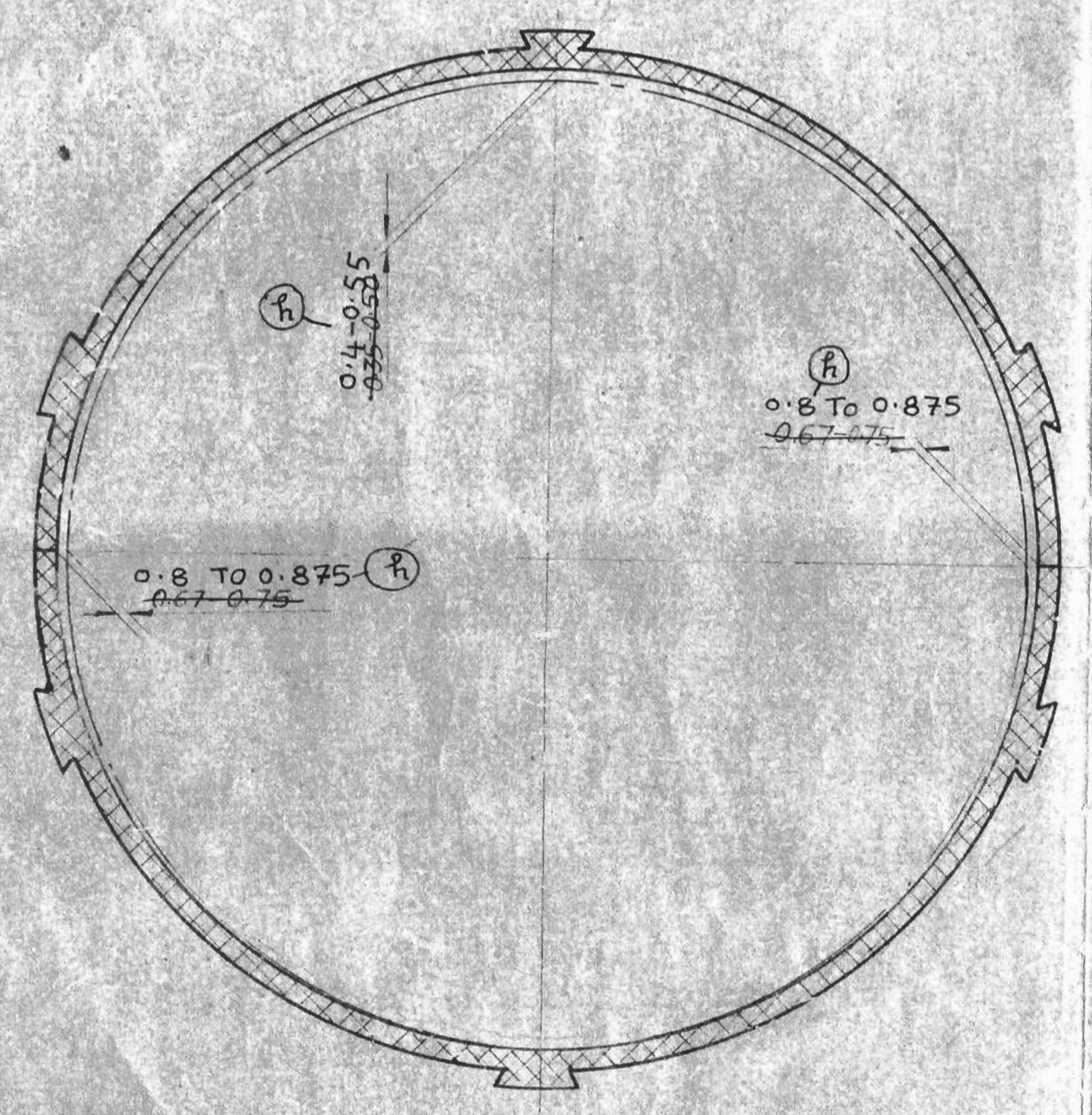
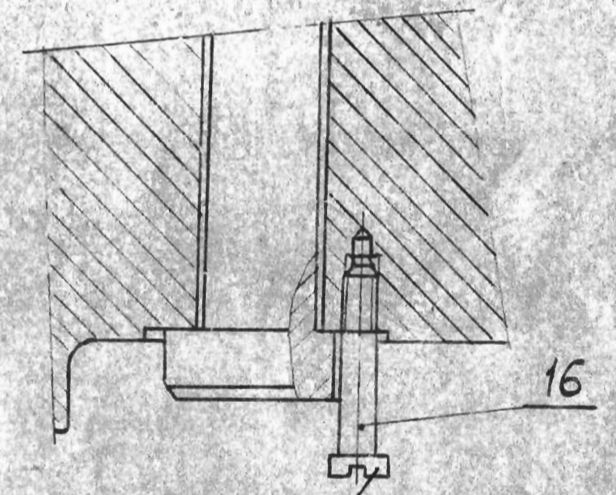


SECTION B-B
SCALE 1:2.5



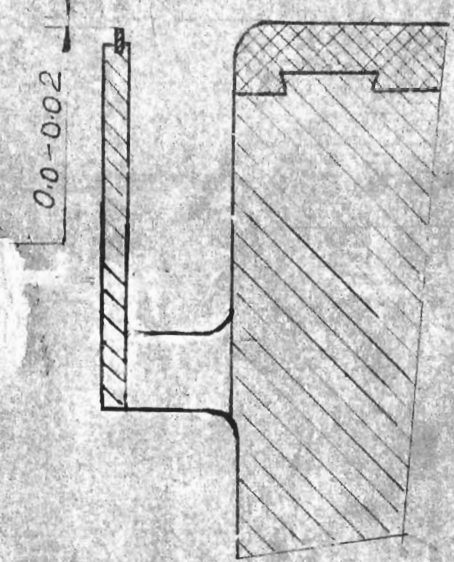
SCALE 1:2

NOTE: ITEM NO. 23 TO BE USED IN PLACE OF ITEM NO. 23 FOR ALL SETS AFTER SET NO. 49 i.e. METTUR-I OWNWARDS. FOR SET NO. 49 AND EARLIER SETS ITEM NO. 23 HOLDS GOOD.

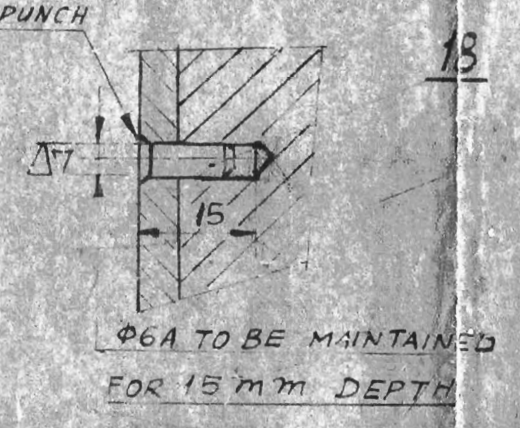


LOCK THE SET SCREW BY TIGHTENING UP TO ITS THREAD RUNOUT

SCALE 1:2



SECTION D-D
SCALE 1:1 (TURNED)



NOTE FOR SPARE:-

FOR SPARE BEARING INNER DIAMETER 360 (AS PER JOURNAL DIA) AND 340 (AS PER LOG SHEET) SHOULD HAVE 2 MM ALLOWANCE IN EACH CASE.

TECH. 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 & 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 0.25 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 360 PLACE SHIMS OF 1mm THICKNESS UNDER EVERY ADJUSTING PAD. OTHER SHIMS OF THICKNESS 0.5, 0.3, 0.2, 0.15 & 0.1 ARE MEANT FOR CENTERING.
- PADS AND SHIMS ARE NOT REMOVED FROM THE BEARING FOR PACKING AND DESPATCH.
- AFTER TESTING OF TURBINE AT THE 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 (ITEM 18) ARE TO BE DRILLED TOGETHER WITH OIL GUARD RINGS (ITEM 26)
- PAINTING AND CONSERVATION OF THE BEARING IS AS PER INSTRUCTIONS OULG 001.
- PAINTING SURFACE AREA - 2m²
- CONSERVATION SURFACE AREA - 0.6m²
- AFTER BABBETING, DYE PENETRANT TEST TO BE CARRIED OUT AT THE ENDS TO ENSURE PROPER BONDING OF THE BABBIT METAL.

ZONE	ITEM NO.	DESIGNATION	DESCRIPTION	QTY.	PER PIECE	TOTAL	MATERIAL	REMARKS
B1	28	AA7327622	PRD. CYL D4 L 25 DUPLEX 2000	2	0.30	0.60	TYPE PR703 AA7327622	
B1	27	32431010	SPECIAL PIPE JOINT DNOM15	1	0.844	0.844		SUB ASSY.
B4	26	32406010	OIL GUARD RING (IN TWO HALVES)	2	1.205	2.410		SUB-ASSY.
B1	25	178370-015	SEALING RING d=28	1	0.009	0.009	CO PER FRTP-2 05.92.007	
B1	24	178370-012	SEALING RING d=18	2	0.005	0.010	CO PER FRTP-2 05.92.007	
E1	23	-	COPPER RESISTANCE L 1500 THERMISTOR TOLERANCE 1% PS:0568-000	2	0.003	0.006	TYPE CA-100 PS:0568-000	
G1	22	733322-011	PLUG 3/8" PIPE	2	0.063	0.126	STEEL C20 AA:10108	
E4	21	-	BABBIT	-	-	14.0	BABBIT 86.15-561	
A2	20	31405005	ORIFICE PLATE #22	1	0.251	0.251	STEEL C 20 AA:10108	
B2	19	32425014	STOP WASHER	1	0.625	0.625	STEEL 25X10X0.5 PS:0616-010	
A3	18	518935-154	CYLINDRICAL PIN 6X6X14	8	0.003	0.024	STEEL C40 AA:10208	
B2	17	218904-128	SCREW M8X16	26	0.007	0.182	STEEL 45 PS:0616-010	
A3	16	32425013	SCREW SPECIAL	4	0.046	0.184	STEEL C40 AA:10208	
B2	15	118994-128	SPLIT COTTER PIN	4	0.018	0.072	MILD STEEL	
B2	14	238940-017	NUT M30	4	0.22	0.88	STEEL 5 D PS:0616-010	
B2	13	32406002	SPECIAL BOLT M30X130	4	2.65	10.6	STEEL C40 AA:10208	
B4	12	32425011	BOLT M16X25	8	0.109	0.872	STEEL C40 AA:10208	
A2	11	218904-079	SCREW M5X12	1	0.002	0.002	STEEL 4.5 PS:0616-010	
B4	10	32425003	ADJUSTING PAD	3	5.5	16.5	STEEL S142-5 AA:10108	
A2	9	32425008	ADJUSTING PAD WITH HOLE	1	4.74	4.74	STEEL S142-5 AA:10108	
B2	8	32425007	SHIM THICK 5=10mm	4	0.164	0.656	STEEL 30Cr13 IS:1570-61	
B2	7	32425006	SHIM THICK 5=0.5 mm	2	0.082	0.164	STEEL 22Cr13 IS:1570-61	
B2	6	32425005	SHIM THICK 5=0.3 mm	2	0.049	0.098	STEEL 22Cr13 IS:1570-61	
B2	5	32425004	SHIM THICK 5=0.2 mm	2	0.033	0.066	STEEL 22Cr13 IS:1570-61	
B2	4	32425003	SHIM THICK 5=0.15 mm	2	0.024	0.048	STEEL 22Cr13 IS:1570-61	
B2	3	32425002	SHIM THICK 5=0.1 mm	2	0.014	0.028	STEEL 22Cr13 IS:1570-61	
B4	2	32431001	HOUSING FOR BEARING 360 (LOWER HALF)	1	340	340	CSN-625152856M II-0500-401	
B4	1	32431001	HOUSING FOR BEARING 360 (UPPER HALF)	1	290	290	CSN-625152856M II-0500-401	

INVENTORY No. SIGN AND DATE SUPERVISOR INVENTORIAL No. SIGN AND DATE

39
LETTER WEIGHT SCALE
- B 602 2 1.5
697-0
SHEET-1 TOTAL SHEET-4