

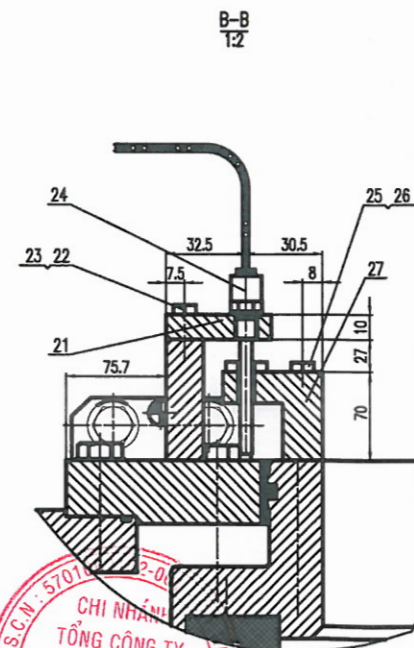
37	GB 3432.1	O型密封圈 400x3.3x1.7445	8	件数	
38	GB 3432.1	O-TYPE SEAL RING	8	件数	
39	GB 3432.1	FLUX SCREW	8	件数	
35	GB/T 110	内螺纹圆螺母 M12x50	8	件数	
34	GB/T 97.1	FEMALE THREAD TAPER PIN	8	件数	
33	GB/T 5783	垫圈 16	8	件数	
32	GB/T 5782	螺栓 M16x50	8	件数	
31	GB 3432.1	O型密封圈 400x3.3x1.7445	18	件数	
30	GB/T 110	内螺纹圆螺母 M20x70	4	件数	
29	GB 3432.1	FEMALE THREAD TAPER PIN	4	件数	
28	GB 3432.1	止动销	4	件数	
27	GB 3432.1	SET PLATE	4	件数	
26	GB 3432.1	密封块	1	件数	
25	GB/T 110	内螺纹圆螺母 M10x80	2	件数	
24	GB/T 5782	FEMALE THREAD TAPER PIN	2	件数	
23	GB/T 5782	螺栓 M12x30	2	件数	
22	GB/T 5782	螺栓 M12x30	2	件数	
21	GB 3432.1	密封块	1	件数	
20	GB 3432.1	BACK UP PIN	2	件数	
19	GB 3432.1	密封块	2	件数	
18	GB 3432.1	密封块	2	件数	
17	GB/T 110	内螺纹圆螺母 M20x120	4	件数	
16	GB/T 70.1	FEMALE THREAD TAPER PIN	4	件数	
15	GB/T 97.1	垫圈 10	52	件数	
14	GB/T 70.1	垫圈 10	52	件数	
13	GB/T 2578	密封块	10mm	件数	
12	GB 3432.1	密封块	(1)	件数	
11	GB 3432.1	密封块	24	件数	
10	GB 3432.1	密封块	24	件数	
9	GB 3432.1	密封块	(1)	件数	
8	GB 3432.1	密封块	(1)	件数	
7	GB/T 93	密封块	60	件数	
6	GB/T 5782	密封块	24	件数	
5	GB 3432.1	密封块	1	件数	
4	GB 3432.1	密封块	(1)	件数	
3	GB 3432.1	密封块	(1)	件数	
2	GB 3432.1	密封块	1	件数	
1	GB 3432.1	密封块	25mm	件数	

技术要求

- 所有密封装配的零件厂内应尽可能进行预装,并作好标记。
- 厂内预装时,应仔细调整使项9与项12的间隙均匀并满足图中要求后,方可打定位销。
- 检修密封项19在厂内预装及工地安装后,作0.7MPa正常工作压力气密性试验,不得漏气,排气后应复位。
- 工地安装时,所有橡胶制品的接头,均需用粘合剂粘牢, (粘合剂由电站自备)。
- 检修密封在机组停机时通气,开机前排气。
- 工地安装时,项3, 5, 9, 12的分半面均应涂MF-1型密封胶, (密封胶由电站自备)。
- 厂内预装时,应仔细调整使项28与项29的间隙,并满足所有两端间隙相等要求后,方可打定位销。
- 工地安装时,应保证项5的N面在盘车时检查其跳动不大于0.05mm。
- 工地安装完后,应通清洁水(水经过50μm过滤器过滤)冲洗,使进水孔和密封面脏物堆积,同时应在均布四处用百分表检查密封环浮动灵活性和水平度。
- 主轴密封冷却水(水经过50μm过滤器过滤)压为0.2~0.6MPa,水量为2~6L/s,电站可根据实际运行情况,通过磨损量监测来调整密封冷却水的压力和流量。
- 机组启动前,应先通入密封冷却水,运行中不得中断密封冷却水。
- 密封块允许磨损量15mm。
- 按DB413油漆规范进行油漆。

TECHNICAL SPECIFICATIONS:

- ALL PARTS OF THIS ASSEMBLY SHOULD BE PREASSEMBLED AS FAR AS POSSIBLE IN FACTORY AND MARK IT ACCORDINGLY.
- WHEN PREASSEMBLING IN FACTORY, THE CLEARANCE BETWEEN ITEM 9 AND ITEM 12 SHOULD BE ADJUSTED AS FAR AS IT SHALL BE EVEN AND SATISFAIED WITH REQUIREMENT OF DRAWING, THEN ASSEMBLE DOWEL LOCATING PINS.
- ITEM 19 SHOULD BE TESTED BY 0.7MPa SERVICE PRESSURE AFTER BOTH IT IS PREASSEMBLED IN FACTORY AND SETTED UP AT SITE. IT SHALL NOT BE BLOW BY AND CAN REVERT AFTER BEING EXHAUST.
- AGGLUTINATE ALL JOINTS OF RUBBER ITEM HARD AT SITE. THE SEALANT SHOULD BE SUPPLIED BY EMPLOYER.
- THE INFLATABLE STAND BY SEAL SHALL BE AIR FEED AFTER THE WATER TURBINE STOP RUNNING AND IT SHALL BE EXHAUST BEFORE IT IS RUNNING.
- THE INTERFACES OF ITEM 3, 5, 9, 12 AND SO ON, SHOULD BE SMEARED WITH MF-1 SEALANT (SUPPLIED BY EMPLOYER).
- WHEN PREASSEMBLING IN FACTORY, THE CLEARANCE BETWEEN ITEM 28 AND ITEM 29 SHOULD BE ADJUSTED AND SATISFAIED WITH REQUIREMENT OF DRAWING, THEN ASSEMBLE DOWEL LOCATING PINS.
- THE OSCILLATION RANGE OF SURFACE N (ITEM 5) SHOULD BE LESS THAN 0.05mm WHEN CHECK AT SITE.
- FINISHING SETTING AT SITE, RINSE THIS SEAL WITH CLEAN WATER (THROUGH 50μm FILTER) AND ENSURE THAT THERE IS NOT GARBAGE AT INFALL AND ON SEALING SURFACE. AT THE SAME TIME CHECK THE MOBILITY AND LEVELNESS OF SEAL RING AT FOUR EQUALLY SPACED POINTS.
- THE COOLING WATER PRESSURE OF THIS SEAL (THROUGH 50μm FILTER) IS 0.2~0.6MPa, AND THE WATERFLOW IS ABOUT 2~6L/s. THE PRESSURE AND WATERFLOW CAN BE ADJUSTED BY ABRASION LOSS ACCORDING TO PRACTICAL SITUATION.
- MUST PUT THROUGH COOLING WATER TO SEAL BEFORE THE UNITS START AND THE COOLING WATER CAN NOT BE INTERMITTED.
- ALLOWABLE ABRASION LOSS OF SEAL BLOCK IS 15mm.
- PAIN AS STANDARD: DB413.



CHI NHANH
TỔNG CÔNG TY
PHÁT ĐIỆN

CÔNG TY THỦY ĐIỆN ĐỒNG NAI

BẢN VẼ LẬP HỆ THỐNG ĐEM KÍN TRỰC
NHÀ MÁY THỦY ĐIỆN ĐỒNG NAI 4

Tên: _____ Đơn vị: _____ Ngày: _____

Được: _____ Ngày: _____

Kiểm tra: _____ Ngày: _____

Kiểm tra: _____ Ngày: _____

VIETNAM ELECTRICITY
represented by the Hydropower Project Management Unit No.6 (HPPMU No.6)
DONG NAI 4 HYDROPOWER PROJECT

ENGINEER: Power Engineering Consulting Company No.3 (PECC3)

CONTRACTOR: DONGFANG ELECTRIC CORPORATION

MANUFACTORY: DONGFANG ELECTRICAL MACHINERY CO.,LTD.

CONTRACT NO.: LOT No.17 SUPPLY OF ELECTROMECHANICAL EQUIPMENT AND TECHNICAL SERVICES

EQUIPMENT NAME: ASSEMBLY OF TURBINE PARTS Section No: 05070

1. 2. 1816 1:3 密封装配
Assembly of shaft seal

053816-S