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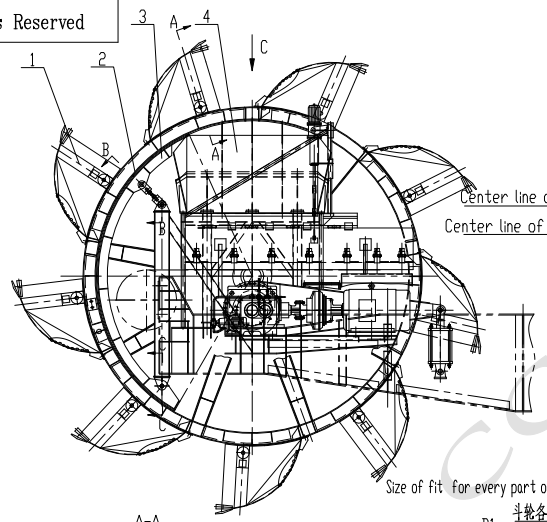

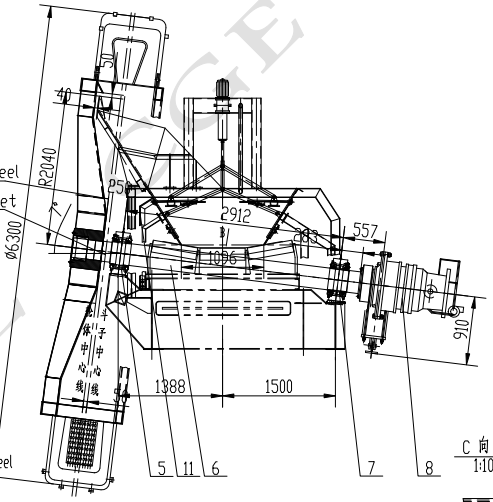

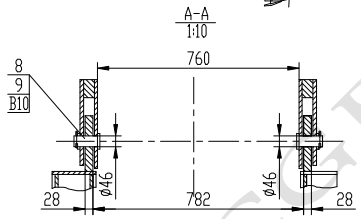

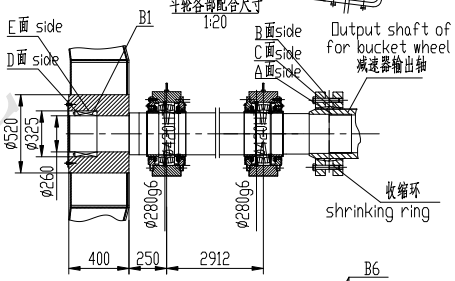

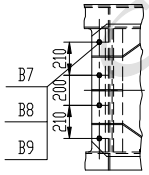

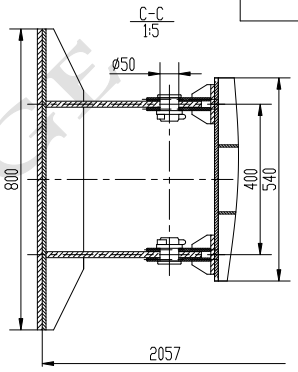

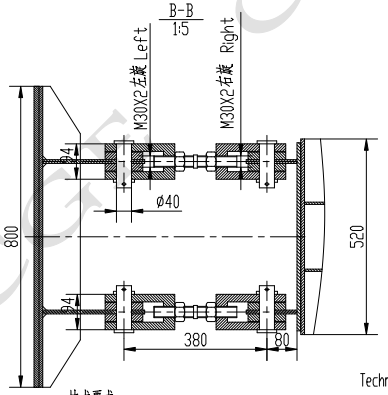

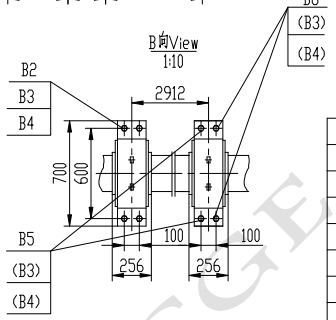

技术要求

1. 装配时轴承应均匀地涂上黄油油量为轴承内腔的 1/3.
2. 件2)圆弧挡板与铲板的侧间隙 5~10mm,该间隙参照件2)圆弧挡板调整.
3. 斗轮铲体周围要安与斗轮相联接,在安装连接之前,必须仔细地用溶剂或丙酮清洗轴的外径及铲体的孔,并保证连接面(D面至E面)上无任何润滑油或其它杂物.联系就位后用力矩扳手和对角或对称均匀地拧紧所有螺栓.每个螺栓每次均拧紧90度,一直达到每个螺栓的拧紧力矩值355N·m.
4. 斗轮驱动装置周围要安与斗轮铲联接,在斗轮减速器输出轴伸在斗轮轴上之前,必须仔细地用溶剂或丙酮清洗轴的外径及斗轮减速器输出轴的孔,并保证连接面(A面)无上任何润滑油或其它杂物.联系就位后用对角或对称均匀地拧紧所有螺栓.然后用手拧紧4-5个等间距的螺栓,拧紧时要保证两个法兰盘面平行,随后用手拧紧其余的螺栓,然后用力矩扳手顺时针或逆时针均匀地拧紧所有螺栓.每个螺栓每次均拧紧90度一直达到每个螺栓的拧紧力矩,力矩值见减速器说明书.
5. 件8)斗轮驱动装置减速器内加注油型号和数量应依据随附的说明书规定执行.

Technical requirement

1.During installation, the bearing should be coated with grease even , and the grease amount is 1/3 inner cavity of the bearing.
2.The clearance between item 3 ring chute and the inner side of bucket wheel body is in 5~10mm.
3.The Bucket wheel body should be connected with Bucket wheel shaft with expanded sleeve. Before bucket wheel body will be installed, the outer diameter of the bucket wheel shaft and the inner hole of the wheel hub must be cleaned with alcohol or acetone and ensure that there is no lubricant or other contaminations on the connection surface, Before shrinking ring of the expend sleeve telescopes wheel shaft output, when the expand sleeve is installed on the right position, using the torque wrench to tighten all bolt evenly along the clockwise or counter clockwise, each bolt will be tightened about 90 degree each time, until the torque tight force value of each bolts reach 355Nm
4.Fluid motor will be connected to the bucket wheel shaft with expand sleeve , the outer diameter of the bucket wheel shaft and the inner hole of the fluid motor must be cleaned with alcohol or acetone and ensure that there is no lubricant or other contaminations on the connection surface (A side), Before shrinking ring of the expend sleeve telescopes wheel shaft output,the surface(BC side) must be cleaned , when the expand sleeve is on right position, 4-5 equal distance bolts will be tightened by hand immediately , and must ensure two flanges must keep parallel during tight the bolts , then tighten the rest bolts by hand , using the torque wrench to tighten all bolt even along the clockwise or counter clockwise. every one will be tightened about 90 degree each time, until the torque tight force of each bolts reach stipulated value.
5. Item 8 the gear box of bucket wheel driving unit: the type and quantity of filling oil should be carried out according to the corresponding instructions provided.

技术性能表 Main performance list

Bucket Wheel 斗轮	直径D	Diameter D	Ø6300 mm
	转速n	Rotational Speed	6.86r/min
	斗容	Bucket Capacity Volume	0.45 m^3
	斗数	Number Of The Bucket	9
Electrical Motor 电动机	型号	Type	Y280M-4(IP55W,F级level)
	功率P	Power	90kW
Reducer 减速器	型号	Type	P2KA17 (Flender)
	输出扭矩T	Rated Torque	125000N·m
	速比i	Transmission Ratio	215.79

序号No.	代号Standard	名称Denomination	数量Qty	材料 Material	单重 Kg	总重 Kg	备注Remark
B10		开口销Pin Ø8x63	18	Q235-A			
B9		垫圈Washer 20	36	65Mn			
B8		螺母Nut M20	36	5			
B7		螺栓Bolt M20x45	36	4.8			
B6		螺栓Bolt M36x160	2	8.8			
B5		螺栓Bolt M36x170	2	8.8			
B4		垫圈Washer 36	8	65Mn			
B3		螺母Nut M36	8	8			
B2		螺栓Bolt M36x145	4	8.8			
B1		膨胀Expand Sleeve $Z_{\#}$260x325	1	成品Finished Product			
11	F4281-MANU010-0010-M02-008	回程胶带头部护罩 Return Guard At The Head Part Of Belt Conveyor	1	焊接件 Structure			DQ9721.1-2
10		挡圈 check Ring	18	Q235-A			DQ315.1-2
9		销轴 Pin Roll	18	35			DQ315.1-1
8	F4281-MANU010-0010-M02-007	斗轮驱动装置 Bucket Wheel Drive Device	1	装配件 Assembly			DQ9721.1.3
7		轴承组件 Bearing Assembly	1	装配件 Assembly			DQ591.1.4
6		斗轮轴 Bucket Wheel Shaft	1	45			DQ9721.1-1
5		轴承组件 Bearing Assembly I	1	装配件 Assembly			DQ801.1.5
4	F4281-MANU010-0010-M02-004	溜料导料装置 Bucket Wheel Chute	1	装配件 Assembly			DQ9721.1.2
3	F4281-MANU010-0010-M02-003	圆弧挡板 Ring Chute	1	装配件 Assembly			DQ9721.1.1
2	F4281-MANU010-0010-M02-002	轮体 Wheel	1	焊接件 Structure			DQ5919.1.1
1		斗子 Bucket	9	装配件 Assembly			DQ4211.1.1

REV.	DATE	DESIGNED BY	CHECKED BY	REVIEWED BY	APPROVED BY	DESCRIPTION
A	30, OCT, 2013	Ji, Jin Yang	Li, Min	Dai, Yong Qing	Jia, Yan Xun	

OWNER: VIETNAM ELECTRICITY THERMAL POWER PROJECT MANAGEMENT BOARD 3 (EVNTPMB3)
CONSULTANT: POWER ENGINEERING CONSULTING JOINT STOCK COMPANY 2 (EVNPECC2)
CONTRACTOR: DONGFANG ELECTRIC CORPORATION LIMITED (DEC)
SUBCONTRACTOR: CHANGCHUN GENERATING EQUIPMENT GROUP,CHINA

DEC REF. No.: DUYEN HAI 1/CGE/MANU010
MANU REF. No.: MANU010
PROJECT: DUYEN HAI 1 THERMAL POWER PLANT PROJECT
CONTRACT NO.: DH1-30032010

TITLE 1: **Bucket Wheel Unit**

DESIGNED BY: 季金阳 | CHECKED BY: 李敏 | SCALE: 1:50
REVIEWED BY: 魏永清 | DATE: 30, OCT, 2013
APPROVED BY: 贾延逊 | SUBMITTED FOR: FI
STATUS: | DRAWING No.: F4281-MANU010-0010-M02-001 | REV.: A