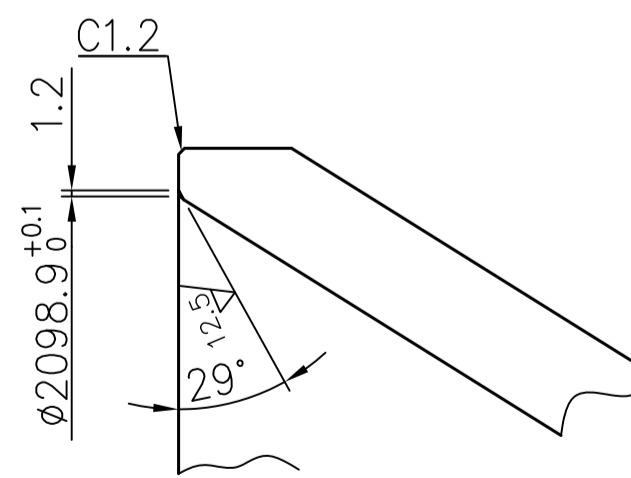



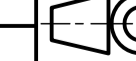
1. DIMENSIONAL CHECK ON PATTERN (SHOULD BE APPROVED BY BHEL/ BHEL TPIA PRIOR TO POURING)
2. VISUAL EXAMINATION AS PER MSS SP 55, QUANTUM OF CHECK 100%.
3. LPI TO BE DONE ON ALL MACHINED SURFACES AND WELD REPAIR AREAS AS PER ASTM E165, AND ACCEPTANCE AS PER ASME SEC.VIII DIV.1 APPENDIX 8.
4. REPAIR WELDING 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.



DETAIL-C

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 1. REF. TO HYDRO230261 FOR UN TOLERANCES. 2. CHAMFER M/CD SHARP ED 1.2 TO 1.0 AT 45°. 3. INTERNAL M/CD CORNER RADI 1 TO 0.7. 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.				TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT  भारत हवी इलेक्ट्रिकल्स लिमिटेड HYDERABAD				MKSV-210C CONCRETE VOLUTE PUMP			
DEPT. PUMPS CODE 410		 SCALE N.T.S		WEIGHT (KG) 765		REF. TO ASSY DRG. -NA-		ITEM NO. -NA-		NO. OF ITEMS -NA-	
TITLE SUCTION LINER: CV-CWP						DRAWING NO. 1 182 65 1 0025			REV. 00		
						SHEET NO. 01		NO OF SHEETS 01			