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(71) Applicant: **United Technologies Corporation**  
**Hartford, CT 06101 (US)**

(72) Inventors:  
• **Coons, Todd**  
**Arizona 85222 (US)**

• **Pietraszkiewicz, Edward**  
**Southington**  
**Connecticut 06489 (US)**

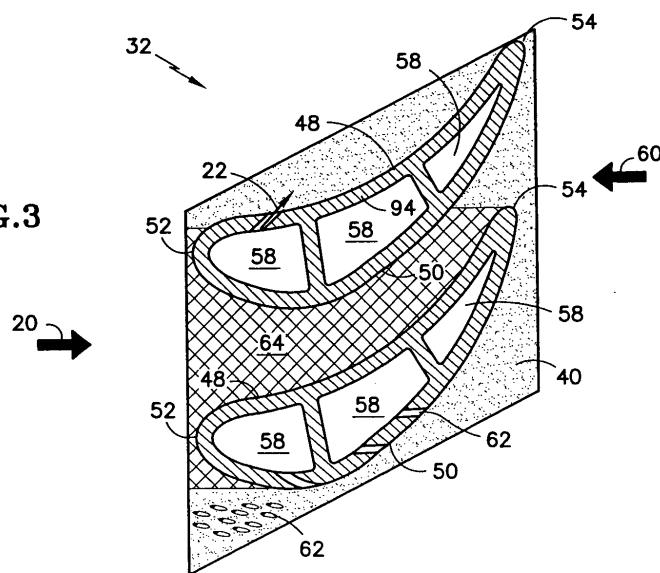
(74) Representative: **Leckey, David Herbert**  
**Frank B. Dehn & Co.**  
**St Bride's House**  
**10 Salisbury Square**  
**London**  
**EC4Y 8JD (GB)**

### (54) Cooled vane cluster

(57) A cast vane cluster (32) with enhanced cooling contains an inner and an outer platform (34, 36) and at least two airfoils (38) for directing a primary fluid stream axially rearward. A duct (56) is bounded by inner and outer endwall surfaces (40, 44), and adjacent airfoil fluid directing surfaces. One or more cooling holes (62) in the duct are drilled using an electrodischarge machine

(EDM) method without a line of sight from the drilling equipment to the cooling hole location. One or more cooling holes (62), located in portions of the duct, may not be visible when viewed from an external location. Additionally, one or more cooling holes (62) may only have an outlet cross sectional area (66) visible when viewed along a longitudinal axis from an external location.

FIG.3





## EUROPEAN SEARCH REPORT

Application Number  
EP 04 25 7975

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The present search report has been drawn up for all claims			
2	Place of search The Hague	Date of completion of the search 7 October 2008	Examiner Steinhauser, Udo
CATEGORY OF CITED DOCUMENTS		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons ..... & : member of the same patent family, corresponding document	
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ANNEX TO THE EUROPEAN SEARCH REPORT  
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