CLAIMS

I claim:

1. A shroud milling method, comprising:

milling a convex side of a shroud;

milling a concave side of the shroud; and

holding a shroud within a common fixture when milling the convex side and when milling the concave side .

2. The shroud milling method of claim 1, including milling a knife-edge of the shroud, and holding the shroud within the common fixture when milling the knife-edge of the shroud.

3. The shroud milling method of claim 1, including moving a milling cutter relative to the shroud and the common fixture during the milling.

4. The shroud milling method of claim 1, wherein the milling the convex side comprises milling a notch radius within the convex side.

5. The shroud milling method of claim 4, wherein a common milling cutter mills the convex side and the notch radius.

6. The shroud milling method of claim 4, wherein the milling the convex side comprises side milling and end milling, the end milling establishing the notch radius.

7. The shroud milling method of claim 1, wherein a common milling cutter mills the convex side and the concave side.

8. The shroud milling method of claim one, wherein the shroud is a turbine shroud of a newly-cast blade.

9. The shroud milling method of claim 1, wherein the milling comprises removing at least some weldment from the shroud.

10. A shroud, comprising:

a concave side of a shroud;

a convex side of the shroud; and

a knife-edge seal of the shroud, wherein the concave side, the convex side, and the knife-edge seal were cut using an end mill cutter.

11. The shroud of claim 10, where in the concave side, the convex side, and the knife-edge seal were held within a common fixture when cut using the end mill cutter.

12. The shroud of claim 10, wherein the shroud is a shroud of a turbine blade of a turbomachine.

13. The shroud of claim 10, wherein the concave side comprises a notch radius established by end milling.

14. The shroud of claim 13, wherein the notch radius was cut using the end mill cutter.

15. The shroud of claim 10, the knife edge seal comprises at least two separate knife edge seals.

16. A method of milling a turbine blade shroud, comprising:

securing a turbine blade within a fixture

milling a concave side of a turbine blade shroud while the turbine blade is secured within the fixture; and

milling a convex side of the turbine blade shroud while the turbine blade is secured within the fixture.

17. The method of claim 16, including milling a knife-edge seal of the turbine blade shroud while the turbine blade is secured within the fixture.

18. The method of claim 16, wherein the turbine blade is not removed from the fixture during the milling.

19. The method of claim 16, including end milling a notch radius when milling the concave side of the turbine blade shroud.

20. The method of claim 16, including using the same milling cutter for milling the concave side and for milling the convex side.

CLAIMS

I claim:

1. A shroud milling method, comprising:

milling a convex side of a shroud;

milling a concave side of the shroud; and

holding a shroud of a blade within a common fixture when milling the convex side and when milling the concave side, the blade extending along an axis, the holding including a clamping force applied to the blade transverse to the axis.

2. The shroud milling method of claim 1, including milling a knife-edge of the shroud, and holding the shroud within the common fixture when milling the knife-edge of the shroud.

3. A method of milling a turbine blade shroud, comprising:

securing a turbine blade within a fixture by applying a clamping force to the blade, the force applied in a direction transverse to an axis of the turbine blade;

milling a concave side of a turbine blade shroud while the turbine blade is secured within the fixture; and

milling a convex side of the turbine blade shroud while the turbine blade is secured within the fixture.

4. The method of claim 3, including milling a knife-edge seal of the turbine blade shroud while the turbine blade is secured within the fixture.