FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG. NO 0-105-18-62012 SH. 22 OF 27

SECTION B-B

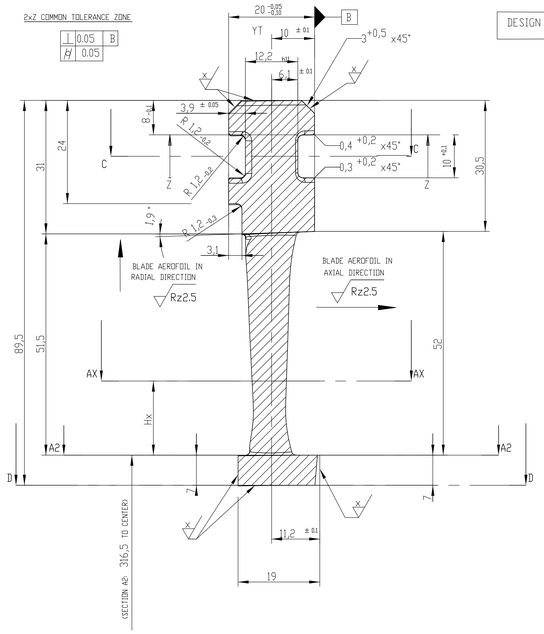
DIRECTION OF STEAM FLOW

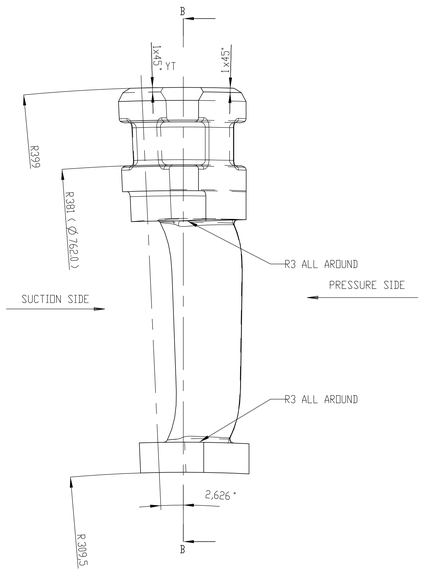
POS. NO.: 1

DESIGN "RIGHT"

2x2 COMMON TOLERANCE ZONE

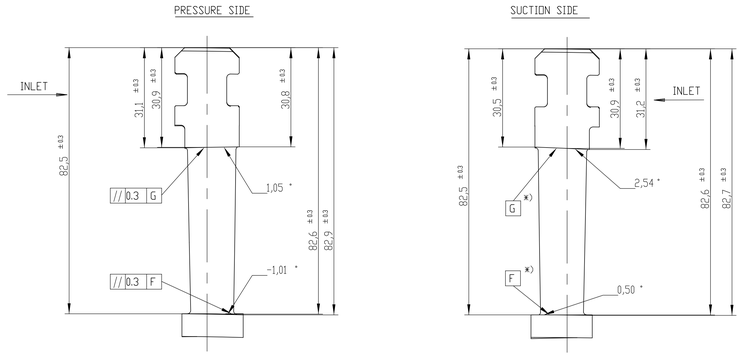
⊥	0.05	B
⌭	0.05	



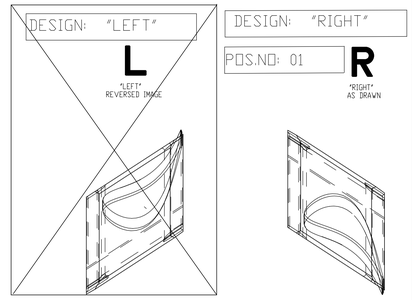


SCHEME FOR D AND S DIMENSIONS

*) REFERED TO ADJACENT BLADE

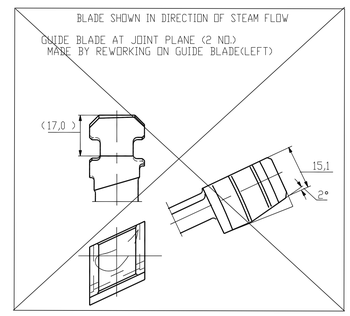


3.2 ALL OVER EXCEPT OTHERWISE STATED (x = Rz100 Rmax160 = 12.5 = Rz2.5 = 0.4 = Rz10 = 1.6)



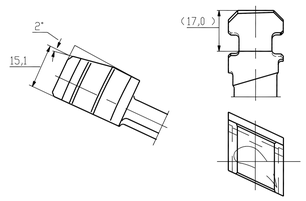
SECTION AX	Hx	Lges	AMI	UMA	RHk	BBi	D
A1 - A1	-10.0	17.03	4.84	9.38	0.09	51.22	5.49
A2 - A2	0.0	17.64	5.06	3.98	0.09	50.83	5.68
A12-A12	10.0	18.24	5.28	1.62	0.10	50.46	5.88
A28-A28	26.0	19.17	5.60	2.14	0.10	49.87	6.18
A43-A43	41.0	20.00	5.90	2.73	0.11	49.32	6.45

LOCAL SMALLEST RADIUS OF CURVATURE ON PRESSURE SIDE: 11.2 MM

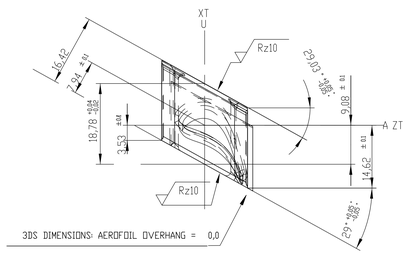


POS.NO : 02

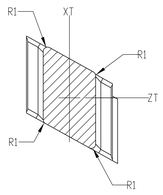
JOINT BLADE AT PARTING PLANE (2 NO.)
MADE BY REWORKING ON GUIDE BLADE(RIGHT)



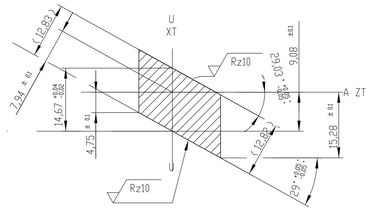
VIEW X



SECTION CC

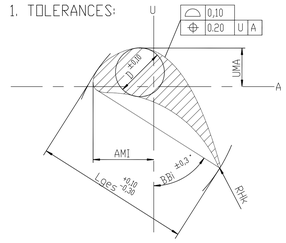


SECTION DD



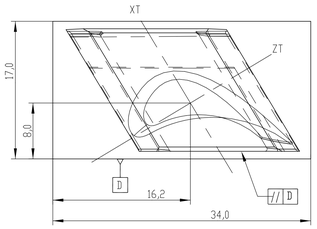
TECHNICAL REQUIREMENTS

1. TOLERANCES:

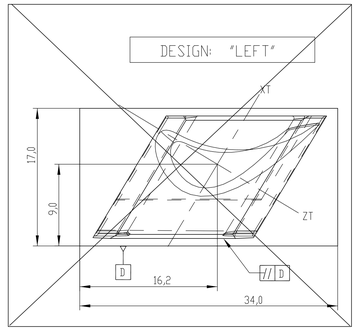


2. STRAK NUMBER: 80581
3. NUMBER OF BLADES/ROW: 134
(INCLUDING JOINT BLADES)

DESIGN: "RIGHT"



DESIGN: "LEFT"



CENTRE DISTANCES IN SEMI-FINISHED CONDITION

22(RIGHT) 22
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.	UNTOL. DIMS. OR C/M/F	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM NO.	NO.OF ITEMS
118		NTS	0.110	-NA-	-NA-	-NA-

CODE 415

TITLE GUIDE BLADE - RIGHT

S-135-S20-TR090/052A2S

CAGE CODE -

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

SHT. No 22 NO. OF SHT. 27

REV.	DATE	ALTERED	CHD/APPD	ZONE

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

GENERAL DIMENSIONAL LIMITS,FITS & TOLERANCES AS PER HY02302G1

COMPUTER FILE NAME T-1134 | REF. DRG. NO. | STDN. AND DATE | INVENTORY NO.

May Fri 15 11:42 2015

Printed by : P SHASHANK-FM2301 / 6115381 on 18-05-16 15:10:00

This Drawing is printed from Engineering Digital Archive System (EDAS). Therefore signatures are not essentially required.