



AREAS:  
 SEGMENTS: 32 OPENINGS (COLD)  
 TIP CHECK ON 99.044-0 - THROAT = 1.823 PITCH = 6.410  
 PITCH ON 97.904-0 - THROAT = 1.445 PITCH = 5.490  
 ROOT CHECK ON 76.782-0 - THROAT = 1.111 PITCH = 3.61  
 COLD CALCULATED EXIT CHECKING AREA = 0.27.70 SQ IN  
 JOINTS: 16 OPENINGS (COLD)  
 TIP CHECK ON 99.044-0 - THROAT = 1.003 PITCH = 4.590  
 PITCH ON 97.904-0 - THROAT = 1.535 PITCH = 5.840  
 ROOT CHECK ON 76.782-0 - THROAT = 1.164 PITCH = 3.140  
 COLD CALCULATED EXIT CHECKING AREA = 0.22.61 SQ IN

DESIGN AREA: (HOT) = 966.75 SQ IN  
 (COLD) = 826.7 SQ IN  
 (COLD CALCULATED AREA USING TIP CHECK & ROOT CHECK SECTS)  
 MFG CHECK AREA: 946.75 = 9.95 SQ IN  
 (±1.0% COLD CALC. NOM)

- NOTES:
- RESTORE FRESH TO GAS PATH SIDE OF INTERNALS AND VAMES AS SPECIFIED IF NECESSARY.
  - WATER WASH AND DISMANTLE NOZZLE AND DIAPHRAGM SEGMENTS.
  - NOZZLE SEGMENT AND DIAPHRAGM MUST BE LOADED ON SURFACES INDICATED BY "M" TO AVOID RADIAL OR AXIAL CHECKS. AFTER ASSEMBLY IN THIS CASE, LOAD SEGMENTS DOWNSTREAM AND CHECKWISE (LOADING DOWNSTREAM) AND COMPLETE AREA CHECK IS TO BE MADE AND REPORTED TO DIESEL OR CHECK SHEET (PT 900). ALSO RECORD INNER AND OUTER HOPE AND DIAPHRAGM SIGNAL GAPS AT ENTRANCE AND EXIT SIDES.
  - GROUP CHECKS TO BE RECORDED ON CHECK SHEET (PT 900). GAP CHECKS TO BE RECORDED ON CHECK SHEET (PT 464).
  - IN ADDITION TO THE ABOVE MANUFACTURING CHECKS, ALL FIELD ASSEMBLY OF NOZZLE SECTIONS MUST HAVE DATA MEASURED AND RECORDED ON PT 900. (PT 900 AND CHECK SHEET) AND SUBMITTED TO GREENVILLE MECH. ENGINEERING FOR RECORD PURPOSES.
  - ALL WELDS PER PER-AGI (II)
  - AREA CHECK PER ITEM 14 AND ITEM 15. 1.8X (57)W FROM 4 TO 14 IMPULSES PER REVOLUTION.

STAKE PLUG (PT 4) IN PLACE OVER TUBES IN TURBINE CASE (4 PLACES EA. PLUG)  
 TYP ASM OF NOZZLE RETAINING PIN FOR SEGMENTS 2 THRU 7 AND 10 THRU 12 (12 PLACES TOTAL)  
 VIEW B-9 (8-0)

TYP ASM OF NOZZLE RETAINING PIN FOR SEGMENTS 8, 11 & 14 (4 PLACES TOTAL)  
 SECTION D-12 (0-4) ROTATED 195° CCW

REMOVE THIS PORTION OF OUTER WALL AT HOOK OVER THE LEAD INDICATED AS SHOWN  
 CL GAP  
 (5L.840 R)  
 VIEW E-13 (F-12)  
 STAKE 4 PLACES SOLENET. TYP PARTS 27120  
 END OF IC MUST CONTACT INNER END OF PITS 27128  
 GADE EXHAUST TURBINE INTO END OF PITS 27128 UNTIL PROPERLY SEATED  
 HETS 2748 MUST MAKE AGAINST THIS SURFACE BEFORE SIGNATURE  
 DETAIL H-13 (C-5) TYP 2 PLACES  
 BOTTOM PIN (PT 5) & STAKE DIAPH. INTO GROOVE IN PIN (4 PLACES) TO LOCK  
 VIEW J-13 (J-13)  
 SECTION J-14 (F-8) ROTATED 106.30° CCW ASSEMBLY OF DIAPHRAGM PIN TYP 1 PLACE PER SEGMENT 16. SEGMENTS TOTAL

GROUP DESCRIPTION  
 1 NOZZLE PIN (COATED)  
 2 NOZZLE PIN (UNCOATED)  
 3 NOZZLE PIN (UNCOATED)  
 4 NOZZLE PIN (UNCOATED)

REPAIRS

NOZZLE SEGMENT	NOZZLE PIN	DIAPHRAGM PIN	DIAPHRAGM PIN	DIAPHRAGM PIN
1	1	1	1	1
2	1	1	1	1
3	1	1	1	1
4	1	1	1	1
5	1	1	1	1
6	1	1	1	1
7	1	1	1	1
8	1	1	1	1
9	1	1	1	1
10	1	1	1	1
11	1	1	1	1
12	1	1	1	1
13	1	1	1	1
14	1	1	1	1
15	1	1	1	1
16	1	1	1	1

*Handwritten note:* 3/17/70  
 DTTP