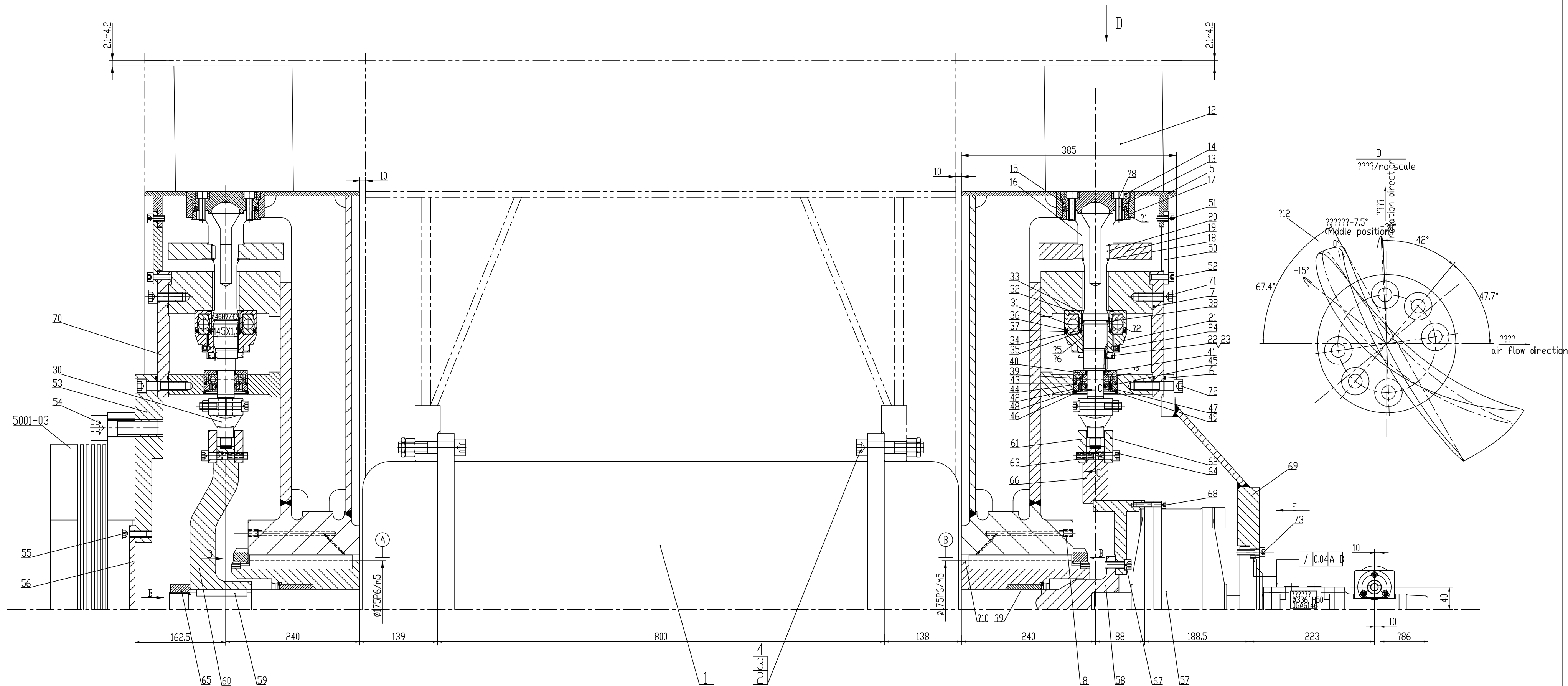




Technical requirements

2. ?????? ??/note?
Description rotor assembly
1. ??????????????????????
Coat "Anti seize" Molykote 1000 on the mating surfaces of impeller during assembling is about 94.36°C
2. ?????????(7014)
Full blade shaft bearing with lubricating grease.
3. ?????????????????????
Remove oil from slide block and its mating surface then coat with Molykote 1000
4. ?????????????????????
Do not handle the screw thread of self-locking nut and adjusting lever and blade shaft, but the thin oil shall be added.
5. ?????????(7014)????????
Add the lubricating grease to blade shaft's nut and screw thread before lock in, the nut should be tweaked to suitable pretightening force.
6. ?????????????????????
After adding lubricating grease to blade shaft bearing, filling aperture should be sealed using plug screw coated with 609 sealing grease.
7. ?????????????????????
The mating surface between adjusting lever and blade shaft should be oil removing for pressing force.
8. ?????????(molykote1000)????7014?
Remove oil and grease from blade screw, then coat molykote 1000
NOTE:7014 can not be added
9. ?????????(??)????????
Remove the grease from the mating surface between shaft and lever, bush and small shaft of hydraulic device or linkage rod.
10. ?????????????????
Before fitting the impeller, coat cuprum on main bearing and screw thread according to process stipulation.
11. ?????????????????
Tighten all the screw and nut according to the list we provided.
NOTE: the self-locking nut could be tightened no more than 1/4 turn.
12. ?????????????????75°?
For blade No.1, the blade angle and calibration tails should be adjusted on impeller 5° per grill.
2. ?????? ??
Specification of dismounting and assembling of impeller
1. ?????????35.34T
The stretching force is 35.34 ton during bearing of hub, the blade weight with colored word "blade"

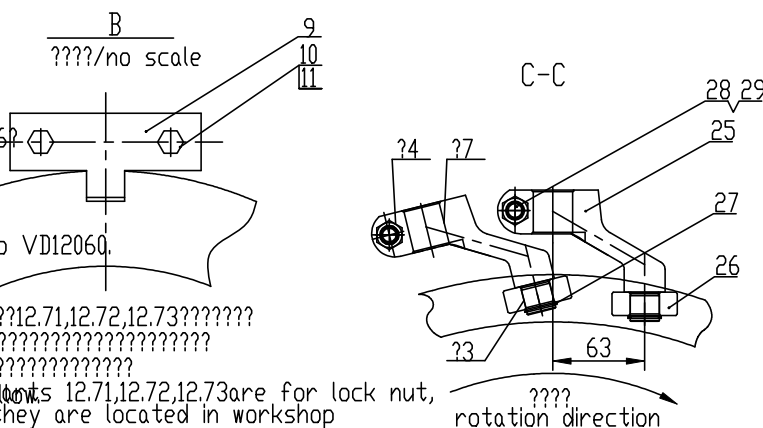


Table of force moment											
tight bolt according table											
????????(kg.m)/tighting torch(kg.m)											
???????/ISO stand screw					???????/ISO stand screw					thin type	
?? grade 6.9					?? grade 6.9						
?? type	17	2	8.8	10.9	12.9	?? type	17	2	8.8	10.9	12.9
M10	3.3	3.9	5.5	6.6		M8X1	1.84	2.16	3	3.6	
M12	5.8	6.9	9.6	11.6		M10X1.25	3.52	4.16	5.8	7	
M16						M12X1.5	6.1	7.2	10.8	12.8	
M20						M16X1.5	10	12	16.8	20	
M24						M20X1.5	15.2	18	25.2	30.4	
M27						M24X2	22	26	36.8	44	
M30						M27X2	30.8	36.8	51.2	61.6	
M36						M30X2	41.6	48	68.8	84	
M42						M36X2	52	62.4	88	104	
M48							77.6	92	128	156	
M56							108	128	180	216	