

INVENTORY NO. S-135-528-TR148/09982M S-135-528-TR148/09982M 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 COMPANY.

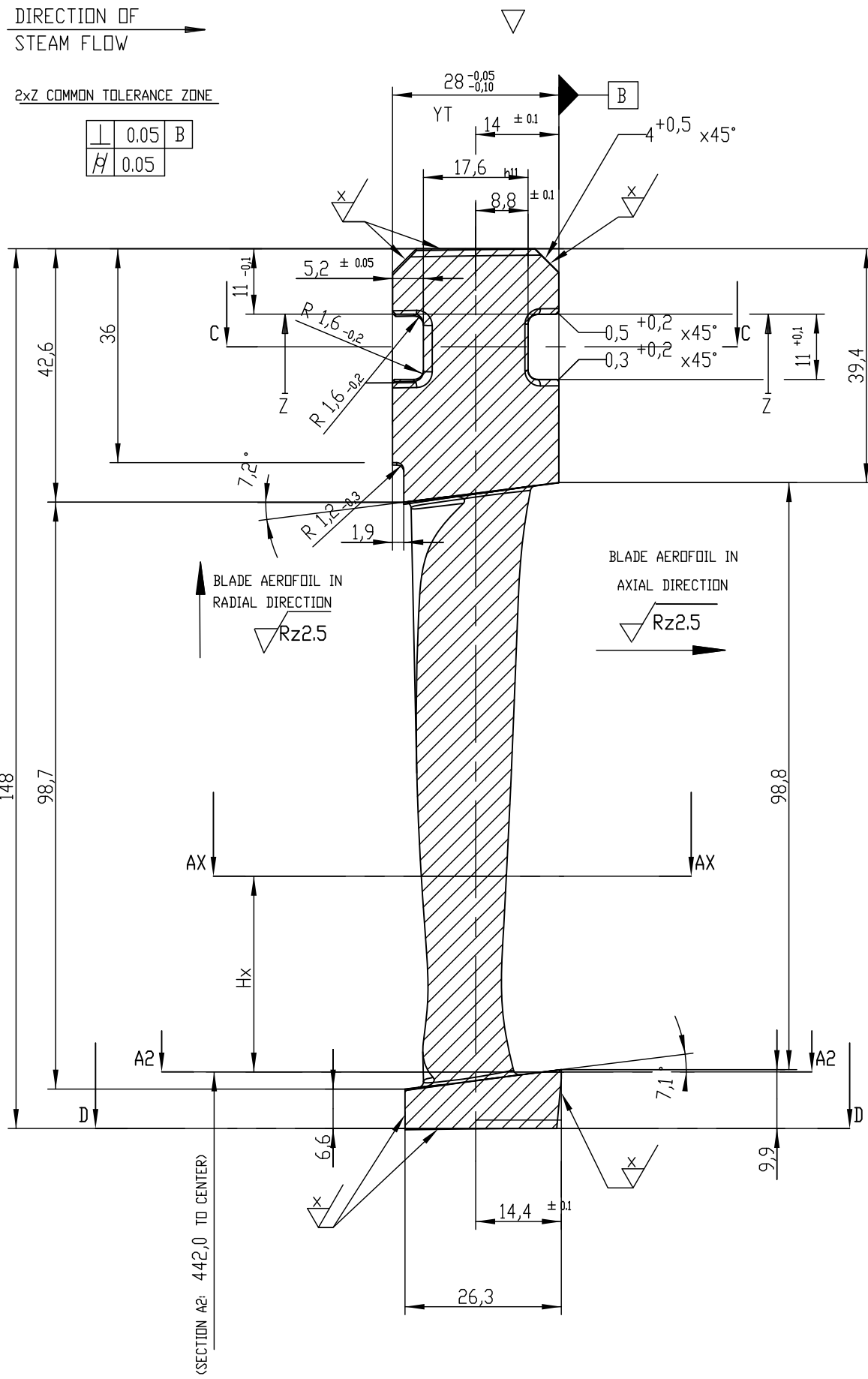
GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261

FIRST ANGLE PROJECTION

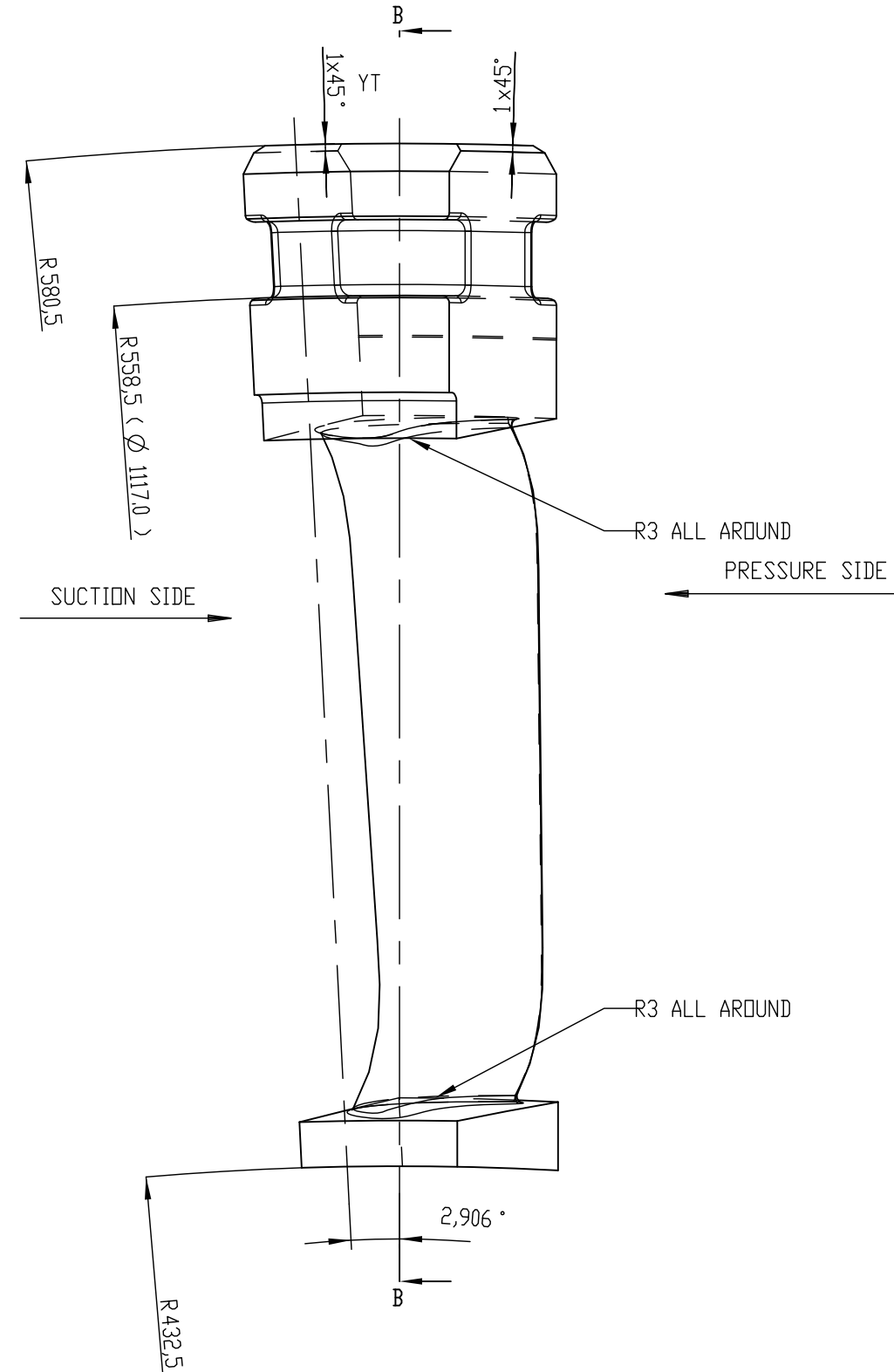
11029-81-501-0

(ALL DIMENSIONS ARE IN mm)

SECTION B-B

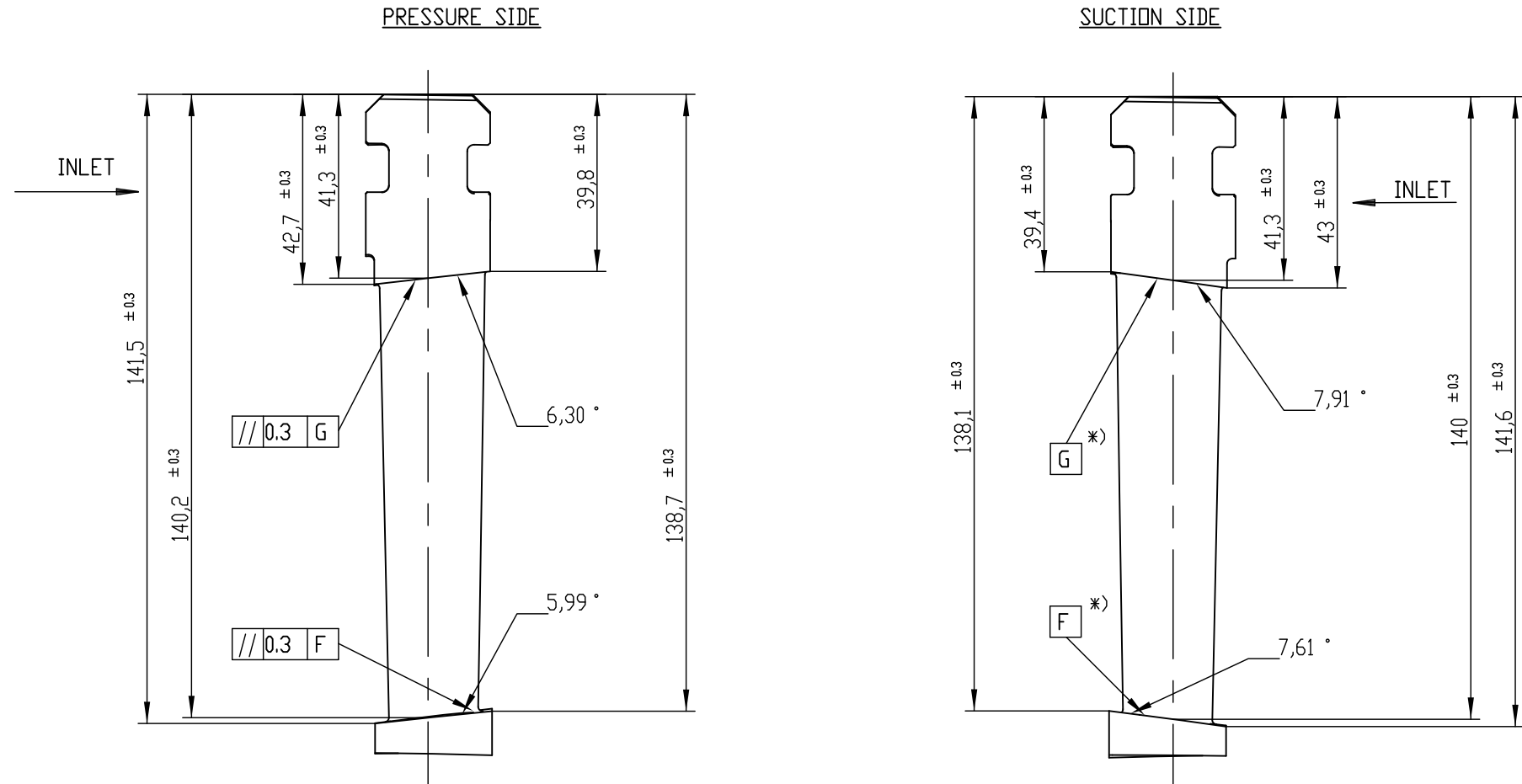


DESIGN 'RIGHT'



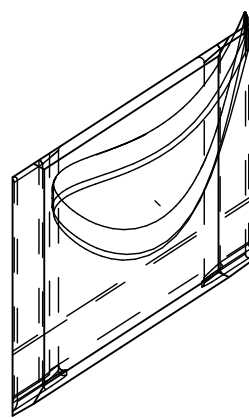
SCHEME FOR D AND S DIMENSIONS

\*) REFERED TO ADJACENT BLADE



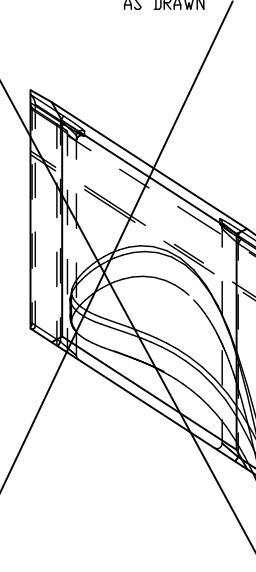
DESIGN: 'LEFT'

POS NO:1



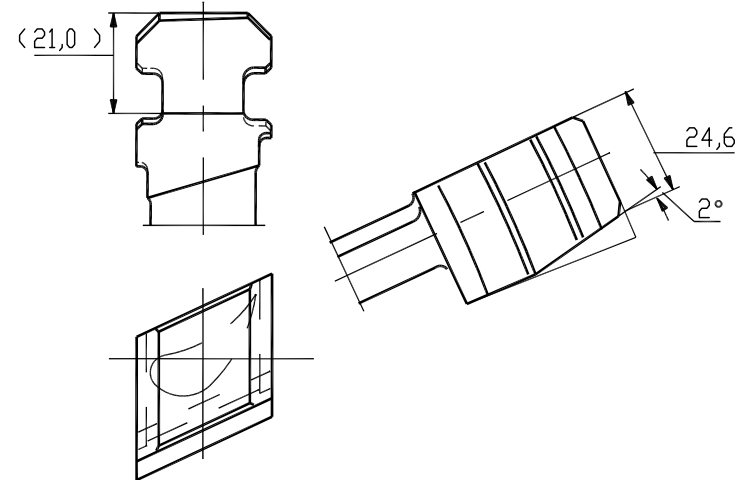
DESIGN: 'RIGHT'

POS NO:1



POS NO:2

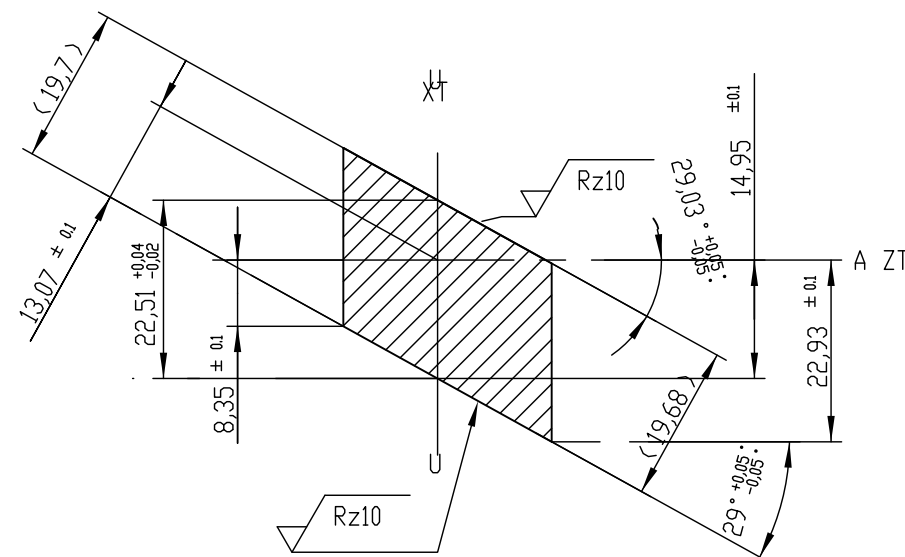
BLADE SHOWN IN DIRECTION OF STEAM FLOW  
JOINT BLADE AT PARTING PLANE (2 NO.)  
MADE BY REWORKING ON GUIDE BLADE(LEFT)



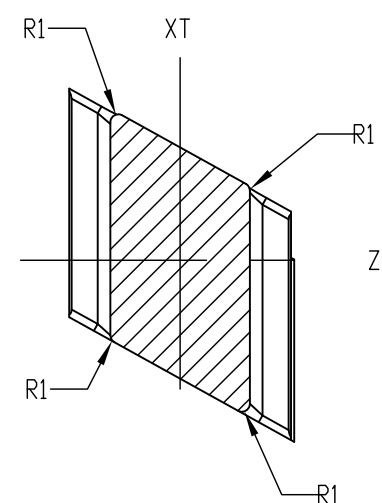
SECTION AX	Hx	Lges	AMI	UMA	RHk	BBI	D
A1 - A1	-10.0	26.80	8.60	11.24	0.14	49.14	8.64
A2 - A2	0.0	27.42	8.83	6.14	0.15	48.94	8.84
A6 - A6	12.0	28.16	9.09	2.95	0.15	48.71	9.08
A19-A19	51.0	30.57	9.94	5.09	0.16	47.91	9.85
A30-A30	84.0	32.61	10.64	7.50	0.17	47.22	10.51

LOCAL SMALLEST RADIUS OF CURVATURE ON PRESSURE SIDE: 17.6 MM

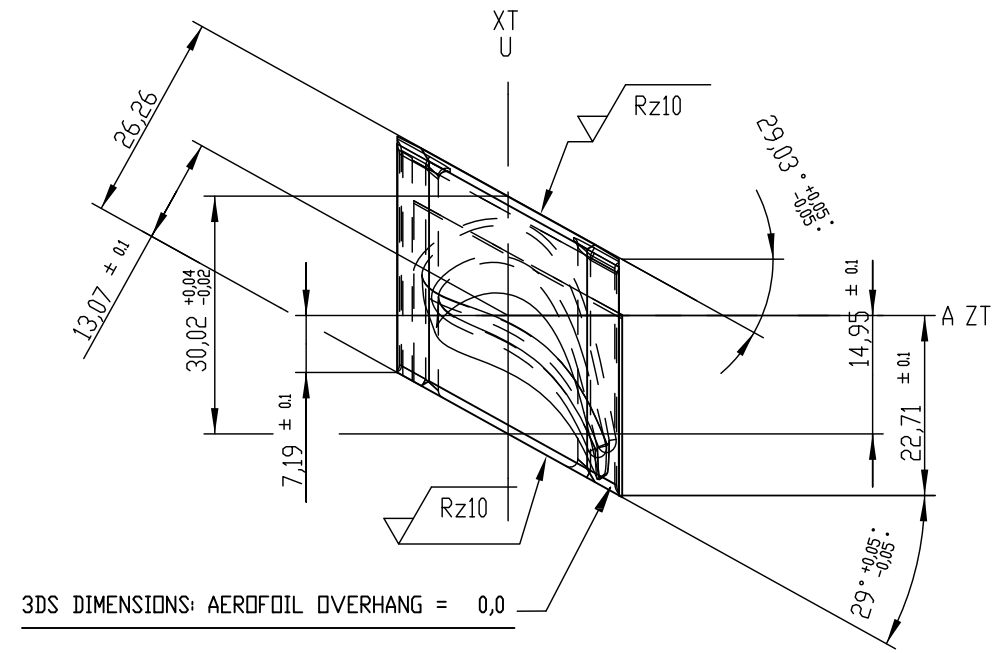
SECTION D-D



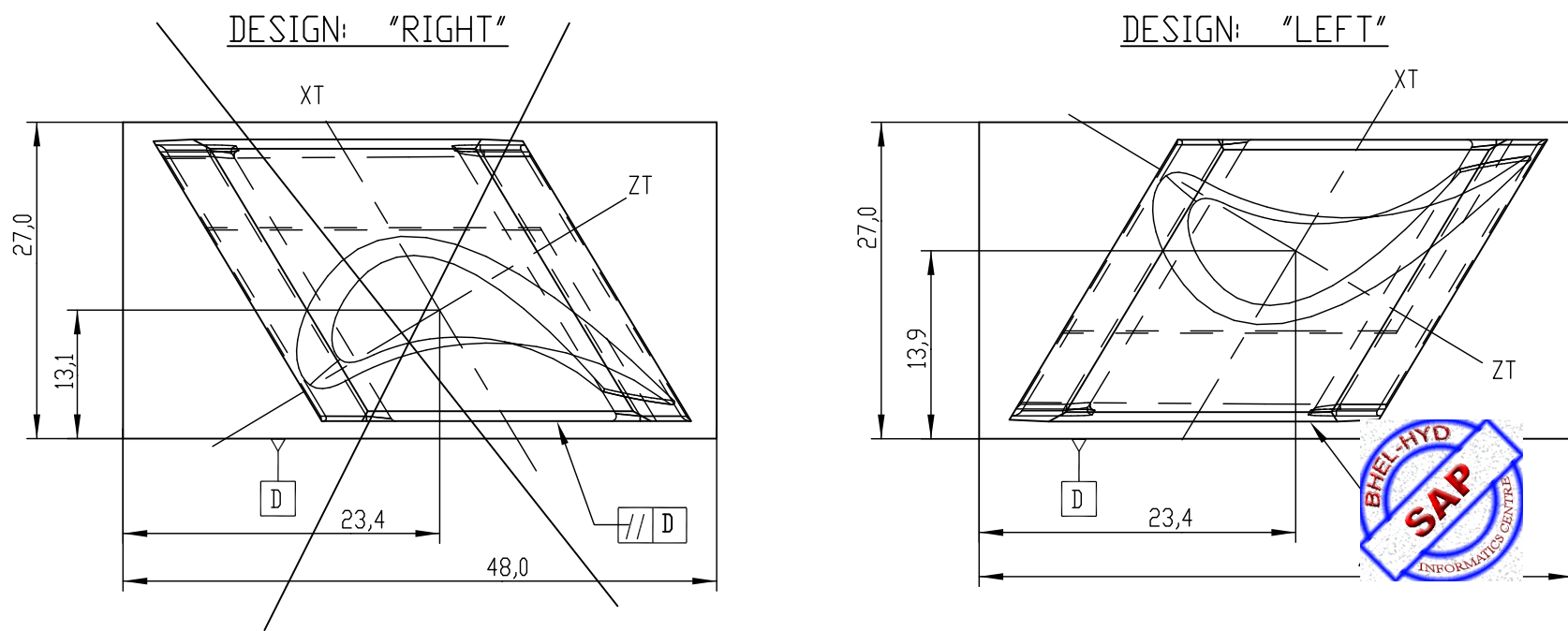
SECTION C-C



VIEW X

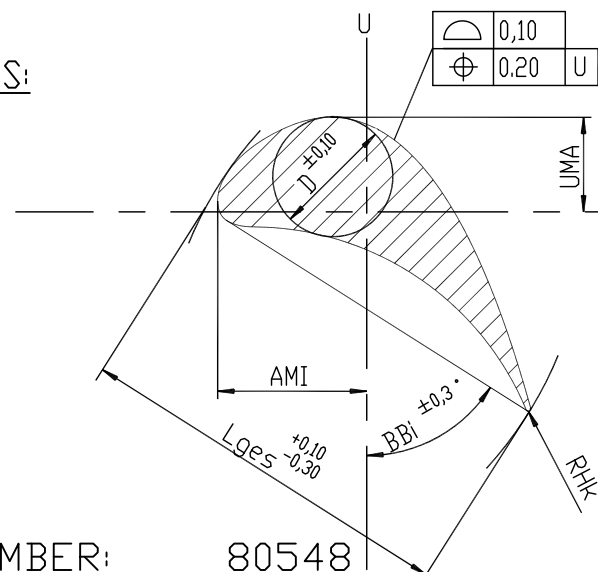


CENTRE DISTANCES IN SEMI-FINISHED CONDITION



TECHNICAL REQUIREMENTS

1. TOLERANCES:



2. STRAK NUMBER: 80548  
3. NUMBER OF BLADES/ROW: 122  
(INCLUDING JOINT BLADES)

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		NAME		SIGN.	DATE	IND OF VAR.
BHARAT HEAVY ELECTRICALS LTD.		A. HEMASUNDAR			09/02/2005	
HYDERABAD		K. THIRUMATHULU			09/02/2005	-NA-
		T.S. PRABHAKAR			09/02/2005	
REPT. LTB	UNITS. BINS. OR C/M/F	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM NO.	IND OF VAR.
1:1	1:1	1:1	0.27	-NA-	-NA-	
TITLE: GUIDE BLADE - LEFT						REV. 00
DRAWING NO. 0-105-18-62011						
SHT. No 10						ND OF SHT. 21