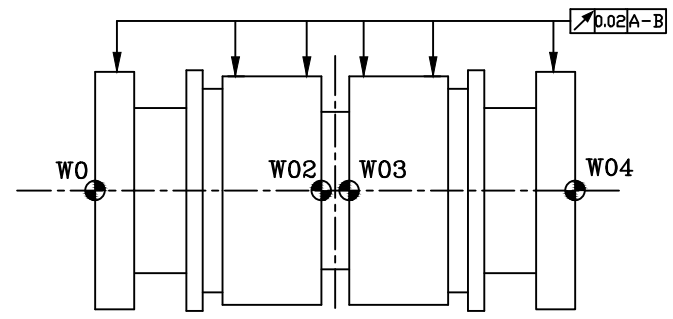


TOLERANCE STATEMENT				
NOMINAL SIZE mm		TOLERANCE RANGE		
		H7	h8	h9
ABOVE	UP TO	UPPER	UPPER	UPPER
		LOWER	LOWER	LOWER
1250	1600	+ 0.125	0	0
		0	- 0.078	- 0.310
1800	2000	+ 0.150	0	0
		0	- 0.092	- 0.370
2000	2500	+ 0.175	0	0
		0	- 0.110	- 0.440

**TECHNICAL REQUIREMENTS :**

1. RADIAL RUN OUT SHALL BE PERFORMED AT STAGE 1L, 6L, 8L, 1R, 6R AND 8R WITH RESPECT TO LOCATION A-B OF LP ROTOR (POM10000). THE SURFACE FINISH AT THESE LOCATIONS SHALL BE . PERMISSIBLE RUN-OUT VALUES WHICH ARE VALID FOR ALL STAGES SHALL BE AS PER THE SKETCH BELOW.



2. GROOVE SHALL BE MACHINED AS PER FOLLOWING DRAWINGS :-

MOVING BLADE		GUIDE BLADE	
STAGE	DRAWING NO.	STAGE	DRAWING NO.
1L, R	41010746012	1L, R	41030446013
2L, R	41010746014	2L, R	41030446014
4L, R	41020446014	4L, R	41030446015
5L, R	41030446011	5L, R	41030446016
6L, R	41030446012		
7L	11030746031		
7R	11030746033		
8L	01030746032		
8R	01030746034		

3. LOCATION OF INSERTION GROOVES SHALL BE AS PER TECHNOLOGICAL INSTRUCTION MEL 944.004 (FY 100113) WITH  $\alpha=60^\circ$

STAGE	DRAWING NO.
IL-6L	41030446021
IR-6R	41030446022

4. FOR THE VALUE OF TOLERANCE (H7, H9 AND H6), SEE TOLERANCE STATEMENT