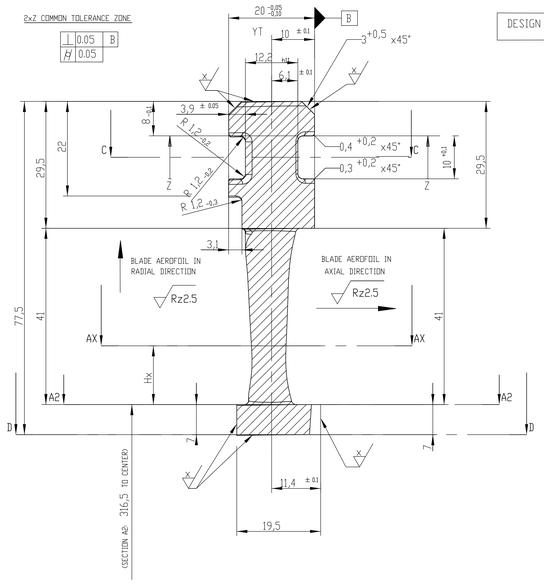
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG. NO 0-105-18-62012 SH. 15 OF 27

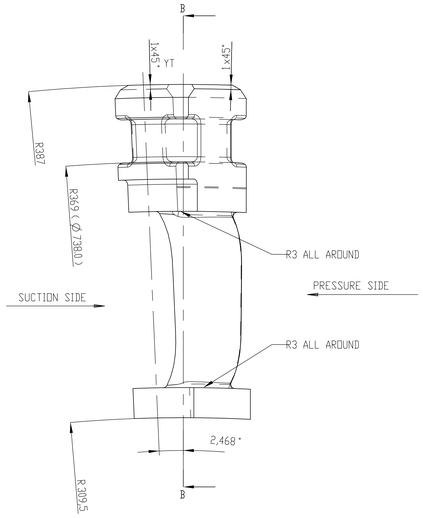
SECTION B-B

DIRECTION OF STEAM FLOW



DESIGN 'RIGHT'

POS. NO.: 1

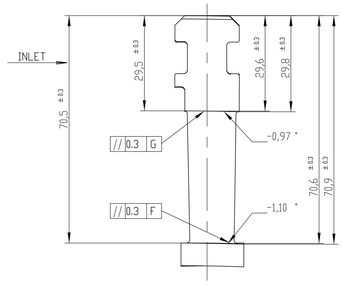


SCHEME FOR D AND S DIMENSIONS

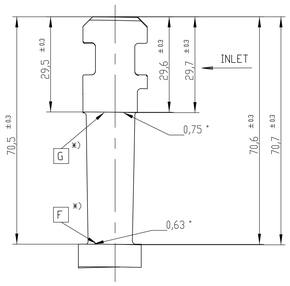
*) REFERED TO ADJACENT BLADE

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

PRESSURE SIDE



SUCTION SIDE



DESIGN: "LEFT"

L

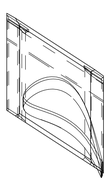
"LEFT" REVERSED IMAGE

DESIGN: "RIGHT"

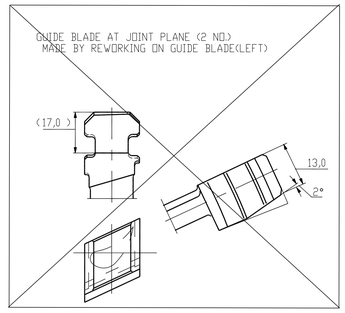
POS.NO: 01

R

"RIGHT" AS DRAWN



BLADE SHOWN IN DIRECTION OF STEAM FLOW

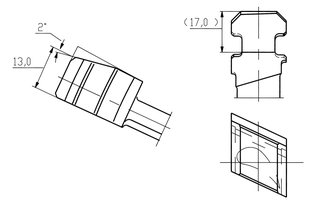


SECTION AX	Hx	Lges	AMI	UMA	RHk	BBi	D
A1 - A1	-10.0	17.42	5.10	9.38	0.09	51.73	5.61
A2 - A2	0.0	18.04	5.33	4.06	0.10	51.33	5.81
A12-A12	10.0	18.65	5.54	1.75	0.10	50.96	6.01
A23-A23	21.0	19.30	5.77	2.15	0.10	50.55	6.22
A33-A33	31.0	19.85	5.97	2.67	0.11	50.17	6.40

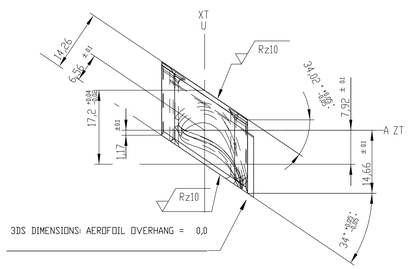
LOCAL SMALLEST RADIUS OF CURVATURE ON PRESSURE SIDE: 11.4 MM

POS.NO : 02

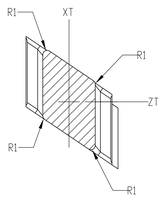
JOINT BLADE AT PARTING PLANE (2 NO.)
MADE BY REWORKING ON GUIDE BLADE(RIGHT)



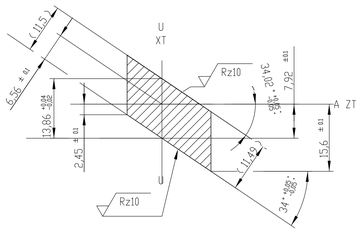
VIEW X



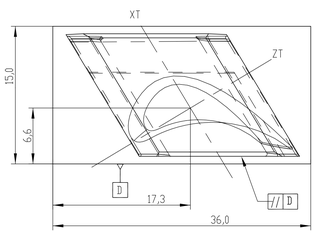
SECTION CC



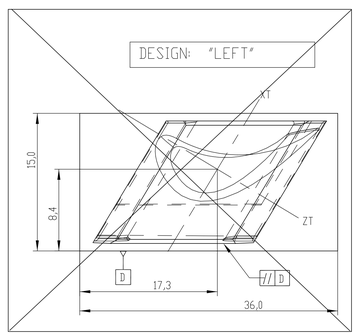
SECTION DD



DESIGN: "RIGHT"



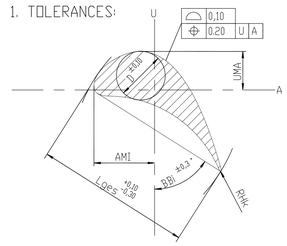
DESIGN: "LEFT"



CENTRE DISTANCES IN SEMI-FINISHED CONDITION

TECHNICAL REQUIREMENTS

1. TOLERANCES:



2. STRAK NUMBER: 80574
3. NUMBER OF BLADES/ROW: 142
(INCLUDING JOINT BLADES)

15(RIGHT) | 15
ROW NO. | VAR

TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LTD
HYDERABAD

	NAME	DATE	NO.OF VAR.
DRN.	A HEMASUNDAR	15/5/2015	
CHD.	K THRIMURTHULU	15/5/2015	-NA-
APPD.	T.S.PRABHAKAR	15/5/2015	

DEPT. LTB | UNTOL. DIMS. GR C/M/F | SCALE NTS | WEIGHT (KG) 0,090 | REF. TO ASSY. DRG. -NA- | ITEM NO. -NA- | NO.OF ITEMS -NA-

CODE 415

TITLE GUIDE BLADE - RIGHT
S-135-S20-TR078/041A2S

CARD CODE -

DRAWING NO. 0-105-18-62012 REV. 00

SHT. No 15 NO. OF SHT. 27

REV.	DATE	ALTERED	CHD/APPD
ZONE			

GENERAL DIMENSIONAL LIMITS,FITS & TOLERANCES AS PER HY0230261

COMPUTER FILE NAME T-1134

REF. DRG. NO.

SIGN. AND DATE

INVENTORY NO

THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPAY

SAP DOC NO

CHECKED