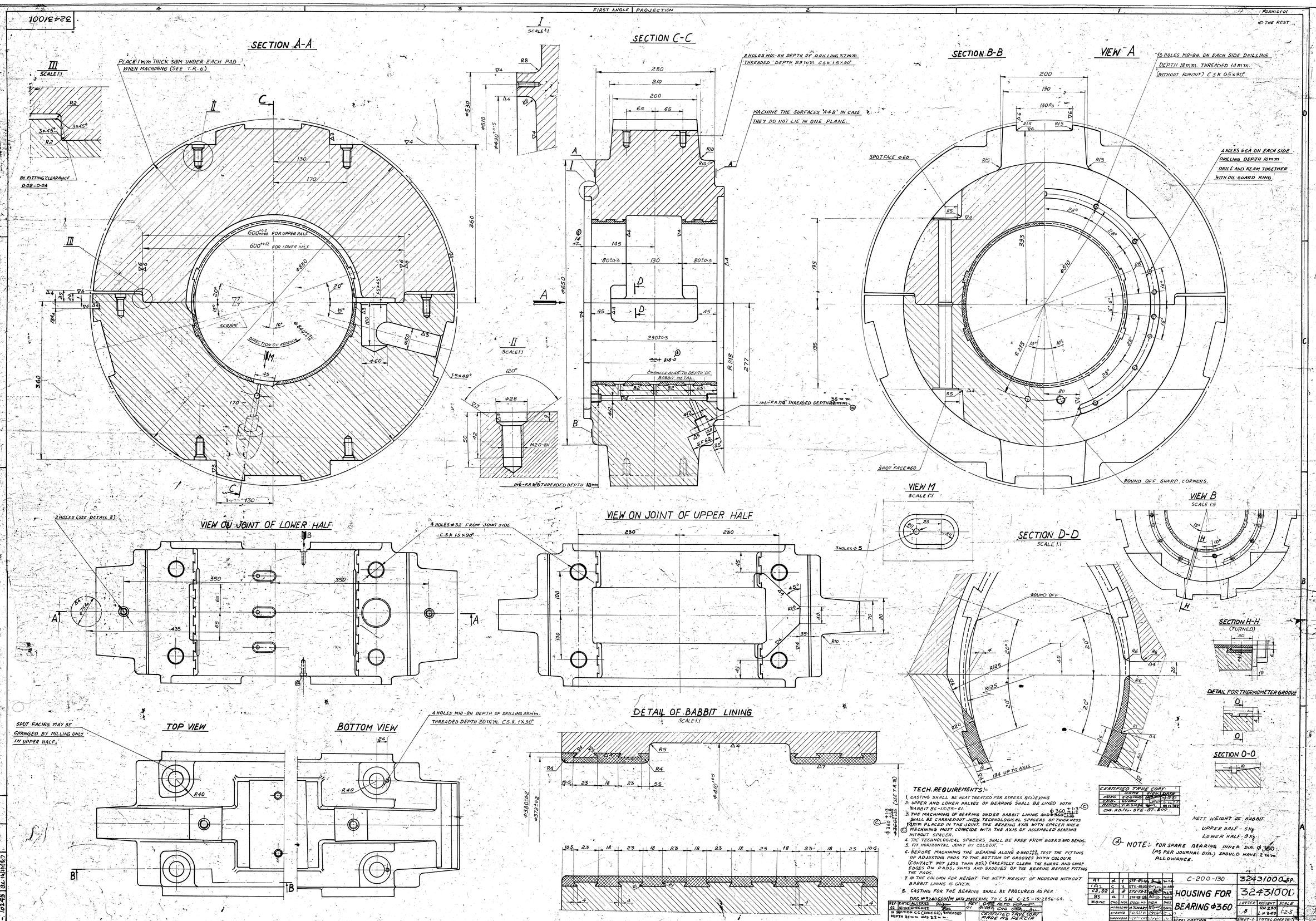
32431001
FIRST ANGLE PROJECTION
FORM 01-01
SECTION A-A
PLACE 1mm THICK SHIM UNDER EACH PAD WHEN MACHINING (SEE T.R.6)
BY FITTING CLEARANCE 0.02-0.04
600 FOR UPPER HALF
600 FOR LOWER HALF
SCRAPE
DIRECTION OF ROTATION
SECTION C-C
8 HOLES M16-8H DEPTH OF DRILLING 37mm THREADED DEPTH 29mm C.S.K 1.5×90°
MACHINE THE SURFACES 'A & B' IN CASE THEY DO NOT LIE IN ONE PLANE.
CHAMFER AT 45° TO DEPTH OF BABBIT METAL.
INL-FR 3/4" THREADED DEPTH 35mm
INL-FR 3/8" THREADED DEPTH 18mm
SECTION B-B
VIEW A
13 HOLES M8-8H ON EACH SIDE DRILLING DEPTH 18mm THREADED 14mm (WITHOUT RUNOUT) C.S.K 0.5×90°
4 HOLES Φ6A ON EACH SIDE DRILLING DEPTH 10mm DRILL AND REAM TOGETHER WITH OIL GUARD RING.
SPOT FACE Φ60
ROUND OFF SHARP CORNERS.
VIEW M
SCALE 1:1
VIEW B
SCALE 1:5
SECTION D-D
SCALE 1:1
ROUND OFF
194 UP TO AXIS
SECTION H-H
(TURNED)
DETAIL FOR THERMOMETER GROOVE
SECTION O-O
VIEW ON JOINT OF LOWER HALF
2 HOLES (SEE DETAIL B)
4 HOLES Φ32 FROM JOINT SIDE C.S.K 1.5×90°
VIEW ON JOINT OF UPPER HALF
3 HOLES Φ5
TOP VIEW
SPOT FACING MAY BE CHANGED BY MILLING ONLY IN UPPER HALF.
BOTTOM VIEW
4 HOLES M10-8H DEPTH OF DRILLING 26mm THREADED DEPTH 20mm C.S.K 1×90°
DETAIL OF BABBIT LINING
SCALE 1:1
TECH. REQUIREMENTS:-
1. CASTING SHALL BE HEAT TREATED FOR STRESS RELIEVING
2. UPPER AND LOWER HALVES OF BEARING SHALL BE LINED WITH BABBIT 86-IS:25-61.
3. THE MACHINING OF BEARING UNDER BABBIT LINING AND BACKING SHALL BE CARRIED OUT WITH TECHNOLOGICAL SPACERS OF THICKNESS 1.2mm PLACED IN THE JOINT. THE BEARING AXIS WITH SPACER WHEN MACHINING MUST COINCIDE WITH THE AXIS OF ASSEMBLED BEARING WITHOUT SPACER.
4. THE TECHNOLOGICAL SPACERS SHALL BE FREE FROM BURRS AND BENDS.
5. FIT HORIZONTAL JOINT BY COLOUR.
6. BEFORE MACHINING THE BEARING ALONG Φ840 TEST THE FITTING OF ADJUSTING PADS TO THE BOTTOM OF GROOVES WITH COLOUR (CONTACT NOT LESS THAN 80%) CAREFULLY CLEAN THE BURRS AND SHARP EDGES ON PADS, SHIMS AND GROOVES OF THE BEARING BEFORE FITTING THE PADS.
7. IN THE COLUMN FOR WEIGHT THE NETT WEIGHT OF HOUSING WITHOUT BABBIT LINING IS GIVEN.
8. CASTING FOR THE BEARING SHALL BE PROCURED AS PER DRG. No 3240 6001/M WITH MATERIAL TO C.S.W. C-25-IS:2856-64.
CERTIFIED TRUE COPY
NETT WEIGHT OF BABBIT:
UPPER HALF - 5kg
LOWER HALF - 9kg
NOTE:- FOR SPARE BEARING INNER DIA. Φ360 (AS PER JOURNAL DIA.) SHOULD HAVE 2mm ALLOWANCE.
C-200-130
HOUSING FOR BEARING Φ360
32431001
S.T.D.