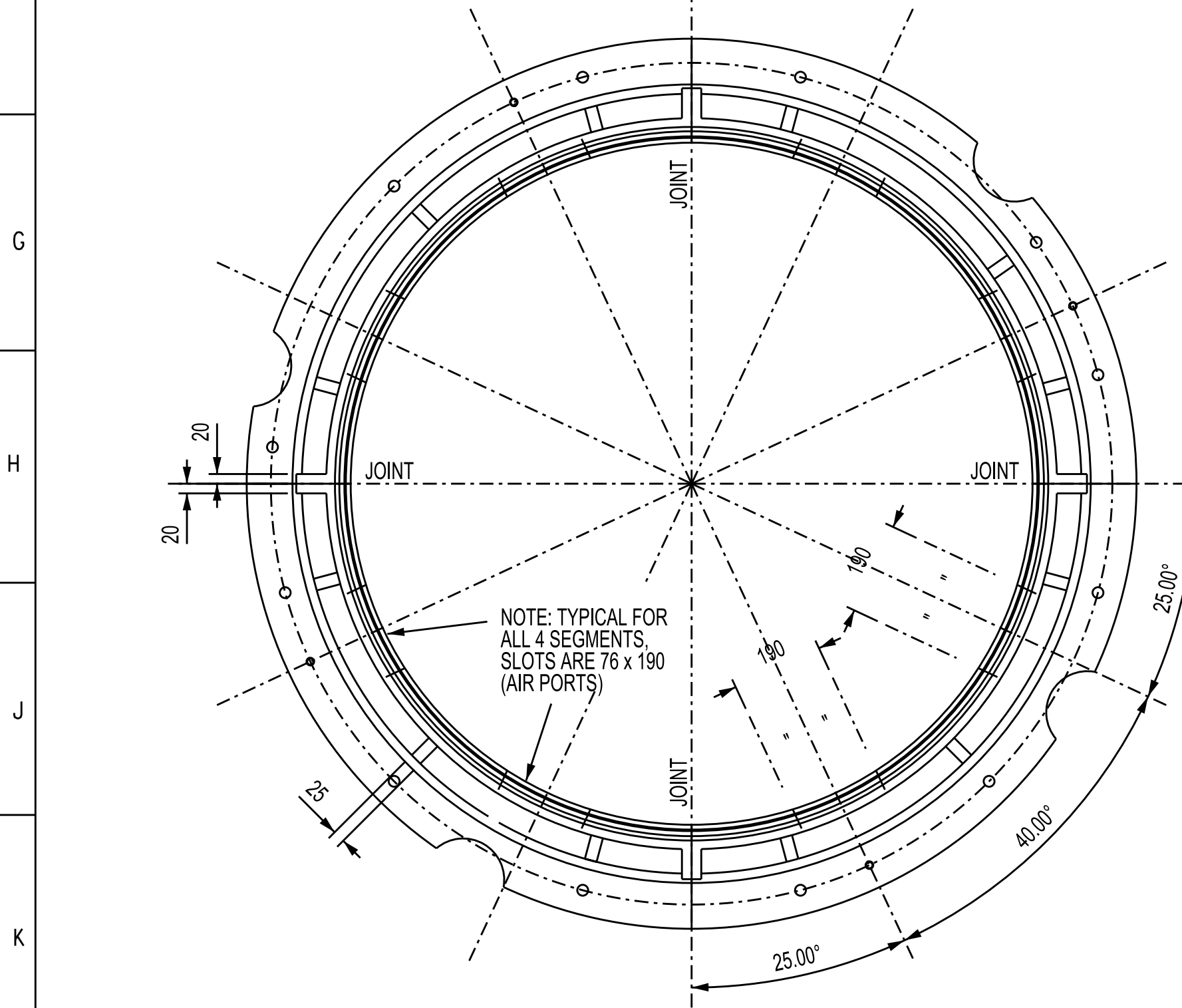


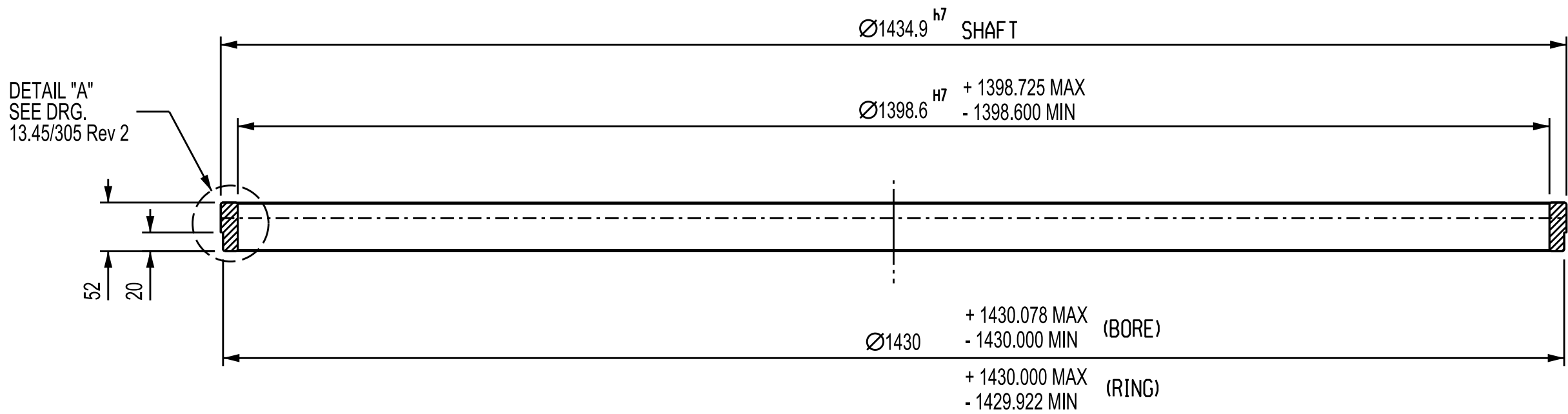
BOLT POSITIONING  
FOR ITEM 1 AND 2  
SCALE 1:10

DRILL & TAP 24 HOLES  
TO FIT M10 x 12.6 LG

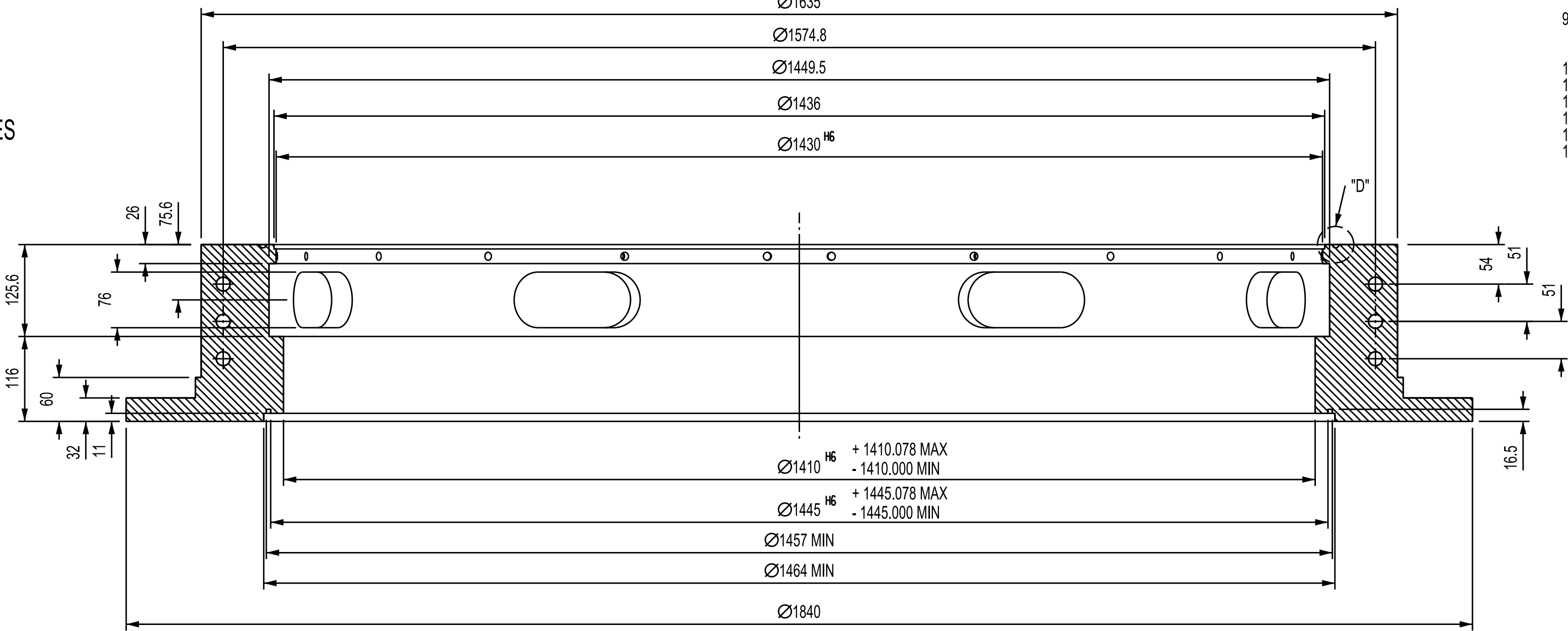


SLOT POSITION  
FOR ITEM 2  
SCALE 1:10

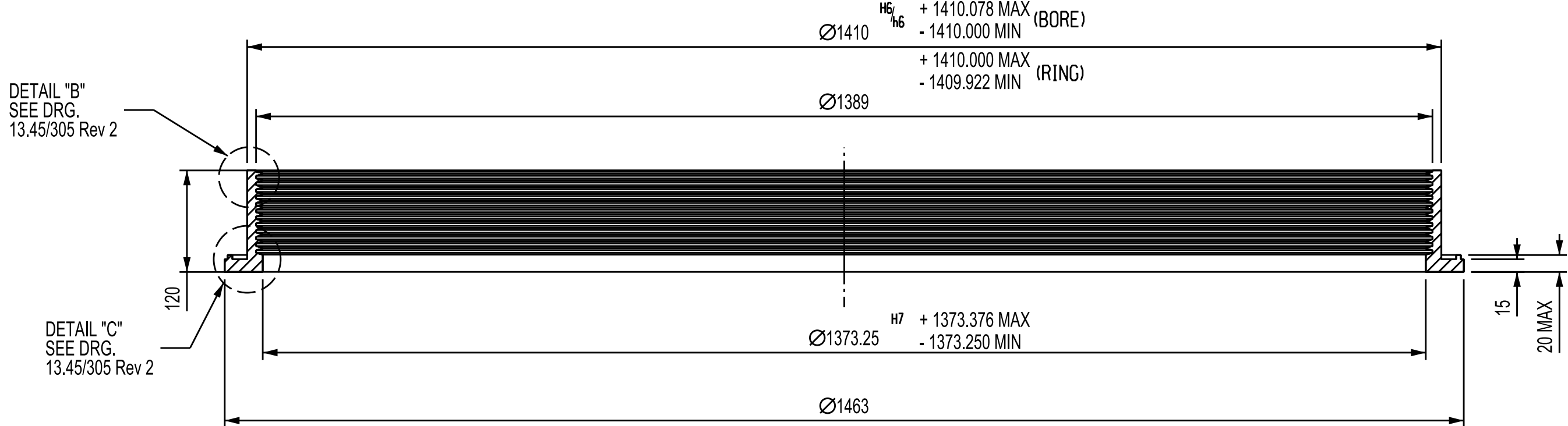
SURFACE ROUGHNESS ISO R468 Ra VALUES	
3,2	
1,6	
0,8	



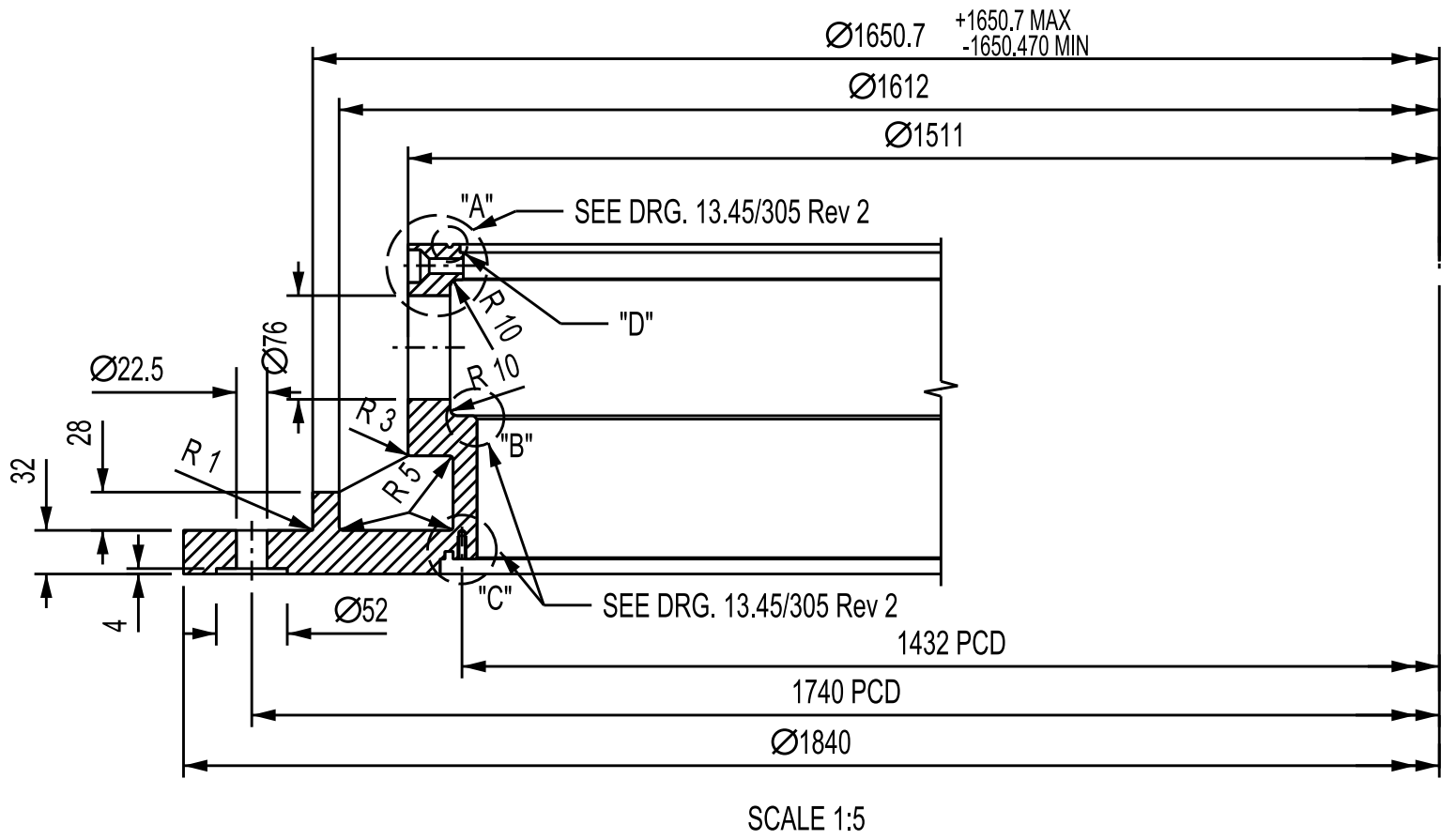
UPPER WEARING RING  
SECTION, ITEM 1  
SCALE 1:5



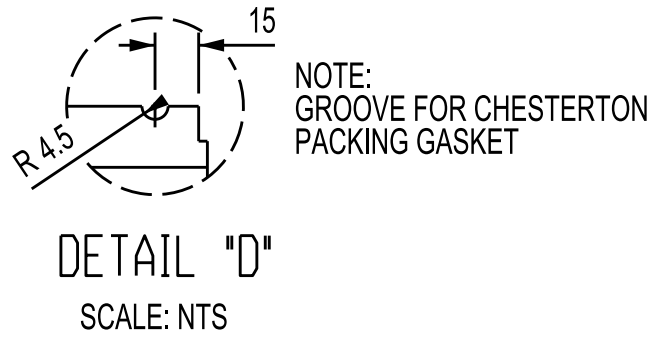
LYBYRINTH SEAL RING  
SECTION, ITEM 2  
SCALE 1:5



LOWER WEARING RING  
SECTION, ITEM 5  
SCALE 1:5



SCALE 1:5



DETAIL "D"  
SCALE: NTS

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

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

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  $\pm 0.25$
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  $\pm 3$
14. TOLERANCE ON CASTING THICKNESS  $\pm 3$
15. MACHINE WHERE SHOWN THIS

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

28	04	04/02/08	REDRAWN ON CAD FOR CLARITY	W.B.					13.45/304	SHEET 1
D.O.	REV	DATE	REVISION	REV	CHKD BY	APP BY	AUTH BY	KKS APP	13.45/305	LABYRINTH SEAL RING
AUTHORISED FOR ESKOM BY:				CLASSIFICATION				REFERENCE DRAWINGS		
CODIFICATION BY:				KRIEL POWER STATION BOILER 1-3, 10.8E PF MILLS LABYRINTH AIR SEAL RING				DETAIL DRAWING		
APPROVED BY:										
CHECKED BY:										
CREATED BY:				ESKOM HOLDINGS SOC LTD REG NO 2002/015927/30				13.45/304		
W.Badenhorst 04/02/08								SHT 2-2		
SCALE AS SHOWN								REV 4		