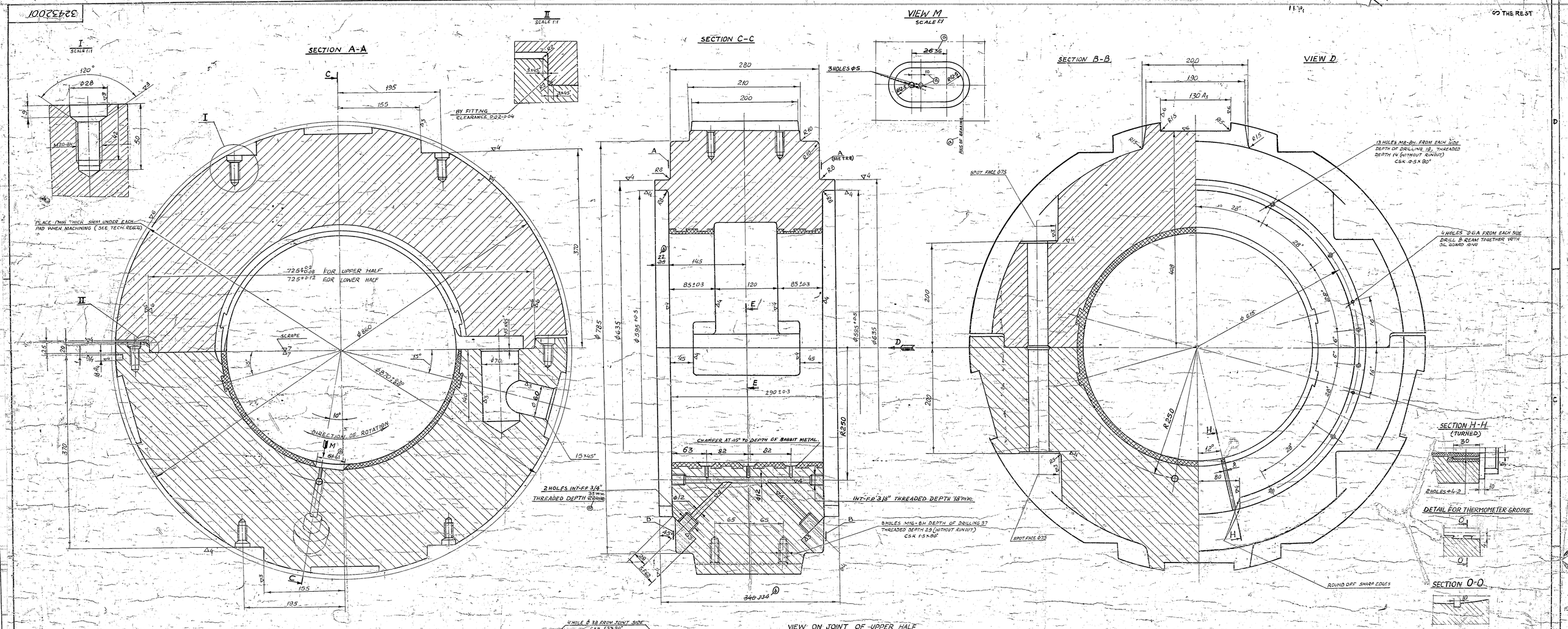
32432001

FIRST ANGLE PROJECTION

√0 THE REST



TECH REQUIREMENTS

1. CASTING SHALL BE HEAT TREATED FOR STRESS RELIEVING
2. UPPER AND LOWER HALVES OF BEARING SHALL BE LINED WITH BABBIT Б6-1525-61 (Б-83 GOST 1320-55)
3. THE MACHINING OF BEARING UNDER BABBIT LINING AND ϕ435$^{+1.35}_{+1.25}$ SHALL BE CARRIED OUT WITH TECHNOLOGICAL SPACERS OF THICKNESS 1mm 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 ϕ870$^{+0.30}_{+0.15}$ TEST THE FITTING OF ADJUSTING PADS TO THE BOTTOM 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 NET WEIGHT OF HOUSING IS GIVEN
   NET WEIGHT OF BABBIT UPPER HALF – 7.2 Kg
   LOWER HALF – 11.9 Kg
8. MACHINE THE SURFACES A & B INCASE THEY DO NOT LIE IN ONE PLANE.
9. CASTING FOR THE BEARING SHALL BE PROCURED AS PER DRG.No 32425001/M WITH MATERIAL TO CSW C-25-15:2856-64.

(6) NOTE: FOR SPARE BEARING INNER DIA ϕ435 (AS PER JOURNAL DIA) SHOULD HAVE 2mm ALLOWANCE.

.01	01	STE-09-P 1274				C-200-130	32432000 SP
C	1	STE-09-2485					
Б	2	STE-09-P 1273				HOUSING FOR BEARING ϕ435	32432001
Г	2	STE-09-P 1272					
CHG.	NOS.	DOCUMT.	SIGN	DATE			
WORKED		M Tyurina				LETTER: B	WEIGHT: UM 338 LM 367
CHECKED		U Prokhyan					SCALE: 1:2.5
SUPERVISED							
TECH-CONT		S Palk				CSW-C25 15:2856-64	SHEET 1 / TOTAL SHEET 7
STD-CONT						П-0590-A01	
APPROVED		D Sul				HEEP STD	

NET WEIGHT NAME SIGN DATE

SIZE A4