NOTE TO SUPPLIER:

1. CASTING SHALL BE SUPPLIED IN ROUGH MACHINED CONDITION AS PER THIS DRAWING DIMENSIONS. THE FINISHING ALLOWANCE IS ABOUT 2MM.
2. SURFACE ROUGHNESS OF MACHINED SURFACES SHALL BE NOT OVER 6.3 MICRONS. SURFACE ROUGHNESS OF VANE&FLOW PASSAGE SHALL BE NOT OVER 5 MICRONS.
3. 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.
4. MANUFACTURE THIS IMPELLER BY PRECISION CASTING WITH THE GIVEN 3D=DATA.
5. 100% MPI ON CASTING SHALL BE DONE AS PER STD A40850133 AND ACCEPTANCE AS PER A40850134 LEVEL-II.
6. RADIOGRAPHY TEST SHALL BE CONDUCTED AS PER ASTM E142 AND ACCEPTANCE NORMS AS PER ASTM E446 LEVEL-II.
7. MATL SPECN SHALL BE AS PER HY19593.
8. ADDITIONAL QUALITY REQUIREMENTS SHALL BE AS PER FP60288.

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED

1. REF. TO HY0230261 FOR UNITS TOLERANCES.

2. CHAMFER M/CD SHARP EDGES 1.2 TO 1.0 AT 45°.

3. INTERNAL M/CD CORNER RADII TO 0.7.

4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOW UP SIDE BACK SLASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

भारत रेली इलेक्ट्रिकल्स लिमिटेड
रैलाव
BHARAT RLY ELECTRICAL LTD.
HYDERABAD

MDG406

DRN.	NAME	SIGN.	DATE	NO. OF W.A.R.
CHD.	ASH. K.		11.03.23	
APPD.	M.S.RAM		11.03.23	

DEPT.	PUMPS	SCALE	WEIGHT (KG)
CODE	410	NTS	NA

REF. TO ASSY DRG.	ITEM NO.	NO. OF ITEMS
	NA	NA

TITLE IMPELLER INTER STAGE (CASTING)

DRAWING NO. 0 180 40 2 4678 00

REV. 00

SHEET NO. 01 NO OF SHEETS 01