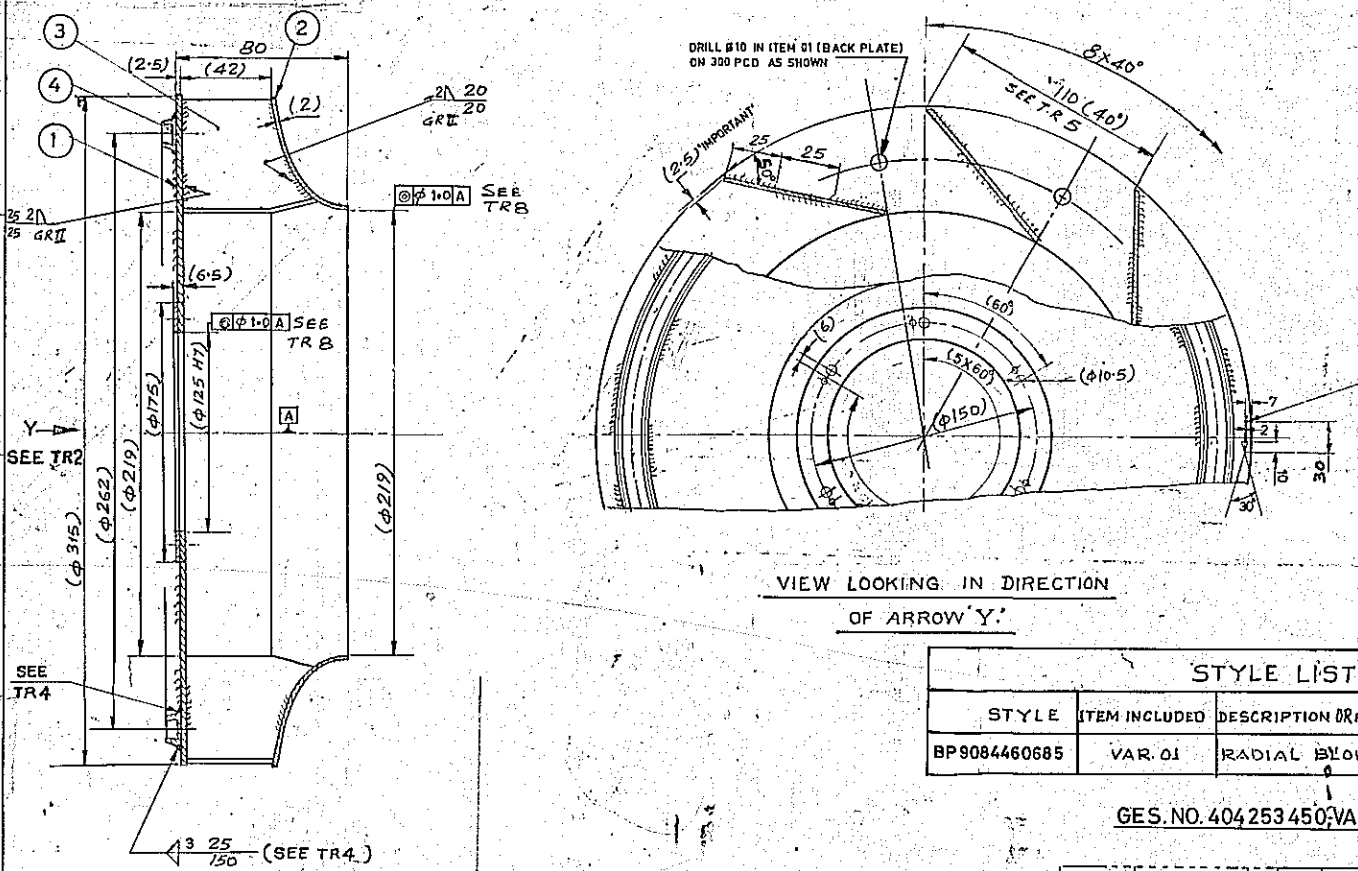


DRG NO 24023240023



GAUGE LIST				
LIMIT	NOM SIZE	SYM	NO	ITEM TYPE

TOOL LIST		
IT. NO	TOOL	DESCRIPTIONS
	1509352	SETTING BLOCK

STYLE LIST			
STYLE	ITEM INCLUDED	DESCRIPTION OR REMARKS	RECORDED SIG. DATE
BP9084460685	VAR. 01	RADIAL BLOWER	<i>Radhyuma</i>

T.R. CONTINUED:-
 B BACK PLATE & DISC TO BE WELDED SUCH THAT DISPLACEMENT OF ANY TWO DIAMETRICALLY OPPOSITE POINTS (ONE ON Φ125 WITH RESPECT TO ANOTHER ON Φ219) DOES NOT EXCEED 1.0 mm FROM NOMINAL OF 172 mm.

D.O. NOTE:-
 n6 = 5300 R.P.M.
 n5 = 6900 R.P.M.
 J = 0.05 kg m²
 9. ALL WELDS TO BE SOUND AND CONTINUOUS WITHOUT ANY UNDER CUTS. CROSS WELDING TO BE DONE AT BLADE ENDS WHERE POSSIBLE TO PREVENT UNDER CUT/BURNOUT.

GES. NO. 404253450, VAR. 01.

TECHNICAL REQUIREMENTS :-

- 1 ALL ITEMS TO BE PICKLED TO PROC. SPEC. 8604 BEFORE WELDING
- 2 DIRECTION OF ROTATION: CLOCKWISE LOOKING AT BALANCING RING, ITEM 4, (i.e. LOOKING IN THE DIRECTION OF ARROW Y) FBM TO INDICATE DOR? BY WELD DEPOSITED ARROWS AS SHOWN, ON BOTH OUTER SIDES OF BLOWER.
- 3 ALL WELDS TO BE TO CORP. STD. AA 062-21-01 GRADE II.
- 4 SPACE WELDS ON I/D OF BALANCING RING TO BE BETWEEN SPACE WELDS ON O/D. BLADES TO BE SPACE WELDED AS SHOWN.
- 5 CHORD LENGTH MEASURED ON Φ315
- 6 COMPLETE BLOWER TO BE PAINTED BY FBM WITH PRIMER TO AA 56110. SURFACE AREA TO BE COVERED 130 SQ. METERS (PER COAT)
- 7 BLOWER TO BE FINALLY PAINTED BY IMM WITH AA 56131. WELD DEPOSITED ARROWS TO BE PAINTED WITH WHITE PAINT TO AA 56127.
 B SEE R.H. SIDE OF DRG.

VAR. 01	REMARKS	ITEM NO.	DESCRIPTION	STD.	DRAWING NO.	MATL. CODE	MATL. SPECN.	UNIT WT KG	QTY.	ZONE
01		04	BLANCING RING 243x281	AM 54018	07	BP9084321693		0.49		
09		03	BLOWER BLADE	44023242011	01			0.051		
01		02	BLOWER DISC	34023242011	01	BP9084321669		0.81		
01		01	BLOWER BACK PLATE	24023240029	01			1.66		

ADDITIONAL INFORMATION
 ASOBBA 411-11
 STATUS OF DRAWING

TYPE OF PRODUCT 1LA7-56 2P
 OR
 NAME OF CUSTOMER/PROJECT Φ315x42/Φ125

DISTRIBUTION OF PRINTS
 AME - 1 TEX - 1
 IMM - 3 FBM - 4

BHARAT HEAVY ELECTRICALS LIMITED
 BHOPAL

DEPT. AME
 CODE 40A

SCALE N.T.S.

WEIGHT (KG) 3.4

REF. TO ASSY. DRG. 34023240035

TITLE RADIAL BLOWER UNIDIRECTIONAL, CLOCK WISE

DRAWING NO. 24023240023

SHEET NO. 1 NO. OF SHEETS 1

INVENTORY NO. 7-504572

SIGN. & DATE

REF. DRG. NO.

REV	DATE	ALTD. (SPV)	CHKD.	REV	DATE	ALTD. (SPV)	CHKD.
05	09.10.99	CKD.		02	31.3	CKD.	
03	6-9-87		<i>Radhyuma</i>	01	13.12.84	CHECKED	
04	12/3/87	CHECKED					

IF-B WITH DIMM 2.5, IMPORTANT ADDED FROM TR. 4 BY FBM DELETED INT. B. 8 AND 7, AA 56110 AND AA 56131 WAS PS. 56110 AND PS. 56131 RESPECTIVELY. T.R. 9. CHANGED. ST. NOS. CHANGED IN 12 DIGITS.

STYLE NO. ADDED 111

TOOL NO. ADDED 40A

REF. AME/602-5172 DT. 13.9.86.

BLADE ANGLE 50° WAS 40° (F-6)

T.R. 3 MODIFIED.