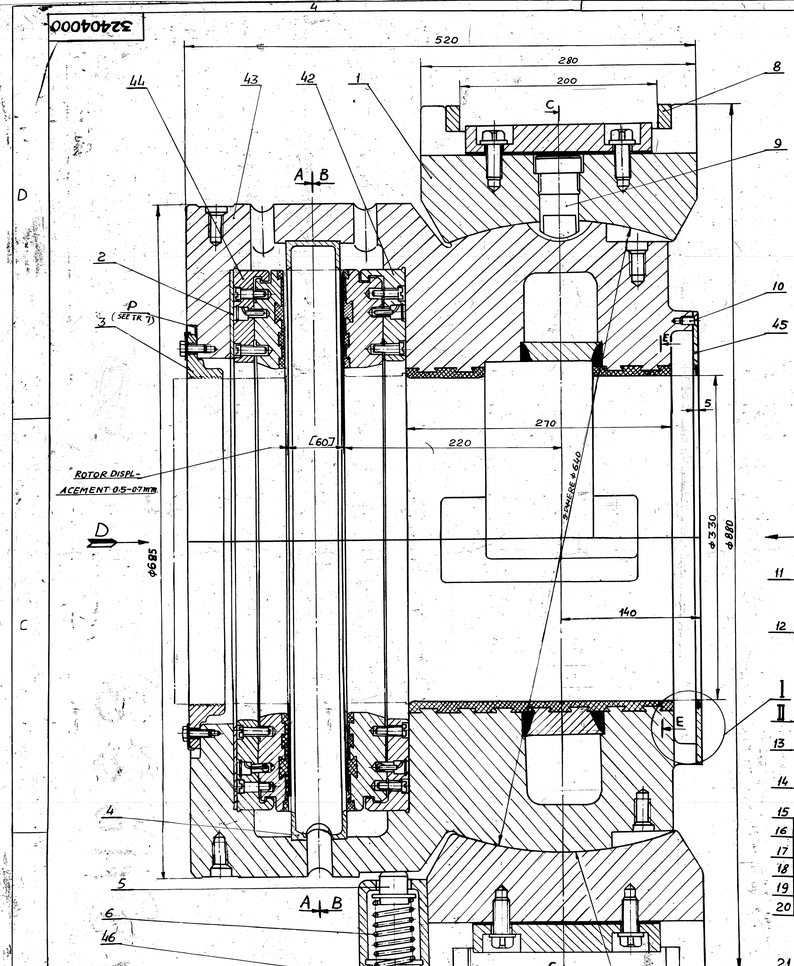
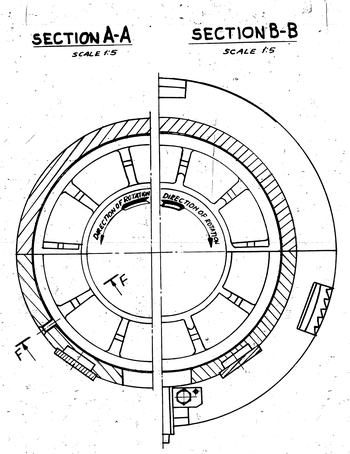
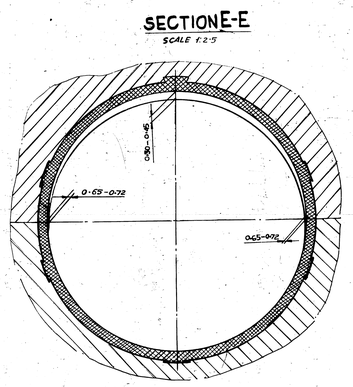
FIRST ANGLE PROJECTION

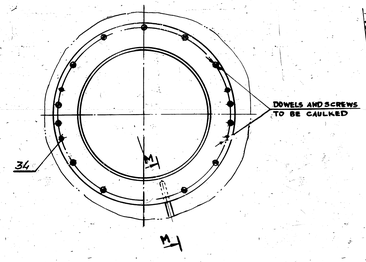
FORM 01-03

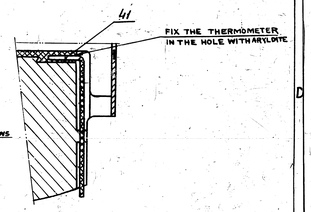
32404000

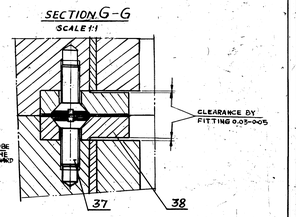


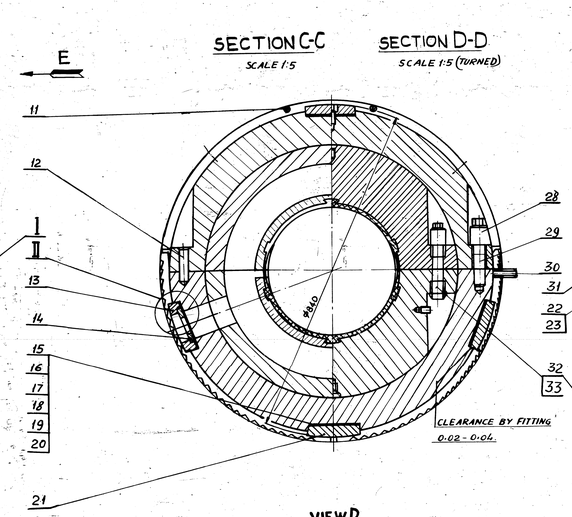


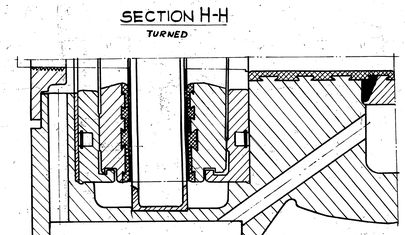


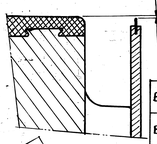




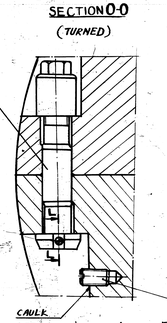


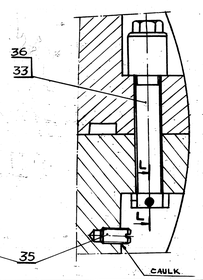


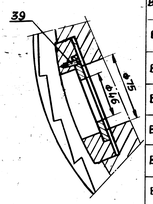


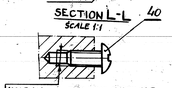


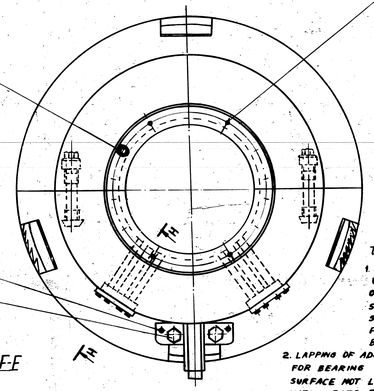
SUPERSEEDES THE OLD DRG UNDER THE SAME NO. CHANGE ADVICE NO. (STE-83-437). SIGN & DATE. 27/7/84

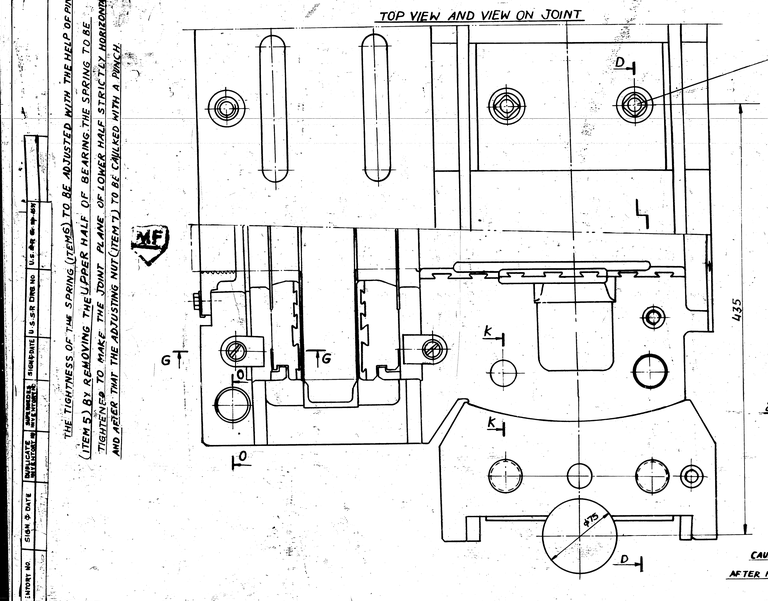




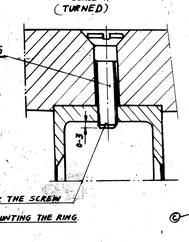








THE TIGHTNESS OF THE SPRING (ITEM 6) TO BE ADJUSTED WITH THE HELP OF PIN (ITEM 5) BY REMOVING THE UPPER HALF OF BEARING. THE SPRING TO BE TIGHTENED TO MAKE THE JOINT PLANE OF LOWER HALF STRICTLY HORIZONTAL AND AFTER THAT THE ADJUSTING NUT (ITEM 7) TO BE CAULKED WITH A PUNCH.



CAULK THE SCREW AFTER MOUNTING THE RING

TECH. REQUIREMENTS:-

1. MORE THAN THREE SHIMS ARE NOT ALLOWED UNDER ANY ADJUSTING PAD FOR THE ALIGNMENT OF THE BEARING AT THE PLANT TEST BED. THE SAME ARE SENT FOR ERECTION AT THE POWER STATION WHERE DISMANTLING OF ADJUSTING PADS AND CHANGE OF SHIMS ARE NOT ALLOWED BEFORE CHECKUP OF ALIGNMENT.
2. LAPPING OF ADJUSTING PADS TO THE BORE (IN THE PEDESTAL) FOR BEARING TO BE CHECKED WITH COLOUR (CONTACT SURFACE NOT LESS THAN 80%) AFTER FITTING THE PADS INTO SEATS FOR BEARING AND BEFORE PLACING THE ROTOR CHANGE THE SHIMS ONLY UNDER THE LOWER PAD TO ENSURE A CLEARANCE OF 0.05 mm.
3. AFTER ROTOR INSTALLATION AND INSTALLATION OF UPPER AND LOWER HALVES OF THE BEARING INCREASE THE TOTAL THICKNESS OF THE SET OF SHIMS UNDER UPPER ADJUSTING PAD BY 0.2 TO 0.25 mm TO ENSURE INTERFERENCE OF THE ORDER OF 0.1 TO 0.15 mm BETWEEN UPPER PAD AND PEDESTAL COVER DURING ASSEMBLY OF TURBINE.
4. PADS AND SHIMS ARE NOT REMOVED FROM THE BEARING FOR PACKING AND DISPATCH.
5. AFTER TESTING OF TURBINE AT PLANT TEST BED SCRAPPING OF BABBIT IS ALLOWED ONLY IN ACCORDANCE WITH THE PERMISSION CARD OF STD. ALIGNMENT IS TO BE CHECKED SECOND TIME AT THE TEST BED INCASE SCRAPPING IS EXCESSIVE.
6. CONSERVATION OF THE BEARING IS AS PER INSTRUCTION 0646-001.
7. THE SURFACES MARKED 'P' TO BE COATED WITH SHELLAC OR BAKELITE VARNISH.
8. THE DIMENSION IN BRACKETS [60] FOR REFERENCE ONLY.
9. CONSERVATION SURFACE AREA - 6 cm².
10. AFTER BABBITING, DYE PENETRANT TEST TO BE CARRIED OUT AT THE ENDS TO ENSURE PROPER BONDING OF THE BABBIT METAL.

NOTE FOR SPARE

FOR SPARE BEARING INNER DIAMETER ø330 (AS PER JOURNAL DIA) AND ø840 (AS PER LOG SHEET) SHOULD HAVE 2 MM ALLOWANCE.

ZONE	ITEM NO	DESIGNATION	DESCRIPTION	QTY	PRC WGT No. IN KG	TOTAL	MATERIAL
B4	46	31404050 1186089	CUP	1	2.37	2.37	
D3	45	32404050 1229232	OIL GAURD RING (IN TWO HALVES)	1	2.82 0.96	2.82 0.96	
D4	44	32404040 1232615	THRUST RING WITH SURGE PADS	1	60.3	60.3	
D4	43	32404030 1232605	HOUSING OF BEARING ø330	1	771	771	
D4	42	32404020 1232610	THRUST RING WITH WORKING PADS	1	64.98	64.98	
D1	41	— TCM-148	COPPER RESISTANCE THERMOMETER TYPE CRT-03 L=135, PS: 0583-001	1	0.3	0.3	— TP23 GOST 6651-53
B2	40	13-8905-130 10-7824-222	SCREW M8X20	6	0.01	0.06	STEEL 35 IS: 1367-61 20 GOST 1050-60
B1	39	21-8904-073 H 27-64	SCREW M5X12 IS: 1365-62	1	0.002	0.002	STEEL 45 IS: 1367-61 25 GOST 1050-60
C1	38	31404028 1070261	STOPPER	8	0.07	0.56	STEEL St-42-0 IS: 226-62 MCM3 GOST 380-50
C1	37	21-8904-158 H 27-64	SCREW M10X25 IS: 1365-62	8	0.016	0.128	STEEL 45 IS: 1367-61 25 GOST 1050-60
B2	36	32404011 1223965	SPECIAL BOLT M24X150	2	0.78	1.56	STEEL C20 IS: 2073-62 25 GOST 1050-60
B2	35	23-8907-226 H 34-61	SCREW M16X50 IS: 2388-63	9	0.025	0.234	STEEL 35 IS: 1367-61 25 GOST 1050-60
B2	34	31-8935-164 H 69-61	CYLINDRICAL PIN G16 X14 IS: 2393-63	8	0.015	0.120	STEEL C40 IS: 2073-62 45 GOST 1050-60
B2	33	49-8945-024 TM 387-3-39	CAP NUT M24	6	0.361	2.166	STEEL C40 IS: 2073-62 35 GOST 1050-60
B2	32	32404009 TM 540-67	SPECIAL BOLT M24X150	4	0.815	3.230	STEEL C20 IS: 2073-62 35 GOST 1050-60
B2	31	32404098 1216482	COVER	2	1.5	3.0	STEEL St-42-0 IS: 226-62 MCM3 GOST 380-50
B2	30	32425014 1223623	STOP WASHER	1	0.625	0.625	STEEL St-3M GOST 380-50 Sheet 20 - 4.75
ZONE	ITEM NO	DESIGNATION	DESCRIPTION	QTY	PRC WGT No. IN KG	TOTAL	MATERIAL

ZONE	ITEM NO	DESIGNATION	DESCRIPTION	QTY	PRC WGT No. IN KG	TOTAL	MATERIAL
B3	29	23-8951-339 H 252-67	STUD M20X180 IS: 1862-61	4	0.739	2.956	STEEL 35 IS: 1367-61 25 GOST 1050-60
B2	28	31404024 102 1075	CAP NUT M30	4	0.336	1.344	STEEL C20 IS: 2073-62 20 GOST 1050-60
A3	27	51-8935-197 H 60-61	CYLINDRICAL PIN 8X40 X25 IS: 2393-63	2	0.010	0.020	STEEL C40 IS: 2073-62 45 GOST 1050-60
A3	26	33-8920-267 H 238-64	BOLT M20X40 IS: 1364-60	2	0.164	0.328	STEEL 35 IS: 1367-61 25 GOST 1050-60
A3	25	21-8904-164 H 27-64	SCREW M10X45 IS: 1365-62	6	0.038	0.214	STEEL 45 IS: 1367-61 25 GOST 1050-60
B3	24	32425011 H 42-62	BOLT M16X55	6	0.103	0.620	STEEL C40 IS: 2073-62 45 GOST 1050-60
B3	23	11-8951-098 GOST 3693-82	LOCKING WASHER M8	38	0.007	0.266	STEEL 45 IS: 1367-61 10 KH GOST 1050-60
B3	22	33-8920-131 H 426-64	BOLT M8X20 IS: 1364-60	58	0.016	0.928	STEEL 35 IS: 1367-61 20 GOST 1050-60
B3	21	32425009 TM 527-66	ADJUSTING PAD	3	5.5	16.5	STEEL 35 GOST 4784-74 MCM3 GOST 380-50
B3	20	32425007 TM 528-6-66	SHIM THICK S = 1.0 mm	4	0.164	0.656	— STEEL 2X13 GOST 4986-54
B3	19	32425006 TM 528-5-66	SHIM THICK S=0.5 mm	2	0.082	0.164	— STEEL 2X13 GOST 4986-54
B3	18	32425005 TM 528-4-66	SHIM THICK S=0.3 mm	2	0.049	0.098	STEEL 2X13 GOST 4986-54
B3	17	32425004 TM 528-3-66	SHIM THICK S=0.2 mm	2	0.033	0.066	STEEL 2X13 GOST 4986-54
B3	16	32425003 TM 528-2-66	SHIM THICK S=0.15 mm	2	0.024	0.048	— STEEL 2X13 GOST 4986-54
B3	15	32425002 TM 528-1-66	SHIM THICK S=0.1 mm	2	0.016	0.032	— STEEL 2X13 GOST 4986-54
C3	14	32404007 TM 329-66	ORIFICE PLATE ø46	1	0.309	0.309	STEEL St-42-0 IS: 226-62 CM3 GOST 380-50
C3	13	32425008 TM 525-66	ADJUSTING PAD WITH HOLE	1	4.74	4.74	STEEL St-42-0 IS: 226-62 MCM3 GOST 380-50
C3	12	31404016 1021708	LOCATING PIN 25X100	2	0.36	0.72	STEEL C40 IS: 2073-62 45 GOST 1050-60
C3	11	21-8904-110 H 27-64	SCREW M6X25 IS: 1365-62	8 A 8	0.006	0.048 0.032	STEEL 45 IS: 1367-61 20 GOST 1050-60
D3	10	21-8904-128 H 27-64	SCREW M8X15 IS: 1365-62	13	0.007	0.091	STEEL 45 IS: 1367-61 20 GOST 1050-60
D3	9	32404006 1136314	STOPPER	1	0.9	0.9	STEEL C40 IS: 2073-62 CM3 GOST 380-50
D3	8	32404005 1070268	ADJUSTING RING	2	8.4	16.8	STEEL St-42-0 IS: 226-62 MCM3 GOST 380-50
B4	7	31404031 1186060	ADJUSTING NUT	1	0.68	0.68	STEEL C20 IS: 2073-62 25 GOST 1050-60
B4	6	31404033 1004242	COMPRESSION SPRING	1	0.6	0.6	STEEL C 60 IS: 2062-61 60 GOST 2090-58
B4	5	31404032 1090573	PIN	1	0.36	0.36	STEEL C20 IS: 2073-62 CM3 GOST 380-50
C4	4	32404004 1232609	SEALING RING	1	2.5	2.5	ALUMINIUM AL-4 IS: 1127-53 A-8 GOST 2685-53 BRASS GT
D4	3	32404003 1232608	SEALING RING	1	3.1	3.1	ALUMINIUM AL-4 IS: 1127-53 A-8 GOST 2685-53 BRASS GT
D4	2	32404002 1232607	ADJUSTING RING	1	2.1	2.1	STEEL St-42-0 IS: 226-62 MCM3 GOST 380-50
D4	1	32404001 1232606	HOUSING FOR BEARING IN TWO HALVES	1	570	570	CAST IRON GC 25 IS: 1030-61 Grade 25
ZONE	ITEM NO	DESIGNATION	DESCRIPTION	QTY	PRC WGT No. IN KG	TOTAL	MATERIAL

REMARK

32404000 SP

C - 200 - 130

RADIAL THRUST BEARING ø330

32404000

LETTER | WEIGHT | SCALE

SHEET 8 | TOTAL SHEETS

STD

A3	C	1	172-80-17		
	D	2	172-80-18		
A3	C	1	172-80-20		
B7	D	2	172-80-16		
A3	E	1	172-80-23		
ZONE	NO.		INCHARGE		
	NAME				
	DESIGNED				
	CHECKED				
	TECH. CHEC				
	STD. CHEC				
	APPROVED				