FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

DRAWING NUMBER 1-11605-01100

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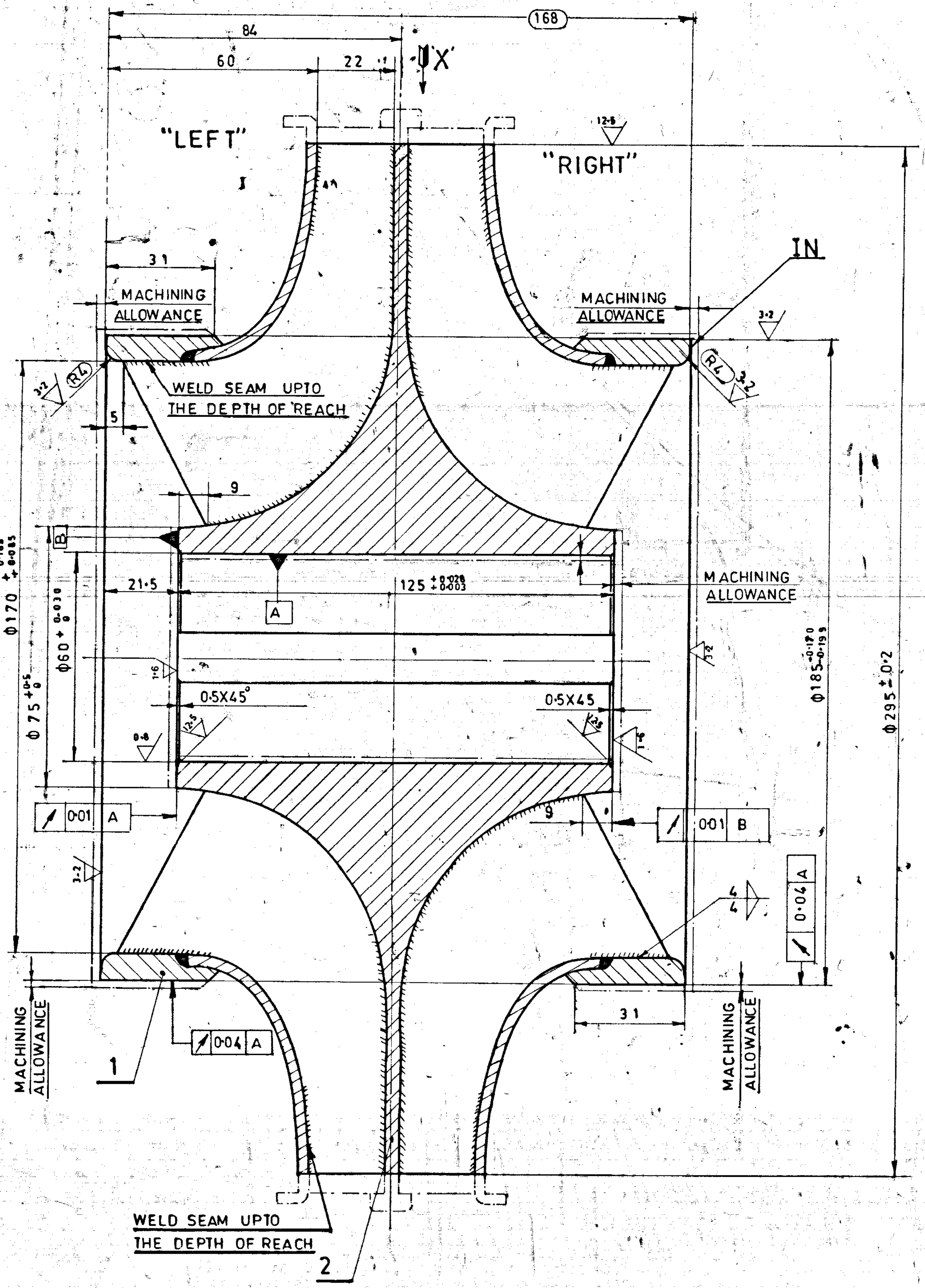
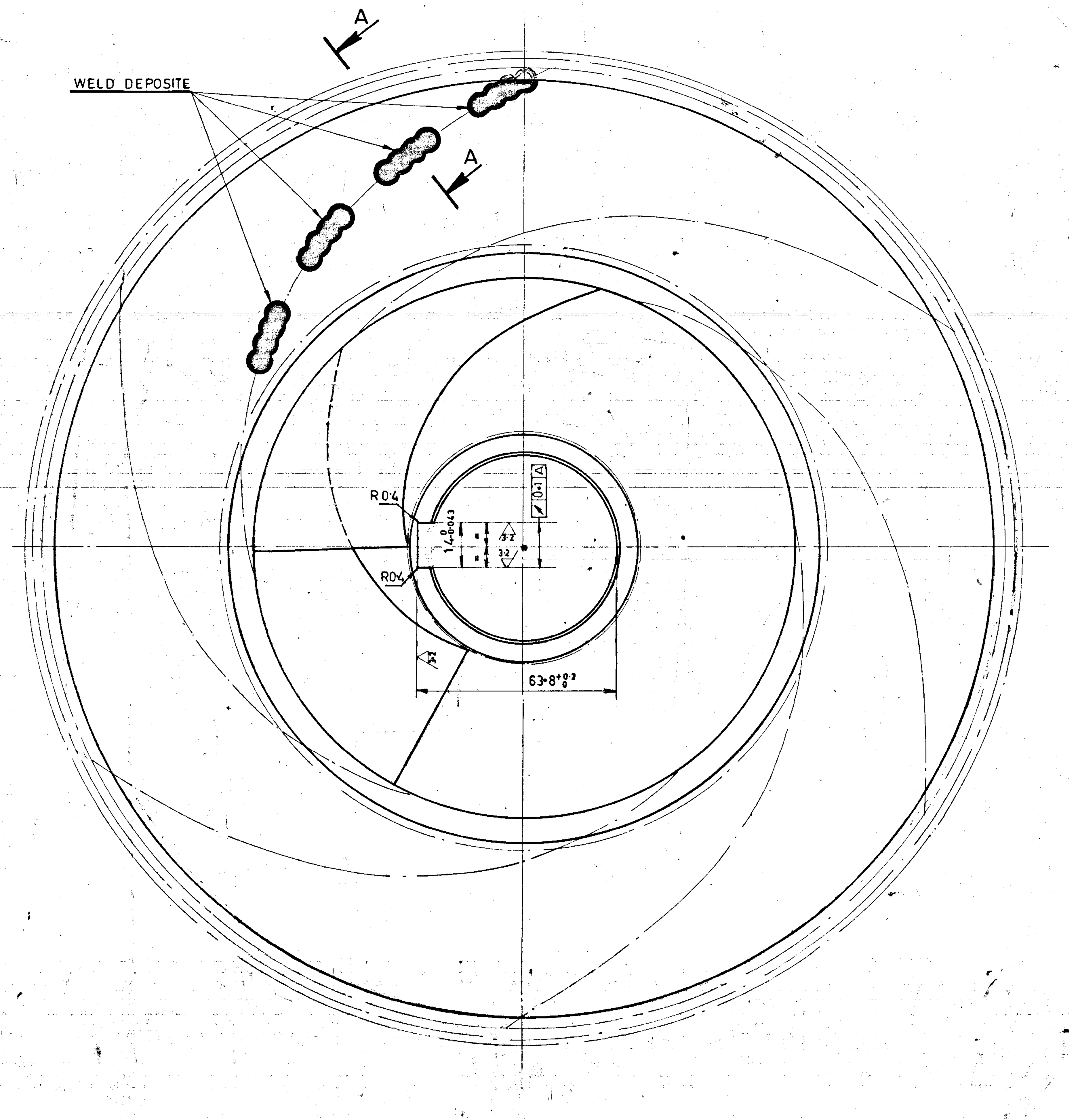


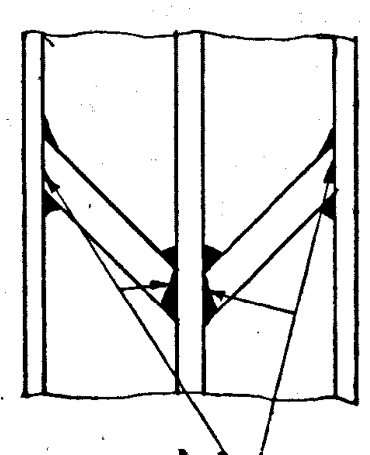


TECH. REQT:-

1. WELD CLASSIFICATION GROUP ACC. TO HW0620099: BK/ BS.
2. WELDING TEST SCOPE ACC. TO HW0850199: CATAGORY OF SERVICE REQT. 1.
3. DYE PENETRATION/MAGNETIC PARTICLE TEST SHALL BE CARRIED OUT TO ENSURE THAT WELD SEAM IS FREE FROM ANY CRACKS.
4. AFTER WELDING OF SIDE COVER ASSLY. AND DISC ASSLY. ITEM NO. 1 & 2 RESPECTIVELY, HEAT TREAT THE IMPELLER TO REMOVE THE INTERNAL STRESSES BEFORE FINAL MACHINING.
5. AFTER WELDING, CAREFULLY CLEAN THE PASSAGES TO REMOVE ANY METAL DEPOSITION.
6. DURING FINAL MACHINING THE DIMENSIONS ENCIRCLED AS (----) SHALL BE CONTROLLED & RECORDED.
7. AFTER FINAL MACHINING, THE IMPELLER SHALL BE STATICALLY BALANCED. MAX. PERMISSIBLE IMBALANCE IS 20GmCm.
8. DYNAMIC BALANCING OF THE IMPELLER SHOULD BE CARRIED OVER TOGETHER WITH SHAFT ITEM NO. 1 OF DRG. NO. 0-11605-01000, ALONG WITH ALL THE ROTATING PARTS. VIZ HYDRAULIC IMPELLER, HALF GEAR COUPLING ETC. THE MAX PERMISIBLE IMBALANCE IS 20 TO 40 Cm.Cm.
9. THE MATL. REMOVAL FOR BALANCING SHOULD BE DONE FROM THE PLACES AS GIVEN BELOW DEPENDING UPON THE AMOUNT OF THE MATL. REMOVAL.
   (1) BY TAPER GRINDING OF HOLES IN HYDRAULIC IMPELLER.
   (2) FINISHING OF OUTER BLADE EDGES.
   (3) FINISH MACHINING ON INNER DIA OF RING ITEM NO. 2
10. IDENTIFICATION ACC. TO HW0400397 AT THE PLACE MARKED WITH IN.

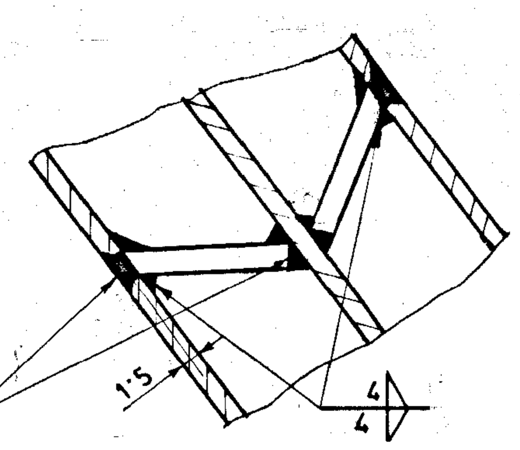
NOTE:-

IMPELLER CONSISTS OF TWO MAIN PARTS NO. 1 & 2 FOR SIDE COVER ASSLY. AND DISC ASSLY. AS PER DRG. NO. 2-11605-01110 AND 1-11605-01120 RESPECTIVELY.



VIEW 'X'

ANY GAP AND PENETRATION OR CAVITIES FOUND IN WELDING AFTER FINISH MACHINING OF OUTSIDE DIA 295±0.2 SHALL BE REPAIRED BY REWELDING AND REMACHINING.



SECTION A-A

INVENTORY NO.	SIGN & DATE	REF. DRG. NO.
51-15570		4132-11551

QTY. / VARIANT 00	REMARKS	DESCRIPTION	ITEM No.	STD.	DRAWING NO.	ITEM NO. / VARIANT	MATERIAL CODE / MATERIAL SPECN.	A C	COMP. GROUP	UNIT WT. (Kg.) / QUANTITY		DI	ZONE
		IMPELLER			1-11605-01100		W963116 05 01	C		17 00			
CARD TYPE 2						CARD TYPE 1							

GR. SP. NO.	STATUS OF DRG.
GMS 0-11605-01000	

AGREED DEPT.	NAME	SIGN	DATE

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: STEAM TURBINE 200/210 M.W.

BHARAT HEAVY ELECTRICALS LIMITED
HARDWAR

DEPT.	CODE	SCALE	WEIGHT (KG)	REF TO ASSY. DRG.	ITEM No.
S.T.E.	04011	1:1	17.00	0-11605-01000	071

TITLE: IMPELLER

	NAME	SIGN.	DATE
DRAWN	S.C.G.		4-1-81
CHECKED	B S G		10.1.81
APPROVED	M.R.K.		3.11.81

DIMENSIONS TO BE CONTROLLED WITHIN LIMITS AS SHOWN. MACHINING TOLERANCE ±.25 mm UNLESS OTHERWISE SHOWN. NON MACHINING TOLERANCE ±

CARD CODE	DRAWING NO.	REV.
	1-11605-01100	00

SHEET NO. 1 | NO. OF SHEETS:- 1

REV.	DATE	ALTERED / CHECKED	ZONE

LT-1-0059 SIZE A1