

**NATIONAL THERMAL POWER CORPORATION LTD.
1X500 MW NTPC FEROZE GANDHI UNCHAHAR TPP
STAGE-IV**

VOLUME-II B

**TECHNICAL SPECIFICATIONS
FOR
VIBRATION ISOLATION SYSTEM
FOR
ID FAN (2 NOS)
PA FAN (2 NOS)
FD FAN (2 NOS)**

SPECIFICATION NO. PE-TS-401-618-C001 (REV 0)



**BHARAT HEAVY ELECTRICALS LIMITED
Project Engineering Management
PPEI BUILDING, HRD & ESI COMPLEX
Plot No. 25, Sector 16A
NOIDA, U.P. – 201301
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SECTION 'A'

SCOPE OF WORK



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SCOPE

1. Supply of Vibration Isolation System (VIS)

- i) Vibration Isolation System (VIS)
- ii) Tools and facilities required for erection and commissioning including seaworthy packing & transportation etc. complete.

2. Supervision of erection and commissioning of the VIS.

Vendor shall deploy experienced manpower for setting the VIS in position and final adjustments after machine installation. Vendor shall also confirm the readiness at site before deploying the manpower for supervision of erection. Vendor shall furnish proposed erection strategy of the entire system and procedure for replacement of VIS and downtime involved.

3. Design & Engineering for the Vibration Isolation System

Design and engineering shall consist of the following:

- i) Selection of Vibration Isolation System (VIS).
- ii) Static and dynamic analysis and design of RCC deck slab (supporting arrangement for the equipment supported on VIS)
- iii) Calculation of loads on supporting structure along with their points of application and deflection limitations.
- iv) Calculation should establish that no dynamic loads are transferred to the structure supporting VIS and that the foundation system meets the amplitude/frequency requirements.
- v) Checking of stiffness for structure supported on VIS.

4. Documentation

Vendor shall furnish following documents:

- i) Bill of materials of various elements included in the supply along with detailed specifications of system and various items included in supply and standards local or international standards to which they conform.
- ii) General Arrangement (GA) drawing showing location and supporting details of VIS.
- iii) GA and reinforced concrete details drawings for deck slab including bar bending schedule.
- iv) Embedment drawings showing location of all embedment and their details pertaining to RCC deck slab.
- v) Design document
- vi) Methodology of providing the shuttering and its removal as well as concreting of deck slab, installation of VIS and sequence of above operation.
- vii) Installation and maintenance manual indicating equipment, procedures, etc. necessary for installation/maintenance of VIS.



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- viii) List of power plants where such systems have been successfully installed for such applications.
- ix) Performance certificate from the end user/customer for at least two successfully executed contracts for such system.



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SECTION 'B'

PROJECT INFORMATION



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PROJECT INFORMATION

1.	Owner	NATIONAL THERMAL POWER CORPORATION LTD.
2.	Project	1X500 MW NTPC FGUTPP STAGE-IV
3.	No of Units	1
4.	Consultant	NATIONAL THERMAL POWER CORPORATION LTD.
5.	Location	The plant is located in Raebareli district of Uttar Pradesh, it is bounded by villages khnapur, Faridpur and Khaliqpur Khurd. Mustafabad town is located at a distance of about 3 kms from the plant. Unchahar railway station on Allahabad-Raebareli broad gauge (BG) section of Northern Railway (NR) is 2 kms away. The nearest airport is located at Lucknow a distance of approximately 110 km from the project site.
6.	District	Raebareli district of Uttar Pradesh
7.	Nearest Major Town	Mustafabad town is located at a distance of about 3 kms from the plant.
8.	Nearest Railway station	Unchahar railway station on Allahabad-Raebareli broad gauge(BG) section of Northern Railway(NR) is 2 kms away.
9.	Nearest Airport	The nearest airport is located at Lucknow a distance of approximately 110 km from the project site.



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SECTION 'C'

SPECIFIC TECHNICAL REQUIREMENTS



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1. General Requirement

- 1.01. In case of any conflict between section-C and section-D, Section-C will prevail over Section-D.
- 1.02. Bidder shall quote based on the input drawings as per Table-1 to satisfy the design requirement as per the relevant applicable codes refer annexure- I, and section -D.

Table-1

<u>Sl. No</u>	<u>TITLE</u>	<u>DRAWING NO.</u>
1	GENERAL ARRANGEMENT OF INDUCED DRAFT FAN NDZV 47 SIDOR	0-00-099-27477 (R1)
2	GENERAL ARRANGEMENT OF PRIMARY AIR FAN PAF 19/10.6-2	1-00-100-28907 (R1)
3	GENERAL ARRANGEMENT OF FORCED DRAFT FAN FAF 24.5/11.8-1	1-00-098-28906 (R1)

- 1.03. Bidder shall furnish the information about the entire range of spring units, damper units and spring cum damper units, manufactured by the vendor. The information to be furnished should include the load carrying capacity, stiffness (vertical & horizontal), damping resistance, dimension of spring and damper units as well as quality plan.
- 1.04. The vibration isolation system supplied shall be of proven make and shall be in successful operation supporting machines like ID/PA/FD fan.
- 1.05. The isolation efficiency of at least 90% shall be provided for the fan foundation.
- 1.06. The nominal spring capacity shall be at least 25% higher than the actual spring-supported weight for the ID/PA/FD fan.

2. Seismic Loading:

Seismic loads shall be calculated adopting the site specific seismic information as specified in annexure-II

3. Wind Loading :

The various design parameters as defined in IS: 875 (Part 3) to be adopted for the project site shall be as follows:

- a. The basic wind speed "Vb" at ten metres above the mean ground level: 47 m/s.
- b. The risk coefficient "K1" : 1.07



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c. Category of terrain

: Category 2

Note: Notwithstanding the values of the above mentioned parameters, the design wind pressure so computed at any point shall not be taken less than 1500 N/sq.metre for all classes of structures, i.e. A, B & C, as defined in IS: 875 (Part-3).

4. Material of construction

- i. Minimum Grade of Concrete: M35.
- ii. TMT HYSD (Thermo-mechanically Treated High Yield Strength Deformed Bars) steel bars of grade Fe 500D conforming to IS 1786.

5. Documents to be submitted by vendor

- i. Soft copy of all documents/drawings shall be furnished in pdf and AutoCAD format as applicable.
- ii. Hard copies shall also be submitted.
- iii. Submission of civil drawings/documents shall be as mentioned in the table below

	Drawing	Document
For Approval	Soft copy + 6 nos. hard copies	Soft copy + 3 no. hard copy + 2 CD
For RFC	Soft copy + 15 nos. hard copies	1 sets of paper print + 2CD

6. Material (Design & Supply)

6.01. Steel helical springs and viscous dampers shall consist of:

- a. Steel helical spring units and viscous dampers along with viscous liquid including associated auxiliaries for installation of the spring units and dampers like steel shims, adhesive pads, etc.
- b. Frames for pre-stressing of spring elements.
- c. Suitable hydraulic jack system including electric pumps, high pressure tubes etc. required for the erection, alignment etc. of the spring units. One set of extra hydraulic jacks, and hand operated pumps shall also be provided.
- d. Any other items may be required for the pre-stressing, erection, release of pre-stress, alignment and commissioning of the steel helical springs and viscous dampers.

6.02. The design of the supporting arrangement for the equipment supported on steel helical springs and viscous dampers shall be done by vendor. The supporting arrangement shall consist of an RCC deck supported on steel helical spring units and viscous dampers which in turn shall be supported on RCC substructure/steel structure.



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- 6.03. The spring units should have stiffness in both vertical and horizontal directions with the horizontal stiffness not less than 50% of vertical stiffness. The stiffness should be such that the vertical natural frequency of any spring unit at its rated load carrying capacity is not more than 3 Hz.
- 6.04. The damper units or spring cum damper units should be of viscous type offering velocity proportional damping. The damper units should be suitable for temperatures ranging from 0 to 50° c. The damping resistance of the individual damper units should be such that the designed damping can be provided using reasonable number of units within available space.
- 6.05. The sizes of the spring units, damper units, spring cum damper units should be such that groups of such units can be accommodated on column heads in case of elevated foundations and on pedestals/walls in case of foundations at ground level.
- 6.06. The steel helical springs and viscous dampers shall be designed for a minimum operating life of 30 years.

7. Manufacturing & Testing

- 7.01. Complete manufacturing and testing of the steel helical springs and viscous dampers shall be done at the manufacturing shop of the vendor. For this purpose the vendor shall submit the detailed programme for approval of customer and take up the manufacturing / testing after approval of such quality plan. The quality plan shall include:
- a) Manufacturing schedule and quality check exercised during manufacturing.
 - b) Detail of test to be carried out at the manufacturing shop with its schedule.
 - c) Special requirements, if any, regarding concreting of top deck.
 - d) Complete step- by- step procedure covering the installation and commissioning of the spring system.
 - e) Manuals for erection, commissioning, testing and maintenance of the steel helical springs and viscous dampers.
 - f) A checklist for confirming the readiness of the civil fronts for erection of steel helical springs and viscous dampers.
 - g) Checklist for equipment required at each stage of erection.
 - h) Bill of materials (data sheet) of various elements such as spring units, viscous dampers, with their rating, stiffness etc. included in the supply.
 - i) Bill of material (data sheet) for frames for pre stressing, hydraulic jack including electric pump, high pressure tubes, hand operated pump etc. with their rating and numbers.
 - j) Any other details which may be necessary to facilitate design and construction of the foundations / structures.
- 7.02. The springs shall conform to codes DIN 2089 and DIN 2096. The quality assurance and inspection procedure shall be finalised on the basis of the above codes and the quality plans be drawn accordingly.

8. Transportation



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8.01. Steel helical springs and viscous dampers shall be suitably protected, coated, covered, boxed and crated to prevent damage or deterioration during transit and handling.

8.02. The vendor shall be responsible for any loss or damage during transportation, handling.

9. Erection and Commissioning

9.01. Complete erection and commissioning of the steel helical springs and viscous dampers including pre-stressing of elements, placing of elements in position, checking clearances on the shuttering of the RCC top deck, releasing of pre-stress in spring elements, making final adjustments and alignments etc. all shall be supervised by a specialist supervisor.

9.02. The scope of work shall be deemed to include all activities, which may not have been explicitly mentioned but are reasonably implied for the successful commissioning of steel helical springs and viscous dampers.

9.03. The vendor shall guarantee the performance of the steel helical springs and viscous dampers for 24 months from the date of commissioning of each machine which shall be termed as "Guarantee Period".

10. Supervision

The supervision of installation of steel helical springs and viscous dampers including pre-stressing, placing, releasing and alignment of spring units shall be done by a specialist supervisor of vendor, trained for this purpose.

11. Realignment of Spring System

If any realignment of the steel helical springs and viscous dampers is required to be done for aligning the shaft or for any other reasons during the first one year of operation from the date of commissioning of the machine, the same shall be done by the vendor.

ANNEXURE-I (Section-C)

Codes and Standards

Some of the relevant applicable Indian standards and codes, etc. applicable to this section of the specification are listed below:

DIN : 4024 Machine foundations; Flexible supporting structures for machine with rotating masses.

DIN : 2089 Helical compression springs out of round wire and rod: calculation & design.

DIN : 2096 Helical compression springs out of round wire and rod: quality requirements for hot formed compression springs.

VDI : 2056 Criteria for assessing mechanical vibrations of machine.

VDI : 2060 Criteria for assessing the state of balance of rotating rigid bodies.

ANNEXURE - II



CLAUSE NO.	TECHNICAL REQUIREMENTS	ANNEXURE-XXVI																
	<p style="text-align: right;">ANNEXURE - EQ</p> <p>CRITERIA FOR EARTHQUAKE RESISTANT DESIGN OF STRUCTURES AND EQUIPMENT</p> <p>All structures shall be designed for seismic forces adopting the site specific seismic information provided in this document and using the other provisions in accordance with IS:1893 (Part 1):2002. Pending finalisation of Parts 2 to 5 of IS:1893, provisions of part 1 shall be read along with the relevant clauses of IS:1893:1984, for structures other than the buildings.</p> <p>A site specific seismic study has been conducted for the project site. The peak ground horizontal acceleration for the project site, the site specific acceleration spectral coefficients (in units of gravity acceleration 'g') in the horizontal direction for the various damping values and the multiplying factor (to be used over the spectral coefficients) for evaluating the design acceleration spectra are as given at Annexure-EQ1.</p> <p>Vertical acceleration spectral values shall be taken as 2/3rd of the corresponding horizontal values.</p> <p>The site specific design acceleration spectra shall be used in place of the response acceleration spectra, given at figure-2 in IS:1893 (Part 1). The site specific acceleration spectra along with multiplying factors specified in Annexure-EQ1 includes the effect of the seismic environment of the site, the importance factor related to the structures and the response reduction factor. Hence, the design spectra do not require any further consideration of the zone factor (Z), the importance factor (I) and response reduction factor (R) as used in the IS:1893 (Part 1).</p> <p>Damping in Structures</p> <p>The damping factor (as a percentage of critical damping) to be adopted shall not be more than as indicated below for:</p> <table><tr><td>a)</td><td>Steel structures</td><td>:</td><td>2%</td></tr><tr><td>b)</td><td>Concrete structures and brick structures in cement mortar</td><td>:</td><td>5%</td></tr><tr><td>c)</td><td>Concrete Stacks / ND Cooling Towers</td><td>:</td><td>2%</td></tr><tr><td>d)</td><td>Steel stacks</td><td>:</td><td>As per IS:6533 & CICIND Model Code, whichever is more critical.</td></tr></table>	a)	Steel structures	:	2%	b)	Concrete structures and brick structures in cement mortar	:	5%	c)	Concrete Stacks / ND Cooling Towers	:	2%	d)	Steel stacks	:	As per IS:6533 & CICIND Model Code, whichever is more critical.	
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	<p>Method of Analysis</p> <p>Since most structures in a power plant are irregular in shape and have irregular distribution of mass and stiffness, dynamic analysis for obtaining the design seismic forces shall be carried out using the response spectrum method. The number of vibration modes used in the analysis should be such that the sum total of modal masses of all modes considered is at least 90 percent of the total seismic mass and shall also meet requirements of IS:1893 (Part 1). Modal combination of the peak response quantities shall be performed as per Complete Quadratic Combination (CQC) method or by an acceptable alternative as per IS:1893 (Part 1).</p> <p>If the design base shear (V_B), obtained from modal combination, is less than the base shear (\bar{V}_B), computed using the approximate fundamental period (T_a) given in IS:1893:Part 1 and using site specific acceleration spectra with appropriate multiplying factor, the response quantities (e.g. member forces, displacements, storey forces, storey shears and base reactions) shall be enhanced in the ratio of \bar{V}_B / V_B. However, no reduction is permitted if \bar{V}_B is less than V_B.</p> <p>For building less than 12m in height, design seismic base shear and its distribution to different floor levels along the height of the building may be carried out as specified under clause 7.5, 7.6 & 7.7 of IS:1893 (Part 1) and using site specific design acceleration spectra. The design horizontal acceleration spectrum value (A_h) shall be computed for the fundamental natural period as per clause 7.6 of IS:1893 (Part 1) using site specific spectral acceleration coefficients with appropriate multiplying factor given in Annexure-EQ1.</p> <p>Further, the spectral acceleration coefficient shall get restricted to the peak spectral value if the fundamental natural period of the structure falls to the left of the peak in the spectral acceleration curve.</p> <p>Design/Detailing for Ductility</p> <p>The site specific design acceleration spectra is a reduced spectra and has an in-built allowance for ductility. Structures shall be engineered and detailed in accordance with relevant Indian/International standards to achieve ductility.</p>
FGUTPP Stage – IV (1 x 500) EPC PACKAGE	<div data-bbox="614 1843 930 1919"> TECHNICAL SPECIFICATIONS SECTION VI PART-B </div> <div data-bbox="930 1843 1208 1919"> Sub-Section - D-01 Civil Works </div> <div data-bbox="1208 1843 1367 1919"> Annexure –EQ Page 2 of 6 </div>

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CLAUSE NO.	TECHNICAL REQUIREMENTS
	<p style="text-align: right;"><u>ANNEXURE – EQ1</u></p> <p><u>SITE SPECIFIC SEISMIC PARAMETERS FOR DESIGN OF STRUCTURES AND EQUIPMENT</u></p> <p>The various site specific seismic parameters for the project site shall be as follows:</p> <ol style="list-style-type: none"> 1) Peak ground horizontal acceleration : 0.26g 2) Multiplying factor to be applied to the site specific horizontal acceleration spectral coefficients (in units of gravity acceleration 'g') to obtain the design acceleration spectra <ol style="list-style-type: none"> a) for moment resisting steel frames designed and detailed as per IS:800 and moment resisting RC frames designed and detailed as per IS:456 : 0.091 b) for braced steel frames designed and detailed as per IS:800 : 0.068 c) for moment resisting RC frames designed and detailed as per IS:456 and IS:13920 : 0.055 d) for design of structures not covered under 2 (a) to 2 (c) above and under 3 below : 0.091 3) Multiplying factor to be applied to the site specific horizontal acceleration spectral coefficients (in units of gravity acceleration 'g') for design of equipment and structures where inelastic action is not relevant or not permitted : 0.13 <p>Note: g = Acceleration due to gravity</p> <p>The horizontal seismic acceleration spectral coefficients are furnished in subsequent pages.</p>
FGUTPP Stage – IV (1 x 500) EPC PACKAGE	<div style="display: flex; justify-content: space-between;"> <div> TECHNICAL SPECIFICATIONS SECTION VI PART-B </div> <div> Sub-Section - D-01 Civil Works </div> <div> Annexure –EQ Page 3 of 6 </div> </div>

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CLAUSE NO.	TECHNICAL REQUIREMENTS																																																																																																																
	<p><u>HORIZONTAL SEISMIC ACCELERATION SPECTRAL COEFFICIENTS</u> <u>In units of 'g'</u></p>																																																																																																																
	<table><tr><th rowspan="2">Time Period (Sec)</th><th colspan="2">Damping Factor (as a percentage of critical damping)</th></tr><tr><th>2%</th><th>5%</th></tr><tr><td>0.000</td><td>1.000</td><td>1.000</td></tr><tr><td>0.030</td><td>1.000</td><td>1.000</td></tr><tr><td>0.050</td><td>1.645</td><td>1.445</td></tr><tr><td>0.100</td><td>3.231</td><td>2.379</td></tr><tr><td>0.120</td><td>3.868</td><td>2.713</td></tr><tr><td>0.123</td><td>3.868</td><td>2.755</td></tr><tr><td>0.125</td><td>3.868</td><td>2.755</td></tr><tr><td>0.150</td><td>3.868</td><td>2.755</td></tr><tr><td>0.200</td><td>3.868</td><td>2.755</td></tr><tr><td>0.250</td><td>3.868</td><td>2.755</td></tr><tr><td>0.300</td><td>3.868</td><td>2.755</td></tr><tr><td>0.350</td><td>3.868</td><td>2.755</td></tr><tr><td>0.400</td><td>3.868</td><td>2.755</td></tr><tr><td>0.450</td><td>3.868</td><td>2.755</td></tr><tr><td>0.500</td><td>3.868</td><td>2.755</td></tr><tr><td>0.550</td><td>3.868</td><td>2.755</td></tr><tr><td>0.561</td><td>3.868</td><td>2.755</td></tr><tr><td>0.598</td><td>3.868</td><td>2.755</td></tr><tr><td>0.602</td><td>3.868</td><td>2.755</td></tr><tr><td>0.613</td><td>3.795</td><td>2.755</td></tr><tr><td>0.630</td><td>3.695</td><td>2.683</td></tr><tr><td>0.650</td><td>3.582</td><td>2.600</td></tr><tr><td>0.675</td><td>3.449</td><td>2.504</td></tr><tr><td>0.700</td><td>3.326</td><td>2.414</td></tr><tr><td>0.750</td><td>3.104</td><td>2.253</td></tr><tr><td>0.800</td><td>2.910</td><td>2.113</td></tr><tr><td>0.850</td><td>2.739</td><td>1.988</td></tr><tr><td>0.900</td><td>2.587</td><td>1.878</td></tr><tr><td>0.950</td><td>2.451</td><td>1.779</td></tr><tr><td>1.000</td><td>2.328</td><td>1.690</td></tr><tr><td>1.050</td><td>2.217</td><td>1.610</td></tr><tr><td>1.100</td><td>2.116</td><td>1.536</td></tr><tr><td>1.150</td><td>2.024</td><td>1.470</td></tr><tr><td>1.200</td><td>1.940</td><td>1.408</td></tr><tr><td>1.250</td><td>1.862</td><td>1.352</td></tr></table>	Time Period (Sec)	Damping Factor (as a percentage of critical damping)		2%	5%	0.000	1.000	1.000	0.030	1.000	1.000	0.050	1.645	1.445	0.100	3.231	2.379	0.120	3.868	2.713	0.123	3.868	2.755	0.125	3.868	2.755	0.150	3.868	2.755	0.200	3.868	2.755	0.250	3.868	2.755	0.300	3.868	2.755	0.350	3.868	2.755	0.400	3.868	2.755	0.450	3.868	2.755	0.500	3.868	2.755	0.550	3.868	2.755	0.561	3.868	2.755	0.598	3.868	2.755	0.602	3.868	2.755	0.613	3.795	2.755	0.630	3.695	2.683	0.650	3.582	2.600	0.675	3.449	2.504	0.700	3.326	2.414	0.750	3.104	2.253	0.800	2.910	2.113	0.850	2.739	1.988	0.900	2.587	1.878	0.950	2.451	1.779	1.000	2.328	1.690	1.050	2.217	1.610	1.100	2.116	1.536	1.150	2.024	1.470	1.200	1.940	1.408	1.250	1.862	1.352		
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0.350	3.868	2.755																																																																																																															
0.400	3.868	2.755																																																																																																															
0.450	3.868	2.755																																																																																																															
0.500	3.868	2.755																																																																																																															
0.550	3.868	2.755																																																																																																															
0.561	3.868	2.755																																																																																																															
0.598	3.868	2.755																																																																																																															
0.602	3.868	2.755																																																																																																															
0.613	3.795	2.755																																																																																																															
0.630	3.695	2.683																																																																																																															
0.650	3.582	2.600																																																																																																															
0.675	3.449	2.504																																																																																																															
0.700	3.326	2.414																																																																																																															
0.750	3.104	2.253																																																																																																															
0.800	2.910	2.113																																																																																																															
0.850	2.739	1.988																																																																																																															
0.900	2.587	1.878																																																																																																															
0.950	2.451	1.779																																																																																																															
1.000	2.328	1.690																																																																																																															
1.050	2.217	1.610																																																																																																															
1.100	2.116	1.536																																																																																																															
1.150	2.024	1.470																																																																																																															
1.200	1.940	1.408																																																																																																															
1.250	1.862	1.352																																																																																																															
FGUTPP Stage – IV (1 x 500) EPC PACKAGE	TECHNICAL SPECIFICATIONS SECTION VI PART-B	Sub-Section - D-01 Civil Works	Annexure –EQ Page 4 of 6																																																																																																														

8

CLAUSE NO.	TECHNICAL REQUIREMENTS		
	<u>HORIZONTAL SEISMIC ACCELERATION SPECTRAL COEFFICIENTS</u> <u>In units of 'g'</u>		
	Time Period (Sec)	Damping Factor (as a percentage of critical damping)	
		2%	5%
	1.300	1.791	1.300
	1.350	1.724	1.252
	1.400	1.663	1.207
	1.450	1.606	1.166
	1.500	1.552	1.127
	1.550	1.502	1.090
	1.600	1.455	1.056
	1.650	1.411	1.024
	1.700	1.369	0.994
	1.750	1.330	0.966
	1.800	1.293	0.939
	1.850	1.258	0.914
	1.900	1.225	0.889
	1.950	1.194	0.867
	2.000	1.164	0.845
	2.050	1.136	0.824
	2.100	1.109	0.805
	2.150	1.083	0.786
	2.200	1.058	0.768
	2.250	1.035	0.751
	2.300	1.012	0.735
	2.350	0.991	0.719
	2.400	0.970	0.704
	2.450	0.950	0.690
	2.500	0.931	0.676
	2.550	0.913	0.663
	2.600	0.895	0.650
	2.650	0.878	0.638
	2.700	0.862	0.626
	2.750	0.847	0.615
	2.800	0.831	0.604
	2.850	0.817	0.593
	2.900	0.803	0.583
	2.950	0.789	0.573
	3.000	0.776	0.563
	3.050	0.763	0.554
FGUTPP Stage – IV (1 x 500) EPC PACKAGE	TECHNICAL SPECIFICATIONS SECTION VI PART-B	Sub-Section - D-01 Civil Works	Annexure –EQ Page 5 of 6

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CLAUSE NO.	TECHNICAL REQUIREMENTS																																																														
	<p style="text-align: center;"><u>HORIZONTAL SEISMIC ACCELERATION SPECTRAL COEFFICIENTS</u> <u>In units of 'g'</u></p> <table><tr><th rowspan="2">Time Period (Sec)</th><th colspan="2">Damping Factor (as a percentage of critical damping)</th></tr><tr><th>2%</th><th>5%</th></tr><tr><td>3.100</td><td>0.751</td><td>0.545</td></tr><tr><td>3.150</td><td>0.739</td><td>0.537</td></tr><tr><td>3.200</td><td>0.728</td><td>0.528</td></tr><tr><td>3.250</td><td>0.716</td><td>0.520</td></tr><tr><td>3.300</td><td>0.705</td><td>0.512</td></tr><tr><td>3.350</td><td>0.695</td><td>0.504</td></tr><tr><td>3.400</td><td>0.685</td><td>0.497</td></tr><tr><td>3.450</td><td>0.675</td><td>0.490</td></tr><tr><td>3.500</td><td>0.665</td><td>0.483</td></tr><tr><td>3.550</td><td>0.656</td><td>0.476</td></tr><tr><td>3.600</td><td>0.647</td><td>0.469</td></tr><tr><td>3.650</td><td>0.638</td><td>0.463</td></tr><tr><td>3.700</td><td>0.629</td><td>0.457</td></tr><tr><td>3.750</td><td>0.621</td><td>0.451</td></tr><tr><td>3.800</td><td>0.613</td><td>0.445</td></tr><tr><td>3.850</td><td>0.605</td><td>0.439</td></tr><tr><td>3.900</td><td>0.597</td><td>0.433</td></tr><tr><td>3.950</td><td>0.589</td><td>0.428</td></tr><tr><td>4.000</td><td>0.582</td><td>0.423</td></tr></table>	Time Period (Sec)	Damping Factor (as a percentage of critical damping)		2%	5%	3.100	0.751	0.545	3.150	0.739	0.537	3.200	0.728	0.528	3.250	0.716	0.520	3.300	0.705	0.512	3.350	0.695	0.504	3.400	0.685	0.497	3.450	0.675	0.490	3.500	0.665	0.483	3.550	0.656	0.476	3.600	0.647	0.469	3.650	0.638	0.463	3.700	0.629	0.457	3.750	0.621	0.451	3.800	0.613	0.445	3.850	0.605	0.439	3.900	0.597	0.433	3.950	0.589	0.428	4.000	0.582	0.423
Time Period (Sec)	Damping Factor (as a percentage of critical damping)																																																														
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FGUTPP Stage – IV (1 x 500) EPC PACKAGE	TECHNICAL SPECIFICATIONS SECTION VI PART-B	Sub-Section - D-01 Civil Works	Annexure –EQ Page 6 of 6																																																												



TITLE:

**STANDARD TECHNICAL
SPECIFICATION FOR VIBRATION
ISOLATION SYSTEM**

SPECIFICATION NO. PE-TS-999-600-C026

VOLUME - II B

SECTION - D

REV.NO. 0 DATE 05/07/2010

SHEET 1 OF 5

VOLUME: II B

SECTION - D

SUB-SECTION - D26

VIBRATION ISOLATION SYSTEM

SPECIFICATION NO. PE-TS-999-600-C026



Bharat Heavy Electricals Limited
Project Engineering Management



TITLE:

**STANDARD TECHNICAL
SPECIFICATION FOR VIBRATION
ISOLATION SYSYTEM**

SPECIFICATION NO. PE-TS-999-600-C026

VOLUME - II B

SECTION - D

REV.NO. 0 DATE 05/07/2010

SHEET , 2 OF 5

C O N T E N T

CLAUSE NO.	DESCRIPTION	SHEET NO.
1.00.00	SCOPE	3
2.00.00	Supply of VIS	3
3.00.00	Supervision of Erèction and Commissioning	3
4.00.00	Design Engineering of Vibration Isolation System	3
5.00.00	Quality Plan and Test Certificate	5
6.00.00	Environmental Protection	5



TITLE:

**STANDARD TECHNICAL
SPECIFICATION FOR VIBRATION
ISOLATION SYSTEM**

SPECIFICATION NO. PE-TS-999-600-C026

VOLUME - II B

SECTION - D

REV.NO. 0 DATE 05/07/2010

SHEET : 3 OF 5

VIBRATION ISOLATION SYSTEM**1.00.00 SCOPE**

This section covers supply, supervision of erection/ commissioning & design engineering of the vibration isolation system (VIS) suitable for ID/PA/FD Fans/ TDBFP/MDBFP/TURBOGENERATORS/MILLS. The vibration isolation system shall be of proven make and should be in successful operation for similar machines.

2.00.00 Supply of VIS

VIS shall be supplied complete along with recommended spares if any. The selection of VIS shall be done by the vendor, in case not done by customer, so that the amplitude at bearing locations are within permissible limits as per machine supplier recommendation or ISO10816 whichever is governing and no dynamic loads are transferred to the structure supporting VIS. Minimum 90 % isolation shall be achieved and the system shall be capable of withstanding Seismic/Wind forces.

3.00.00 Supervision of Erection and Commissioning**3.01.00 Manual**


Vendor shall supply installation and maintenance manual indicating equipment, procedures etc. necessary for installation and replacement of VIS with downtime involved.

3.02.00 Tools and facilities

Vendor shall supply all tools and facilities as required for successful erection and commissioning of VIS. Vendor shall deploy experienced manpower to supervise successful installation of VIS

4.00.00 Design Engineering of Vibration Isolation System**4.01.00 Dynamic Analysis**

The dynamic analysis shall consist of free vibration analysis and forced vibration analysis. Isolation efficiency of at least 90 % shall be obtained. The fundamental natural frequency shall be sufficiently above or below the

	TITLE: STANDARD TECHNICAL SPECIFICATION FOR VIBRATION ISOLATION SYSYTEM	SPECIFICATION NO. PE-TS-999-600-C026 VOLUME - II B SECTION - D REV.NO. 0 DATE 05/07/2010 SHEET : 4 OF 5
	<p>frequency corresponding to operating speed .Vibration amplitude shall be calculated at all bearing locations and shall satisfy the permissible limits as per ISO 10816 or as specified by the machine supplier. Transient analysis shall be carried out for the short circuit /blade failure condition with an appropriate force function if required by the machine supplier. The forces for which substructure is to be designed shall be furnished.</p> <p>4.02.00 Static Analysis</p> <p>The static analysis shall include the</p> <ul style="list-style-type: none"> a) Dead weights of machine stationary parts, b) Dead weights of machine rotary parts c) Loads due to machine power torque d) Loads due to maximum allowable unbalance e) Temperature loads f) Loads due to blade unbalance/short circuit g) Erections loads h) Seismic Loads i) Any other loads given by the supplier <p>Various load combinations must be investigated to obtain the most severe loads for foundation design purpose as per relevant IS codes or as per machine supplier recommendation whichever is more critical.</p> <p>4.03.00 Check for Shaft Misalignment</p> <p>Foundation deck must be adequately stiff to withstand all operating load combinations without excessively upsetting the rotor shaft alignment .The structural design must carefully be analysed for relative deflection for the members supporting machine shaft to satisfy the limits as given by machine supplier if any.</p> <p>4.04.00 Design of RCC deck supported on VIS</p> <p>Vendor shall provide General arrangement drawing of deck showing location and supporting detail of VIS, all embedment and their details as per the machine supplier drawing.</p> <p>RCC design shall be done by working stress method for all machine foundations. Minimum reinforcement shall be governed by IS : 2974 as well IS : 456.</p> <p>All documents/drawings shall be supplied in 25 (twenty five) prints. All calculations shall be supplied in 6 (six) sets. Soft copy of the drawings in Auto Cad shall be supplied along with the soft copy of the documents supplied</p>	



TITLE:

**STANDARD TECHNICAL
SPECIFICATION FOR VIBRATION
ISOLATION SYSYTEM**

SPECIFICATION NO. PE-TS-999-600-C026

VOLUME - II B

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SHEET 5 OF 5

All documentation shall be in English language and all RCC/structural design shall be conforming to the relevant Indian Standard Code of practice.

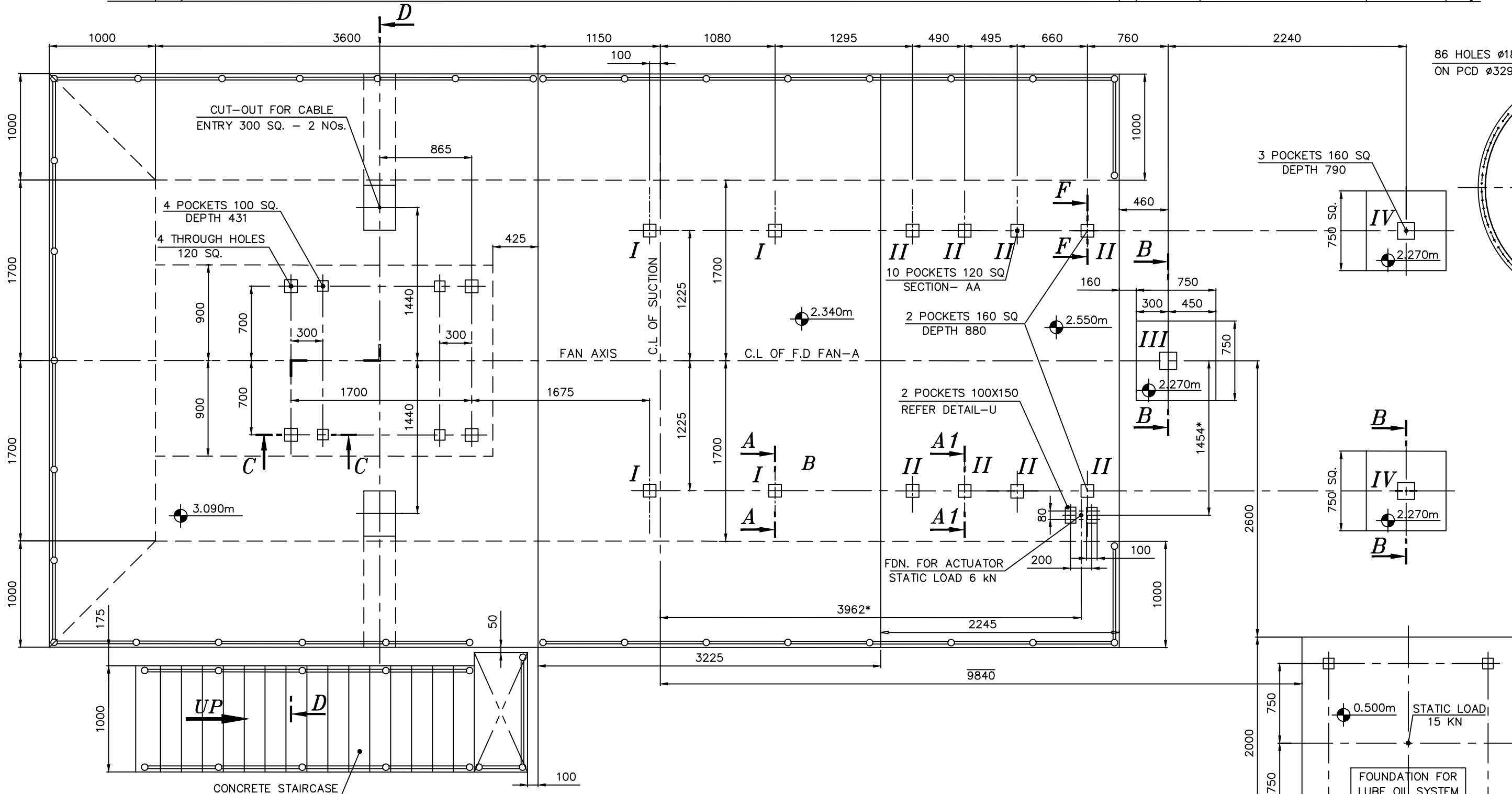
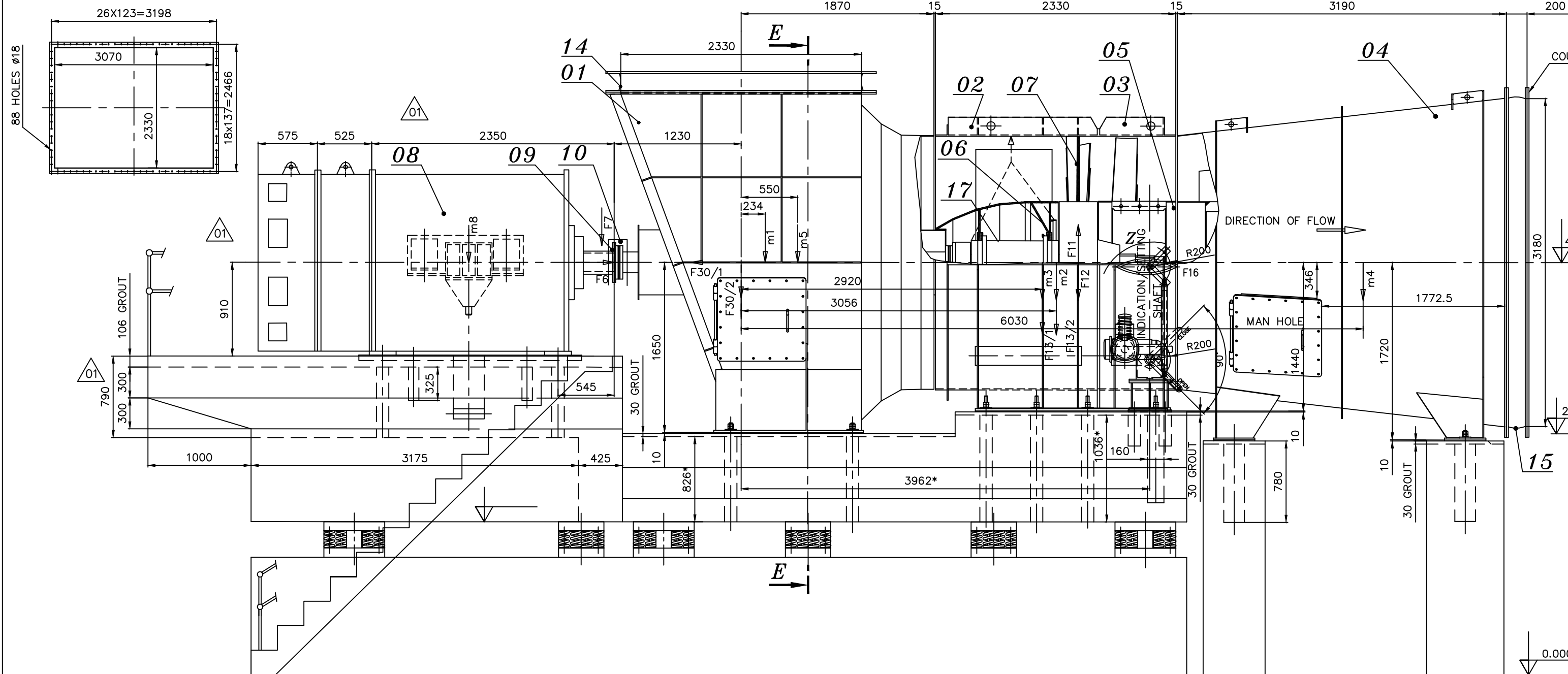
5.00.00 Quality Plan and Test Certificate

Vendor shall furnish the quality plan and Test certificate for the hardware in their scope of supply. The quality plan shall be reviewed by BHEL /Consultant wherein the inspection and hold points shall be indicated. Vendor shall submit test certificate based on approved Quality Plan. Despatch of material by the vendor shall only take place after the receipt of Material Dispatch Clearance Certificate (MDCC) issued by BHEL/Consultant on the basis of test reports/test certificates submitted by the Vendor after manufacture.

6.00.00 Environmental Protection

VIS shall be suitably protected against environmental damages e.g. abrasion, discolouration, corrosion, oily water etc. to give a prolonged service matching the plant life.

SUCTION FLANGE



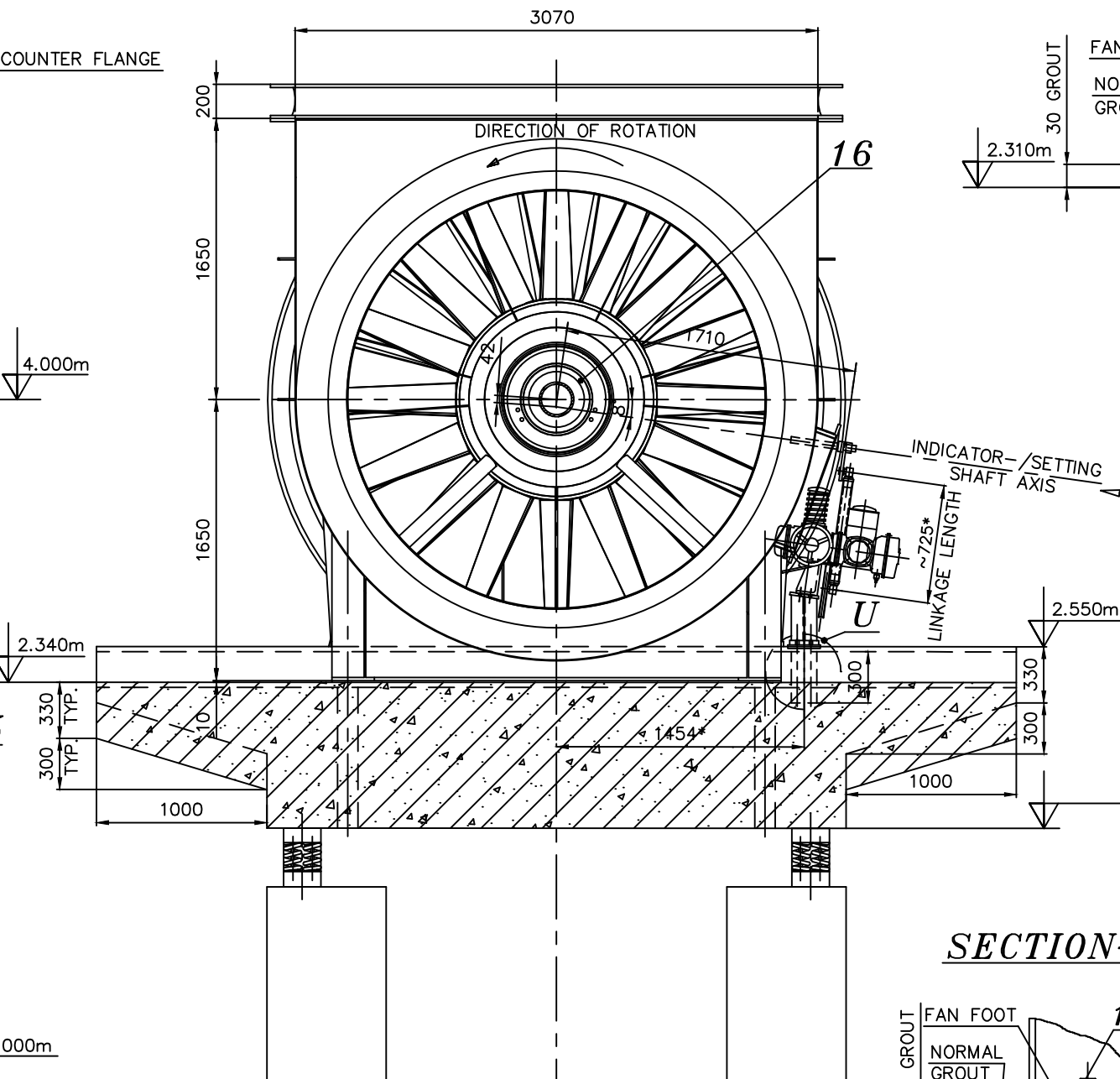
Id. number	(m) mass in [kg] including insulation	(F) force in [N]	Designation
1	3430		Suction box with inlet nozzle.
2	5650		Fan housing with straightener vane section and nose fairing
3	2116		Complete rotor assembly
4	3820		Diffuser with tail fairing
5	670		Intermediate shaft with coupling
6	1560		Axial thrust on motor shaft for motor with fixed bearing
7	3685		Radial load on motor shaft
8	11500		Drive motor
9	-		Frame of the motor
10	-		Oil supply unit with oil filling
11	7367		Max. rotating load due to unbalance of the fan rotor
12	93050		Unbalance in case of damage
13/1	20760		Max. load when lifting the rotor assembly
13/2	24950		Max. load when lifting the fan housings upper part
14	98320		Foundation
15	-		Load during starting sequence by short-circuit torque of the motor
16	15539		Axial thrust of the fan (due to pressure increase)
30/1	21136		Stat. and dyn. forces caused by air stream of suction box in horiz. direction
30/2	10768		Stat. and dyn. forces caused by air stream of suction box in vert. direction

LOAD POINT	FORCE [N]	FORCE [N]	FORCE [N]	FORCE [N]	FORCE [N]
I	+18700	+600	+5400	±100	±1000
II	+16800	+100	±2000	±100	±1000
III	+17000	±00		±100	±900
IV	+10400	±900		±100	±900

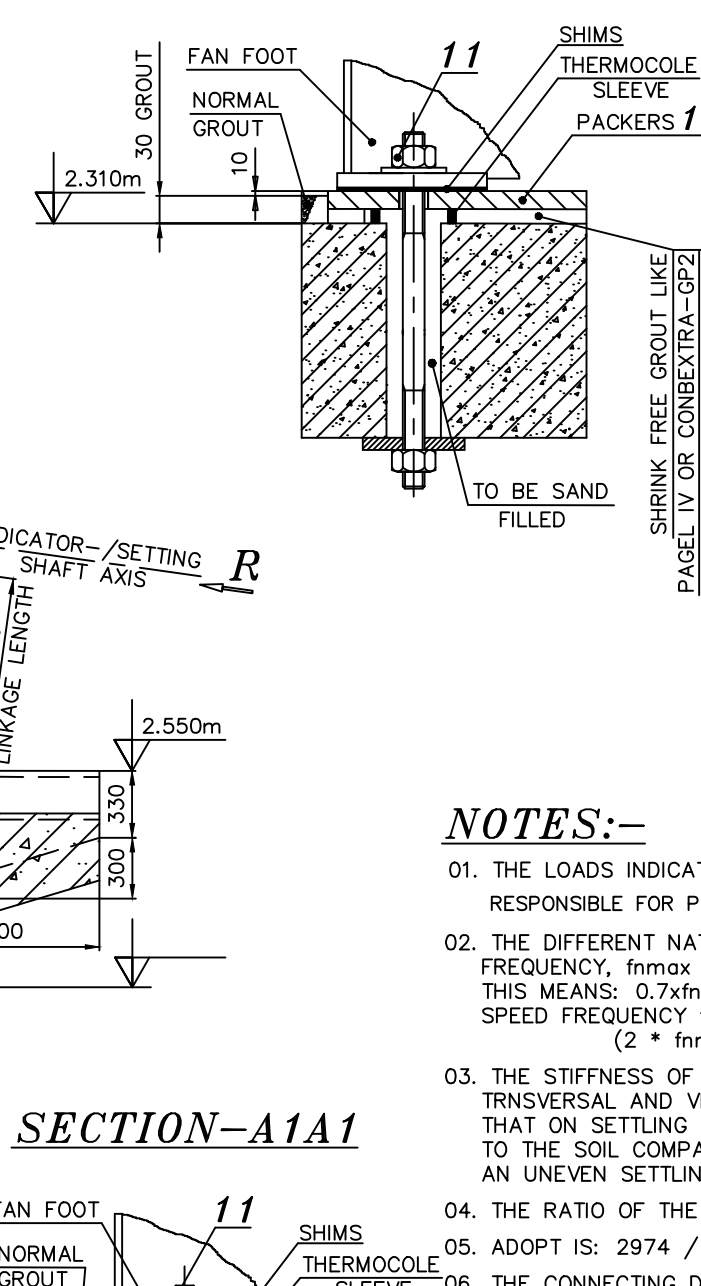
SL NO	DESCRIPTION	MATERIAL	THICKNESS (mm)	QTY.
17	SHAFT	42CRMO4V	-	1
16	BEARINGS	NU 236EM1.C3	-	1
15	OUTLET EXPANSION JOINT	7236B.MP.UA	-	2
14	INLET EXPANSION JOINT	IS : 2062 & RUBBER	-	1
13	SHIMS	S.S	-	AS REQD.
12	PRIMARY PACKER	IS : 2062	20	8
11	FOUNDATION FASTENERS FOR FAN	ASTM A105	-	15
10	COUPLING GUARD	IS : 2062	-	1
09	SPACER COUPLING	STEEL	-	1
08	MOTOR WITH FNDN. FASTENERS	1525 kW / 990 RPM	-	1
07	BLADES	ENAC-AIS9MgT6, BHN MIN 75	-	14
06	IMPELLER HUB	S355J2G3	-	1
05	HOUSING CORE	IS : 2062	6	1
04	DIFFUSER	IS : 2062	6	1
03	OUTLET GUIDE VANE ASSY.	IS : 2062	6	1
02	IMPELLER HOUSING	IS : 2062	20	1
01	SUCTION CHAMBER	IS : 2062	6	1

BILL OF MATERIAL

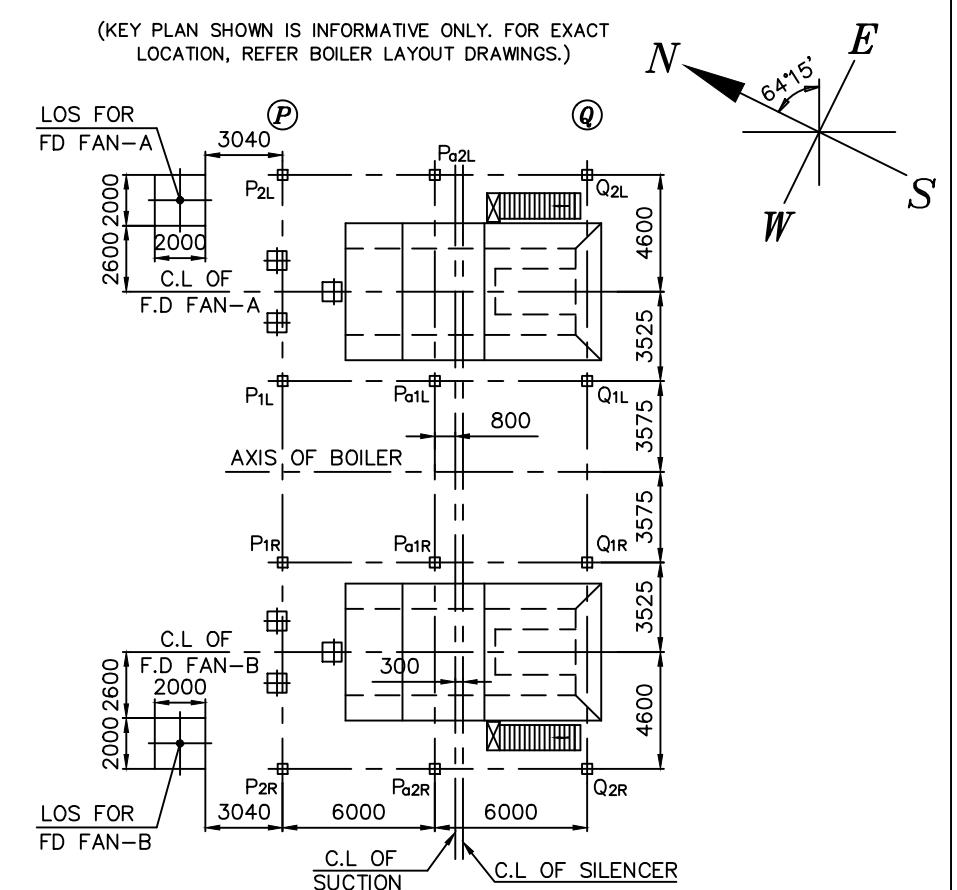
SECTION-EE



SECTION-AA



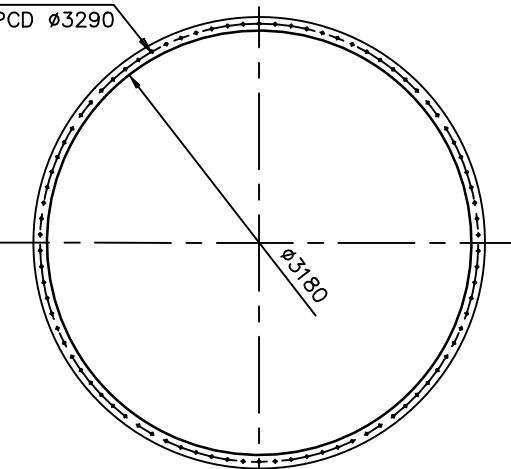
KEY PLAN*



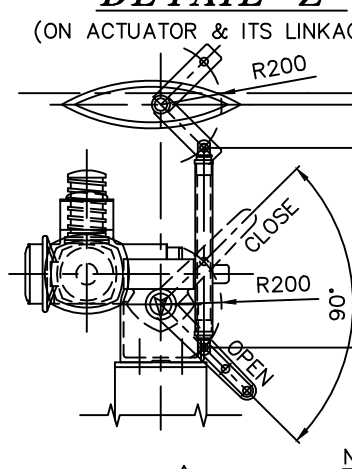
NOTES:-

- THE LOADS INDICATED ON FOUNDATION ARE WITHOUT ALLOWANCES FOR VIBRATIONS. CIVIL DESIGNERS ARE RESPONSIBLE FOR PROPER DESIGN OF FOUNDATION TAKING INTO ACCOUNT OF THE ALLOWANCES FOR VIBRATION ALSO.
- THE DIFFERENT NATURAL FREQUENCIES OF THE FOUNDATION HAVE TO BE 20% AWAY FROM THE SPEED FREQUENCY. $f_{nmax} = n/60$ AND 20% AWAY FROM THE DOUBLE OF THE SPEED FREQUENCY, $2 \times f_{nmax}$. THIS MEANS: $0.7 \times f_n$ TO $1.3 \times f_n$ AND $0.8 \times (2 \times f_n)$ TO $1.2 \times (2 \times f_n)$. SPEED FREQUENCY $f_{nmax} = 16.5$ HZ ($2 \times f_{nmax} = 33.0$ HZ)
- THE STIFFNESS OF THE FOUNDATION HAS TO BE AT LEAST $CF > 1.0E+06$ N/mm IN LONGITUDINAL, TRANSVERSAL AND VERTICAL DIRECTIONS RELATING TO THE FAN AXIS. IT HAS TO BE TAKEN INTO CONSIDERATION ON SETTLING THE FOUNDATION THE TOTAL NATURAL FREQUENCIES OF THE FOUNDATION CAN ARISE DUE TO THE SOIL COMPACTION AND THE RESULTING INCREASES OF THE ELASTIC MODULUS. AN UNEVEN SETTLING OF THE FOUNDATION HAS TO BE EXCLUDED.
- THE RATIO OF THE FOUNDATION MASS TO THE ROTOR MASS HAS TO BE GREATER THAN 20.
- ADOPT IS: 2974 / PART-IV FOR THE FOUNDATION DESIGN.
- THE CONNECTING DUCTS AT INLET AND OUTLET OF FAN MUST BE SELF SUPPORTED AND SHOULD NOT BE WELDED WITH EXPANSION JOINTS.
- FOUNDATION POCKETS SHOULD BE PERPENDICULAR TO THE FLAT SURFACES OF FOUNDATION.
- ACCURATE TEMPLATES SHALL BE USED FOR LOCATING CORES FOR POCKET HOLES TO ENSURE THEIR DIMENSIONAL ACCURACY.
- TOLERANCE BETWEEN ANY TWO POCKET CENTRES IS ± 5 mm.
- TOLERANCE ON CONCRETE LEVELS ± 25 mm.
- IN AREAS WHERE SOLE PLATES AND ANCHOR PLATES ARE TO BE INCORPORATED IN FOUNDATION CONCRETE, THE SIZE OF THE COARSE AGGREGATE USED SHALL NOT EXCEED 20 mm AND DOWN GRADED TO FACILITATE CHIPPING AND SCRAPPING AND THEREBY ENSURING MAXIMUM CONTACT ON THE MATING AREAS.
- NON-SHRINK GROUT IS TO BE USED. REFER GENERAL SPECIFICATIONS ISSUED BY BHEL/RANIPET FOR NON-SHRINK GROUT. THIS ALSO CONTAINS THE PREPARATIONS OF PRIMARY PACKERS & SHIMS.
- GROUTING SHOULD BE DONE ONLY AFTER FINAL ALIGNMENT OF FAN.
- ELEVATIONS & POCKET DEPTH SHOWN IN FOUNDATION PLAN ARE INCLUDING GROUTING THICKNESS.
- GROUTING IS IN THE SCOPE OF ERECTION GROUP.
- HANDRAILS, STEEL PLATFORMS, STAIRS, LADDERS & THEIR EMBEDMENTS ARE IN THE SCOPE OF BHEL/TRICHY.
- FAN FOUNDATION SHOULD NOT BE USED AS SUPPORT FOR OTHER STRUCTURES OR EQUIPMENTS.
- FOUNDATION CONFIGURATION SHOWN IN THIS DRAWING IS ONLY INFORMATIVE/TYPICAL. TYPE AND DETAILS OF FOUNDATION ARE TO BE FINALISED BY CIVIL DESIGNERS.
- FOR MOTOR ERECTION, REFER MOTOR SUPPLIER'S ERECTION MANUAL.
- MAX. AMPLITUDE REFERRED TO SUPPORTING AREA - TOP EDGE OF FOUNDATION IS 150 MICRONS.
- THE NATURAL FREQUENCY OF THE DUCTS AND SUPPORTING STRUCTURES SHOULD BE CLEARLY AWAY FROM THE OPERATING FREQUENCY OF FAN.
- LOAD DUE TO SHORT CIRCUITING OF MOTOR SHOULD BE TAKEN INTO ACCOUNT WHILE DESIGNING THE FOUNDATION.
- SUITABLE DRAIN HOLES ARE TO BE PROVIDED IN THE FOUNDATION.
- ALL THE INSERTS, EMBEDMENTS, HANDRAILS, FOUNDATION BOLT ASSY, GROUTS AND GROUTING ARE IN THE SCOPE OF BHEL.
- THE DRAIN LINE FROM THE FAN SHALL BE SUITABLY ROUTED TO THE NEAREST TRENCH BY BHEL/PIPING CENTRE.

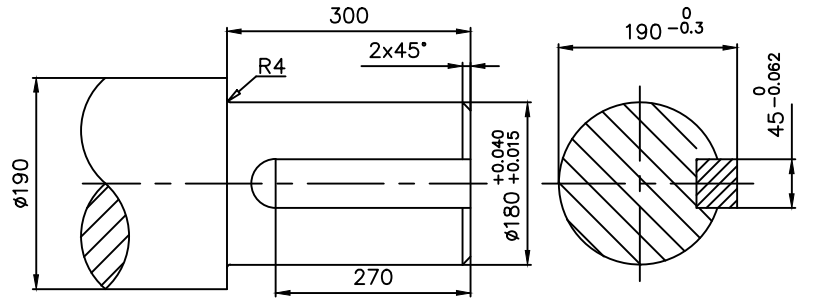
DELIVERY FLANGE



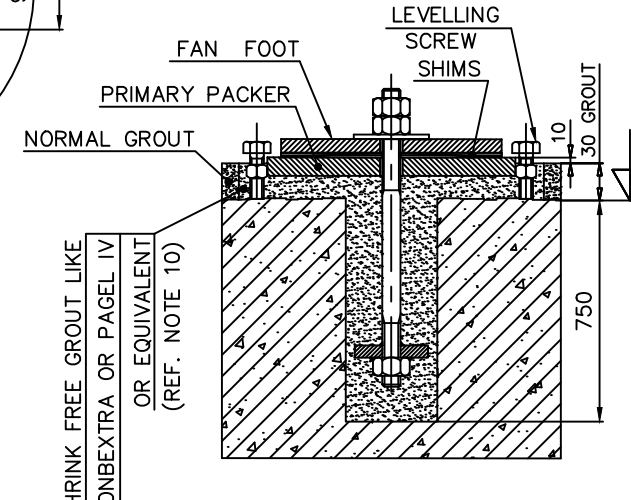
DETAIL-Z*



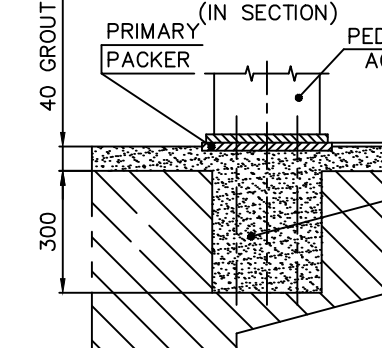
MOTOR SHAFT END



SECTION-BB



DETAIL-U



FAN DETAILS:

TYPE	: FAF 24.5/11.8-1
NO. OF FANS PER BOILER	: TWO (IDENTICAL)
FAN WEIGHT WITH OUT MOTOR AND COUPLING	: 17700 kg
WEIGHT OF ROTATING PARTS	: 2116 kg
GD ² OF FAN	: 1400 kg.m ²
SPEED OF FAN	: 990 RPM
MAX WT. TO BE HANDLED FOR MAINTENANCE	: 3500 kg.
MAX. ADMISSIBLE AMPLITUDE REFERRED TO SHAFT LEVEL	
HORIZONTAL	: 120 MICRON
VERTICAL	: 120 MICRON
AXIAL	: 120 MICRON

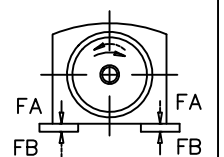
MOTOR DETAILS:

RATING	: 1525 kW / 996 RPM
TYPE	: SQ. CAGE INDUCTION, 1LA7902-6 TETV IP55
MAKE	: M/s. BHEL/BHOPAL
WEIGHT OF MOTOR	: 11500 kg
WEIGHT OF ROTATING PARTS	: 2800 kg
GD ² OF MOTOR	: 576 kg.m ²
MOTOR DRG. NO.	: 34020046457
BEARINGS	: DE : NU238 BORE Ø190+6238MC3
	: NDE : NU232W BORE Ø160
LUBRICATION	: 100 GREASE (SERVOGEM-3 OR EQUIVALENT)

FOUNDATION LOAD OF MOTOR

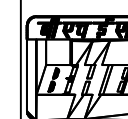
MAX. FORCE CALCULATED FROM THE MAX. IMPULSE TORQUE - FM	= 160 KN
FORCE EXERTED BY WEIGHT ON EACH SIDE - FG	= 58 KN
FOUNDATION LOAD ON EACH SIDE COMPRESSION - FA = FM+FG	= 218 KN
TENSILE FORCE - FB = FM-FG	= 102 KN

THE FORCE OCCUR ALTERNATIVELY INDEPENDENT OF THE DIRECTION OF ROTATION.



CUSTOMER NO. : R552

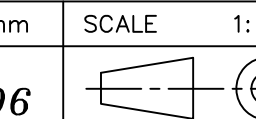
NTPC DRG. NO. 1450-001R-SCRN-PVM-B-002				
PROJECT	NBPHL FEROZE GANDHI UNCHAHAR THERMAL POWER STATION STAGE-IV (2X500 MW) STEAM GENERATOR WITH ELECTROSTATIC PRECIPITATOR PACKAGE			
DEPT	NAME	SIGN	DATE	
DRN	P.S.N	sd.....	08.01.2014	
DES	S.AG	sd.....	08.01.2014	
CHD	V.P.S	sd.....	08.01.2014	
APPD	V.P.S	sd.....	08.01.2014	



BHARAT HEAVY ELECTRICALS LTD.
BOILER AUXILIARIES PLANT
RANIPET - 632 406

GENERAL ARRANGEMENT OF FORCED DRAFT FAN FAF 24.5/11.8-1

ALL DIMENSIONS ARE IN mm
BHEL/RANIPET DRG. NO.
1-00-098-28906



DRAWING NO.
SHEET 01 OF 01

REV. 01

Size A1

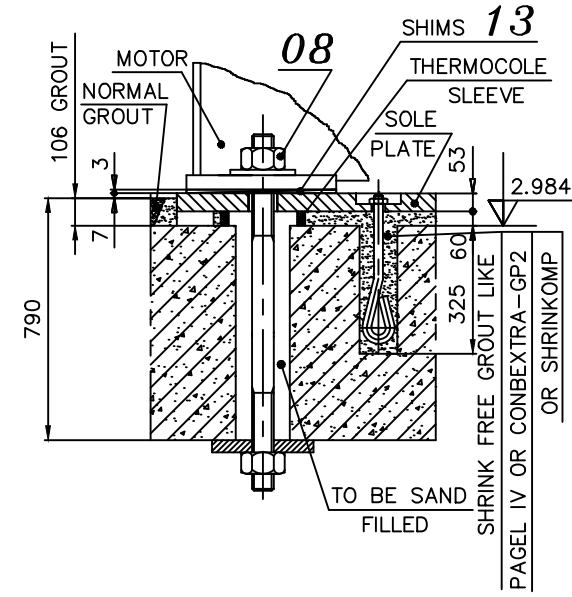
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REV.	DATE	ALTD:	CHKD:	APPD:
01	10.03.2014	S.AGARWAL	V.P. SHYAM	V.P. SHYAM

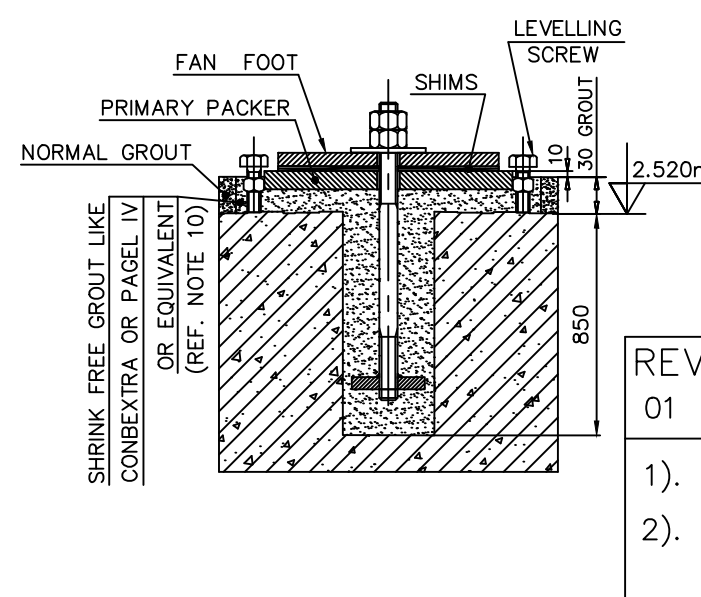
- MOTOR AND ITS FOUNDATION DETAILS UPDATED.
- NTPC DRAWING NO.UPDATED.

* MARKED DIMENSIONS TO BE CONFIRMED LATER

SECTION-CC



SECTION-FF



SECTION-EE

2360

200

1280

1280

3.500m

2.210m

2.370m

1607

16

DIRECTION OF ROTATION

INDICATOR - SETTING SHAFT AXIS

1000 (TYP)

1194

15

16

0.000m

FAN FOOT

12 PRIMARY PACKER

LEVELLING SCREW

SHIMS

NORMAL GROUT

2.130m

SHRINK FREE GROUT LINE (NONEXTRA OR PAGEL IV) OR EQUIVALENT (REF. NOTE 10)

(KEY PLAN SHOWN IS INFORMATIVE ONLY. FOR EXACT LOCATION, REFER BOILER LAYOUT DRAWINGS.)

	01. THE LOADS INDICATED ON FOUNDATION ARE WITHOUT ALLOWANCES FOR VIBRATIONS. CIVIL DESIGNERS (PEM), ARE RESPONSIBLE FOR PROPER DESIGN OF FOUNDATION TAKING INTO ACCOUNT OF THE ALLOWANCES FOR VIBRATION ALSO.
OF SHIRINKOMP	02. THE DIFFERENT NATURAL FREQUENCIES OF THE FOUNDATION HAVE TO BE 20% AWAY FROM THE SPEED FREQUENCY, $f_{max} = n/60$ AND 20% AWAY FROM THE DOUBLE OF THE SPEED FREQUENCY, $2 \times f_{max}$. THIS MEANS: $0.8xfn$ TO $1.2xfn$ AND $0.8x(2xfn)$ TO $1.2x(2xfn)$. SPEED FREQUENCY $f_{max} = 24.83$ HZ ($2 \times f_{max}$) = 49.66 HZ
	03. THE STIFFNESS OF THE FOUNDATION HAS TO BE AT LEAST OF $> 1.0E+06$ N/mm IN LONGITUDINAL, TRANSVERSAL AND VERTICAL DIRECTIONS RELATING TO THE FAN AXIS. IT HAS TO BE TAKEN INTO CONSIDERATION THAT THE SETTLING OF THE FOUNDATION THE TOTAL NATURAL FREQUENCIES OF THE FOUNDATION CAN ARISE DUE TO THE SOIL COMPACTION AND THE RESULTING INCREASES OF THE ELASTIC MODULUS AN UNEVEN SETTLEMENT OF THE FOUNDATION HAS TO BE EXCLUDED.
	04. THE RATIO OF THE FOUNDATION MASS TO THE ROTOR MASS HAS TO BE GREATER THAN 20.
	05. ADOPT IS: 2974 / PART-IV FOR THE FOUNDATION DESIGN.
	06. THE CONNECTING DUCTS AT INLET AND OUTLET OF FAN MUST BE SELF SUPPORTED AND SHOULD NOT BE WELDED WITH EXPANSION JOINTS.
	07. FOUNDATION POCKETS SHOULD BE PERPENDICULAR TO THE FLAT SURFACES OF FOUNDATION.
	08. ACCURATE TEMPLATES SHALL BE USED FOR LOCATING CORES FOR POCKET HOLES TO ENSURE THEIR DIMENSIONAL ACCURACY.
	09. TOLERANCE BETWEEN ANY TWO POCKET CENTRES IS ± 5 mm.
	10. TOLERANCE ON CONCRETE LEVELS -25 mm.
E	11. IN AREAS WHERE SOLE PLATES AND ANCHOR PLATES ARE TO BE INCORPORATED IN FOUNDATION CONCRETE, THE SIZE OF THE COARSE AGGREGATE USED SHALL NOT EXCEED 20 mm AND DOWN GRADDED TO FACILITATE CHIPPING AND SCRAPPING AND THEREBY ENSURING MAXIMUM CONTACT ON THE MATING AREAS.
	12. NON-SHRINK GROUT IS TO BE USED, REFER GENERAL SPECIFICATIONS ISSUED BY BHEL/RANIPET FOR NON-SHRINK GROUT. THIS ALSO CONTAINS THE PREPARATIONS OF PRIMARY PACKERS & SHIMS.
	13. GROUTING SHOULD BE DONE ONLY AFTER FINAL ALIGNMENT OF FAN.
OF SHIRINKOMP	14. ELEVATIONS & POCKET DETAIL SHOWN IN FOUNDATION PLAN ARE INCLUDING GROUTING THICKNESS.
	15. GROUTING IS IN THE SCOPE OF ERECTION GROUP.
	16. HANDRAILS, STEEL PLATFORMS, STAIRS, LADDERS & THEIR EMBEDMENTS ARE IN THE SCOPE OF BHEL/TRICHY.
	17. FAN FOUNDATION SHOULD NOT BE USED AS SUPPORT FOR OTHER STRUCTURES OR EQUIPMENTS.
	18. FOUNDATION CONFIGURATION SHOWN IN THIS DRAWING IS ONLY INFORMATIVE/TYPICAL. TYPE AND DETAILS OF FOUNDATION ARE TO BE FINALISED BY CIVIL DESIGNERS
	19. FOR MOTOR ERECTION, REFER MOTOR SUPPLIER'S ERECTION MANUAL.
	20. THE NATURAL FREQUENCY OF THE DUCTS AND SUPPORTING STRUCTURES SHOULD BE CLEARLY AWAY FROM THE OPERATING FREQUENCY OF FAN.
	21. LOAD DUE TO SHORT CIRCUITING OF MOTOR SHOULD BE TAKEN INTO ACCOUNT WHILE DESIGNING THE FOUNDATION.
	22. SUITABLE DRAIN HOLES ARE TO BE PROVIDED IN THE FOUNDATION.
	23. ALL THE INSERTS EMBEDMENTS, HANDRAILS, FOUNDATION BOLT ASSY, GROUTS AND GROUTING ARE IN THE SCOPE OF BHEL.
	24. THE DRAIN LINE FROM THE FAN SHALL BE SUITABLY ROUTED TO THE NEAREST TRENCH BY BHEL/PIPING CENTRE.

[illegible]

66 HOLES
PCD 257

Ø245.0

018 ON
0

106 GROUT
3
7
990

MOTOR

08

13

THERMOCOOLE SLEEVE

SOLE PLATE

SHIMS

2.484m

325

53

TO BE SAND FILLED

SHRINK FREE GROUT LINE
IV OR CONCRETE-SP2
OR SHIMCOMP

Technical drawing of a fan foot assembly showing a cross-section of a concrete wall. The drawing includes labels for 'NORMAL GROUT', '30 GROUT', '10', '2.340m', '1606*', 'FAN FOOT', 'SHIMS', 'THERMOCOLE SLEEVE', 'SHRINK FREE GROUT LIKE SLIV OR CONEXTRA-GP2 OR SHRINKOM', and '109', '10', '11', '12', '13', '14', '15', '16', '17', '18', '19'.

[illegible]

TYPE	:	PWF 19/10.6-2
NO. OF FANS PER BOILER	:	TWO
WEIGHT OF THE FAN WITH OUT MOTOR	}	11900 kg [INCLUDING PART LO
WEIGHT OF ROTATING PARTS	:	2900 kg
GD ² OF FAN	:	1400 kg.m ²
SPEED OF FAN	:	1490 RPM
MAX.ADMISSBLE AMPLITUDE REFERRED TO SHAFT LE		
		HORIZONTAL :100 MICRON
		VERTICAL :100 MICRON
		AXIAL :100 MICRON
TORQUE REQUIRED TO OPERATE SERVO MOTOR	:	10 K
MAX WT. TO BE HANDLED FOR MAINTENANCE	:	3000

MAKE	:	M/s. BHEL/BHOPAL
TYPE	:	1LA7904-4, TETV, IP55
NG RATING	:	2650 KW/1494 RPM/162 AMP/11 KV
WEIGHT OF MOTOR	:	13500 kg [INCLUDING ROTATING PART LOAD]
WEIGHT OF ROTATING PARTS	:	2500 kg
GD ² OF MOTOR	:	488 kg.m ²
MOTOR DRG. NO.	:	1 402 00 41280
BEARINGS	DE :	ROLLER BRG. - NU 236 BORE Ø180 BALL BRG. - 6236 MC 3
	NDE :	ROLLER BRG. - NU 232M BORE Ø160
LUBRICATION	:	IOC GREASE SERVOGEM 3 OR EQUI.

MAX. FORCE CALCULATED FROM THE MAX. IMPULSE TORQUE $-FM = 127 \text{ kN}$
 FORCE EXERTED BY THE WEIGHT ON EACH SIDE $----- FG = 67.5 \text{ kN}$
 FOUNDATION LOAD ON EACH SIDE COMPRESSION $- FA = FM + FG = 194.5 \text{ kN}$
 TENSILE FORCE $- FB = FM - FG = 60 \text{ kN}$
 THE FORCES OCCUR ALTERNATIVELY 50 TIMES PER SECOND INDEPENDENT OF
 DIRECTION OF ROTATION.

16	BEARINGS	NU330EM1.C3	—	2
		7234B.MP.UA	—	3
13	OULET EXPANSION JOINT	IS: 2062 & RUBBER	—	1
14	INLET EXPANSION JOINT	IS: 2062 & RUBBER	—	1
13	SHIMS	S.S	—	AS REQD.
12	PRIMARY PACKER	IS : 2062	20	10
11	FOUNDATION FASTENERS FOR FAN	ASTM A105	—	17
10	COUPLING GUARD	IS : 2062	—	1
09	SPACER COUPLING	STEEL	—	1
08	MOTOR WITH FNDN. FASTENERS	2650 KW / 1494 RPM	—	1
07	BLADES	ENAC—AISI9Mg7BHN MIN 75	—	40
06	IMPELLER HUB	S355J2G3	—	2
05	HOUSING CORE	IS : 2062	6	1
04	DIFFUSER	IS : 2062	6	1
03	OUTLET GUIDE VANE ASSY.	IS : 2062	6	1
02	IMPELLER HOUSING	IS : 2062	20	1
01	SUCTION CHAMBER	IS : 2062	6	1
SL NO	DESCRIPTION	MATERIAL	THICKNESS (mm)	QTY.
<i>BILL OF MATERIAL</i>				

[illegible]

JOB NO: R552

STATUS:	CONTRACT
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DISTRIBUTION			

1
N

RE
05

01.

02

1

DRAWN AND IS INFORMATION PROVIDED	NAME	SIGN.	DATE
	DRAWN	P S N	Sd

THE LD., INFORM E PRO	CHECKED	S.AGARWAL	Sd.....	04.02.2014
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APPVD.	V.P.SHYAM	Sd.....	04.02.2014
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CAUTION: ELECTRICAL WORK IS BEING PERFORMED ON THIS EQUIPMENT. DO NOT TOUCH ANY ELECTRICAL COMPONENTS OR WIRING. NTPC DWG. NO. 1450-001R-SGR

BHEL DWG. NO.	1-00-100-28
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TITLE: GENERAL ARRANGEMENT OF

4 GENERAL ARRANGEMENT OF PRIMARY AIR FAN

PAF 19/10.6-2

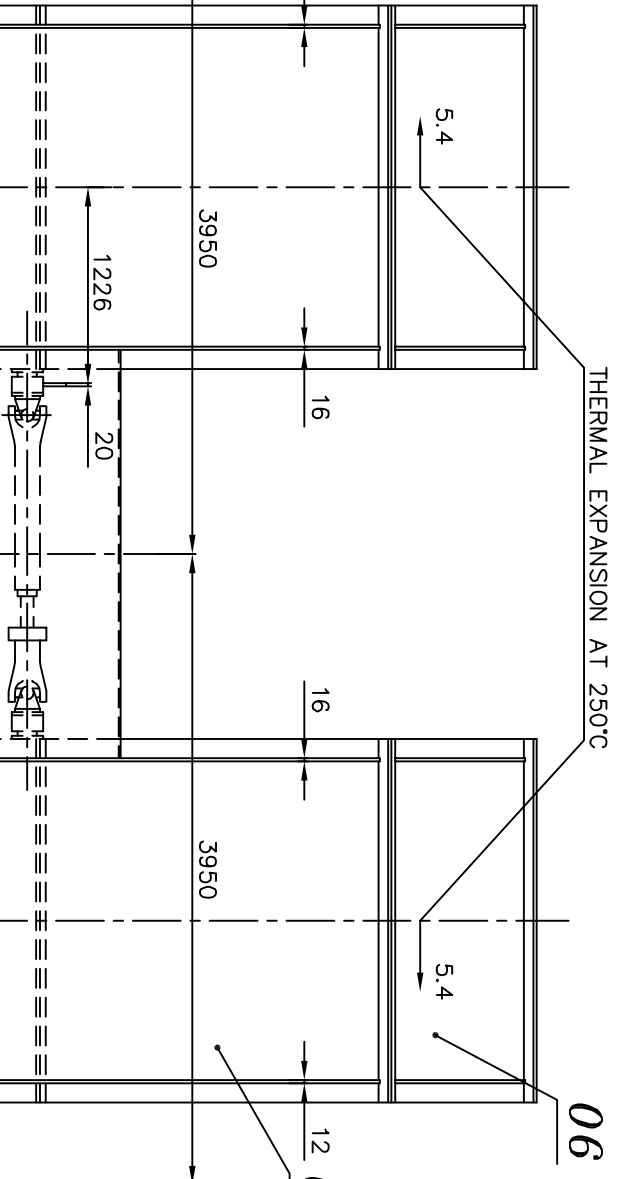
N-PVM-B-004	SHEET No.	REV. 01	MBE JOB M
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3907	TOP	SCALE: 1:35	SIZE : A1
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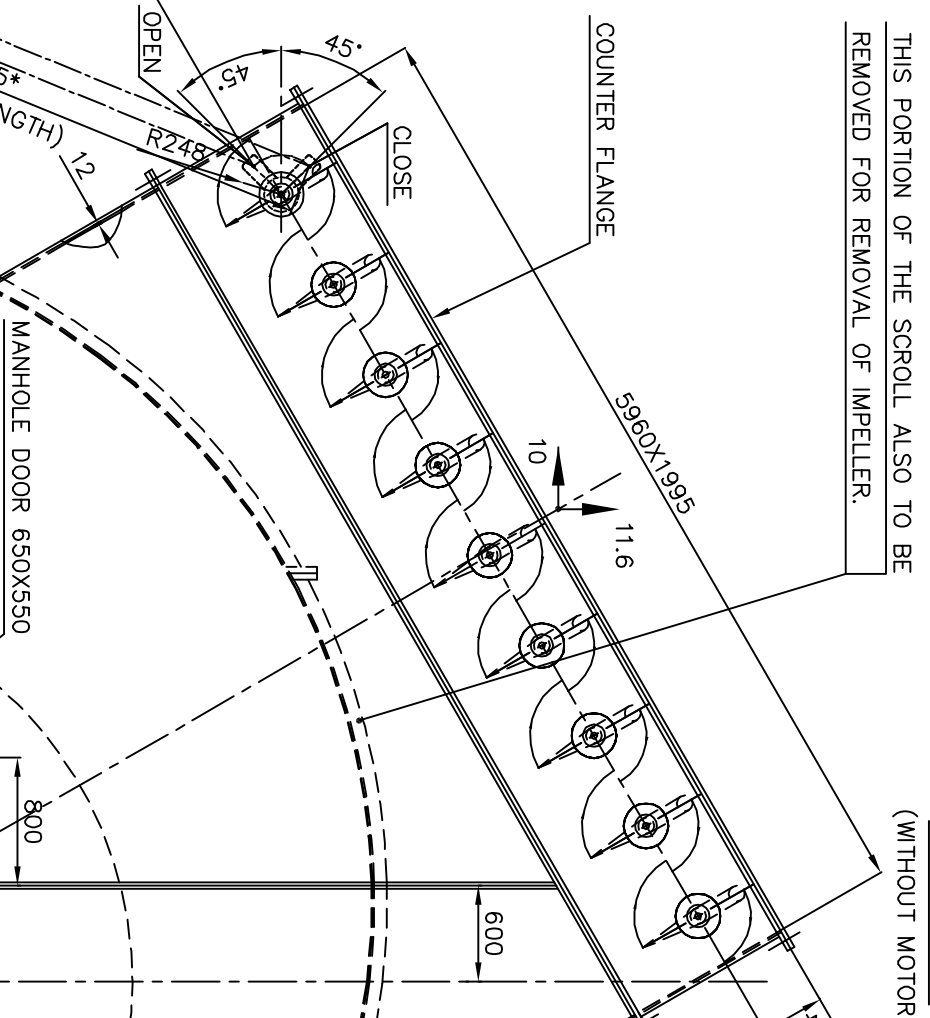
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Size A1

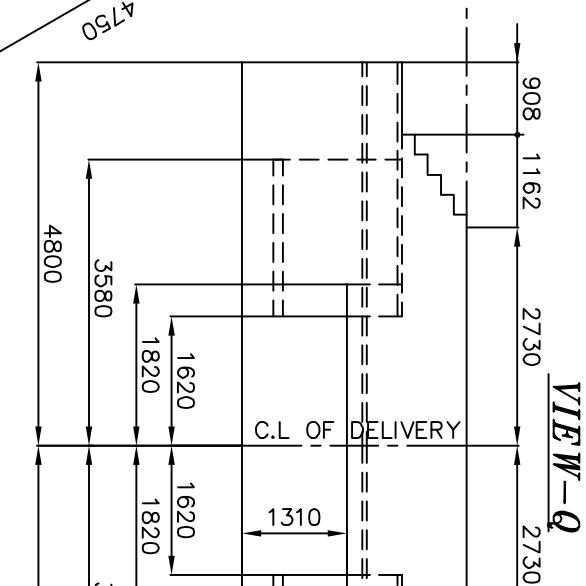
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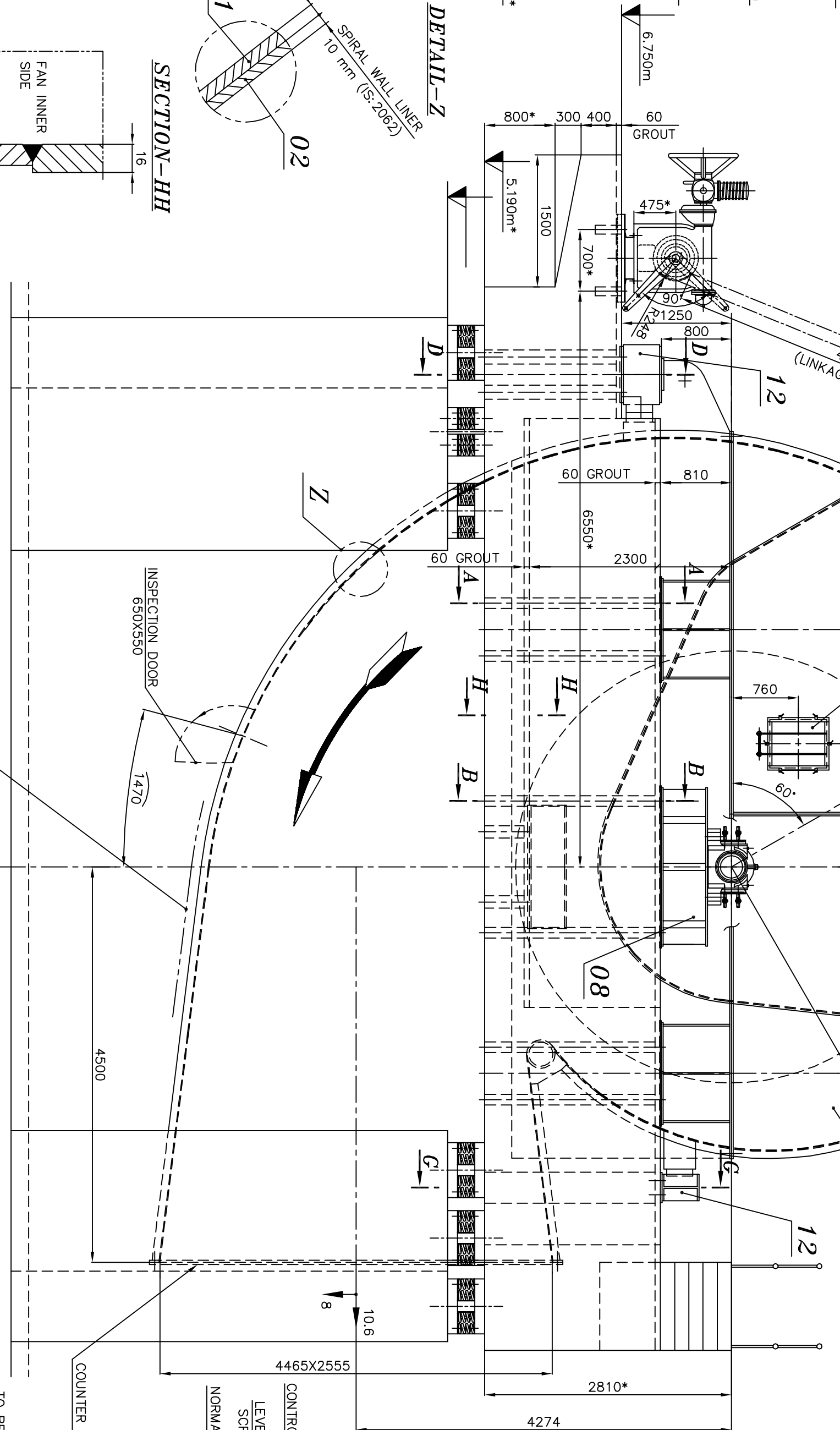
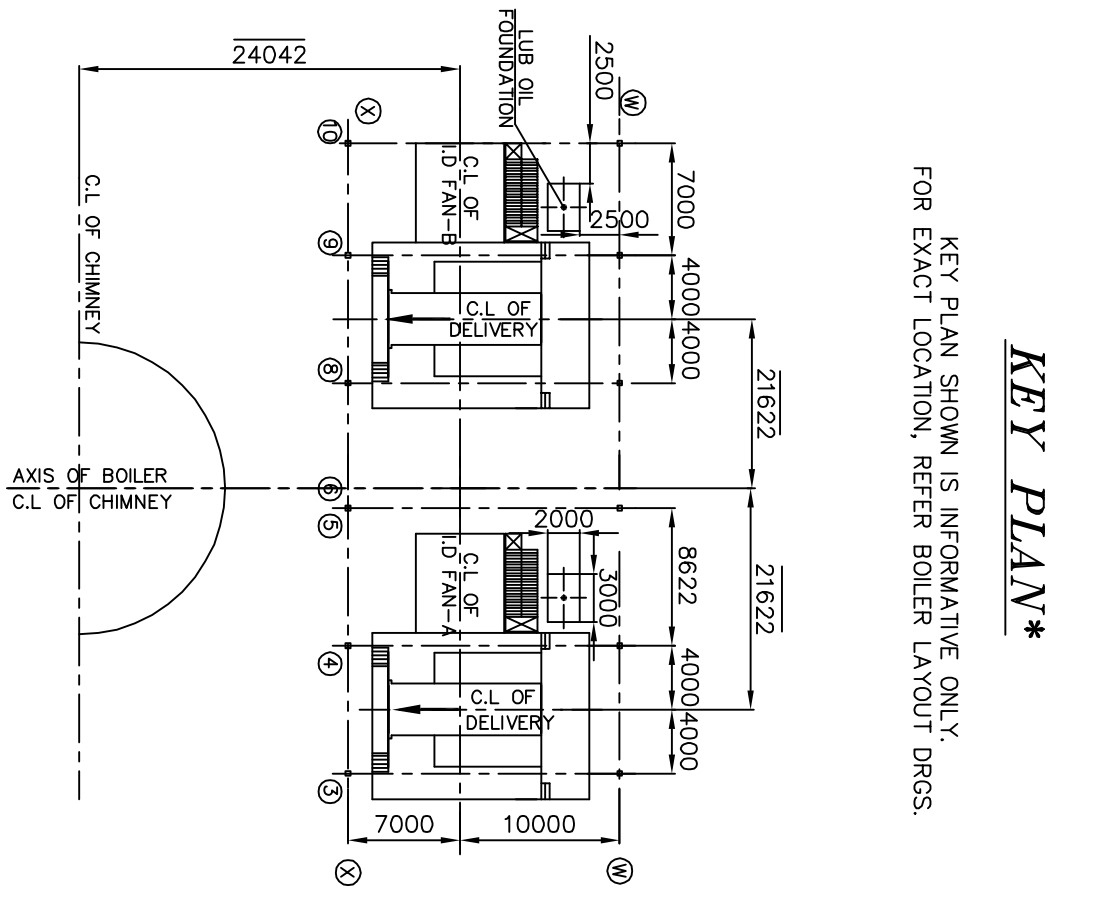
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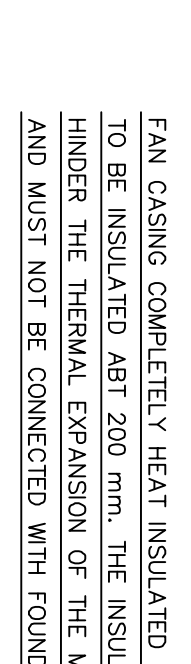
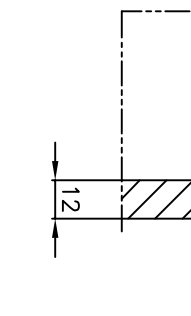
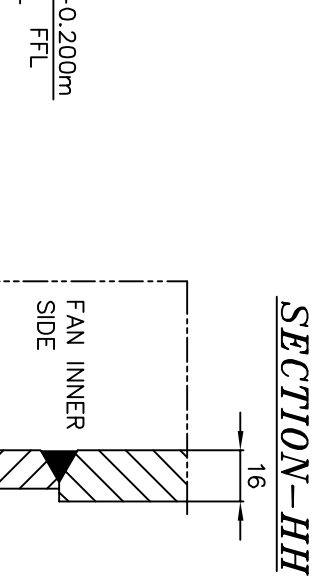
VIEW-Q
2730



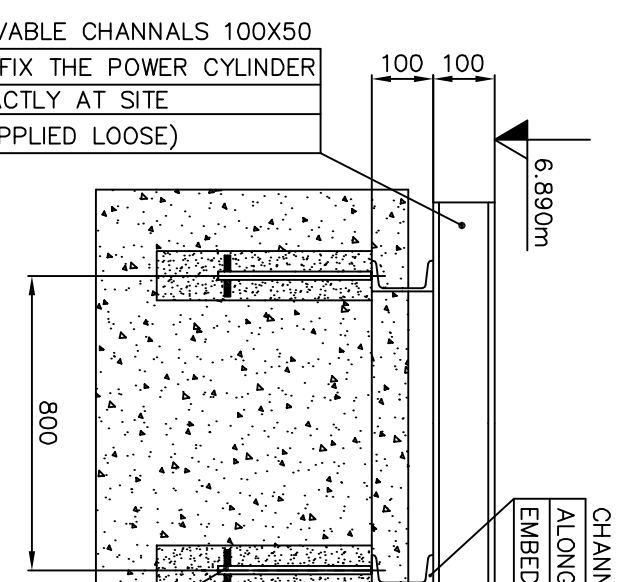
KEY PLAN*



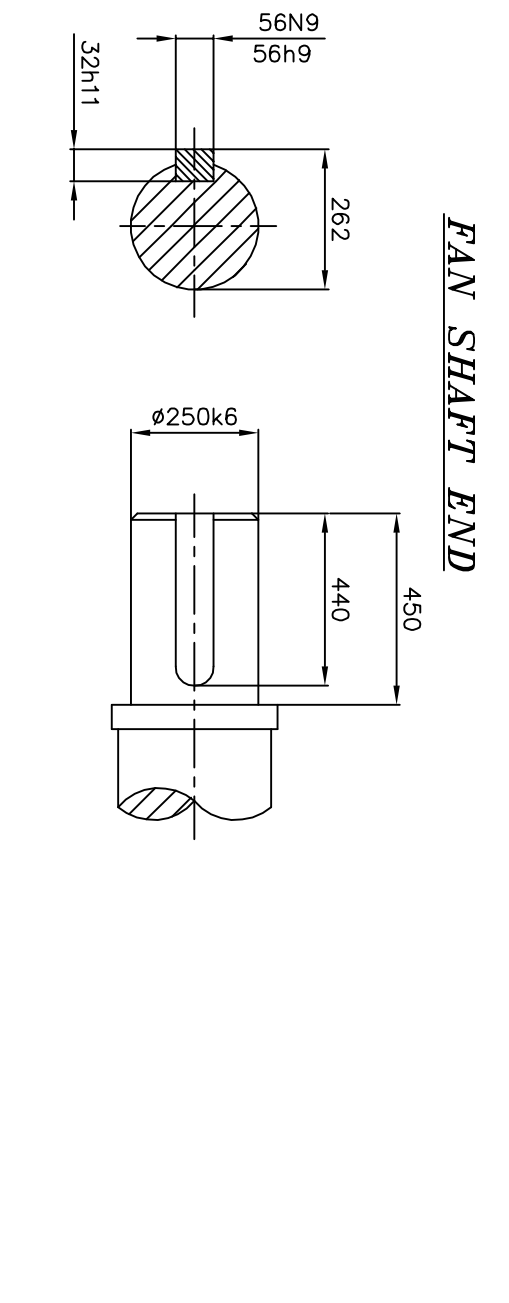
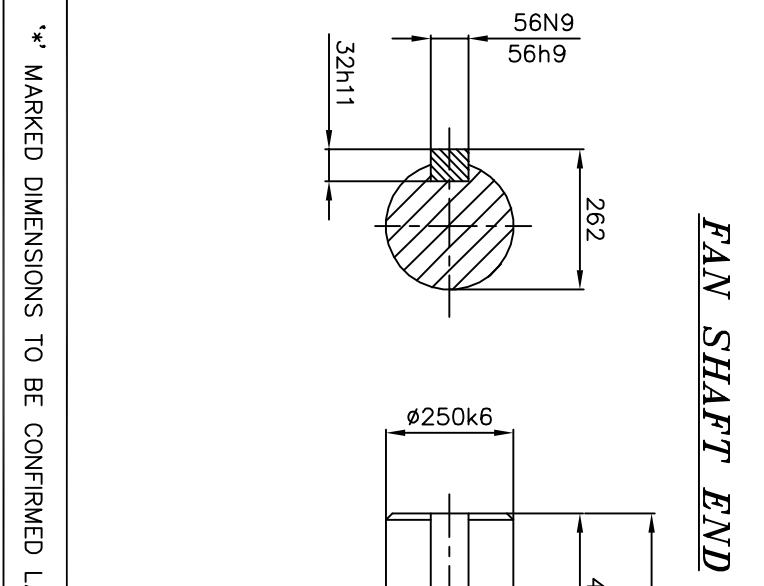
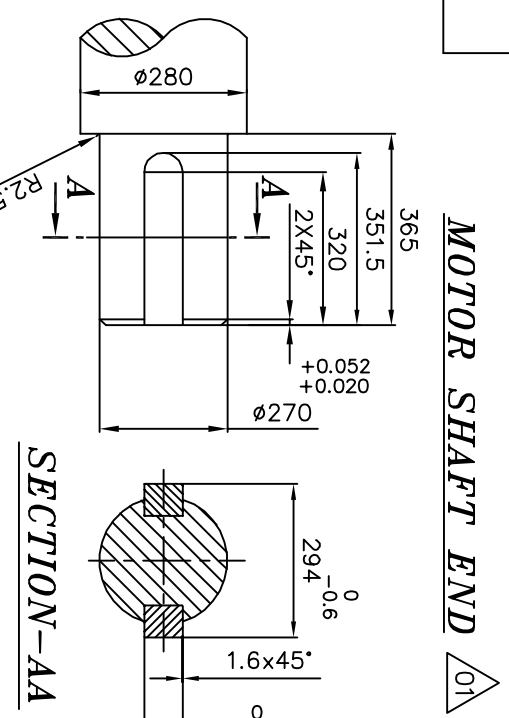
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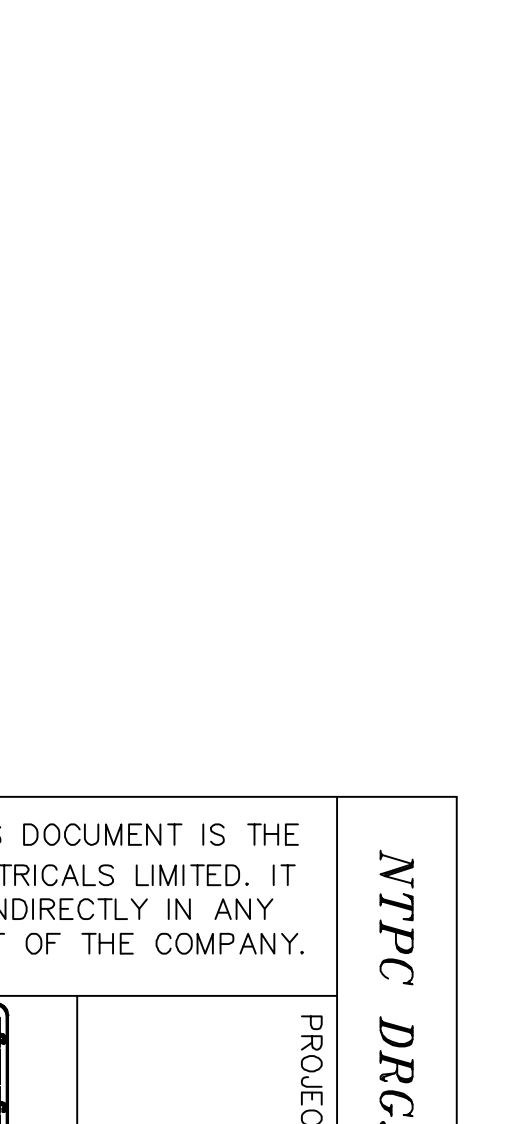
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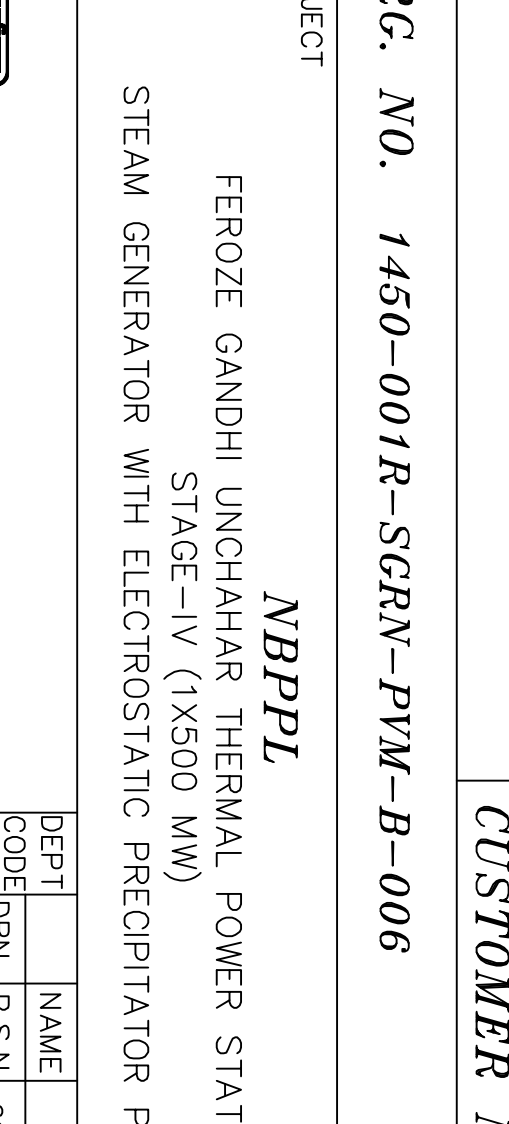
FAN SHAFT END



1000



CUSTOMER 1



REV.	DATE	ALTD:	CHKD:	APPD:
01	10.03.2014	S.AGARWAL	V.P. SHYAM	V.P. SHYAM

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NTPC DRG. NO. 1450-001R-SGRN-PVM-B-006

CUSTOMER NO. : R552

TITLE
GENERAL ARRANGEMENT OF

INDUCED DRAFT FAN
NDZV 47 SIDOR

BH&L/RAINPET DRG. NO. 0-00-099-27477	SCALE 1:50	DRAWING NO.
SHEET 01 OF 0		

REV. 01