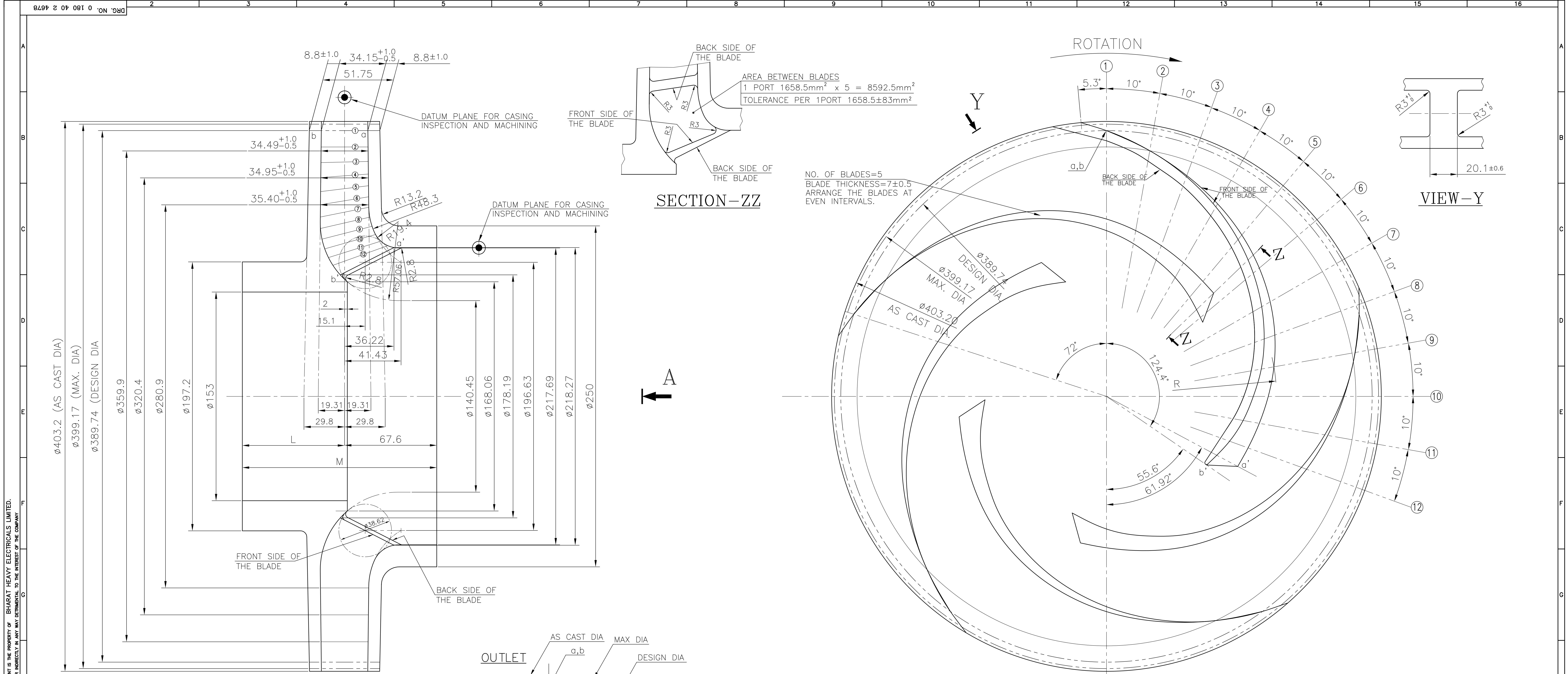
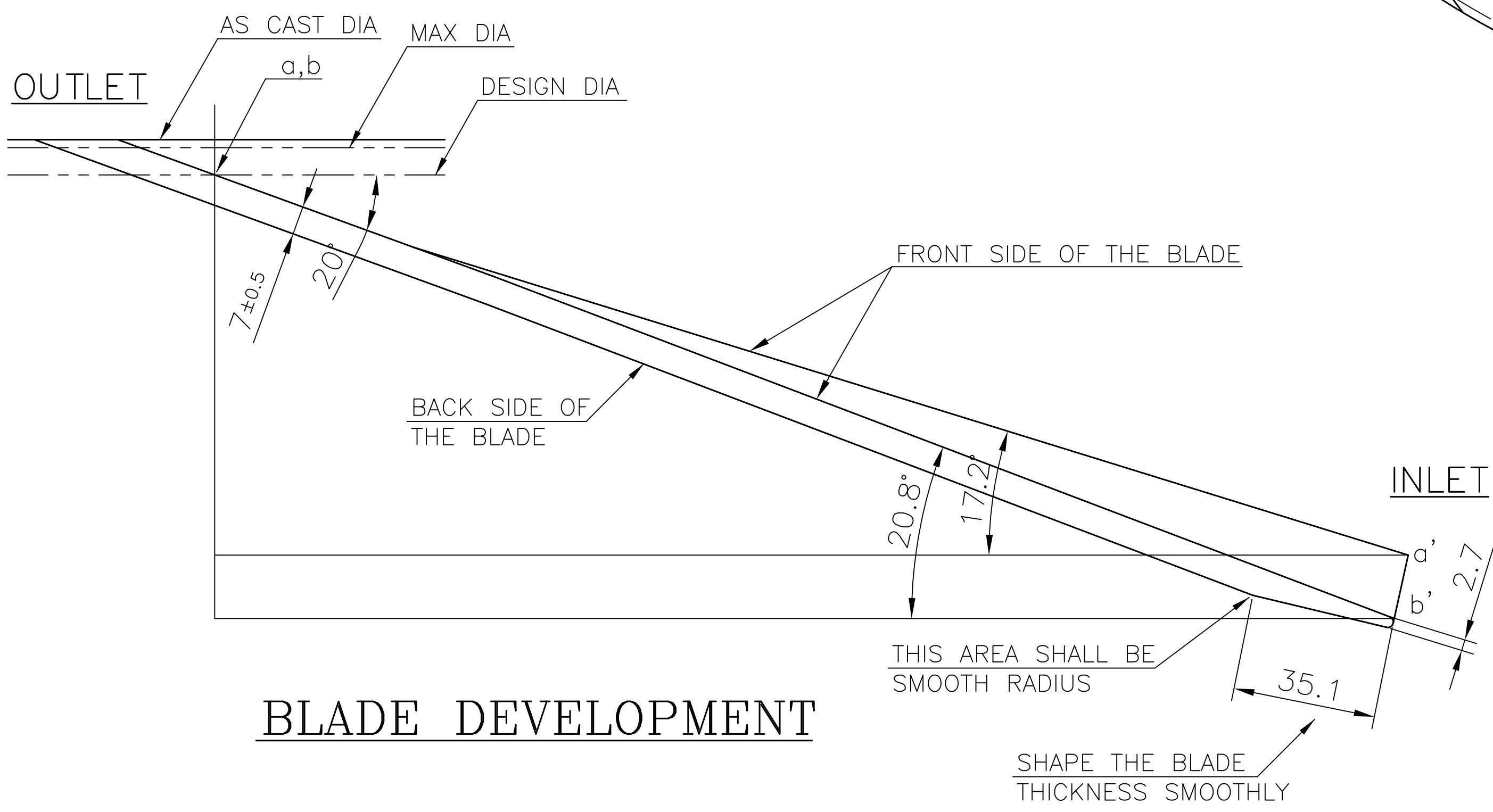




DIMENSIONS TABLE AND REMARKS				
MARK	L	M	ROTATING DIRECTION (VIEWED FROM SUCTION NOZZLE)	No. OF STG
01	75	142.6	C.W	2ND STAGE
02	113	180.6	C.W	3RD STAGE
03	75	142.6	C.C.W	4TH STAGE & 5TH STAGE
04	113	180.6	C.C.W	6TH STAGE

RADIUS RADIAL COORDINATE (AT FRONT SIDE OF BLADE)

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'	194.87	182.89	172.26	163.02	154.45	146.33	138.65	131.41	124.71	118.68	113.81	110.52	109.135
b-b'	194.87	182.87	171.42	160.44	150.16	140.53	131.51	123.10	115.29	108.17	101.78	93.10	89.095



NOTE TO SUPPLIER:

- CASTING SHALL BE SUPPLIED IN ROUGH MACHINED CONDITION AS PER THIS DRAWING DIMENSIONS. THE FINISHING ALLOWANCE IS ABOUT 2MM.
- SURFACE ROUGHNESS OF MACHINED SURFACES SHALL BE NOT OVER 6.3 MICRONS. SURFACE ROUGHNESS OF VANE&FLOW PASSAGE SHALL BE NOT OVER 5 MICRONS.
- 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.
- MANUFACTURE THIS IMPELLER BY PRECISION CASTING WITH THE GIVEN 3D-DATA.
- 100% MPI ON CASTING SHALL BE DONE AS PER STD AA0850133 AND ACCEPTANCE AS PER AA0850134 LEVEL-II.
- RADIOGRAPHY TEST SHALL BE CONDUCTED AS PER ASTM E142 AND ACCEPTANCE NORMS AS PER ASTM E446 LEVEL-II.
- MATL SPECN SHALL BE AS PER HY19593.
- ADDITIONAL QUALITY REQUIREMENTS SHALL BE AS PER FP60288.

ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT. GROSS WT.
04	IMPELLER 6TH STG				FP9219324857	30.9
03	IMPELLER 4TH STG AND 5TH STG				FP9219324849	27.3
02	IMPELLER 3RD STG				FP9219324830	30.9
01	IMPELLER 2ND STG				FP9219324822	27.3

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED

- REF TO HY0230261 FOR UNSTATED TOLERANCES.
- CHAMFER W/CD SHARP EDG 1.2 TO 1.0 AT 45°.
- INTERNAL W/CD CORNER RADIUS 1 TO 0.7.
- 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

NAME OF CUSTOMER/PROJECT

MDG406

DEPT. PUMPS

SCALE

NTS

WEIGHT (KG)

REF. TO ASSY DRG.

ITEM NO.

NO OF ITEMS

TITLE

IMPELLER INTER STAGE (CASTING)

DRAWING NO.

0 180 40 2 4678

REV.

00

SHEET NO. 01

NO OF SHEETS 01