

122-12-979

B-B

5B₇(-0.03)R₂₀ ✓(✓)

2±15'

2+0.25
14 п.поперечн
φ R0.25 ±0.05
①

⑤*

1/0.15 A

1/0.2 A

1/0.3 A

58°30'±15'

φ50 B₇(-0.02)

φ47.5(-0.02)

φ28 B₇(-0.02)

A

R₂₀φ14 A₄(-0.02)φ62 A₄(-0.02)φ3.1 A₄(-0.02)φ172 C₄(-0.02)

90°±1°

4±0.25

φ35

B

B

1/0.2 A

4 B₇(-0.02)

B-B

90°±1°

3±0.25

для всех
поперечн

③*

2+0.25
14 п.поперечн
φ R0.25 ±0.05
①

②*

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

675-71-271

IMPELLER HUB

AMr6 Gost 4784-74

WEIGHT

SCALE

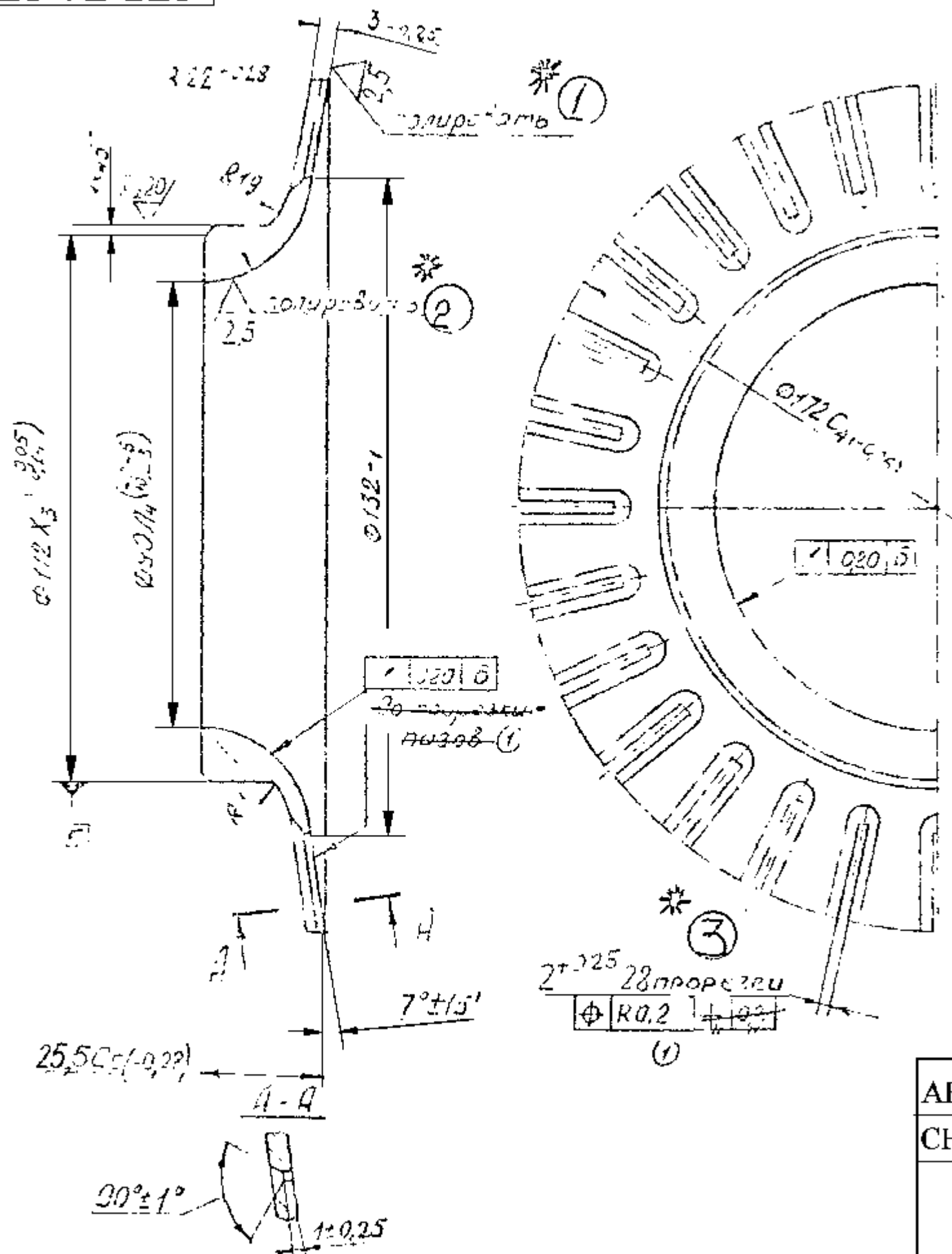
0.55

1:1

SHT

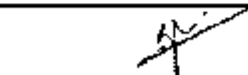
SHTS

- *① fourteen slots
 *② fourteen slots
 *③ For all slots
 *④ Check runout before grooves are cut.
 *⑤ Polish



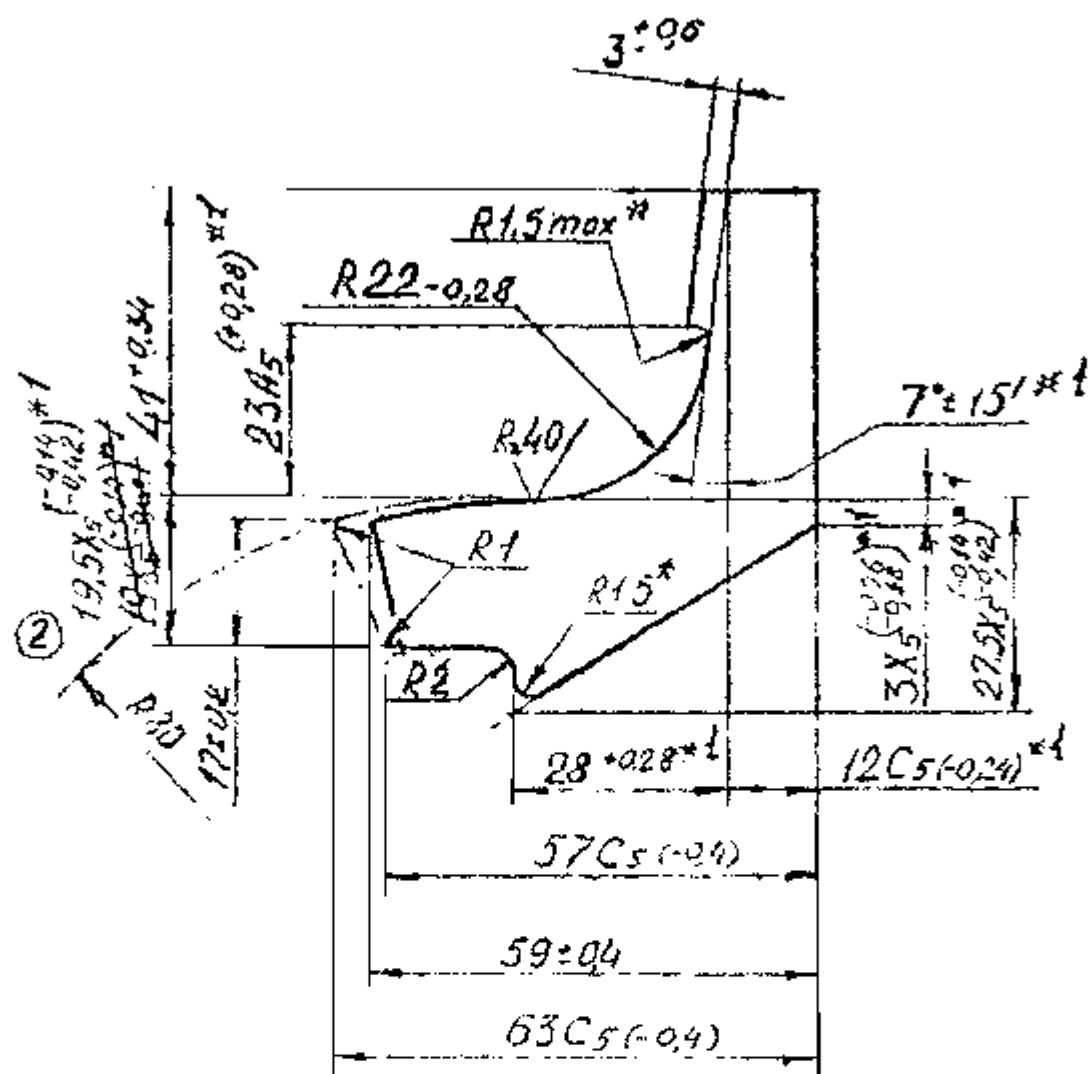
TECHNICAL CONDITIONS

- *~~(1)~~ Polish
- *~~(2)~~ Polish
- ~~4~~(3) Twenty eight slots
- *~~(4)~~ Check runout before grooves are cut.

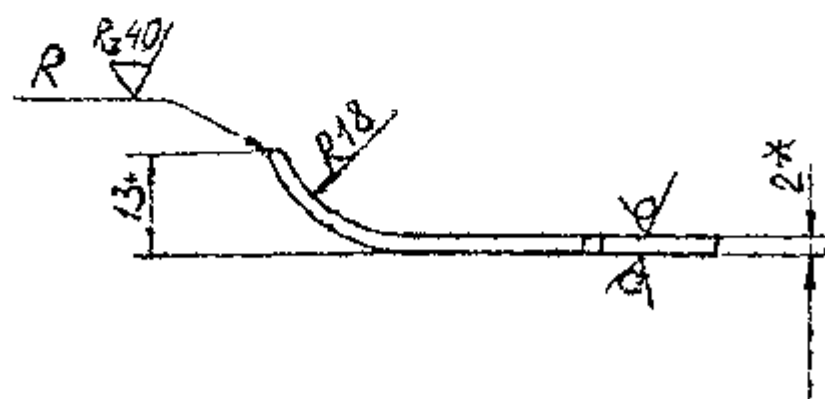
APPROVED		675-71-272		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		DISK		
			WEIGHT	SCALE
			0.28	1:1
		SHT 1	SHTS 1	
		AM+6 Gost 4784-74		

675-71-273

✓ (v,)



1. Unspecified limit deviations of sizes - ± 0.5 mm.
2. ^ESizes are given for reference.
3. ^{nl}Ensure sizes by means of tools.
4. Substitute for material - sheet AMr5M-2,0 ГОСТ 21631-76.



APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

675-71-273

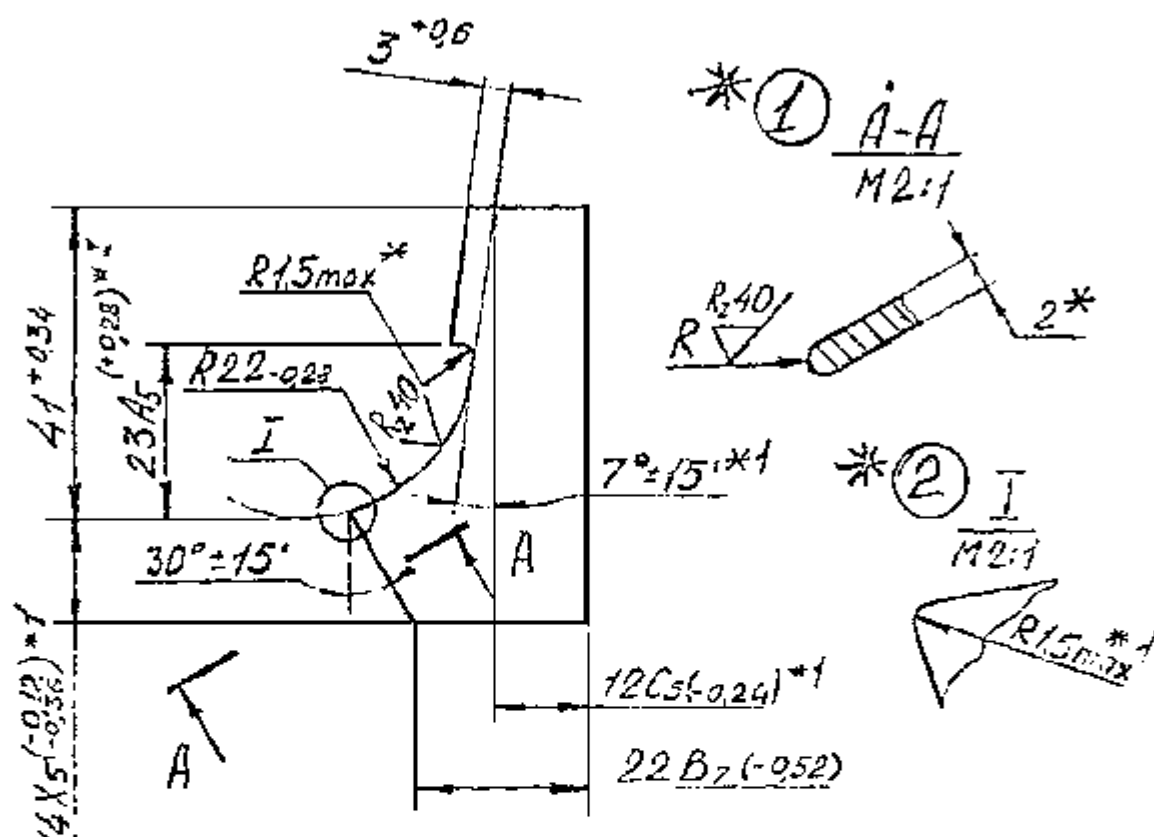
VANE

Sheet AMr65M-2
Gost 21631-76

WEIGHT SCALE

0.01 1:1

SHT 1 SHTS 1



* (1) A - A
Scale 2:1

* (2) I
Scale 2:1

- (3) 1. Unspecified limit deviations of sizes - ± 0.5 mm.
 2. ¹²Size is given for reference.
 3. ¹²Ensure sizes by means of tools.
 4. Substitute for material - sheet AMr5M-2,0 ГОСТ 21631-76

(2)

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

675-71-274

VANE

Sheet AMr65M-2
Gost 21631-76

WEIGHT SCALE

0.0065 1:1

SHT SHTS

Ref. No.	Designation	Description	Qty	Remarks
	675-71-c6218CB	<u>Documents</u> Assembly drawing		
		<u>Parts</u>		
1	675-71-271	Impeller hub	1	
2	675-71-272	Disk	1	
3	675-71-273	Vane	14	
4	675-71-274	Vane	14	

APPROVED
CHECKED



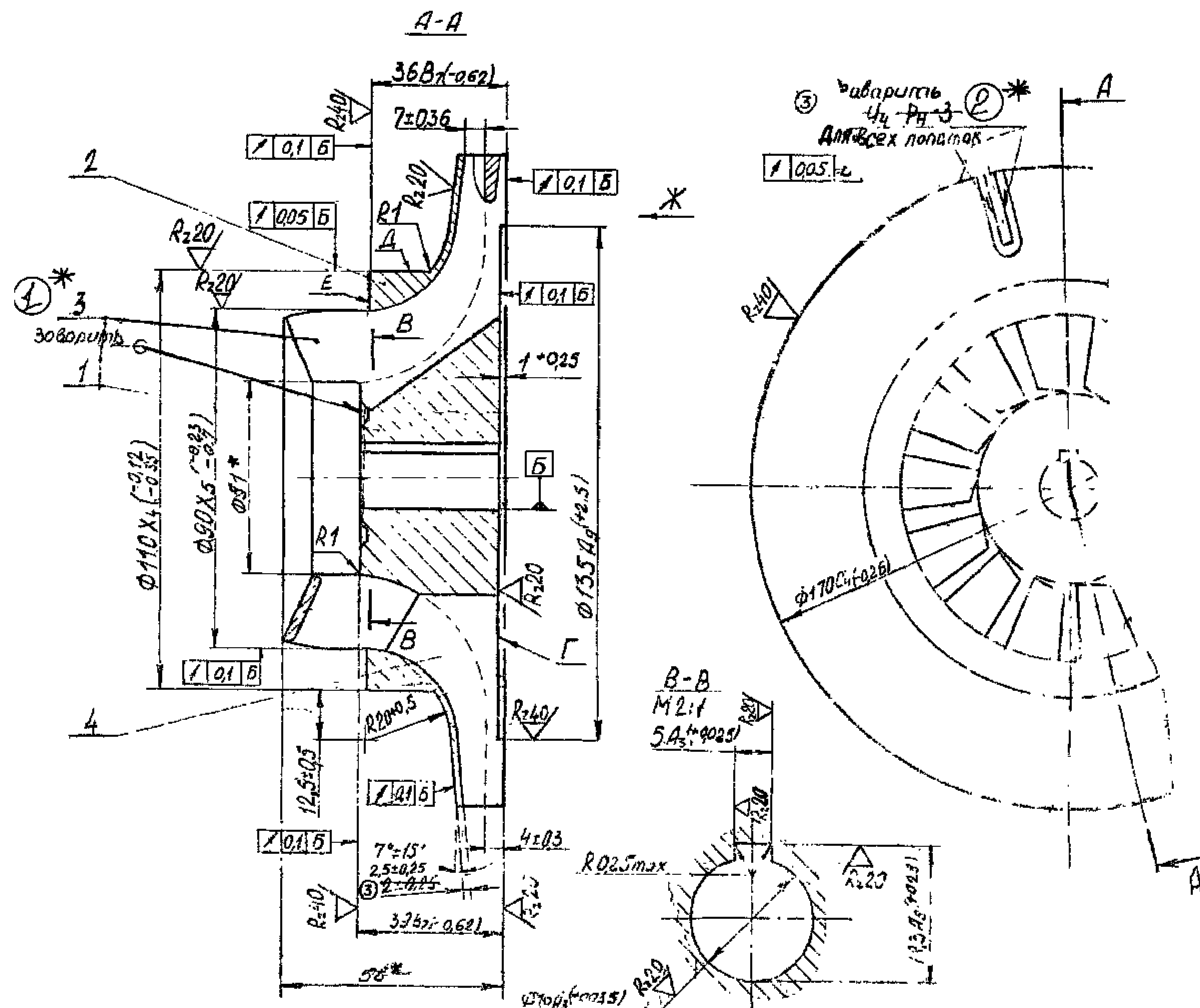
675-71-Sb218

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

IMPELLER

WEIGHT SCALE

SHT SITTS



5

TECHNICAL CONDITIONS

- *(1) Weld
 *(2) Weld for all vanes
 *(3) View E
 *(4) Weld for all vanes
 *(5) 1. Welds - according GOST 14806-69.
 2. After welding remove internal stress by thermal treatment.
 3. Coating: anodic oxidation hard 20 to 30 μ . Absence of coating on surface E is tolerable.
 4. Weld rolls on inner profile surfaces of parts Ref. Nos 1 and 2 and on surfaces of parts Ref. Nos 3 and 4 are not tolerable. Dressing flush with above-mentioned surfaces is tolerable.
 5. μ Size is given for reference.
 6. During dynamic test, perform balancing:
 (a) drill holes ϕ 12 mm, maximum, on circular section of surface I from ϕ 60 to ϕ 30 mm to depth of 15 mm, maximum;
 (b) chamfer 6x45°, maximum, on surface II;
 (c) it is allowed to drill holes on end face E of ϕ 4 to ϕ 102 mm to depth of 8 mm, maximum.
 7. Balance with semi-circular key 5x7.5 GOST 24071-80. Install key at 5 to 7 mm from end face I. Permissible unbalance - 0.3 gcm.
 8. Visually check quality of welds. Surface pores up to 1 mm and up to 6 pcs are tolerable.
 9. Other requirements for quality of welds - according to GOST 3-4001-77 for off-design welded joints.

APPROVED		675-71-Sb218Sb				
CHECKED		IMPELLER ASSY DRG.			WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)					1.0	1:1
				SHT SHTS		