FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

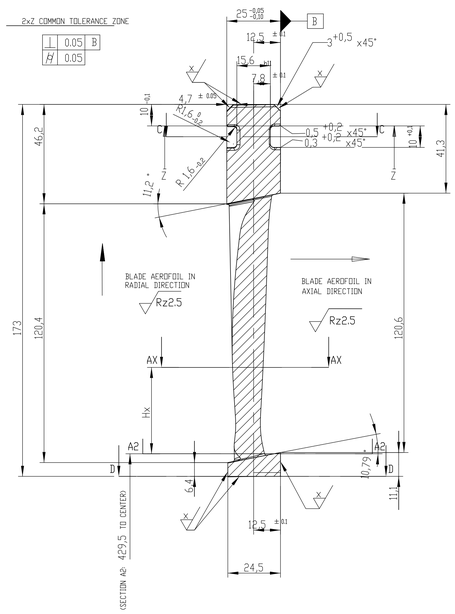
DRG. NO 0-301-75-00016 SH. 32 OF 41

SECTION B-B

DIRECTION OF STEAM FLOW

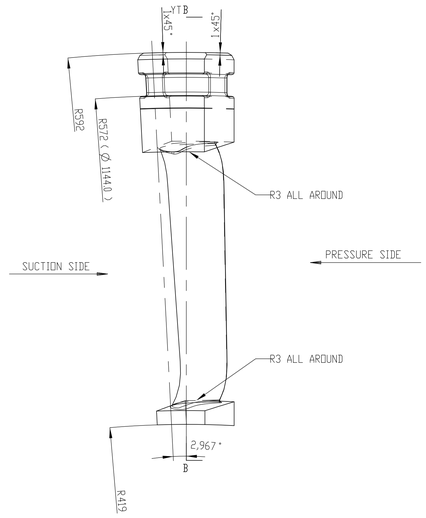
2x2 COMMON TOLERANCE ZONE

⊥	0.05	B
⫽	0.05	



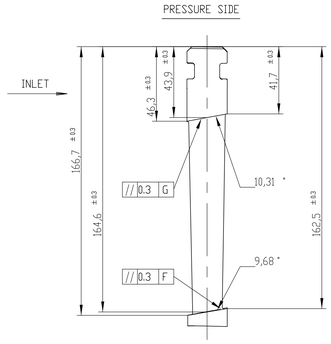
POS. NO.: 01

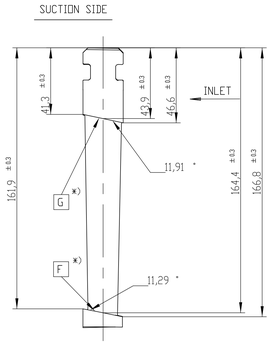
DESIGN "RIGHT"



SCHEME FOR D AND S DIMENSIONS

*) REFERED TO ADJACENT BLADE





SECTION AX	Hx	Lges	AMI	UMA	RHk	BBi	D
A1 - A1	-10.0	24.59	8.78	10.81	0.13	48.85	7.92
A2 - A2	0.0	25.18	8.99	5.74	0.13	48.68	8.11
A6 - A6	12.0	25.89	9.24	2.74	0.14	48.49	8.34
A22-A22	60.0	28.72	10.24	5.74	0.15	47.69	9.26
A37-A37	105.0	31.37	11.17	8.99	0.16	46.93	10.11

LOCAL SMALLEST RADIUS OF CURVATURE ON PRESSURE SIDE: 16.1 MM

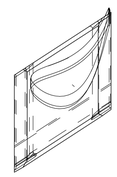
3.2 ALL OVER EXCEPT OTHERWISE STATED (x = Rz100 Rmax160 = 12.5 = Rz2.5 = 0.4 = Rz10 = 1.6)

DESIGN: "LEFT"

POS.NO: 01

L

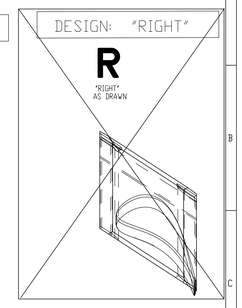
"LEFT" REVERSED IMAGE



DESIGN: "RIGHT"

R

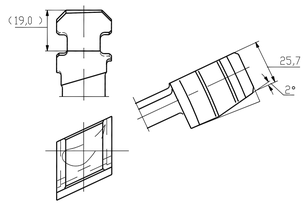
"RIGHT" AS DRAWN



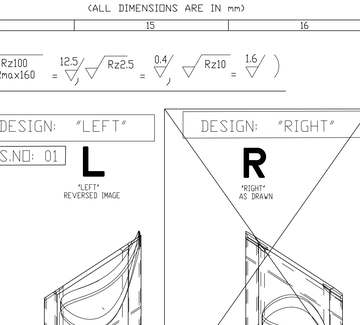
BLADE SHOWN IN DIRECTION OF STEAM FLOW

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

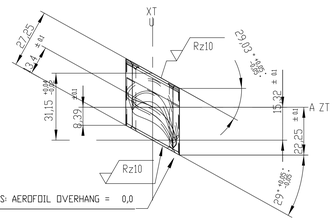
POS.NO : 02



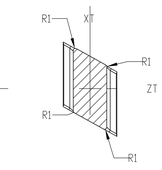
JOINT BLADE AT PARTING PLANE (2 NO.)
MADE BY REWORKING ON GUIDE BLADE(RIGHT)



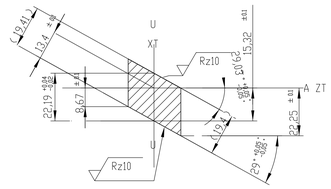
VIEW X



SECTION CC



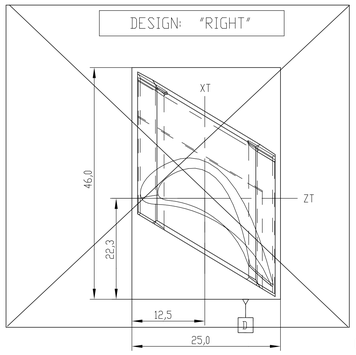
SECTION DD



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

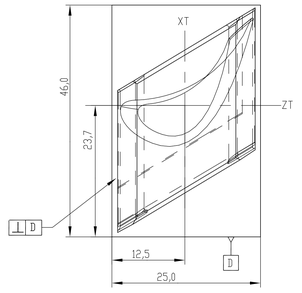
AUSFUEHRUNG 02 "R"
DESIGN 02 "R"

DESIGN: "RIGHT"



AUSFUEHRUNG 01 "L"
DESIGN 01 "L"

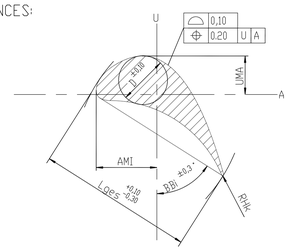
DESIGN: "LEFT"



CENTRE DISTANCES IN SEMI-FINISHED CONDITION

TECHNICAL REQUIREMENTS

1. TOLERANCES:



2. STRAK NUMBER: 80722
3. NUMBER OF BLADES/ROW: 120
(INCLUDING JOINT BLADES)

32(LEFT)	32
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		22.12.2016	
CHD.	K THRIMURTHULU		22.12.2016	-NA-
APPD.	T.S.PRABHAKAR		22.12.2016	

DEPT.	UNTOL. DIMS. OR C/M/F	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM NO.	NO.OF ITEMS
CODE 413	±1.0	NTS	0,421	-NA-	-NA-	-NA-

TITLE GUIDE BLADE - LEFT
S-135-S25-TR173/121C2L

CAGE CODE -

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

SHT. No 32 NO. OF SHT. 41

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

GENERAL DIMENSIONAL LIMITS,FITS & TOLERANCES AS PER HY02302161

COMPUTER FILE NAME T-1161

STDA. AND DATE

REF. DRG. NO.

INVENTORY NO.

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Mar Thu 24 14:02 2016

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