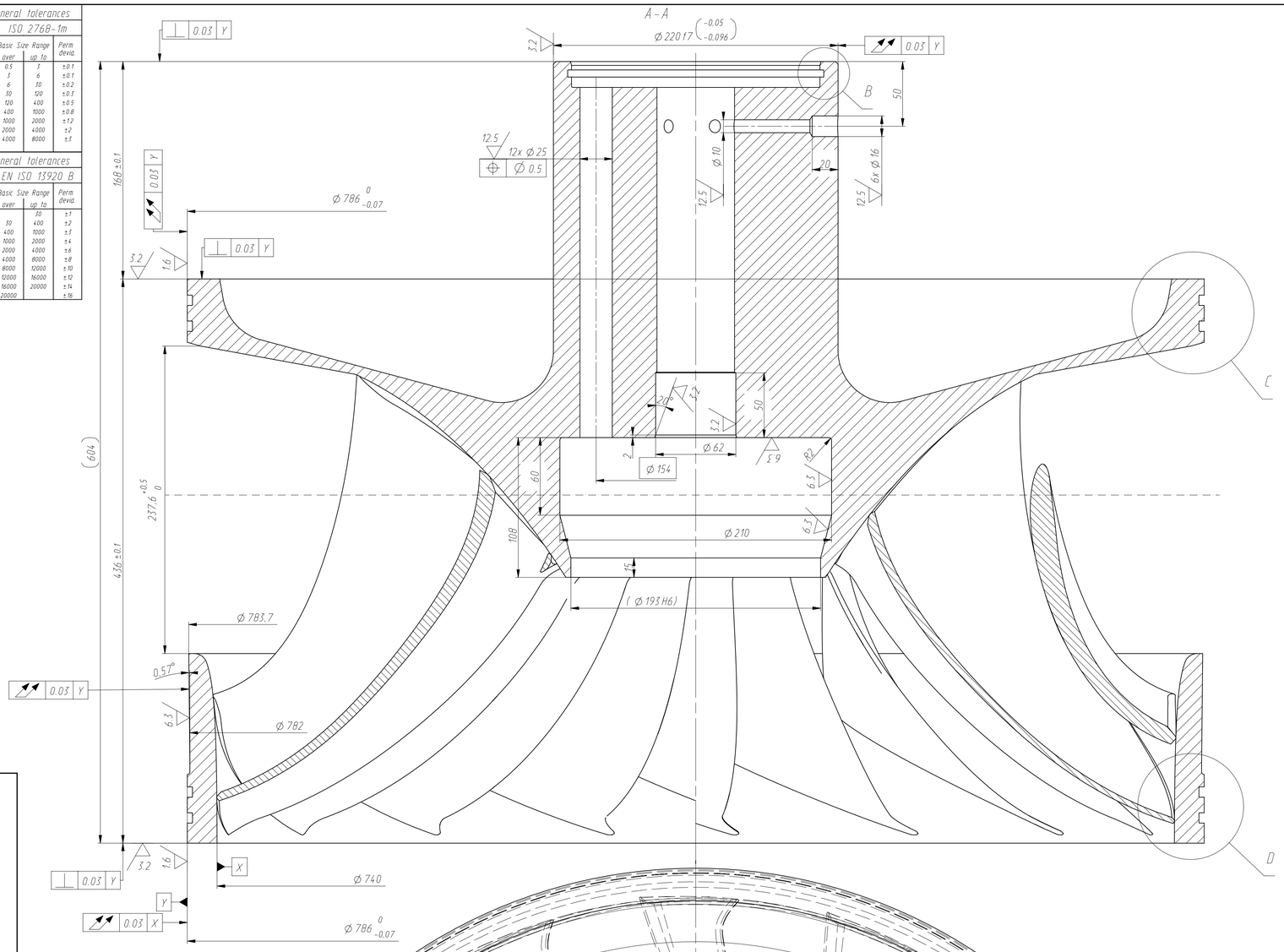
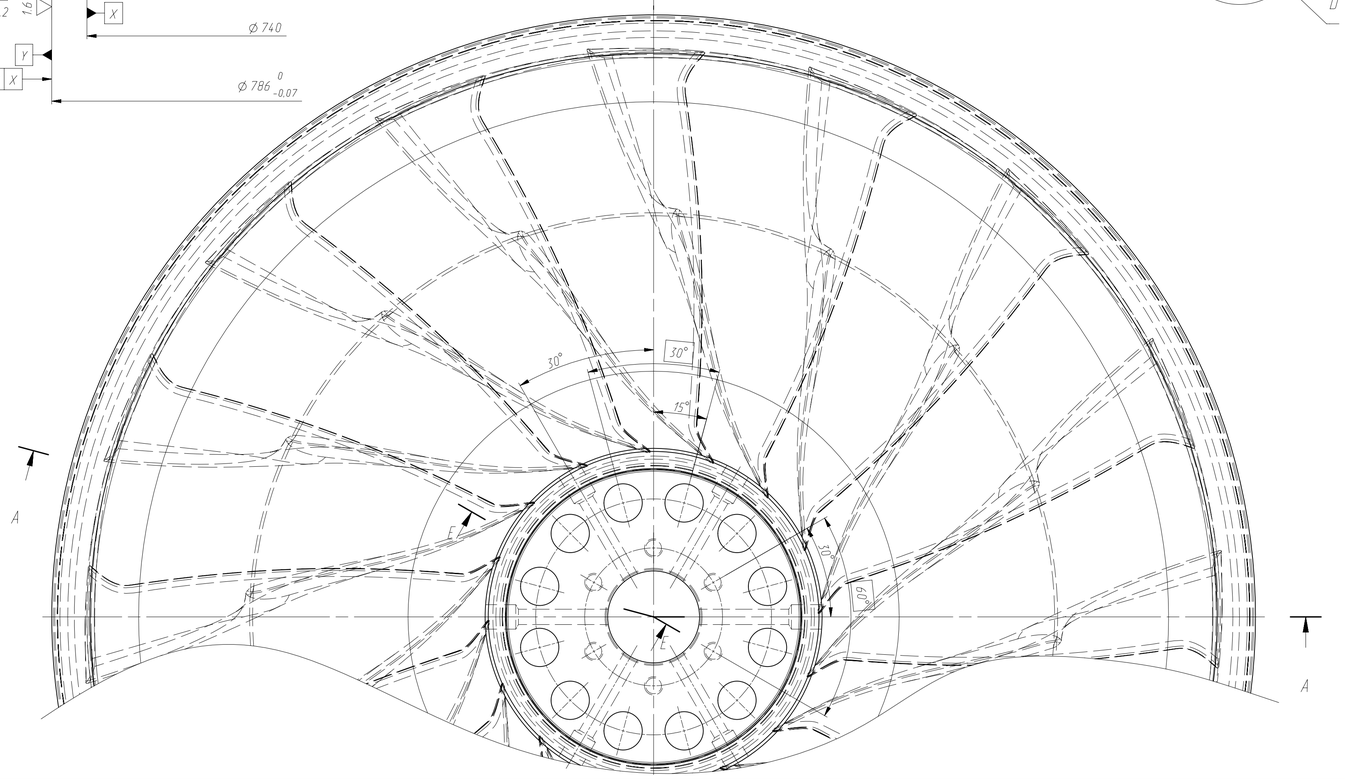
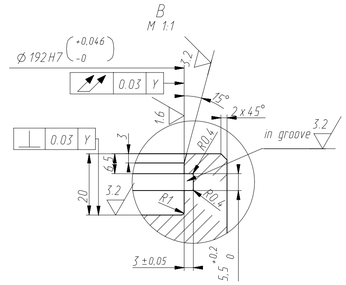
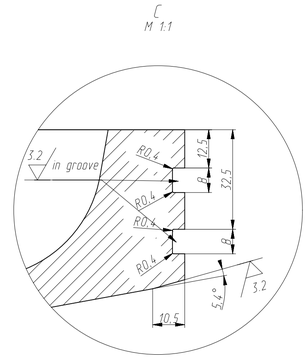
General tolerances			
	ISO 2768-1m		
	Basic Size Range over	up to	Perm devia.
Machining	0.5	3	±0.1
	3	6	±0.1
	6	30	±0.2
	30	120	±0.3
	120	400	±0.5
	400	1000	±0.8
	1000	2000	±1.2
	2000	4000	±2
	4000	8000	±3

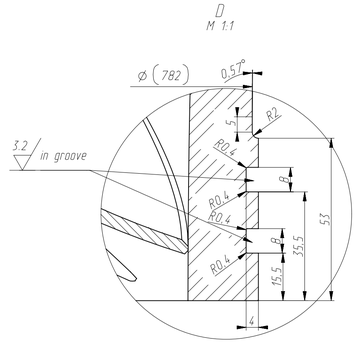
General tolerances			
	EN ISO 13920 B		
	Basic Size Range over	up to	Perm devia.
Welding		30	±1
	30	400	±2
	400	1000	±3
	1000	2000	±4
	2000	4000	±6
	4000	8000	±8
	8000	12000	±10
	12000	16000	±12
	16000	20000	±14
	20000		±16

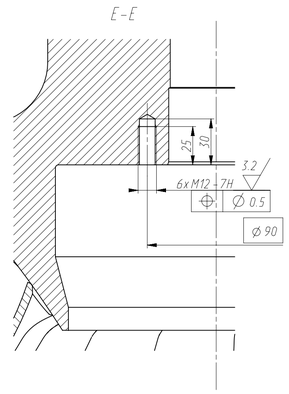












	Surface requirements Изисквания към повърхнините	PT
Crown Главина	Ra 3.2 □m	CCH 70-3 Klass III
Band Пръстен	Ra 3.2 □m	CCH 70-3 Klass III
Blades Лопатка	Ra 3.2 □m To be fine ground on inlet and outlet to Ra 1.6 □m входящия и изходящия ръб полирани до	CCH 70-3 Klass III

Технически изисквания

1. Да се извърши динамично балансиране на Колело работно след предварителна и след окончателна мех. обработка съгласно ISO 1940/1 клас G 2.5; допустим дебаланс при n=1843min⁻¹
2. Отнемането/прибавянето на тежест за баланс, да се извърши след указание на инженер от КО.

Pos. Поз.	Drawing No. Означение	Name Наименование	Qty. Кол.	Kg/each Маса	Material Материал	Ref. Заб.
1	1996400	Runner pre machined Колело работно, предварителна обработка	1	380	-	

1995100 — Runner Group Assembly

Turbine 'Francis'

T496

Correct.	Qty	Document No	Sign	Date
Drawn		Arabadzhiev		2015.02
Checked		Arabadzhiev		
T.Control				
Approved				

Proj. method

Drawing No: 1996300

Revision: 0

Turbine 'Francis'
Runner
Колело работно

Mass	Scale
295	1:2

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VAPHYDRO BY VAPTSIA

Size A1