



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 AA0850133 AND ACCEPTANCE AS PER AA0850134 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.

SECTION	①	②	③	④	⑤	⑥	⑦	⑧	⑨	⑩	⑪	⑫	INLET
ANGLE	0°	10°	20°	30°	40°	50°	60°	70°	80°	90°	100°	110°	
a-a'	166.73	154.95	146.46	138.92	133.26	128.08	123.01	118.65	114.76	111.70	108.16	105.34	103.995
b-b'	166.73	154.95	145.51	136.68	130.19	124.31	119.00	114.29	110.17	106.05	101.92	98.97	96.62
c-c'	166.73	154.95	144.93	135.50	127.84	121.95	116.06	110.76	106.05	101.92	97.20	93.08	89.55

[illegible]