



- TECHNICAL REQUIREMENTS:
- FOR MACHINING OF BLADE AND SEALING GROOVES OF ROTOR AND CASING AND OTHER LOCATING DIMENSIONS, REFER DRAWING NO. 9101072905.
  - MINIMUM AXIAL CLEARANCES
- | TURBINE SIDE |                          |                     |                   |
|--------------|--------------------------|---------------------|-------------------|
| STAGE        | IN FRONT OF MOVING BLADE | BEHIND MOVING BLADE | IN FRONT OF GUIDE |
| 1-5          | 3.7(-)                   | 4.8(+)              |                   |
| 6-12         | 3.7(-)                   | 3.7(+)              |                   |
| 13-15        | 4.8(+)                   | 4.8(+)              |                   |
| 17-18        | 4.8(+)                   | 4.7(+)              |                   |
| 19-22        | 4.7(-)                   | 4.7(+)              |                   |
| 23           | 5.8(+)                   | 5.8(+)              |                   |
4. LOCATION OF INSERTION GROOVES AS PER TECHNOLOGICAL INSTRUCTION NO. 0944.004 (F.V. 100113),  $\kappa=30^\circ$
5. FOR THE VALUES OF TOLERANCES (H7, h6, h9), SEE TOLERANCE STATEMENT.