



**技术要求 Technical requirements**

一、转子总装图：(注) Description rotor assembly (Note):

注1: 用脂润滑，黄油为“7014”牌稠度膏。 Note 1: Fill labyrinth seal with lubricating grease 7014

注2: 在叶榫销和叶榫套之间配合处上涂一层防锈油“G-Rapid”。 Note 2: Spray coat anti seize grease G-Rapid on the mating surfaces between blade shaft bearing segment and blade shaft disc

注3: 叶榫销涂油(14.81)黄油润滑(7014)。 Note 3: Fill tube grease 7014 on blade shaft guide bearing (14.81)

注4: 在榫头及与榫头配合小管嘴一端涂防锈油“G-Rapid”。 Note 4: Spray coat anti seize grease G-Rapid on blade shaft disc blocks at its mating surface.

注5: 将5、6榫头必须按实际尺寸能装紧力榫紧。 Note 5: Part 5, 6 shall be bonded into O rings according actual sizes.

注6: 叶榫销每枚加脂(7014)黄油并至少涂紧力榫紧。 Note 6: Add the lubricating grease 7014 to blade shaft nut and screw thread, the nuts to be tightened to suitable pre-tightening force and then locked.

注7: 叶榫销加脂后，加油孔用黄油密封509号特制膏。 Note 7: After adding lubricating grease to blade shaft bearings, filling aperture should be sealed using plug screw coated with 509 sealing cream.

注8: 将叶片与叶榫的配合面涂油或涂油后顺油流方向涂一层防锈油。 Note 8: The mating surface between adjusting levers and blade shaft shall be removed of oil & grease, and cleaned by use of propane, so as to ensure the clamping force.

注9: 叶榫销与榫头配合处，涂一层防锈油“Moylekote 1000”，注意不能加7014脂润滑。装配时，叶榫销与榫头配合处，涂一层防锈油。 Note 9: The mating surface between adjusting levers and blade shaft shall be removed of oil & grease, and cleaned by use of propane, so as to ensure the clamping force.

注10: 拆卸时涂防锈油，涂防锈油并涂一层防锈油“G-Rapid”。 Note 10: Remove the grease from the mating bush, coat the shaft extension of the hydraulic device with anti seize grease G-Rapid.

注11: 密封脂，在叶榫配合的榫头及榫头密封处涂工艺脂润滑。 Note 11: Before filling the impeller, coat cuprum on main bearing location and screw thread according to process stipulation.

注12: 多次涂防锈油的榫头应涂防锈油，螺母：自锁螺母至少多涂一层防锈油。 Note 12: Tighten all the screw and nut according to the list we supplied. NOTE: The self-locking nut could be tightened no more than twice.

注13: 对第1号叶片，将叶片角度及榫头打在中分线处，即状态下半轴取中分线处，每隔45°一个。 Note 13: For blade No. 1, the blade angle and calibration falls should be chiseled on impellers 5 degree per grill.

注14: 榫头与榫套之间，榫头与榫套之间，榫头与榫套之间涂油后涂515号面密封脂。 Note 14: The flat surface sealant 515 shall be applied between bearing cover and load ring, between load ring and connecting ring, and between guide ring and connecting ring.

注15: 推杆插入后从推杆密封处涂油或涂油并涂一层防锈油7014脂润滑。 Note 15: After the push bar is fit in, fill lube grease 7014 in the gap between push bar and shaft bush.

二、叶榫接拆说明：(注) Description of dismounting and assembling of impeller (note)

1: 叶榫接拆时所需的拉力为34.3T。Stretching force during bearinging hub axle hole is 34.3 tons.

2: 叶榫接拆时所需的压力为117MPa (表压)。 Oil pressure during bearinging is 117MPa (gauge pressure)

3: 拆卸时叶榫的温度(在叶片榫头)为107.1℃。Impeller temperature during assembly: ~107.1℃.

4: 榫头与榫套的配合公差为H7/k6，榫头与榫套的配合公差为H7/k6。 The rotor balance in the factory requests the V02060,specific steps are as follows:

三、榫头与榫套的配合公差为H7/k6，榫头与榫套的配合公差为H7/k6。 The rotor balance in the factory requests the V02060,specific steps are as follows:

(1) 榫头与榫套的配合公差为H7/k6，榫头与榫套的配合公差为H7/k6。 According to the steps, a total of three times of balance tests.

		叶榫接拆时 Impeller welded condition	叶榫接拆时 Impeller without blades	叶榫接拆时 Impeller with blades
I	叶榫接拆时 Impeller welded condition	Q 1.6	10	4516.5
II	叶榫接拆时 Impeller without blades	Q 1.6	10	19849.9
III	叶榫接拆时 Impeller with blades	Q 2.5	16	27182

四、叶榫在工厂进行平衡试验，要求如下： Note 1: The impeller dynamic balance at the work site requests the V02060,specific steps are as follows:

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	11.55	11.80	13.81	14.54	15.12	15.14	16.13	16.14
叶榫接拆时 Impeller welded condition	1120	502	95	129	54	38	68	784
叶榫接拆时 Impeller without blades	19.34	19.35	19.36	19.46	19.71	19.74	19.75	19.79
叶榫接拆时 Impeller with blades	20	94	27	94	54	149	231	149

FOR CONSTRUCTION	
0	ISSUED FOR CONSTRUCTION
REV.	DESCRIPTION
OWNER	POWER GENERATION CORPORATION 1
CONSULTANT	THERMAL POWER PROJECT MANAGEMENT BOARD 3
CONTRACTOR	POWER ENGINEERING CONSULTING JOINT STOCK COMPANY 3
SUBCONTRACTOR	THE CONSORTIUM OF CHENGDA-DEC-SWEPI-DEPC
SHANGHAI BLOWER WORKS CO., LTD. (SBW)	
PROJECT :	DUYEN HAI 3 THERMAL POWER PLANT PROJECT
CONTRACT NO.:	DH3-05082011
DRAWING NAME:	
ROTOR ASSEMBLY	
转子	
PROJECT CONTROL NO.:	DH3-31(32)HFE-W-P50-0001
DRAWING NO. :	SG04A394
REV:	0