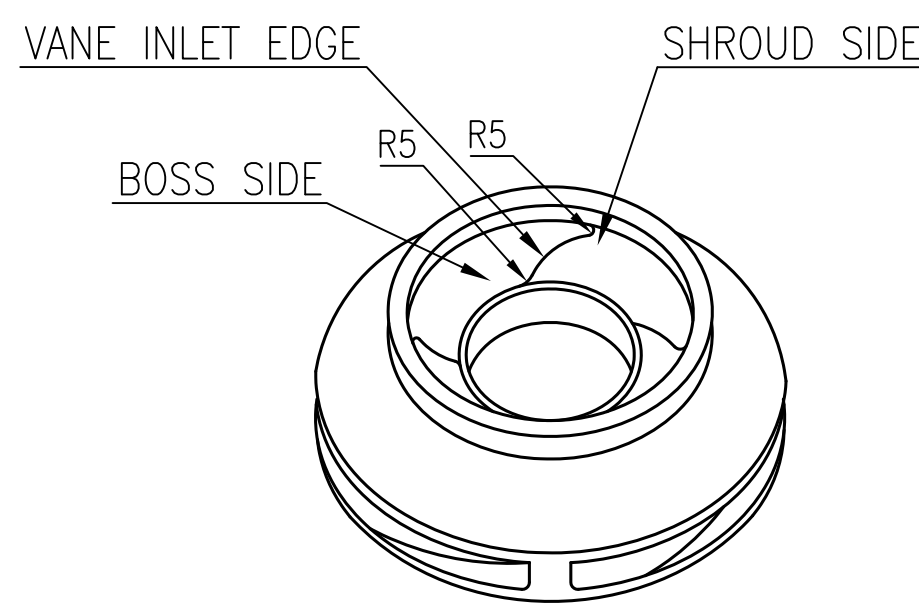
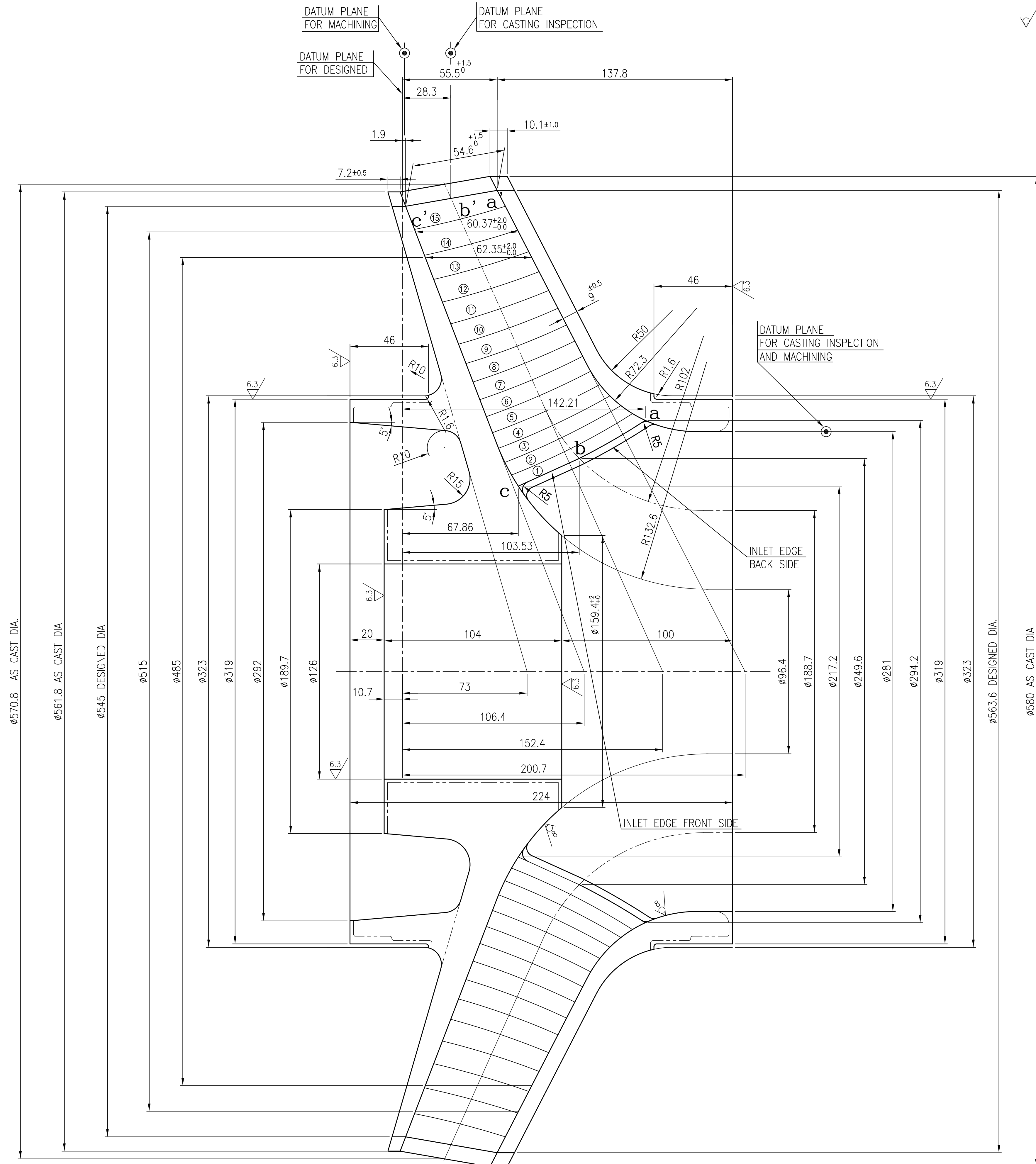


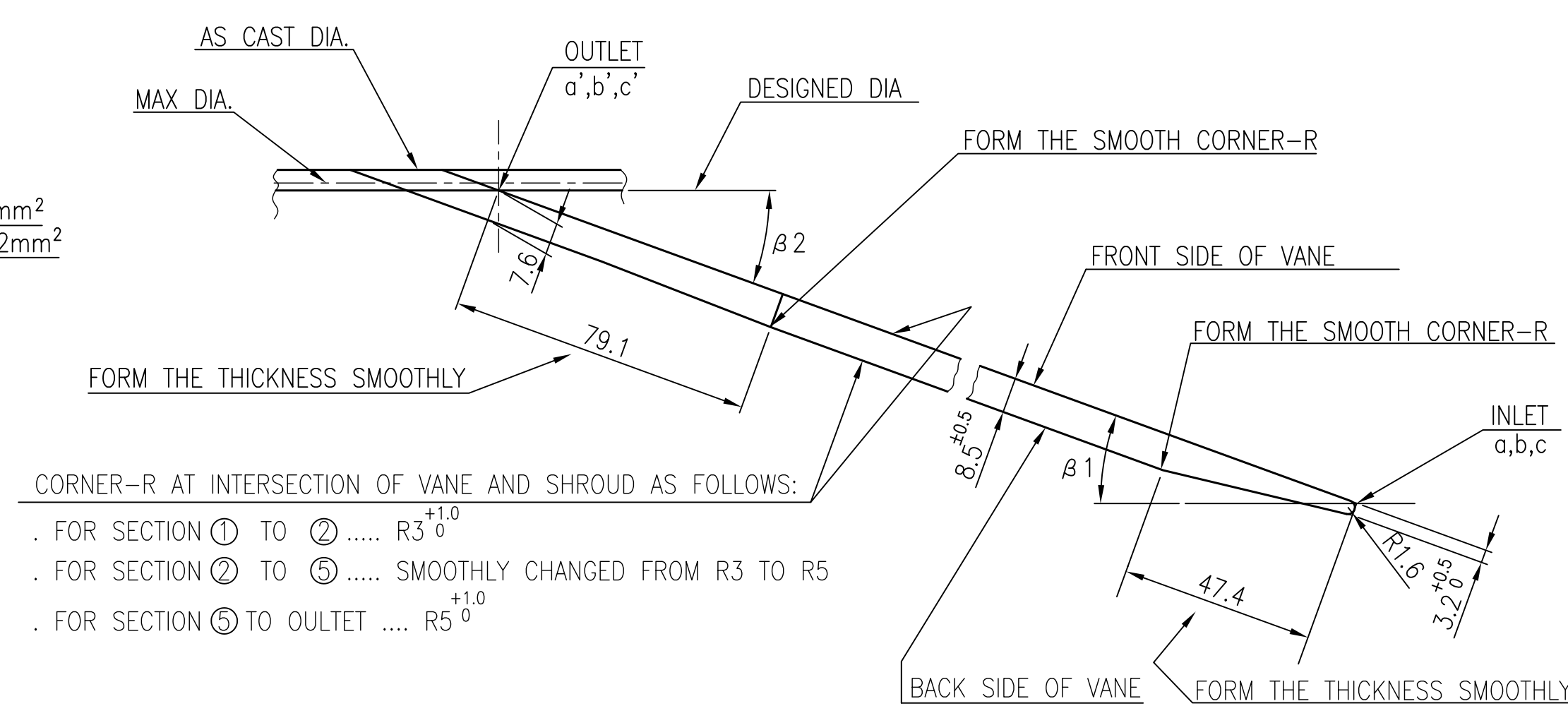


RADIUS RADIAL COORDINATE (AT THE FRONT SIDE OF THE VANE)

	①	②	③	④	⑤	⑥	⑦	⑧	⑨	⑩	⑪	⑫	⑬	⑭	⑮	DESIGNED DIA	INLET ANGLE	OUTLET ANGLE
a-a'	147.10	150.78	155.43	161.22	167.96	175.74	184.37	193.39	202.87	212.74	223.18	234.19	245.95	258.58	272.33	281.80	16.71°	19.18°
b-b'	124.80	130.38	136.83	144.23	152.49	161.41	170.71	180.48	190.63	201.26	212.55	224.41	237.04	250.51	265.03	277.10	18.42°	20.00°
c-c'	108.45	114.91	122.31	130.57	139.68	149.17	159.04	169.47	180.29	191.68	203.63	216.25	229.54	243.77	258.95	272.50	20.72°	20.72°

[illegible]

DETAIL OF VANE INLET, OUTLET



DETAIL OF VANE INLET, OUTLET

NOTE TO FOUNDRY:—

1. CASTINGS TO BE SUPPLIED IN MACHINED CONDITION AS PER DIMENSIONS INDICATED IN THIS DRAWING.
2. SURFACE FINISH IN FLOW PASSAGES SHALL BE 8 MICRONS.
3. MAJOR WELD REPAIRS SHALL BE DONE AS PER PRODUCT STD NO.FP70006. MINOR WELD REPAIRS SHALL BE DONE AS PER PRODUCT STD NO.FP70017. WELDER QUALIFICATION AS PER ASME-IX. REPAIR CHARTS SHALL BE FURNISHED FOR APPROVAL.
4. MPI TO BE DONE AS PER AA0850133 ACCEPTANCE AA0850134, LEVEL-II.
5. DP TO BE DONE ON ALL ACCESSIBLE AREAS AS PER AA0850131. ACCEPTANCE AS PER AA0850132, LEVEL-II.
6. CHAIN DOUBLE DASHED LINE INDICATES FINISH MACHINING.
7. FINAL MACHINING DRAWING NO. 01811214433.

					FP9219324482	83.9	83.9
					HY19593		1
			VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT. GROSS WT.	
					MATERIAL SPECN.	QUANTITY	
ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT. GROSS WT.	QUANTITY

THE FOLLOWING CONDITIONS APPLY 1. EXCEPT OTHERWISE STATED 2. REF. TO HY0230261 FOR UNLS TOLERANCES. 3. CHAMFER M/CD SHARP EDGE 1.2 TO 1.0 AT 45°. 4. INTERNAL M/CD CORNER RADII TO 0.7. 5. 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  भारत होलोकॉन्कयु लिमिटेड देहली BHARAT HEV ELECTRICAL LTD. HYDERABAD				144RND-800							
DEPT. PUMPS CODE 410		 SCALE NTS		WEIGHT (KG) 83.9		NAME ACAD.		SIGN. 		DATE 01.08.14		NO. OF V. -NA-			
REF. TO ASSY DRG.		REF.		DATE 01.08.14		NAME M.S.RAM		SIGN.		DATE 01.08.14		NO. OF ITEMS -NA-			
TITLE IMPELLER INTER STAGE (CASTING)				DRAWING NO. 0 181 12 4434 03				REV. 03							
SHEET NO. 01				NO. OF SHEETS 03				13				14			
												15			
												16			