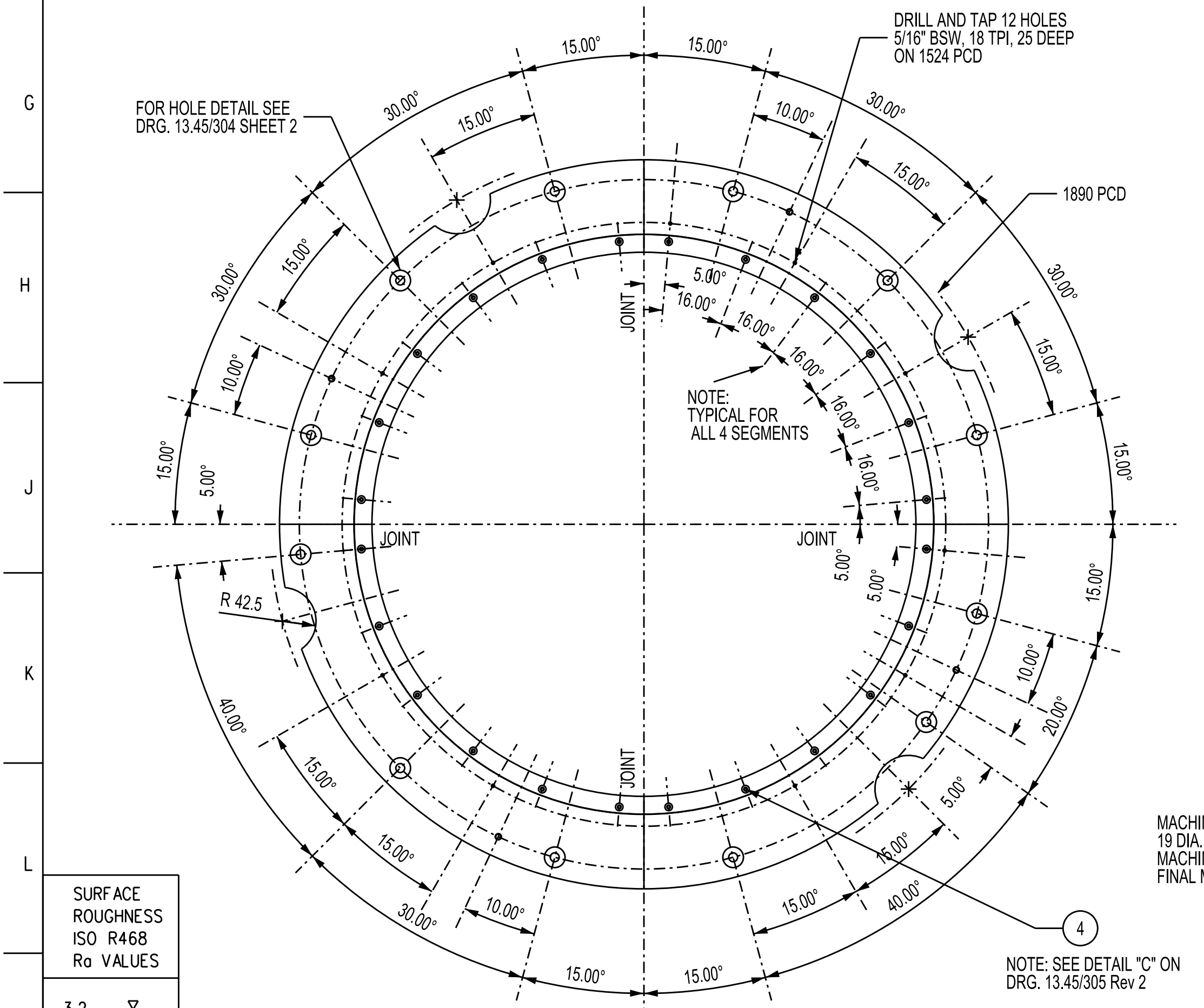


VIEW FROM 'A'
SCALE 1:10



VIEW FROM 'B'
SCALE 1:10

DRILL & TAP 4 HOLES
5/8" BSW, 11 TPI, ON
1740 PCD AS SHOWN

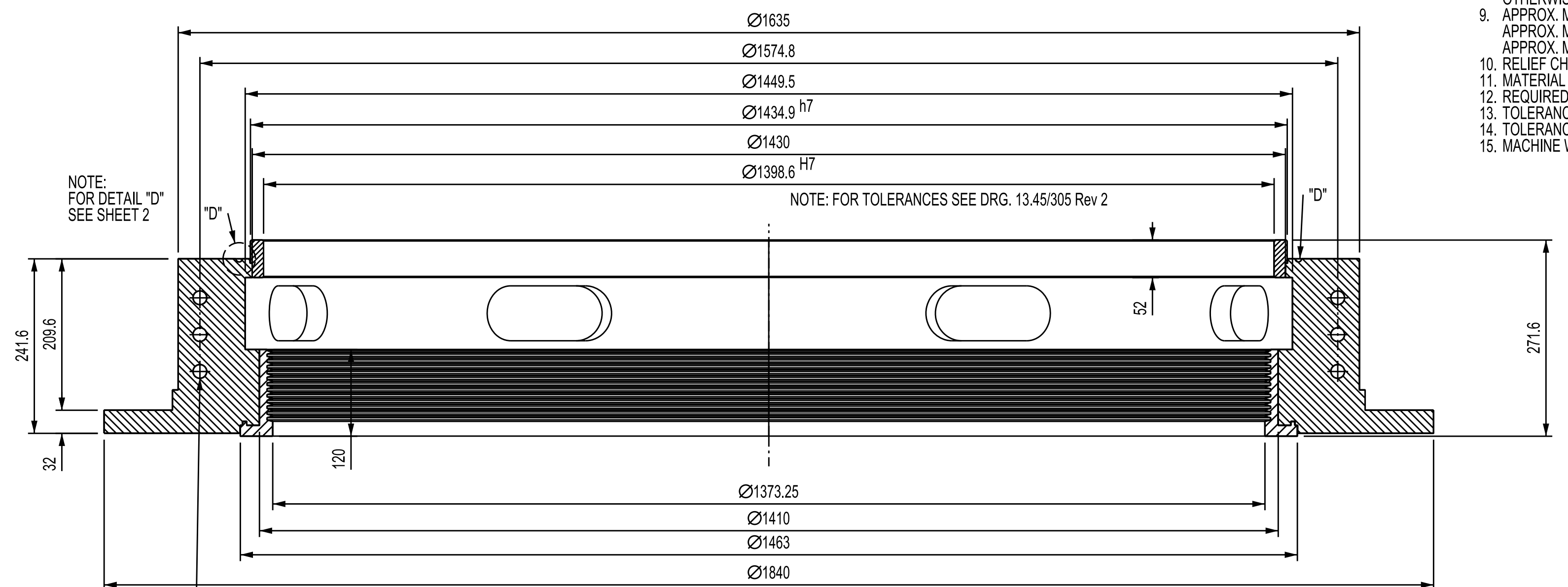
AIR PORTS

USE 6 X 0.75 MM
THICK BRASS SHIMS,
PER SEGMENT (4.5MM)

MACHINE JOINT FACES AND DRILL
19 DIA HOLES, REAM AND FIT 12 x
M20 MACHINE FITTED BOLTS, BEFORE
FINAL MACHINING

NOTES:-

1. REMOVE ALL SHARP EDGES
2. MACHINING AS INDICATED
3. ENSURE PROPER ALIGNMENT BEFORE ASSEMBLY
4. ITEM 1 & 5 WEARING RING MATERIAL: PHOSPHOR BRONZE PB 1-C TO BS1400:1973
5. ITEM 2 AIR SEAL RING MATERIAL: ALUMINIUM, LM4 (EN 1706 AC-45200)
6. ALL DIMENSION IN mm
7. 100% VISUAL & DIMENSIONAL INSPECTION ON COMPLETED WORK
8. TOLERANCE ON MACHINED SIZES UNLESS OTHERWISE STATED ± 0.25
9. APPROX. MASS OF ITEM 1: 20.47kg x 4 = 81.88kg
APPROX. MASS OF ITEM 2: 44.173kg x 4 = 176.692kg
APPROX. MASS OF ITEM 5: 8.9kg x 4 = 35.6kg
10. RELIEF CHECK FOR CRACKING
11. MATERIAL CERTIFICATE
12. REQUIRED FOR ITEMS 1, 2 & 5
13. TOLERANCE ON CASTING SIZES ± 3
14. TOLERANCE ON CASTING THICKNESS ± 3
15. MACHINE WHERE SHOWN THIS



GENERAL MEASUREMENTS
SECTION A - A
SCALE 1:5

| ITEM | DESCRIPTION | STOCK NUMBER |
|------|--|--------------|
| | COMPLETE ASSEMBLY, LABYRINTH SEAL RING | 666020 |
| 1 | UPPER WEARING RING | 696289 |
| 5 | LOWER WEARING RING | 696281 |

NOTE:
THIS DRG. TO BE READ IN
CONJUNCTION WITH 13.45/305 Rev 2

| ITEM | QTY | DESCRIPTION | MATERIAL | REMARKS |
|------|-----|------------------------------|-----------------|-----------|
| 1 | 1 | UPPER WEARING RING | PHOSPHOR BRONZE | SEE NOTES |
| 2 | 1 | LABYRINTH SEAL RING | ALUMINIUM | SEE NOTES |
| 3 | 24 | M10 x 45LG C/SK SOCKET SCREW | H.T.S | SEE NOTES |
| 4 | 24 | M8 x 30LG C/SK SOCKET SCREW | H.T.S | SEE NOTES |
| 5 | 1 | LOWER WEARING RING | PHOSPHOR BRONZE | SEE NOTES |

| |
|---|
| SURFACE ROUGHNESS ISO R468 Ra VALUES |
| 3.2 |
| 1.6 |
| 0.8 |

| | | | | | | | | | | |
|--------------------------|-----|------------|----------------------------|----------------|------|-----|------|---|--------------------|---------------------|
| | | | | | | | | | 13.45/304 | SHEET 2 |
| | | | | | | | | | 13.45/305 | LABYRINTH SEAL RING |
| 28 | 04 | 11/02/2001 | REDRAWN ON CAD FOR CLARITY | N.B. | | | | | | |
| D.O. | REV | DATE | REVISION | REV | CHKD | APP | AUTH | KKS | REFERENCE DRAWINGS | |
| AUTHORISED FOR ESKOM BY: | | | | CLASSIFICATION | | | | KRIEL POWER STATION BOILER 1-3,10.8E PF MILLS LABYRINTH AIR SEAL RING | | |
| CODIFICATION BY: | | | | PBS PATH | | | | | | |
| APPROVED BY: | | | | | | | | | | |
| | | | | | | | | | | |
| CHECKED BY: | | | | | | | | DETAIL DRAWING | | |
| Frik Le Roux | | | | | | | | | | |
| CREATED BY: | | | | | | | | | | |
| W.Badenhorst 11/02/01 | | | | | | | | | | |
| SCALE | | | | AS SHOWN | | | | 13.45/304 | | |
| | | | | | | | | SHT 1-2 | | |
| | | | | | | | | REV 4 | | |