

INVENTORY NO.

REF.DRG.NO.
P2-Q99977-R0

COMP. FILE NAME
FP21804215078-00

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FIRST ANGLE PROJECTION

DRG.NO.
2 180 421 5078

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NOTE TO SUPPLIER:

1. TECHNICAL DELIVERY CONDITIONS SHALL BE AS PER HY19593.

2. ADDITIONAL QUALITY REQUIREMENTS SHALL BE AS PER FP60291.

3. STRESS RELIEVING SHALL BE DONE AFTER ANY WELDING WITHIN -20°C OF TEMPERING TEMPERATURE.

4. MANUFACTURE THE CASING IN ACCORDANCE WITH THE FOLLOWING DRAWINGS.

DESCRIPTION	DRG. NO. (INTERNAL REF.)	BHEL DRG.NO.	
1ST VOLUTE AND CROSSOVER DRAWING	P1-Q9978-R0	01804214676	CORE
STD VOLUTE AND SHORT CROSSOVER DRAWING	P1-Q9979-R0	01804214677	
LONG CROSSOVER DRAWING	P1-Q9980-R0	01804214678	
SUC.VOLUTE DRAWING	P1-Q9981-R0	01804214679	
DISCH.VOLUTE DRAWING	P1-Q9982-R0	01804214680	
COUP SIDE DRAWING	P1-Q9983-R0	01804214681	OUTLINE MOULD
END SIDE DRAWING	P1-Q9984-R0	01804214682	
LONGITUDINAL SECTIONAL DRAWING	P1-Q9985-R1	01804214683	
MATING FACE DRAWING	P1-Q9986-R2	01804214684	
OUTLINE DRAWING	P1-Q9987-R1	01804214685	

NOTE TO MACHINE SHOP:

1. MACHINE THE CASING IN ACCORDANCE WITH THE FOLLOWING DRAWINGS.

DESCRIPTION	DRG. NO. (INTERNAL REF.)	BHEL DRG.NO.
COUP SIDE DRAWING	P1-Q9983-R0	01804214681
END SIDE DRAWING	P1-Q9984-R0	01804214682
LONGITUDINAL SECTIONAL DRAWING	P1-Q9985-R1	01804214683
MATING FACE DRAWING	P1-Q9986-R2	01804214684
OUTLINE DRAWING	P1-Q9987-R1	01804214685
ADDL MACHINING DRAWING (tapping)	P1-Q9988-R0	01804214686
ADDL MACHINING DRAWING FOR VOLUTE EDGE(2ND TO 6TH STAGES)	P2-Q9989-R0	21804215076
IMPELLER&INNER CASING POLISHING PROCEDURE THE WATER PASSAGE	P5-19443-R0	FP60291
INNER CASING ASSY.	-	01804214687

2. STRESS RELIEVING SHALL BE DONE AFTER ROUGH MACHINING AND WELDING AS PER HY0640261, TEMPERATURE SHALL BE 590-650°C

3. LPI SHALL BE DONE AFTER ROUGH MACHINING AND AFTER FINAL MACHINING, AS PER AA0850131, ACCEPTANCE AS PER AA0850132, LEVEL-II.

ITEM NO

DESCRIPTION

DRAWING NO.

VAR. NO.

RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.

MATERIAL CODE

MATERIAL SPECN.

NET WT.

GROSS WT.

QUANTITY

FP9219306182

1640

1720

HY19593

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THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED...

1. REF.TO HY0230261 FOR UNSPECIFIED TOLERANCES.

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

3. INTERNAL M/CD CORNER RADII 1 TO 0.7.

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.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

MDG406

DEPT. PUMPS

CODE 410

SCALE NTS

WEIGHT(Kg) NA

REF. TO ASSY DRG. NA

ITEM NO. NA

NO.OF ITEMS NA

TITLE

INNER CASING M/C (UPPER & LOWER HALVES)

DRAWING NO. 2 180 42 1 5078

REV. 00

SHEET NO. 01

NO OF SHEETS 01

DRN. AS KALYAN

CHD. AS KALYAN

APPD. M.S.RAM

DATE 05.06.20

DATE 05.06.20

DATE 05.06.20

NAME

SIGN.

DATE

NO.OF VAR.

AS KALYAN

05.06.20

NA

DEPT. PUMPS

CODE 410

SCALE NTS

WEIGHT(Kg) NA

REF. TO ASSY DRG. NA

ITEM NO. NA

NO.OF ITEMS NA

TITLE

INNER CASING M/C (UPPER & LOWER HALVES)

DRAWING NO. 2 180 42 1 5078

REV. 00

SHEET NO. 01

NO OF SHEETS 01

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