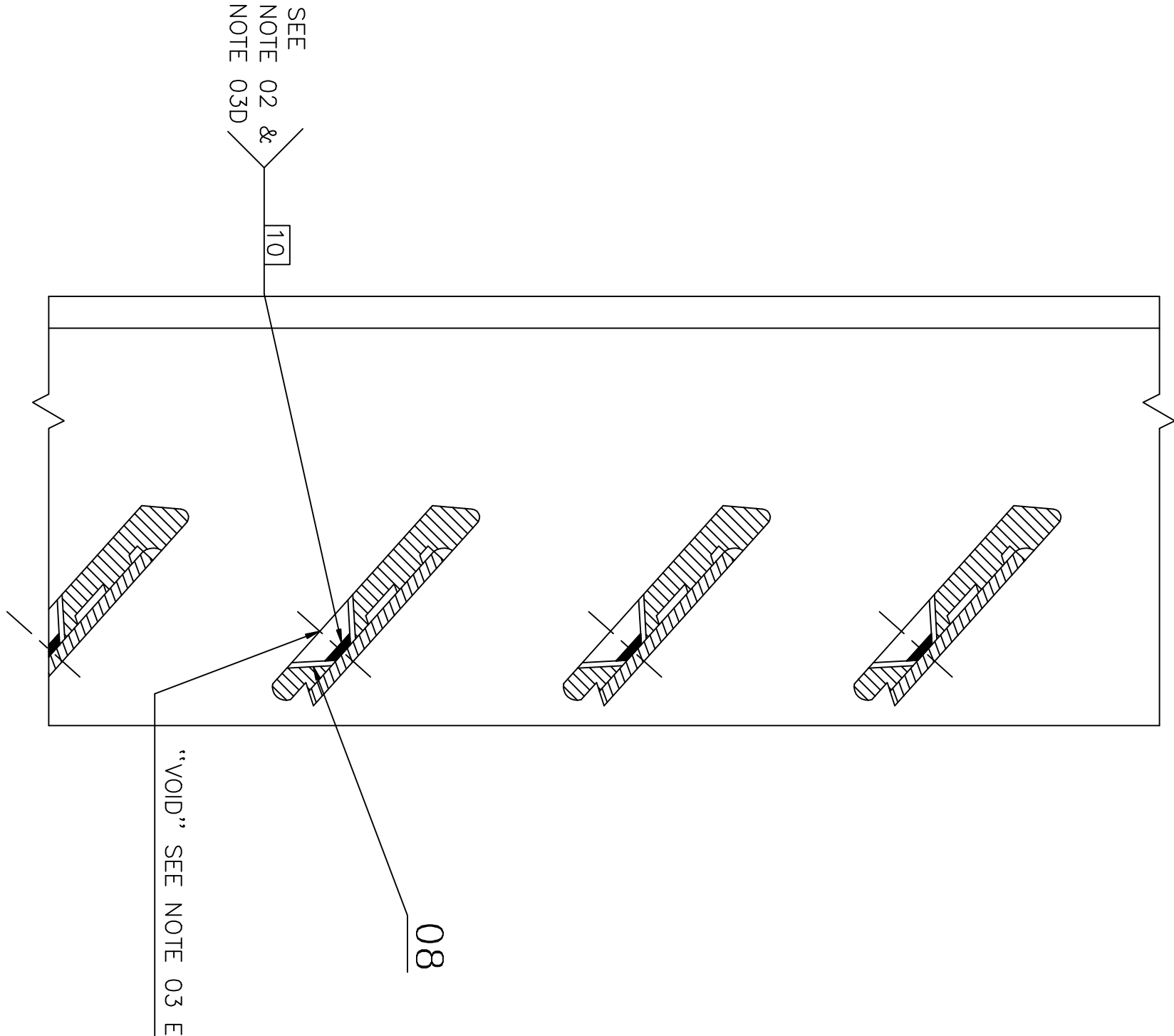
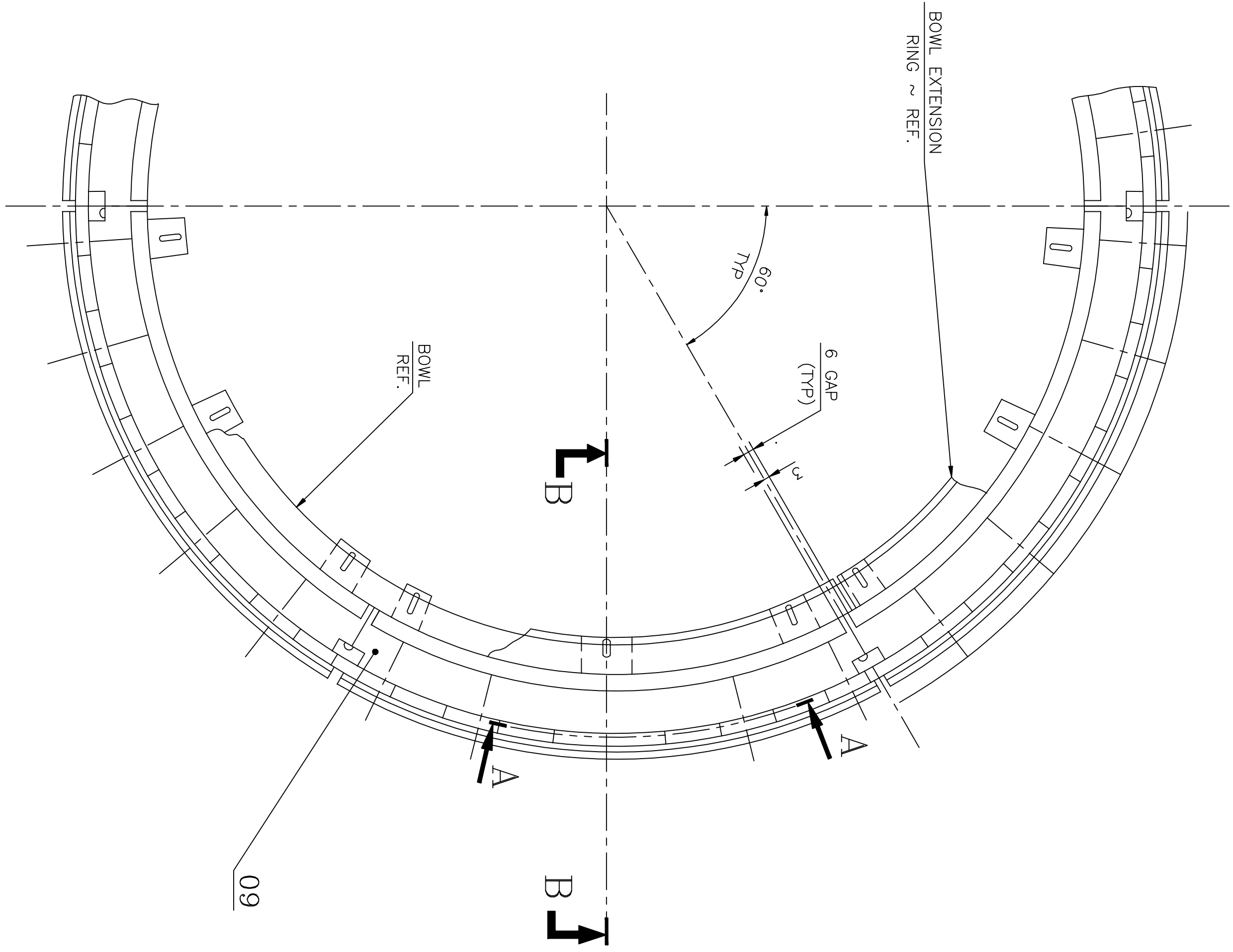


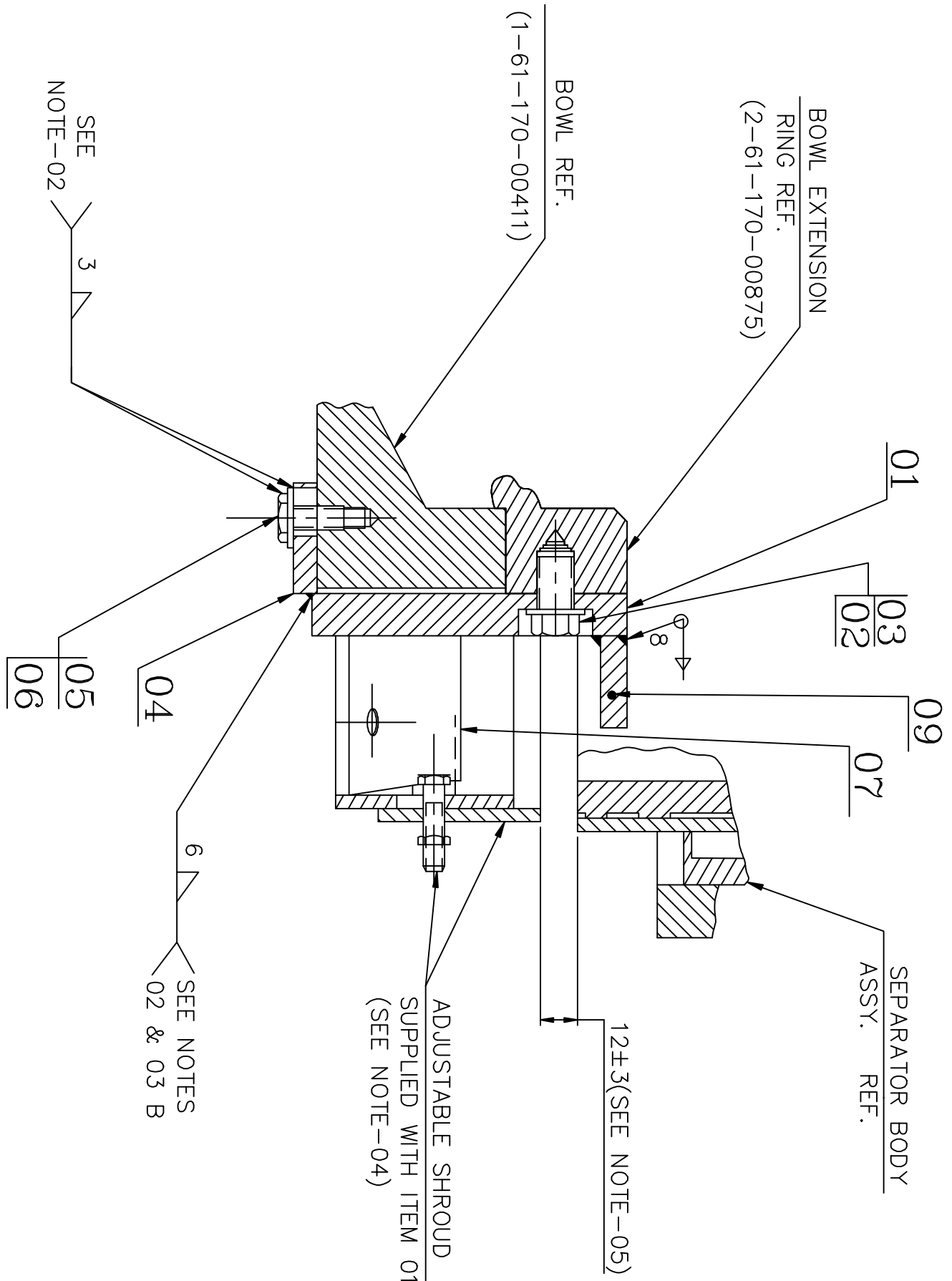
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

25200-041-19-0
ONCRD



SECTION-AA



SECTION-BB

NOTES:-

- UNLESS OTHERWISE NOTED, TORQUE ALL HEX HD CAP SCREWS AND APPLY THREAD LOCKING SEALANT TO ALL FASTENERS PER DWG 2-61-162-00817
- GROUND EACH INDIVIDUAL VANE WHEEL SEGMENT (ITEM - 1) BEFORE WELDING.
- ATTACH VANE WHEEL SEGMENT (ITEM - 01) TO BOWL EXTENSION RING AND TO BOWL PER SECTION-BB AS FOLLOWS.
 - ASSURE PROPER POSITION AND SNUG - UP SCREWS (ITEM 02 & 03) DO NOT APPLY THREAD LOCKING SEALANT OR TORQUE THESE SCREWS AT THIS TIME.
 - ATTACH VANE WHEEL SUPPORT LUGS (ITEM - 04) WITH SCREWS & WASHERS (ITEMS 05 & 06) TO BOWL, WELD AS SPECIFIED.
 - APPLY THREAD LOCKING SEALANT (LOCTITE # 271) TO SCREWS & WASHERS (ITEMS 02 & 03) AND TORQUE TO 500 FT/LBS. (41.5 kgm)
 - ATTACH VANE WHEEL LINERS (ITEM - 07) TO VANE WHEEL SEGMENT (ITEM - 01) USING WELD PLUG (ITEM - 08) AND WELD AS SPECIFIED PER SECT - AA AND APPLICATION OF WELD PLUGS DWG. 3-61-370-00838.
 - APPLY RTV SEALER TO WELD PLUG (ITEM - 08) 'VOID' UNTIL FLUSH WITH LINER SURFACE.
- SET ADJUSTABLE SHROUD CLEARANCE PER SECT - BB AS FOLLOWS:
 - LOOSEN FASTENER & LIFT SHROUD TO SPEC. DIM TIGHTEN FASTENER BUT DO NOT TORQUE OR APPLY THREAD LOCKING SEALANT.
 - ROTATE BOWL SLOWLY AND CHECK CLEARANCE AROUND ENTIRE PERIPHERY
 - LOOSE FASTENERS ONE BY ONE.
 - APPLY LOCTITE 280 TO FASTENERS.
 - TORQUE FASTENERS TO 5.5 kgm.

INVENTORY NO	SIGN AND DATE	REF. DRG. NO.	COMPUTER FILE NAME
		D-74-637	06100237.DWG

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IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY

1	2	3	4	5	6	7	8	9	10	11
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REV	DATE	REASON
01	10.6.96	DESIGNED
02	10.6.96	CHECKED
03	10.6.96	APPROVED

REV	DATE	REASON	LISC
01	10.6.96	CHECKED	BWG
02	10.6.96	APPROVED	BWG

TITLE	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	REV.
VANE WHEEL APPLICATION	N/S	699.96	D-74-637	03

NO	DESCRIPTION	DRAWING NO.	MATL. SPECN.
01	VANE WHEEL SEGMENT ASSY.	3-61-170-00881	ASSY.

TYPE OF PRODUCT	NAME OF CUSTOMER/PROJECT
BHARAT HEAVY ELECTRICALS LTD.	HYDERABAD, INDIA.

DATE	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	REV.
10.6.96	N/S	699.96	D-74-637	03

NO	DESCRIPTION	DRAWING NO.	MATL. SPECN.
01	VANE WHEEL SEGMENT ASSY.	3-61-170-00881	ASSY.

09	RE RESTRICTION RING-UPPER	4-61-170-90233		6	11.000
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08	WELDING PLUG	4-61-370-00805		0.050	
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07	VANE LINER	2-61-170-00781		2.800	
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06	WASHER Ø17		AA716100080	0.010	
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05	HEX.HD SCREW M16x50		AA7121123525	0.100	
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04	VANE WHEEL SUPPORT LUG	3-61-170-00882		1.500	
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03	WASHERS		AA7161001102	0.030	
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02	HEX.HD SCREW M24x50		HY7121124700	0.280	
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01	VANE WHEEL SEGMENT ASSY.	3-61-170-00881		824.410	
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