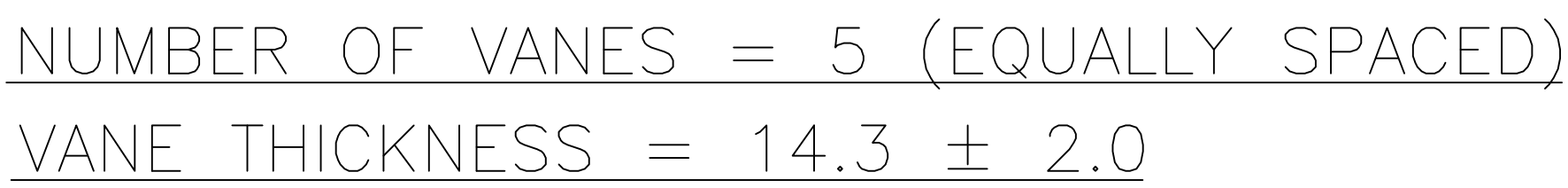
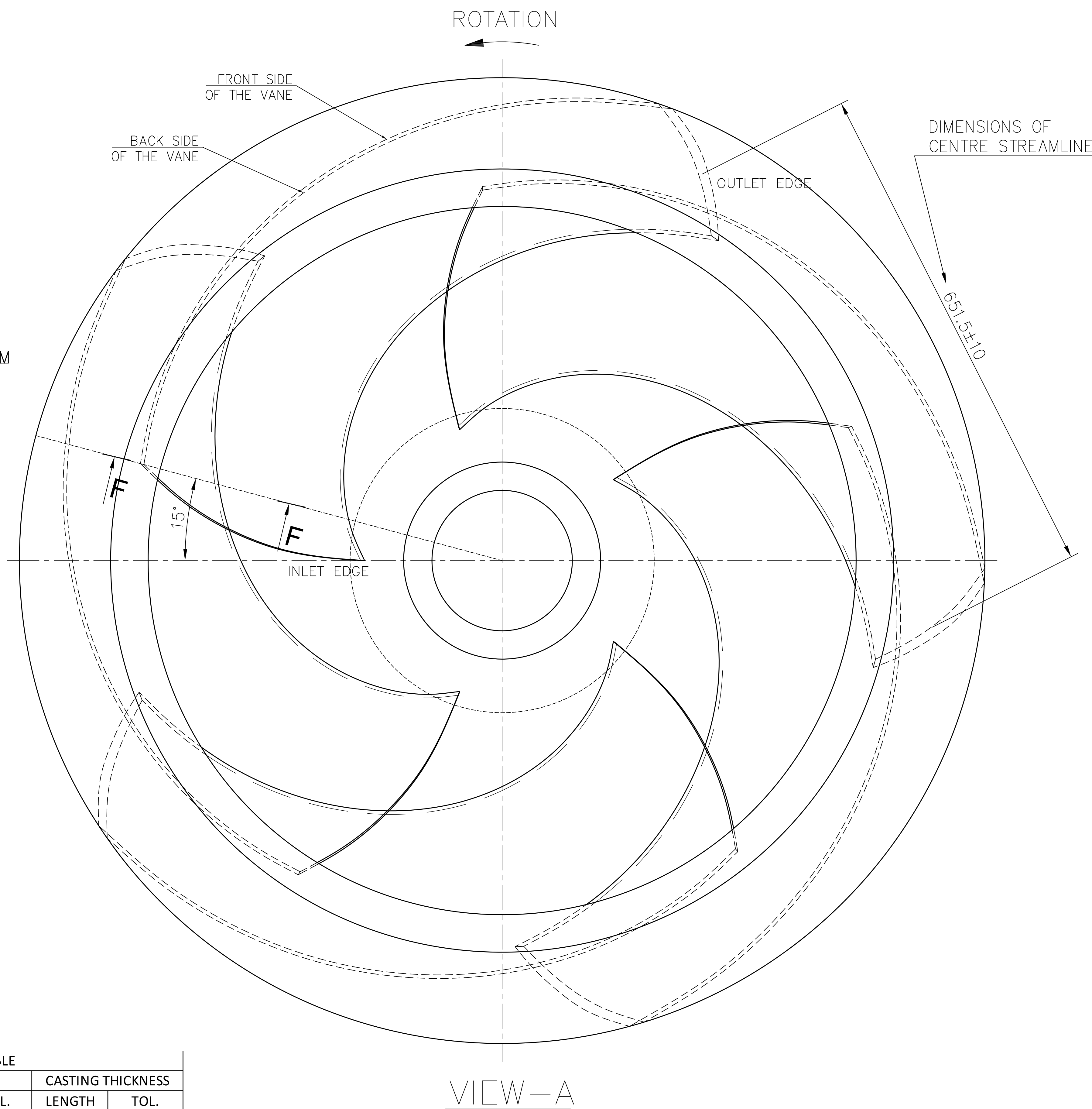


DRG. NO.

INVENTORY NO	SIGN. AND DATE	REF. DRG. NO.	COMPUTER FILE NAME :
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$$\frac{A (1 \text{ PORT})}{\Sigma A} = \frac{63552 \pm 3178 \text{ SQ.MM}}{63552 \times 5} = 317760 \text{ SQ.MM}$$

SECTION — FF



1. 3D MODEL OF IMPELLER SHALL BE SUBMITTED TO BHEL.
PATTERN SHALL BE OFFERED FOR WITNESS
2. IMPELLER FLOW PASSAGES SHALL HAVE A MIN. SURFACE FINISH OF 5 MICRONS.
REST OF THE SURFACES SHALL HAVE SURFACE FINISH OF 12.5 MICRONS
3. ALL VANE PROFILE DIMENSIONS WILL BE WITNESSED ON THE MACHINED BED.
SUPPLIER TO ARRANGE FOR THE SAME.
4. SUITABLE TEMPLATE OF ALL SECTIONS (SUCTION FACE AND PRESSURE FACE)
SHALL BE PREPARED AS PER HYDRAULIC DETAIL DRAWING FOR CHECKING
THE VANE PROFILE OF THE PATTERN
4. AS CAST IMPELLER WILL BE INSPECTED BY BHEL PRIOR TO DISPATCH.
5. FOR VANE COORDINATES, REFER 01835020014-00, T.D.C AS PER SPEC. FP50710

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

01	IMPELLER				FP9750710010		690
					FP50710		01
ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT.	GROSS WT.
					MATERIAL SPECN.		QUANTITY

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED...				TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT																								
1. REF.TO HY0230261 FOR UNSPECIFIED TOLERANCES.				IMPELLER-SRP-220																								
2. CHAMFER M/CD SHARP EDGES 1.2 TO 1.0 AT 45°.				भीएल भारत हीवी इलेक्ट्रिकल लिमिटेड दिल्ली भARAT HEAVY ELECTRICALS LTD. DELHI <table><tr><td></td><td>NAME</td><td>SIGN.</td><td>DATE</td><td>NO.OF VAR.</td></tr><tr><td>DRN.</td><td>ASK</td><td>—sd—</td><td>13.07.20</td><td></td></tr><tr><td>CHD.</td><td>MSR</td><td>—sd—</td><td>13.07.20</td><td></td></tr><tr><td>APPD.</td><td>HRK</td><td>—sd—</td><td>13.07.20</td><td></td></tr></table>					NAME	SIGN.	DATE	NO.OF VAR.	DRN.	ASK	—sd—	13.07.20		CHD.	MSR	—sd—	13.07.20		APPD.	HRK	—sd—	13.07.20		
	NAME	SIGN.	DATE	NO.OF VAR.																								
DRN.	ASK	—sd—	13.07.20																									
CHD.	MSR	—sd—	13.07.20																									
APPD.	HRK	—sd—	13.07.20																									
3. INTERNAL M/CD CORNER RADI 1 TO 0.7.				<table><tr><td>DEPT.</td><td>PUMPS</td><td>SCALE</td><td>WEIGHT (KG)</td><td>REF. TO ASSY DRG.</td><td>ITEM NO.</td><td>NO.OF ITEMS</td></tr><tr><td>CODE</td><td>410</td><td>N.T.S</td><td></td><td>—NA—</td><td>—NA—</td><td></td></tr></table>				DEPT.	PUMPS	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO.OF ITEMS	CODE	410	N.T.S		—NA—	—NA—								
DEPT.	PUMPS	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO.OF ITEMS																						
CODE	410	N.T.S		—NA—	—NA—																							
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.				<table><tr><td colspan="4">TITLE</td><td colspan="2">DRAWING NO.</td><td>REV.</td></tr><tr><td colspan="4">IMPELLER CASTING DRAWING</td><td colspan="2">0 183 50 2 0015</td><td>00</td></tr><tr><td colspan="4"></td><td colspan="2">SHEET NO.</td><td>NO OF SHEETS</td></tr></table>				TITLE				DRAWING NO.		REV.	IMPELLER CASTING DRAWING				0 183 50 2 0015		00					SHEET NO.		NO OF SHEETS
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