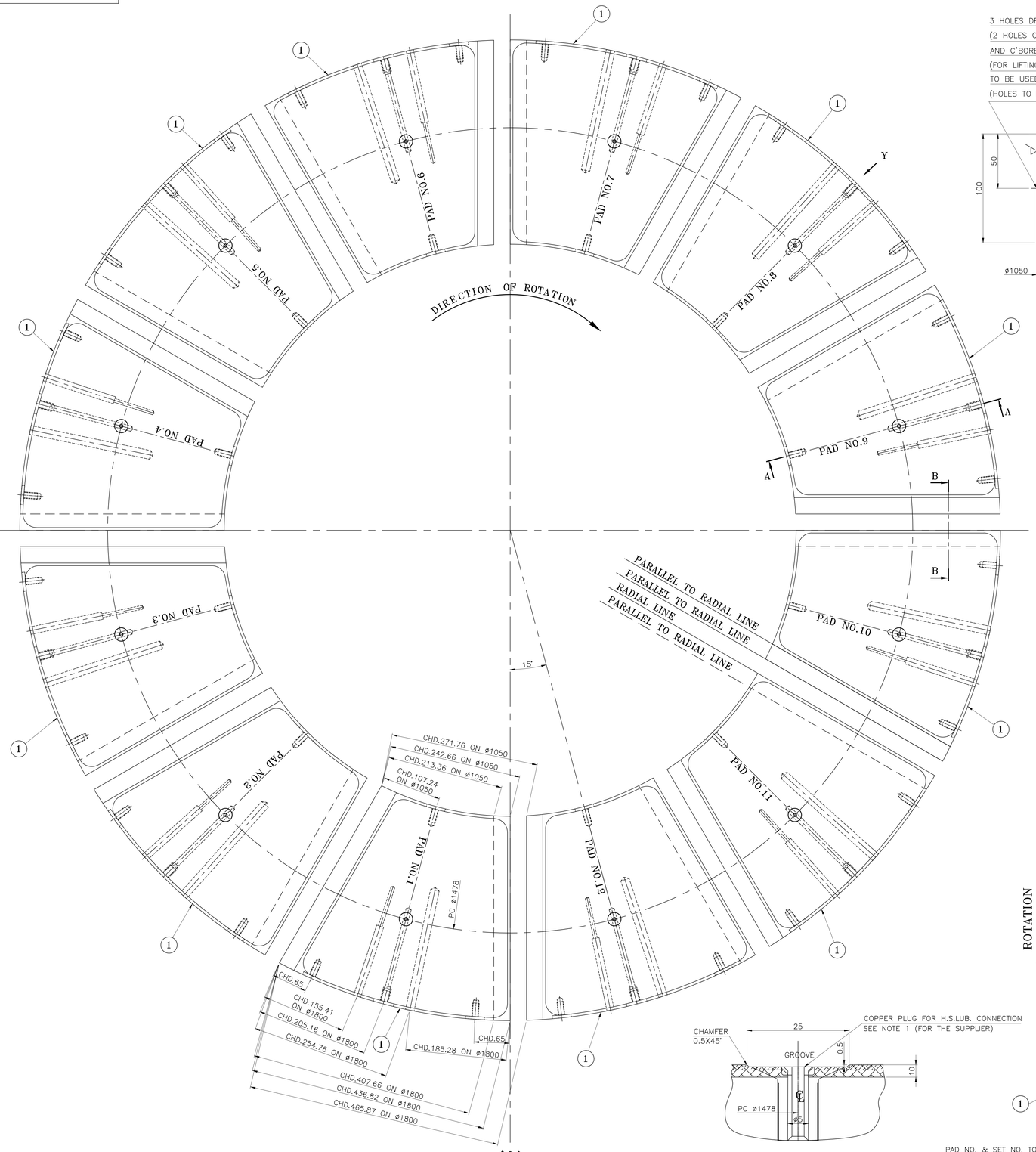
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

DRG. NO. 0 255 01 86601



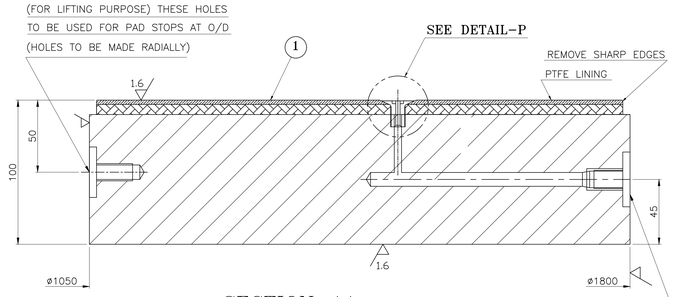
※ DOWN STREAM

▽ ALL OVER

SET OF THRUST BEARING PADS

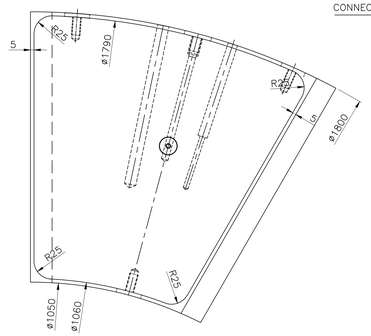
ENLARGED DETAIL–P

DIRECTION OF ROTATION

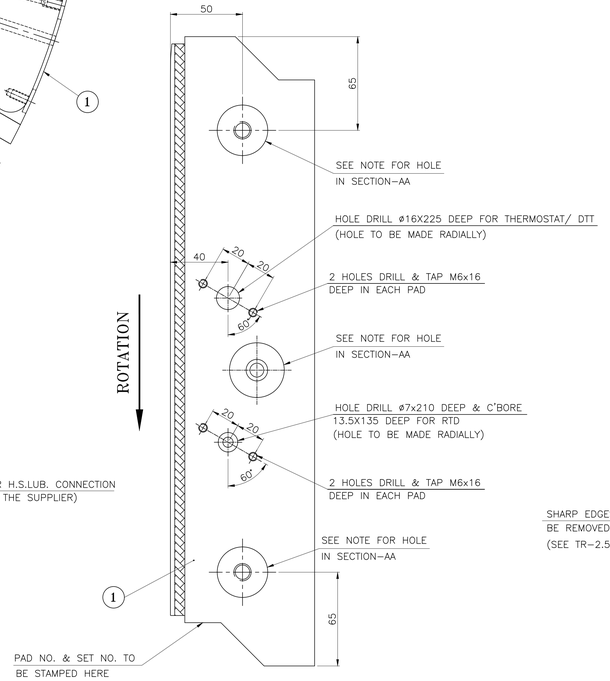


SECTION–AA

1–HOLE IN EACH PAD DRILL ø9.6x180 DEEP, C'BORE ø15x25 DEEP AND TAP RP 3/8"x20 DEEP AND S'FACE ø38 FOR H.S. CONNECTION (HOLE TO BE MADE RADIALLY)



TOP VIEW OF PAD SHOWING PTFE PROFILE



VIEW AS ARROW–Y

FOR RTD/DTT/ THERMOSTAT

TECHNICAL REQUIREMENTS:–

1. BASE METAL :–

1.1 THE BASE MATERIAL OF PAD SHALL BE M.S. PLATE TO DIN. EN 10025, Gr:S 275 J2G3 OR M.S.PLATE TO AA10119 (IS:2062–GR:B–FE 410 WB) CAN BE USED. IT IS TO BE HEAT TREATED FOR HYDROGEN DIFFUSION.

1.2 FULL AREA OF PLATES TO BE ULTRASONICALLY TESTED FROM BOTH SURFACES AS PER CATEGORY 2 OF B.H.E.L. STANDARD AA0850118, 'ULTRASONIC TESTING, CLARIFICATION AND ACCEPTANCE STANDARDS FOR STEEL FORGINGS, BILLETS

1.3 THE SURFACE FINISH OF ALL MACHINED SURFACES SHOULD BE 3.2 MICRONS OR BETTER EXCEPT OTHERWISE STATED.

2. FINISHED PADS :–

2.1 FOR THRUST PADS :–

a) STEEL AND PTFE SURFACES TO BE FLAT WITHIN 0.01mm MEASURED BY USING BS 817 GR '0' SURFACE PLATE AND THICKNESS VARIATION NOT TO EXCEED 0.02MM IN EACH PAD.

b) FOR INTERCHANGEABILITY, THICKNESS VARIATION FROM PAD TO PAD OF EACH SET SHOULD BE WITHIN 0.03mm.

2.2 TEST THE PAD MATERIAL & PTFE MATERIAL & ITS BONDING AS PER APPROVED QA PLAN.

2.3 STAMP SET NOS & PAD NOS. ON EACH PAD IN LOCATION INDICATED.

2.4 PACKING TO BE DONE IN ACCORDANCE WITH DRG. NO.32550101400 BY SUPPLIER.

2.5 SUITABLE GROOVES/PROVISION FOR PAD WEAR INDICATION FOR PTFE LINING SHALL BE PROVIDED BY SUPPLIER.

3. DIMENSIONAL REQUIREMENTS:–

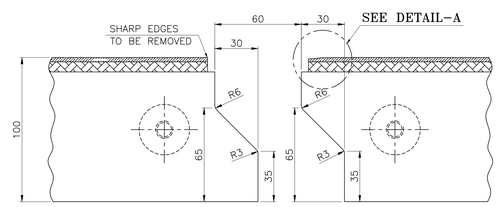
3.1 THE CHORD DIMENSIONS OF THRUST PADS SHALL BE WITHIN $^{+0}_{-0.5}$ MM.

3.2 THE PITCHING OF VARIOUS HOLES SHALL BE WITHIN ±1 MM. EXCEPT OTHERWISE STATED.

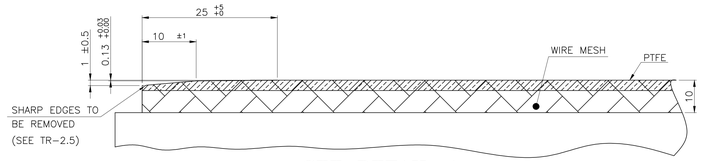
3.3 ALL OTHER DIMENSIONS RELATED TO GEOMETRY AND SHAPE OF PAD SHALL BE WITHIN ±0.25 MM.

NOTE FOR SUPPLIER:–

1. COPPER PLUG DESIGN AND DETAIL TO BE FURNISHED BY SUPPLIER AT THE TIME OF APPROVAL.
2. PTFE SURFACES OF THE PADS MUST BE FREE FROM DIRT, DENTS, SCRATCH & HAIRLINE MARKS ETC.
3. SHARP EDGES OF PTFE TO BE REMOVED AS SHOWN IN THE DRAWING. CHAMFERING SHOULD NOT BE DONE FOR REMOVING SHARP EDGES.
4. THE METAL BASE SURFACES SHOULD BE PROPERLY CLEANED & SURFACE FINISH SHOULD BE AS PER DRAWING AND METAL SURFACES SHOULD BE FREE FROM DENTS MARKS, RUSTING AND BLACK COLOUR PATCH MARK ETC.
5. THE COPPER PLUG FITMENT SHOULD BE ADEQUATE IN THE PADS. THE BONDING EDGES OF COPPER PLUG SHOULD BE NOT HAVE ANY CAVITY, DEFECT ETC.
6. TOP EDGE OF COPPER PLUG SHOULD HAVE PROPER CHAMFER AS SHOWN IN THE DRG.
7. THERE SHOULD BE NO PROJECTION OF METAL WIRE AT BONDING EDGE I.E. BETWEEN PTFE AND METAL.



SECTION–BB



SEE DETAIL–A

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