IN_MARUTI_N17.30.04-1111P1SCE

27

26

15

E

C

B

D

A

14

13

10

11

8

9

3

2

1

16

详图B
DETAIL B

剖视E-E
SECTION E-E

剖视C-C
SECTION C-C

剖视B-B
SECTION B-B

详图A
DETAIL A

剖视D-D
SECTION D-D

剖视F-F
SECTION F-F

剖视G-G
SECTION G-G

φ730 JM 0.13 GAP 间隙

φ517.34 CONTACT DIAMETER 密封面直径

φ459 diameter of valve seat neck 阀座颈部直径

φ430 JM 0.26 GAP 间隙

φ755 NECK
diameter of valve seat neck
阀座颈部直径

密封面直径
CONTACT DIAMETER φ373

φ430 H7/r6 SM 0.166 SH 0.063 SHRINK 过盈

φ410 SM 0.063 JM 0.04 SHRINK 过盈 GAP 间隙

130

100

F

见注2
SEE NOTE 2

直支撑
STRAIGHT LEG

220

JM 0.19 GAP 间隙

φ430 JM 0.26 GAP 间隙

见注2 a=3
SEE NOTE 2

100

G

φ30 H7/js SM 0.011 JM 0.019 SHRINK 过盈 GAP 间隙
TO COUNTERDRILLED AT ASSEMBLY 装配时同钻铰

110

装配时同钻铰
TO COUNTERDRILLED AT ASSEMBLY

φ30 H7/js SM 0.011 JM 0.019 SHRINK 过盈 GAP 间隙

110

2 IDENTICALS MACHINING
2 USINAGES IDENTIQUES
两处加工和配要求相同

CLEARANCE TO BE ADJUSTED WHEN FITTING
装配时调整间隙

φ430 H7/r6 SM 0.166 SH 0.063 SHRINK 过盈
TO COUNTERDRILLED AT ASSEMBLY 装配时同钻铰

零件序号 REPERES ITEM	拧紧力矩 TIGHTENING TORQUE (10N.M)
9	17 DAN.M
3	32 DAN.M
13	100 DAN.M
7	22 DAN.M

NOTE 1: JM-MAX CLEARANCE, Jm-MIN CLEARANCE
SM-MAX FIT, Sm-MIN FIT
注1：JM代表最大间隙 Jm代表最小间隙
SM代表最大过盈 Sm代表最小过盈

NOTE 2: WELDS CLASS C ACCEPTANCE CRITERIA 3
(BA Q 20252)
注2：焊缝验收等级3,(BA Q 20252)

No.	Drawing No.	Text	Qt.	Material	Single Weight	Total Weight	Remark
34	N17.30.04.730(1)	木塞 stopper	4	木料 tree			
33	N17.30.04.721(1)	木塞 stopper	2	木料 tree			
32	N17.30.04.710(1)	木塞 stopper	2	木料 tree			
31	N17.30.04.501(1)	双锥垫圈 bipyramid washer 33	2	15CrMoA-5	0.027	0.054	
				B57N-J			
30	N17.30.04.491(1)	螺塞 screw plug M33	2	25Cr2Mo1VA-5	0.695	1.39	
				B60N-J			
29	N17.30.04.480	双锥垫圈 bipyramid washer 30	4	15CrMoA-5	0.025	0.1	
				B57N-J			
28	N17.30.04.477(1)	螺塞 screw plug M30	4	25Cr2Mo1VA-5	0.45	1.8	
				B60N-J			
27	N17.30.04.105-1	接管座口准备 joint groove defence Φ530	(2)		21	42	
26	N17.30.04.110-1	joint groove defence Φ560	(2)		22	44	
25	N17.30.04.103-1	主汽门调节阀杆组合件 main stop valve control stem stop units	(4)		75.7	303	
24	N17.30.04.62-1(1)	调节阀阀杆阀盘装配图 control valve stem/disc setting drawings	(2)		137	274	
23	N17.30.04.51-1(1)	主汽门阀阀杆阀盘装配图 main stop valve stem/disc setting drawings	(2)		198.45	378.9	
9A	N17.30.04.36(1)	弹簧撑架 flex supporting frame(left)	1	ZG20Cr1Mo-1.7(GW)	205		
				B58J-V			
22	N17.30.04.45-1(1)	隔热屏装配图 heat shield setting drawings	(2)		6.4	12.8	
21	N17.30.04.44-1(1)	调节阀阀帽装配图 control valve bonnet setting drawings	(2)		382	764	
20	N17.30.04.43-1(1)	隔热屏装配图 heat shield setting drawings	(2)		14	28	
19	N17.30.04.41-1(1)	主汽门阀阀帽装配图 main stop valve bonnet setting drawings	(2)		255	510	
18	N17.30.04.33-1(1)	调节阀阀盖装配图 control valve cap setting drawing	(2)		975	1950	
17	N17.30.04.19-1(1)	主汽门阀阀盖装配图 main stop valve cap setting drawing	(2)		2469	4938	
16	N17.30.04.18(1)	止动片 locking plate	16	Q235A	0.212	3.38	
15	N17.30.04.17(1)	弹簧撑架 flex supporting frame(right)	1	E28-4	205		
				ZG20Cr1Mo-1.7(GW)			
				B58J-V			
14	N17.30.03.07(1)	销子 pin φ30	6	25Cr2Mo1VA-5	0.55	3.3	
				B15A-JJ5			
13	N17.30.01.68(1)	双头螺柱 stud M39x120	24	Xr39MoV3NbNB-5	1.48	35.52	
				08L-J			
12		止动片 locking plate 6x30x180	4	Q235A	0.254	1.02	
11	N17.30.01.65(1)	直支撑架 straight supporting frame	4	ZG20Cr1Mo-1.7(GW)	165	660	
				B58J-V			
10	B1195-2005	螺母 nut M39	24	25Cr2Mo1VA-5	0.415	9.96	
9	N17.30.01.10(1)	螺塞 screw plug M24	4	25Cr2Mo1VA-5	0.25	1	
				B60N-J			
8	N17.30.04.12(1)	双头垫圈 bipyramid washer 24	6	15CrMoA-5	0.01	0.04	
				B57N-J			
7	N17.30.04.11(1)	螺塞 screw plug M30	6	25Cr2Mo1VA-5	0.24	0.96	
				B60N-J			
6	N17.30.04.10(1)	垫圈 washer	6	1Cr13-2	0.01	0.04	
				C52R-J			
5	N17.30.04.09(1)	销子 PIN Φ20x176	6	25Cr2Mo1VA-5	0.18	0.72	
				B60N-J			
4	N17.30.04.08-1/2(1)	调节阀阀座粗加工图 control valve seat roughing drawings	2		(80)	(160)	
				B57N-S			
	N17.30.04.08-1/3(1)	调节阀阀座精加工图 control valve seat finishing drawings	(2)		40	80	
3	N17.30.04.07(1)	螺栓 bolt M27	40	25Cr2Mo1VA-5	0.45	18	
				B60N-J			
2	N17.30.04.06-1/2(1)	主汽门阀阀座粗加工图 main stop valve seat roughing drawings	2		(433)	(866)	
	N17.30.04.06-1/3(1)	主汽门阀阀座精加工图 main stop valve seat finishing drawings	(2)	B57N-S	440	880	
1	N17.30.04.02-1/3(1)	右阀阀体精加工图 right valve case finishing drawings	(1)		5760		
	N17.30.04.02-1/2(1)	右阀阀体焊接及粗加工 right valve case fitting welding and roughing	(1)		(7000)		CJAO
		阀体着色探伤图 valve case crack detection defecting drawing					
1A	N17.30.04.01-1/3(1)	左阀阀体精加工图 left valve case finishing drawings	(1)		5760		
	N17.30.04.01-1/2(1)	左阀阀体焊接及粗加工 left valve case fitting welding and roughing	(1)		(7000)		CJAO

DRAWING TITLE

PROJECT:- 1 x 300 MW COAL BASED THERMAL POWER PLANT
VILLAGE – BANDAKHAR, TEHSIL – PALI, DIST. – KORBA, C.G

OWNER:- M/s. MARUTI CLEAN COAL & POWER LTD.

OWNER'S CONSULTANT:- FICHTNER CONSULTING ENGINEERS (INDIA) PVT. LTD.

EPC CONTRACTOR:- IOT INFRASTRUCTURE & ENERGY SERVICES LTD.

BTG EP CONTRACTOR:- 华西能源工业股份有限公司 China Western Power Industrial Co., Ltd.

BTG DESIGN INSTITUTE:- NORTH CHINA POWER Engineering (Beijing) Co,Ltd

Beijing BEIZHONG Steam Turbine Generator Co.,LTD

Design	周7强	12-04-10	中?主汽?b右装配b
Check	李朝3	12-05-28	
Verify	李志?7	12-05-28	
Standard Exam	-建国	12-05-28	REHEAT STEAM VALVE, RIGHT ASSEMBLE DRAWING
Approve			

Reviser | Revision Date
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