FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG. NO 0-105-18-62011 SH. 04 OF 21

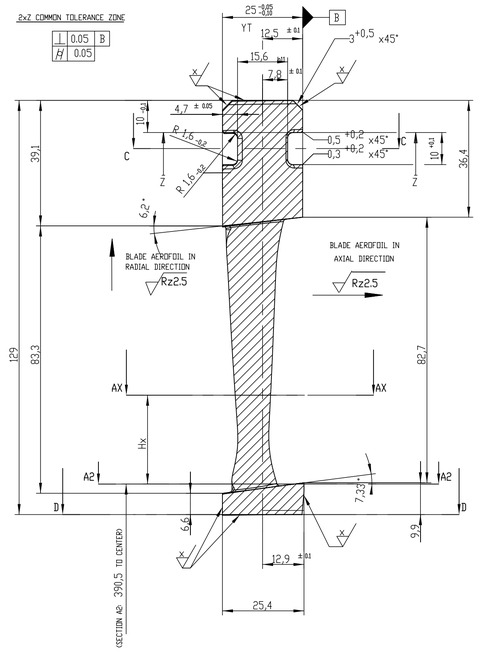
## SECTION B-B

DIRECTION OF STEAM FLOW

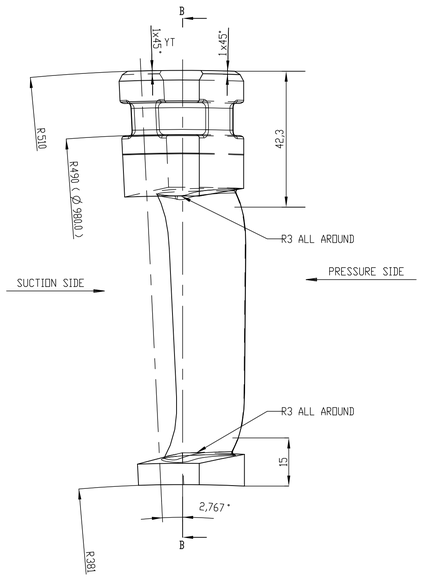
2xZ COMMON TOLERANCE ZONE

| | | |
|---|---|---|
| ⊥ | 0.05 | B |
| ⫽ | 0.05 | |

POS. NO.: 1

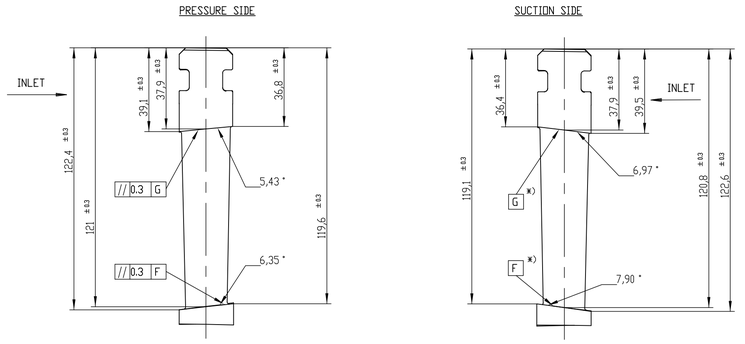



DESIGN "RIGHT"




## SCHEME FOR D AND S DIMENSIONS

*) REFERED TO ADJACENT BLADE

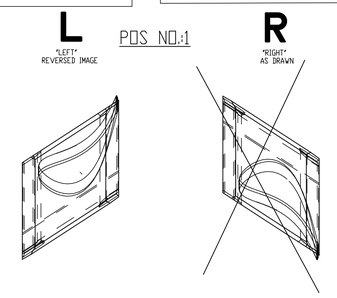



| SECTION AX | Hx | Lges | AMI | UMA | RHk | BBi | D |
|---|---|---|---|---|---|---|---|
| A1 - A1 | -10.0 | 24.66 | 9.33 | 10.42 | 0.13 | 52.49 | 7.95 |
| A2 - A2 | 0.0 | 25.28 | 9.55 | 5.13 | 0.14 | 52.24 | 8.15 |
| A6 - A6 | 12.0 | 26.04 | 9.83 | 1.93 | 0.14 | 51.96 | 8.39 |
| A16-A16 | 42.0 | 27.97 | 10.52 | 3.08 | 0.15 | 51.23 | 9.01 |
| A25-A25 | 69.0 | 29.75 | 11.16 | 4.57 | 0.16 | 50.58 | 9.59 |

LOCAL SMALLEST RADIUS OF CURVATURE ON PRESSURE SIDE: 16.2 MM

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

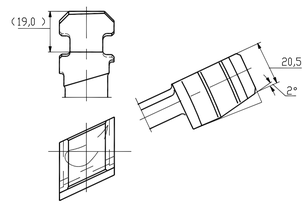
DESIGN: "LEFT" DESIGN: "RIGHT"



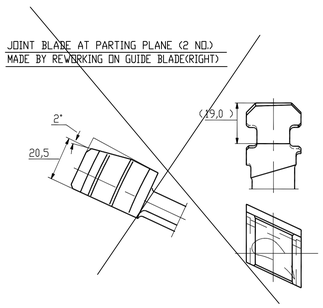

BLADE SHOWN IN DIRECTION OF STEAM FLOW

POS NO.:2

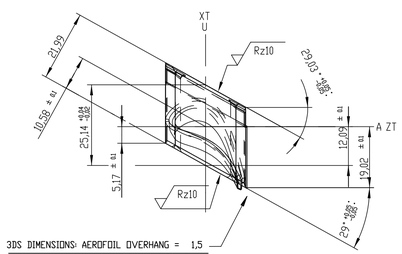
JOINT BLADE AT PARTING PLANE (2 NO.) MADE BY REWORKING ON GUIDE BLADE(LEFT)



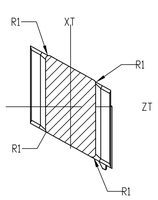

JOINT BLADE AT PARTING PLANE (2 NO.) MADE BY REWORKING ON GUIDE BLADE(RIGHT)



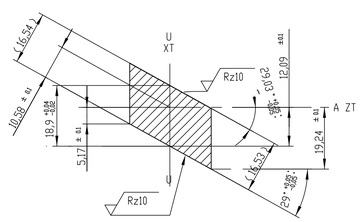

## VIEW X




## SECTION C-C

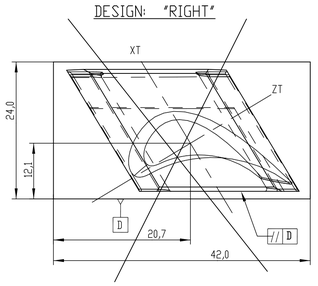



## SECTION D-D

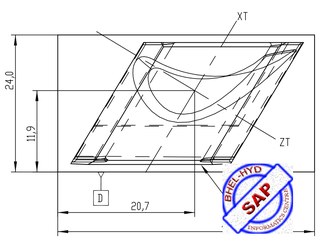



## CENTRE DISTANCES IN SEMI-FINISHED CONDITION

DESIGN: "RIGHT"

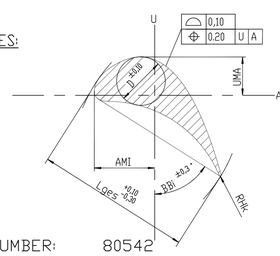



DESIGN: "LEFT"




## TECHNICAL REQUIREMENTS

1. TOLERANCES:




2. STRAK NUMBER: 80542
3. NUMBER OF BLADES/ROW: 128
(INCLUDING JOINT BLADES)

| | |
|---|---|
| 04(LEFT) | 04 |
| ROW NO. | VAR |

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LTD. HYDERABAD

| | NAME | SIGN. | DATE | NO.OF VAR. |
|---|---|---|---|---|
| DRN. | A HEMASUNDAR | | 29.12.2015 | |
| CHD. | K THIRUMURTHULU | | 29.12.2015 | -NA- |
| APPD. | T.S.PRABHAKAR | | 29.12.2015 | |

| DEPT | UNTOL. DIMS. GR. C/M/F | SCALE | WEIGHT (KG) | REF. TO ASSY. DRG. | ITEM NO. | NO.OF ITEMS |
|---|---|---|---|---|---|---|
| 17.0 | | NTS | 0,19 | -NA- | -NA- | -NA- |
| CODE 415 | | | | | | |

TITLE GUIDE BLADE - LEFT

CARD CODE: -

DRAWING NO. 0-105-18-62011 REV. 00

SHT. No 04 NO. OF SHT. 21

REV. | DATE | ALTERED | CHD/APPD | ZONE

S-105-S25-TR129/083B4M

GENERAL DIMENSIONAL LIMITS,FITS & TOLERANCES AS PER HY0230261

COMPUTER FILE NAME: T-1134

REF. DRG NO. —

SIGN AND DATE

INVENTORY NO

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Mar Tue 10 10:38 2015

Printed by : P SHASHANK-FM2301 / 6115381 on 18-05-16 10:33:05