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COPYRIGHT AND CONFIDENTIAL The information on this document is the property of BHARAT HEAVY ELECTRICALS LIMITED, It must not be used directly or indirectly in any way detrimental to the interest of the company. <u>FLOATING SEALS</u> 1.0 <u>SCOPE</u> This standard specifies the requirements of Floating seals used at bearing housing-NDE of Boiler fund pumps and Booster Pumps. 2.0 <u>MATERIALS</u> 2.1 The materials of Floating Seal shall be as follows: a) Body- Bronze to BS: 1400-LB2 b) Pin – Carbon Steel to BS970 – 080- M40 c) Garter Spring – spring steel. 3.0 <u>TECHNICAL REQUIREMENT:</u> 3.1 DIMENSIONS & FINISH 3.1.1 Dimensions of the Floating seals shall be as mentioned in the table. 3.1.2 Permitted ovality on Z is 0,01mm and squareness of faces ‘X’ and ‘Y’ should be 0.01 with datum Z. 3.1.3 Unspecified faces finish is 3.2 microns. 3.2 MANUFACTURING OF SPRING: Last coil on each and of spring shall be set at 45 to from a hook, ends to be hooked together on assembly to from complete garter spring. 4.0 <u>CERTIFICATES / REPORTS:</u> Five copies of the certificates covering the following details shall be supplied. a) Dimensional report b) Guarantee certificate for trouble free service for a period of 24 months from the date of supply.					
Ref. Doc	Revisions : Refer to record of revisions :		Prepared : TSR	Approved : JGC	Date : 17-7-82



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5.0 MARKING

5.1 The following details shall be marked on each Floating seal as shown in the figure:

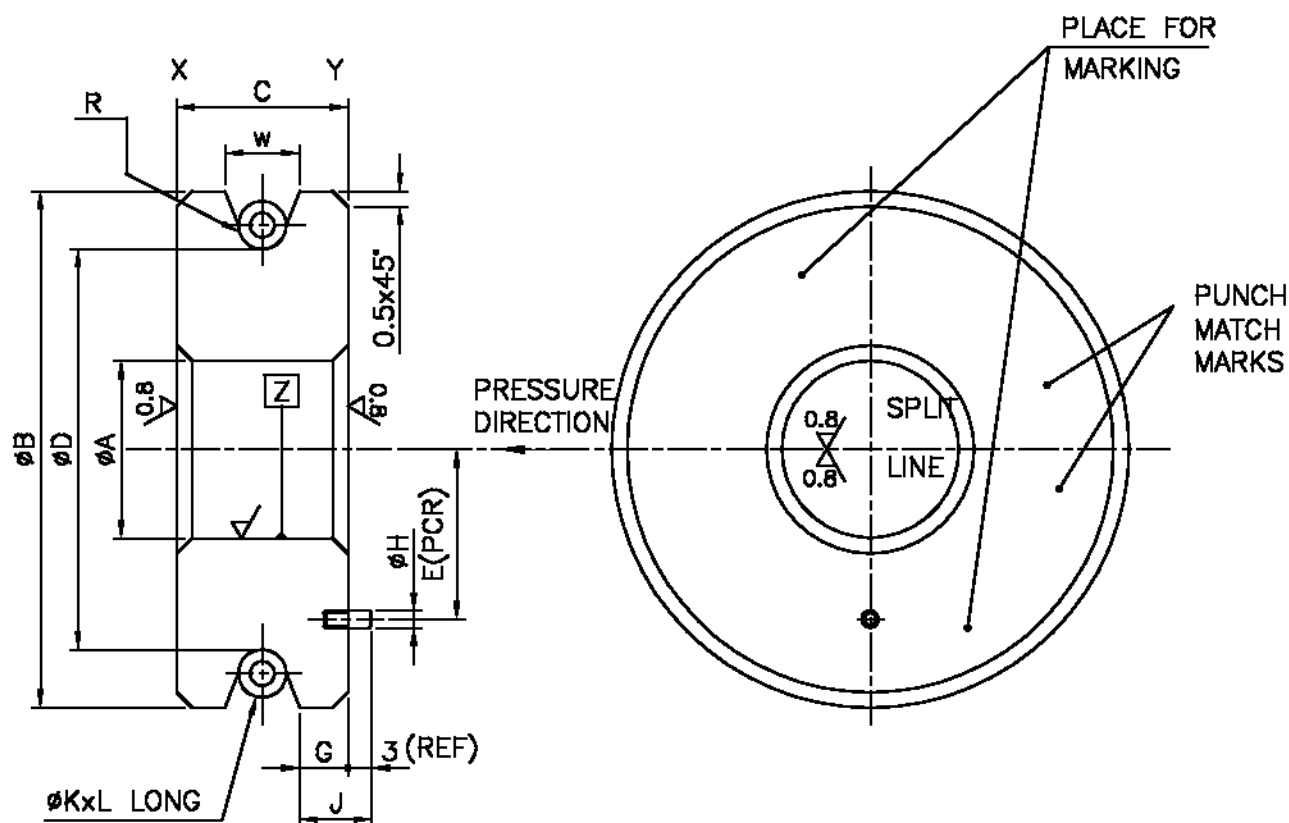
a) Standard No. FP50078, VAR.NO.

5.2 The order no and manufacturer's name shall be marked on box.

6.0 PACKING:

Each Floating seal assembly shall be kept separately in polythene cover and such covers shall and be kept properly in a card board box to avoid mechanical damagesduring transport.

FLOATING SEAL SPLIT





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TABLE-1 (ALL DIMENSIONS ARE IN mm)

VAR NO.	FLOATING SEAL TYPE (FOR INFORMATION)	SHAFT	A	B	C	D	E	R	G	HOLE TOL.	H		K	L	W	WT	MATERAIL CODE
											Pin dia	LENGTH					
01	GB-265-055 GLACIER	ø55.000/ ø54.981	ø55.11 ø55.08	74	5.970/ 5.940	ø67	31.5	2	0.735	2.07/ 1.97	ø2	6	3.2	179	4.5	0.08	FA1B56 FP9750078012
02	GB-265-090 GLACIER	ø91.000/ ø90.978	ø91.11 ø91.09	111	9.960 9.924	ø104	49	2	5	3.09 2.97	ø3	8	3.2	275	7	0.26	FK6D30 FP9750078020
03	GB-265-120 GLACIER	ø111.99/ ø111.97	ø112.07 ø112.09	148.00 9.924	9.960 9.924	ø137	65	2.8	3	3.09 2.97	ø3	6	4.8	332	7	0.42	FK4E36 FP9750078039
04	B-1087-080 GLYCO	ø62.925/ ø62.905													7		FA1E64 FP9750078047
05	B-1087-080 GLYCO/MECHELL MICHELL DRG. A3-899-07996	ø79.91/ ø79.89	ø79.96 ø80.01	ø101	9.960 9.924	ø94	44	2.5	5	ø3	ø3	8	ø3.2	249	7	0.20	FA1B75/FRH27 FP9750078055
06	GB 267-100 SHAFT DIA. 94.85/94.83	ø94.85/ ø94.83	ø94.954 ø94.932	ø121	9.960 9.924	ø114	54	2	5	3.09/ 2.97	ø3	8	ø3.2	300	7	0.30	FK2C45 FP9750078063
07	GB 267-100 SHAFT DIA. 99.98/100.00	ø99.98/ ø100.00	ø100.106 ø100.084	ø121	9.960 9.924	ø114	54	2	5	3.09/ 2.97	ø3	8	ø3.2	300	7	0.30	FK2C45 FP9750078071
08		ø89.978/ ø90.000	ø90.11 ø90.01	ø111	9.960 9.924	ø104	49	2	5	3.09/ 2.97	ø3	8	ø3.2	275	7	0.26	SINGERAULLI FP9750078080
DETAILS OF FLOATING SEALS TO MFG. INDIGENOUSLY																	
V.NO.					TECH. REQMTS.		MATL CODE		V.NO.	DESCRIPTION	TECH.REQMTS.		MATL.CODE				
50	SPRING WIRE DIA. OF SPRING 3.2 COIL ø0.4 MATERIAL. SPRING STEEL LENGTH IN METERS						FP9750078500		52	FLOATING SEAL (FK6D30)	AS PER VAR.02 OF FP50078		FP9750078527				
51	FLOATING SEAL (FA1B56)				AS PER VAR.NO. 01 OF FP 50078		FP9750078519										

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		Rev. No.	Date	Revision Details	Revised By	Approved By
		01	23-12-83	DIA. A added	TSR	JGC
		02	22-4-86	Var. no. 05 added.	TSR	JGC
		03	9-12-86	Var. nos 06 & 07 added.	TSR	JGC
		04	4-1-91	Var. nos 50, 51, 52 added	TSR	JGC
		05	14-2-91	In var. no. 03 revised	TSR	JGC
		06	2-5-91	Var.no. 03 revised.	TSR	JGC
		07	23-6-95	Generally revised in line with EMI-011	TSR	JGC
		08	18.08.2012	GROOVE WIDTH 'W' FOR VAR 01 CORRECTED TO 4.5.	ASJK	PS
		09	16.10.2012	DIMENSION 'G' FOR VAR 01 CORRECTED TO 0.735	ASJK	PS
		10	29.03.2014	FLOATING SEAL TYPE & MATERIAL CODE FOR VAR.03 CORRECTED.	JNM	MSR