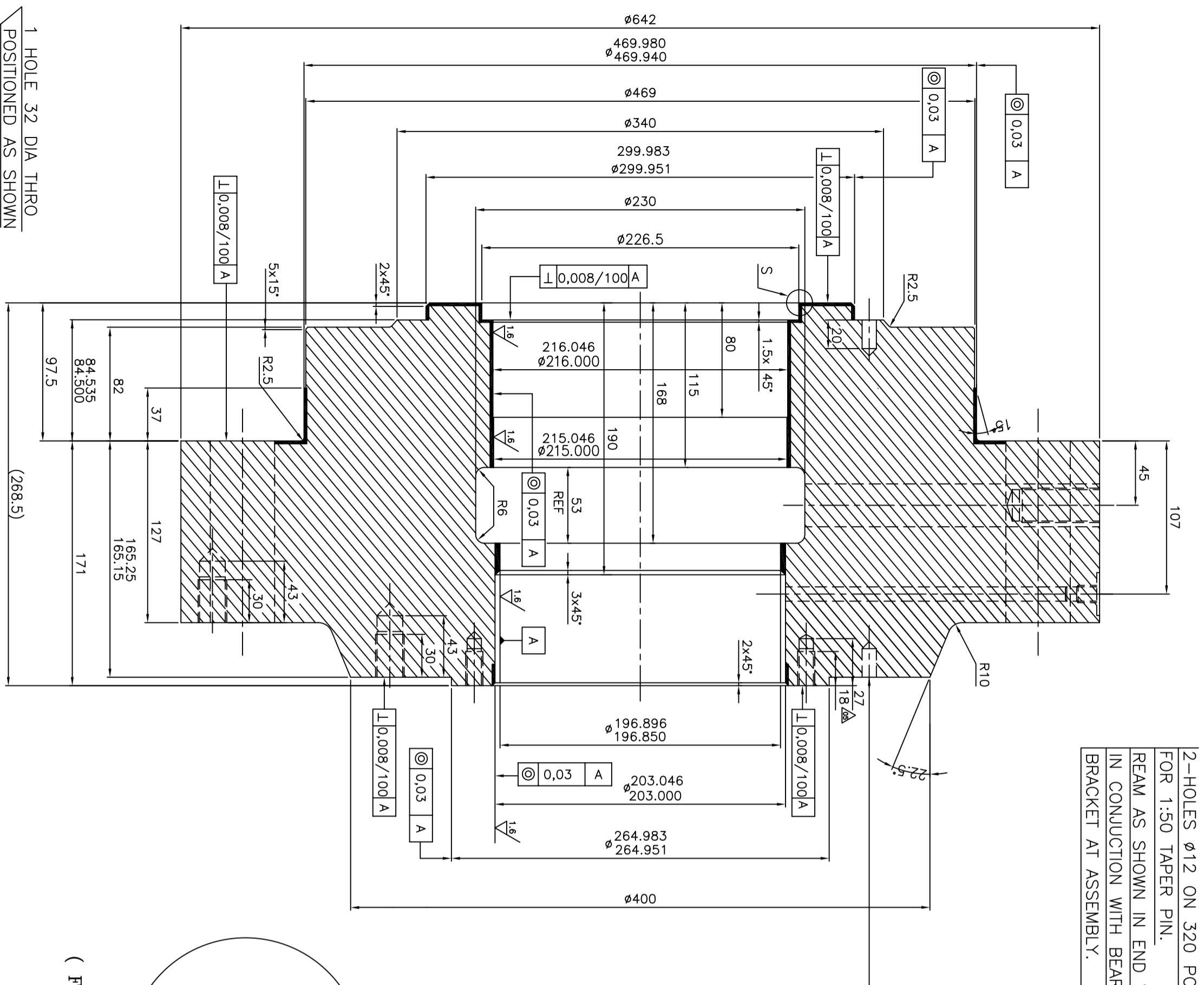


FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

3.2/1.6



2-HOLES $\phi 12$ ON 320 PCD
FOR 1:50 TAPER PIN.
REAM AS SHOWN IN END VIEW
IN CONJUNCTION WITH BEARING
BRACKET AT ASSEMBLY.

$\phi 45-16$ HOLES EQ. SPACED THRO.
2 HOLES DIA 12 THRO TAPPED 1/2" NPT

M24-6H-1HOLE SPOT FACING $\phi 60 \times 5$ -DEEP
MAX.DRILL DEPTH 61, MIN.FULL THREAD 45

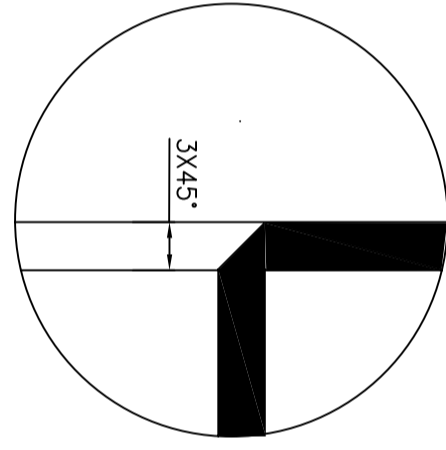
$\phi 11$, 1-HOLE, 20-DEEP ON 320 PCD
MARK OFF ON ASSEMBLY

M12-6H, 8-HOLES EQ. SPACED

M20-6H, 12-HOLES EQ. SPACED

M20-6H, 2-HOLES THRO.,
COUNTER BORE $\phi 22 \times 100$ -DEEP
(FOR STARTING SCREW)

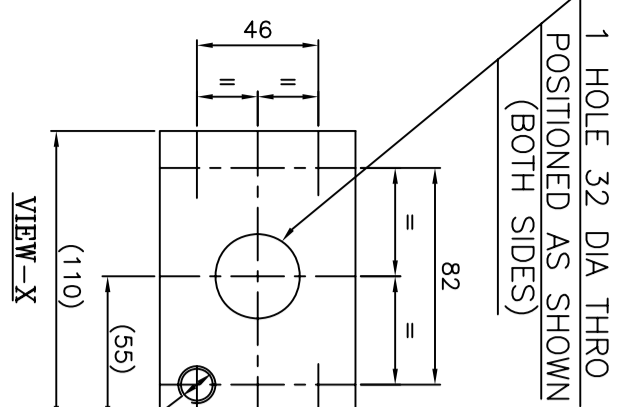
M20-6H 4 HOLES



VIEW-S
(FOR SEAL WELDING)

NOTES TO SHOP:-

1. LIQUID PENETRANT EXAMINATION TO BE DONE ON ALL ACCESSIBLE AREAS AS PER STD.NO.AA0850131, ACC.STD AA0850129, LEVEL-II.
2. CONDUCT HYDRAULIC PR. TEST ON ASSEMBLY WITH PUMP CASING AND SUCTION GUIDE WITHOUT DRUM BUSH.
3. PRE WELD MACHINING DRAWING NO. 31804414468



1 HOLE 32 DIA THRO
POSITIONED AS SHOWN
(BOTH SIDES)

M12-6H-4 HOLES PITCHED
MAX.DRILL DEPTH 24, MIN.FULL THREAD 15
AS SHOWN (BOTH SIDES)

ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT.	GROSS WT.	QUANTITY
						412.00	528.0	1

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED...			
1.	REF TO HYD30261 FOR UNSPECIFIED TOLERANCES.		
2.	CHAMFER M/CD SHARP EDGES 1.2 TO 1.0 AT 45°.		
	INTERNAL M/CD CORNER RADI 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		NAME		SIGN.		DATE	
DEPT. PUMPS ENGS	BHARAT HEAVY ELECTRICALS LTD. HYDERABAD	DRN.				18-4-96	NO. OF VAR.
SCALE		APPD.				18-4-96	VAR.
1:2		REF. TO ASSY DRG.				19-4-96	NO. OF TURNS
412.00						NA	REV.

TITLE	Drawing No.	SHEET NO.	NO. OF SHEETS
DISCHARGE COVER	CG8P0022/PRO1	01	01

