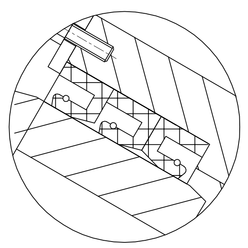

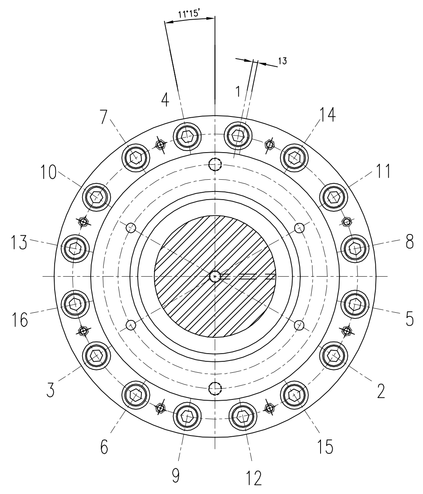

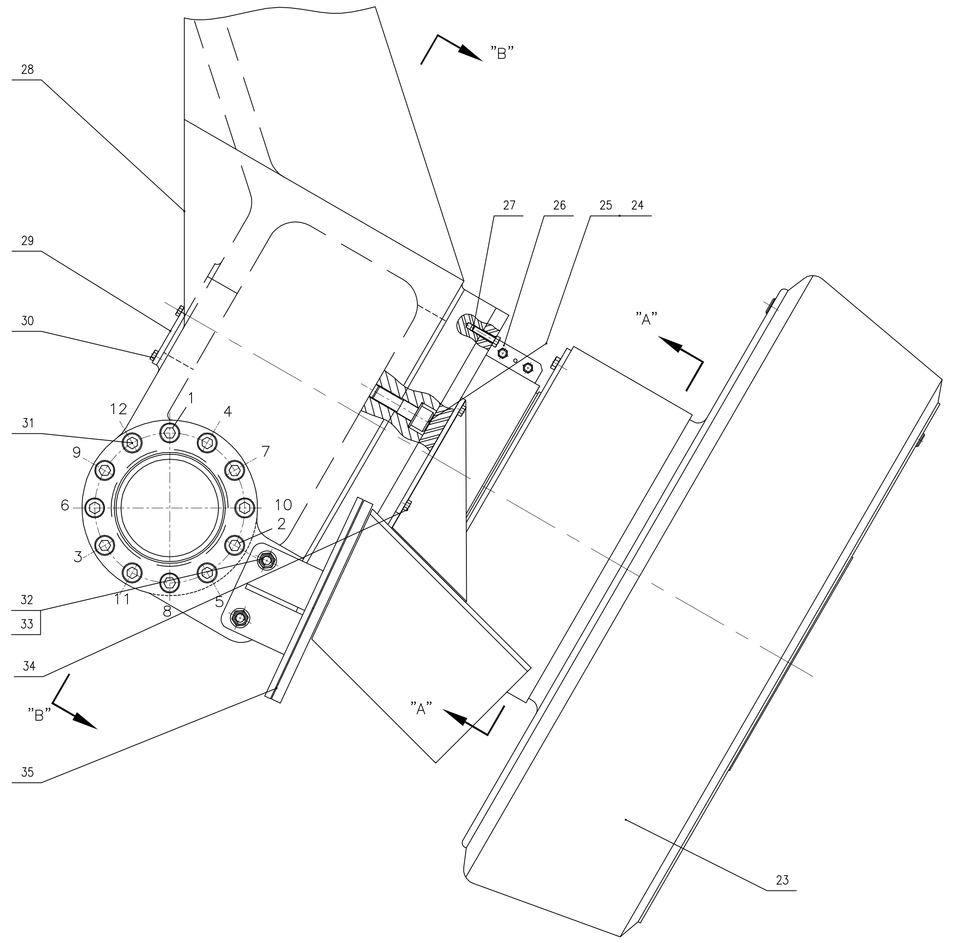

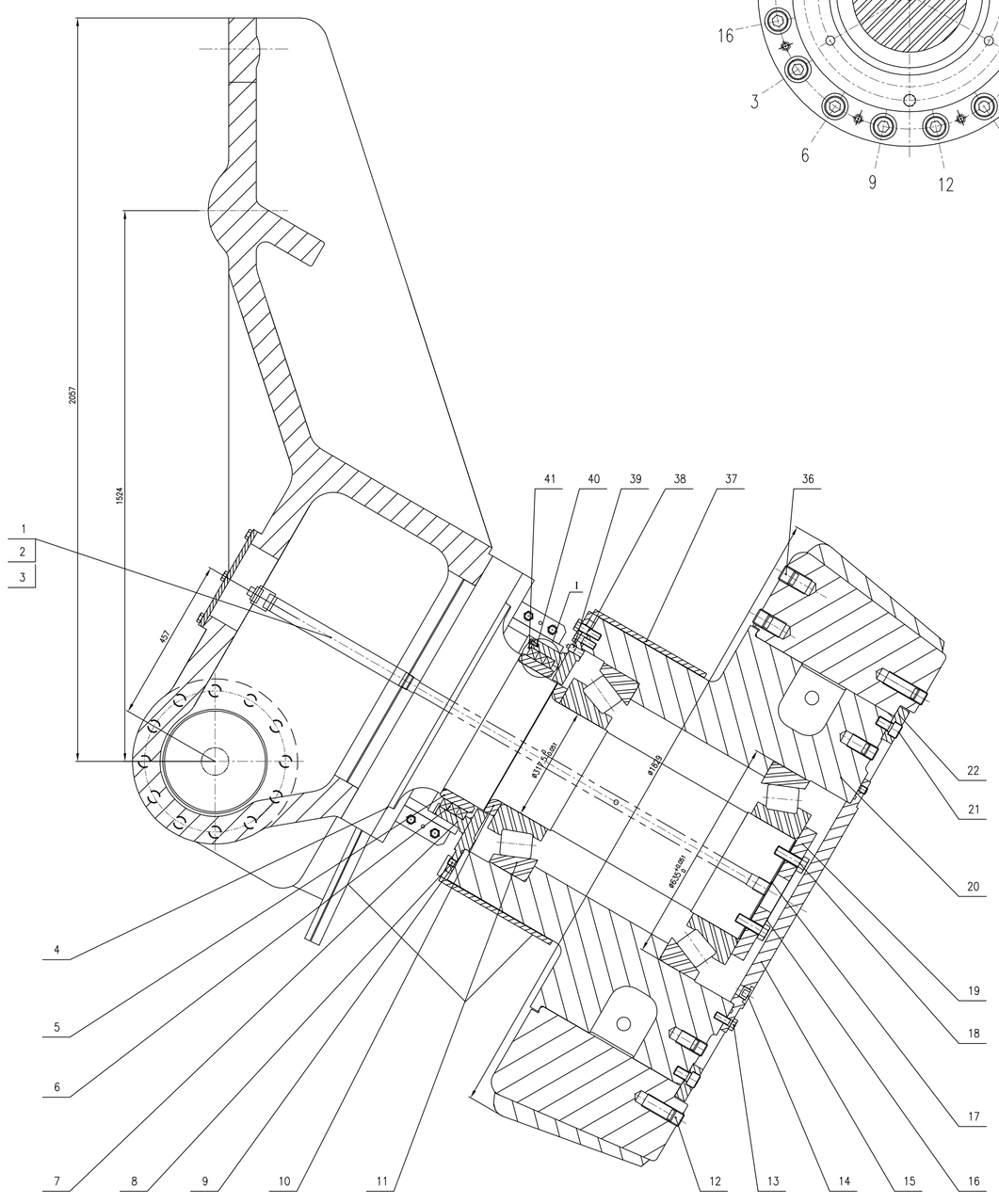

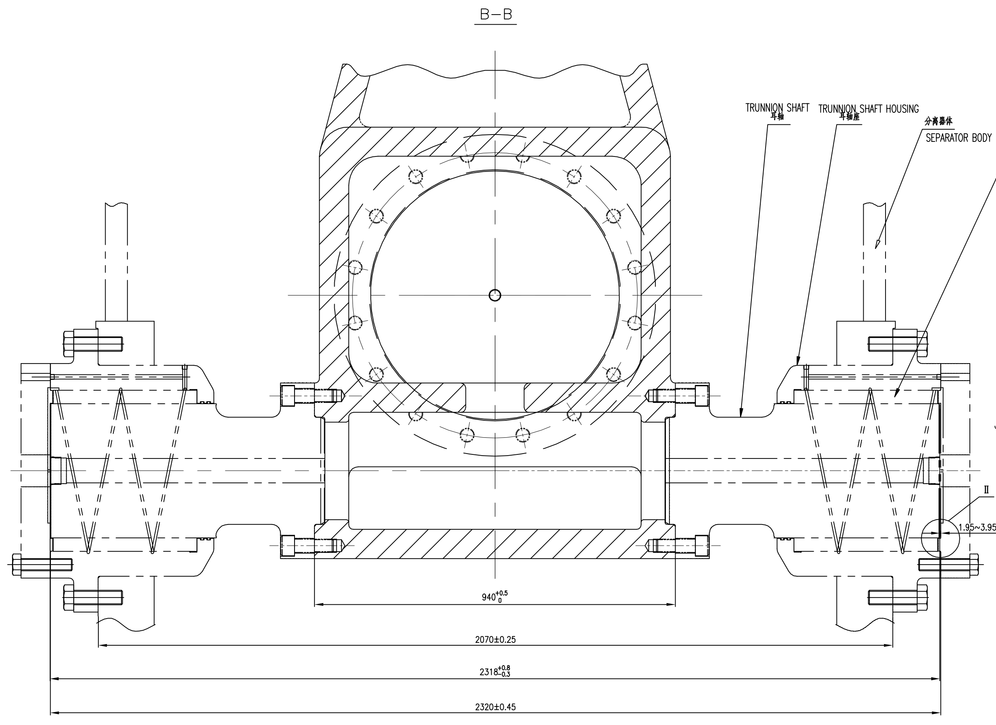

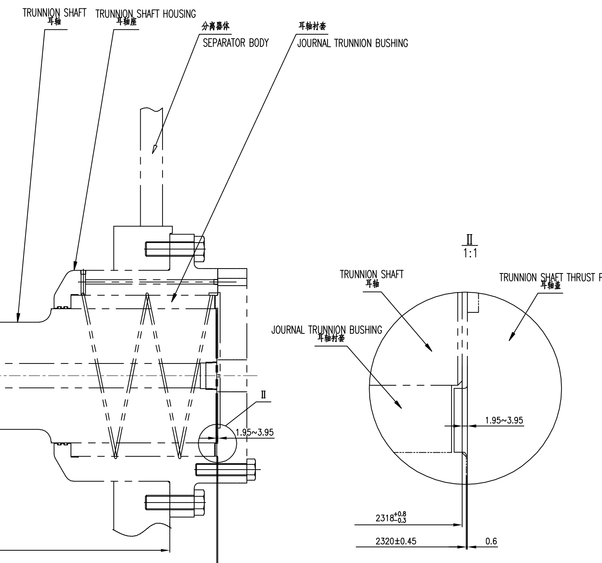

FOR CONSTRUCTION

技术要求

1.在装配时所有镀管螺纹上涂以螺纹粘结剂聚四氟乙烯薄膜。
2.除另有要求外，拧紧螺栓和螺钉，并在所有紧固件上涂以螺纹锁紧粘结剂，当>M24时用可赛新1277，当≤M24时用可赛新1271。
3.按A–A剖面上所编顺序号分三步拧紧螺钉把磨辊轴装置紧固在磨辊头上（该图仅供拧紧螺钉顺序之用）。
（1）拧至14.9Nm
（2）拧至1491Nm
（3）拧至2534Nm
4.按所编顺序号分三步拧紧螺钉（序号31）把耳轴紧固在磨辊头上
（1）拧至13.5Nm（10FT–LBS）
（2）拧至1355Nm（1000FT–LBS）
（3）拧至2304Nm（1700FT–LBS）
5.序号17垫片组厚度由装配定，保证轴承轴向间隙为0.025–0.076mm。

NOTES

1. APPLY PIPE THREAD SEALANT W/TEFLON TO ALL PIPE THREADS AT ASSEMBLY.
2. UNLESS OTHERWISE NOTED,TORQUE ALL HEX HEAD CAP SCREWS.APPLY THREAD–LOCKING SEALANT KESAIXIN 1271(d≤M24) OR KESAIXIN 1277(d>M24) PER DRAWING B–GP–2175.
3. TORQUE BY NUMBER SEQUENCE STARTING WITH OFFSET LOCATION PER SECTION "A–A". TORQUE IN THREE (3) STEPS TO SECURE JOURNAL SHAFT ASSEMBLY TO JOURNAL HEAD WITH (16) HEX. SOCKET HEAD CAP SCREWS:
   STEP #1: TORQUE TO 14.9 NM;
   STEP #2: TORQUE TO 1491 NM;
   STEP #3: TORQUE TO 2534 NM.
4. TORQUTE BY NUMBER SEQUENCE STARTING WITH BOLT ITEM 31 PER SIDE ELEVATION VIEW. TORQUE IN THREE (3) STEPS TO SECURE TRUNNION SHAFT TO JOURNAL HEAD WITH (12) HEX. SOCKET HEAD CAP SCREWS:
   STEP #1: TORQUE TO 10 FT–LBS.
   STEP #2: TORQUE TO 1000 FT–LBS.
   STEP #3: TORQUE TO 1700 FT–LBS.
5. THE QUANTITY OF SHIM SET. JOURNAL BEARING KEEPER ARE DETERMINED DURING ASSEMBLY.JOURNAL BEARING（ITEM 17）END CLEARANCE 0.025~0.076mm.

序号 ITEM NO.	代号 DRAWING NO.	名称 DESCRIPTION	数量 QTY/SET	材料 MATERIAL	单重 UNIT WEIGHT	总重 TOTAL WEIGHT	备注 REMARKS
41	K3868.10–16	油封挡圈 SEAL KEEPER	2	Q235–A	2.4	4.8	
40	GB/T 5783–2000	螺栓 M8x16 HEXAGON HEAD CAP SCREW	8	8.8	0.011	0.088	
39	JB/ZQ 4446.4	螺塞 R1/2 PLUG SCREW	1	35	0.03	0.03	
38	GB/T 5782	螺栓 M20x65 HEXAGON HEAD CAP SCREW	8	8.8	0.206	1.6	
37	K3868.10–15	磨辊座衬板 JOURNAL HOUSING LINER	2	WELDMENT	46.5	93	
36	GB/T 78	螺钉 M48x45 HEXAGONAL SOCKET SET SCREW	4	45H	0.108	0.6	
35	K3868.10.5.0	磨辊头衬板装置 JOURNAL HEAD LINER ASSEMBLY	1	ASSEMBLY	514.5	514.5	
34	GB/T 5783	螺栓 M16x80 HEXAGON HEAD CAP SCREW	4	8.8	0.141	0.56	
33	GB/T 97.1	垫圈 24 PLAIN WASHER	4	140HV	0.031	0.144	
32	GB/T 5783	螺栓 M24x50 HEXAGON HEAD CAP SCREW	4	8.8	0.269	1	
31	GB/T 70.1–2000	螺钉 M36x90 HEXAGONAL SOCKET HEAD CAP SCREW	24	12.9	1.15	27	
30	GB/T 5783	螺栓 M16x30 HEXAGON HEAD CAP SCREW	6	8.8	0.082	0.45	
29	K3868.10–14	磨辊头盖 JOURNAL HEAD COVER PLATE	1	Q235–A	6.2	6.2	
28	K3868.10–13	磨辊头 JOURNAL HEAD	1	ZG270–500	3300	3300	
27	GB/T 5782	螺栓 M16x70 HEXAGON HEAD CAP SCREW	8	8.8	0.132	1.056	
26	K3868.10.4.0	磨辊裙罩装置 JOURNAL SKIRT ASSEMBLY	1	ASSEMBLY	126.22	126.22	
25	JB/ZQ 4352	螺钉 M42x130 HEXAGONAL SOCKET HEAD CAP SCREW	16	8.8	2.1	33.6	
24	K3868.10–12	垫圈 42 WASHER	16	45	0.086	1.4	
23	K3868.10.3.0	辊套 OVERLAID GRINDING ROLL	1	ASSEMBLY	5080	5080	
22	K3868.10–11	磨辊挡圈 GRINDING ROLL KEEPER	4	16Mn	16.8	67.2	
21	GB/T 70.1	螺钉 M30x45 HEXAGONAL SOCKET HEAD CAP SCREW	16	8.8	0.5	8	
20	K3868.10–10	磨辊座 JOURNAL HOUSING	1	ZG270–500	3402	3402	
19	K3868.10–9	磨辊轴承挡圈 JOURNAL BEARING KEEPER	1	Q235–A	36	36	
18	GB/T 5783	螺栓 M30x80 HEXAGON HEAD CAP SCREW	8	8.8	0.618	4.9	
17	K3868.10–8	垫片组 SHIM SET	1	QSn6.5–0.1	1.5	1.5	
16	K3868.10–7	止动垫片 JOURNAL BEARING KEEPER SHIM	1	Q235–A	0.35	0.35	
15	K3868.10–6	下磨辊座盖 JOURNAL HOUSING COVER – LOWER	1	16Mn	122	122	
14	K3868.10.2.0	磁性螺塞 MAGNET PLUG SCREW	1	ASSEMBLY	0.159	0.159	
13	GB/T 5783	螺栓 M20x50 HEXAGON HEAD CAP SCREW	24	Q235A	0.173	3.1	
12	GB/T 78	螺钉 M42x50 HEXAGONAL SOCKET SET SCREW	12	45H	0.105	1.26	
11	GP–6639	轴承 TAPERED ROLLER BEARING	2	FINISH PRODUCT	231	462	
10	K3868.10–5	环 RING	1	45	10.8	10.8	
9	K3868.10–4	O型密封圈 O–RING	2	RUBBER	0.2	0.4	
8	GB/T 78	螺钉 M20x25 HEXAGONAL SOCKET SET SCREW	6	45H	0.041	0.738	
7	K3868.10–17	磨辊座盖 JOURNAL HOUSING COVER – UPPER	1	WELDMENT	113.4	113.4	
6	102110	油封 OIL SEAL	3	FINISH PRODUCT	2	6	
5	K3868.10–3	油封耐油环 SEAL WEAR RING	1	20CrMo	27.5	27.5	
4	K3868.10–2	磨辊轴 JOURNAL SHAFT	1	45	1263	1263	
3	GB 3289.31–82	外方管堵 32 SQUARE HEAD PIPE PLUG	1	KTB400–05	0.15	0.15	
2	GB 3289.22–82	外接头 32 FEMALE UNION	1	KTB400–05	0.28	0.28	
1	K3868.10–1	镀锌管 32x3.25x457 GALVANIZED PIPE	1	Q235–A	1.4	1.4	

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REV.	DESCRIPTION	DATE	DESIGNED BY	CHECKED BY	REVIEWED BY	APPROVED BY
0	Issued for construction					

OWNER: POWER GENERATION CORPORATION 1
THERMAL POWER PROJECT MANAGEMENT BOARD 3
CONSULTANT: POWER ENGINEERING CONSULTING JOINT STOCK COMPANY 3
CONTRACTOR: THE CONSORTIUM OF CHENGDA–DEC–SWEPDI–ZEPC
SUBCONTRACTOR: SHANGHAI HEAVY MACHINERY PLANT CO.,LTD. 上海重型机器厂有限公司

PROJECT : DUYEN HAI 3 THERMAL POWER PLANT PROJECT
CONTRACT NO: DH3–05082011

DRAWING NAME: 磨辊装置 JOURNAL ASSEMBLY
Total: 共 1 张
No.: 第 1 张

PROJECT CONTROL NO: DH3–31(32)HFC–M–PSZ–0028
Scale: 1:1

DRAWING NO: K3868(B).10.0 REV: 0 SAP: E020206553000000 REV: 0