

DR. NO. 1-332-08-04408

FIGURE-A

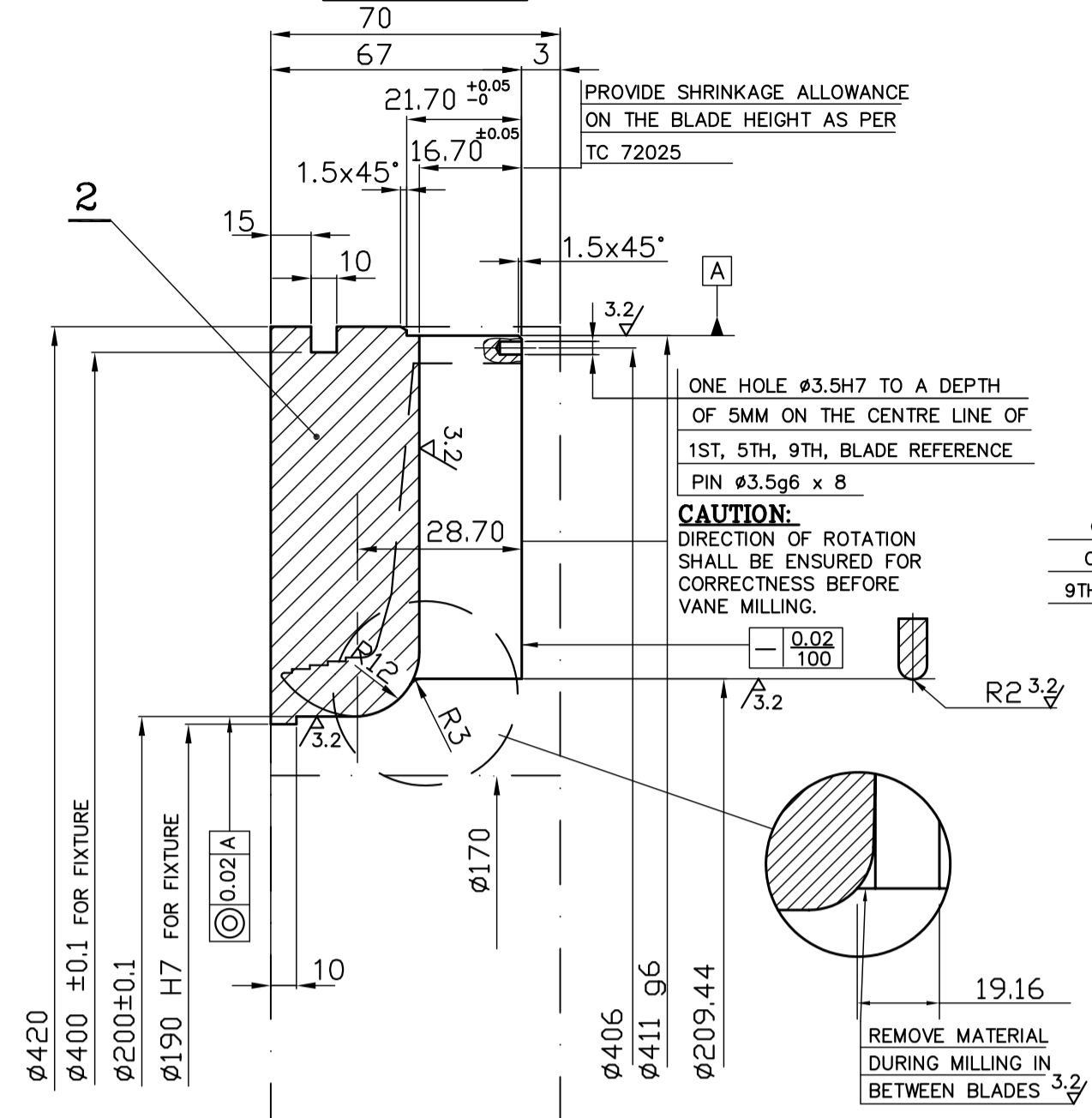
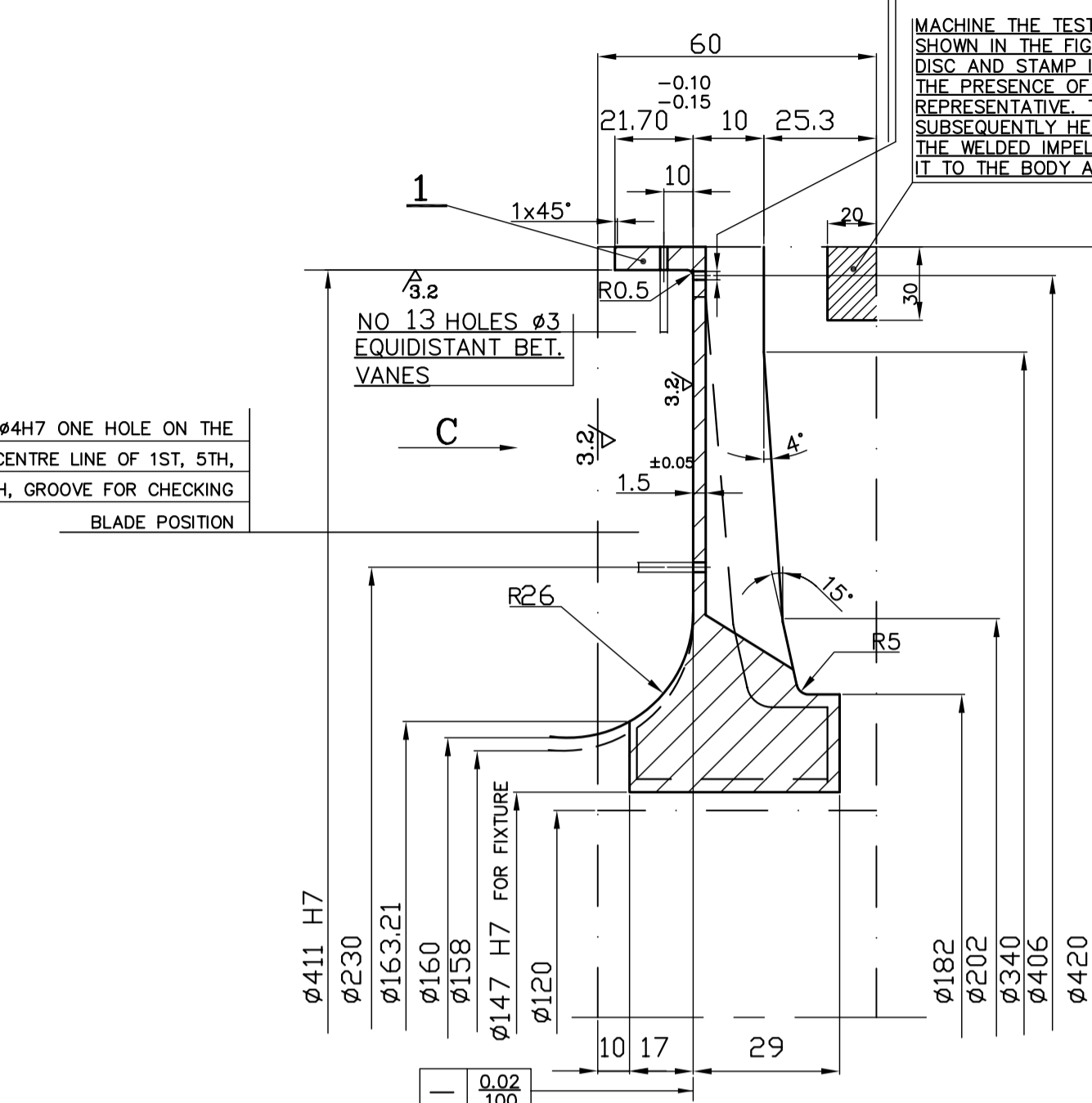
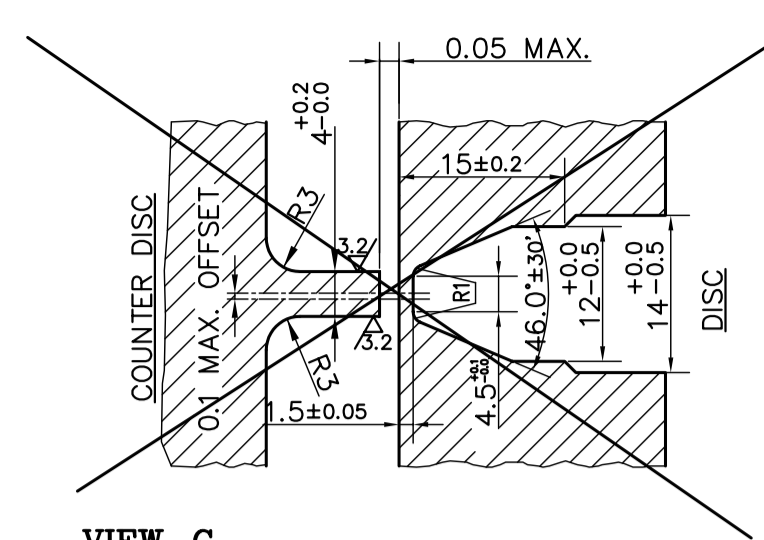


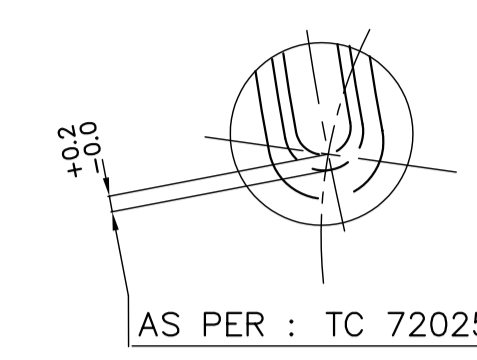
FIGURE-B



SECTION F-F



DETAIL V



VIEW-C

NO 13 GROOVES EQUIDISTANT TOLERANCES ON PITCH OVER EXT. DIA & INT. DIA IS ±0.1

RECOVER FROM THIS RING A TEST PIECE ACCORDING TO FIG. F AND RESERVE THE REMAINING MATERIAL FOR FURTHER TESTS

FIGURE-D

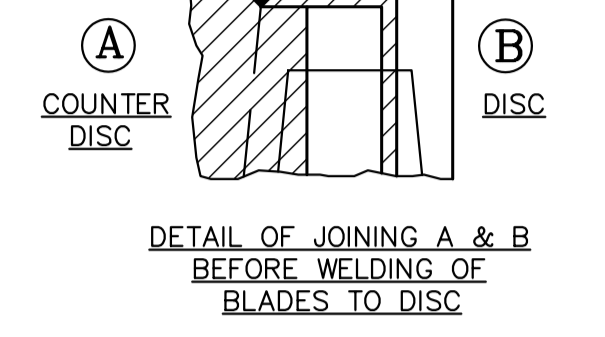
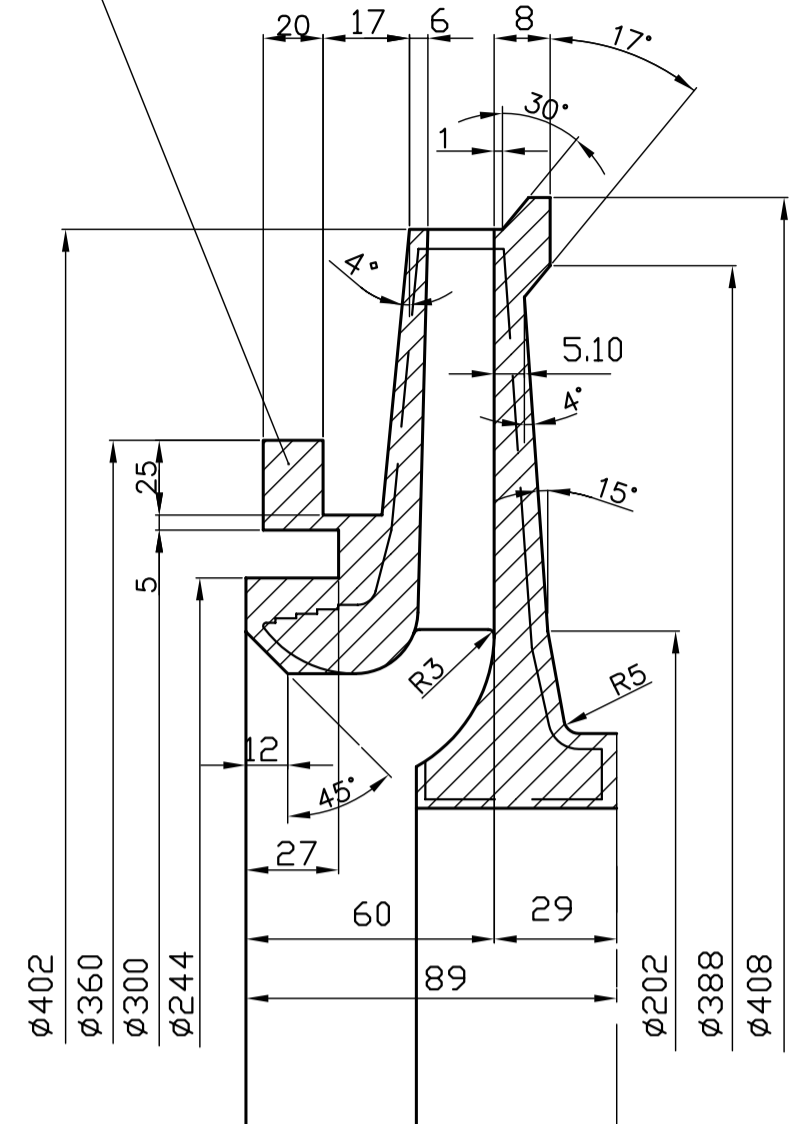
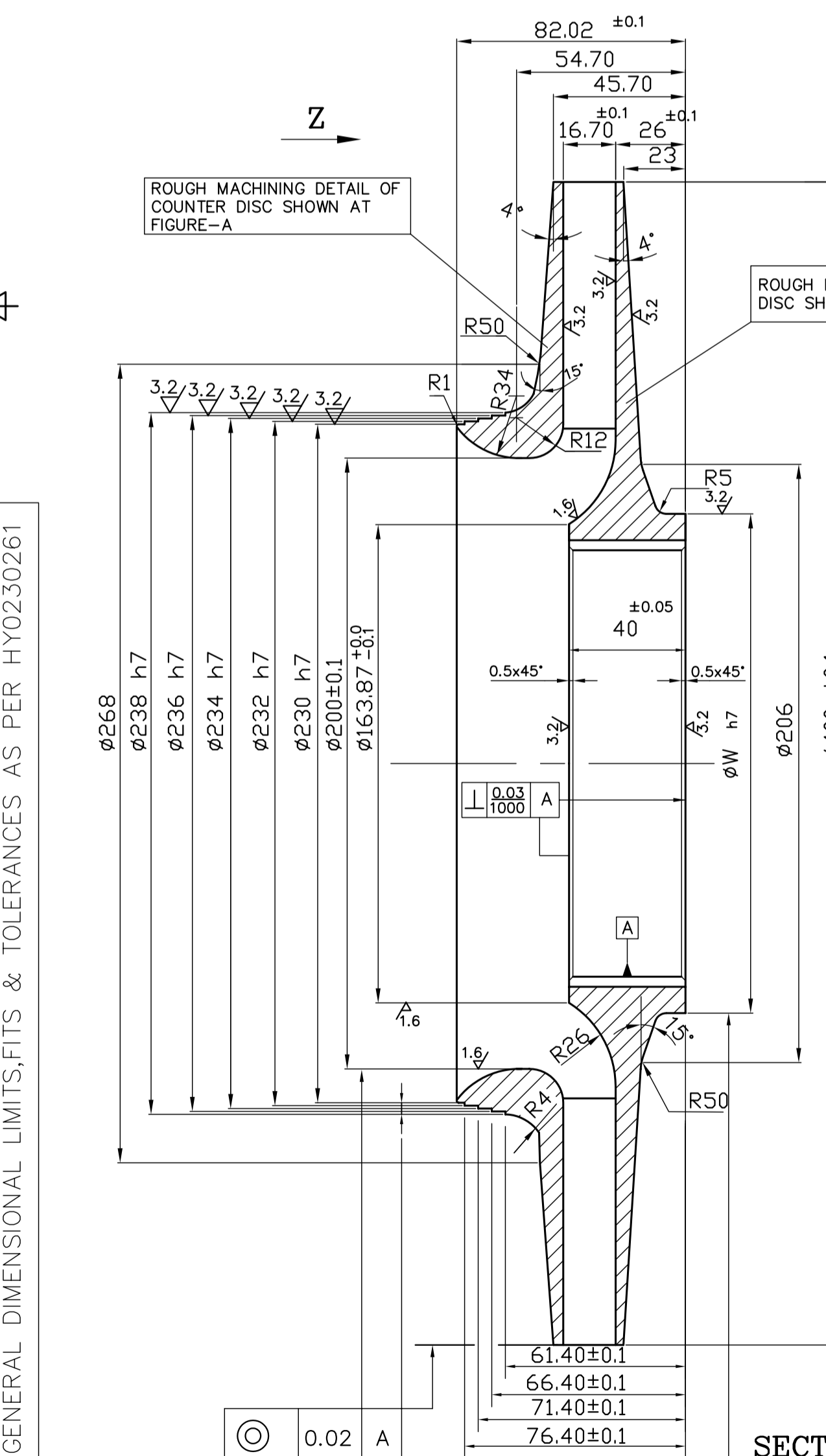
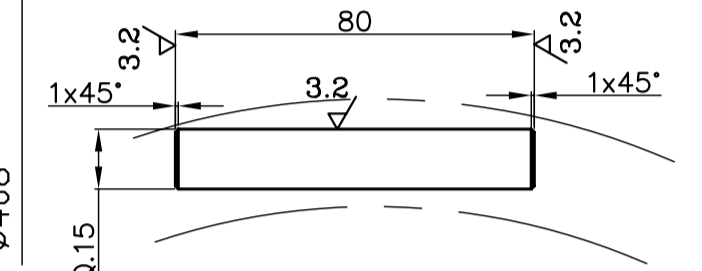
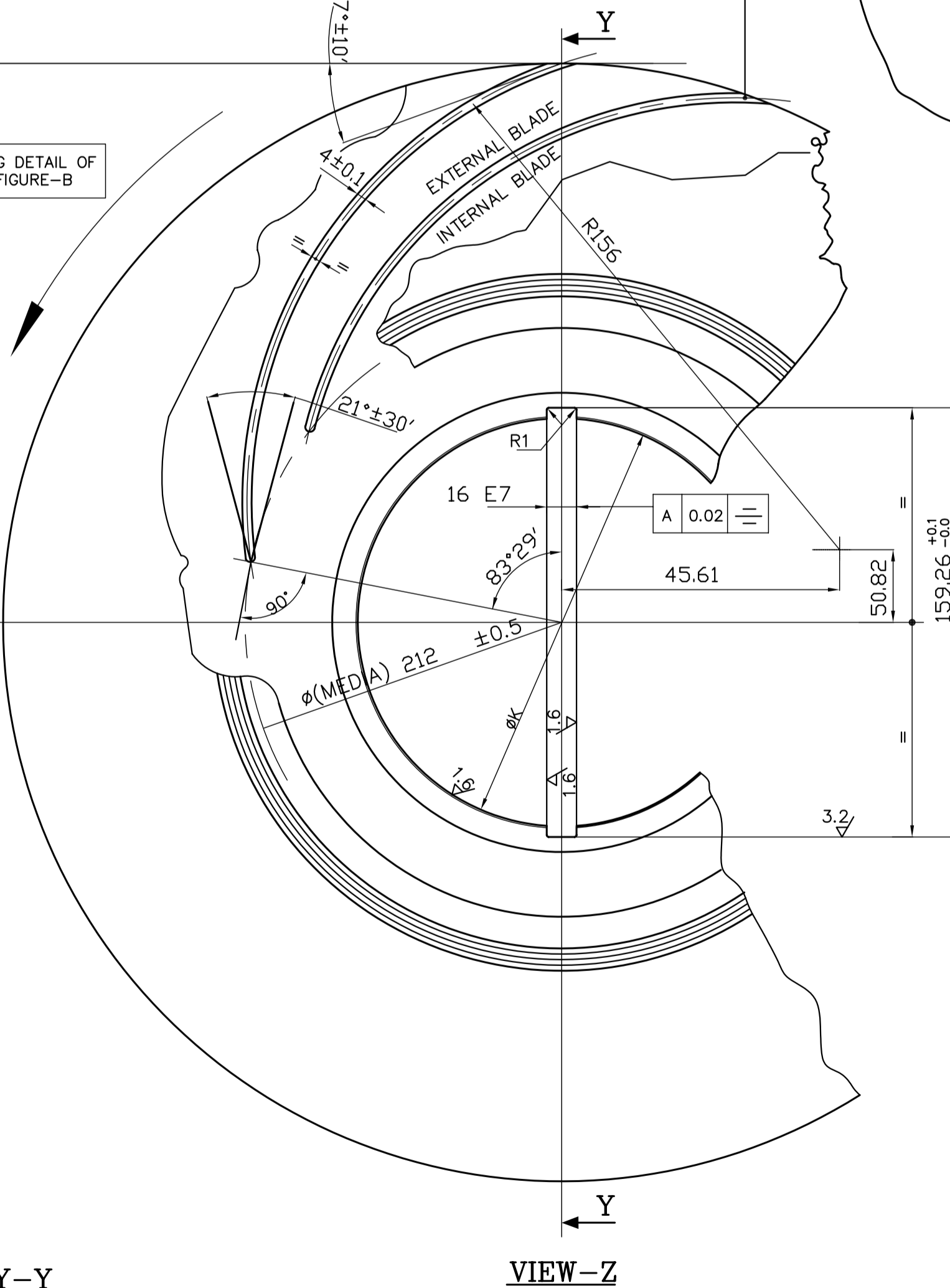


FIGURE-F



13-BLADES EQUIDISTANT. THE TOLERANCES ON THE PITCH OF BLADES MEASURED OVER DIA EXT. AND DIA INT. IS ±0.1



WELDING DETAIL FOR THE DETAILS OF EDGE PREPARATION AND WELDING SEE RELEVANT WPS

VAR NO	MATERIAL SPECIFICATION	HEAT TREATMENT CYCLE YS IN Kg /mm ²	WPS NO	øW	øK
01	HY 19377 (KMN COGNE)	55 TO 65	WE-364	ø175.74	ø152 ±0.02
02		65 TO 75	WE-358	ø175.74	ø152 ±0.02
03		85 TO 95	WE-359	ø175.71	ø152 ±0.04
04		100 TO 110	WE-385	ø175.71	ø152 ±0.04
05		60 TO 65	WE-364	ø175.74	ø152 ±0.02
06		70 TO 75	WE-358	ø175.74	ø152 ±0.02
07	HY 19391 (X12 Cr13)	55 TO 65	WE/EL/370	ø175.71	ø152 ±0.02
08		65 TO 75	WE/EL/371	ø175.71	ø152 ±0.02
09		60 TO 65	WE/EL/370	ø175.71	ø152 ±0.02
10		70 TO 75	WE/EL/371	ø175.71	ø152 ±0.02
11	HY 19395 (FV 520 B)	55 TO 63	WE/EL/370	ø175.71	ø152 ±0.02
12		85 TO 105	WE-347-H	ø175.71	ø152 ±0.04
13	HY 19395 (FV 520 B)	> 105	WE-		
14		68 TO 80	WE-347-GS	ø175.71	ø152 ±0.04
15		80 TO 95	WE-414	ø175.70	ø152 ±0.04
16					

CAUTION: INTERCHANGEABLE JOB NO DEVIATION PERMITTED

NOTE :- FOR PRODUCTION, INSPECTION AND TESTING OF IMPELLER. REFER SPECIFICATION NO ITN 07029 FOR SEQUENCE OF OPERATIONS

SCALE 1:1

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LTD. HYDERABAD

NAME	K.G.K	SIGN.	DATE	NO. OF VAR.
DRN.	G.S.S.P.K		16.08.05	
CHD.	P.N.R		17.08.05	
APPD.			18.08.05	

DEPT. COMPR. UNTO. DIMS. GR. C/M/F

SCALE NTS

WEIGHT (KG) 15.54

REF. TO ASSY. DRG.

ITEM NO. NO. OF ITEMS

TITLE IMPELLER DIA 400 F5- CCW

CARD CODE N.A.

DRAWING NO. 1-332-08-04408 05

REV. SHT. No. NO. OF SHT.

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GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261

REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED
05	15.09.05	CHD/APPD P.V.C	04	25.10.00	CHD/APPD P.V.C	03	25.02.00	CHD/APPD S.RAGHURAM	05	15.09.05	CHD/APPD P.V.C	04	25.10.00	CHD/APPD P.V.C	03	25.02.00	CHD/APPD S.RAGHURAM	05	15.09.05	CHD/APPD P.V.C
		WPS NO. ADDED & WELD GROOVE MODIFIED			DRAWING REDRAWN IN AUTOCAD R14			WPS TABLE ADDED												