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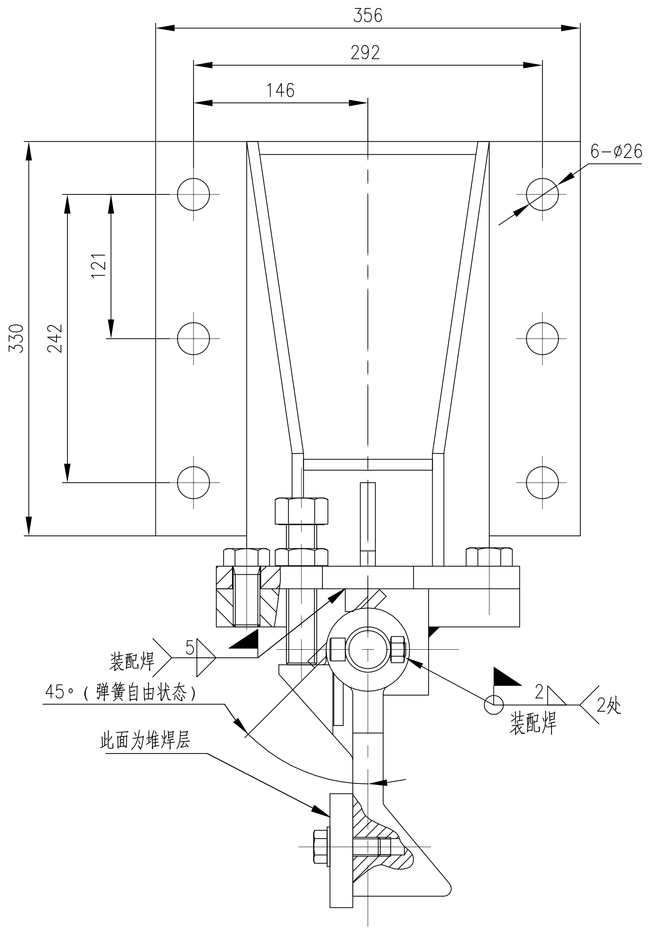

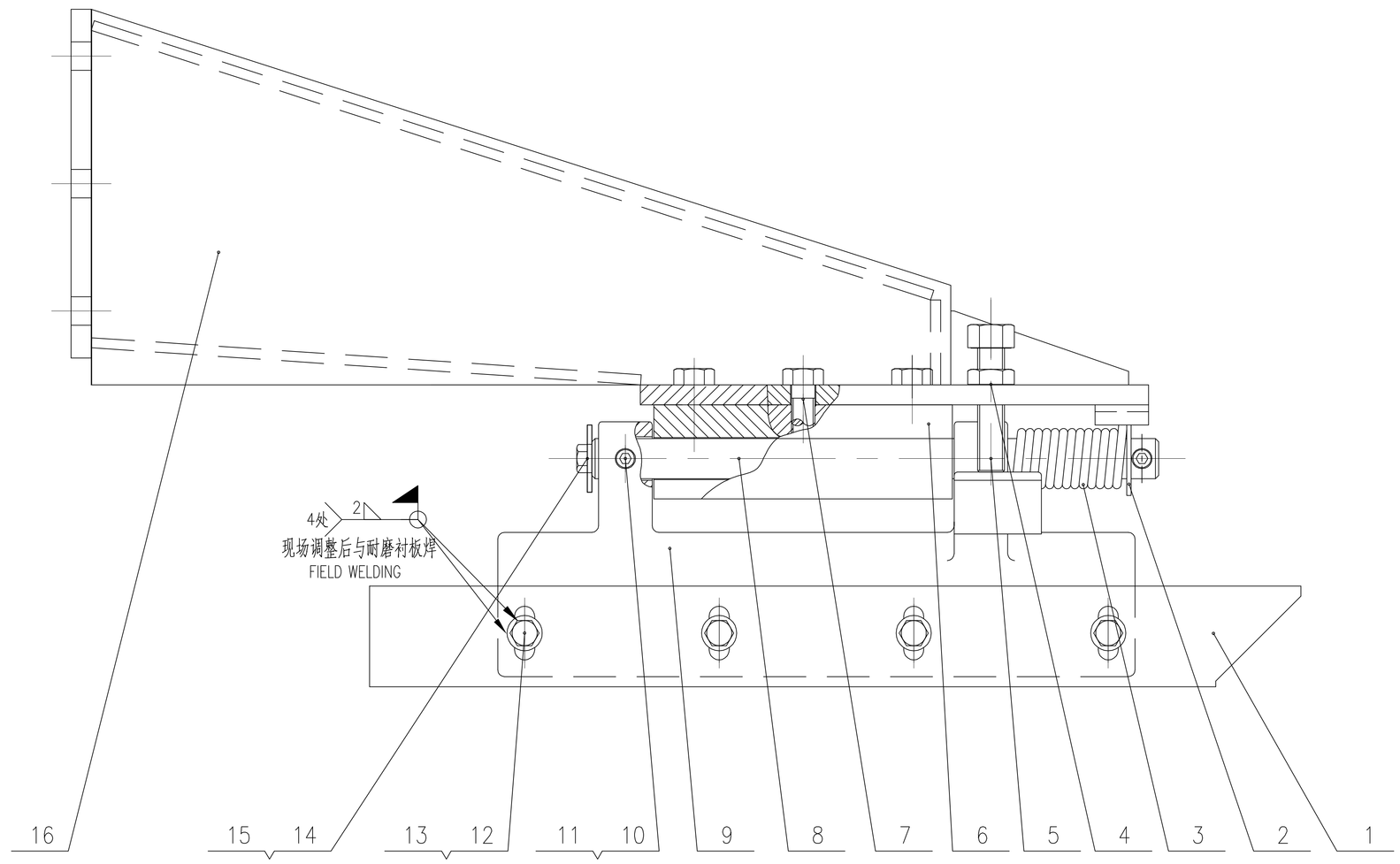

NOTE

1.THE SCRAPER AND THE VERTICAL DIRECTION HAVE 45 DEGREES ANGLES,WHEN INSTALLING THE TORSIONAL SPRING AND THE SCRAPER, ROTATES THE SCRAPER TO THE GRAPHICAL REPRESENTATION POSITION, THEN THE PRE-TIGHT BOLT, LIMITS THE SCRAPER IN THE VERTICAL POSITION, SCREWS TIGHT THE NUT SET BOLT, THE PRETIGHTENING UP FORCE MOMENT IS 271N.m;

2.BOLT TU Loctite 271 THREAD CEMENTING AGENTS, THE PRETIGHTENING UP FORCE MOMENT IS 465N·M;

3.THE BOLT SPREADS THE RELAXATION CEMENTING AGENT, AFTER ON-SITE ADJUSTMENT, THE PRETIGHTENING UP FORCE MOMENT IS 27N.m, AND WITH WEAR-RESISTING BACKING WELDING.

技术要求

1.安装扭簧（序号3）与刮板（序号9）时，刮板与垂直方向成45度夹角。
转动刮板到图示的垂直位置，然后顶紧螺栓（序号5）把刮板限制在竖直位置。
拧紧螺母（序号4)固定螺栓，预紧力矩271N·m。

2.螺栓（序号7）涂乐泰271螺纹粘结剂，预紧力矩465N·m。

3.现场调整后螺钉（序号12）涂防粘结剂，预紧力矩27N·m,并与耐磨衬板焊接。

16	K3868.6-4	刮板支架 SCRAPER BRACKET	1	ASSEMBLY	79.8	79.8	
15	GB 95-85	垫圈 16 16 WASHER	1	140HV	0.04	0.04	
14	GB 5783-86	螺栓 M16X20 BULL RING	1	8.8	0.05	0.05	
13	GB 97.1-85	垫圈 16 16 WASHER	4	140HV	0.011	0.044	
12	GB 70-85	螺钉 M16X50 M16X50 SCREW	4	8.8	0.11	0.44	
11	GB 70-85	螺钉 M12X80 M12X80 SCREW	2	8.8	0.081	0.162	
10	GB 6170-86	螺母 M12 M12 NUT	2	8	0.012	0.024	
9	K3868.6-6	刮板 SCRAPER	1	ZG35GrMn	32.2	32.2	
8	K3868.6-3	轴 SHAFT	1	45	4.8	4.8	
7	GB 5783-86	螺栓 M24X50 M24X50 SCREW	6	8.8	0.269	1.614	
6	K3868.6-2	刮板支撑架 SCRAPER BRACKET	1	ASSEMBLY	27.3	27.3	
5	GB/T 5783-2000	螺栓 M16x100 M16X100 SCREW	1	8.8	0.17	0.17	
4	GB 6170-86	螺母 M16 M16 NUT	1	8	0.029	0.029	
3	K3868.6-5	扭簧 SPRING	1	55CrMnA	0.8	0.8	
2	GB 95-85	垫圈 36 36 WASHER	1	100HV	0.079	0.079	
1	K3868.6-1	衬板 BULL RING	1	SA1750CR	12.5	12.5	

序号 ITEM NO.	代号 DRAWING NO.	名称 DESCRIPTION	数量 QUANTITY	材料 MATERIAL	单重 UNIT WEIGHT	总重 TOTAL WEIGHT	备注 REMARKS

FOR CONSTRUCTION

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REV.	DESCRIPTION	DATE	DESIGNED BY	CHECKED BY	REVIEWED BY	APPROVED BY
0	Issued for construction					

OWNER: POWER GENERATION CORPORATION 1
THERMAL POWER PROJECT MANAGEMENT BOARD 3

CONSULTANT: POWER ENGINEERING CONSULTING JOINT STOCK COMPANY 3

CONTRACTOR: THE CONSORTIUM OF CHENGDA-DEC-SWEPDI-ZEPC

SUBCONTRACTOR: SHANGHAI HEAVY MACHINERY PLANT CO.,LTD.
上海重型机器厂有限公司

PROJECT : DUYEN HAI 3 THERMAL POWER PLANT PROJECT

CONTRACT NO: DH3-05082011

DRAWING NAME: 刮板装置
SCRAPER ASSEMBLY

Total: 共 1 张

No.: 第 1 张

PROJECT CONTROL NO: DH3-31(32)HFC-M-PSZ-0024

Scale: 1:1

DRAWING NO: K6345.6.0 REV: 0 SAP: E020410111000000 REV: 0