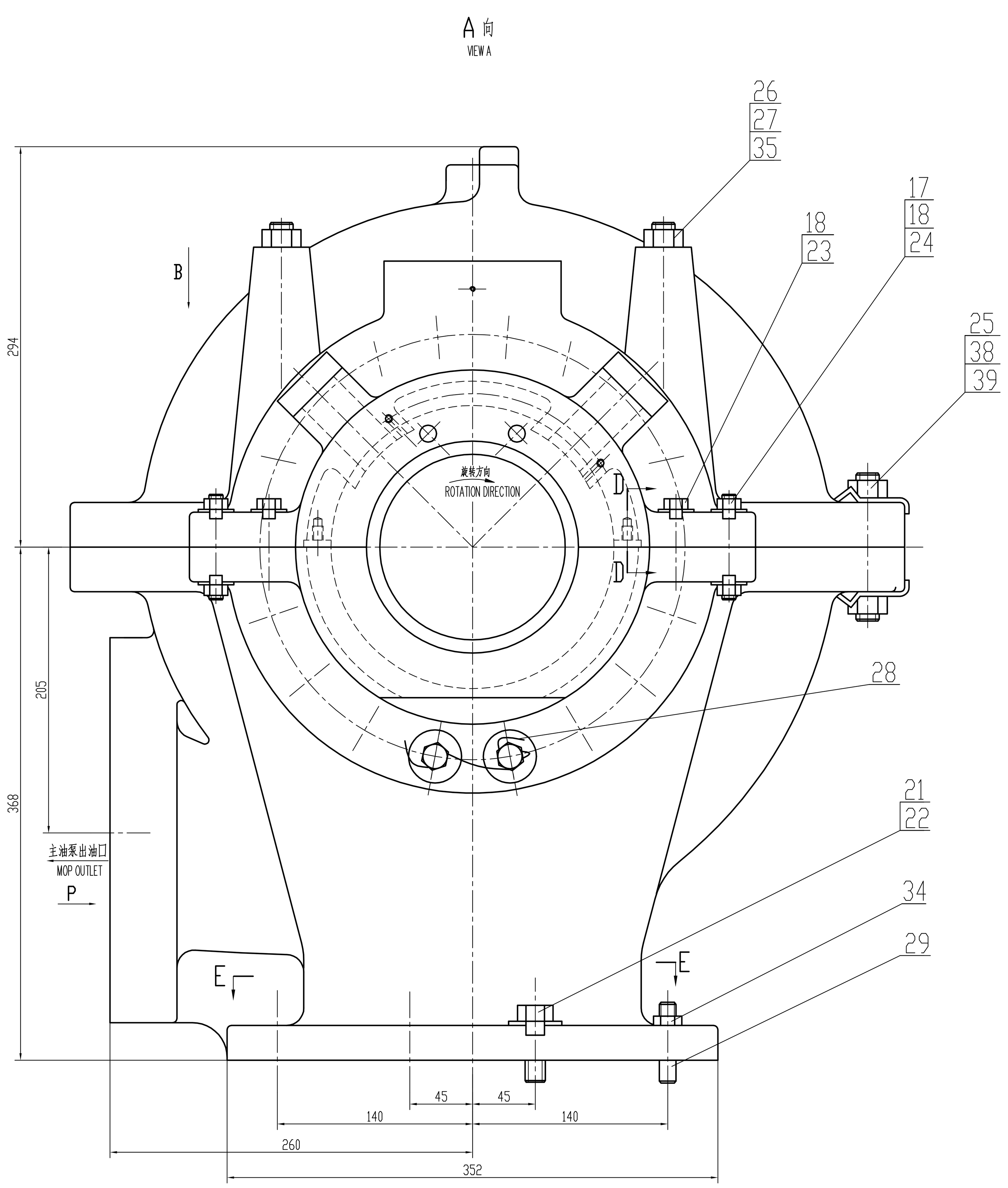
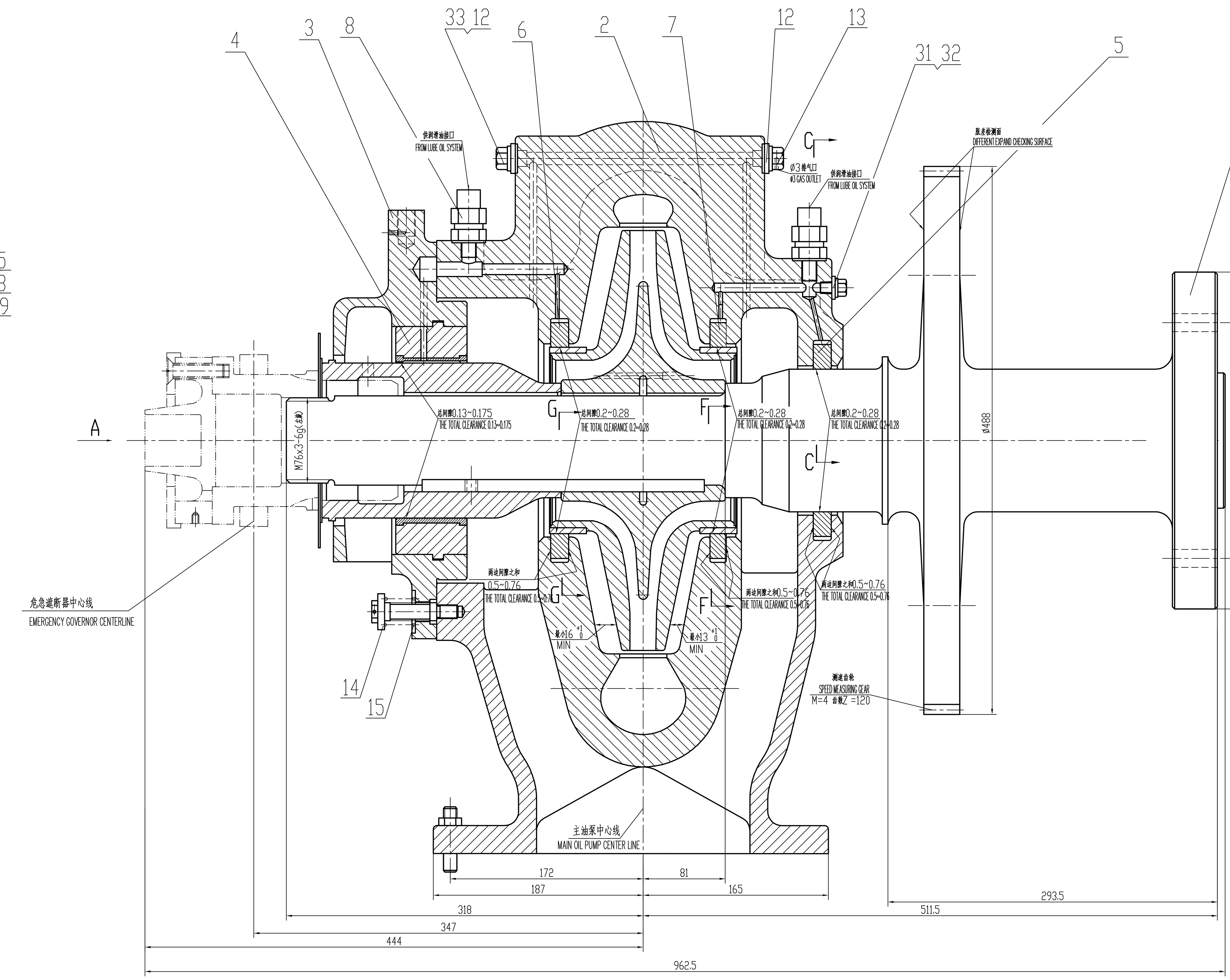
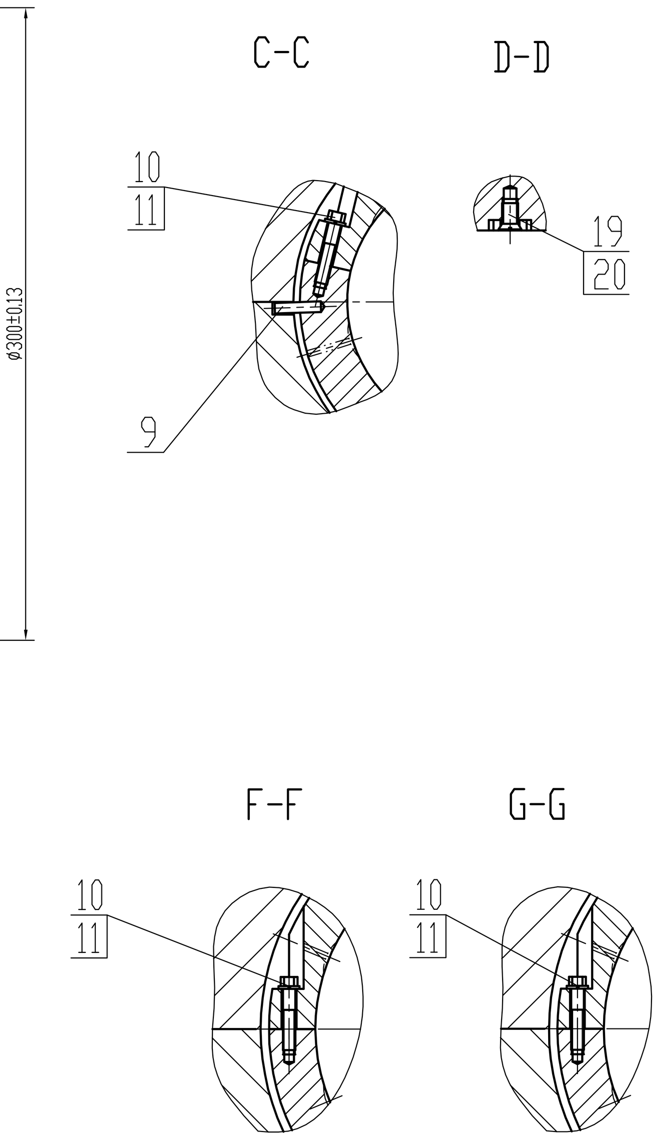
(WDA)D300AL-511000A | 密级 | 公司秘密

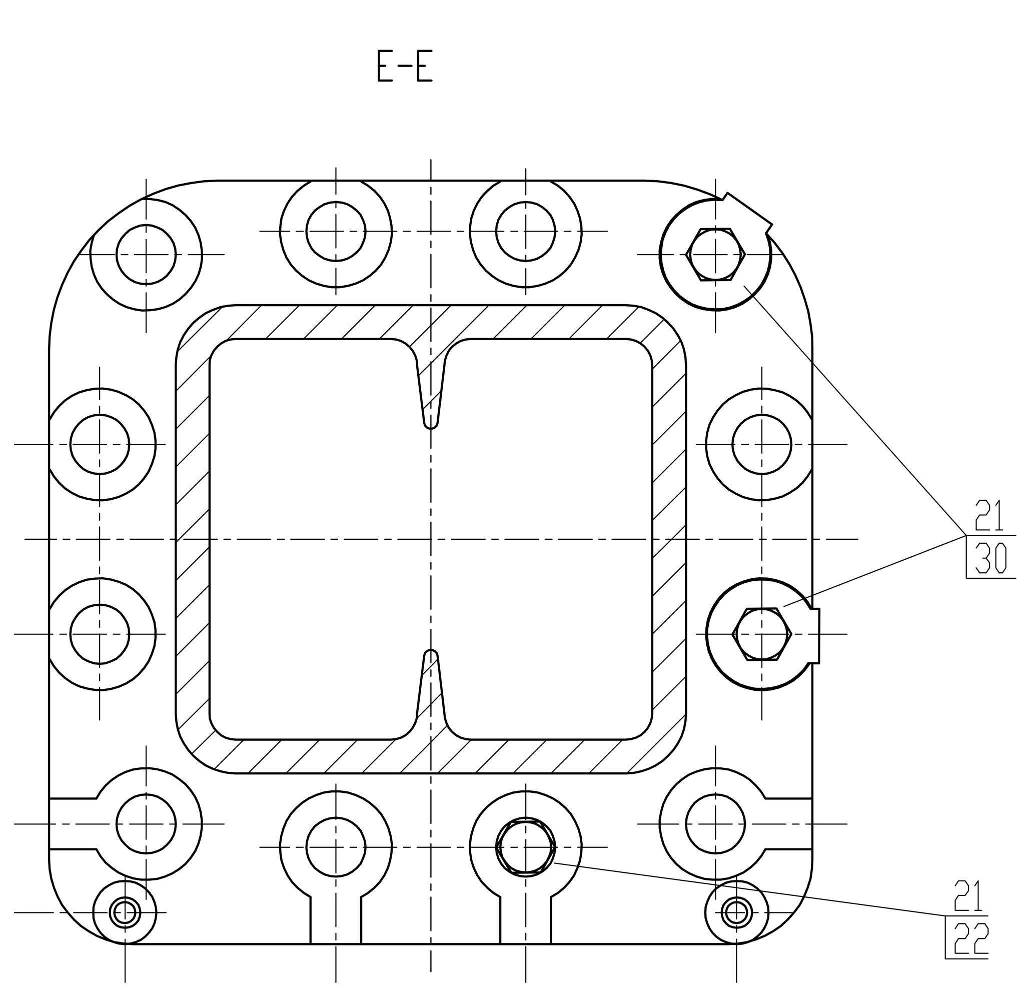
PLM控制 涂改无效

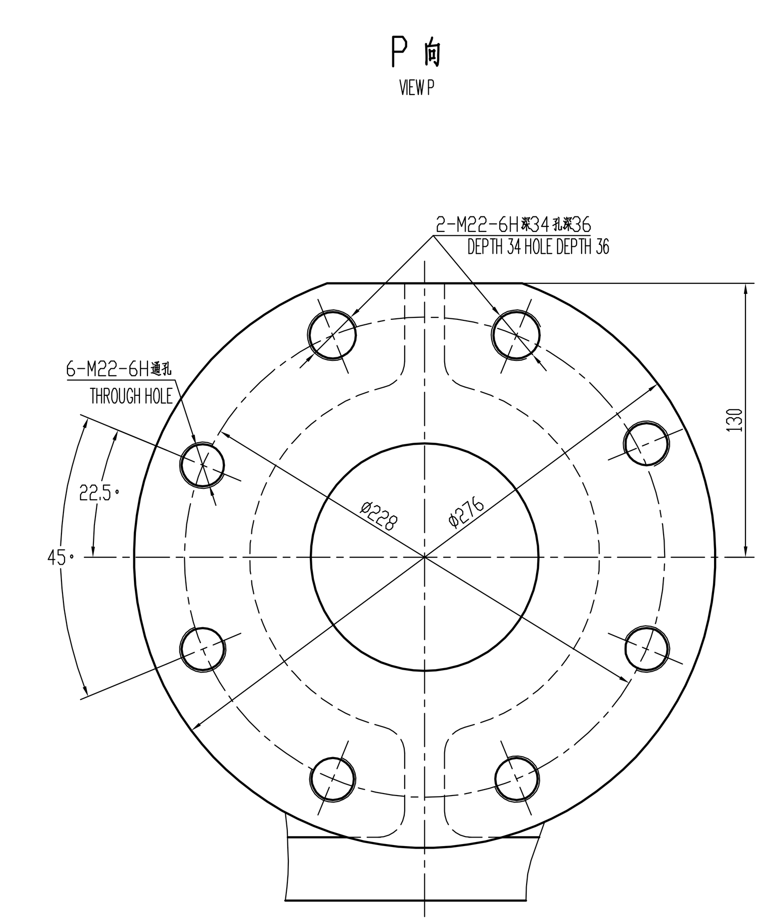
R00 初次发布

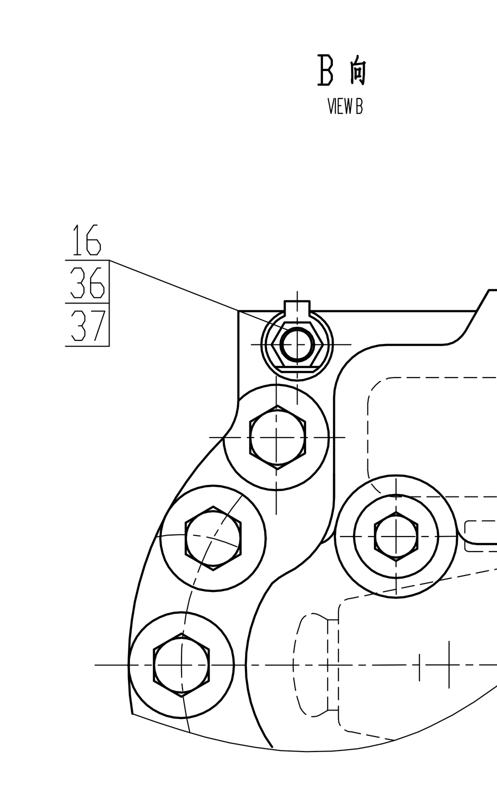












ITEM 序号	DRAWING NO 分图号	DESCRIPTION 名称	QUN 数量	MAT'L 材料	UWT 单重	TWT 总重	REMARKS 备注
37	GB854-88	单耳止动垫圈16 WASHER 16	2		0.00821	0.01642	
36	GB/T6170A-2000	六角螺母M16 NUT 16	2		0.029	0.058	
35	D185A-511000A035	特制螺栓 TAILOR-MADE BOLT	4	25Cr2MoVA	0.97	3.88	
34	GB/T6172.1-2000	六角薄螺母 M12 BOLT	2		0.00656	0.01312	
33	D00-600602A003	螺塞 M14×1.5 SCREW PLUG M14x1.5	1	35	0.0335	0.0335	
32	D00-600607A001	垫圈 10 WASHER 10	1	8A06	0.00046	0.00046	
31	D00-600602A001	螺塞 M10×1 SCREW PLUG M10x1	1	35	0.0172	0.172	
30	D600B-511000B009	垫圈 WASHER	8	Q235-B	15.4	123.2	
29	DH883-93	定位螺栓 POSITIONING PLUG	2	45	0.065	0.13	
28	D350G-511000A028	不锈钢丝 L=1830 STAINLESS STEEL WIRE	1	STEEL WIRE δ2/0Cr18Ni9	0.011	0.011	
27	GB854-88	单耳止动垫圈 24 WASHER 24	4		0.01268	0.05072	
26	GB/T6170C-2000	六角螺母 M24 NUT M24	4	25Cr2MoVA	0.0888	0.3552	
25	GB897C-88	双头螺柱(bm=1d) M30×120 DOUBLE-SCREW BOLT (bm=1d) M30x120	10	25Cr2MoVA	0.7324	7.324	
24	D600B-511000B007	铰螺栓 BOLT	2	45	0.1	0.2	
23	GB/T5783-2000	六角头螺栓 M12×45 BOLT M12x45	2		0.04725	0.0945	
22	D600B-511000B006	垫圈 WASHER	4	Q235-B	0.0210	0.0840	
21	GB/T5783-2000	六角头螺栓 M24×55 BOLT M24x55	12		0.2835	3.402	
20	GB/T68-2000	开槽沉头螺钉 M6×12 BOLT M6x12	2		0.0026	0.0052	
19	D600B-511000B005	垫圈 WASHER	2	25	0.10	0.20	
18	GB854-88	单耳止动垫圈 12 WASHER 12	6		0.0048	0.0288	
17	GB/T6170A-2000	六角螺母 M12 NUT M12	4		0.01193	0.04772	
16	GB/T881-2000	螺尾锥销 16×100 END SCREW WEDGE PIN 16X100	2		0.15	0.3	
15	D600B-511000B003	盘簧 SPRING	14	60Si2MnA	0.120	1.680	
14	D600B-511000B002	六角头螺栓 HEXAGON HEAD BOLT	14	45Cr1MoV	0.040	0.560	
13	D600B-511000B001	排气螺塞 VENT PLUG	1	35	0.09	0.09	
12	D00-600607A003	垫圈 14 WASHER 14	2	8A06	0.00088	0.00176	
11	GB/T70.1-2008	内六角圆柱头螺钉 M6×30 SCREW BOLT M6X30	6		0.0082	0.0492	
10	GB93-87	标准型弹簧垫圈 6 SPRING WASHER 6	6		0.00015	0.0009	
9	GB119/1-86	圆柱销 A5×20 PIN A5X20	1		0.00306	0.00306	
8	D00-600304A	旋入管接头DN10 SCREWED JOINT DN10	2		0.158	0.316	
7	D300AL-511400A	密封环 SEAL RING	1		1.8	1.8	
6	D300AL-511300A	密封环 SEAL RING	1		1.8	1.8	
5	D350G-511300A	密封环 SEAL RING	1		2.30	2.30	
4	D600B-511400B	浮动轴承 FLOAT BEARING	1		7.40	7.40	
3	D600B-511300B	左端盖 LEFT SHELL COVER	1		31.50	31.50	
2	D300AL-511200A	泵壳 PUMP SHELL	1		156	156	
1	D300AL-511100A	转子 ROTOR	1		198.192	198.192	

技术要求

1 用不锈钢丝将螺栓拴在一起，防止其转动，根据外形弯制与接头相焊，上、下半应分开。
2 清洁度JB/T4058-1999中洁-2要求进行。
3 固定轴承座的滑动负荷应调整在900~1130kg（目标1000kg）。
4 本部套参加前轴承箱总装，转子部分随汽机转子发货，其余部分随前轴承箱发货。
5 安装排气螺塞（件13）时，必须使排气孔垂直向下。
6 整体做性能试验。

NOTE

1 USE STAINLESS STEEL WIRE TO BUNDLE WITH BOLT TO PREVEND THE BOLT ROTATING,BENDING AND WELDING WITH WELD HEAD. UPPER HALF AND BOTTOM HALF SHALL BE SEPERATED.
2 CLEANLINESS SHOULD MEET THE REQUITRMENT OF JB/T4058-1999-2.
3 THE SLIDE LOAD FOR FIXING BEARING PEDESTAL SHALL BE ADJUSTED BETWEEN 900~1130kg(THE AIM IS 1000kg).
4 THE PART SHOULD BE ASSEMBLED IN THE FRONT BEARING BOX ASSEMBLE LINE. THE OIL PUMP ROTOR SHOULD BE DELIVERED WITH THE TURBINE ROTOR.THE OTHER PARTS SHOULD BE DELIVERVED WITH THE FRONT BEARING BOX.
5 PLEASE STRAIGHT DOWN THE VENT, WHEN INSTALL THE EXHAUST PLUG(ITEM 13).
6 THE MAIN OIL PUMP SHOULD DO THE OVERALL PERFORMANCE.

ITEM 序号	DRAWING NO 分图号	DESCRIPTION 名称	QUN 数量	MAT'L 材料	UWT 单重	TWT 总重	REMARKS 备注
39	GB854-88	单耳止动垫圈16 WASHER 16	20		0.03117	0.6234	
38	GB/T6170C-2000	六角螺母M16 NUT M16	20	25Cr2MoVA	0.1844	0.6234	

REV	DATE	DESCRIPTIONS	PREPARED	CHECKED	REVIEWED	APPROVED

GECELCA 3.2

CHINA UNITED ENGINEERING CORPORATION

GECELCA 3.2 POWER PLANT, COLOMBIA
哥伦比亚 GECELCA 3.2 燃煤电厂

更改标记 SYM	处数 NO	文件代号 REV AUTH DOC NO	签字 SIG	日期 DATE
设计 DES ENGR			邓荣华	2015-04-22
校对 CHECK			[illegible]	2015-04-27
审核 VER			[illegible]	2015-04-27
会签 MFGENGR				
标准审查 STD ENGR			[illegible]	2015-04-27
审批 APP			[illegible]	2015-04-28

主油泵
MAIN OIL PUMP

(WDA)D300AL-511000A

版本号 REV	重量 WT	比例 SCALE
R00	921.6	1:2

共 1 张 第 1 张
SHEET 1 OF 1

东方汽轮机有限公司
DONGFANG TURBINE Co.,Ltd.

版本：R16