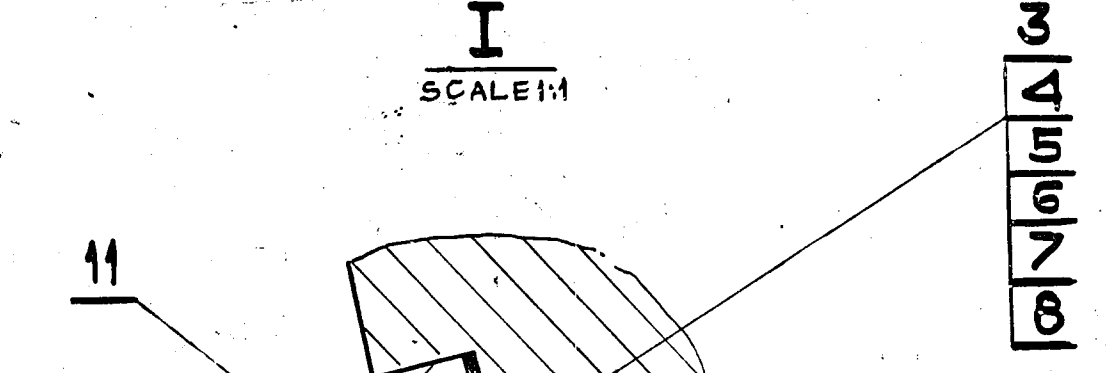
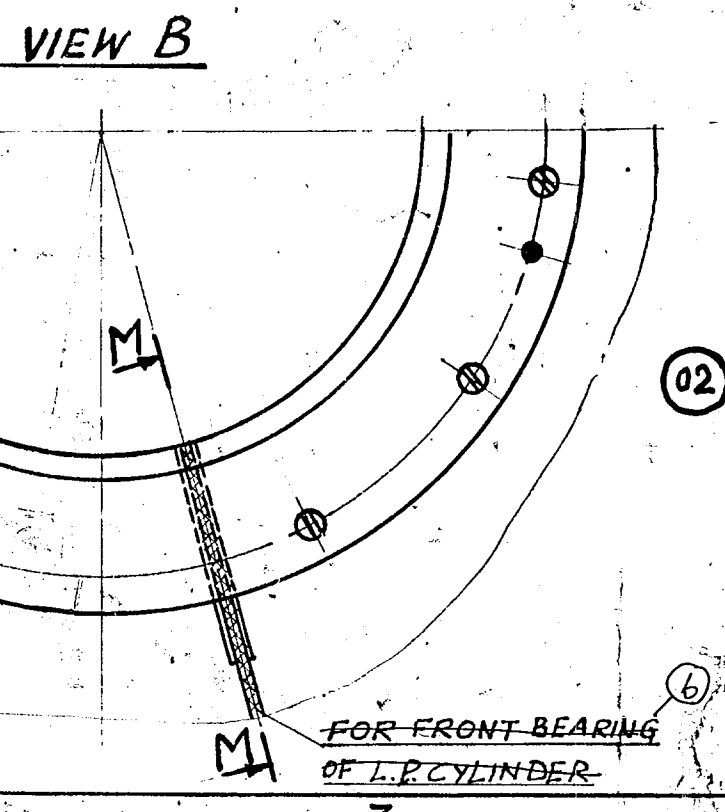
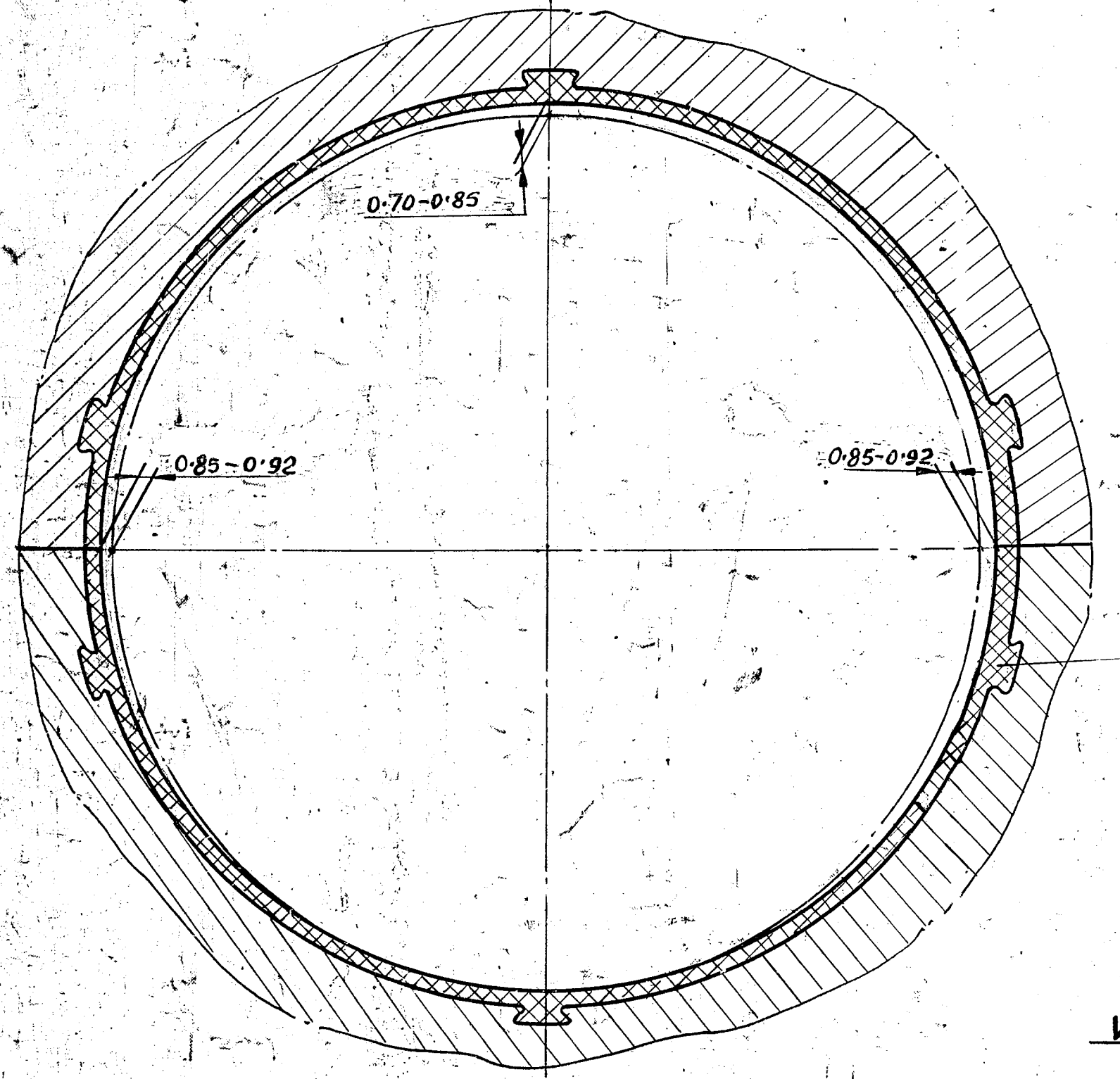


DETAIL OF FASTENING OF ORIFICE PLATE



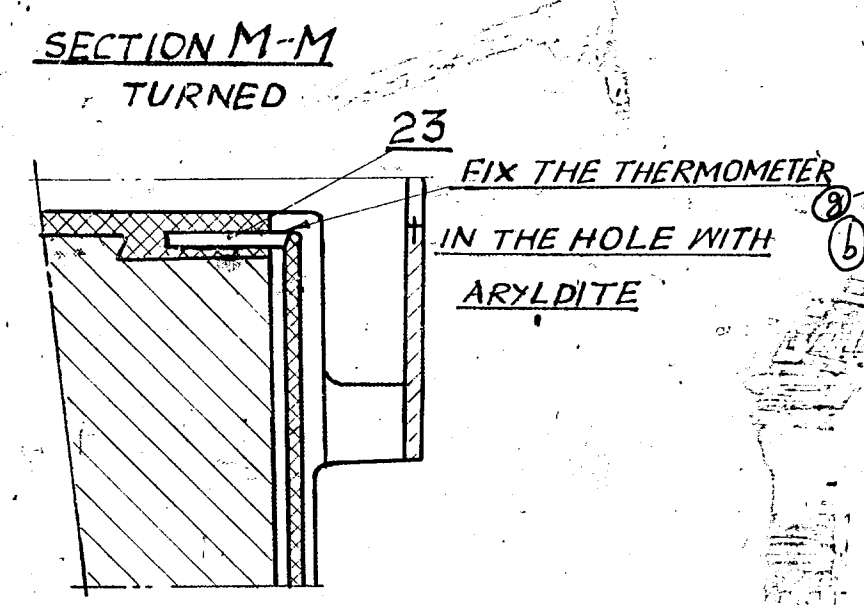
NOTE FOR SPARE:-  
FOR SPARE BEARING  
INNER DIAMETER  $\phi$  435 (AS PER  
JOURNAL DIA) AND  $\phi$  870 (AS PER  
LOG SHEET) SHOULD HAVE 2MM  
ALLOWANCE IN EACH CASE.

- TECHNICAL REQUIREMENTS:-
- 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.
  - 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 0.15 TO 0.35 mm.
  - ENSURE AN INTERFERENCE OF THE ORDER OF 0.15 TO 0.25 mm BETWEEN UPPER PAD AND PEDESTAL COVER DURING ASSEMBLY OF TURBINE.
  - FOR MACHINING OF  $\phi$  870, PLACE SHIMS OF 1MM THICKNESS UNDER EVERY ADJUSTING PAD. OTHER SHIMS OF THICKNESS 0.5, 0.3, 0.2, 0.15 TO 0.10 ARE MEANT FOR CENTERING.
  - PADS AND SHIMS ARE NOT REMOVED FROM THE BEARING FOR PACKING AND DISPATCH.
  - 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 IN CASE SCRAPPING IS EXCESSIVE.
  - THE HOLES FOR LOCATING PINS (PART 19) ARE TO BE DRILLED TOGETHER WITH OIL GUARD RINGS PART 27.
  - PAINTING AND CONSERVATION OF THE BEARING IS AS PER INSTRUCTION 0446.001. PAINTING SURFACE AREA - 2m<sup>2</sup>. CONSERVATION SURFACE AREA - 0.0m<sup>2</sup>.
  - DIMENSION IN BRACKETS FOR REFERENCE ONLY.
  - AFTER BABBITING, DYE PENETRANT TEST TO BE CARRIED OUT AT THE ENDS TO ENSURE PROPER BONDING OF THE BABBIT METAL.
  - ITEM NO. 24 IS OF SPECIAL PIPE JOINT DRG. NO. 32431010 WILL BE DESPATCHED WITH THE JACKING OUT. PIPE LINE DRG. NO. 32431000, IF THE BRG. IS TO BE USED AS PIPE. FRONT OR JACK OIL PIPE LINE DRG. NO. 32431000 IS TO BE USED AS L.A.C. REAR BRG. NO. 25 OPENING THREADS OF ITEM NO. 001 OF 32431010 TO BE PROTECTED BY RUNTAP BEFORE DISPATCH.
- NOTE: ITEM NO. 29 TO BE USED IN PLACE OF ITEM NO. 23 FOR ALL SETS AFTER SET NO. 49 I.E. METTUR-I ONWARDS. FOR SET NO. 49 AND EARLIER SETS ITEM NO. 23 HOLDS GOOD.

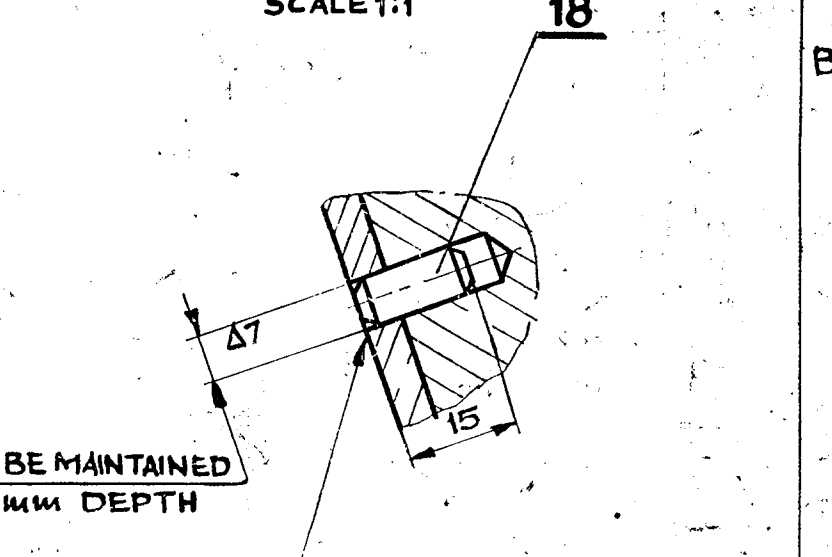


VARIANT TABLE:

VAR.	DESCRIPTION
00	EXISTING BEARINGS
01	BEARING FOR UPGRADING OF 200/210MM L.M.N. SETS. C.BDM-00032432000-01.



DETAIL OF MOUNTING OF OIL GUARD RINGS ON LOCATING PINS



ZONE	ITEM NO.	DESIGNATION	DESCRIPTION	QTY	P.P.C. TOTAL	MATERIAL	REMARKS
B2	29	AA7324.620	PRD CYL. L. 25 DUPLX 3000	2	0.30	TYPE CRT. 03	
B3	28	13-524-013	PIPE JOINT DRG. NO. 32431010	1	0.24	STEEL C 20	SEE R.R. 71 SUB-ASSY.
B4	27	32425020	OIL GUARD RING (IN TWO HALVES)	2	7.18	STEEL C 20	SUB-ASSY.
B4	26	71-8322-014	PLUG 3/4" PIPE	1	0.215	AA:10108	
B4	25	17-8370-015	SEALING RING d=28	2	0.305	COPPER FRTP-2	
B3	24	17-8370-012	SEALING RING d=18	2	0.005	COPPER FRTP-2	
B2	23	-	COPPER RESISTANCE THERMOMETER TYPE CRT-03	1	0.03	TYPE CRT. 03	
B4	22	71-8322-011	PLUG 3/8" PIPE	2	0.063	STEEL C 20	
A3	21	-	BABBIT	-	-	BABBIT 86	
A3	20	32420002	ORIFICE PLATE $\phi$ 26	1	0.246	STEEL C 20	
B2	19	32425014	STOP WASHER	1	0.625	STEEL 25MM $\phi$	
B2, B1	18	51-8935-154	CYLINDRICAL PIN 6X6X14	8	0.003	STEEL C 40	
B2	17	21-8904-128	SCREW M8X15	26	0.007	STEEL 45	
B1	16	32425013	SCREW SPECIAL	4	0.046	STEEL C 40	
B2	15	11-8994-189	SPLIT COTTER PIN 6.3X6.3	4	0.019	MILD STEEL	
B2	14	23-8940-019	NUT M36	4	0.396	STEEL S D	
B2	13	32425012	SPECIAL BOLT M36X140	4	3.88	STEEL C 40	
B4	12	32425011	BOLT M16X35	8	0.109	STEEL C 40	
A3	11	21-8904-079	SCREW M5 X12	1	0.002	STEEL 45	
B2	10	32425009	ADJUSTING PAD	3	5.5	STEEL SE-42-S	
A3	9	32425008	ADJUSTING PAD WITH HOLE	1	4.74	STEEL SE-42-S	
A3	8	32425007	SHIM THICK S=1.0mm	4	0.164	STEEL 30 C13	
A3	7	32425006	SHIM THICK S=0.5mm	2	0.082	STEEL 22 C13	
A3	6	32425005	SHIM THICK S=0.3mm	2	0.049	STEEL 22 C13	
B3	5	32425004	SHIM THICK S=0.2mm	2	0.033	STEEL 22 C13	
B3	4	32425003	SHIM THICK S=0.15mm	2	0.029	STEEL 22 C13	
B3	3	32425002	SHIM THICK S=0.1mm	2	0.0164	STEEL 22 C13	
B4	2	32432001	HOUSING FOR BEARING (LOWER HALF)	1	369	CSW-C25/152856-64	
B4	1	32432001	HOUSING FOR BEARING (UPPER HALF)	1	338	CSW-C25/152856-64	

JOURNAL BEARING  $\phi$  435 (FRONT AND REAR-BEARING OF LPC)

LETTER	WEIGHT	SCALE
B	782.6	1:5

SHEET-1 TOTAL SHEET 1  
HEEP STD

INVENTOR: SIGN AND DATE  
SUPERVISOR: SIGN AND DATE  
DRAWING: SIGN AND DATE  
CHECKED BY: SIGN AND DATE  
DATE: 31/10/10

ZONE	CHG. NOS.	DOC. NO.	SIGN	DATE
A3	02	1	STE-10/10/10	31-10-10
A2	01	2	STE-06/04/10	31-10-10
INT. TR.	3	1	STE-01/04/10	31-10-10
ZONE	CHG. NOS.	DOC. NO.	SIGN	DATE