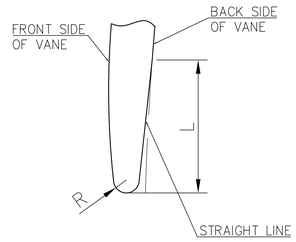
FIRST ANGLE PROJECTION

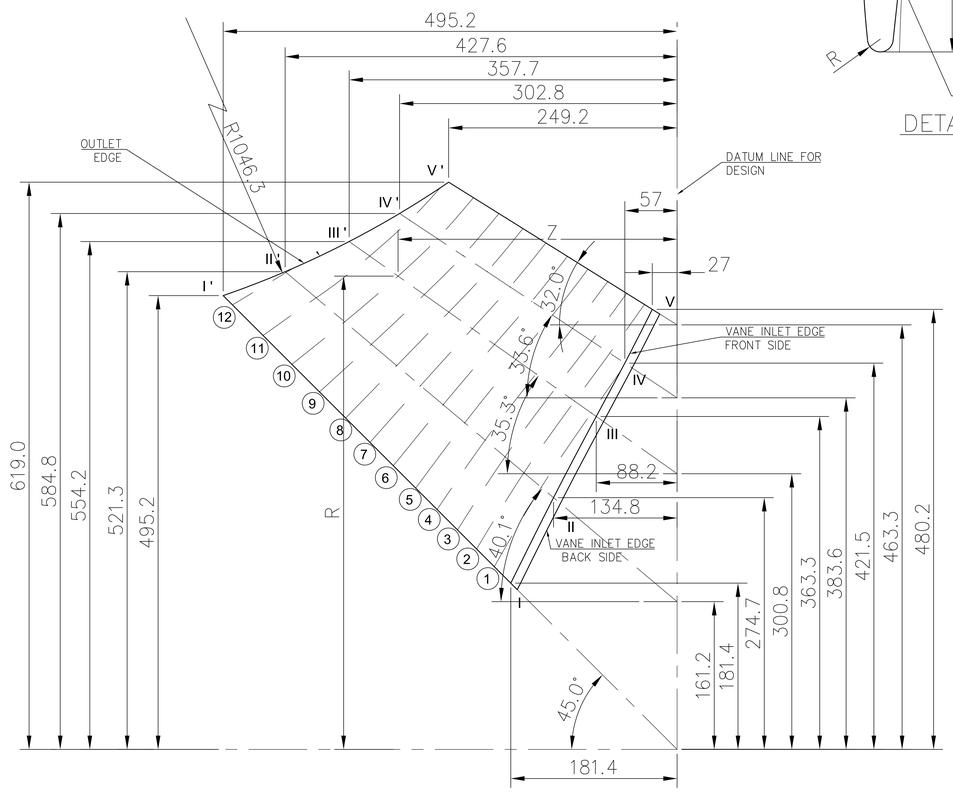
(ALL DIMENSIONS ARE IN mm)

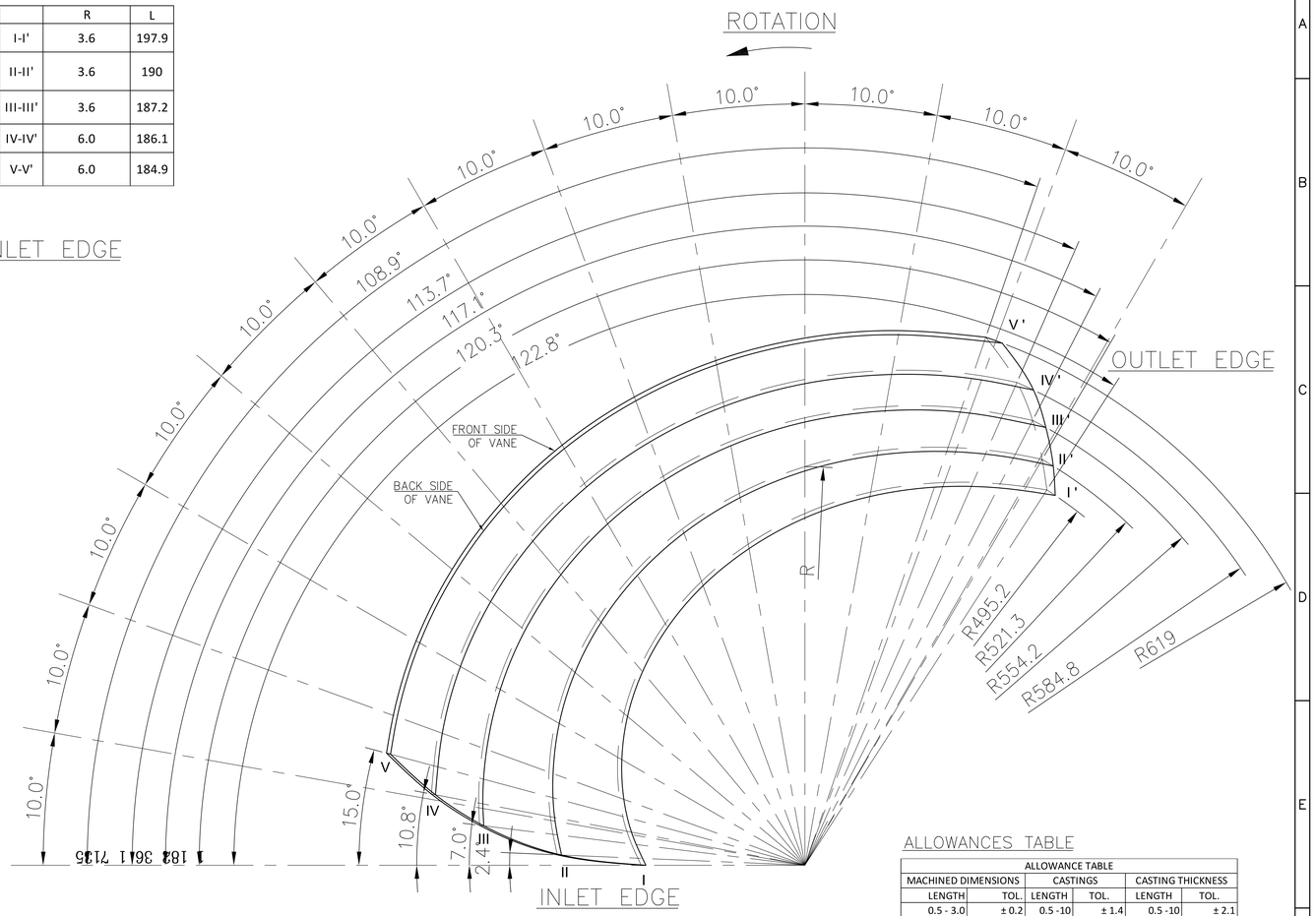
DRG. NO. 0 183 50 2 0014



DETAIL OF INLET EDGE

	R	L
I-I'	3.6	197.9
II-II'	3.6	190
III-III'	3.6	187.2
IV-IV'	6.0	186.1
V-V'	6.0	184.9





ALLOWANCES TABLE

ALLOWANCE TABLE					
MACHINED DIMENSIONS		CASTINGS		CASTING THICKNESS	
LENGTH	TOL.	LENGTH	TOL.	LENGTH	TOL.
0.5 - 3.0	± 0.2	0.5 -10	± 1.4	0.5 -10	± 2.1
- 6.0	± 0.3	- 16	± 1.5	- 16	± 2.2
- 30	± 0.5	- 25	± 1.6	- 25	± 2.3
- 120	± 0.8	- 40	± 1.8	- 40	± 2.5
- 400	± 1.2	- 63	± 2.0	- 63	± 2.8
- 1000	± 2.0	- 100	± 2.2	- 100	± 3.0
- 2000	± 3.0	- 160	± 2.5	- 160	± 3.5
- 4000	± 4.0	- 250	± 2.8	- 250	± 4.0
- 8000	± 5.0	- 400	± 3.1	- 400	± 4.5
- 16000	± 6.0	- 630	± 3.5	- 630	± 5.0
		- 1000	± 4.0	- 1000	± 5.5
		- 1600	± 4.5	- 1600	± 6.5
		- 2500	± 5.0	- 2500	± 7.5
		- 4000	± 6.0	- 4000	± 8.5
		- 6300	± 7.0	- 6300	± 10.0
		- 10000	± 8.0	- 10000	± 11.5

RADIAL COORDINATES FOR THE FRONT SIDE OF THE VANE

		INLET		1	2	3	4	5	6	7	8	9	10	11	12	OUTLET		THICKNESS
		INLET ANGLE	INLET EDGE	10°	20°	30°	40°	50°	60°	70°	80°	90°	100°	110°	120°	OUTLET EDGE	OUTLET ANGLE	
I-I'	RP	0	181.43	199.42	218.71	239.53	261.82	285.14	309.56	335.01	361.61	390.11	420.25	451.70	485.05	495.19	122.8	14.3
	ZP		181.43	199.42	218.71	239.53	261.82	285.14	309.56	335.01	361.61	390.11	420.25	451.70	485.05	495.19		
II-II'	RP	2.4	274.73	286.02	301.88	319.26	337.46	356.32	376.10	396.92	418.78	442.05	466.57	492.79	520.42	521.29	120.3	14.3
	ZP		134.78	148.19	167.10	187.70	209.33	231.68	255.22	279.91	305.91	333.49	362.64	393.76	426.57	427.61		
III-III'	RP	7	363.30	367.06	380.03	394.58	409.79	425.43	441.89	459.11	477.15	496.22	516.44	538.30	-	554.18	117.1	14.3
	ZP		88.18	93.52	111.83	132.33	153.80	175.93	199.20	223.45	249.01	275.88	304.44	335.34	-	357.74		
IV-IV'	RP	10.8	421.50	-	432.40	445.54	459.44	473.88	488.97	504.72	521.35	538.79	557.32	577.43	-	584.79	113.7	14.3
	ZP		57.01	-	73.41	93.20	114.12	135.81	158.54	182.25	207.26	233.53	261.44	291.68	-	302.75		
V-V'	RP	15	480.15	-	485.54	497.64	510.50	524.02	538.02	552.68	568.33	584.68	602.06	-	-	618.98	108.9	14.3
	ZP		27.03	-	35.64	55.05	75.65	97.23	119.68	143.12	168.19	194.40	222.14	-	-	249.23		

NUMBER OF VANES = 5 (EQUALLY SPACED)

VANE THICKNESS = 14.3 ± 2.0

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

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: IMPELLER-SRP-220

भारत हेवी इलेक्ट्रिकल्स लिमिटेड हैदराबाद
BHARAT HEAVY ELECTRICALS LTD. HYDERABAD

	NAME	SIGN.	DATE
DRN.	ASK	–sd–	13.07.20
CHD.	MSR	–sd–	13.07.20
APPD.	HRK	–sd–	13.07.20

NO.OF VAR.

DEPT. PUMPS | CODE 410 | SCALE N.T.S | WEIGHT (KG) | REF. TO ASSY DRG. –NA– | ITEM NO. –NA– | NO.OF ITEMS –NA–

TITLE: IMPELLER VANE COORDINATES

DRAWING NO. 0 183 50 2 0014 | REV. 00

SHEET NO. | NO OF SHEETS

REV.	DATE	ALTERED	CHECKED	APPD.
ZONE				

THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY

COMPUTER FILE NAME : | REF. DRG. NO. | SIGN. AND DATE | INVENTORY NO

Sep Mon 21 13:34 2020

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