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SPACERS ITEM NO. 032, 033, 035 & 036 BETWEEN BEARING PEDESTAL AND BEARING SHELL ARE FITTED WITH A CLEARANCE OF 0 TO 0.02mm. THE EXACT COMBINED THICKNESS OF THE SPACERS IS MADE BY PUTTING SHIMS (ITEM NO. 049 TO 052) BETWEEN THE SPACERS DURING ASSEMBLY.

CLEARANCE MADE BY FITTING KEY (ITEM NO. 015) DURING ASSEMBLY AT SITE

MOLYKOTE SHOULD BE APPLIED ON THE SEATING FACES OF THE CAPNUTS. STUDS TO BE TIGHTENED WITH TIGHTENING TORQUE 367Kg-M (3600N-m) DURING FINAL ASSLY. AT SITE.

WITH THERMO-COUPLE HOLE

TOTAL CLEARANCE $0.3^{\pm0.1}$ DURING ASSEMBLY(SEE T.R.-2)

SHAFT ø630 $^{-0.078}_{-0.198}$

SHAFT ø350 $_{-0.032}$

SHAFT ø630 $^{-0.078}_{-0.198}$

SEAL STRIP ø630.2 $^{+0.2}_{-0.2}$

HOSE SHOULD NOT BE TWISTED OR BEND AT SHORT RADIUS DURING ASSEMBLY. HOSE TO BE CLAMPED IN BEARING PEDESTAL USING PIPE CLAMPS AT ABOUT 3 POINTS. REFER FIG-3 (ZONE 61).

EXACT THICKNESS OF SHIM IS DETERMINED DURING ASSEMBLY AFTER ADJUSTING THE BEARING SHELL TO THE ℄ OF TURBINE

SEALING STRIP MUST BE MACHINED AT SITE ROUND THE SHAFT SO THAT SEALING STRIP TOUCHES THE BOTTOM OF THE SHAFT WHEN STATIONARY.

SECTION AA

SECTION BB

SECTION CC

SECURED BY CAULKING ALL AROUND

62,63,64

FIGURE-3

VIEW ON JOINT PLANE

PLAN VIEW

SECTION JJ

SECTION KK

SECTION DD

SECTION EE

SECTION FF

SECTION GG

SECTION HH

DETAIL I

SECTION LL

TOTAL CLEARANCE OF 0.3±0.1 BETWEEN THE THRUST PADS AND SHAFT COLLAR SHALL BE ACHIEVED WITH THE HELP OF SHIMS ITEM NO.9 AND 10.

DIRECTION OF ROTATION

FIGURE-1 (REF.TR-4)

FIGURE-2 (REF.TR-4)

VIEW M

VIEW O

VIEW P

VIEW R

VIEW S

POSITIONS OF PADS, FITTED KEYS AND SPRING ELEMENTS MARKED (STAMPED IN BEARING BODY AND PADS) AS PER SKETCH GIVEN ABOVE.

TECHNICAL REQUIREMENTS :-

1. SPHERE ø1050 SHOULD BE MANUFACTURED WITH 5mm THICK SHIM PLACED BETWEEN THE BEARING SHELL AND SPHERICAL PIECE (ITEM NO. 015) AND NO ALTERATION IS PERMITTED AT THIS POSITION DURING SHOP ASSEMBLY. DURING SHOP ASSEMBLY THE CENTERING OF BEARING SHOULD BE DONE BY SELECTING THE PROPER THICKNESS FOR ITEM NO. 038. MAXIMUM ADJUSTMENT OF ±0.30 IS ALLOWED DURING CENTERING OF BEARING AT SITE DURING OVERHAUL WITH THE HELP OF SHIMS (ITEM NOS. 045 TO 048).
2. TOTAL CLEARANCE OF 0.3±0.1 BETWEEN THE THRUST BEARING PADS AND SHAFT COLLARS SHALL BE ACHIEVED WITH THE HELP OF SHIMS (ITEM NO. 009 & 010).
3. ALL THE UNUSED SHIMS MUST BE SUPPLIED LOOSE TO SITE.
4. FIG-1 SHOWS THE DETAIL FOR MACHINING OF OIL POCKET AND FIG-2 GIVES THE MACHINING DETAILS OF BEARING DIAMETER FOR REFERENCE AT SITE.

GMS-No./ C.B.O.M	01170327000	STATUS OF DRG	
GRADE OF UNTOL.DIM	STT	N.SINGH	Sd/- 18.6.94
M/CG.-E/M/F AA0230208			
WELDING-A/B/E/F/H AA0621104			
GAS CUTTING-T3/AA0621101			

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: STEAM TURBINE

BHARAT HEAVY ELECTRICALS LTD. RANIPUR, HARDWAR

	NAME	SIGN.	DATE	NO. OF VAR
DRN	SPS SENGAR	Sd/-	6.5.94	
CHD	P.AGARWAL	Sd/-	12/5/94	---
APPD	Dr.V.K.SINGH	Sd/-	6-7-94	

REV	DATE	ALTERED / CHECKED
02	18.8.03	ALTERED SPSS Sd/- CHECKED SB Sd/-

DEPT STE | CODE 4011 | SCALE N.T.S. | WEIGHT (KG) 2265 | REF. TO ASSY. DRG. ------- | ITEM No. --- | NO. OF ITEMS ---

DRAWING NO. 0-11703-27000 | CARD CODE | SHEET No. 01 | No. OF SHEETS 01

TITLE : RADIAL THRUST BEARING ø380x290

DRG. SUPERSEDES OLD DRG. UNDER SAME NUMBER. C/A NO. STE-03-F1127

DRG. DELETED/DRG.RETURNED WITHOUT ANY CHANGE AND SUPERSEDED BY SDRG NO.OF DRG.SHEETS REDUCED TO 1 FROM 2

7404-16205 REFERENCING No.

INVENTORY No.

A0 SIZE