FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG. NO 0-301-75-00016 SH. 40 OF 41

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

SECTION B-B

DIRECTION OF STEAM FLOW

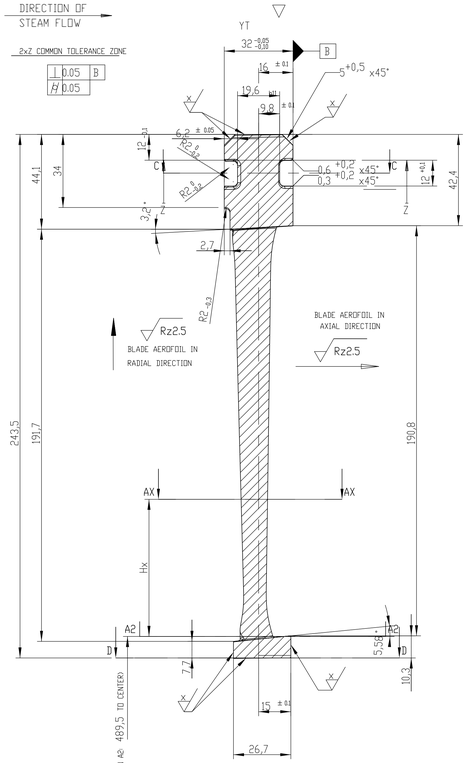
2xZ COMMON TOLERANCE ZONE

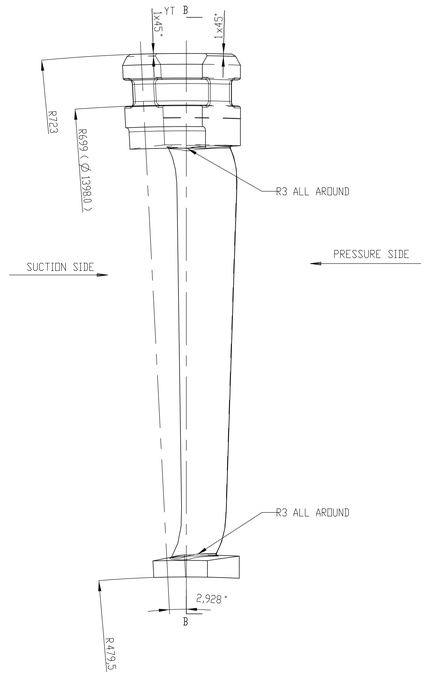
⊥ 0.05 B

⫽ 0.05

POS. NO.: 01

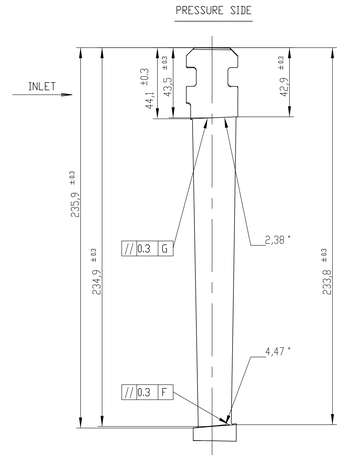
DESIGN "RIGHT"

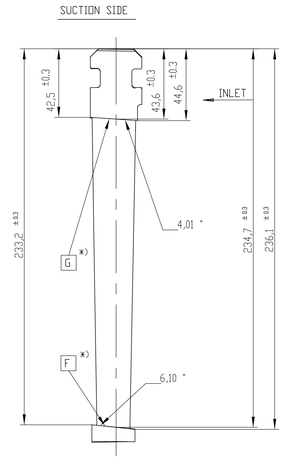




SCHEME FOR D AND S DIMENSIONS

*) REFERED TO ADJACENT BLADE





SECTION AX	Hx	Lges	AMI	UMA	RHk	BBi	D
A1 - A1	-10.0	25.17	8.39	12.06	0.13	55.20	8.11
A2 - A2	0.0	25.69	8.58	6.42	0.14	55.00	8.28
A6 - A6	12.0	26.31	8.81	2.58	0.14	54.78	8.48
A34-A34	96.0	30.71	10.42	3.26	0.16	53.13	9.90
A61-A61	177.0	35.03	11.95	4.71	0.17	51.50	11.29

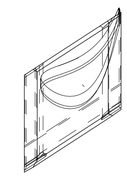
LOCAL SMALLEST RADIUS OF CURVATURE ON PRESSURE SIDE: 16.5 MM

DESIGN: "LEFT"

POS.NO: 01

L

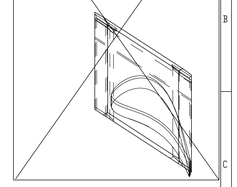
"LEFT" REVERSED IMAGE



DESIGN: "RIGHT"

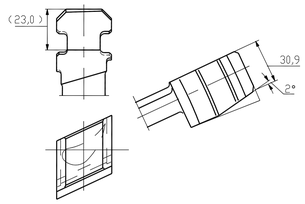
R

"RIGHT" AS DRAWN

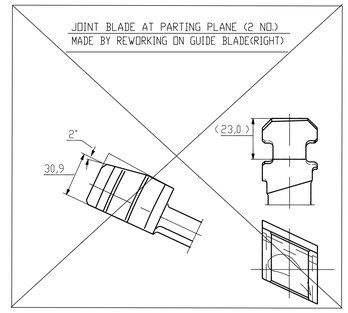


BLADE SHOWN IN DIRECTION OF STEAM FLOW
GUIDE BLADE AT JOINT PLANE (2 NO.)
MADE BY REWORKING ON GUIDE BLADE(LEFT)

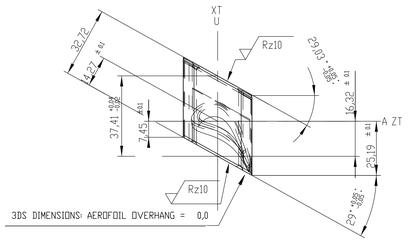
POS.NO : 02



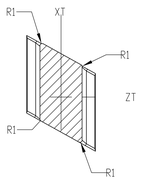
JOINT BLADE AT PARTING PLANE (2 NO.)
MADE BY REWORKING ON GUIDE BLADE(RIGHT)



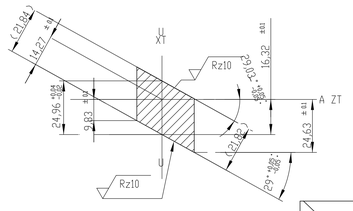
VIEW X



SECTION CC

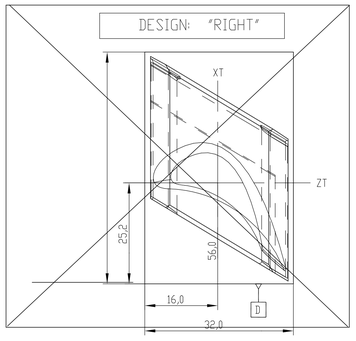


SECTION DD

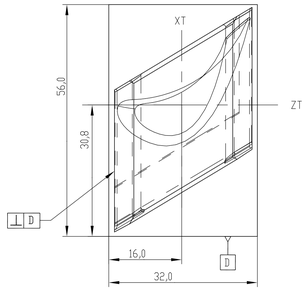


RAW PART IN POSITION OF CENTERING (WITHOUT SCALE)
(RELATED TO MINIMAL DIMENSIONS)

DESIGN: "RIGHT"



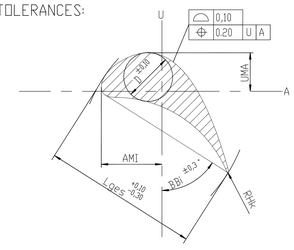
DESIGN: "LEFT"



CENTRE DISTANCES IN SEMI-FINISHED CONDITION

TECHNICAL REQUIREMENTS

1. TOLERANCES:



2. STRAK NUMBER: 80730
3. NUMBER OF BLADES/ROW: 122
(INCLUDING JOINT BLADES)

40(LEFT)	40
ROW NO.	VAR

TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LTD
HYDERABAD

	NAME	DATE	NO.OF VAR.
DRN.	A HEMASUNDAR	22/02/16	
CHD.	K THIRUMURTHY	22/02/16	-NA-
APPD.	T.S.PRABHAKAR	22/02/16	

DEPT.	UNTOL. DIMS.	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM NO.	NO.OF ITEMS
CODE 415	GR C/M/F	NTS	0,66	-NA-	-NA-	-NA-

TITLE: GUIDE BLADE - LEFT
S-135-S32-TR244/191E2S

CARD CODE -

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

SHT. No 40 NO. OF SHT. 41

REV.	DATE	ALTERED	CHD/APPD	ZONE

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GENERAL DIMENSIONAL LIMITS,FITS & TOLERANCES AS PER HY0230261

COMPUTER FILE NAME: T-1161

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