FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

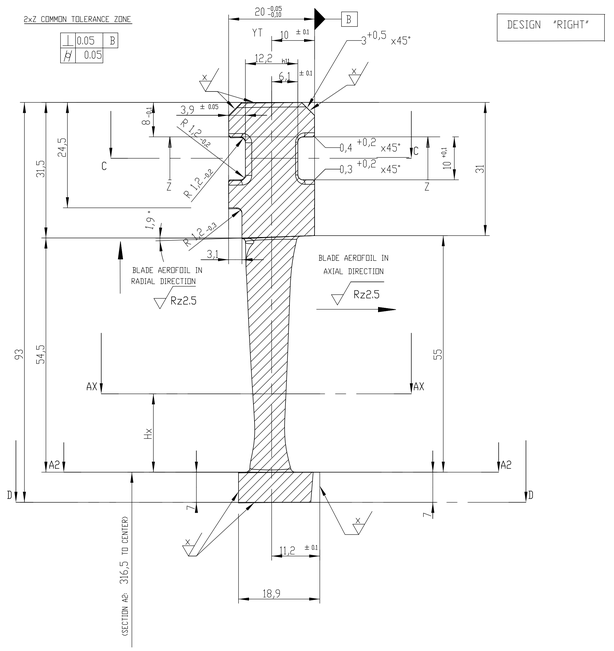
DRG. NO 0-105-18-62012 SH. 23 OF 27

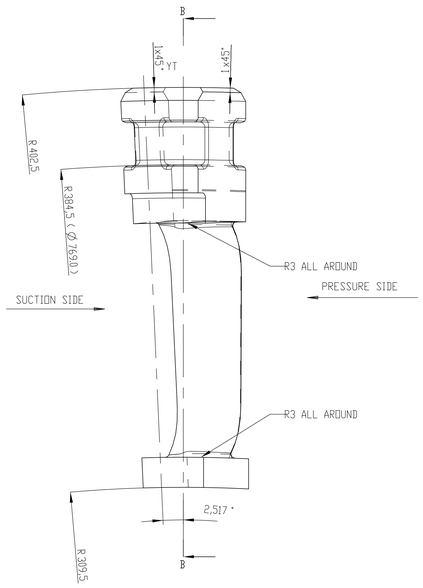
SECTION B-B

DIRECTION OF STEAM FLOW

POS. NO.: 1

DESIGN "RIGHT"

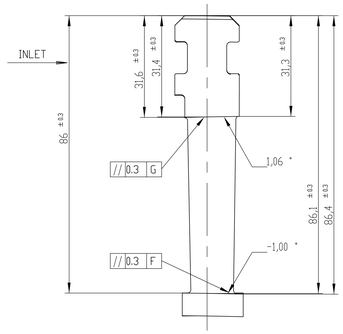




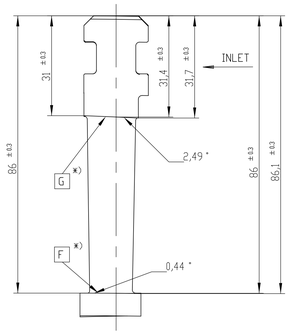
SCHEME FOR D AND S DIMENSIONS

*) REFERED TO ADJACENT BLADE

PRESSURE SIDE

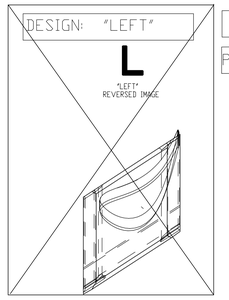


SUCTION SIDE



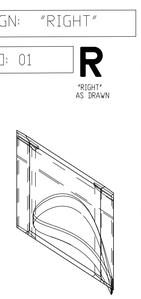
3.2 ALL OVER EXCEPT OTHERWISE STATED (Rz100 Rmax160 = 12.5 = Rz2.5 = 0.4 = Rz10 = 1.6)

DESIGN: "LEFT"

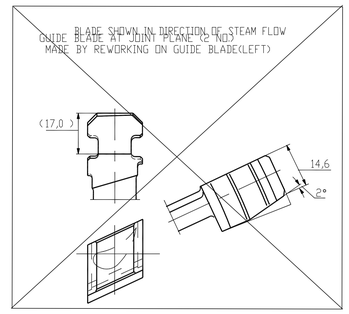


DESIGN: "RIGHT"

POS.NO: 01



BLADE SHOWN IN DIRECTION OF STEAM FLOW
GUIDE BLADE AT JOINT PLANE (2 NO.) MADE BY REWORKING ON GUIDE BLADE(LEFT)

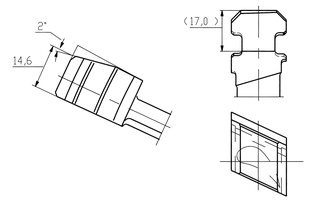


SECTION AX	Hx	Lges	AMI	UMA	RHk	BBi	D
A1 - A1	-10.0	16.98	4.83	8.95	0.09	51.23	5.47
A2 - A2	0.0	17.53	5.02	3.64	0.09	50.85	5.65
A12-A12	10.0	18.09	5.22	1.38	0.10	50.49	5.83
A30-A30	28.0	19.09	5.58	2.15	0.10	49.84	6.15
A46-A46	44.0	19.98	5.89	2.94	0.11	49.25	6.44

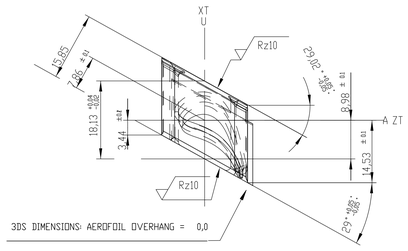
LOCAL SMALLEST RADIUS OF CURVATURE ON PRESSURE SIDE: 11.1 MM

POS.NO : 02

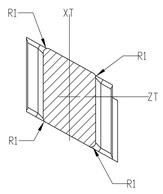
JOINT BLADE AT PARTING PLANE (2 NO.) MADE BY REWORKING ON GUIDE BLADE(RIGHT)



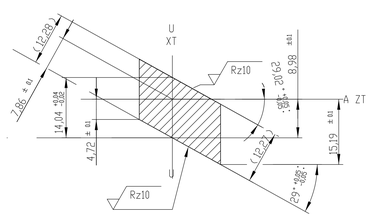
VIEW X



SECTION CC

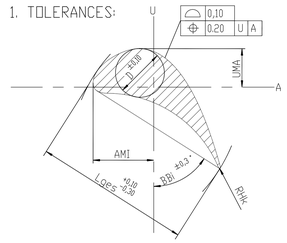


SECTION DD



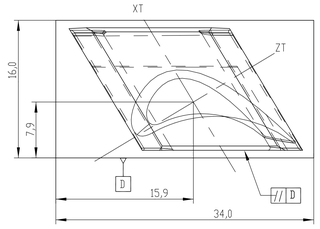
TECHNICAL REQUIREMENTS

1. TOLERANCES:

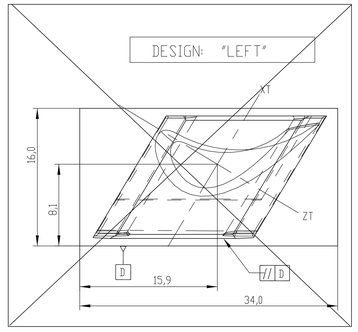


2. STRAK NUMBER: 80582
3. NUMBER OF BLADES/ROW: 140 (INCLUDING JOINT BLADES)

DESIGN: "RIGHT"



DESIGN: "LEFT"



CENTRE DISTANCES IN SEMI-FINISHED CONDITION

23(RIGHT)	23
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
CODE 415		NTS	0,110	-NA-	-NA-	-NA-

TITLE GUIDE BLADE - RIGHT
S-135-S20-TR093/055A2S

CARS CODE -

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

SHT. No 23 NO. OF SHT. 27

REV.	DATE	ALTERED	CHD/APPD	ZONE

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

GENERAL DIMENSIONAL LIMITS,FITS & TOLERANCES AS PER HY0230261

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May Fri 15 11:42 2015
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