

**FORGINGS – COUPLING HALF/THRUST COLLAR**

DESIGNATION : COUPLING HALF/THRUST COLLAR
FP90068-XX (var.no.)

DIMENSIONS : As per variant table

NDT REQUIREMENT : UT as per AA0850118, acceptance Cat-2.
MPI as per AA0850102, acceptance Cat-2.

FOR VAR.NOS.01~06 :

MATERIAL : AA10208 (for forgings inside)
IS1570 P-II, 40C8 (for forgings outside)

CONDITION : Forged, Normalised and rough machined

MECH PROPERTIES : As per matl.specn

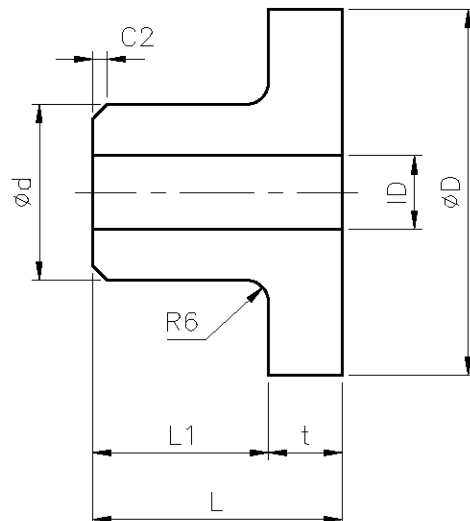
FOR VAR.NO.07 :

MATERIAL : AA10216 (for forgings inside)
IS1570 P-II, 45C8 (for forgings outside)

CONDITION : Forged, H&T and rough machined
(Hardening 820-870°C, oil quenching
Tempering 550-650°C, water cooling)

MECH PROPERTIES : TS>690 N/sq.mm, YS>490N/sq.mm
EL>17%, Ra>45%, Hardness=201-269BHN

12.5/
▽ All over



ALL DIMENSIONS ARE IN mm

VAR. NO.	ØD	Ød	ID	L	L1	t	Wt kg.	MATL NO. (Forging Inside) MATL CODE (Forging Outside)	M/C DRG. (for intl. ref.)	PUMP TYPE APPLICATION
01	170	90	35	90	55	35	8.4	FP90068-07	31861610002	100NCU COUPLING HALF
								FP9690068016	31861610003	
02	210	115	35	110	75	35	15.0	FP90068-02	21841610001	100CJH COUPLING HALF
								FP9690068024	21841610002	
03	210	115	45	110	75	35	14.3	FP90068-03	21851610001	125COAV/305 COUPLING HALF
								FP9790068034	21851610002	
04	325	170	60	170	110	60	55.0	FP90068-04	31811610002 31811610003 31811610005	150CJNV-CEP COUPLING HALF
								FP9690068040	11804015286	FK4E3-BFP THRUST COLLAR
05	250	170	50	210	80	130	61.0	FP90068-05	21871510001	150COAV COUPLING HALF DRIVEN PART
								FP9790068050		
06	240	120	50	125	80	45	21.0	FP90068-06	11804013543	FK2C45 THRUST COLLAR
								FP9790068069		
07	290	130	80	95	40	55	29.0	FP90068-07	21804015023	MDG455 THRUST COLLAR
								FP9790068077		

Revisions:

Refer to record of revisions

Prepared:

T.S.RAO

Approved:

J.GOPICHAND

Date:

28.9.1983



PRODUCT STANDARD

PUMPS
HYDERABAD

FP90068

Rev No. 10

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RECORD OF REVISIONS

REV.NO.	DATE	REVISION DETAILS	REVISED BY	APPRD. BY
01	21.3.85	TAPER 6" ADDED	TSR	YRL
02	21.5.86	VAR.NO. 06 ADDED.	TSR	YRL
03	19.9.88	FOR V.NO. 01 t WAS 49	TSR	YRL
04	10.8.89	STD. GENERALLY REVISED	TSR	YRL
05	9.1.90	MATL. WAS AA10208	TSR	YRL
06	15.10.99	STD. REDRAWN ON AUTOCAD	TSR	JGC
07	10.03.04	MATERIAL CODE ADDED FOR FK4E36 AT VAR.NO. 04	MSR	BRK
08	29.12.05	SPECN TITLE, PUMP TYPE DETAILS	MSR	BRK
09	10.04.13	VAR NO. 07 ADDED	ASK	MSR
10	10.04.17	Material codes added for Forgings Outside. Dimns, wts & specn revised.	MSRAM	KHRK

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