FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

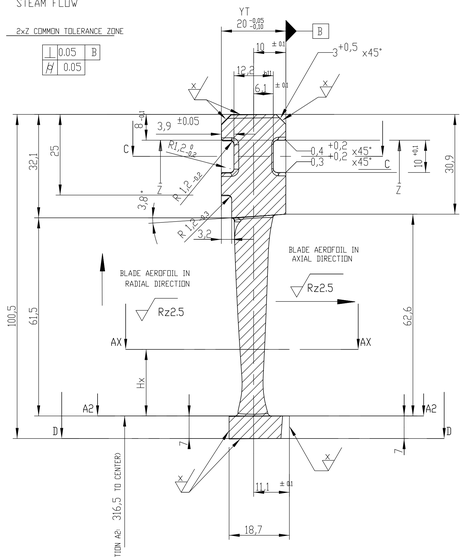
DRG. NO 0-105-18-62012 SH. 25 OF 27

SECTION B-B

DIRECTION OF STEAM FLOW

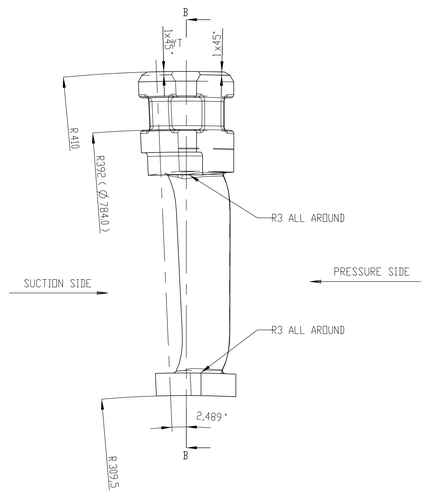
2xZ COMMON TOLERANCE ZONE

⊥	0.05	B
⫽	0.05	



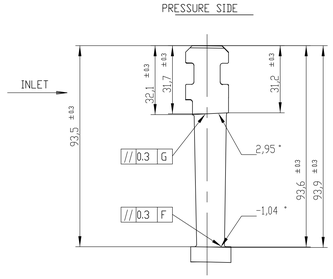
POS. NO.: 1

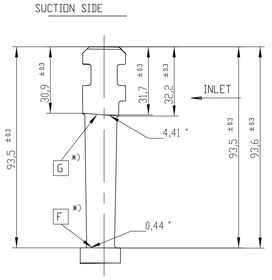
DESIGN 'RIGHT'



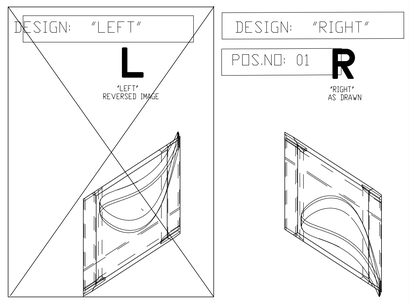
SCHEME FOR D AND S DIMENSIONS

*) REFERED TO ADJACENT BLADE





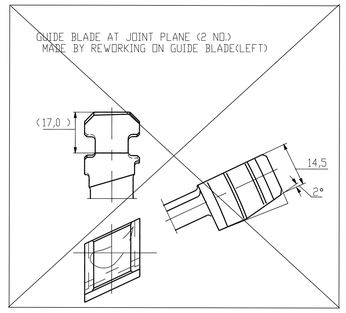
3.2 ALL OVER EXCEPT OTHERWISE STATED (x = Rz100 Rmax160 = 12.5 = Rz22.5 = 0.4 = Rz10 = 1.6)



SECTION AX	Hx	Lges	AMI	UMA	RHk	BBi	D
A1 - A1	-10.0	16.78	4.63	8.75	0.09	50.44	5.41
A2 - A2	0.0	17.33	4.83	3.46	0.09	50.11	5.59
A12-A12	10.0	17.89	5.03	1.21	0.10	49.79	5.76
A33-A33	31.0	19.05	5.44	2.14	0.10	49.12	6.14
A53-A53	51.0	20.16	5.83	3.13	0.11	48.48	6.50

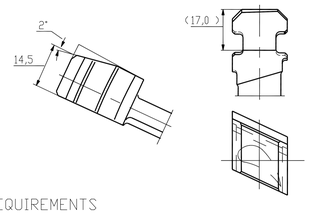
LOCAL SMALLEST RADIUS OF CURVATURE ON PRESSURE SIDE: 11.0 MM

BLADE SHOWN IN DIRECTION OF STEAM FLOW

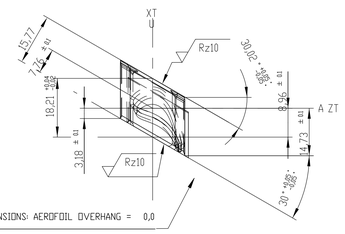


POS.NO : 02

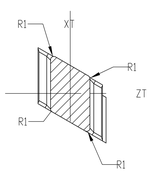
JOINT BLADE AT PARTING PLANE (2 NO.)
MADE BY REWORKING ON GUIDE BLADE(RIGHT)



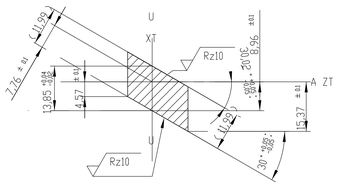
VIEW X



SECTION CC

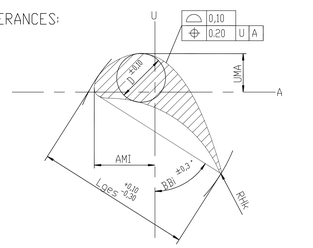


SECTION DD



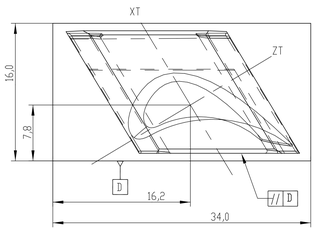
TECHNICAL REQUIREMENTS

1. TOLERANCES:

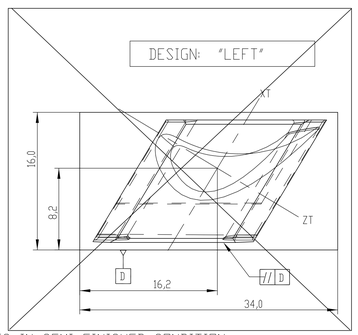


2. STRAK NUMBER: 80584
3. NUMBER OF BLADES/ROW: 142
(INCLUDING JOINT BLADES)

DESIGN: "RIGHT"



DESIGN: "LEFT"



CENTRE DISTANCES IN SEMI-FINISHED CONDITION

25(RIGHT) 25
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 THIRUMURTHY	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-TR101/063A2S

DRAWING NO. 0-105-18-62012 REV. 00
CARD CODE -
SHT. No 25 NO. OF SHT. 27

REV.	DATE	ALTERED	CHD/APPD
ZONE			

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GENERAL DIMENSIONAL LIMITS,FITS & TOLERANCES AS PER HY0230261

COMPUTER FILE NAME T-1124

REF. DRG. NO.

SIGN. AND DATE

INVENTORY NO

May Fri 15 11:40 2015

Printed by : P SHASHANK-FM2301 / 6115381 on 18-05-16 15:10:08

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