

**Blades are machined with 0.075 Dia. End Mill once proper setting is made. No movement of End Mill is permitted except when moving over to machine 0.065 Thickness of Blade. End Mill is set to machine full length of blade. Also, end mill should have 0.020-0.030 radius no sharp corners at bottom of blade.**

**Turbine (Impulse) One Required**

- No. of Blades: 28
- Annular Area: 3.3 in²
- Press Ratio: 2:1
- Wt. of Gas: 0.5 lbs/sec
- Material: "Universal Cyclops" (A 286 or 1753)
- Heat treat per Mfg. Spec.
- Balance Turbine: Max. out balance .005 gram at outside dia.

*Blade Impressions printed by rolling turbine dim. over drawn bottom view impression. Due to ink + rolling is oversize.*
Compressor Impeller

One Req.

Mat: Alum Alloy (356-T6) Casting

"Static Balance": Mount on Bal. Shaft

Using Harden & Ground Knife Edges
Perfectly Horizontal and 60 Cycle Vibrator; Balance for Zero Displacement
NOTE: BOTTOM OF SLOT MUST HAVE .030 RADIUS

GAS TURBINE NOZZLE
16 BLADES EQUALLY SPACED
MAT. 321 STAINLESS STEEL