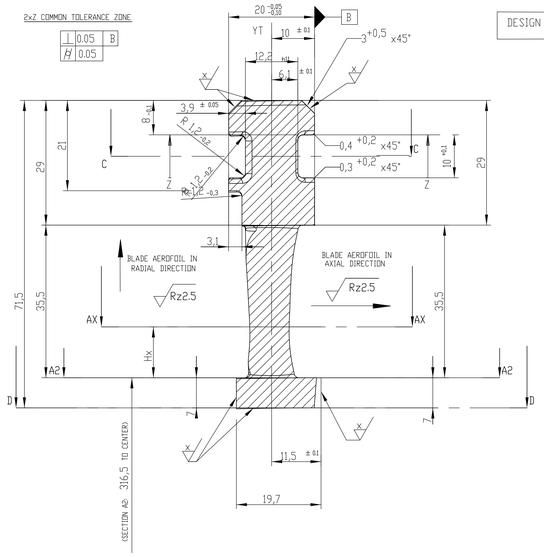
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG. NO 0-105-18-62012 SH. 02 OF 27

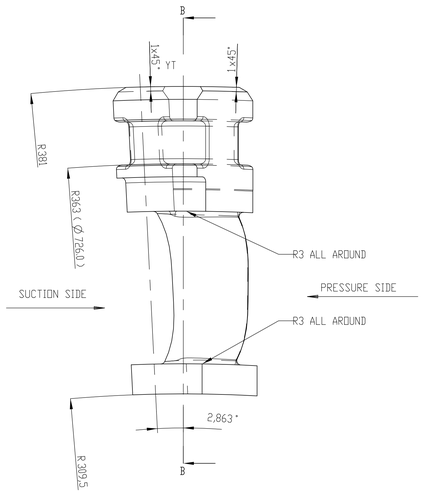
SECTION B-B

DIRECTION OF STEAM FLOW



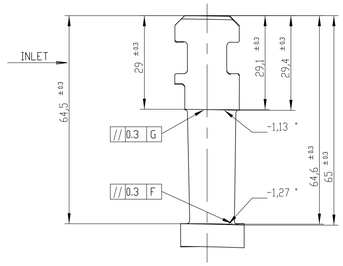
POS. NO.: 1

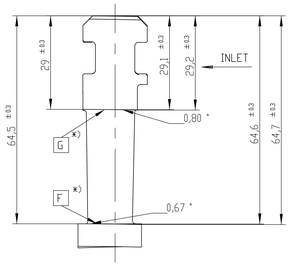
DESIGN 'RIGHT'



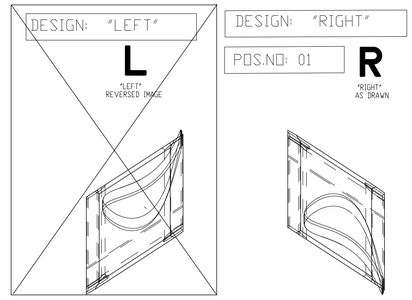
SCHEME FOR D AND S DIMENSIONS

*) REFERED TO ADJACENT BLADE





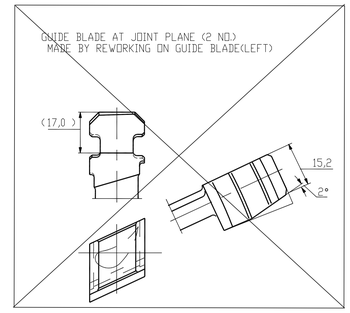
3.2 ALL OVER EXCEPT OTHERWISE STATED (Rz100 Rmax160 = 12.5 Rz2.5 = 0.4 Rz10 = 1.6)



BLADE SHOWN IN DIRECTION OF STEAM FLOW

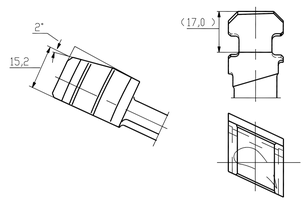
SECTION AX	Hx	Lges	AMI	UMA	RHk	BBi	D
A1 - A1	-10.0	18.94	5.14	9.84	0.10	47.10	6.10
A2 - A2	0.0	19.57	5.35	4.58	0.10	46.71	6.31
A12-A12	10.0	20.21	5.57	2.19	0.11	46.34	6.51
A20-A20	18.0	20.71	5.74	2.46	0.11	46.03	6.67
A27-A27	25.0	21.15	5.89	2.92	0.11	45.77	6.82

LOCAL SMALLEST RADIUS OF CURVATURE ON PRESSURE SIDE: 12.4 MM

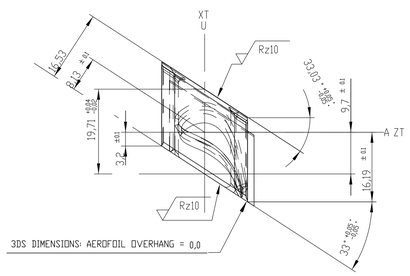


POS.NO : 02

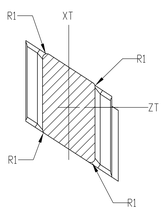
JOINT BLADE AT PARTING PLANE (2 NO.)
MADE BY REWORKING ON GUIDE BLADE(RIGHT)



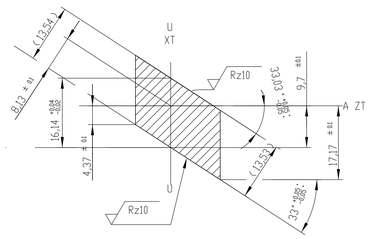
VIEW X



SECTION CC

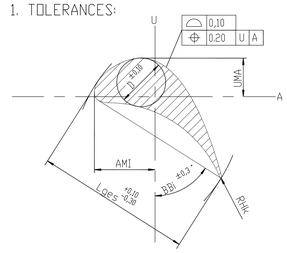


SECTION DD



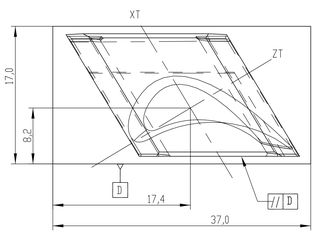
TECHNICAL REQUIREMENTS

1. TOLERANCES:

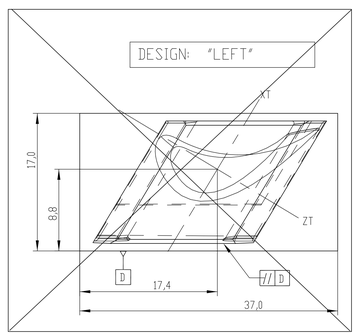


2. STRAK NUMBER: 80561
3. NUMBER OF BLADES/ROW: 122
(INCLUDING JOINT BLADES)

DESIGN: "RIGHT"



DESIGN: "LEFT"



CENTRE DISTANCES IN SEMI-FINISHED CONDITION

ROW NO.	02(RIGHT) 02 VAR
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT	BHARAT HEAVY ELECTRICALS LTD HYDERABAD
DRN.	A HEMASUNDAR 15/5/2015
CHD.	K THRIMURTHULU 15/5/2015
APPD.	T.S.PRABHAKAR 15/5/2015
DEPT.	LTD
CODE	415
UNTOL. DIMS. OR C/M/F	
SCALE	NTS
WEIGHT (KG)	0,100
REF. TO ASSY. DRG.	-NA-
ITEM NO.	-NA-
NO.OF ITEMS	-NA-
TITLE	GUIDE BLADE - RIGHT
	S-135-S20-TR07Z/036A4S
CARD CODE	-
DRAWING NO.	0-105-18-62012
REV.	00
SHT. No 02	NO. OF SHT. 27

REV.	DATE	ALTERED	CHD/APPD	ZONE

INVENTORY NO | SIGN. AND DATE | REF. DRG. NO. | COMPUTER FILE NAME T-1124

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GENERAL DIMENSIONAL LIMITS,FITS & TOLERANCES AS PER HY0230261