

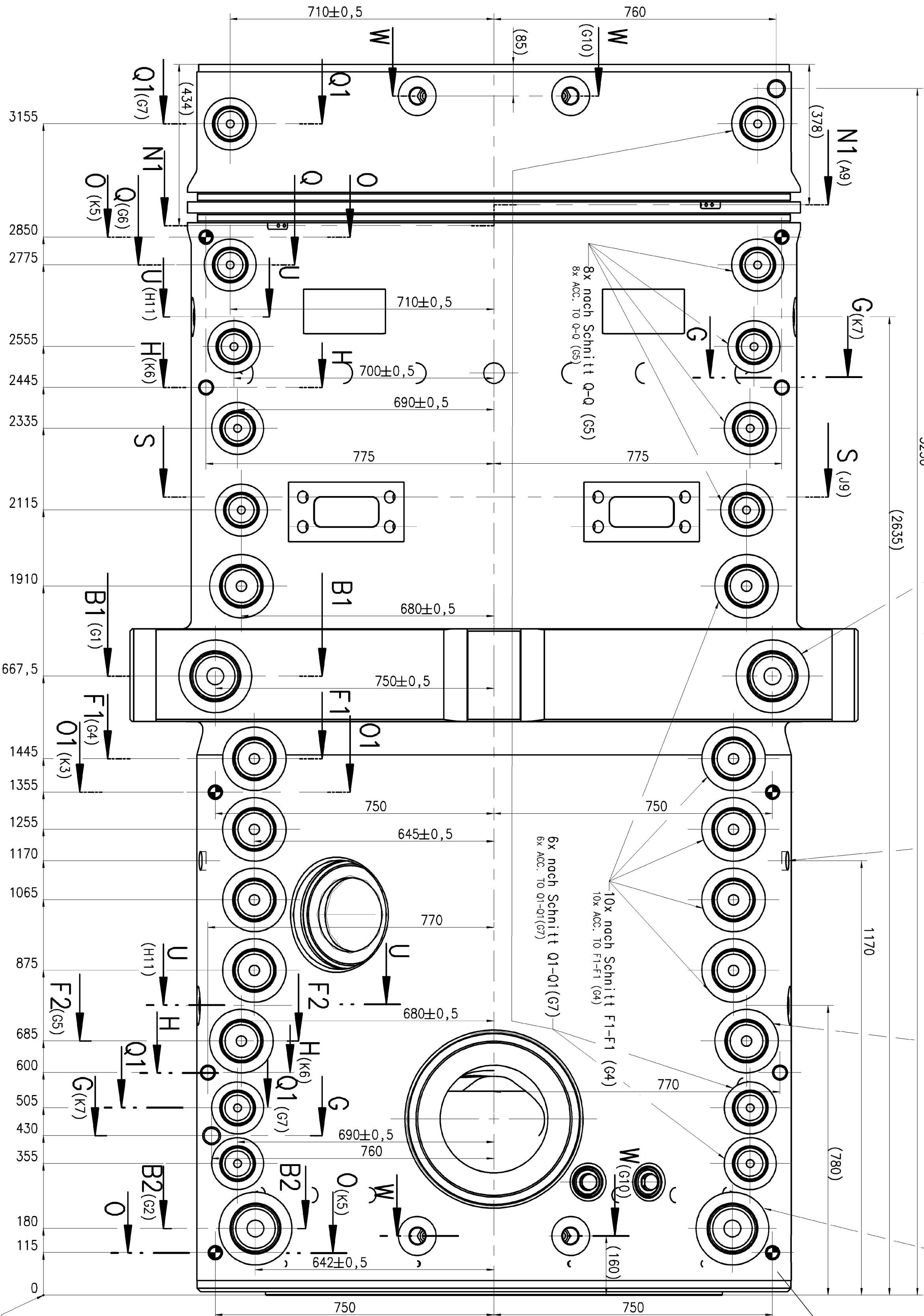
Ansicht auf das Oberteil

2x nach Schnitt B1-B1 (G1)

2x nach Schnitt B2-B2 (G2)

2x nach Schnitt F2-F2 (G8)

2x nach Schnitt B2-B2 (G2)



Anzug der Schrauben / TIGHTENING OF BOLTS

DESIGN					STUD TIGHTENING						
Pos.Nr. in der Stückliste POS.NO. IN THE BILL OF MATERIAL	Lfd.-Nr. in der Zeichnung LOCATION NO. IN THE DRAWING	Form	Teil- zeichnungs-/ Norm-Nr. STANDARD-NO. MATERIAL	Gewinde- bezeichnung. THREAD DESIGNATION	Nenn- länge NOMINAL LENGTH	Meß- länge GAUGED LENGTH	Dehnung d. Meßlänge und zul. Abweichung EXTENSION OF GAUGED LENGTH & TOLERANCE	Mutterver- drehwinkel NUT TORQUE ANGLE	mit Pos. 599 (HT- Lock) beschichtet nach TLV 3965/01 COATED WITH ITEM 599 (HT-LACQUER) ACC. TO TLV 3965/01		
		TYPE	TUN 12110.100 X19CRMVBNM11-1	d1 in mm	L in mm	LM in mm	SEE NOTE -1 ΔLM in mm	SEE NOTE -1 Abweichung TOLERANCE in mm	SEE NOTE -1 α in °		
505	200-209; 224-227	A	ST01043 HW18814	BM90x6	375	316	0,55	0	0,10	49,5	X
507	210-223	A	ST01043 HW18814	BM110x6	415	347	0,60	0	0,15	54,0	X
509	228-229	A	ST01043 HW18814	BM130x8	505	424	0,70	0	0,15	47,0	X
510	212-213	A	ST01043 HW18814	BM130x8	535	454	0,80	0	0,15	54,0	X
NOTE :- 1) Bei warm anzusetzenden Schrauben ist die Mutter nach einer Anpressung des Bolzens von etwa 0,05mm um den Mutterverformungswinkel anzuziehen. Er ist insbesondere bei Nachabgleich von Dichtheitsliste und Flansch nicht sicher herzustellen. Bei Flanschen mit äußerem Spalt ist der Spalt der Mutterverformungswinkel der Mechanik mitzuteilen. Bei warm und bei kalt angezogenen Schrauben sind die Anspanne der Maß länger im kalten, unbelasteten und im kalten, angespannten Zustand ins Schraubprotokoll einzutragen. 1) IN CASE BOLTS HAVE TO BE TIGHTENED IN WARM CONDITION, THE NUT SHALL BE TIGHTENED BY THE NUT TORQUE ANGLE AFTER AN INITIAL EXPANSION OF 0,05MM. WHEN THE BOLTS ARE TIGHTENED EITHER IN WARM OR IN COLD CONDITION, THE ACTUAL DIMENSION OF THE GAUGED LENGTH IN COLD UNSTRESSED AND COLD TIGHTENED CONDITION HAVE TO BE ENTERED INTO THE BOLT LOGSHEET.											

505, 506

510, 511

509, 511

517

GUIDE BOLT

TAPER PIN REMOVED AFTER
FINAL ASSEMBLY

516

SET SCREW

515

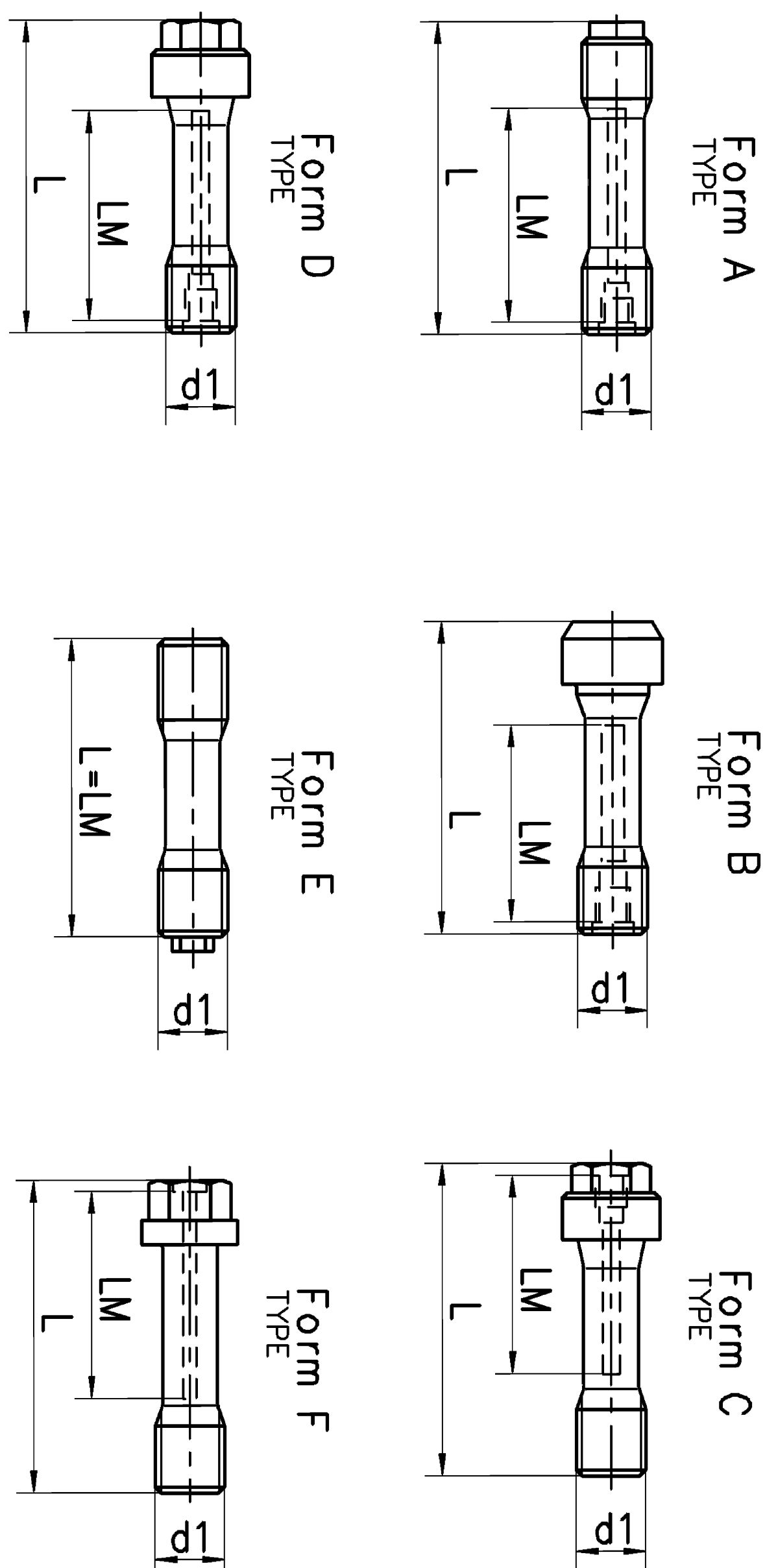
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GUIDE BOLT

518

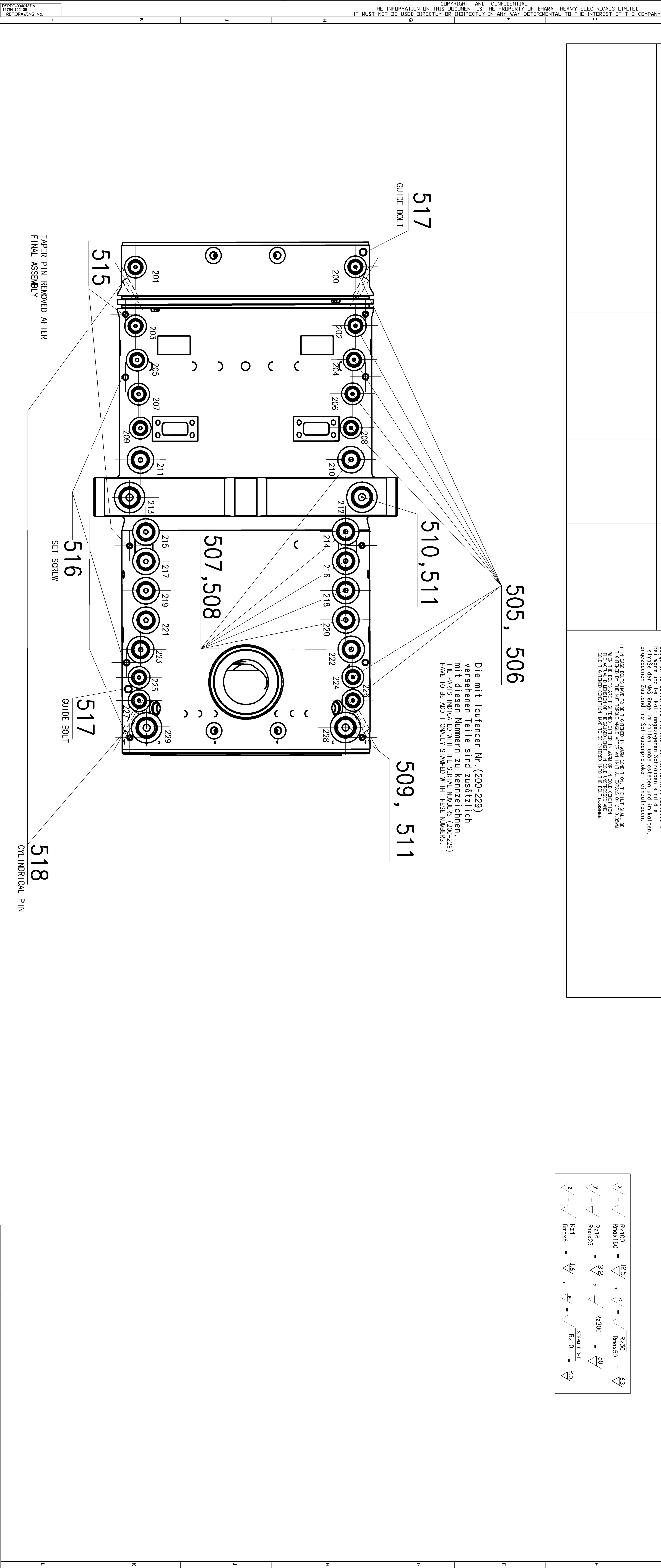
CYLINDRICAL PIN

Die mit laufenden Nr.(200-229)
versehenen Teile sind zusätzlich
mit diesen Nummern zu kennzeichnen.
THE PARTS INDICATED WITH THE SERIAL NUMBERS (200-229)
HAVE TO BE ADDITIONALLY STAMPED WITH THESE NUMBERS.



$$\sqrt{\text{R}2100} = \sqrt{\text{R}max160} = \sqrt{12,5}, \quad \sqrt{\text{C}} = \sqrt{\text{R}230} = \sqrt{6,3}$$
$$\sqrt{\text{Y}} = \sqrt{\text{R}216} = \sqrt{3,2}, \quad \sqrt{\text{R}2300} = \sqrt{50}$$
$$\sqrt{\text{Z}} = \sqrt{\text{R}24} = \sqrt{\text{R}max6} = \sqrt{1,5}, \quad \sqrt{\text{E}} = \sqrt{\text{R}210} = \sqrt{2,5}$$

STEM TIGHT



GRADE OF MATERIAL	TYPE OF PRODUCT	STEAM TURBINE
W/Cs-C/W/T/ANQ200208	DR	
WELDING-M/B/C/20H062104	DR	
GAS CUTTING-T/3 AH062103	DR	

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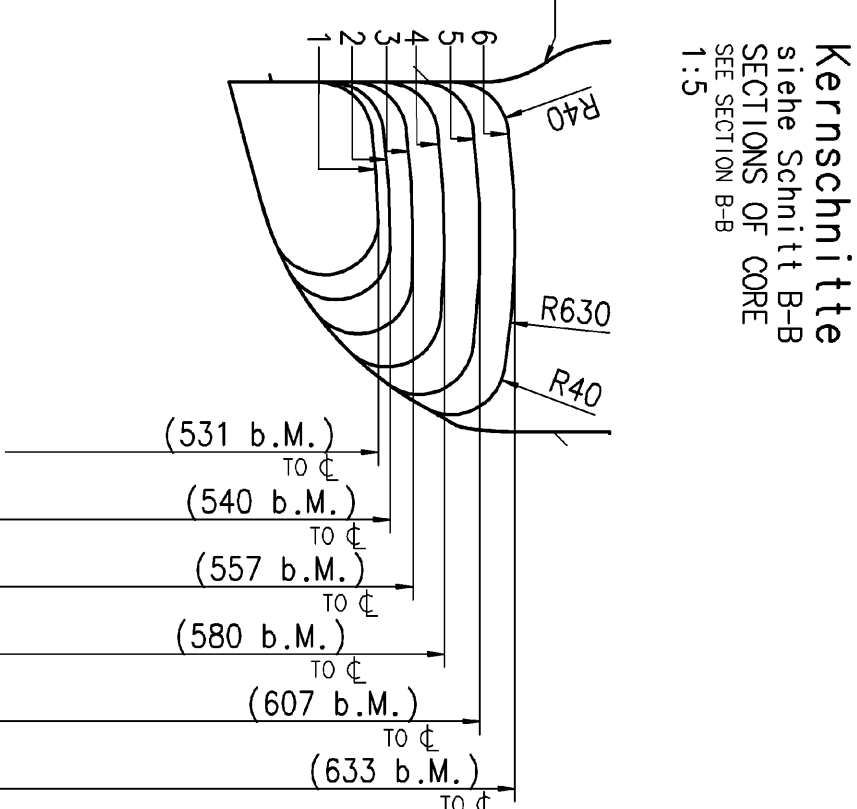
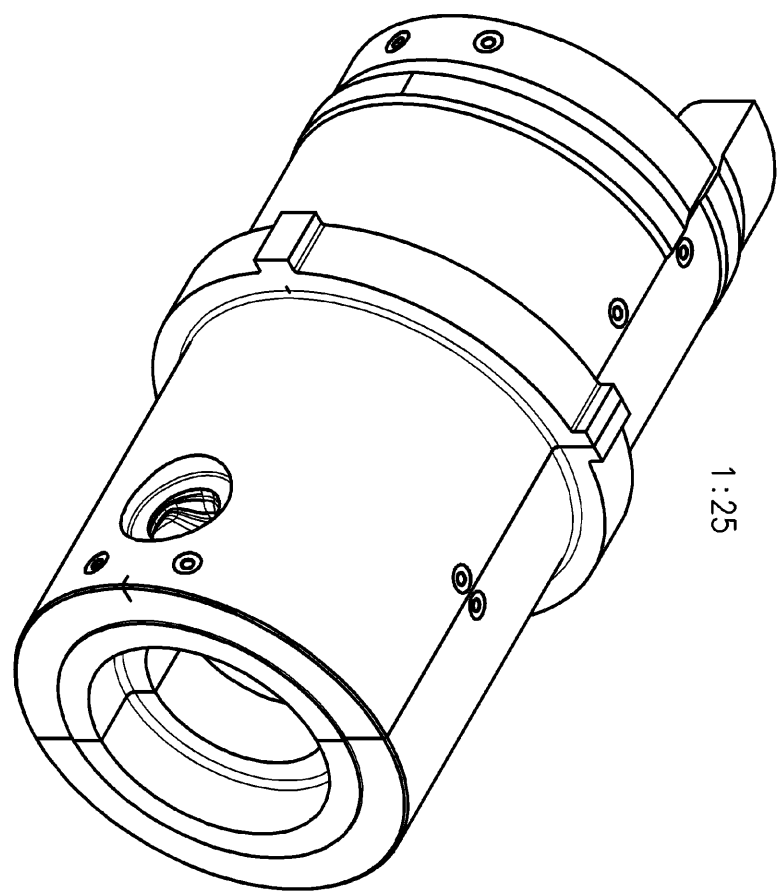
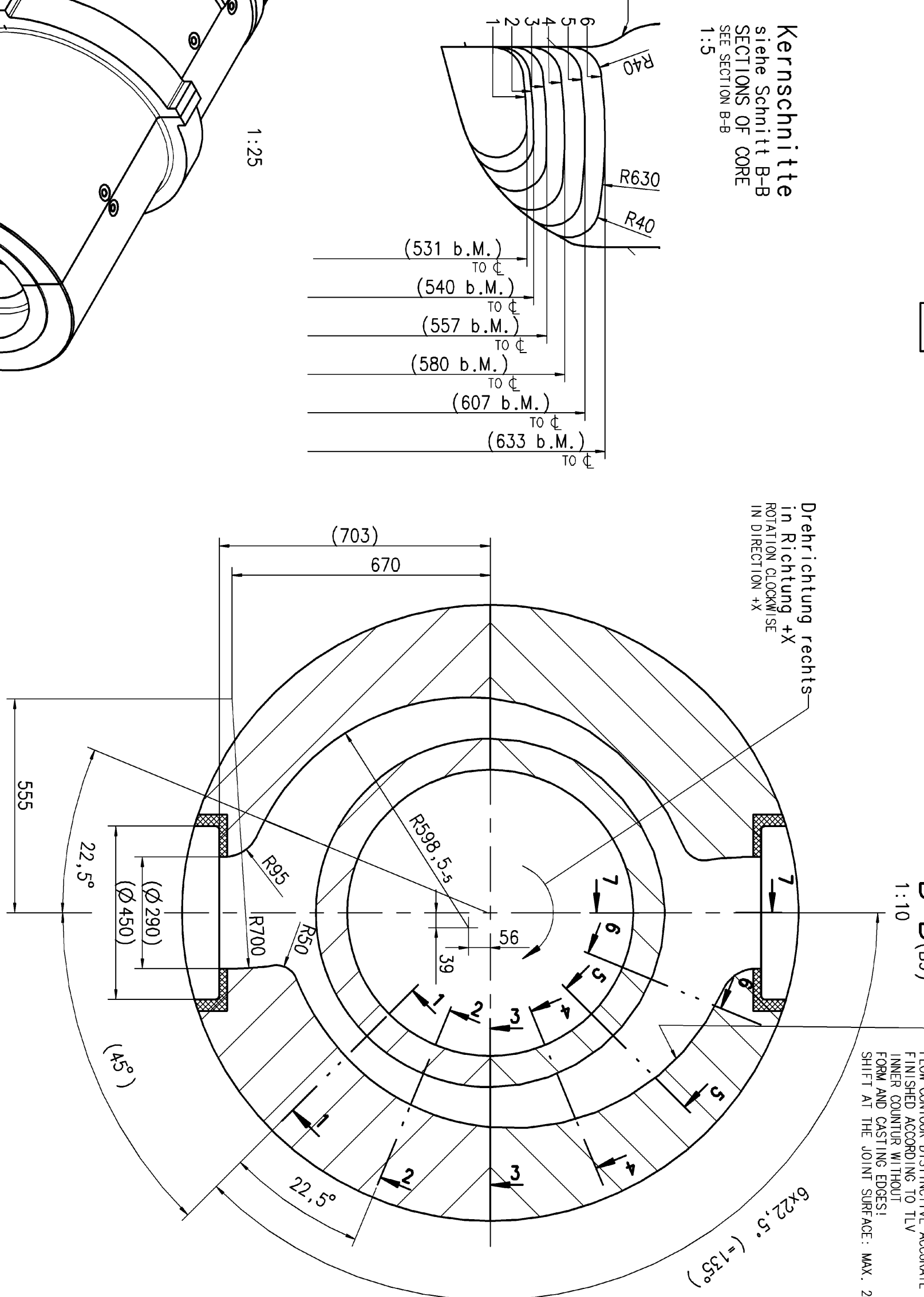
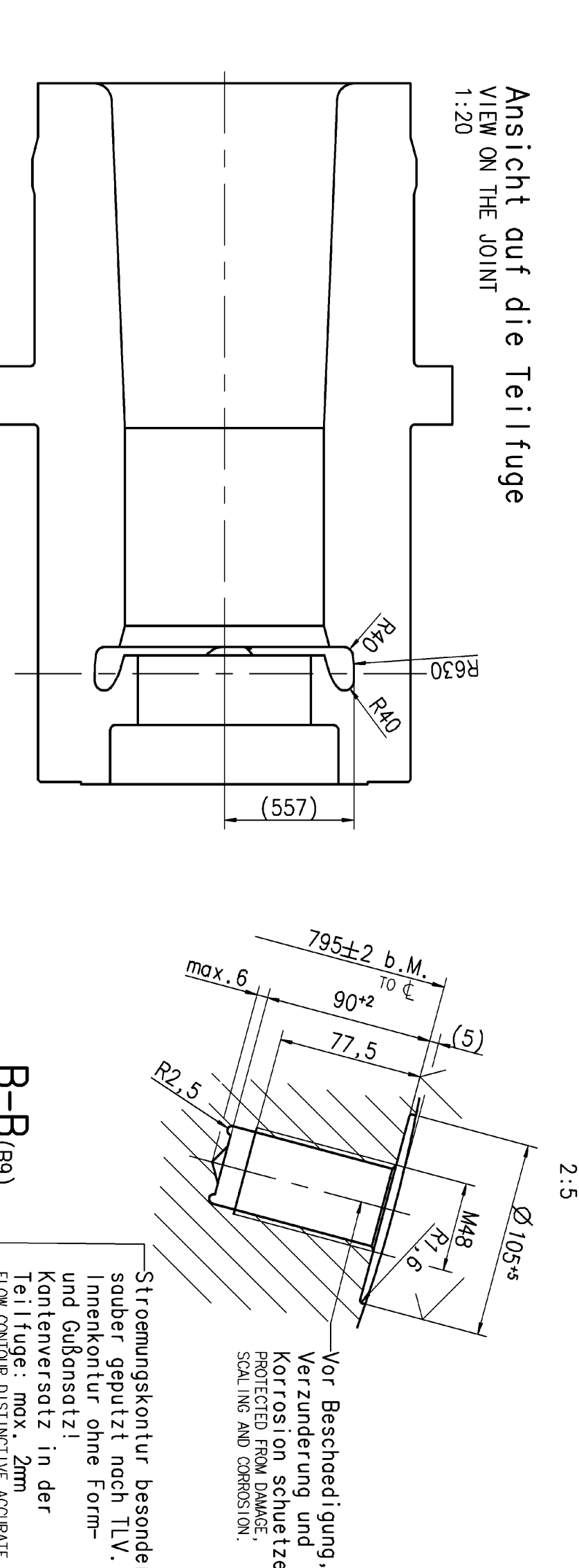
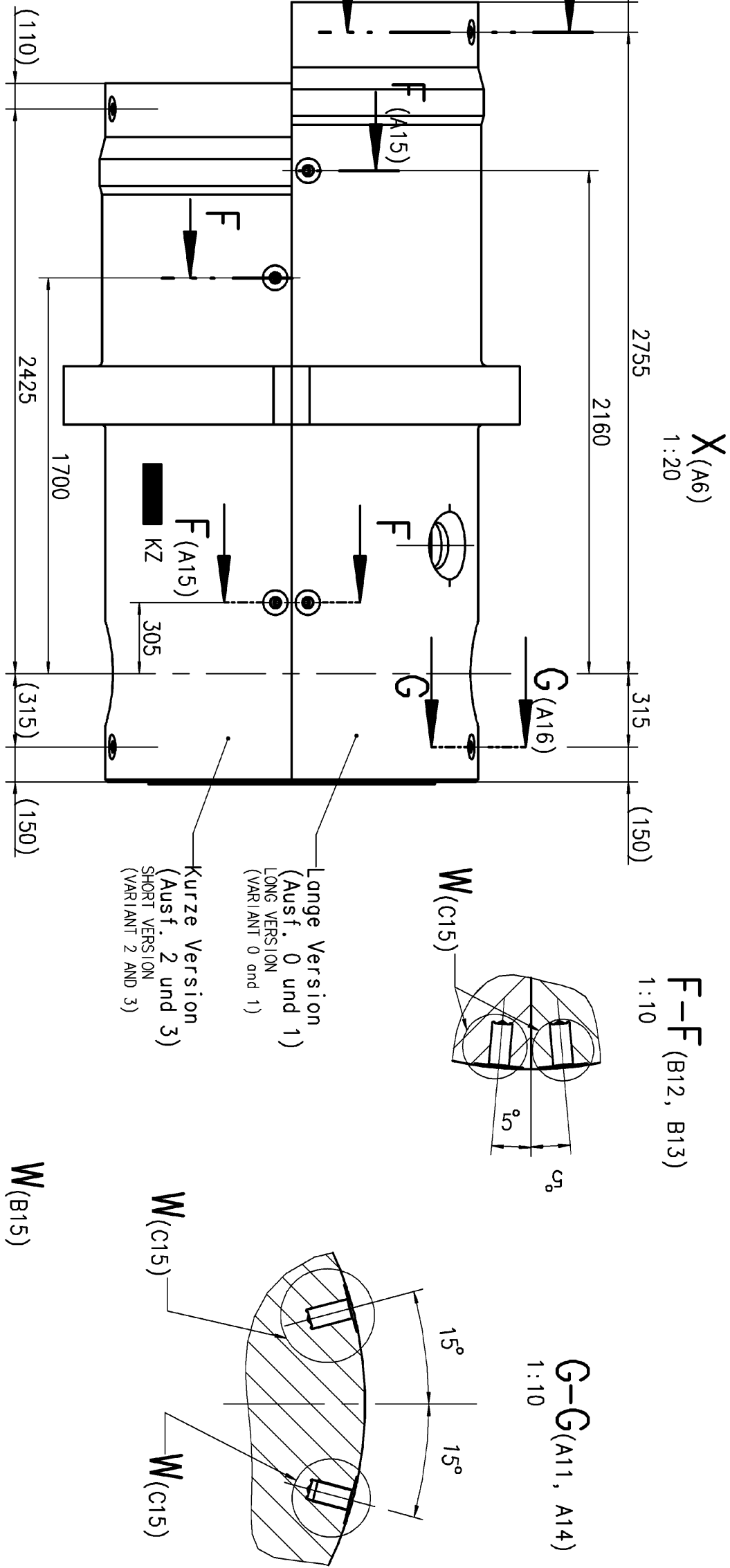
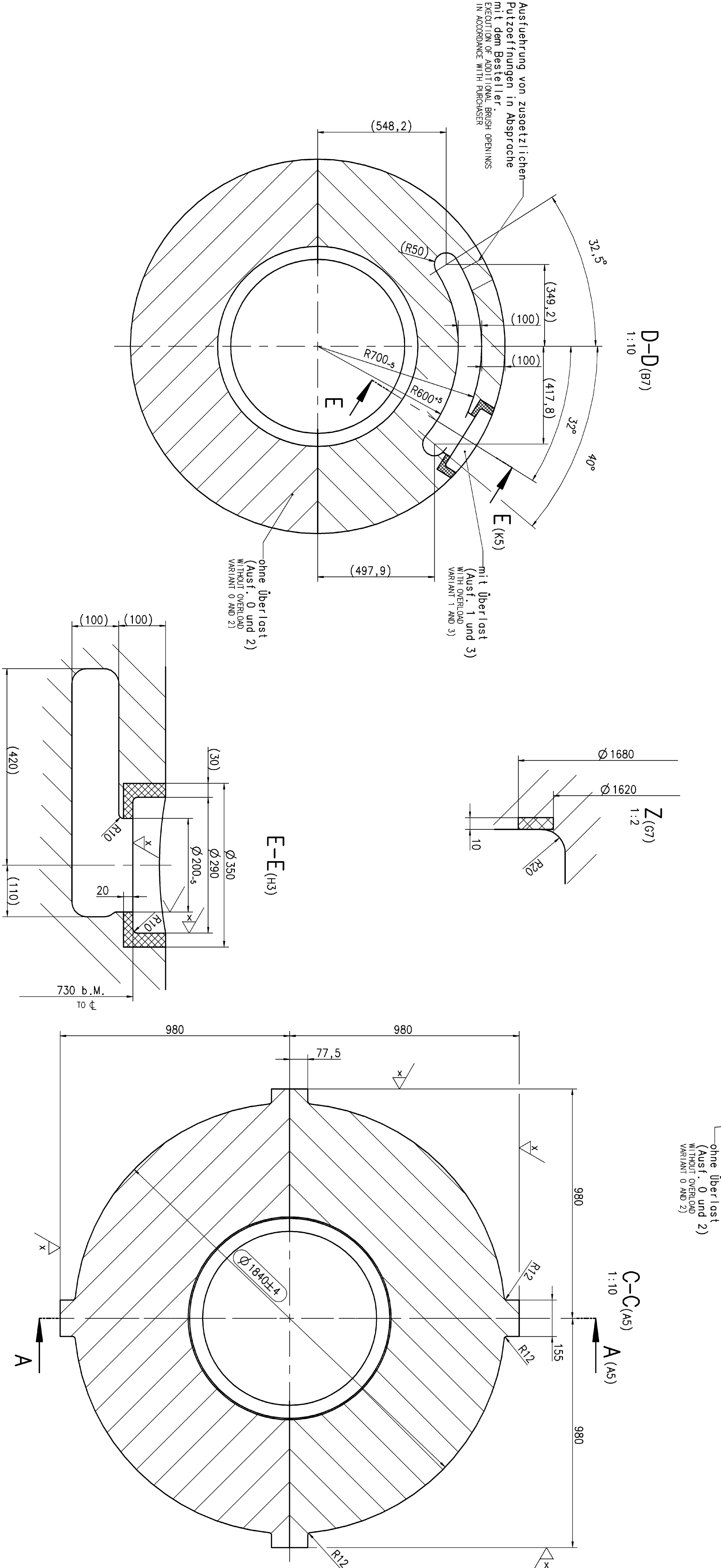
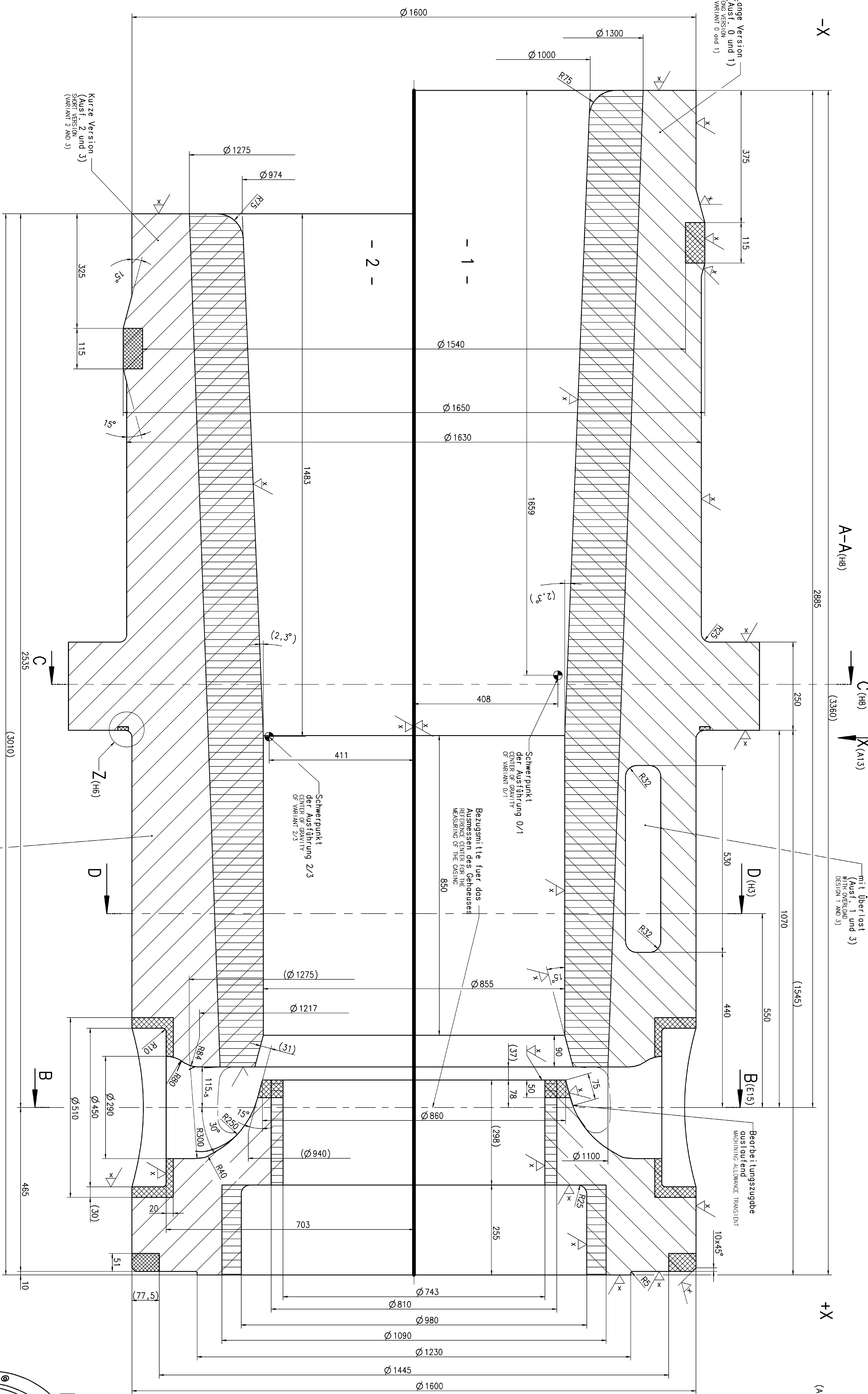
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Bezeichnung				Gewicht [kg]			
DESCRIPTION				WEIGHT [kg]			
Ingenieur: BZ				Teil			
Ausführung: BZ				Theoretisch			
Version				Maximal			
Mit Überlast				Teil			
Version				Theoretisch			
Mit Überlast				Maximal			
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Version				Theoretisch			

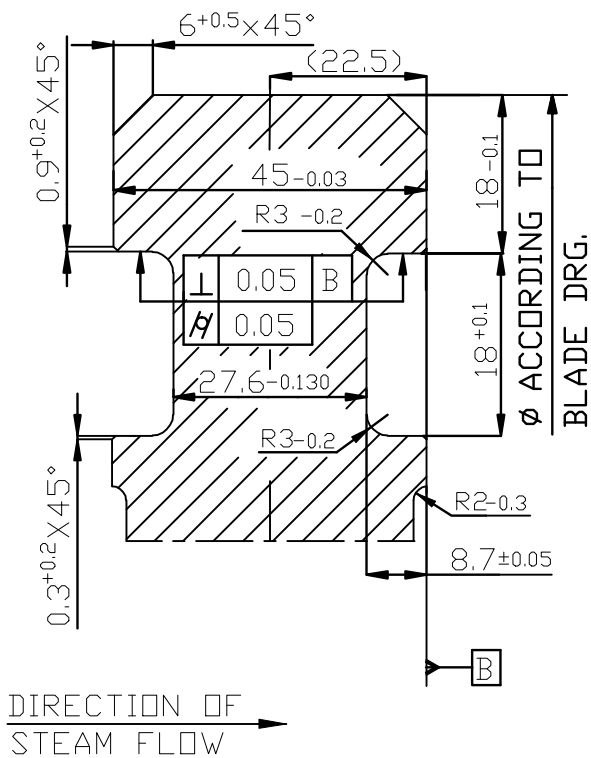
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

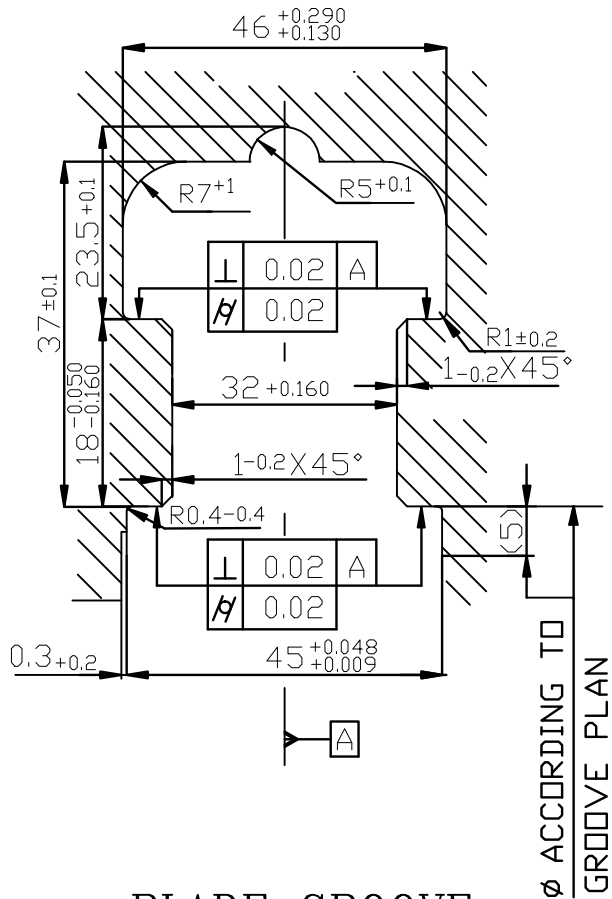
FORM DG 39(B)

REV	DATE	ALTERED	REV	DATE	ALTERED	GMS No./ C.B.O.M. NO. 91010741000	STATUS OF DRG U	
		CHECKED			CHECKED			
ZONE			ZONE		AGREED DEPT	NAME	SIGN	DATE
					STT	G.SINGH	Sd/-	17.4.03
					NCT	P.K.ARORA	Sd/-	16.4.03
GRADE OF UNTOL.DIM M/CG. C/M/F -AA0230208 WELDING A/B/C/D AA0621104						GAS CUTTING-T3 AA0621101		

3.2/▽ ALL OVER



BLADE ROOT



BLADE GROOVE

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6661576

Ref. Drawing No>

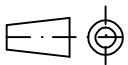
Sign & Date



BHARAT HEAVY ELECTRICALS LTD.
RANIPUR, HARDWAR

	NAME	SIGN	DATE	NO. OF VAR
DRN	HANS LAL	Sd/-	07.3.03	
CHD	P.K.BANSAL	Sd/-	20.3.03	
APPD	T.K.GHOSH	Sd/-	23.5.03	

DEPT	STE
CODE	4011



SCALE
NTS

WEIGHT (KG)

REF. TO ASSY. DRG.
91010741000

ITEM
No.

NO. OF ITEMS	_____
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TITLE : ROOT AND GROOVE
FOR GUIDE BLADE

CARD
CODE

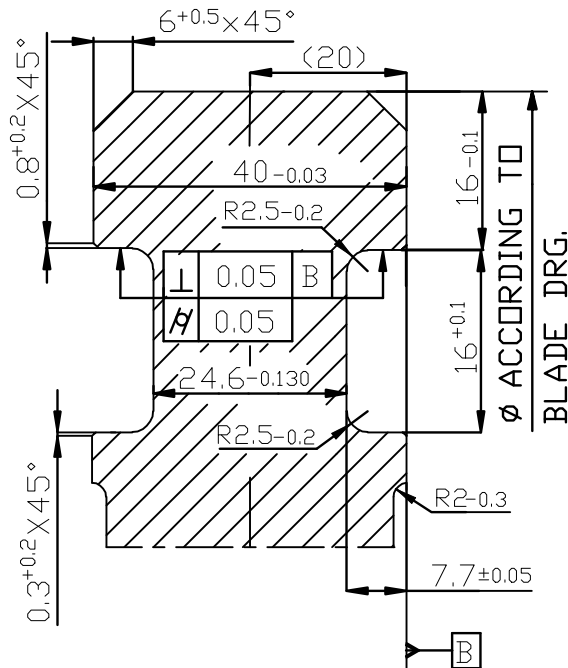
DRAWING NO.
74-10107-41012

SHEET No. 01

No. OF SHEETS	01
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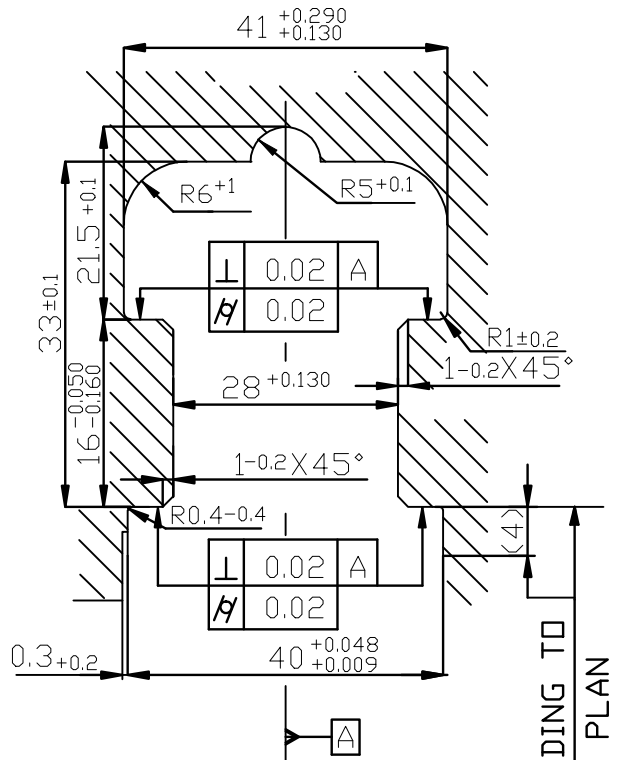
23	24
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REV	DATE	ALTERED	REV	DATE	ALTERED	GMS No./ C.B.O.M. NO.	STATUS OF DRG U		
		CHECKED			CHECKED				
ZONE			ZONE			AGREED DEPT	NAME	SIGN	DATE
						STT	G.SINGH	Sd/-	17.4.03
						NCT	P.K.ARDRA	Sd/-	16.4.03
GRADE OF UNTOL.DIM M/CG. ϕ /M/F -AA0230208 WELDING X/B/C/D AA0621104 GAS CUTTING-T3 AA0621101									



DIRECTION OF
STEAM FLOW →

BLADE ROOT



BLADE GROOVE

6661566
Ref.Drawing No>

Sign & Date



BHARAT HEAVY ELECTRICALS LTD.
RANIPUR, HARDWAR

DRN	NAME	SIGN	DATE	NO. OF VAR
CHD	HANS LAL	Sd/-	07.3.03	
APPD	P.K.BANSAL	Sd/-	20.3.03	
	T.K.GHOSH	Sd/-	23.5.03	

Inventory No.

DEPT STE		SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM No.	NO. OF ITEMS
CODE 4011		NTS	_____	91010741000	_____	_____
TITLE : ROOT AND GROOVE FOR GUIDE BLADE			CARD CODE	DRAWING NO.		
				74-10107-41014 _{22 23 24}		
				SHEET No. 01	No. OF SHEETS 01	

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