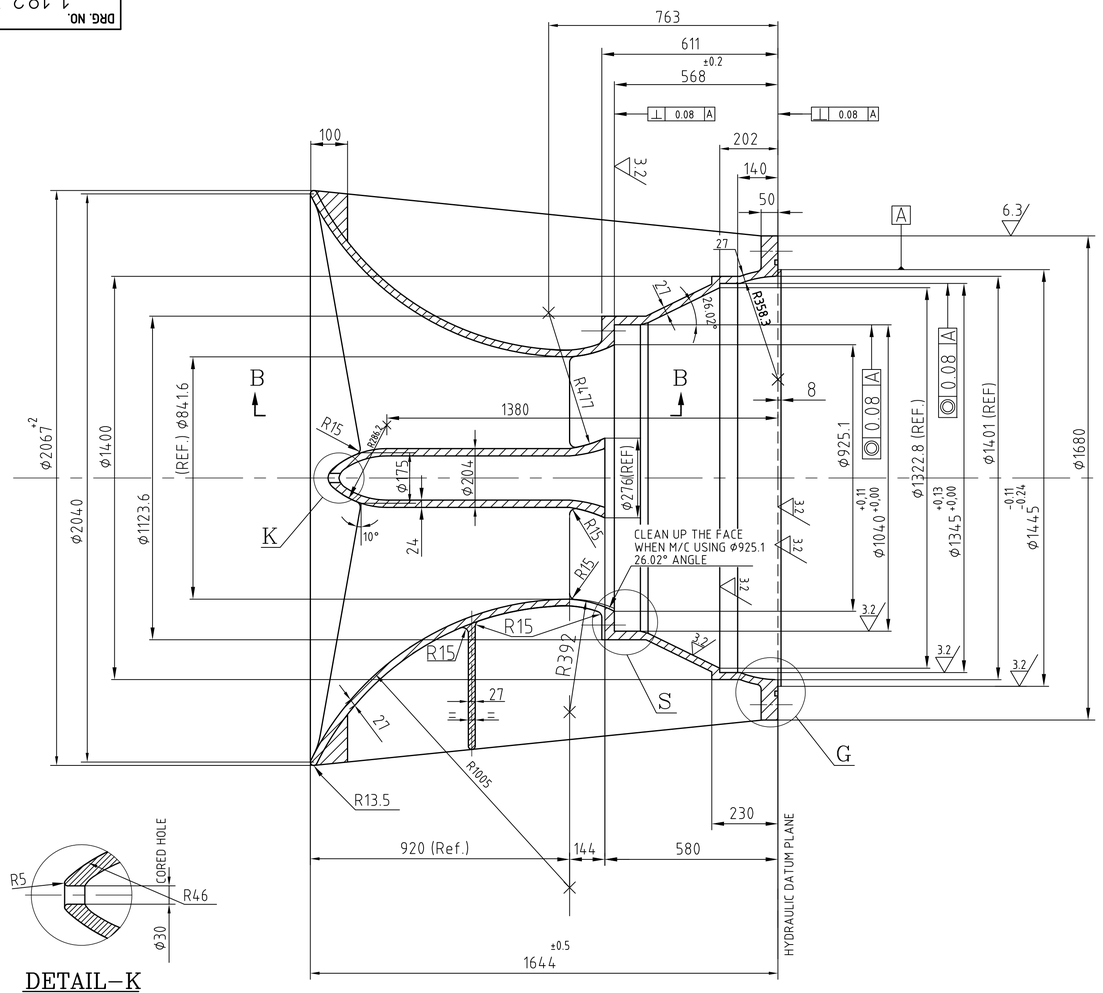
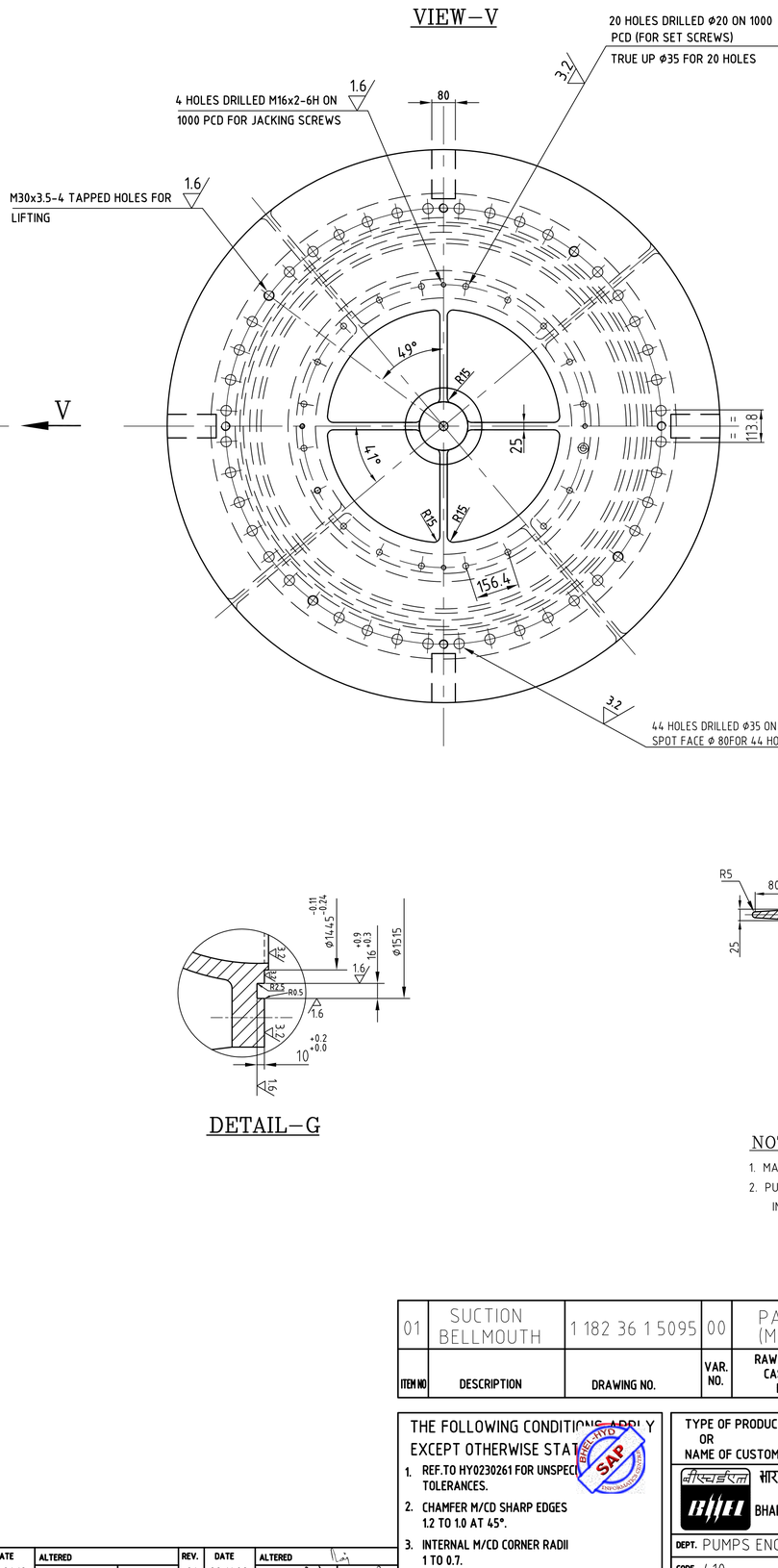
FIRST ANGLE PROJECTION

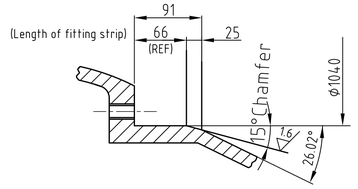
(ALL DIMENSIONS ARE IN mm)

DRG. NO. 1 182 36 1 5095



DETAIL–K





DETAIL–S

DETAIL–G

SECTION B–B

PATTERN NO. M-55-0016

NOTE TO SUPPLIER :

01. MATERIAL SPECIFICATION:- CAST IRON AA19703 +2% Ni
CHEMICAL COMPOSITION:- S = 0.1% (MAX), P = 0.2% (MAX)
MECHANICAL PROPERTIES:- TENSILE STRENGTH - 260 N/Sq.mm (Min)
BRINELL HARDNESS - 180 TO 230 HB

02. TESTS TO BE CARRIED OUT & CERTIFICATES TO BE SUBMITTED TO BHEL

01. DIMENSIONAL CHECK ON PATTERN (SHOULD BE APPROVED BY BHEL PRIOR TO CASTING)
02. VISUAL EXAMINATION AS PER MSS SP 55. 100% CHECKING TO BE DONE.
03. MECHANICAL PROPERTY TEST CERTIFICATES FOR EACH HEAT BATCH TO BE FURNISHED.
04. CHEMICAL PROPERTY CERTIFICATE FOR EACH MELT TO BE FURNISHED.
05. CASTING TO BE STRESS RELIEVED.
06. DIMENSIONAL CHECK ON CASTING.
07. DYE PENETRANT EXAMINATION ON 100% MACHINED AREA AS PER AA0850131 AND ACCEPTANCE NORM AS PER AA0850132 LEVEL III.
08. MATERIAL TESTS (CHEMICAL & MECHANICAL), VISUAL EXAMINATION, PRESSURE TESTING, DIMENSIONAL CHECK ON CASTING AND DPT SHALL BE WITNESSED.

03. IDENTIFICATION

01. CASTING SHALL BE IDENTIFIED BY HEAT/CAST No.
02. MANUFACTURER'S EMBLEM, DRAWING NUMBER & PATTERN NUMBER TO BE STAMPED ON CASTING.

04. PAINTING: (TO BE DONE AS PER PROCESS STD NO : AA0674111)

01. ALL MACHINED SURFACES SHALL BE COATED WITH SUITABLE RUST PREVENTIVE COAT AS PER CATEGORY "B" OF HY049563
02. ALL SURFACES SHALL BE PAINTED WITH 2 COATS (EACH 30 MICRON THICK) OF CHEMICAL RESISTANT EPOXIDE PRIMING PAINT AS PER AA 56105.
03. FINISH PAINTING SHALL BE DONE ON ALL SURFACES WITH 2 COATS (EACH 30 MICRON THICK) OF HIGH BUILD BLACK COAL TAR EPOXIDE PAINT AS PER AA56135

05. TOLERANCES ON DIMENSIONS (NOT TOLERANCED IN THE DRAWING)

01. AS CAST DIMENSIONS AS PER AA0230402 CLASS 3 & MACHINED DIMENSIONS AS PER AA0230208 MEDIUM CLASS CASTING SHALL NOT HAVE ANY SHARP CORNERS.

NOTE :

1. CASTING TO BE STRESS RELIEVED BEFORE FINAL MACHINING
2. WELD REPAIRING OF CASTINGS IS NOT PERMITTED.
3. ALL SHARP CORNERS TO BE REMOVED FROM CASTING.

06. PACKING AND DESPATCHING :

TO BE PROPERLY PACKED AND DESPATCHED SUCH THAT NO DAMAGE IS CAUSED DURING HANDLING AND TRANSIT.

NOTE :–

1. MATCH THE COMPONENT WITH ITS MATING COMPONENTS.
2. PUNCH MATCH MARKS AND PUMP SL. NO. ON Φ1680 PERIPHERY. INSCRIBE THE MARKING SWITHIN A RECTANGLE BY BOLD PAINT LINES.

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	
01	SUCTION BELLMOUTH	1 182 36 1 5095	00	PATTERN (M-55-0016)	FP9110304665	2100.0	
					AA19703+2%NI	01	

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED

1. REF.TO HY0230261 FOR UNSPECIFIED TOLERANCES.
2. CHAMFER M/CD SHARP EDGES 1.2 TO 1.0 AT 45°.
3. INTERNAL M/CD CORNER RADII 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: CW 1Q B8 GOA S.F.=1.06 / DVC MEJIA UNIT-4, 1x210 MW

भारत हेवी इलेक्ट्रिकल्स लिमिटेड हैदराबाद
BHARAT HEAVY ELECTRICALS LTD. HYDERABAD

	NAME	SIGN.	DATE
DRN.	P.R.CHARY		24-07-2002
CHD.	S.SAHU		24-07-2002
APPD.	B.RAJKUMAR		24-07-2002

NO.OF VAR. NA

DEPT.	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO.OF ITEMS
PUMPS ENGG	NTS	2100.0	NA	NA	NA

CODE 410

TITLE: SUCTION BELLMOUTH

DRAWING NO. 1 182 36 1 5095 REV. 02

SHEET NO. 01 NO OF SHEETS 01

REV.	DATE	ALTERED	CHECKED	APPD.	ZONE
02	03.01.18	DRAWING GENERALLY REVISED			
01	22.11.02	INTERNAL RIBS ARE MODIFIED. DETAIL-V REVISED. DCA NO. FP1373 DTD ON 22.11.02			

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COMPUTER FILE NAME: FP118236150 95-01

REF. DRG. NO.

SIGN. AND DATE

INVENTORY NO 1-182-5095

Jan Wed 3 14:27 2018

This Drawing is printed from Engineering Digital Archival System (EDAS). Therefore signatures are not essentially required.