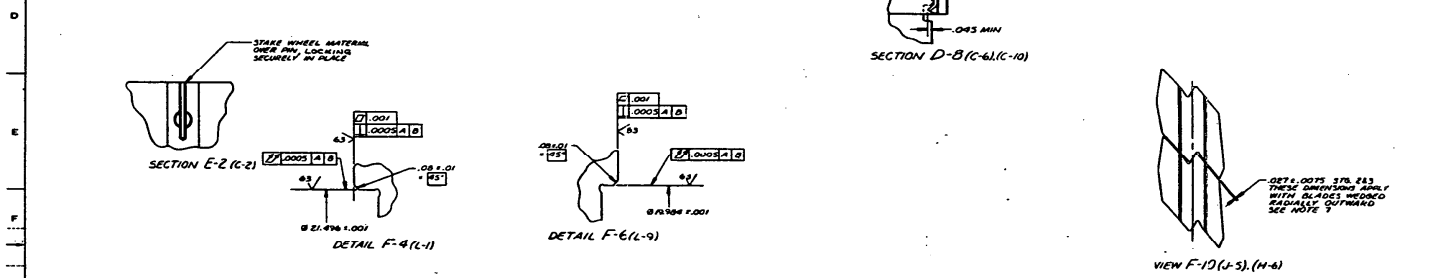
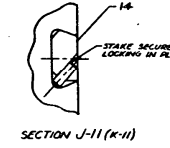
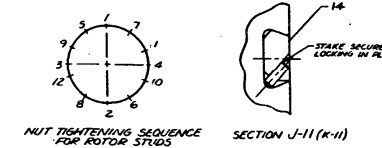
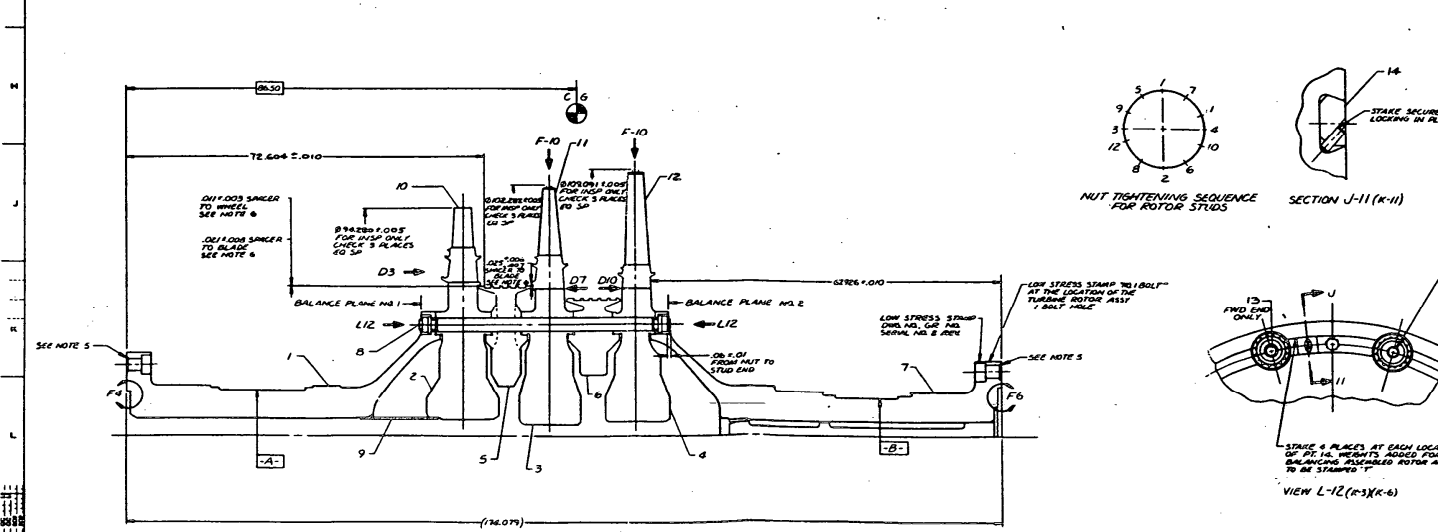


- NOTES:
- FOR ASSEMBLY INSTRUCTIONS SEE ITEM 2.
 - MOMENT WEIGH ALL BLADES. LOCATION DERIVED BY COMPUTER PROGRAM PER ITEM 4.
 - AFTER BLADES AND LOCKING PINS ARE ASSEMBLED, PUSH RADIAL LOCKING PIN INWARD AS FAR AS POSSIBLE AND CHECK TO INSURE THAT THE LOCKING BLADE IS SECURELY LOCKED.
 - DURING ASSEMBLY THE STAGE 2 BLADES SHALL BE SUSPENDED FROM CUSHING THE SPACER SEAL TOOTH SO THAT THE AFT SIDE OF THE BLADE AND WHEEL DOVETAILS ARE ALIGNED.
 - MEASURE THE RUNOUT OF THE FLANGE FACE RELATIVE TO THE AXIS ESTABLISHED BY [A] & [B] ON A RADIAL LINE THRU THE BOLT HOLE NEAREST THE POINT WHERE THE RUNOUT SHOWS THE SURF TO BE AT ITS MAX. MATERIAL POSITION. LOW STRESS STAMP THE RUNOUT VALUE ON THE FLANGE OD.
 - RECORD SPACER CLEARANCES ON ITEM 3. SPACER TENS MUST BE NORMALIZED PRIOR TO MEASUREMENT.
 - SHIM THE NON-PRESSURE SIDE OF THE SHROUD GAP WHILE HOLDING THE GAPS ZERO AS POSSIBLE WITHOUT DAMAGING THE BUCKETS. THE TOTAL GAP SHALL FALL BETWEEN 2.484-.690.



- LOW STRESS STAMP "T" ON WHEEL BELOW THE BUCKET DOVETAIL AT THE ASSEMBLY LOCATION OF THE FIRST BUCKET LISTED IN THE BUCKET CHARTING PROGRAM. LOW STRESS STAMP "S" AT THE LOCATION OF THE SECOND BUCKET. STAMPING SHOULD BE DONE ON THE FWD FACE OF STG 1 WHEEL AND ON THE AFT FACE OF STG 2 & 3 WHEELS.



1	ANODE FIRST LOCK STRONG IDENTIFIED
2	BY STAMPING
3	BY STAMPING
4	BY STAMPING
5	BY STAMPING
6	BY STAMPING
7	BY STAMPING
8	BY STAMPING
9	BY STAMPING
10	BY STAMPING
11	BY STAMPING
12	BY STAMPING