



**FINAL INSPECTION REPORT OF F/3DS
MOVING BLADES**

QA / IDT / 263

SHEET No. 01 OF 02

Profile: .		Customer:		W.O. No. :	
Stage No.		Part No. :		Material Spec:	
Drg. No.:		GR No.:		Heat No.:	
PO/SCO No.&Date:		SMIV/PPMIV No.&Date:		Flat Size:	
No. of blades Inspected:			Nos.	No. of blades Accpeted:	
Subcontractor Name:					

SL.NO.	CHARACTERISTIC		DRG. VALUES	MEASURED VALUES		
				Blade No. 1	Blade No. 2	Blade No. 3
01.	BLADE PROFILE GAP T NO.	ROOT SIDE	MAX 0.1 GAP			
		MIDDLE				
		SHD SIDE				
02.	PROFILE THICKNESS AT THREE SECTIONS	ROOT SIDE				
		MIDDLE				
		SHD SIDE				
03.	PROFILE WIDTH AT THREE SECTIONS	ROOT SIDE				
		MIDDLE				
		SHD SIDE				
04.	PROFILE HEIGHT AT THREE SECTIONS	ROOT SIDE				
		MIDDLE				
		SHD SIDE				
05.	PITCH	ROOT				
		SHROUD				
06.	TAPER EX	EY	0.03 (MAX)			
07.	ROOT GROOVE					
08.	CANAL LENGTH CONCAVE	I/L MID				
09.	CANAL LENGTH CONVEX	I/L O/L				
10.	ROOT LENGTH CONCAVE	I/L MID				
11.	ROOT LENGTH CONVEX	I/L O/L				
12.	RADII & CHAMFERS					
13.	ROOT WIDTH					
14.	NECK WIDTH					
15.	TOTAL LENGTH					
16.	FOOT DIMENSION	I/L O/L				
17.	ROOT PARALLELITY					
18.	ROOT RADIALITY					
19.	GUIDE	OUTLET				
		INLET				

INSPECTED BY:	SIGNATURE:	DATE:	CUSTOMER / 3rd Party : Inspector Sign.&Date
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**FINAL INSPECTION REPORT OF F/3DS MOVING
BLADES**

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SHEET No. 02 OF 02

SL.NO.	CHARACTERISTIC	DRG. VALUES	MEASURED VALUES		
			Blade No. 1	Blade No. 2	Blade No. 3
20.	RHOMBOID ANGLE				
21.	VISUAL: PLACE THE BLADES ONE AFTER ANOTHER IN ARCS AND ENSURE FOLLOWING				
21.A.	MATCHING OF WIDTH MILLING STEP. I/L-O/L				
21.B.	PROFILE DEPTH AT SHROUD O/L				
21.C.	MATCHING OF CANAL NEAR ROOT O/L				
21.D.	MATCHING OF CANAL NEAR ROOT I/L				
21.E.	MATCHING OF CANAL NEAR SHROUD I/L-O/L				
21.F.	BEND OF THE BLADE				
21.G.	SMOOTH CORNER RADII AT ROOT RADIUS TRANSITION				
21.H.	SMOOTH RADII AT PROFILE TRANSITIONS AT ROOT / SHROUD / CHANNEL / BACK				
21.I.	MATCHING OF TOTAL LENGTH				
21.J.	ROUNDING OF OUTLET EDGES				
21.K.	NO SCRATCH / DENTS ON PROFILE				
21.L.	HAND OF THE BLADE (LEFT/RIGHT)				
22.	SURFACE FINISH				
23.	CALIBRATION OF MEASURING INSTRUMENTS USED				
24.	REMARKS				

LOCK BLADE

DRAWING NO.:

1.	ROOT WIDTH				
2.	WEIGHT REDUCTION HOLE / SLOT				
3.	PITCH ROOT SHROUD				
4.	TAPER PIN HOLE DRILLING				
5.	OTHER DIMENSIONS				
6.	REMARKS				

ORDERED QUANTITY:

BLADES ARE ACCEPTED
QUANTITY RELEASED FOR ASSLY:

ASSEMBLY QUANTITY:

INSPECTED BY:

SIGNATURE:

DATE:

CUSTOMER / 3rd Party :
Inspector Sign.&Date