FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG. NO. 0 203 01 21104

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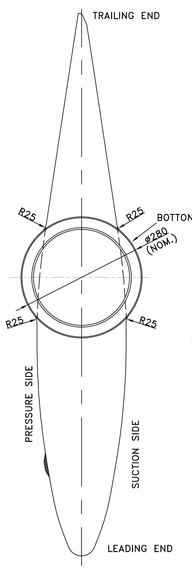
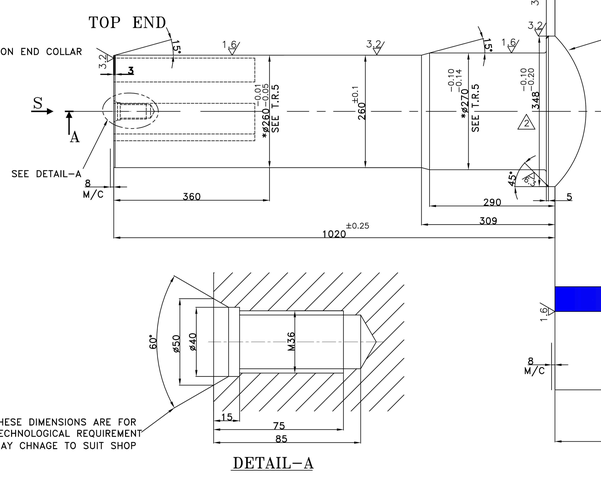


VIEW–T

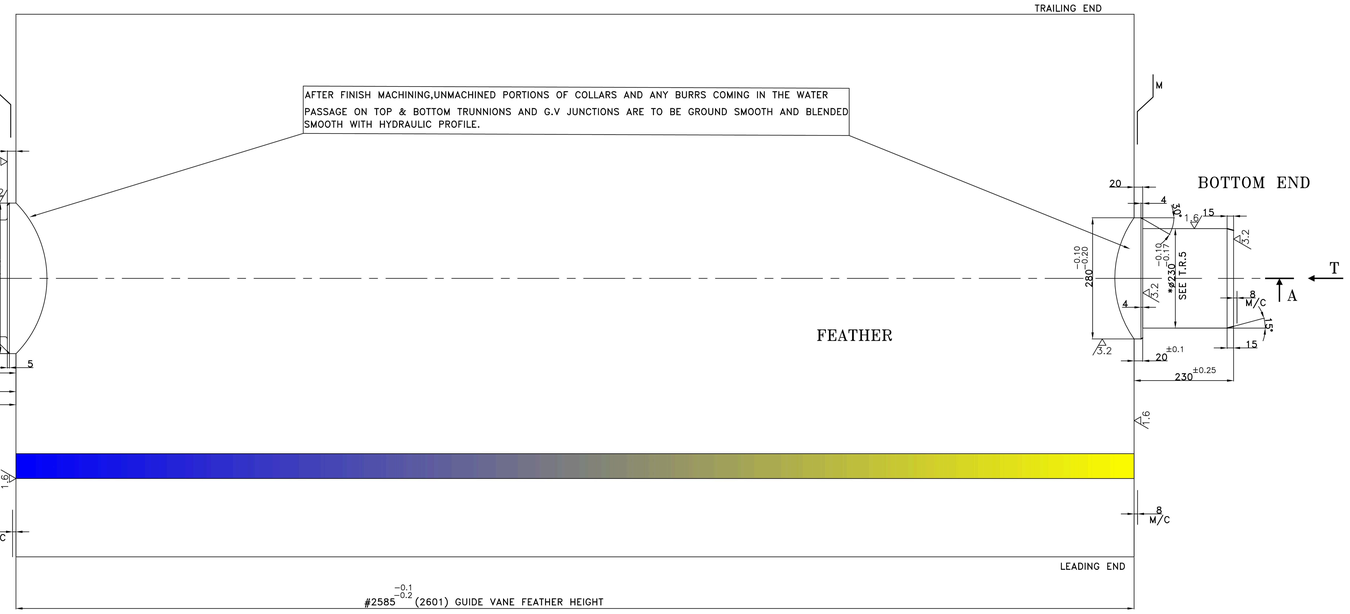
(VIEWED FROM BOTTOM END)



THESE DIMENSIONS ARE FOR TECHNOLOGICAL REQUIREMENT MAY CHNAGE TO SUIT SHOP

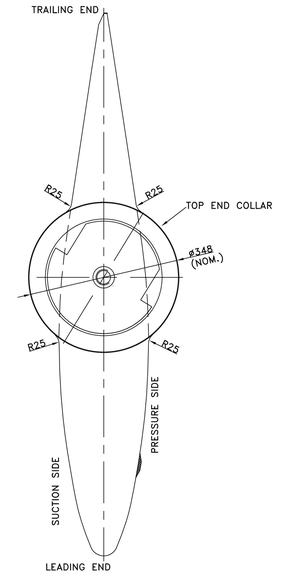
DETAIL–A

AFTER FINISH MACHINING,UNMACHINED PORTIONS OF COLLARS AND ANY BURRS COMING IN THE WATER PASSAGE ON TOP & BOTTOM TRUNNIONS AND G.V JUNCTIONS ARE TO BE GROUND SMOOTH AND BLENDED SMOOTH WITH HYDRAULIC PROFILE.



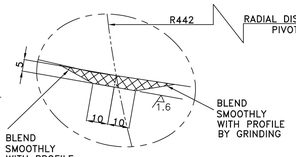
$\#2585^{-0.1}_{-0.2}$ (2601) GUIDE VANE FEATHER HEIGHT

ELEVATION



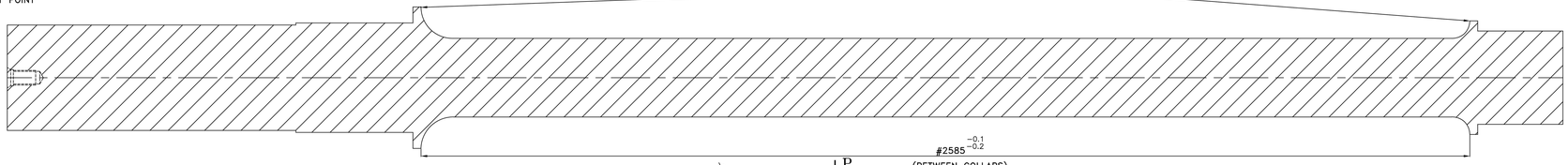
VIEW–S

(VIEWED FROM TOP END)

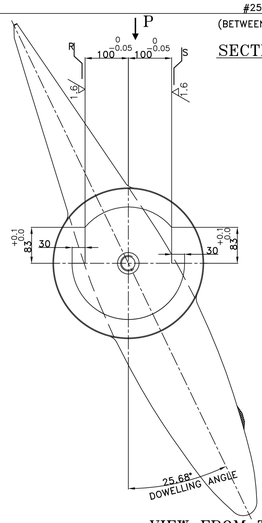


DETAIL–C

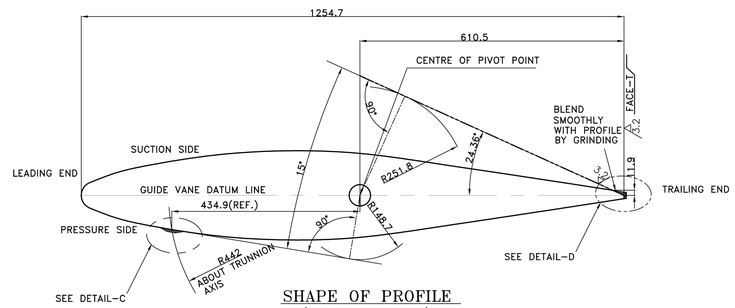
AFTER ASSEMBLING THE GUIDE VANES BLEND THE CORNERS OF TOP AND BOTTOM TRUNNIONS AT A SLOPE OF 15° SMOOTHLY WITH THE TOP AND BOTTOM LINER PLATES



$\#2585^{-0.1}_{-0.2}$ (BETWEEN COLLARS)

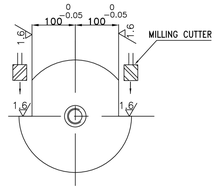


SECTION–AA

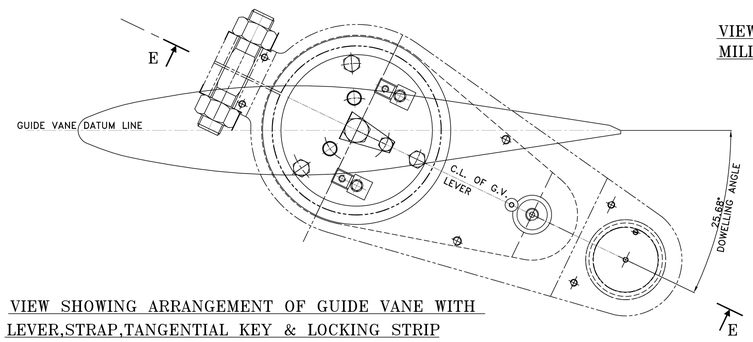


SHAPE OF PROFILE

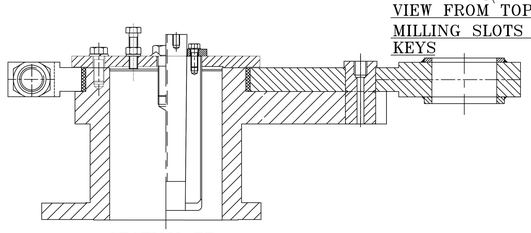
(VIEWED FROM TOP END)



VIEW SHOWING MOVEMENT OF MILLING CUTTER (FOR REFERENCE ONLY)



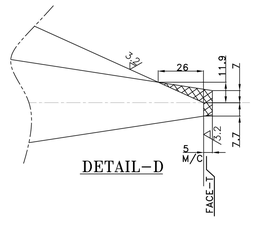
VIEW SHOWING ARRANGEMENT OF GUIDE VANE WITH LEVER,STRAP,TANGENTIAL KEY & LOCKING STRIP



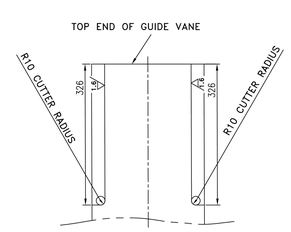
SECTION–EE

VIEW FROM TOP END SHOWING MILLING SLOTS FOR TANGENTIAL KEYS

INDICATIVE 3D VIEW



DETAIL–D



VIEW–P

TECHNICAL REQUIREMENTS:

1. NON–COAXIALITY OF * MARKED DIAMETERS WITH RESPCT TO THEIR COMMON AXIS SHOULD NOT BE MORE THAN 0.03MM.
2. PARALLELITY OF SURFCAES R & S WITH RESPECT TO COMMON AXIS OF TRUNNIONS SHOULD BE MAINTAINED – WITHIN 0.03.
3. NON–PERPENDICULARITY OF SURFACES 'M' AND 'N' WITH THE RESPECT TO COMMON AXIS OF TRUNNIONS SHOULD BE MAINTAINED WITHIN 0.03 MM.
4. '#' MARKED DIMENSION (FEATHER HEIGHT) TO BE STRICTLY MAINTAINED TO ACHIEVE DESIRED CLEARANCES.
5. GUIDE VANES ARE INTERCHANGEABLE, THEREFORE '*' AND '#' MARKED DIMENSIONS TO BE STRICTLY MAINTAINED.
6. OUT OF BALANCE MOMENT OF GUIDE VANE =31328.0 KG–CM, WEIGHT OF FEATHER =3516 KG
7. 100% NDT TO BE CARRIED OUT ON THE FILLET OF SHORT STEM AND LONG STEM:
   (a) MPI TO AA0850134 , ACCEPTANCE LEVEL–2.
   (b) LPI TO AA850132, ACCEPTANCE LEVEL–2.
8. PAINT AND PROTECT TO HT00005 AS FOLLOWS:
   (a) GUIDE VANE FEATHER EXCEPT SURFACE 'M' & 'N' TO CAT–C.
   (b) REMAINING SURFACE TO CAT–G.

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