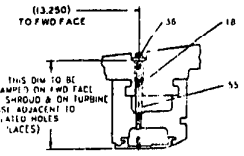
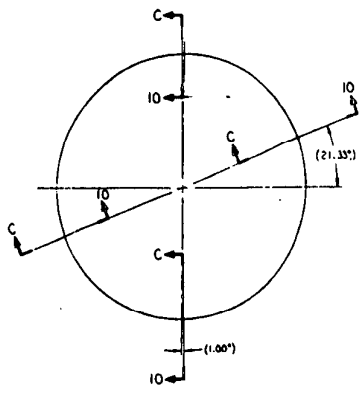
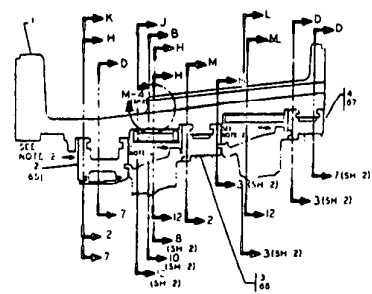


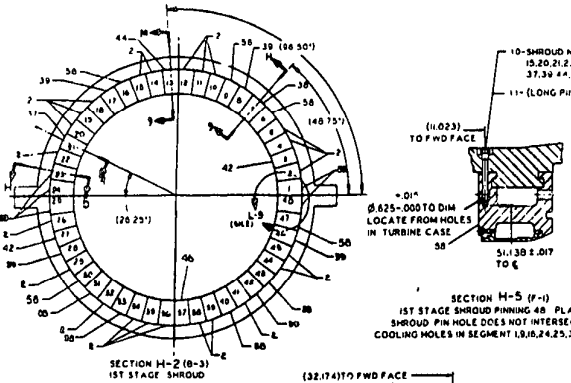
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- NOTES:
1. INSULATION BOLTS TO BE TOPLOADED UP SHROUD BACKED OFF ONE HALF TURN & LOCKED.
 2. LOAD SHROUDS IN DIRECTION SHOWN BEFORE DRILLING.
 3. SET WL ITEM 0234 FOR FIELD TEST INSTRUCTIONS FOR STG 1 SHROUD PINS.
 4. ASSEMBLY OF SHROUDS WITH THREADED FASTENING HOLES SHALL BE AVOIDED WHERE RADIAL THRU HOLES TAKE PLACE.
 5. FOR FIELD REPLACEMENT OF FIRST STAGE SHROUDS HOLES MUST BE DRILLED PRIOR TO FINAL FIELD ASSEMBLY.



SECTION C-10 (A-77B-B7C-A7C-7)
 PROBE HOLES IN PLACES
 SHROUDS 313, 27, & 37

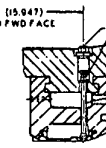


SECTION M-5 (P-1)
 1ST STAGE SHROUD PINNING 48 PLACES.
 SHROUD PIN HOLE DOES NOT INTERSECT
 COOLING HOLES IN SEGMENT 1, 9, 16, 24, 25, 33, 40, & 48

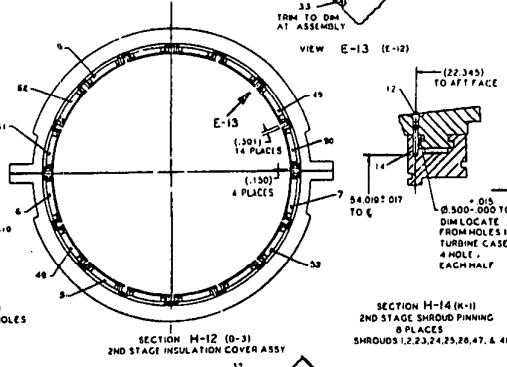
SECTION D-7 (B-3)
 1ST STAGE PROBE HOLES

ORIENTATION TABLE E-7 (SEE SECTION M-7)

NO.	L	HOLE	L	HOLE	L
1	0M17	17	122.433°	33	0M17
2	4.933°	18	129.433°	34	28.733°
3	13.433°	19	137.433°	35	25.433°
4	20.933°	20	144.933°	36	26.433°
5	32.433°	21	152.433°	37	27.2433°
6	42.56°	22	159.933°	38	27.933°
7	47.433°	23	170.067°	39	28.4°
8	54.933°	24	0M11	40	0M11
9	0M17	25	0M11	41	309.433°
10	63.933°	26	109.933°	42	309.933°
11	73.433°	27	119.433°	43	317.433°
12	84.933°	28	124.933°	44	324.933°
13	92.433°	29	127.433°	45	328.433°
14	99.933°	30	128.433°	46	333.933°
15	107.433°	31	127.433°	47	350.067°
16	0M11	32	234.933°	48	0M11

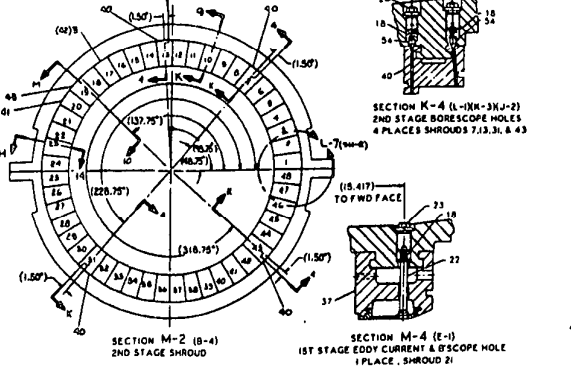


SECTION H-9 (E-3)
 1ST STAGE BORESCOPE HOLES
 SHROUDS 7, 13, 31, & 43

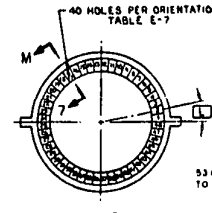


SECTION M-12 (D-3)
 2ND STAGE INSULATION COVER ASSY

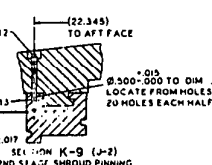
SECTION H-14 (K-11)
 2ND STAGE SHROUD PINNING
 8 PLACES
 SHROUDS 1, 2, 3, 24, 25, 26, 47, & 48



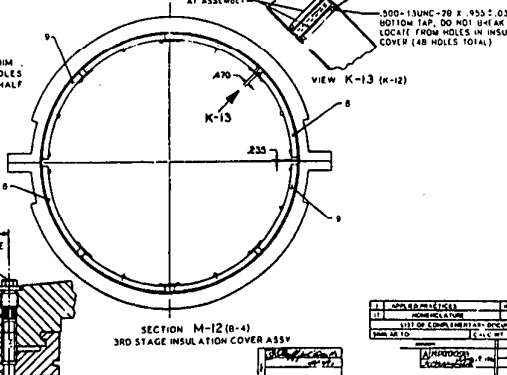
SECTION K-8 (L-11K-3KJ-2)
 2ND STAGE BORESCOPE HOLES
 4 PLACES SHROUDS 7, 13, 31, & 43



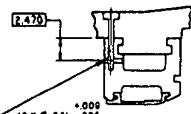
SECTION K-7 (B-3)
 1ST STAGE SHROUD



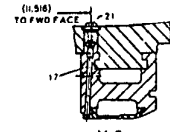
SECTION K-9 (J-2)
 2ND STAGE SHROUD PINNING
 40 PLACES



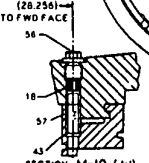
SECTION M-12 (B-4)
 3RD STAGE INSULATION COVER ASSY



SECTION M-4 (E-1)
 1ST STAGE EDDY CURRENT & SCOPE HOLE
 1 PLACE, SHROUD 21



SECTION M-9 (D-2)
 1ST STAGE BORESCOPE HOLES
 7 PLACES
 SHROUDS 6, 13, 17, 21, 26, 42, & 48



SECTION M-10 (J-1)
 2ND STAGE BORESCOPE HOLE
 1 PLACE SHROUD 10

SECTION M-7 (J-6)
 1ST STG COOLING AIR HOLES

NO.	HOLE DIMENSIONS	POSITION
1	Ø.500 x .005	087
2	Ø.500 x .005	087
3	Ø.500 x .005	087
4	Ø.500 x .005	087
5	Ø.500 x .005	087
6	Ø.500 x .005	087
7	Ø.500 x .005	087
8	Ø.500 x .005	087
9	Ø.500 x .005	087
10	Ø.500 x .005	087
11	Ø.500 x .005	087
12	Ø.500 x .005	087
13	Ø.500 x .005	087
14	Ø.500 x .005	087
15	Ø.500 x .005	087
16	Ø.500 x .005	087
17	Ø.500 x .005	087
18	Ø.500 x .005	087
19	Ø.500 x .005	087
20	Ø.500 x .005	087
21	Ø.500 x .005	087
22	Ø.500 x .005	087
23	Ø.500 x .005	087
24	Ø.500 x .005	087
25	Ø.500 x .005	087
26	Ø.500 x .005	087
27	Ø.500 x .005	087
28	Ø.500 x .005	087
29	Ø.500 x .005	087
30	Ø.500 x .005	087
31	Ø.500 x .005	087
32	Ø.500 x .005	087
33	Ø.500 x .005	087
34	Ø.500 x .005	087
35	Ø.500 x .005	087
36	Ø.500 x .005	087
37	Ø.500 x .005	087
38	Ø.500 x .005	087
39	Ø.500 x .005	087
40	Ø.500 x .005	087
41	Ø.500 x .005	087
42	Ø.500 x .005	087
43	Ø.500 x .005	087
44	Ø.500 x .005	087
45	Ø.500 x .005	087
46	Ø.500 x .005	087
47	Ø.500 x .005	087
48	Ø.500 x .005	087