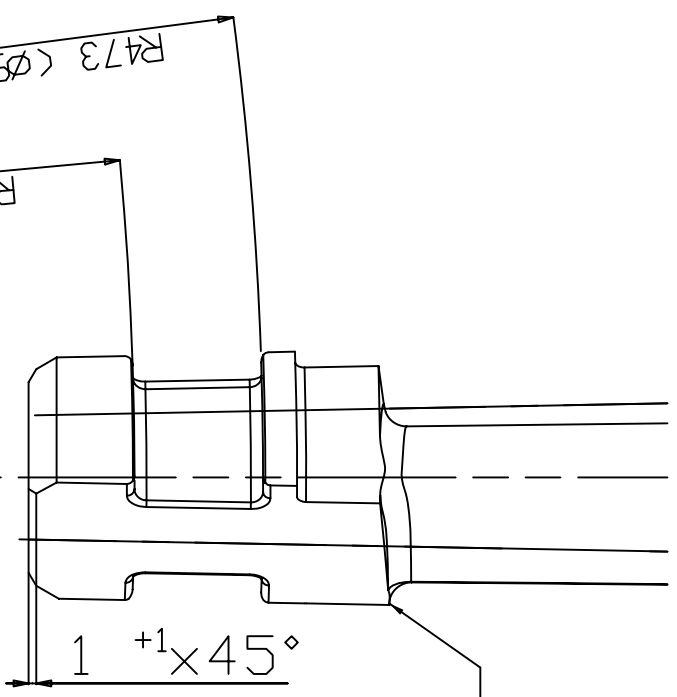
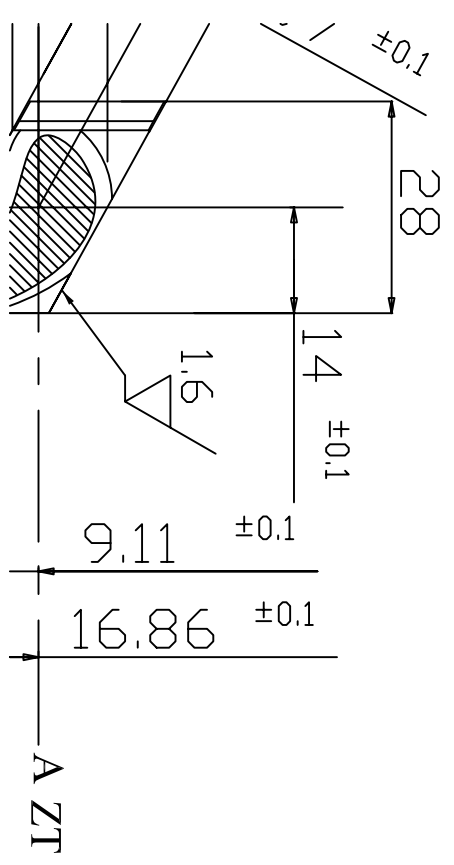


\* DIMENSION REFERRED TO

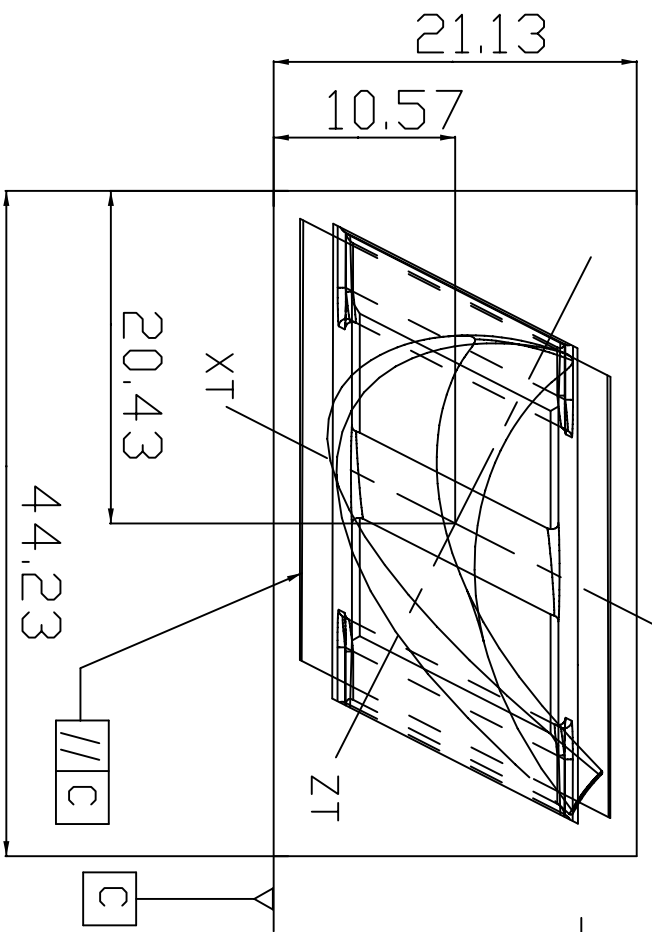
R3 ALL AROUND



XT  
U



EXECUTION : 00 "L"



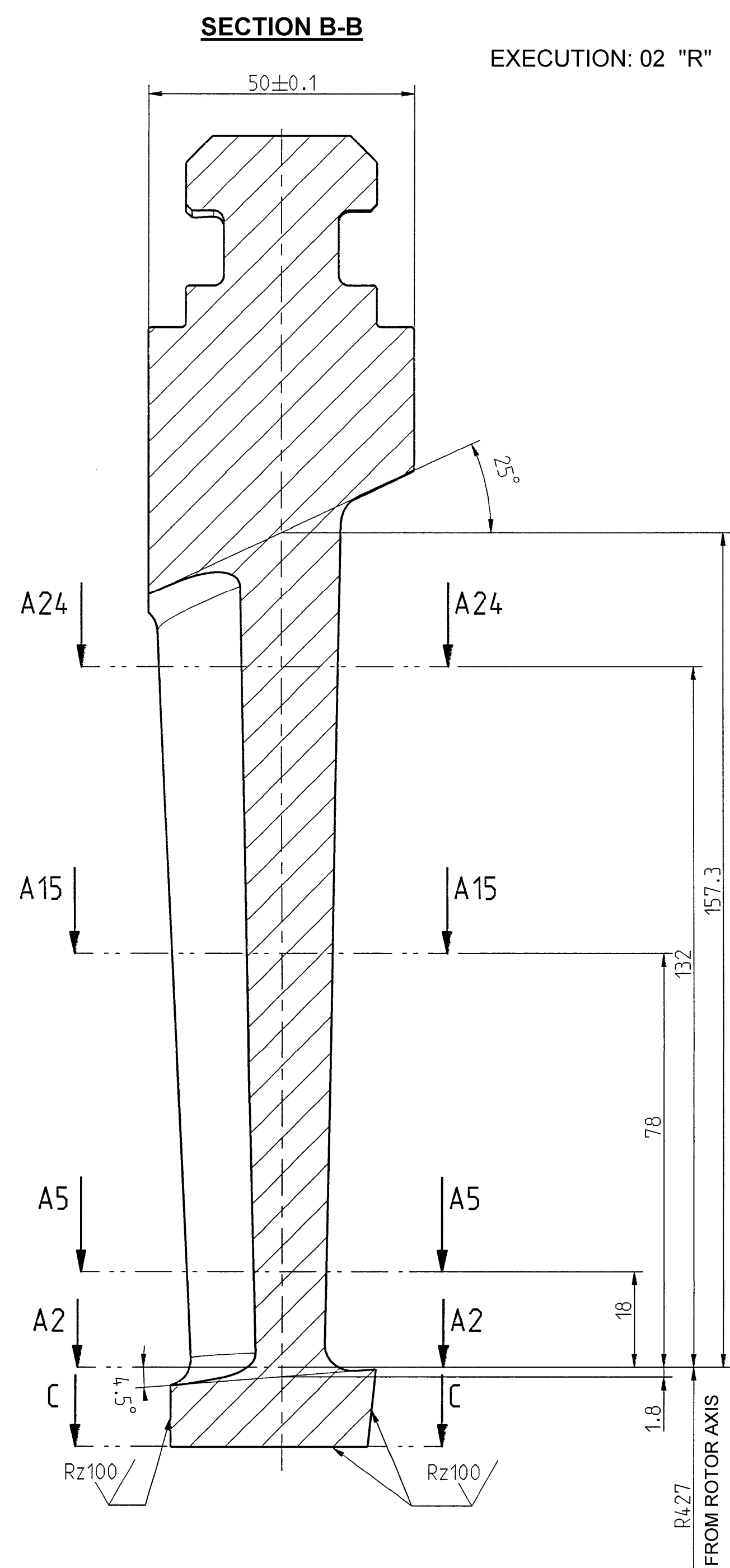
CENTRE DISTANCES IN SEMI FINISHED CONDITION

XT

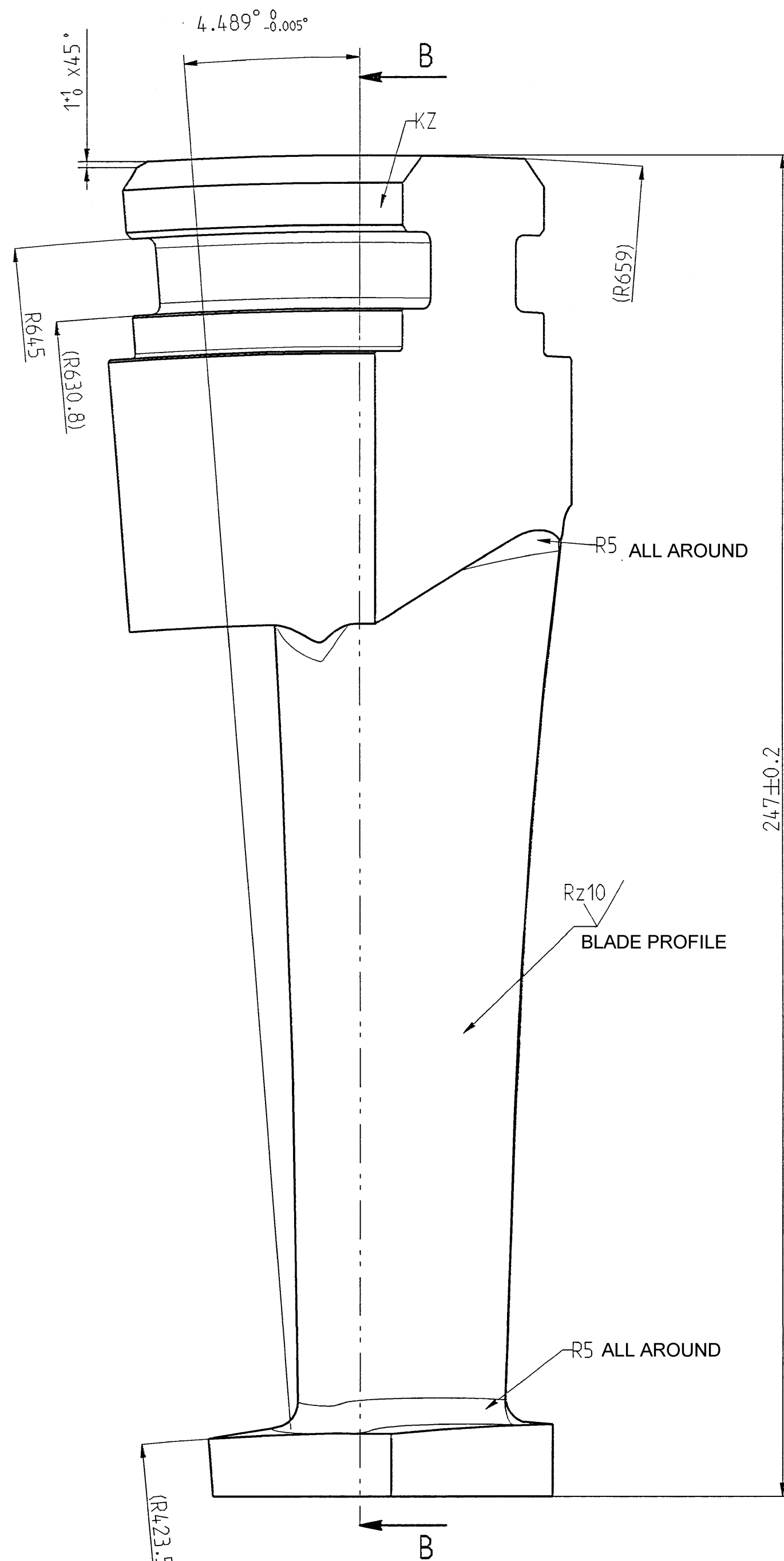
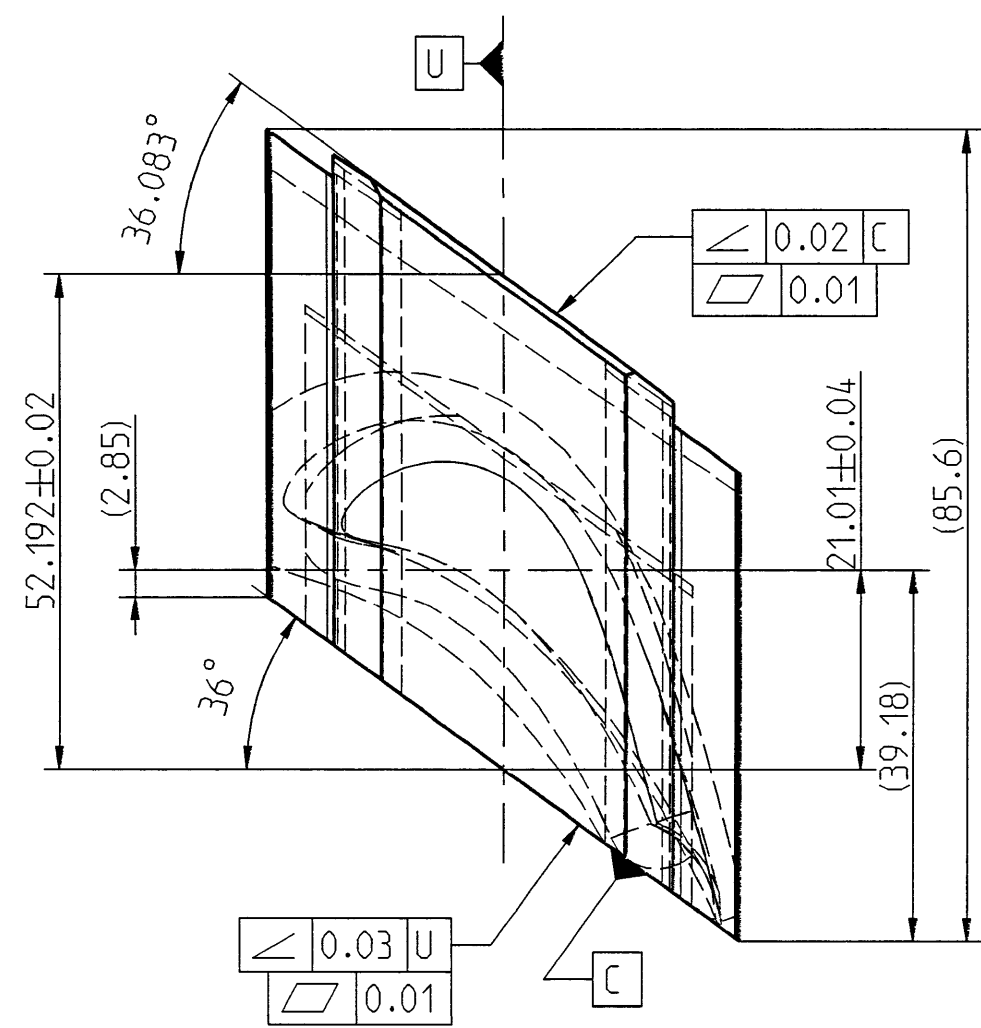
27.7

DRG NO. 1-301-79-00003 SH. 01 OF 01

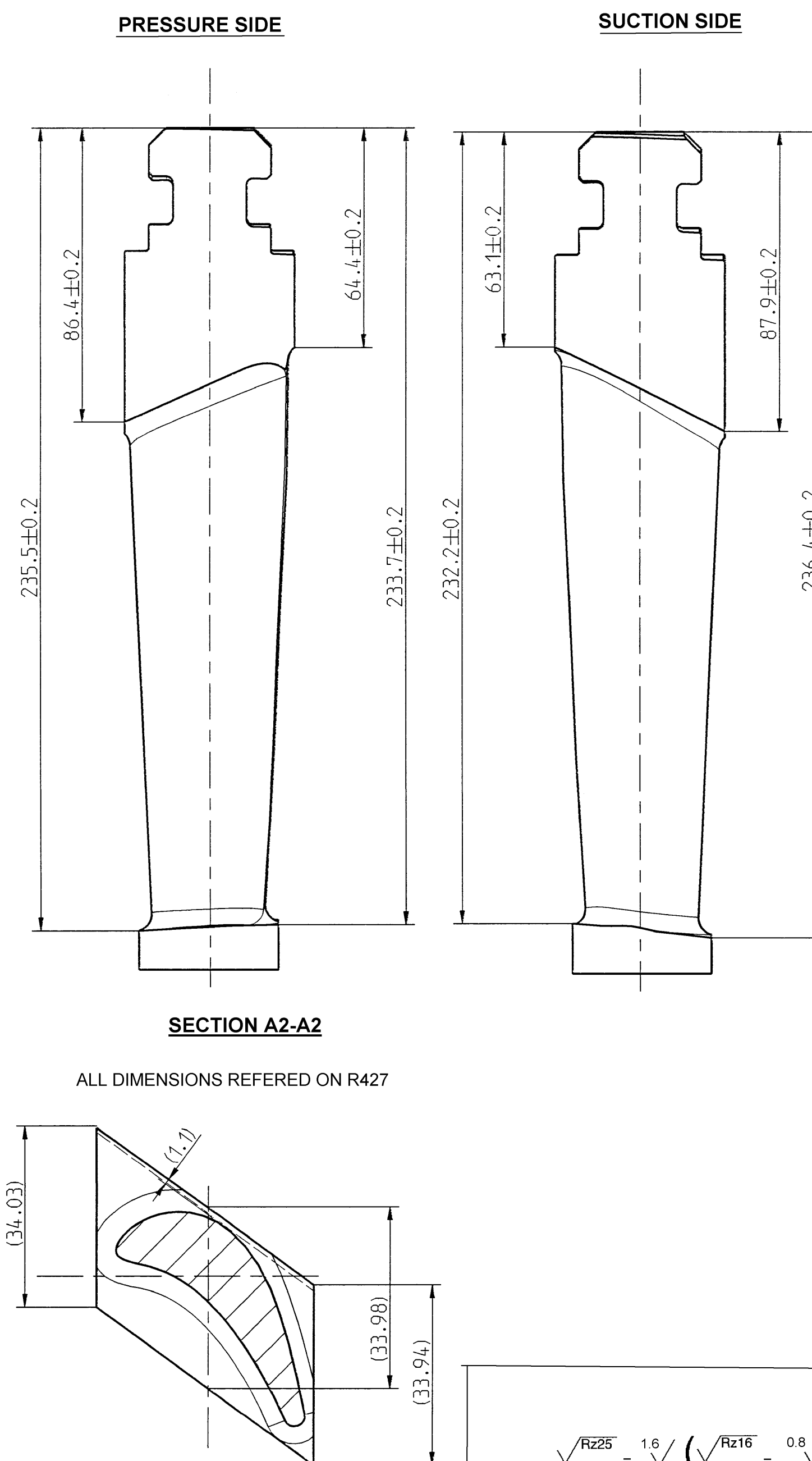
POS : 1



ALL DIMENSIONS REFERED ON R659



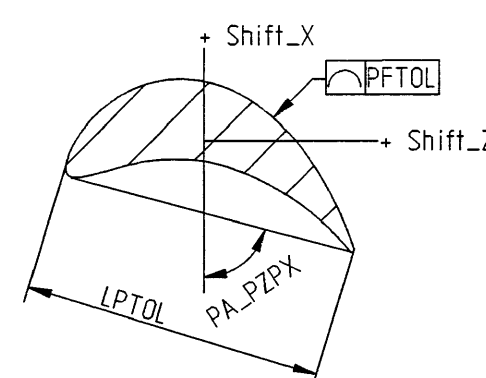
SCHEME OF DIMENSIONS



SECTION A2-A2

ALL DIMENSIONS REFERED ON R427

PROFILE TOLERANCES FOR THE PROFILE SECTION A5, A15, A24.

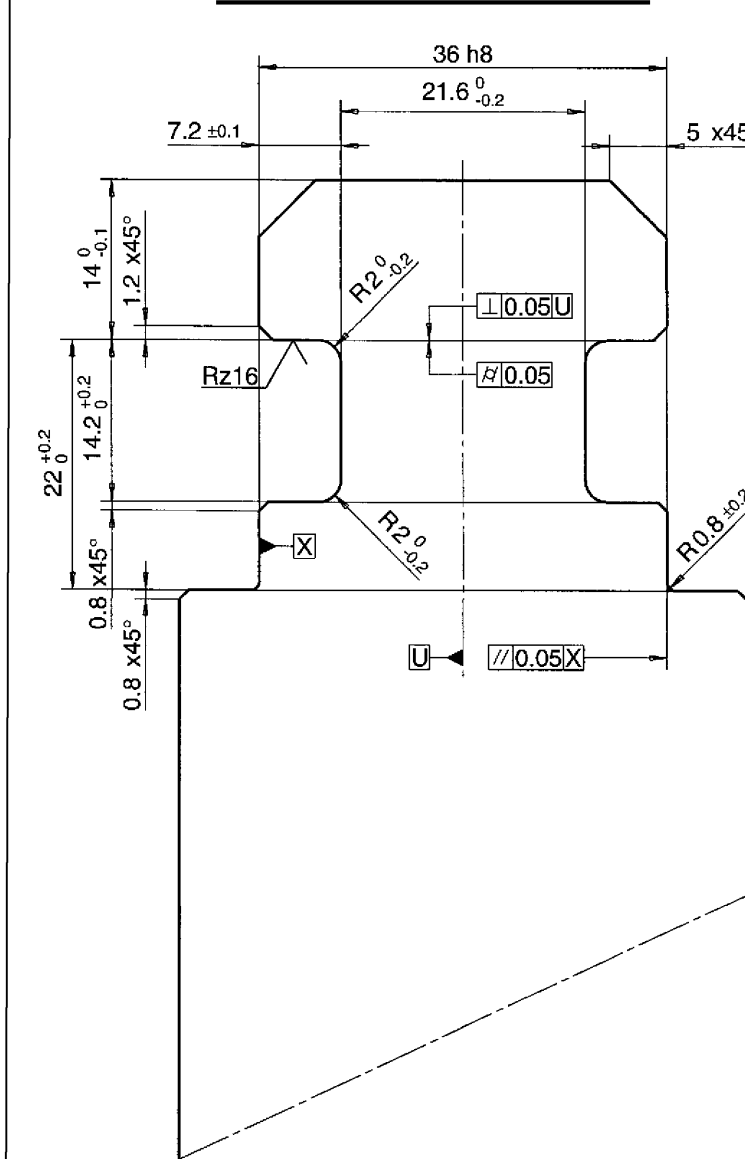


PFTOL	0.20
Shift_X	+0.40
Shift_Z	-0.20
PA_PZPX	±0.20°
LPTOL	+0.20
	-0.40

EY VALUE FOR 250mm SINE BAR LENGTH	
FOR LEFT VAR 00 & 01	FOR RIGHT VAR 02 & 03
EX=5.8248	EX=5.833
EY=16.0434	EY=16.0434

$$\sqrt{Rz25} = 1.6 \sqrt{Rz16} = 0.8 \sqrt{Rz100} = 12.5 \sqrt{Rz10}$$

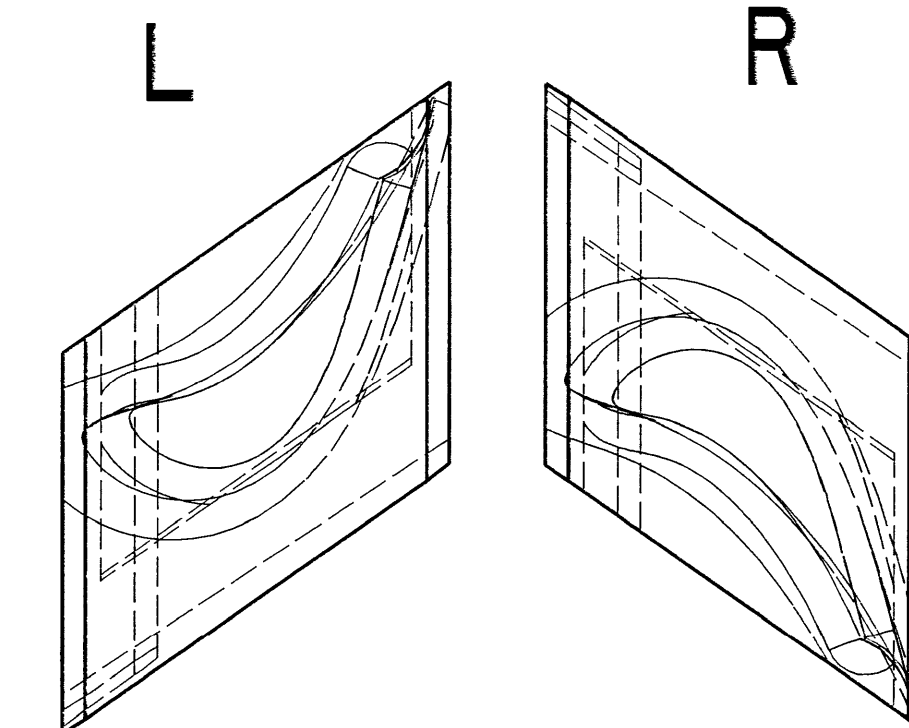
BLADE ROOT DETAIL



$$Rz16 \sqrt{0.8} = \sqrt{Rz10} = 0.8 \sqrt{Rz100} = 12.5 \sqrt{Rz10}$$

EXECUTION: 00 'L'

EXECUTION: 02 'R'

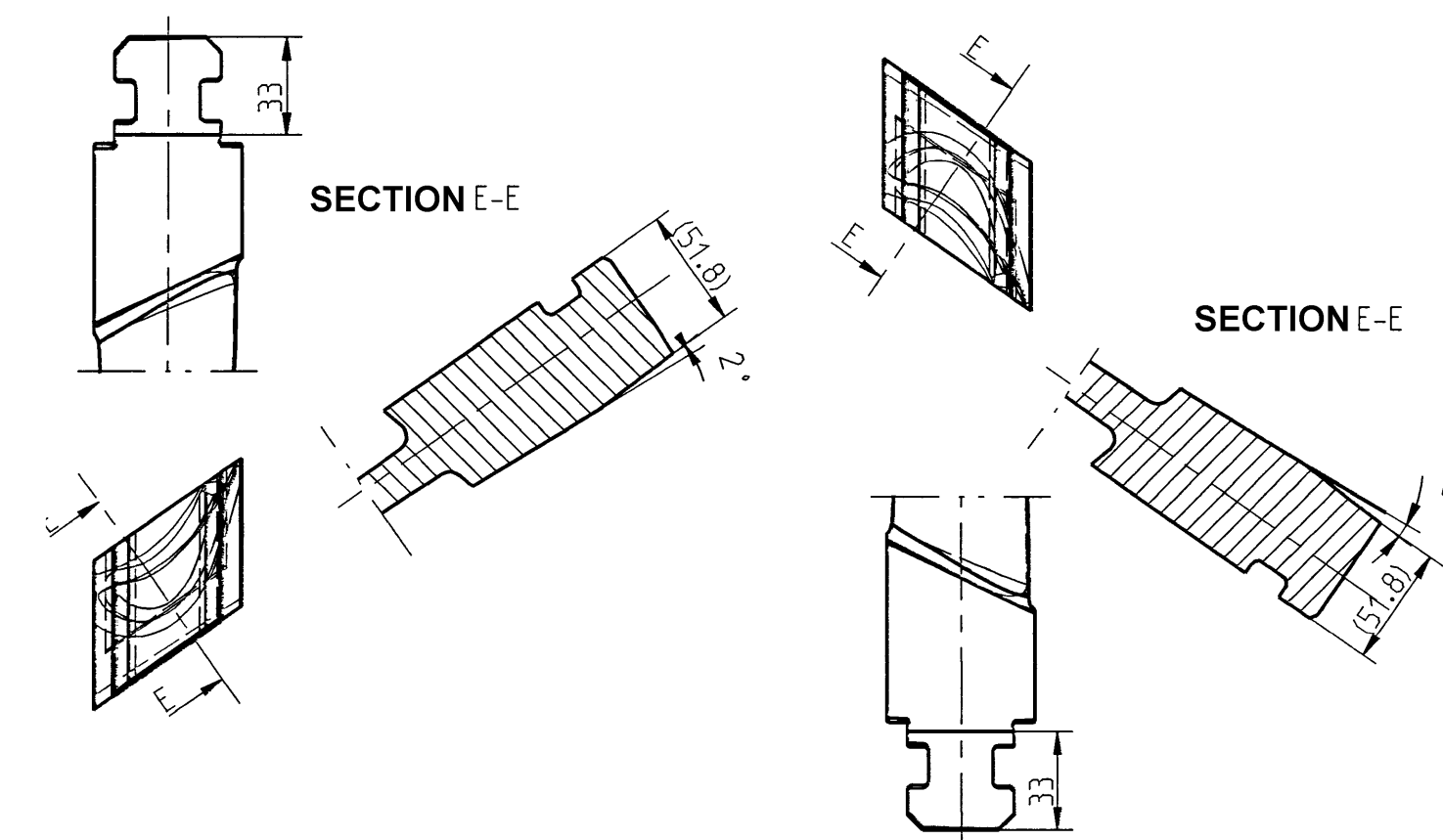


POS : 2

GUIDE BLADES AT JOINT PLANE(2PCS) MADE BY REWORKING ON NORMAL GIUDE BLADE

EXECUTION: 01 'L'

EXECUTION: 03 'R'



NOTES:

1. Profile co-ordinates as per drawing No: 0-301-79-00001-00
2. Profile checking sections: A5, A15, A24.
3. Final Machining as per Blading Plan.
4. Total No. of Blade = 80.

Flat 95X70 X20Cr13V HY10764	2	03	03
	78	02	02
	2	01	01
	78	00	00
Description	No. of Blades	Execution	Var

TYPE OF PRODUCT OR

NAME OF CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LIMITED		NAME	SIGN	DATE	NO OF VAR
DRN	HARISH			14.05.06	
CHD	TS PRABHAKAR			14.05.06	NA
APPD	CNV RAMANA			14.05.06	
DEPT	UNTL DMS	SCALE	WEIGHT (KG)	REF TO ASSY DRG	ITEM NO
415	G/M/f	NTS	1.87	NA	NA
TITLE	DRAWING NO.		CARD CODE	REV	
LP GUIDE BLADE-1 (SL 2.2 SQM)	1-301-79-00003		01	00	
	SHT No	01	NO OF SHT	01	

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GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261

INVENTORY NO

SIGN AND DATE

DRG NO

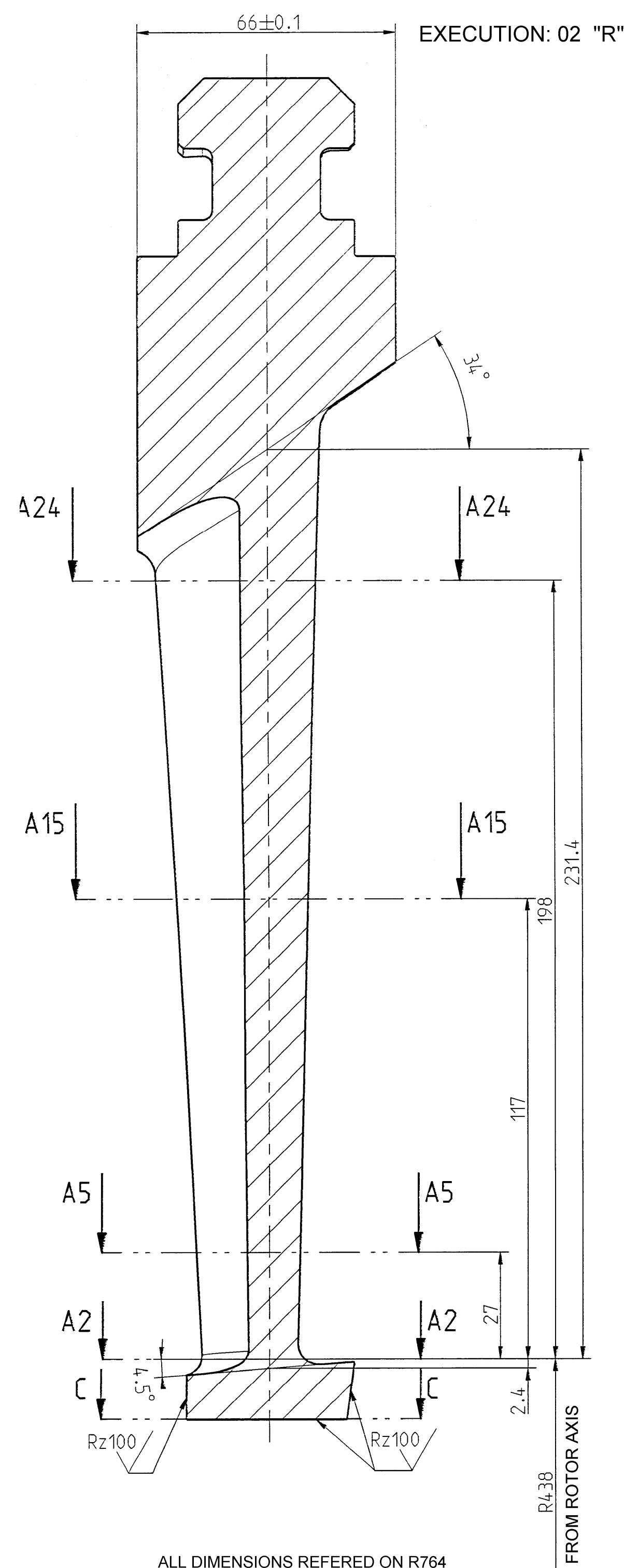
REF

0-2116-2201-10

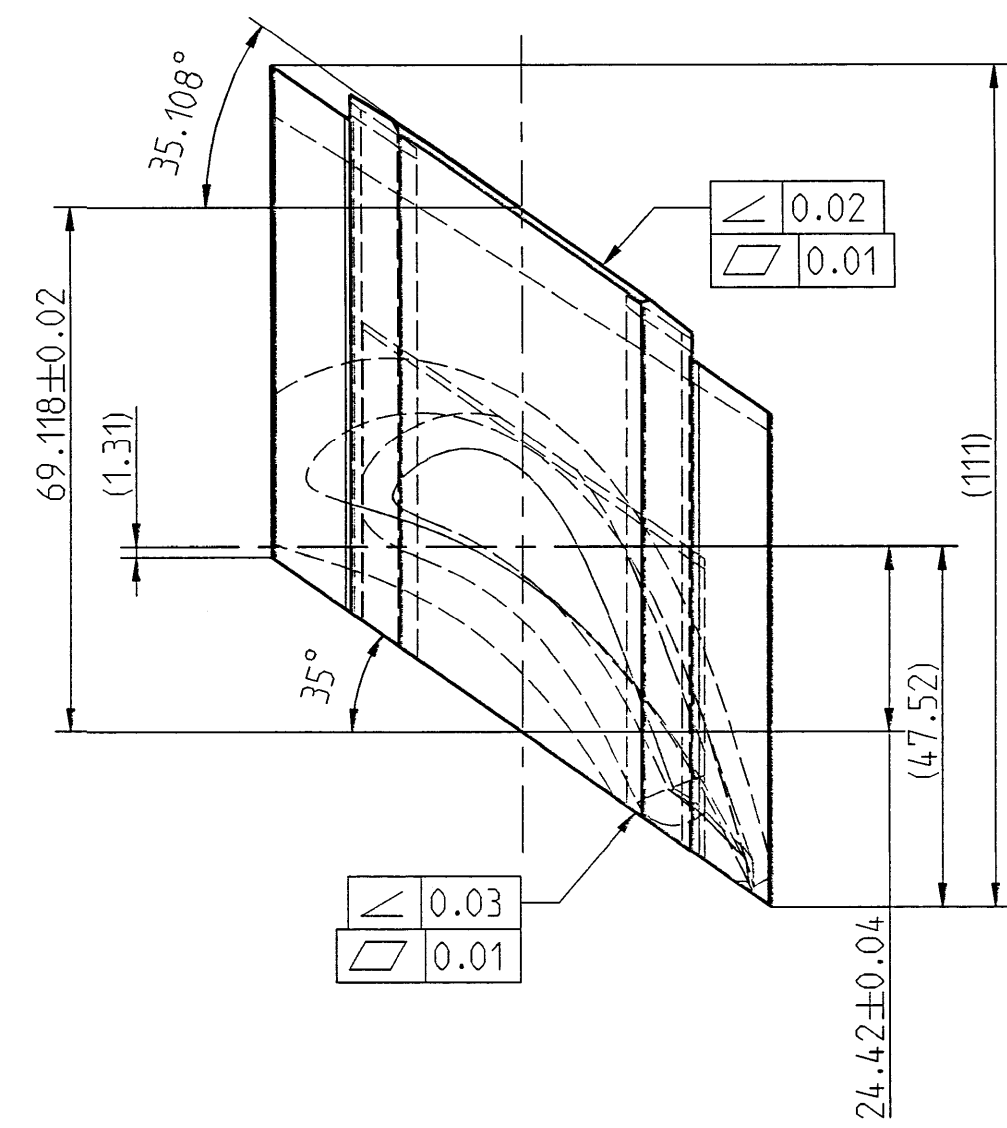
COMPUTER FILE NAME

**SECTION B-B**

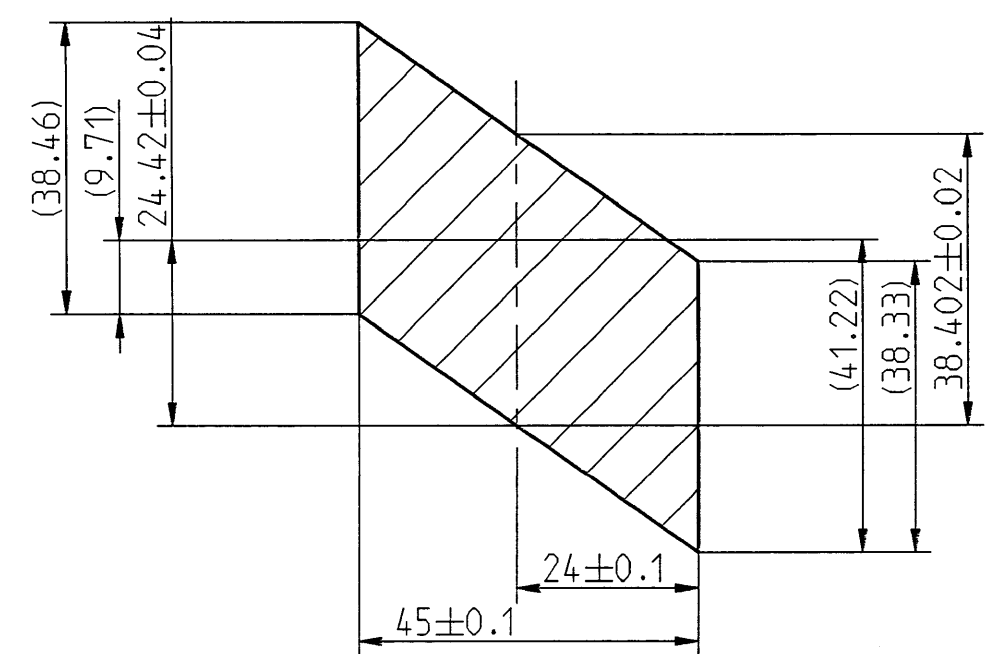
**POS : 1**



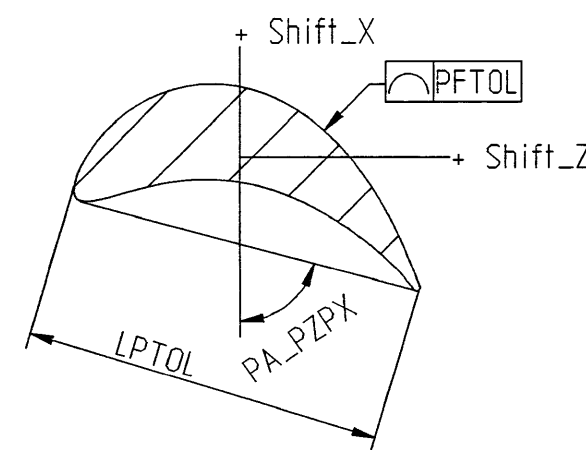
ALL DIMENSIONS REFERED ON R764



**SECTION C-C**



PROFILE TOLERANCES FOR THE PROFILE SECTION A5, A15, A24.

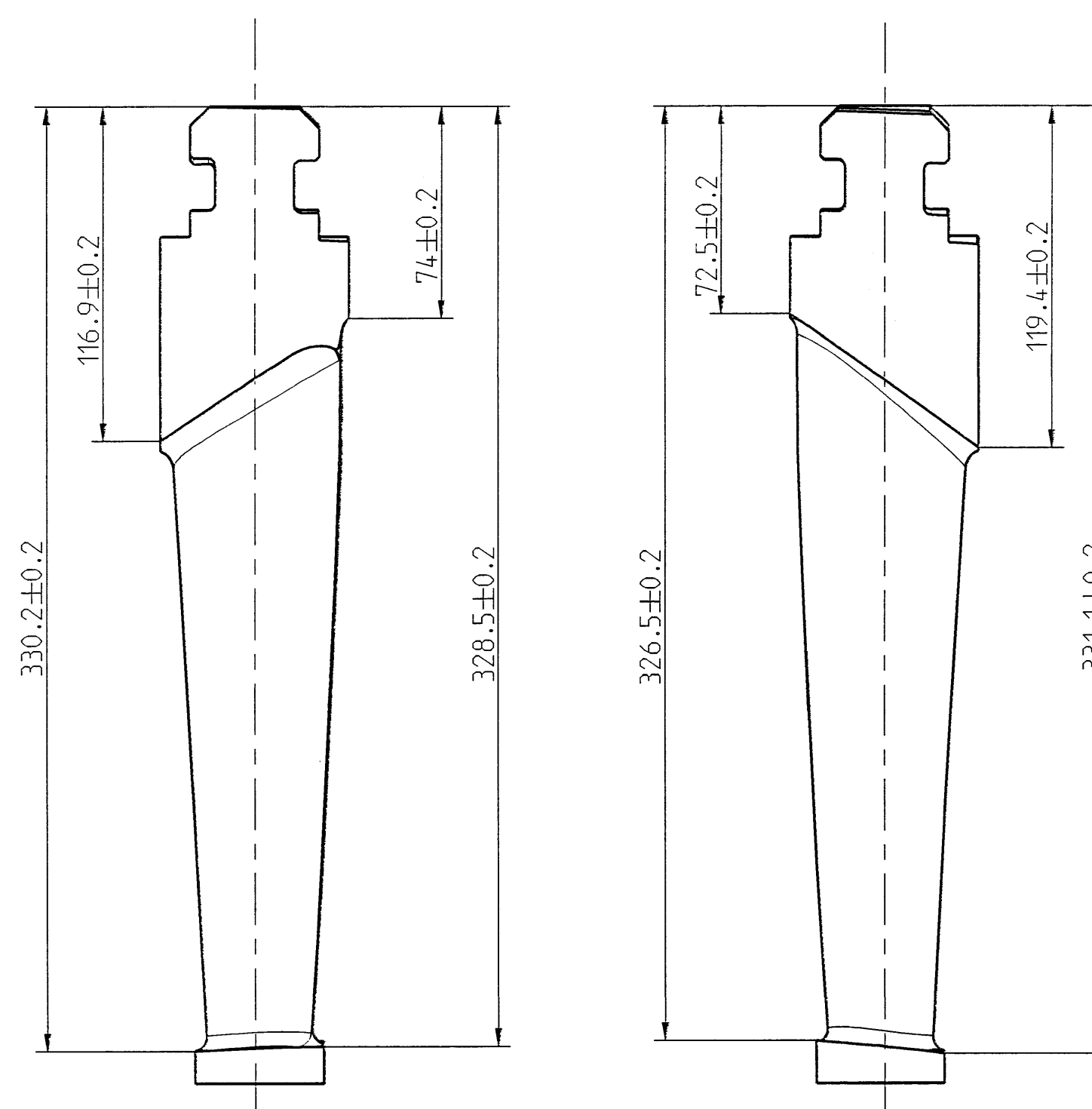


PFTOL	0.25
Shift_X	+0.50 -0.25
Shift_Z	+0.50 -0.25
PA_PZPX	±0.25
LPTOL	+0.25 -0.50

**SCHEME OF DIMENSIONS**

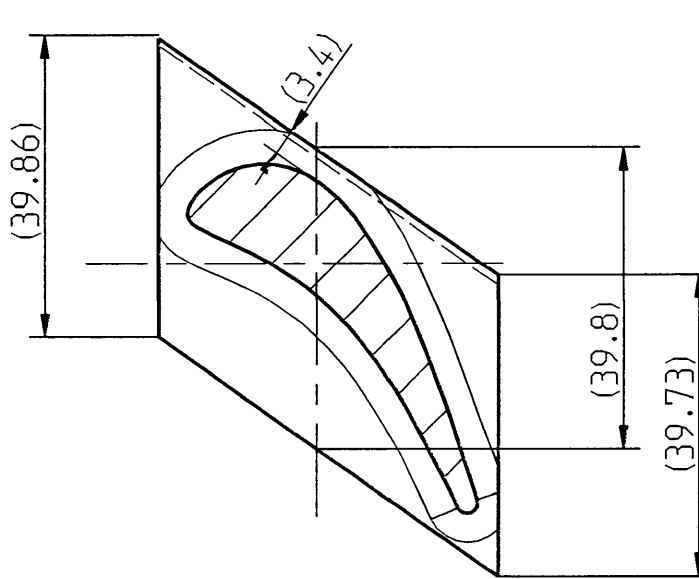
**PRESSURE SIDE**

**SUCTION SIDE**



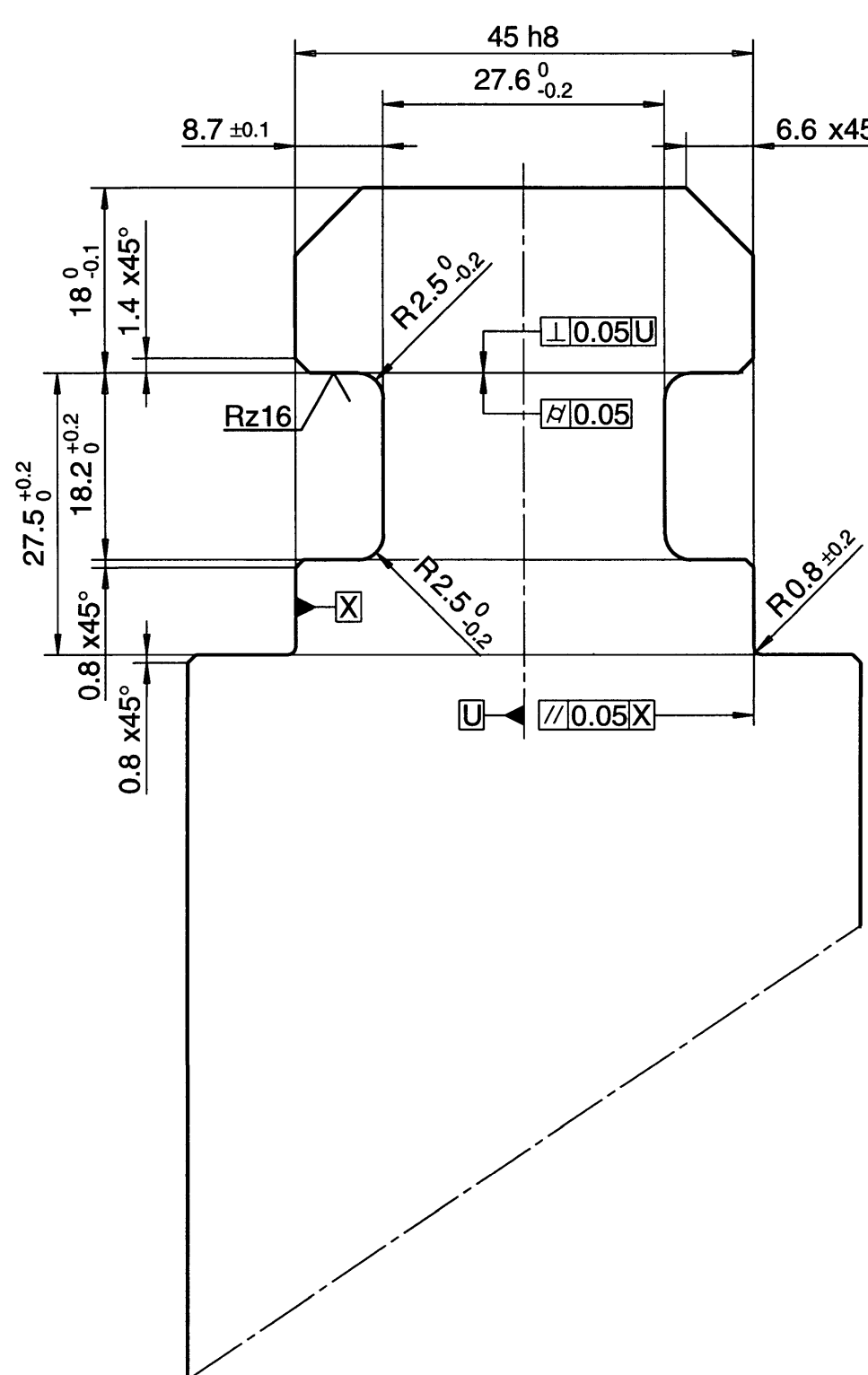
**SECTION A2-A2**

ALL DIMENSIONS REFERED ON R438



EY VALUE FOR 250mm SINE BAR LENGTH	
FOR LEFT VAR 00 & 01	FOR RIGHT VAR 02 & 03
EX= 6.4890	EX= 6.4985
EY= 18.5403	EY= 18.5403

**BLADE ROOT DETAIL**



Rz16/0.8 (Rz10/0.8 Rz100/12.5)

**L**

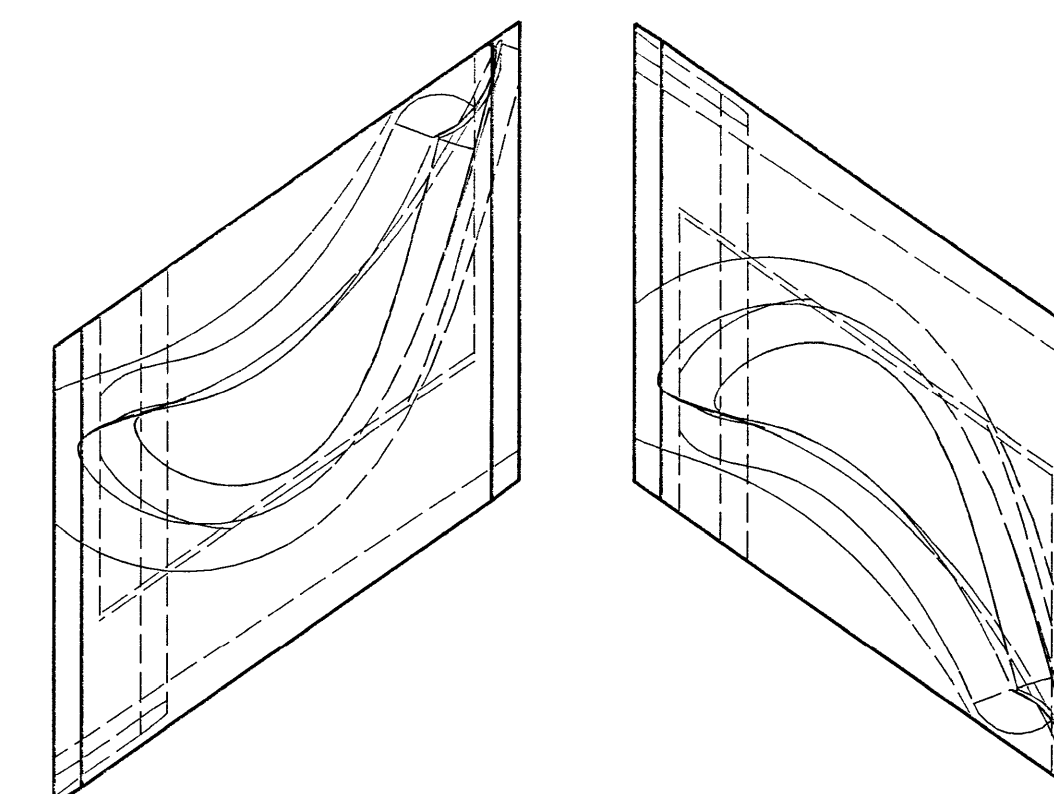
**R**

EXECUTION: 00 "L"

EXECUTION: 02 "R"

LEFT

RIGHT



**POS : 2**

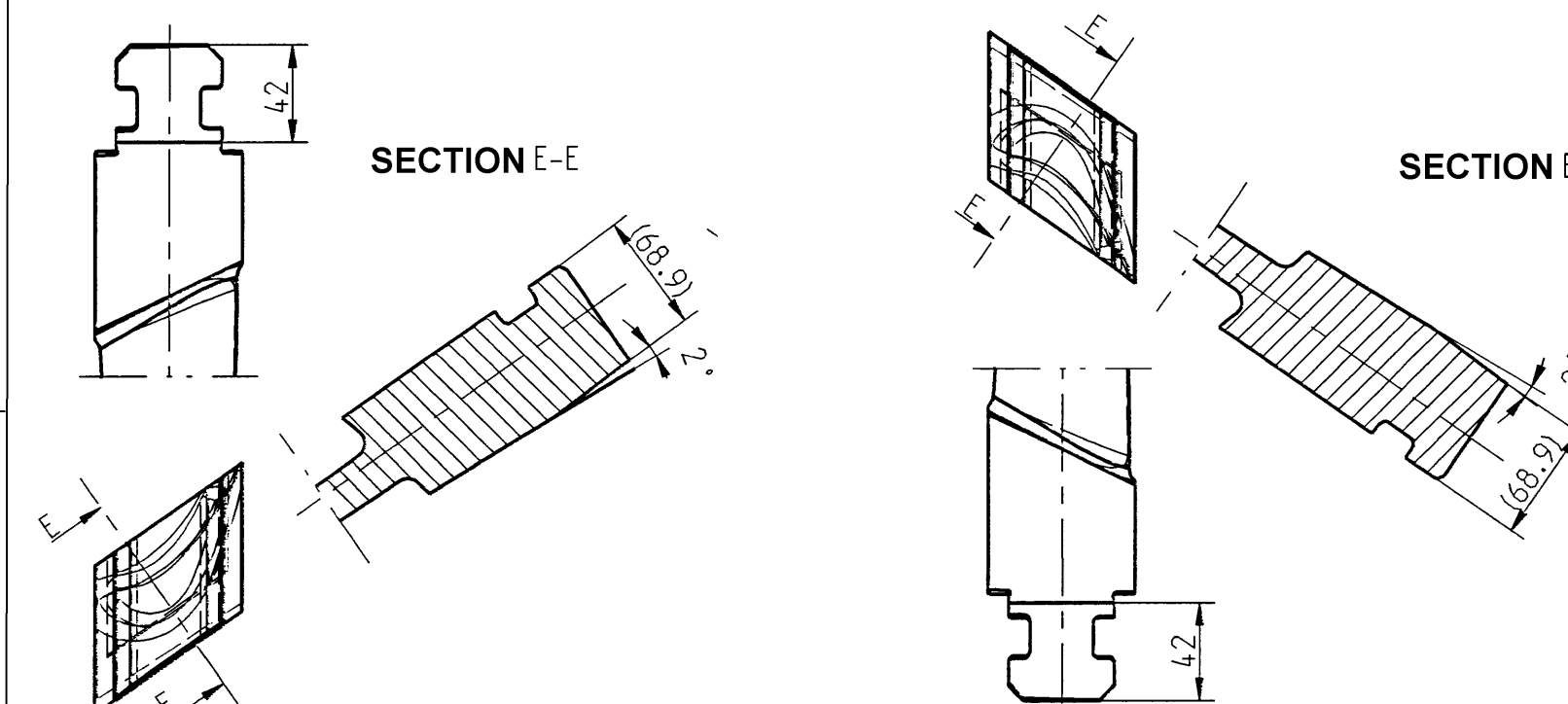
GUIDE BLADES AT JOINT PLANE(2PCS) MADE BY REWORKING ON NORMAL GIUDE BLADE

EXECUTION: 01 "L"

EXECUTION: 03 "R"

**SECTION E-E**

**SECTION E-E**



**NOTES:**

1. Profile co-ordinates as per drawing No: 0-301-81-0001-00
2. Profile checking sections: A5, A15, A24.
3. Final Machining as per Blading Plan.
4. Total No. of Blade = 70.

FLAT 125X80 X20Cr13V HY10764	2	03	03
	68	02	02
	2	01	01
	68	00	00
Description	No. of Blades	Execution	Var

**TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT**

**HYDERABAD**

DRN	HARISH	SIGN	DATE	NO OF VAR
CHD	TS PRABHAKAR		14.05.06	NA
APPD	CNV RAMANA		14.05.06	NA

DEPT	UNTL	DIMS	SCALE	WEIGHT (KG)	REF TO ASSY DRG	ITEM NO	NO OF
415	GR	C/M/F	NTS	3.7	NA	NA	NA

**TITLE**  
LP GUIDE BLADE-2 (SL 2.2 SQM)

**DRAWING NO.**  
1-301-81-0001

REV 00

SHT No 01 NO OF SHT 01

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GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261

