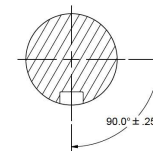
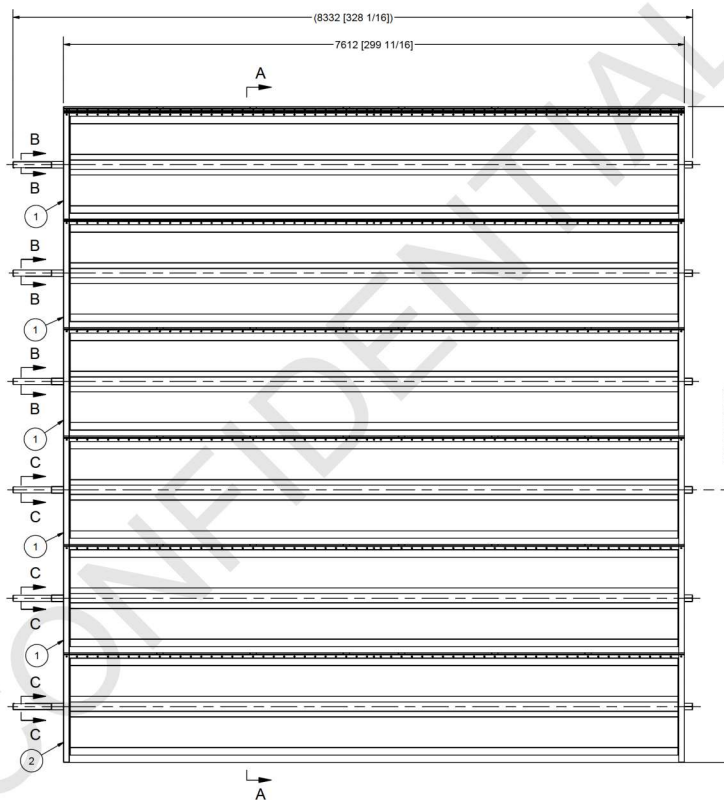
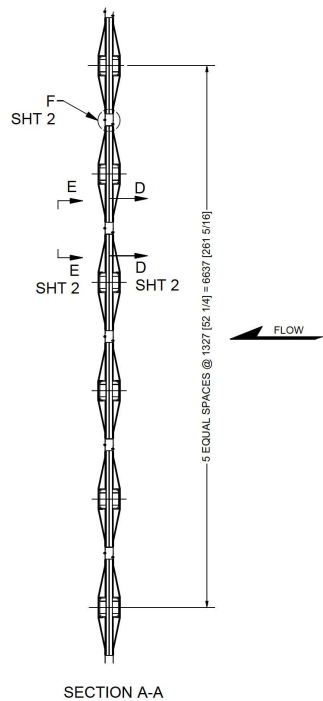
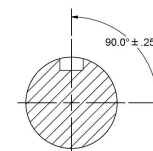


- NOTES:
1. DIMENSIONS ARE MILLIMETERS [INCHES]
  2. INSTALL BLADES WITHOUT SEALS INTO FRAME BEFORE FINAL WELDING OF SIDE FRAME.
  3. CHECK BLADE SEAL EDGE TO ADJOINING BLADE EDGE WHEN BLADE IS IN CLOSED POSITION. EDGES TO BE IN SAME PLANE WITHIN #2 [1/16].
  4. CHECK BLADE ROTATION BEFORE INSTALLING SEALS.
  5. TORQUE SEAL BOLTS TO 11 Nm [8 Ft/Lbs] AND TACK WELD NUT TO BOLT.
  6. USE ANTI-SEIZE ON ALL THREADED FASTENERS PRIOR TO INSTALLING HEX NUT.
  7. **CRITICAL:** CLAMP BARS SHALL BE INSTALLED ON DOWNSTREAM SIDE OF BLADES.

ITEM	QTY	PART NUMBER	DESCRIPTION	MATERIAL	DESIGNATION	MATERIAL LIST DESCRIPTION
1	5	314481	BLADE WELDMENT 1			WELDMENT
2	1	314482	BLADE WELDMENT 2			WELDMENT
3	72	301471	SEAL, BLADE, LEAF, C276 ST, 0.56 mm, 61 mm, 1219 mm	C276 ST	0.56 mm	61 mm x 1219 mm
4	48	301472	CLAMP BAR	C276	3 mm	25 mm x 1141 mm
5	24	301474	CLAMP BAR	C276	3 mm	25 mm x 1180 mm
6	12	314483	SEAL, BLADE, LEAF, C276 ST, 0.56 mm, 61 mm, 755 mm	C276 ST	0.56 mm	61 mm x 755 mm
7	12	314485	CLAMP BAR	C276	3 mm	25 mm x 675 mm
8	732	158286-1082	BOLT, HEX, M8 X 1.25 X 20	Titanium		
9	732	160607-0138	NUT, HEX, M8 X 1.25	Titanium		



SECTION B-B  
SCALE 1/2



SECTION C-C  
SCALE 1/2

ELEVATION VIEW / FLOW INTO PAPER

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DO NOT SCALE PRINT. DIMENSIONS APPLY TO AFTER FINISHED CONDITION. REMOVE ALL SHARP EDGES & BURRS UNLESS OTHERWISE NOTED. DIMENSION TOLERANCES ARE FABRICATION. MACHINING.

UNIT	MM - X 0.0010	IN - X 0.001
ANGLE	° - X 0.01	° - X 0.1
DEPTH	MM - X 0.0010	IN - X 0.001
DRILL	MM - X 0.0010	IN - X 0.001
ASSEMBLY	MM - X 0.0010	IN - X 0.001

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REF BOM

DATE	15-FEB-18	SCALE	1:30
OPERATOR	12-MAR-18	REV	1 OF 2
DESIGNED BY	13-MAR-18		

TITLE: **BLADE ASSEMBLY**

NO: **314480**

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