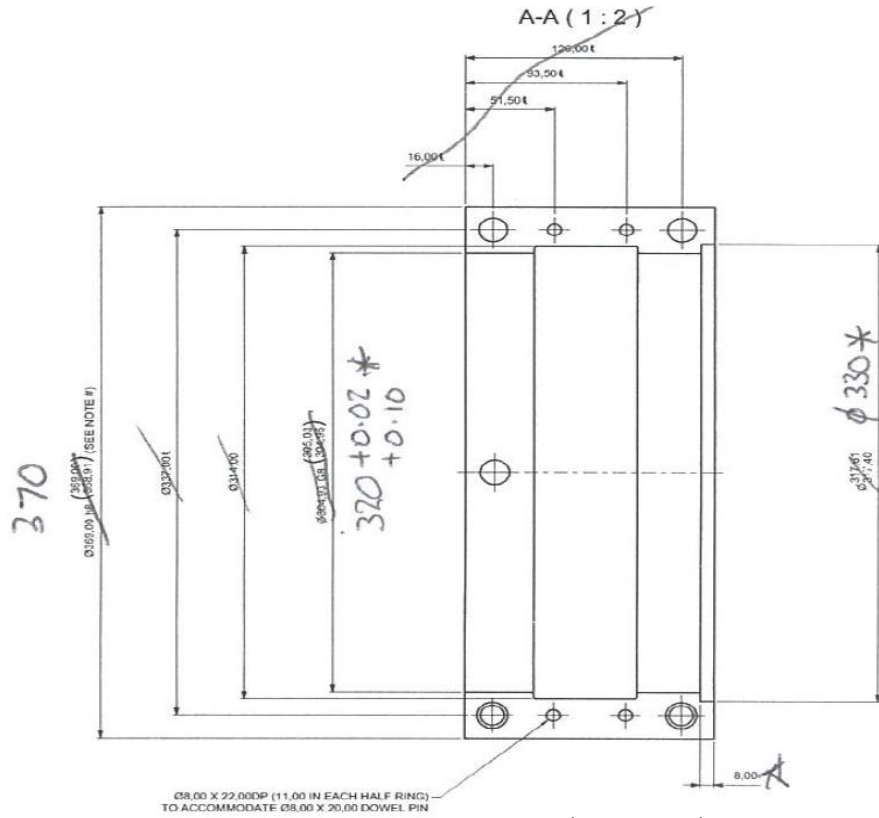


**TANA MACHINES TURBINE SHAFT SLEEVES.**

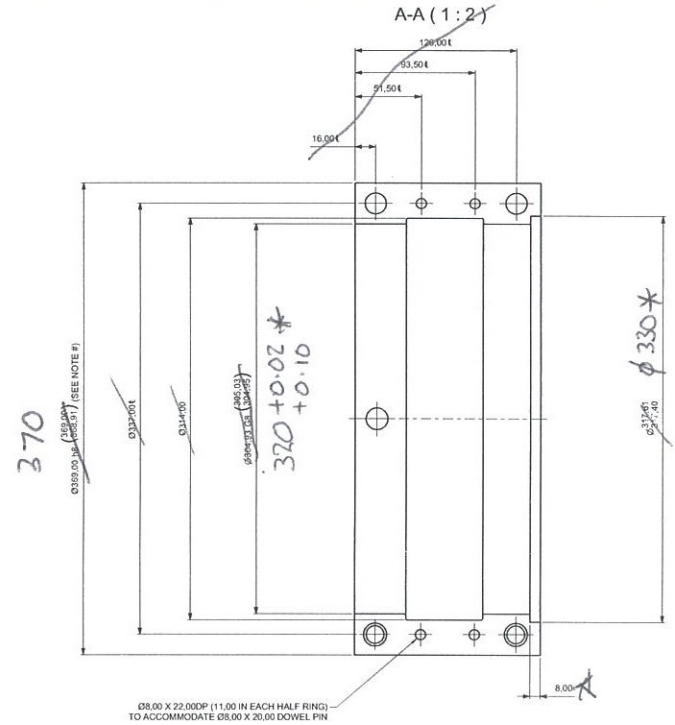
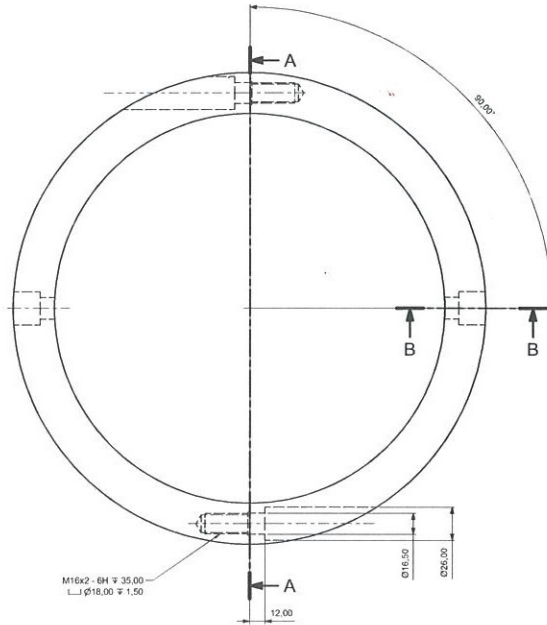
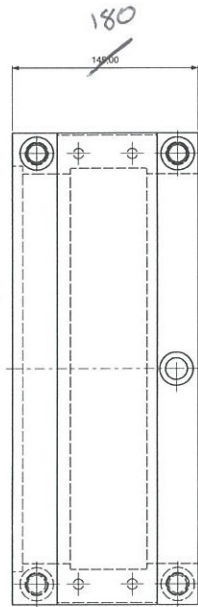
a) Mirira



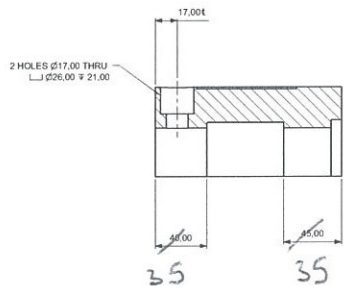
Material: Stainless Steel grade 316 coated with tungsten carbide in portion shown



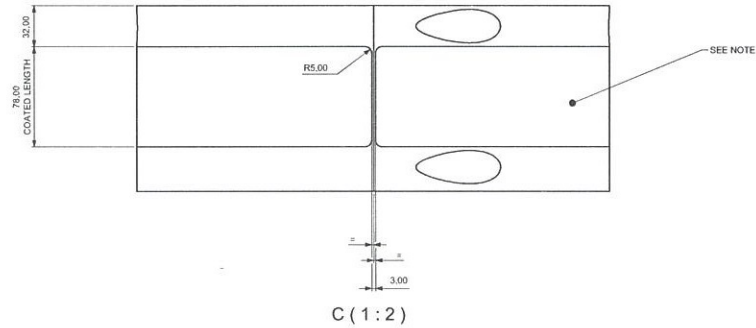
# Mirira



B-B (1:2)



SCALE (1:2)



Note #

Areas to be coated with Tungsten Carbide HVDF hard coating from approved supplier.  
Sleeve OD to be rough machined 0.25mm undersize in area to be coated and 0.2mm oversize either side of coated area and finish machined to 0.6µm to 0.4µm Ra after coating.

**WORKS INSTRUCTIONS**  
RING TO BE ROUGH MACHINED, SPLIT AND THEN STRESS RELIEVED. SPLIT RING MATING FACES TO BE FINISH MACHINED AND MUST BE FEELER GAUGE TIGHT WHEN RE-ASSEMBLED AFTER FINISHED MACHINING.  
EDGES OF SPLIT MATING FACES ARE TO BE LEFT SQUARE AND MUST NOT BE CHAMFERED. BURRS TO BE REMOVED USING AN OIL STONE ONLY.  
FOLLOWING FINAL MACHINING AND PRIOR TO COATING, RINGS ARE TO BE DISASSEMBLED AND CLEANED TO REMOVE ALL TRACES OF CUTTING FLUID/COOLANT ETC. RINGS MUST BE FEELER GAUGE TIGHT WHEN RE-ASSEMBLED.

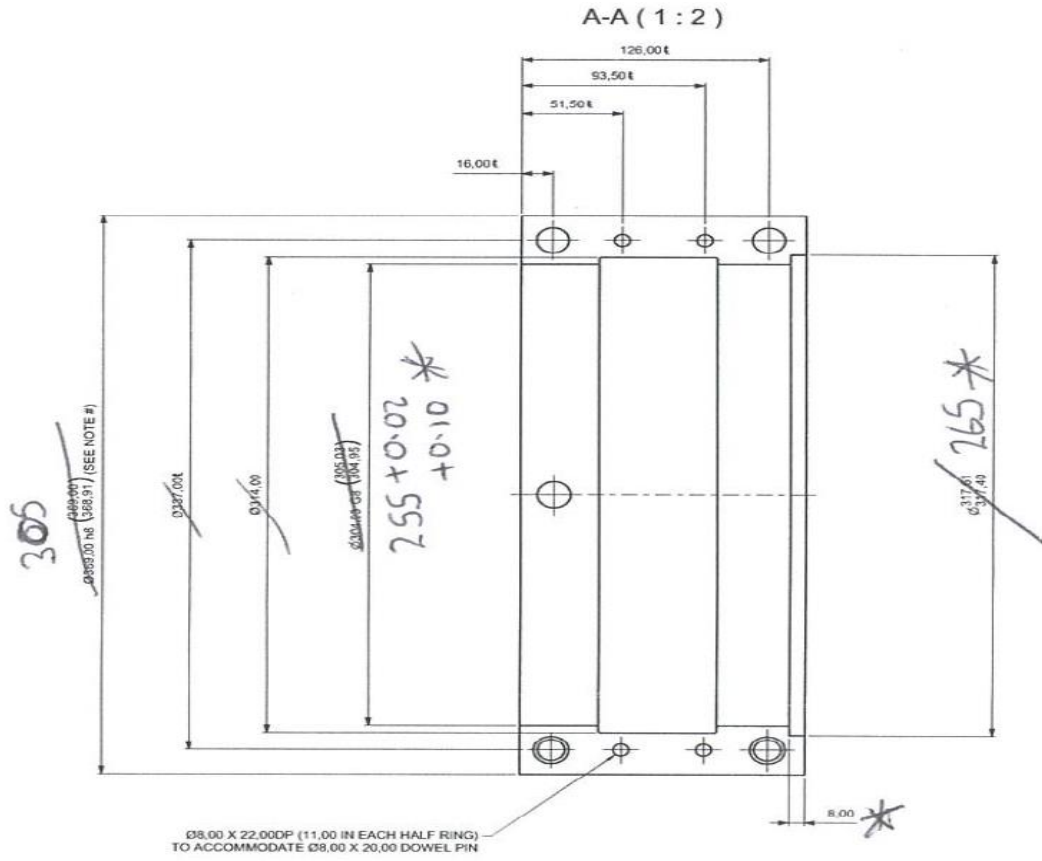
REV	DATE	DESCRIPTION	BY	CHK

IF IN DOUBT - ASK!	PAPER SIZE: A1
ALL DIMENSIONS IN MILLIMETRES UNLESS OTHERWISE STATED	TOLERANCES - UNLESS OTHERWISE STATED
ALL DIMENSIONS UNLESS OTHERWISE STATED	
THIS DRAWING CONTAINS INFORMATION WHICH IS THE EXCLUSIVE PROPERTY OF AND IS UNLAWFUL TO BE REPRODUCED OR DISCLOSED TO A THIRD PARTY OR USED FOR MANUFACTURING PURPOSES WITHOUT THE WRITTEN AUTHORIZATION OF THE OWNER	

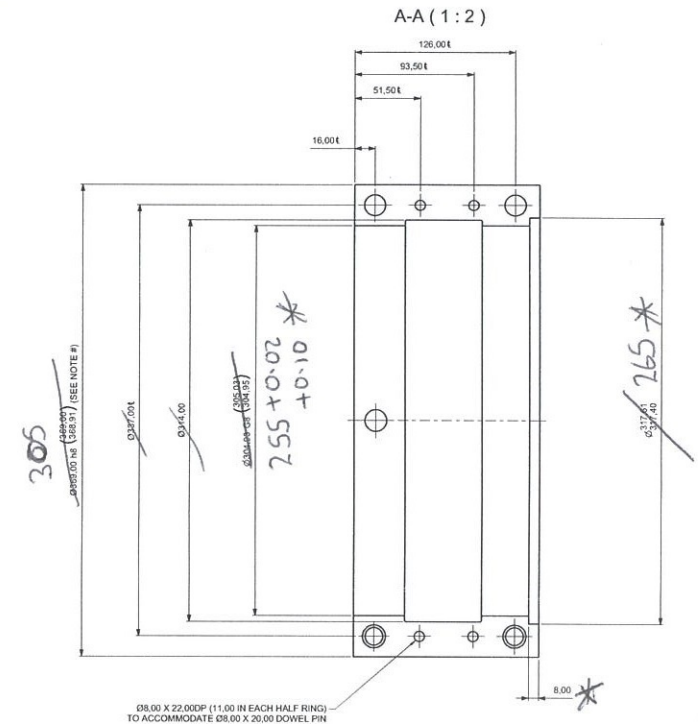
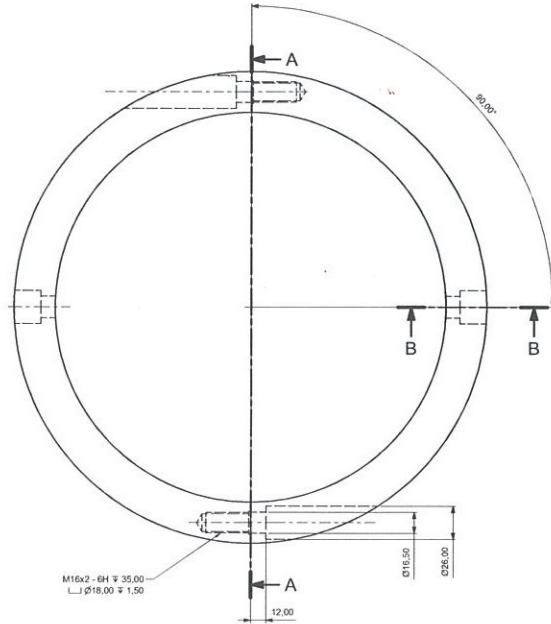
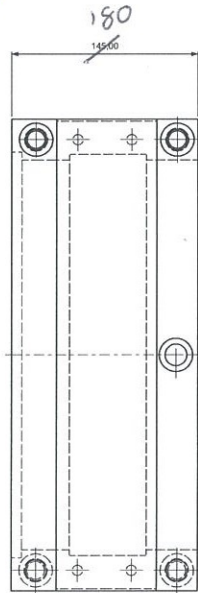
TOLERANCES - UNLESS OTHERWISE STATED			
LINEAR	ANGULAR	FLATNESS	CONCENTRICITY
±0.1	±0.2°	WITHIN 0.05 ACROSS φ	ALL φ TO BE WITHIN 0.05
ALL MACHINED SURFACES TO BE 0.8 µm Ra OR BETTER			REMOVE ALL SHARP EDGES
			R0.1 MAX

Material: Stainless Steel grade 316 coated with tungsten carbide in portion shown

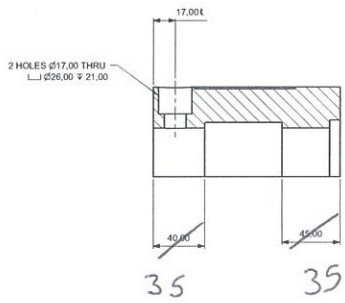
b) Maragwa.



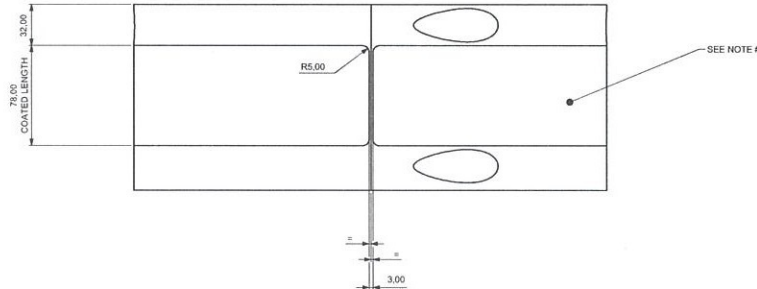
# Maragwa



B-B (1:2)



SCALE (1:2)



C (1:2)



Note #

Areas to be coated with Tungsten Carbide HVOF hard coating from approved supplier.  
Sleeve OD to be rough machined 0.25mm undersize in area to be coated and 0.2mm oversize either side of coated area and finish machined to 0.8µm to 0.4µm Ra after coating.

**WORKS INSTRUCTIONS**  
RING TO BE ROUGH MACHINED, SPLIT AND THEN STRESS RELIEVED. SPLIT RING MATING FACES TO BE FINISH MACHINED AND MUST BE FEELER GAUGE TIGHT WHEN RE-ASSEMBLED AFTER FINISHED MACHINING.  
EDGES OF SPLIT MATING FACES ARE TO BE LEFT SQUARE AND MUST NOT BE CHAMFERED. BURRS TO BE REMOVED USING AN OIL STONE ONLY.  
FOLLOWING FINAL MACHINING AND PRIOR TO COATING, RINGS ARE TO BE DISASSEMBLED AND CLEANED TO REMOVE ALL TRACES OF CUTTING FLUID/COOLANT ETC. RINGS MUST BE FEELER GAUGE TIGHT WHEN RE-ASSEMBLED.

NO.	REV.	BY	DATE
1	000001	ENGLBY	09/04/2014
2	000002	ENGLBY	09/04/2014

IF IN DOUBT - ASK!	PAPER SIZE: A1
ALL DIMENSIONS IN MILLIMETRES UNLESS OTHERWISE STATED	TOLERANCES - UNLESS OTHERWISE STATED
ALL DIMENSIONS SUBJECT TO OUR CONDITIONS OF SALE	
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TOLERANCES - UNLESS OTHERWISE STATED					
LINEAR	ANGULAR	FLATNESS	CONCENTRICITY	SURFACE FINISH	REMOVE ALL SHARP EDGES
±0.1	±0.25°	WITHIN 0.05 ACROSS Ø	ALL Ø TO BE WITHIN 0.05	ALL MACHINED SURFACES TO BE 0.8 µm Ra OR BETTER	R0.1 MAX