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GENERAL DIMENSIONAL LIMITS,FITS & TOLERANCES AS PER HY0230261

COMPUTER FILE NAME T-1161

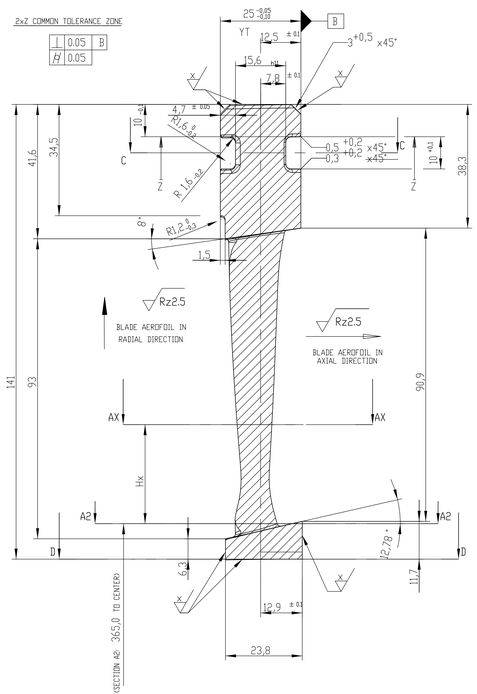
STGN. AND DATE | REF. DRG. NO. | INVENTORY NO.

SECTION B-B

DIRECTION OF STEAM FLOW

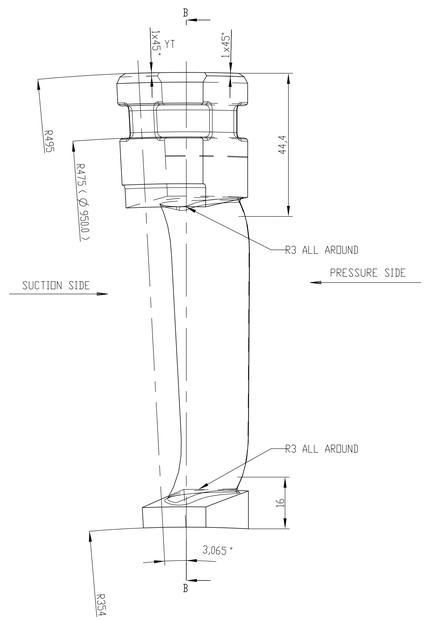
2xZ COMMEN TOLERANCE ZONE

⊥ 0.05	B
⌭ 0.05	



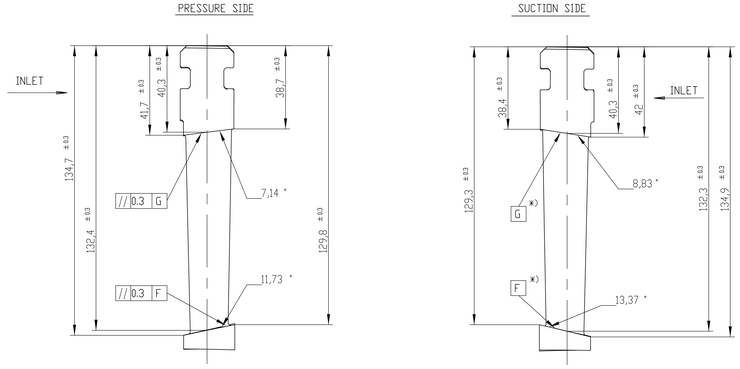
POS. NO.: 01

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	23.38	7.64	9.89	0.13	49.25	7.53
A2 - A2	0.0	24.06	7.89	4.65	0.13	49.02	7.75
A6 - A6	12.0	24.87	8.18	1.59	0.13	48.76	8.02
A17-A17	45.0	27.07	8.95	3.07	0.14	48.04	8.72
A28-A28	78.0	29.21	9.71	4.99	0.16	47.32	9.41

LOCAL SMALLEST RADIUS OF CURVATURE ON PRESSURE SIDE: 15.3 MM

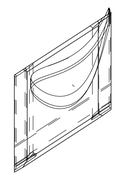
ALL OVER EXCEPT OTHERWISE STATED (X = Rz100 Rmax160 = 12.5 = Rz2.5 = 0.4 = Rz10 = 1.6)

DESIGN: "LEFT"

POS.NO: 01

L

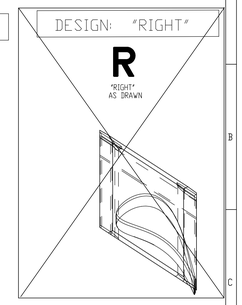
"LEFT" REVERSED IMAGE



DESIGN: "RIGHT"

R

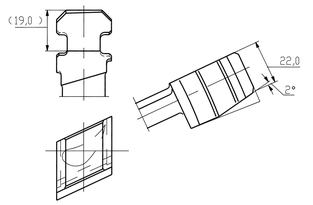
"RIGHT" AS DRAWN



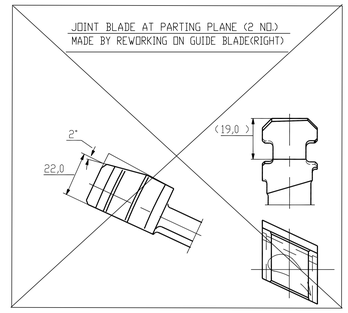
BLADE SHOWN IN DIRECTION OF STEAM FLOW

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

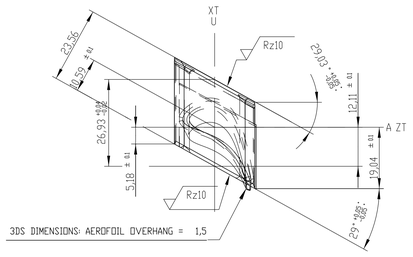
POS.NO : 02



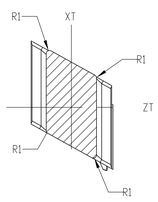
JOINT BLADE AT PARTING PLANE (2 NO.) MADE BY REWORKING ON GUIDE BLADE(RIGHT)



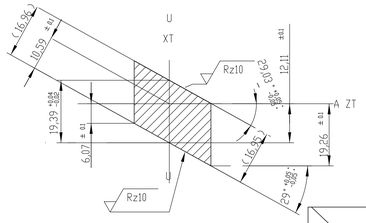
VIEW X



SECTION CC



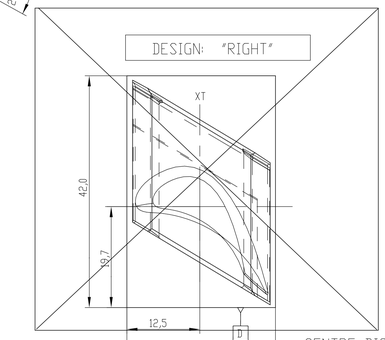
SECTION DD



RAW PART IN POSITION OF CENTERING (WITHOUT SCALE)
(RELATED TO MINIMAL DIMENSIONS)

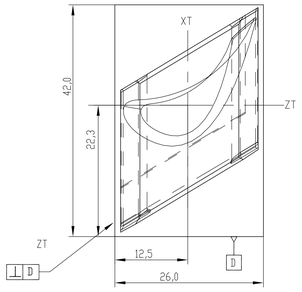
AUSFUEHRUNG 02 "R"
DESIGN 02 'R'

DESIGN: "RIGHT"



AUSFUEHRUNG 01 "L"
DESIGN 01 'L'

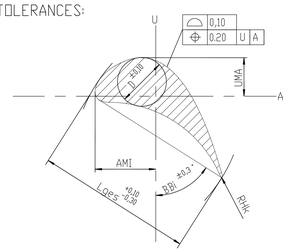
DESIGN: "LEFT"



CENTRE DISTANCES IN SEMI-FINISHED CONDITION

TECHNICAL REQUIREMENTS

1. TOLERANCES:



2. STRAK NUMBER: 80716
3. NUMBER OF BLADES/ROW: 116 (INCLUDING JOINT BLADES)

26(LEFT)	26
ROW NO.	VAR

TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LTD. HYDERABAD

	NAME	DATE	NO.OF VAR.
DRN.	A HEMASUNDAR	22.12.2016	
CHD.	K THRIMURTHULU	22.12.2016	-NA-
APPD.	T.S.PRABHAKAR	22.12.2016	

DEPT.	UNITOL DIMS. OR C/M/F	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM NO.	NO.OF ITEMS
113		NTS	0,315	-NA-	-NA-	-NA-
CODE 413						

TITLE: GUIDE BLADE - LEFT
S-135-S25-TR141/092C2L

CAGE CODE: -

DRAWING NO. 0-301-75-00016 REV. 00

SHT. No 26 NO. OF SHT. 41

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

Mar Thu 24 13:59 2016

Printed by : P SHASHANK-FM2301 / 6115381 on 18-05-16 16:27:29

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