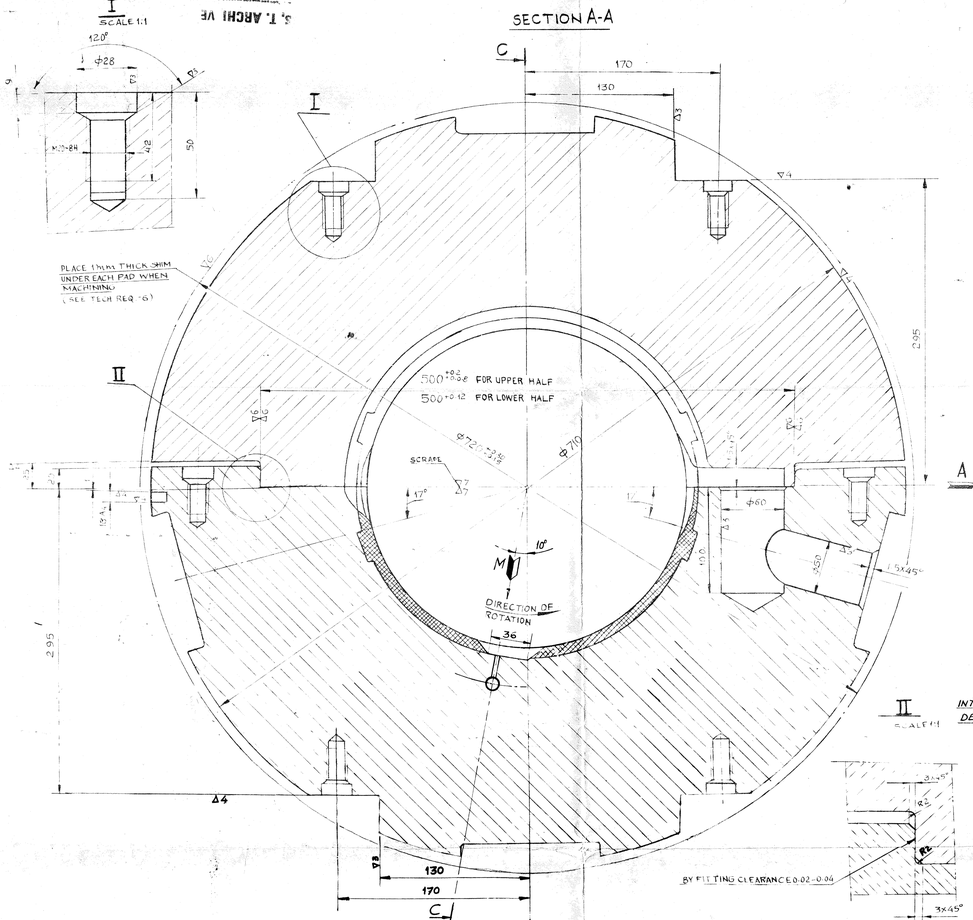
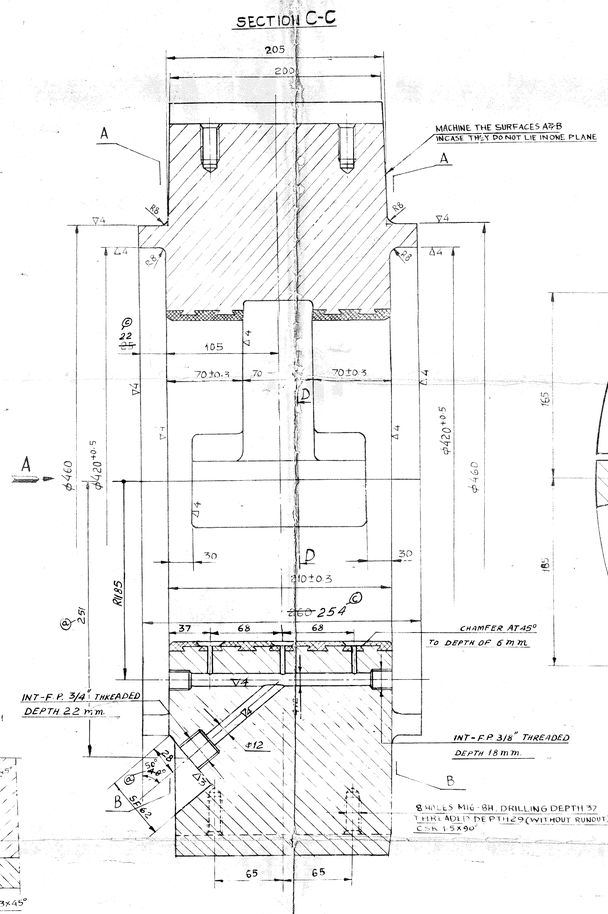
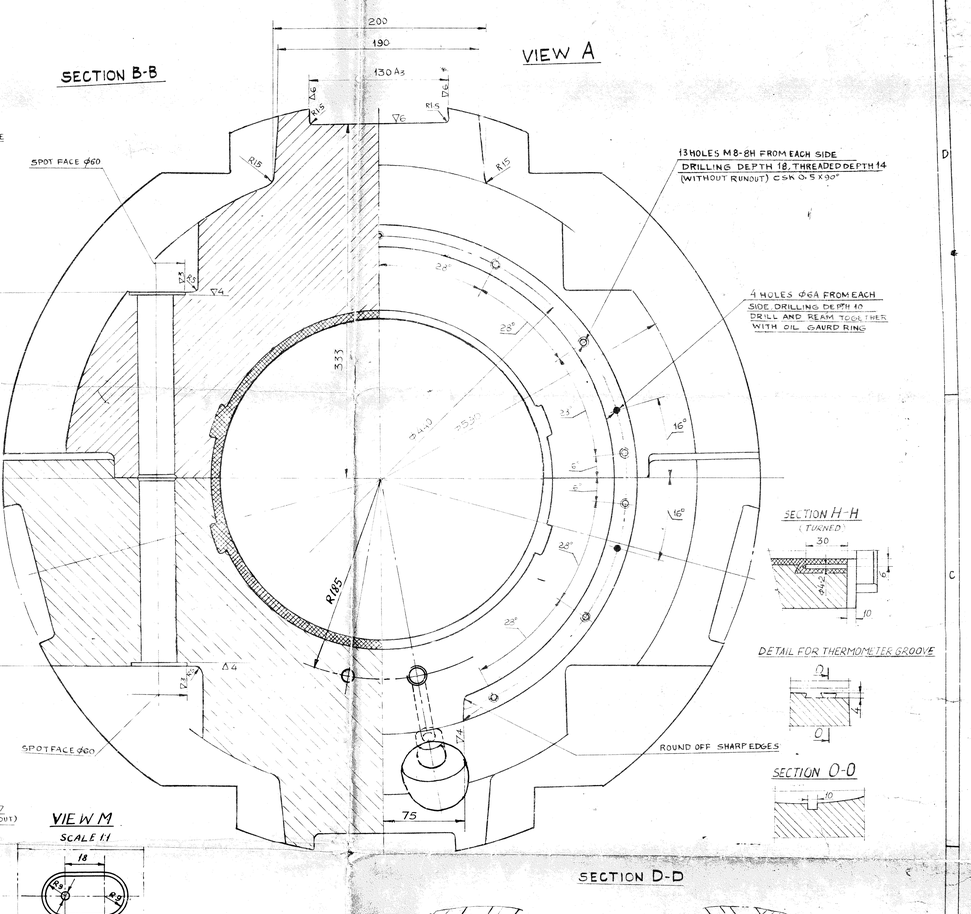
3243300 1

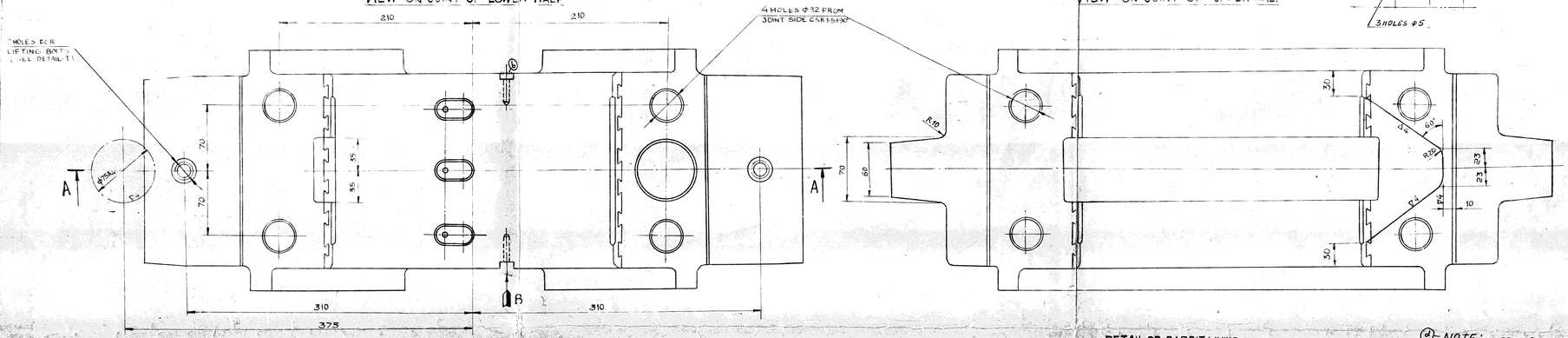
S. T. ARCHIVE

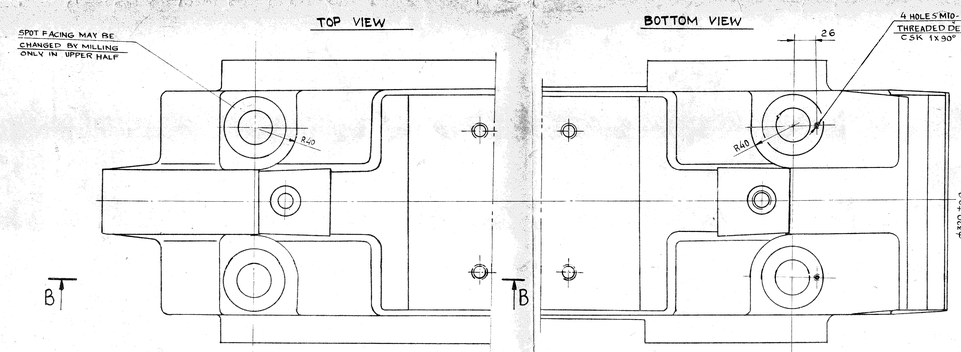
THE REST

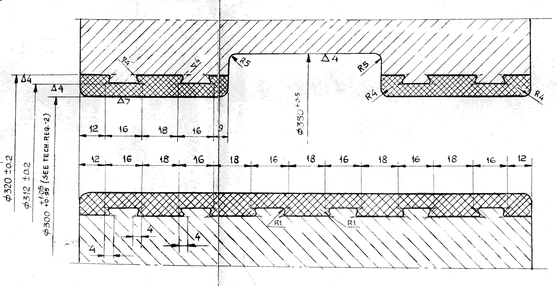












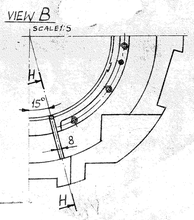
8. CASTING FOR THE BEARING SHALL BE PROCURED AS PER DRG. No 32423001/M WITH MATERIAL TO CSW C-25, IS:2856-64.

NOTE: FOR SPARE BEARING INNER DIAMETER Ø300 (AS PER JOURNAL DIA) SHOULD HAVE 2mm ALLOWANCE.

TECHNICAL REQUIREMENTS:-

1. CASTING SHALL BE HEAT-TREATED FOR STRESS RELIEVING.
2. UPPER AND LOWER HALVES OF BEARING SHALL BE LINED WITH BABBIT B6 - IS:25-64 (B-83 GOST 1320-55)
3. THE MACHINING OF BEARING UNDER BABBIT LINING AND Ø300 +0.05 -0.02 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 Ø720 +0.3 -0.1 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.

NETT WEIGHT OF BABBIT
UPPER HALF — 4 Kg
LOWER HALF — 6 Kg



RD-7.01

B1 B2	4	1	STE-93x45					
C2, D2	2	3	STE-93x45					
B3	6	1	STE-93x45					
C3	4	3						
D3	4	3						
SYMBOL	NO	DOCUMENT						
MORALOV	M. TIMANY							
CHECKED BY								
SUPERVISED								
TECH CONT								
STD CONT								
APPROVED								

MAT.	NAME	SIGN	DATE
ASSEM'D BY			

C - 200 - 150

32433000 SP

HOUSING FOR BEARING Ø300

32433001

LETTER	WEIGHT	SCALE
B	UH 190 LH 216	1:2

CSW - C25/IS 2856-64

II - 0500 - 401

SHEET 1 TOTAL SHEETS 1

HEEP STD

SIZE A4

INVENTORY NO | SIGN & DATE | SUPERSEDING ASSY | SIGN & DATE | INVENTORY NO