FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

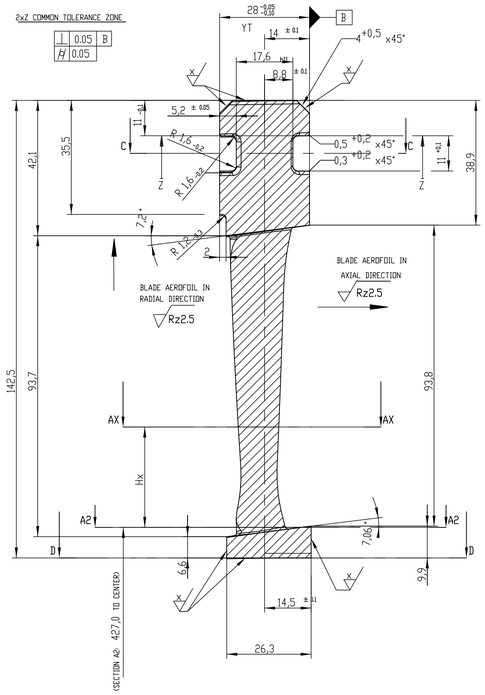
DRG. NO. 0-105-18-62011 SH. 08 OF 21

SECTION B-B

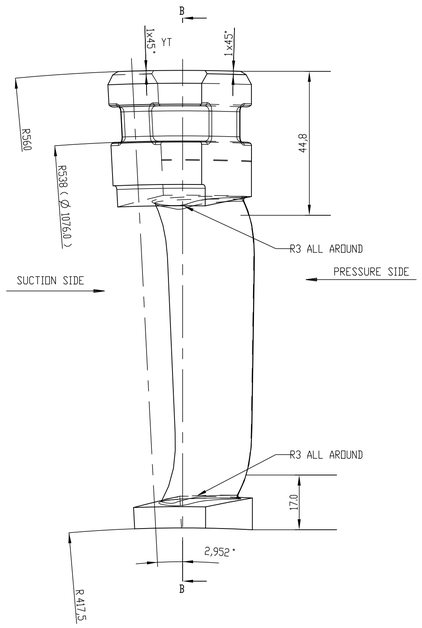
DIRECTION OF STEAM FLOW

2x2 COMMON TOLERANCE ZONE

POS. NO.: 1

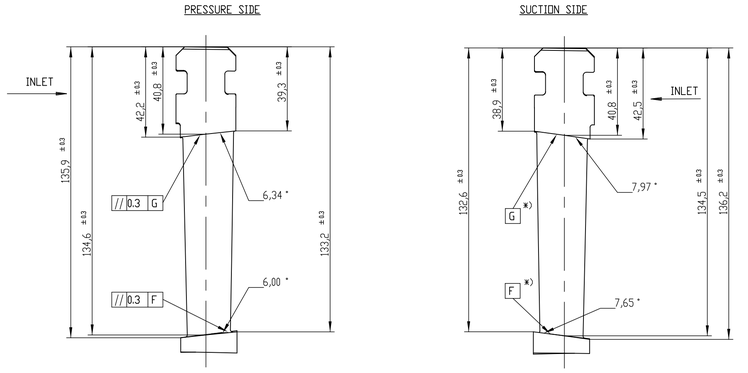


DESIGN "RIGHT"



SCHEME FOR D AND S DIMENSIONS

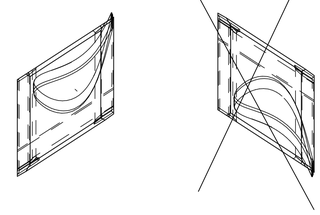
*) REFERED TO ADJACENT BLADE



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

DESIGN: "LEFT" DESIGN: "RIGHT"

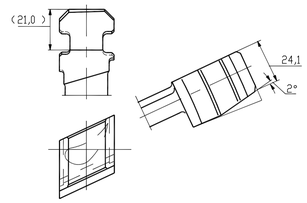
L "LEFT" REVERSED IMAGE — POS NO.:1 — R "RIGHT" AS DRAWN



POS NO.:2

BLADE SHOWN IN DIRECTION OF STEAM FLOW

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

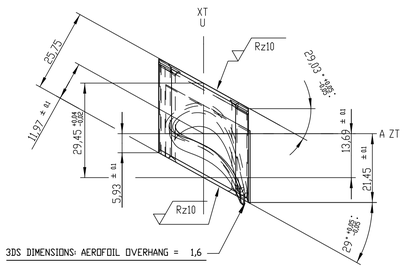


SECTION AX	Hx	Lges	AMI	UMA	RHk	BBi	D
A1 - A1	-10.0	26.86	8.53	11.28	0.14	49.22	8.66
A2 - A2	0.0	27.52	8.77	5.95	0.15	49.00	8.87
A6 - A6	12.0	28.32	9.05	2.48	0.15	48.75	9.13
A18-A18	48.0	30.65	9.87	3.56	0.16	47.98	9.88
A29-A29	81.0	32.73	10.59	5.36	0.17	47.25	10.55

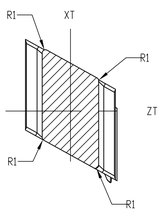
LOCAL SMALLEST RADIUS OF CURVATURE ON PRESSURE SIDE: 17.6 MM

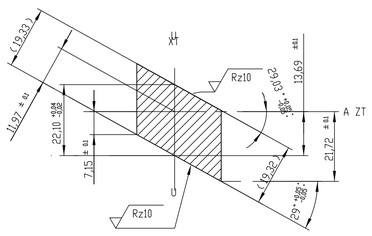
SECTION D-D

VIEW X



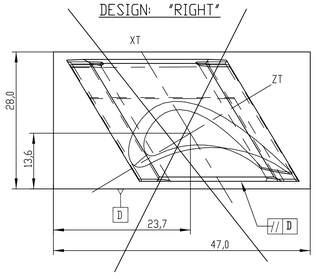
SECTION C-C



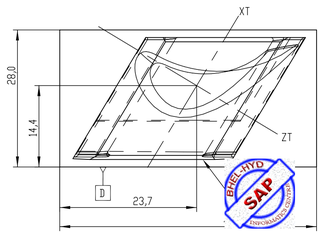


CENTRE DISTANCES IN SEMI-FINISHED CONDITION

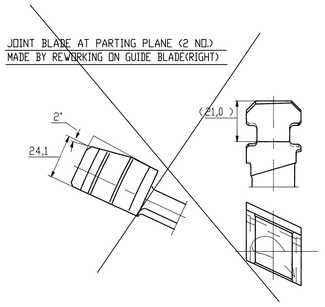
DESIGN: "RIGHT"



DESIGN: "LEFT"

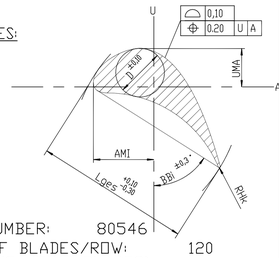


JOINT BLADE AT PARTING PLANE (2 NO.)
MADE BY REWORKING ON GUIDE BLADE(RIGHT)



TECHNICAL REQUIREMENTS

1. TOLERANCES:



2. STRAK NUMBER: 80546
3. NUMBER OF BLADES/ROW: 120
(INCLUDING JOINT BLADES)

08(LEFT)	08
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		19.03.2015	-NA-
CHD.	K THRIMURTHULU		19.03.2015	
APPD.	T.S.PRABHAKAR		19.03.2015	

DEPT	UNTOL. DIMS. OR	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM NO.	NO.OF ITEMS
CODE 415	C/M/F	NTS	0,39	-NA-	-NA-	-NA-

TITLE: GUIDE BLADE - LEFT

CARD CODE: -

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

SHT. No 08 NO. OF SHT. 21

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

S-135-328-TR143/094B2M

COMPUTER FILE NAME: T-1134

REF. DRG NO.

SIGN AND DATE

INVENTORY NO

GENERAL DIMENSIONAL LIMITS,FITS & TOLERANCES AS PER HY0230261

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Mar Tue 10 10:40 2015

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