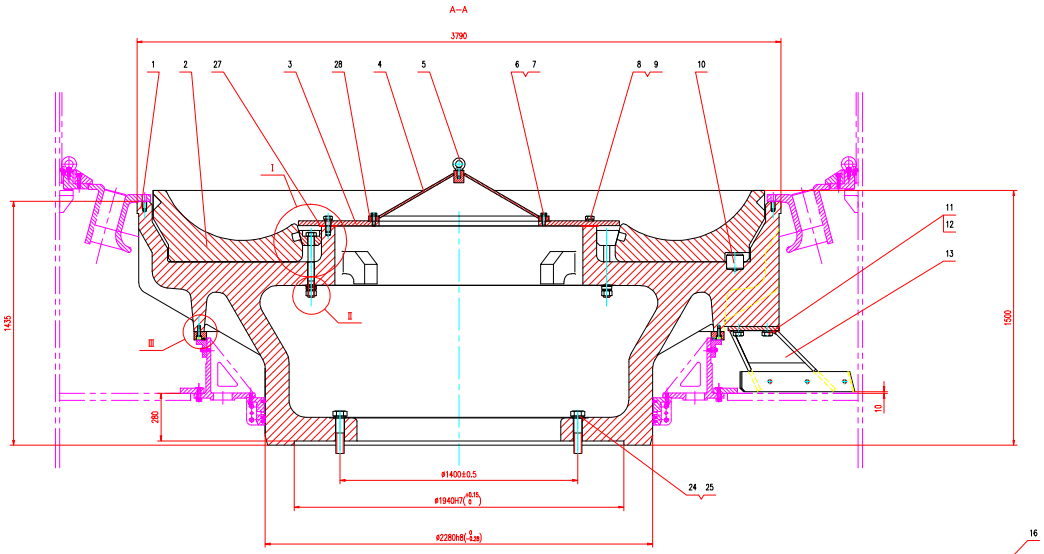
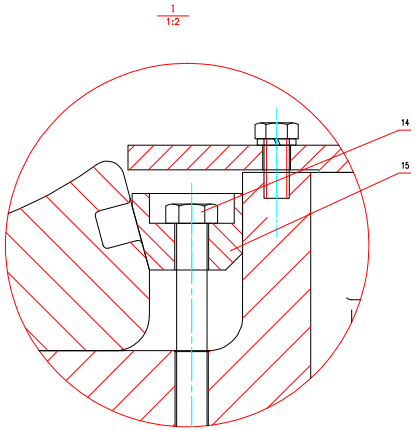
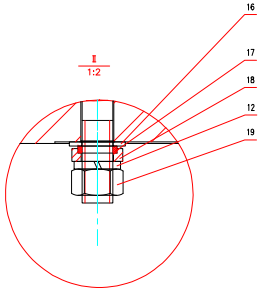
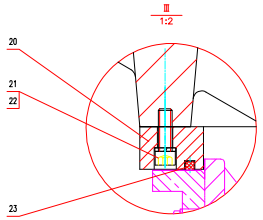
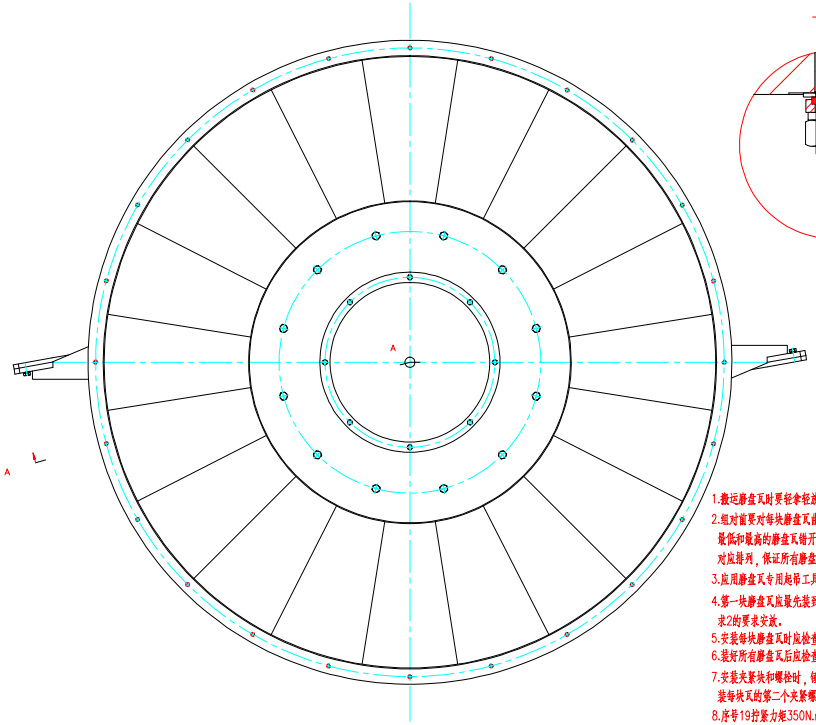










技术要求

1.搬运静盘瓦时要轻拿轻放，不允许碰碰和撞击，不允许采用任何方式对静盘瓦加热。
2.相对面要对每块静盘瓦曲面最低厚度点为基准进行厚度检查，并作记录，其中应把最低和最高的静盘瓦错开180°排列，其余静盘瓦按厚度差由低到高或由高到低顺序对应排列，保证所有静盘瓦安放好相邻二块在曲面最低厚度点的高度差不超过2mm。
3.应用静盘瓦专用起吊工具起吊静盘瓦。
4.第一块静盘瓦应最先装到静盘上装有圆柱定位销的位置上，其余静盘瓦按技术要求2的要求安放。
5.安装每块静盘瓦时应检查静盘瓦底面和静盘接触面的间隙，不得超过0.1mm。
6.装好所有静盘瓦后应检查相邻各瓦间隙，如出现间隙可用序号26调整静盘瓦之间的间隙。
7.安装夹紧块和螺栓时，锤击夹紧块头部，并用70%额定力矩拧紧螺母，然后按此方法安装每块瓦的第二个夹紧螺栓，然后按额定力矩拧紧螺母。
8.序号19拧紧力矩350N.m。
序号24拧紧力矩5150N.m。
9.各零件结合面及螺栓安装前应涂二硫化钼。

Technical Requirement

1.To handle with care for transporting the grinding table liner, it is not allowed to pound and hit it, also not allowed to apply any method for heating the grinding table liner.
2.Before assembly, to carry on thickness inspection for each grinding table liner according to the lowest thickness point of their curved surfaces as datum and make a record. During the inspection, the lowest and highest grinding table liner shall be 180°staggered and arranged, rest of grinding table liners shall be both-sides correspondingly arranged from high to low or from low to high, which guarantee that two adjacent pieces has no more than 2mm height difference at the lowest thickness point after assembly of all grinding table liners.
3.To use the special tools for grinding table liner to hoist it.
4.First piece of grinding table liners shall be installed on the grinding table at the positon where equipped with cylindrical dowel pin fristly, the rest of grinding table liners shall be set according to the Technical Rquirement 2.
5.For installing each grinding table liner, the clearance between the underside and contact surface of grinding table liners shall be inspected and it can not exceed 0.1 mm.
6.To inspect the clearance between adjacent grinding table covers respectively after assembly of all grinding table covers, if have clearance, using item 26 to adjust it.
7.While assembling the clamp blocks and bolts, to hammer the head of clamp blocks and tighten the nuts with 70% rated moment, then to assemble the second clamping bolt of each cover in the same way, afterward to tighten nuts with rated moment.
8.Tightening moment of item 19 is 350N.m.
Tightening moment of item 25 is 5150 N.m.
9.Faying surface oof each parts shall be painted with molybdenum disulfide, before bolt assmebly, it is also required to be painted with molybdenum disulfide.

Item	Code	Description	Qty	Material	Unit Weight (kg)	Total Weight (kg)	Remarks
28		静Pad1040x Φ940x5-XB350	1	Manganese Alloy Steel	1	1	
27		静Pad1640x Φ1440x3-XB350	1	Manganese Alloy Steel	1.5	1.5	
26		钢板Steel plate	C45	800X300	3	Q235A.F	7	21	
25	GB/T93-1987	垫圈45 Washer 45	20	65Mn			
24	GB/T5782-2000	螺栓M48X220 Bolt M48X220	20	8.8级 8.8Grade	3.83	76.6	
23		盖板Docking 10X10X10000	1	Manganese Steel Rolled Plate	5	5	
22	GB/T93-1987	垫圈16 Washer 16	18	65Mn			
21	GB/T70.1-2000	螺钉M16X50 Screw M16X50	18	8.8级 8.8Grade			
20	DH0202.2800.08	密封法兰 Sealing Flange	1	Q7405-15	250	250	镀锌Hot Dip Galvanizing
19	GB/T6170-2000	螺母M36 Nut M36	40	06级 8Grade	0.317	12.68	
18	DH0202.2800.07	垫圈Washer	40	Q235A.F	0.2	8	
17	DH0202.2800.06	密封垫 Sealing Pad	40	Manganese Steel Rolled Plate	0.01	0.4	
16	GB97.1-2002	垫圈36 Washer 36	40	200HBW 200HBGrade			
15	DH0202.2800.05	夹静块 Clamping Block	40	45	7.4	296	
14	GB/T5782-2000	螺栓M36X360 Bolt M36X360	40	8.8级 8.8Grade	3	120	
13	DH0202.2800.020	刮板 Scraper	2	Manganese Alloy Steel Rolled Plate	79.9	159.8	
12	GB/T93-1987	垫圈36 Washer 36	48	65Mn			
11	GB/T5783-2000	螺栓M36X70 Bolt M36X70	8	8.8级 8.8Grade	0.9	7.2	
10	DH0202.2800.04	定位销 Dowel Pin	1	45	5.55	5.55	
9	GB/T5783-2000	螺栓M30X70 Bolt M30X70	12	8.8级 8.8Grade	0.57	6.84	
8	GB/T93-1987	垫圈30 Washer 30	12	65Mn			
7	GB/T93-1987	垫圈20 Washer 20	8	65Mn			
6	GB/T5783-2000	螺栓M20X55 Bolt M20X55	8	8.8级 8.8Grade			
5	GB/T825-1988	螺钉M20 Screw M20	1	20			
4	DH0202.2800.010	罩盖Hood	1	Manganese Alloy Steel Rolled Plate	130	130	
3	DH0202.2800.03	盖板Covering Plate	1	Q235A	495	495	
2	DH0202.2800.02	静磨瓦Grinding Table Liner	20	Cr2021	562	11240	堆焊Hard Facing
1	DH0202.2800.01	静盘支座Grinding Table support	1	ZG270-500	2728	2728	

序号	代号	名称	数量	材料	单件	总计	备注
Item	Code	Description	Qty	Material	Unit Weight (kg)	Total Weight (kg)	Remarks

标记	处数	更改文件号	签名	年月日	通用技术条件 JB/T5000		
设计		标准化			静盘装配 Grinding Table Assembly	重量	比例
审核		工艺				1:5	
批准		共 张	第 张		装配图 Assembly Drawing	DH0202.2800.00 ZYW	

OWNER :	COASTAL ENERGEN PRIVATE LIMITED
OWNER'S ENGINEER :	TCE CONSULTING ENGINEERS LIMITED BANGALORE
CONTRACTOR :	HARBIN POWER ENGINEERING COMPANY LIMITED
CONTRACTOR'S ENGINEERS :	NORTHEAST ELECTRIC POWER DESIGN INSTITUTE CHINA POWER ENGINEERING CONSULTING GROUP
PROJECT NAME :	2X600MW THERMAL POWER PLANT TUTICORIN, TAMILNADU
DESIGN STAGE :	BASIC DESIGN
APPROVED	CHECKED
REVIEWED	PREPARED
DATE	SCALE
CAD FILE	CONTRACTOR'S DRG NO.
	OWNER'S DRG NO.
	Grinding Table Assembly
	REV. No. SHEET No. 1
	No. OF SHEETS 1