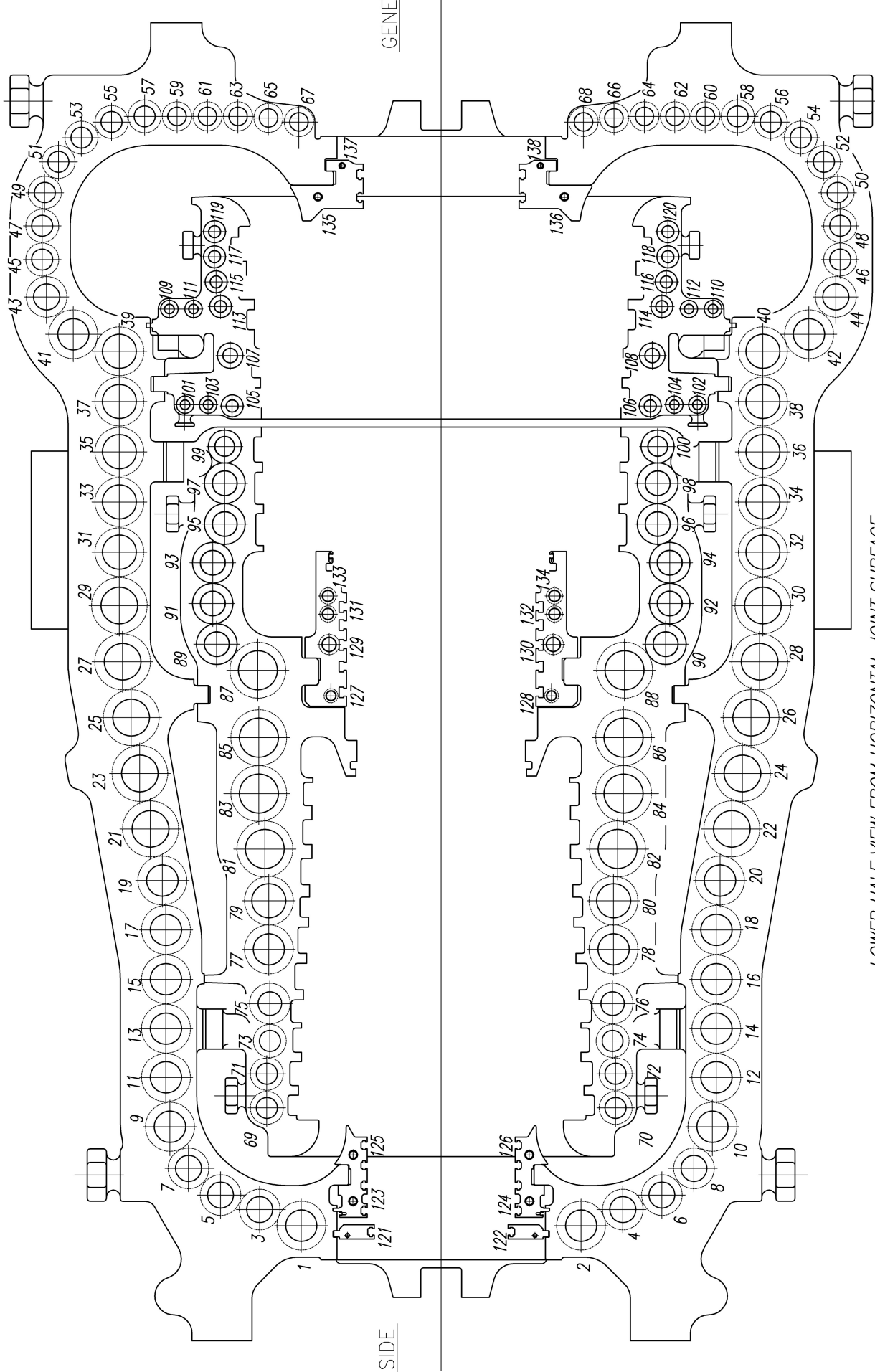




① ARGT JT STUD

GENERATOR SIDE

TURBINE SIDE

LOWER HALF VIEW FROM HORIZONTAL JOINT SURFACE

NOTES

1. STUDS OF BOLT NO. 127-134 TO BE STAMPED WITH NUMBER.
NUTS OF BOLT NO. 127-134 TO BE STAMPED LIKE "A" OR "B" (TOP OR BOTTOM) AND NUMBER.

1 NUMBER

T "T" (TOP) or "B" (BOTTOM) NUMBER

EXAMPLE FOR STAMPING BOLTS

EXAMPLE FOR STAMPING NUTS

STAMPING TO BE DONE AFTER THEY HAVE BEEN FITTED AND ASSEMBLED.

IN CASE OF REASSEMBLY, REASSURE TO ASSEMBLE THE STUDS IN SAME HOLES OF THE CASING.

2. FOR ALL STUDS 2" AND ABOVE IN DIAMETER, BOLT HEATER TO BE USED. AND THOSE LESS THAN 2" DIA. TO BE HAND TIGHTENED.
3. ALL RESULTS TO BE CONFIRMED BY EXTENSIONMETER MEASUREMENTS ON EQUIVALENT METHOD, AND TO BE RECORDED.
4. APPLY DOW CORNING MOLYKOTE P37 ON THE THREAD OF STUDS/ NUTS BOTH SIDES OF WASHERS.
5. NUT ROTATIONS OF (20) APPLIED TO GASKETS INDICATE THOSE AFTER ME

[illegible]

この図面は、設計者の権利、著作権、特許権、商標権、その他の権利を有する。この図面は、設計者の許可なく複製、転載、または他の目的で利用されることを禁じます。また、この図面は、設計者の責任範囲を超えて利用されることを禁じます。

LOCATION OF HOLES		STUD		PARTS (CODE) NUT		WASHER		BOLT DIMENSION			BOLT EXTENSION		NUT ROTATION		TORQUE		MATERIAL		
								SIZE		OVERALL EFFECTIVE LENGTH		HOLE DIA IN STUD				kg·m (N·m)			
1~ 2, 9~12	KIDWUN001336 H7 +BTYPE	THRU STUD	3KS129628 P001	-	-	-	-	UN6	1336	1173	22	1.584~1.759	(251° 27' ~ 279° 13')	-	10~0.5Mo-V	-	10~0.5Mo-V		
		THRU STUD	K2CSTN50 H7					1286	1148	22	1.550~1.722	(246° 3' ~ 273° 21')	-	10~0.5Mo-V					
3~ 8	KIDWUN501286 H7 +BTYPE	THRU STUD	3KS129628 P001	STT 72	-	-	-	UN6	1336	1173	22	1.760~1.935	(279° 23' ~ 307° 9')	-	10~0.5Mo-V	-	10~0.5Mo-V		
13~ 16	KIDWUN001336 RG +BTYPE	THRU STUD	3KS129628 P001	THRU STUD	-	-	-	UN6	1536	1373	22	1.689~1.894	(268° 7' ~ 300° 39')	-	12Cr-Mo-W-V	-	12Cr-Mo-W-V		
17~ 20	KIDWUN001536 RG +BTYPE	THRU STUD	K2CSUT70 H7	THRU STUD	-	-	-	UH7	1579	1395	22	1.877~2.085	(223° 26' ~ 248° 11')	-	12Cr-Mo-W-V	-	12Cr-Mo-W-V		
21~ 24	KIDWUH701579 RG +BTYPE	THRU STUD	K2CSUT70 PRG	THRU STUD	-	-	-	UH7	1579	1395	22	1.556~1.764	(185° 14' ~ 209° 58')	-	10.7Cr-Mo-V-Nb-N	-	10.7Cr-Mo-V-Nb-N		
25~ 30	KIDWUH701579 RS +BTYPE	THRU STUD	K2CSUT64 PRG +D1235 D3195	THRU STUD	-	-	-	UH6 1/2	1562	1386	22	1.546~1.753	(245° 25' ~ 278° 16')	-	10.7Cr-Mo-V-Nb-N	-	10.7Cr-Mo-V-Nb-N		
31~ 38	KIDWUH641562 RS +BTYPE	THRU STUD	3KS131909 P001	THRU STUD	-	-	-	UH6 1/2	1562	1386	22	1.705~1.912	(270° 40' ~ 303° 30')	-	12Cr-Mo-W-V	-	12Cr-Mo-W-V		
39~ 40	KIDWUH641562 RG +BTYPE	THRU STUD	3KS129628 P001	THRU STUD	-	-	-	UN6	1536	1373	22	2.060~2.265	(327° 1' ~ 359° 32')	-	10~0.5Mo-V	-	10~0.5Mo-V		
41~ 42	KIDWUN601536 H7 +BTYPE	THRU STUD	K2CSTN50 H7	THRU STUD	-	-	-	UN5	1186	1048	22	1.572~1.729	(249° 33' ~ 274° 27')	-	10~0.5Mo-V	-	10~0.5Mo-V		
43~ 44	KIDWUN501186 H7 +BTYPE	THRU STUD	K2CSTN40 H7	THRU STUD	-	-	-	UN4	1134	1022	22	1.533~1.686	(243° 21' ~ 267° 38')	-	10~0.5Mo-V	-	10~0.5Mo-V		
45~ 48	KIDWUN401134 H7 +BTYPE	THRU STUD	K2CSTN40 H7	THRU STUD	-	-	-	UN4	1134	1022	22	1.380~1.533	(219° 4' ~ 243° 20')	-	10~0.5Mo-V	-	10~0.5Mo-V		
49~ 58	KIDWUN401134 H7 +BTYPE	THRU STUD	K2CSTN34 H7	THRU STUD	-	-	-	UN3 1/2	1110	1010	22	1.364~1.515	(216° 32' ~ 240° 29')	-	10~0.5Mo-V	-	10~0.5Mo-V		
59~ 68	KIDWUN341110 H7 +BTYPE	THRU STUD	K2CSTN40 H7 (UPPER)	THRU STUD	-	-	-	UN4	874	762	22	1.029~1.143	(163° 21' ~ 181° 26')	-	12Cr-Mo-W-V	-	12Cr-Mo-W-V		
69~ 74	KIDWUN40X874 RG +BTYPE	THRU STUD	K2CSTN40BOLT H7 (LOWER)	THRU STUD	-	-	-	UN5	926	788	22	1.064~1.182	(168° 54' ~ 187° 37')	-	12Cr-Mo-W-V	-	12Cr-Mo-W-V		
75~ 76	KIDWUN50X926 RG +BTYPE	THRU STUD	K2CSTN50 H7 (UPPER)	THRU STUD	-	-	-	UN6	1196	1033	22	1.395~1.549	(221° 27' ~ 245° 53')	-	12Cr-Mo-W-V	-	12Cr-Mo-W-V		
77~ 78	KIDWUN601196 RG +BTYPE	THRU STUD	3KS129628 P001 (UPPER)	THRU STUD	STT 59,60	-	-	UN6	1196	1033	22	1.395~1.549	(221° 27' ~ 245° 53')	-	12Cr-Mo-W-V	-	12Cr-Mo-W-V		
79~ 80	KIDWUH641222 RS +BTYPE	THRU STUD	K2CSUT64 PRG +D1235 D3195 (UPPER)	THRU STUD	-	-	-	UH6 1/2	1222	1046	22	1.413~1.569	(224° 18' ~ 249° 3')	-	10.7Cr-Mo-V-Nb-N	-	10.7Cr-Mo-V-Nb-N		
81~ 86	KIDWUH741265 RS +BTYPE	THRU STUD	3KS140984 P001 (LOWER)	THRU STUD	-	-	-	UH7 1/2	1265	1068	22	1.442~1.602	(171° 40' ~ 190° 41')	-	10.7Cr-Mo-V-Nb-N	-	10.7Cr-Mo-V-Nb-N		
87~ 88	KIDWUH741265 RS +BTYPE	THRU STUD	3KS140984 P002 (LOWER)	THRU STUD	-	-	-	UH7 1/2	1265	1068	22	1.068~1.228	(127° 8' ~ 146° 10')	-	10.7Cr-Mo-V-Nb-N	-	10.7Cr-Mo-V-Nb-N		
89~ 98	KIDWUN50X846 RS +BTYPE	TAP STUD	K2CSTN50 PRG	TAP STUD	-	-	-	UN5	846	670	22	0.905~1.005	(143° 40' ~ 159° 32')	-	10.7Cr-Mo-V-Nb-N	-	10.7Cr-Mo-V-Nb-N		
99~100, 101~104, 109~112	KIDWUN40X795 RS +BTYPE	TAP STUD	K2CSTN40 PRG	TAP STUD	-	-	-	UN4	795	644	22	0.870~0.966	(138° 7' ~ 153° 20')	-	10.7Cr-Mo-V-Nb-N	-	10.7Cr-Mo-V-Nb-N		
105~106, 113~120	KIDWUN20X370 H7	TAP STUD	K2CPNT20 H7	TAP STUD	-	-	-	UN2	370	275	16	0.372~0.412	(56° 57' ~ 63° 3')	-	10~0.5Mo-V	-	10~0.5Mo-V		
107~108	KIDWUN24X406 H7 +BTYPE	TAP STUD	K2CSTN24 H7	TAP STUD	-	-	-	UN2 1/2	406	290	16	0.392~0.435	(60° 1' ~ 66° 35')	-	10~0.5Mo-V	-	10~0.5Mo-V		
121~122	KIDWUN30X519 H7 +BTYPE	THRU STUD	K2CSTN30 H7	THRU STUD	-	-	-	UN3	519	394	22	0.532~0.591	(81° 27' ~ 90° 27')	-	10~0.5Mo-V	-	10~0.5Mo-V		
123~124	KIDWUN20X105 H7	THRU STUD	-	THRU STUD	-	-	-	M20	125	91	-	(0.123~0.136)	(23° 2' ~ 25° 27')	-	10~0.5Mo-V	-	10~0.5Mo-V		
125~126	KIDWUN16X638 T8	THRU STUD	K2CPNT16 PN8 (UPPER)	THRU STUD	-	-	-	UNT1 1/2	187	124	-	(0.168~0.186)	(24° 46' ~ 27° 25')	-	10~0.5Mo-V	-	10~0.5Mo-V		
127~128	KIDWUN16X638 T8	THRU STUD	K2CPNT20 PN8 (UPPER)	THRU STUD	-	-	-	UNT1 1/2	207	144	-	(0.195~0.216)	(28° 45' ~ 31° 50')	-	10~0.5Mo-V	-	10~0.5Mo-V		
129~130	KIDWUN24X342 T8 +BTYPE	THRU STUD	K2CSTN24 PN8 (UPPER)	THRU STUD	-	-	-	UN1 3/4	638	577	10	(0.520~0.577)	(82° 33' ~ 91° 35')	-	Fe-53Ni-19Cr-5Nb-3Mo-Ti-Al-B	-	Fe-53Ni-19Cr-5Nb-3Mo-Ti-Al-B		
131~134	KIDWUN20X242 T8	THRU STUD	4KS146552 P003 (LOWER)	THRU STUD	STT 41	-	-	UN2 1/2	542	461	16	0.413~0.461	(63° 32' ~ 70° 33')	-	Fe-53Ni-19Cr-5Nb-3Mo-Ti-Al-B	-	Fe-53Ni-19Cr-5Nb-3Mo-Ti-Al-B		
135~136	KIDWUN20X242 T8	THRU STUD	4KS146552 P002 (LOWER)	THRU STUD	STT 40	-	-	UN2	242	174	16	(0.157~0.174)	(24° 2' ~ 26° 38')	-	Fe-53Ni-19Cr-5Nb-3Mo-Ti-Al-B	-	Fe-53Ni-19Cr-5Nb-3Mo-Ti-Al-B		
137~138	KIDWUN20X242 T8	THRU STUD	4KS146552 P002 (LOWER)	THRU STUD	STT 40	-	-	UNT1 1/2	382	319	-	(0.431~0.478)	(63° 32' ~ 70° 27')	-	10~0.5Mo-V	-	10~0.5Mo-V		
201	KIDWUN20X316 H7	THRU STUD	K2CPNT20 H7	THRU STUD	STT 84	-	-	UN2	316	221	16	(0.177~0.265)	(1° 29' ~ 15° 0')	-	10~0.5Mo-V	-	10~0.5Mo-V		