



- TECHNICAL REQUIREMENTS -
- MORE THAN THREE SHIMS ARE NOT ALLOWED UNDER ANY ADJUSTING PAD FOR THE ALIGNMENT OF BEARING AT THE PLANT TEST BED. THE SAME ARE SENT FOR RECTION 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 BEARINGS TO BE CHECKED WITH COLOUR (CONTACT SURFACE NOT LESS THAN 80%) BEFORE FITTING THE PADS INTO THE SEATS FOR BEARING AND PLACING THE ROTOR, CHANGE THE SHIMS ONLY UNDER THE LOWER PAD TO ENSURE A CLEARANCE OF 0.05 mm.
  - ENSURE AN INTERFERENCE OF THE ORDER OF 0.25 TO 0.35 mm BETWEEN UPPER PAD AND PEDESTAL COVER DURING ASSEMBLY OF TURBINE.
  - FOR MACHINING  $\phi 87.0$  PLACE SHIMS OF 1mm THICKNESS UNDER EVERY ADJUSTING PAD. OTHER SHIMS OF THICKNESS 0.5, 0.3, 0.2, 0.15 & 0.10 ARE MEANT FOR CENTERING.
  - PAD AND SHIMS ARE NOT REMOVED FROM THE BEARING FOR PACKING AND DISPATCH.
  - AFTER TESTING OF TURBINE AT THE PLANT TEST BED SCRAPPING OF BABBIT IS ALLOWED ONLY IN ACCORDANCE WITH THE PERMISSION OF STD. ALIGNMENT IS TO BE CHECKED SECOND TIME AT THE TEST BED IN CASE SCRAPPING IS EXCESSIVE.
  - PAINTING AND CONSERVATION OF THE BEARING IS AS PER INSTRUCTIONS 0446.001.  
PAINTING SURFACE AREA - 2.2M<sup>2</sup>  
CONSERVATION SURFACE AREA - 0.8M<sup>2</sup>
  - AFTER BABBITING, DYE PENETRANT TEST TO BE CARRIED OUT AT THE ENDS TO ENSURE PROPER BONDING OF THE BABBIT METAL.
  - ITEM Nos. 22 & 23 OF SPECIAL PIPE JOINT DRG. No. 32434000 WILL BE DISPATCHED WITH THE JACKING OIL PIPE LINE DRG. No. 32434000.
    - OPENING & THREADS OF ITEM No. 001 OF 32434000 TO BE PROTECTED BY ADHESIVE TAPE BEFORE DISPATCH.

NOTE FOR SPARE  
FOR SPARE BEARING INNER DIAMETER  $\phi 400$  (AS PER JOURNAL DIA) AND  $\phi 870$  (AS PER LOG SHEET) SHOULD HAVE 2 MM ALLOWANCE IN EACH CASE.

ZONE	ITEM NO	DESIGNATION	DESCRIPTION	QTY	PER FC	TOTAL INVENTORY	MATERIAL	REMARKS
A3	25	AA7322622	PRTD CYL D4 L25 DUPLEX 2000	2	0.30	0.60	TYPE PRT 03 AA7322622	
A2	24	32434010	SPECIAL PIPE JOINT DRG	1	0.84	0.84	SEE T.R. 3	
A2	23	71.8322.011	PLUG 3/8" PIPE	7	0.126	0.882	STEEL C20 AA:10108	
A2	22	17.8370.015	SEALING RING $d=78$	1	0.009	0.009	COPPER FRFP-2 Q502.007	
A2	21	17.8370.012	SEALING RING $d=78$	1	0.009	0.009	COPPER FRFP-2 Q502.007	
A3	20	-	COPPER RESISTANCE THERMOMETER TYPE CRT-03	2	0.03	0.06	TYPE CRT-03 PS-0563-001	
B1	19	-	BABBIT	-	262		BABBIT 95 IS-23-61	
B4	18	32425014	STOP WASHER	1	0.625	0.625	STEEL C40 PS-0616-010	
A4	17	32425013	SCREEN SPECIAL	4	0.446	1.784	AA:10208	
A3	16	32427002	ORIFICE PLATE $\phi 32$	1	0.234	0.234	STEEL C20 AA:10108	
B4	15	11.8994.189	SPLIT COTTER PIN 6.3X63 IS:549-61	4	0.019	0.076	MILD STEEL	
B4	14	23.8940.017	MUT M30 IS:1364-60	4	0.22	0.88	STEEL 5D PS:0616-010	
B4	13	32424002	SPECIAL BOLT M30X390	4	2.42	9.68	STEEL C40 AA:10208	
B3	12	32425011	BOLT M16X35	8	0.109	0.872	STEEL C40 AA:10208	
A3	11	21.8904.079	SCREW M5X12 IS:1366-62	1	0.002	0.002	STEEL 45 PS:0616-010	
B3	10	32425009	ADJUSTING PAD	3	5.5	16.5	STEEL SE-42-5 AA:10108	
A3	9	32425003	ADJUSTING PAD WITH HOLE	1	474	474	AA:10108	
A3	8	32425007	SHIM THICK S=1.0mm	4	0.65	2.6	STEEL 50 CR13 IS:1570-61	
A3	7	32425006	SHIM THICK S=0.5mm	2	0.082	0.164	STEEL 22 CR13 IS:1570-61	
A3	6	32425005	SHIM THICK S=0.3mm	2	0.049	0.098	STEEL 22 CR13 IS:1570-61	
A3	5	32425004	SHIM THICK S=0.2mm	2	0.033	0.066	STEEL 22 CR13 IS:1570-61	
A3	4	32425003	SHIM THICK S=0.15mm	2	0.024	0.048	STEEL 22 CR13 IS:1570-61	
A3	3	32425002	SHIM THICK S=0.1mm	2	0.016	0.032	STEEL 22 CR13 IS:1570-61	
B3	2	32434001	HOUSING FOR BEARING $\phi 400$ (LOWER HALF)	1	470	470	CSM-C2515:2856-63 II-0500-401	
B3	1	32434001	HOUSING FOR BEARING $\phi 400$ (UPPER HALF)	1	440	440	CSM-C2515:2856-63 II-0500-401	

ZONE	ITEM NO	DESIGNATION	DESCRIPTION	QTY	PER FC	TOTAL INVENTORY	MATERIAL	REMARKS
ENTR 3	1	STE-83-227	STEEL 22 CR13	7	0.007	0.049		
ENTR 3	2	STE-81-393	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	3	STE-81-393	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	4	STE-80-75	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	5	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	6	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	7	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	8	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	9	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	10	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	11	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	12	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	13	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	14	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	15	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	16	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	17	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	18	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	19	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	20	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	21	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	22	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	23	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	24	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	25	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	26	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	27	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	28	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	29	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	30	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	31	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	32	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	33	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	34	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	35	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	36	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	37	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	38	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	39	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	40	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	41	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	42	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	43	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	44	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	45	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	46	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	47	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	48	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	49	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	50	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	51	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	52	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	53	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	54	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	55	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	56	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	57	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	58	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	59	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	60	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	61	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	62	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	63	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	64	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	65	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	66	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	67	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	68	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	69	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	70	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	71	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	72	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	73	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	74	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	75	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	76	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	77	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	78	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	79	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	80	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	81	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	82	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	83	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	84	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	85	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	86	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	87	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	88	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	89	STE-78-139	STEEL 22 CR13	1	0.001	0.001		
ENTR 3	90	STE-78-139	STE					