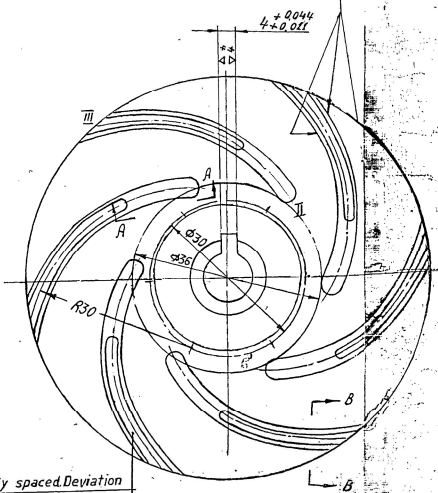
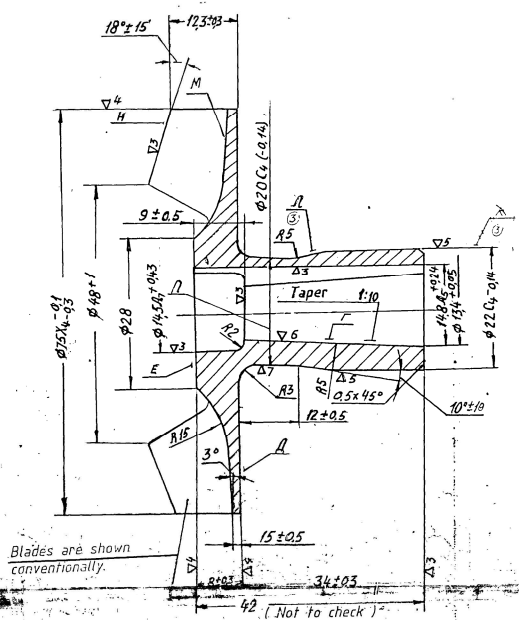
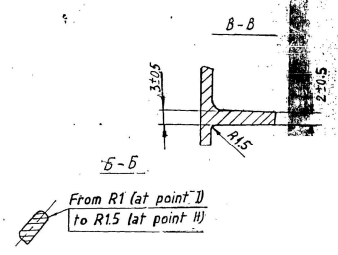
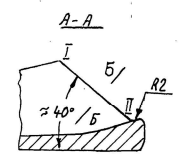
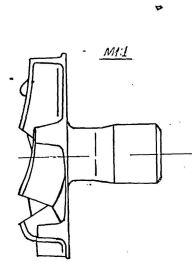


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Dressing of an even surfaces is allowed.



1. Permissible deviations for rough dimensions are as per class II, GOST 2009-55.
2. Casting should be cleaned from sand, metal penetration and sand fusion and other casting laminations. Surfaces of blades and surface M should be smooth. Accept as per standard.
3. Cavities of 15 pieces for a part & non-grouped and not more than 3 pieces for a surface to a depth upto 1mm and of area for each cavity equal to 3mm² may be on surfaces to be machined and not to be machined. Cavities, coinciding on opposite surfaces on surfaces ϕ 20 and on edges of blades are not allowed. Porosity of hub above 0,3mm is not allowed.
4. Blades may be made so that thickness with $2\pm 0,5$ and $3\pm 0,5$ at point II are gradually increased upto $3\pm 0,5$ mm and $4\pm 0,5$ mm at point III.
5. Following is allowed with respect to surface Γ .
 - a) runout of ϕ 20 should not exceed 0,05mm.
 - b) runout of surfaces Δ , E, H, ϕ 22 and ϕ 75 should not exceed 0,15mm.
6. Location of key way slot with respect to blades is arbitrary.
7. Displacement of key way slot with respect to axis of surface Γ should not exceed 0,15mm.
8. Burns and sharp edges are not allowed. Dress burrs on blades. Sharp edges, should not be rounded-off.
9. Alternate material is BP 05U5, C5, BP03U7C5 H1 GOST 613-79, 6PA10X3MЦ2 GOST 493-79 brass NK60-3/1 GOST 17711-72.
10. Do not mark.
11. Make chamfer $1 \times 45^\circ$ on blades at mating angle 18° and ϕ 75.
12. Coating of dimension Π chrome plated, hard 21 micron thickness is allowed upto 42 micron and presence of chrome on external surfaces are allowed.



01007-10	Q	DS CAT NO. ADDED & NOMENCLATURE WAS 'IMPELLER'
02-11-05	02	02-11-05
ISSUE	ISSUE	AMENDMENTS

APPROVED	M. VASU	USED ON - 54-83-78cb-A
CHECKED	DISKINAR	DS CAT NO. 54 83 005-1A
CONTROLLERATE OF INSPECTION (ICVI)	IMPELLER PUMP CENTRIFUGAL	151 of 164
	IMPELLER	WEIGHT SCALE 0,14 2,1
	SHT SHTS	
	GOST 493-79	151 of 310
	BP A9 X 3A	