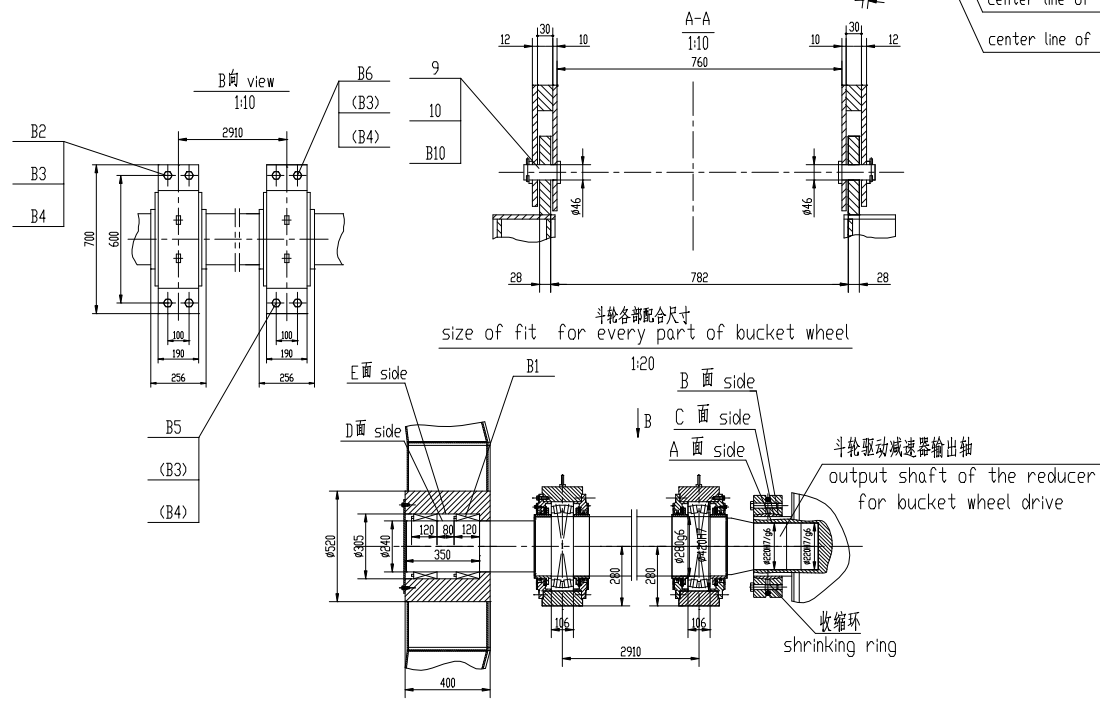
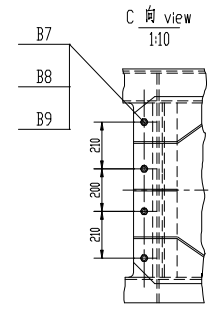


Technical Requirements

- During installation, the bearing should be coated with grease even, and the grease amount is 1/3 inner cavity of the bearing.
- Bucket wheel drive 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 reducer 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 expand sleeve telescopes wheel shaft output, the surface (B,C 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.
- The clearance between item 4 ring chute and the inner side of bucket wheel body is 5~10mm, this clearance will be adjusted according to the ring chute (item 4)
- 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 of (D side, E side), Before shrinking ring of the expand 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

技术要求

- 装配时轴承应均匀地涂上黄油, 涂油量为轴承内腔的 1/3.
- 减速器用胀紧套与斗轮轴联接, 在减速器输出轴套在斗轮轴上之前, 必须仔细地用酒精或丙酮清洗轴的外径及减速器输出轴内孔, 并确保连接面(A面)上无任何润滑剂或其它杂物, 胀套的收缩环套到减速器输出轴前, 必须清洗该表面(B,C面). 胀套就位后立即用手拧紧4-5个等间距的螺栓, 拧紧时要保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, 拧紧时要保证两个法兰盘相互平行, 随后达到每个螺栓的拧紧力矩值, 力矩值见减速器说明书.
- 作4圆弧挡板与轮体内侧间隙 5~10mm, 该间隙参照件4圆弧挡板调整.
- 斗轮轮体用胀紧套与斗轮轴联接, 在安装轮体之前上之前, 必须仔细地用酒精或丙酮清洗轴的外径及轮轴内孔, 并确保连接面(D面, E面)上无任何润滑剂或其它杂物, 胀套就位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值355N·m.



斗轮	直径 D diameter D	Φ6300mm
转速 n rotational speed	6.65r/min	
斗容 bucket capacity volume	0.51m ³	
斗数 number of the bucket	9	
电动机 Electrical Motor	功率 power	90kW
减速器 Fluid motor	转速 rotational speed	1480 r/min
	型号 type	ZHP5.33K
额定输出转矩 rated torque	114993Nm	
	输出转速 rotational speed	6.65r/min

序号 No.	代号 Standard	名称 Denomination	数量 Qty	材料 Material	重量 Kg	总重 Kg	备注 Remark
B10	GB91-86	开口销 split Pin #8x63	18	Q235-A	0.024	0.43	
B9	GB93-87	垫圈 20 Washer	36	65Mn	0.015	0.54	
B8	GB41-86	螺母 M20 Nut	36	5	0.061	2.20	
B7	GB5780-86	螺栓 M20x45 Bolt	36	4.8	0.14	5.04	
B6	GB5782-86	螺栓 M36x150 Bolt	2	8.8	1.64	3.29	
B5	GB5782-86	螺栓 M36x160 Bolt	2	8.8	1.75	3.51	
B4	GB93-87	垫圈 36 Washer	8	65Mn	0.085	0.68	
B3	GB6170-86	螺母 M36 Nut	8	10	0.42	3.36	
B2	GB5782-86	螺栓 M36x140 Bolt	4	8.8	1.53	6.14	
B1	GB5867-86	胀套 Expand Sleeve 75-240x305	2		21.40	42.80	
10	D03151-2	挡圈 check ring	18	Q235-A			
9	D03151-1	销轴 Pin roll	18	35			
8	D05913.1.2ST	连接装置 Bucket Wheel Drive levce	1	装配件 Assembly			
7	D05911.4ST	轴承组件 Bearing assembly I	1	装配件 Assembly			
6	D059131-1	斗轮轴 Bucket Wheel Shaft	1	45			
5	D0801.15ST	轴承组件 Bearing assembly	1	装配件 Assembly			
4	D05913.11ST	圆弧挡板 Ring Chute	1	装配件 Assembly			
3	D00903.11ST	斗轮驱动装置 Bucket Wheel Chute	1	装配件 Assembly			
2	D0595.11ST	轮体 wheel	1	焊接件 Structure			
1	D05911.1	斗子 bucket	9	装配件 Assembly			

PROJECT: BALCO EXPANSION PROJECT-1200MW THERMAL POWER PLANT 印度 BALCO 扩建 1200MW 燃煤电站项目		型号 Type D01500/1500.35 悬臂式斗轮堆取料机	
OWNER: BHARAT ALUMINIUM COMPANY LTD, KORBA, INDIA 印度铝业有限公司		D01500/1500.35 斗轮堆取料机	
CONSULTANTS: DEVELOPMENT CONSULTANTS PVT.LTD, MUMBAI 发展咨询有限公司		D01500/1500.35 Bucket-wheel Stacker/Reclaimer	
CONTRACTOR: SEPCO ELECTRIC POWER CONSTRUCTION CORP. PRC 山东电力基本建设总公司		PROJECT CONTROL No. 00 EAF 41(42) AF 0011	
REV.	DATE	DESCRIPTION	CHECK REVIEW APPROVAL
批准 Approval	审核 Check	名称 Title	斗轮机机构
审定 Review	设计 Designer	图号 DWG No	D05913.1ST
日期 Date	会签 Consignature	比例 Scale	1:25