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|-------------------------------|-------------------|---|---------|---------|-----------------|----------------|----------------------------------|----------------------------------|---------|---------|-----------------|--------------|----------------------------------|
| DRG. No. EL33621B | SHT. No. 1 | ALTERATION SHEET ISSUE NO. SHOWN ENCIRCLED THUS: ○ LATEST ISSUE CANCELS ALL PREVIOUS ISSUES | | | | | | FILENAME = /RLM1600/3/A000013735 | | | | | |
| FOR DRAWING ISSUE SEE SHEET 1 | | SHT. ISS. 2 | DATE | INITIAL | "A" or "G" FORM | DESCRIPTION | SHEET REVISED AT DRAWING ISSUE * | SHT. ISS. 3 | DATE | INITIAL | "A" or "G" FORM | DESCRIPTION | SHEET REVISED AT DRAWING ISSUE * |
| | | A | 23/8/93 | KB | W356 | PLANNING ISSUE | DCP4105W | 1 | 27/8/93 | KB | A15964 | SHEET ISSUED | 1 |

REVISIONS

| ZONE | LTR | DESCRIPTION | DATE | APPROVED |
|------|-----|--|----------|-----------------------|
| A | | DESIGN ACTIVITY TRANSFERRED PER WR GE4S60466 | 04-03-11 | E. TORRES M.A. OTT |

1. THIS COMPONENT IS A TRACEABLE PART IN ACCORDANCE WITH E.G.T.521101, CODE AND IDENTIFICATION NUMBERS TO BE MAINTAINED THROUGH ALL STAGES OF MANUFACTURE. NUMBERS TO BE MARKED IN ACCORDANCE WITH E.G.T.521102 (IDENT MARKING).
3. MINIMUM QUALITY STANDARD. COMPONENT MUST CONFORM TO E.G.T.950420.
6. AFTER FINAL MACHINING PART MUST MEET FLUORESCENT DYE PENETRANT INSPECTION TO E.G.T.526214 CLASS 3 SEE TABLE BELOW.
7. MACHINE ALL OVER TO 63 MICROINCHES.
8. SILVER PLATE .0002-.0006 THICKNESS ON THREAD TO AMS2410
9. SAME AS EL33621A AT ISSUE 1 EXCEPT THREAD LENGTH AND SILVER PLATING

| FLUORESCENT PENETRANT INSPECTION REQUIREMENTS | | | |
|---|--------|--------|--------------------|
| ALLOWABLE INDICATIONS | | | |
| AREA | MAX LG | MIN SP | OTHER REQUIREMENTS |
| ALL | .062 | .250 | MAX OF 10 ALLOWED |

SPECIAL INSTRUCTIONS

- 1) INDICATIONS INTERPRETED AS CRACKS NOT ALLOWED
- 2) NO INDICATIONS ALLOWED WITHIN .250 OF HOLES
- 3) INDICATIONS MUST NOT BE IN FILLETS OR CROSS CORNERS
- 4) INDICATIONS .030 AND SMALLER ARE CONSIDERED NON INTERPRETABLE & ARE ALLOWED IN ANY AREA EXCEPT INDICATIONS MUST BE EITHER SEPARATED BY AT LEAST .250 OR SPACED SO THAT THERE ARE NO MORE THAN 5 INDICATIONS IN ANY .500 Ø CIRCLE

DESIGN RESPONSIBILITY TRANSFERRED FROM CAGE CODE K0140 TO CAGE CODE 07482 ON (04-03-11)

ENGINEERING DATA MANAGEMENT SYSTEMS AT GEAE (07482) USE A DASH IN LIEU OF A SLASH IN THE PART NUMBER AND DRAWING NUMBER SPECIFICATIONS REFERENCED IN THIS DRAWING WITH THE PRE-FIX RGT, EGT OR GTT ARE NOW PRE-FIXED WITH 07482 (EXAMPLE 07482-412002)

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|-------------|--------------|------------------------|---|---|-----------------|
| DRAWN | G.KNIGHT | C.A.D DRAWING | GEOMETRICAL TOLERANCES TO BS 308. GENERAL MACHINING TOLERANCES (U.O.S.) :- HOLES AND INTERNAL SURFACES: SIZE TO + .010" SHAFTS AND EXTERNAL SURFACES: SIZE TO - .010" CENTRE DISTANCES AND CENTRES TO FACES ± .005" ANGLES: ± 0°-30' | MATERIAL :- BS970 420S29S | |
| CHECKED | S.WINTERTON | THIRD ANGLE | ALL DIMENSIONS ARE IN INCHES (U.O.S.). ALL THREADS CLASS 2 MEDIUM FIT (U.O.S.). WELDING SYMBOLS TO E.G.T. STD 400001. REMOVE ALL BURRS & SHARP EDGES (U.O.S.). UNLESS OTHERWISE SPECIFIED SURFACE FINISH ACCEPTED AS CAST, FORGED, WELDED, FLAME CUT ETC. | EST. MASS: lbs ACTUAL MASS: lbs | |
| DATE | 12/8/93 | PROJECTION | SURFACES MARKED ✓ TO BE MACHINED. MACHINING SURFACE FINISH TO BE 125 U' CLA (U.O.S) | FOR INTERPRETATION OF CLASSIFICATION SYMBOLS USED ON THIS DOCUMENT REFER TO E.G.T. STANDARD 412002. THE HIGHEST CLASSIFICATION USED ON THIS DOCUMENT IS:- | |
| APPROVED: | | SCALE: - | | CHARACTERISTICS CLASSIFIED AT GRID REF | ENGIN' APPROVAL |
| DRAUGHTING | A.C.THOMPSON | A | | | |
| DESIGN | S.WINTERTON | (DO NOT SCALE PRINT) | | | |
| ENGINEERING | K.W.R.MORE | | | | |
| PRODUCTION | - | | | | |
| QUALITY | I.MOIG | | | | |
| LAB | - | | | | |

EUROPEAN GAS TURBINES

GEC ALSTHOM

BOROSCOPE PLUG

DRG. No. **EL33621B** SHT No. **1**