(ALL DIMENSIONS ARE IN mm) THIRD ANGLE PROJECTION CH. 01 OF 02 DRG. NO. 0-351-09-61009 NOTES 1. APPLIED PRACTICE PER ITEM 1. 2. WITH FLOATING SEALS (PART 2 AND PART 3) VIBRO-PEEN PER ITEM 4 IN PLACE, MINIMUM RADIAL SEAL TRAVEL SHALL ASSY DWG NO., REV LTR, BE 0.08MIN. GROUP NO., VÉNDOR CODÉ, SERIAL NO. & MANF DATE. 3. FLOATING SEALS (PART 4 AND PART 5) MUST BE BHEL MONOGRAM IN A Ø19.0 LOADED TO THE FORWARD POSITION PRIOR TO CHECKING CIRCLE, LOW STRESS METAL 1,5 /6,4-180° COL BF FIG F-1 THE2.8 DIMENSION. STAMP PER ITEM 4, $\sqrt{0.18 \pm 0.07}$ 4. THERMAL BARRIER COATING TO BE APPLIED PER ITEM 3, CLASS B, AFTER FINAL WELDING, MACHINING, AND HEAT TREATING CYCLE. TBC SHOULD BE APPLIED TO DIMENSIONS SHOWN IN SECT E-7 (SH 2). THICKNESS 0.36±0.09 5. "WEAR COAT" ID OF TRANSITION PIECE PER ITEM 6 AS SHOWN IN SECTION E-7 (SHT 2). 6. CTQ PER ITEM 1, PARAGRAPH 6.13, AND ITEM 7. 7. PROCESSING AND INSPECTION SHALL BE IN ACCORDANCE WITH ITEM 5. 8. DIMENSION "H" & "W" ARE USED TO DETERMINE THE INTERSECTION OF DATUM PLANES F-3 🛶 B, C & PITCH CENTERLINE. 9. ASSEMBLE PARTS 7, 8, 9, 10,11, 12 & 13 (AFT BRACKET, SPACER, BUSHING, BOLT, NUT, WASHER & BELLEVILLE SPRING WASHERS) AS E-7 E-7 SHOWN IN SECT F-3. BELLEVILLE SPRING WASHERS (PART 13) MUST BE ORIENTED WITH CONCAVE SURFACES FACING EACH OTHER TO ENSURE FWD PROPER LOAD ON JOINT.
TORQUE PART 11 (NUT) TO [203,4±2,7 Nm]. 10. WELD PER ITEM 2. AFTER WELDING PT 6 (SIDE RAIL PROTECTOR), THE SIDE SEAL SLOT OPENING MUST BE NO LESS THAN 2.44 WIDE TO A MINIMUM DEPTH OF 8.9 ALONG THE ENTIRE LENGTH. REMOVAL OF MATERIAL SECTION F-3(G-5) 2 PLACES SEE NOTE 9 FROM THE FORWARD SURFACE OF THE SLOT IS PERMITTED TO MEET THIS REQUIREMENT. 11. THIS DIM OBTAINED BY INSERTING SEAL (PT 2)
TO BOTTOM OF GROOVE & MEASURING AT EDGE OF -499,9 ±2,0-BRACKET (PT 7) TO A POINT RADIALLY DOWNWARD ALONG TOP EDGE OF SEAL. 12. DELETED. 13. USE PERMACEL P-167 TAPE (OR MASKING TAPE) TO RETAIN THE FLOATING SEALS TO THE AFT FRAME. APPLY TAPE OVER ENTIRE LENGTH OR A MINIMUM OF (3) PLACES. 14. COATING STELLITE 6 HVOF PER ITEM 6 THICKNESSO.152 ±0.030 SURFACE FINISH Ra 6.3 MAX. -226.l_±.9 ----15. DIMENSIONS IN [] ARE METRIC. ·"W/2"-----2,8 ±,2 ----SEE NOTE 11 (218.9)48.8 SEE NOTE 2 113.92 90.4 180.1 SEE NOTE 2 "H/2" (121.7)R (572.3)REMARKS VAR.NO. 2,8±0,5 SEE NOTE 3 168,4 ±1,0 AS SHOWN VAR 01 DIFF.PART 7, $- \boxed{CTQ} \qquad 14.7 \pm .7$ 7 CTQ DATA COLLECTION P28A-AL-0001 VAR 02 6 HVOF COATING P16B-AG11 OWSA VAR 01 5 PROCESS SPEC P3B-AG18 4 IDENT-TURB/GEN PARTS AND MATL P23A-AG2 TBC'C' CLASS _____A VAR 03 3 TBC SPEC P16B-AG8 COATING OWSA VAR-02 2 WELDING-GENL SPEC P8A-AG1 1 APLD PRAC, GENL MACH 348A9200 IDENT NOMENCLATURE BHEL LIST OF COMPLEMENTARY DOCUMENTS TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT REV. DATE ALTERED - SHRIDHAR

O1 28.11.18 CHD/APPD KAMALDEEP
ONE VAR 03 ADDED FOR TBC 'C'
CLASS COATING

TI REV. DATE ALTERED SHRIDHAR RI

02 01.12.18 CHD/APPD KAMALDEEP C WEIGHT (KG) REF. TO ASSY. DRG. EV. DATE ALTERED CHD/APPD ODE.

423

UNTOL. DIMS.

GR.

¢/M/‡

SCALE

NTS REV. DATE ALTERED CHD/APPD DATE ALTERED
CHD/APPD DATE ALTERED CHD/APPD ZONE CHANGE IN TEXT FIELD TITLE ASSEMBLY, & DCA NO:50000006972 0-351-09-61009 DCA: 500000006960 SHT. No 01 NO OF SHT. 02

