

DETAIL E

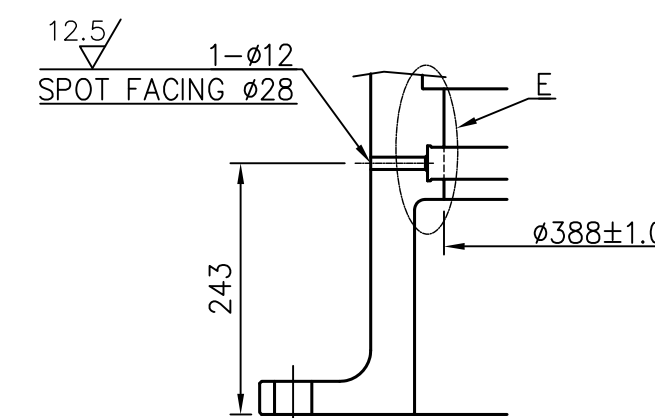
SECTION AA

NOTE TO SUPPLIER:

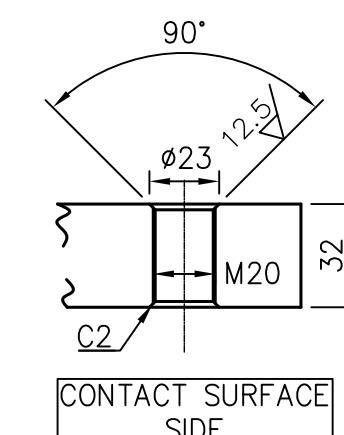
1. DIMENSIONAL CHECK ON PATTERN (SHOULD BE APPROVED BY BHEL/ BHEL TPJA PRIOR TO POURING)
2. VISUAL EXAMINATION AS PER MSS SP 55, QUANTUM OF CHECK 100%.
3. LPI TO BE DONE ON ALL MACHINED SURFACES AND WELD REPAIR AREAS AS PER AA850131, AND ACCEPTANCE AS PER AA850132 LEVEL II.
4. REPAIR WELDING PROCEDURE SHALL BE SUBMITTED IN ADVANCE. REPAIR OF LARGE DEFECT SHALL BE DONE AFTER APPROVAL FROM BHEL.
5. AFTER WELDING, ADEQUATE HEAT TREATMENT SHALL BE DONE.
6. "LARGE DEFECT" IS DEFINED THAT THICKNESS OF DEFECT IS 20% OR MORE OF TOTAL THICKNESS, OR 25MM OR MORE, OR REMOVED AREA IS 65MM OR MORE.
7. CASTING IDENTIFICATION:
  - A. BY HEAT / CAST NUMBER
  - B. MANUFACTURER'S EMBLEM, DRAWING No. AND PATTERN No. TO BE STAMPED ON CASTING
8. PAINTING PROCEDURE SHALL BE REFERRED TO FP13615.

CERTIFICATES TO BE SUBMITTED:

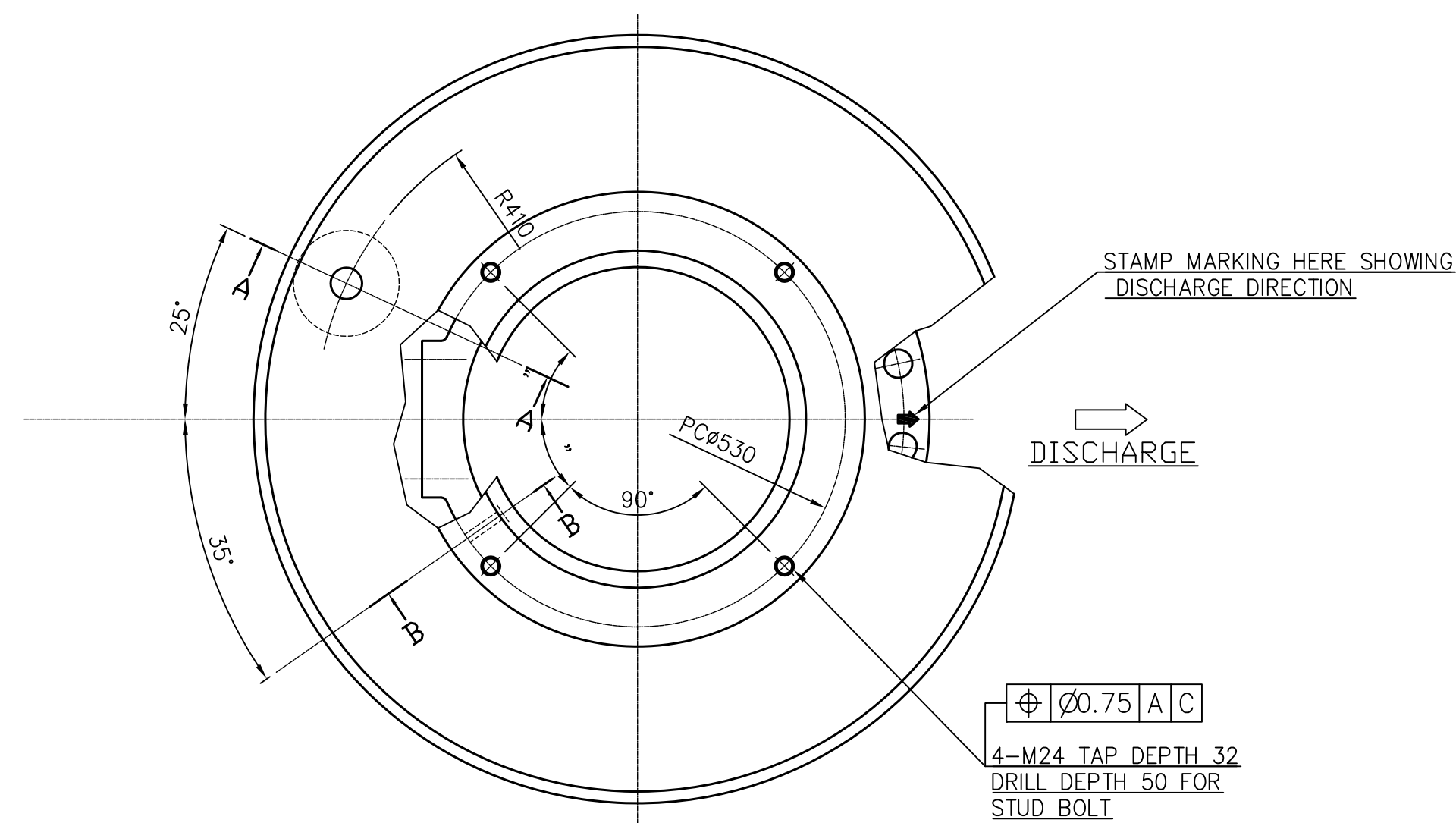
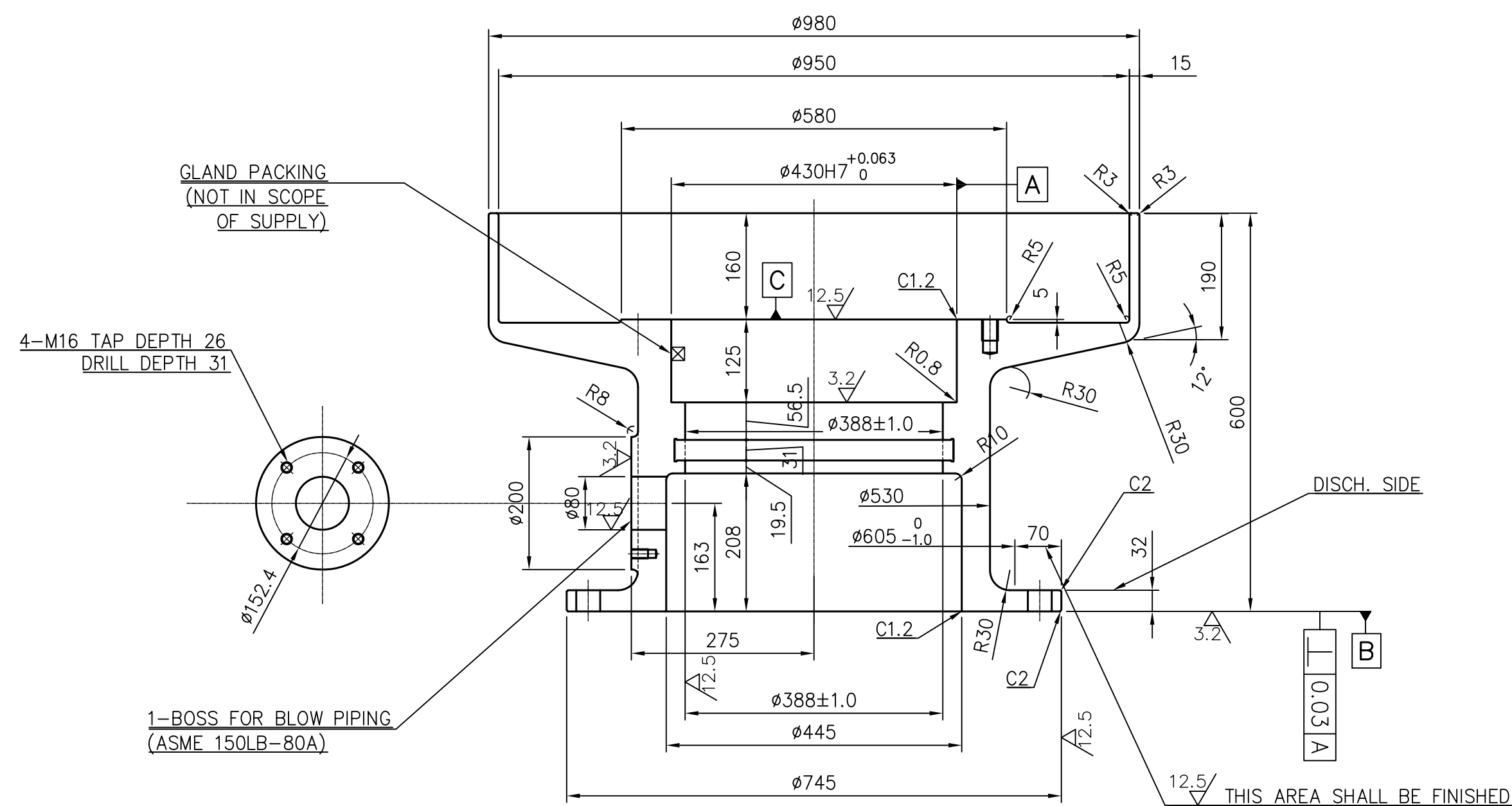
1. DIMENSIONAL CHECK ON CASTING.
2. MECHANICAL PROPERTIES.
3. CHEMICAL ANALYSIS.
4. STRESS RELIEVING.



## SECTION BB





## SECTION CC



REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED	
		CHECKED	APPD.			CHECKED	APPD.			CHECKED	APPD.			CHECKED	APPD.			CHECKED	APPD.
ZONE				ZONE				ZONE				ZONE				ZONE			

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		MKSV 210C CONCRETE VOLUTE PUMP	
1. REF. TO HY0230261 FOR U TOLERANCES.		 भारत हीवी इलेक्ट्रिकल्स लिमिटेड HYDRABAD BHARAT HEAVY ELECTRICALS LTD. HYDERABAD		NAME SIGN DATE	
2. CHAMFER M/CD SHARP ED 1.2 TO 1.0 AT 45°.				DRN. SUDHEER —sd— 30.11.19	
3. INTERNAL M/CD CORNER RADII 1 TO 0.7.				CHD. MSRAM —sd— 30.11.19	
4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE DASH SLASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.		DEPT. PUMPS	SCALE N.T.S	WEIGHT (KG) 587	REF. TO ASSY DRG. —NA—
CODE 410				ITEM NO. —NA—	NO.OF ITEMS —NA—
TITLE STUFFING BOX: CV—CWP				DRAWING NO. 1 182 65 1 0026	
				REV. 00	
				SHEET NO. 01 NO OF SHEETS 01	