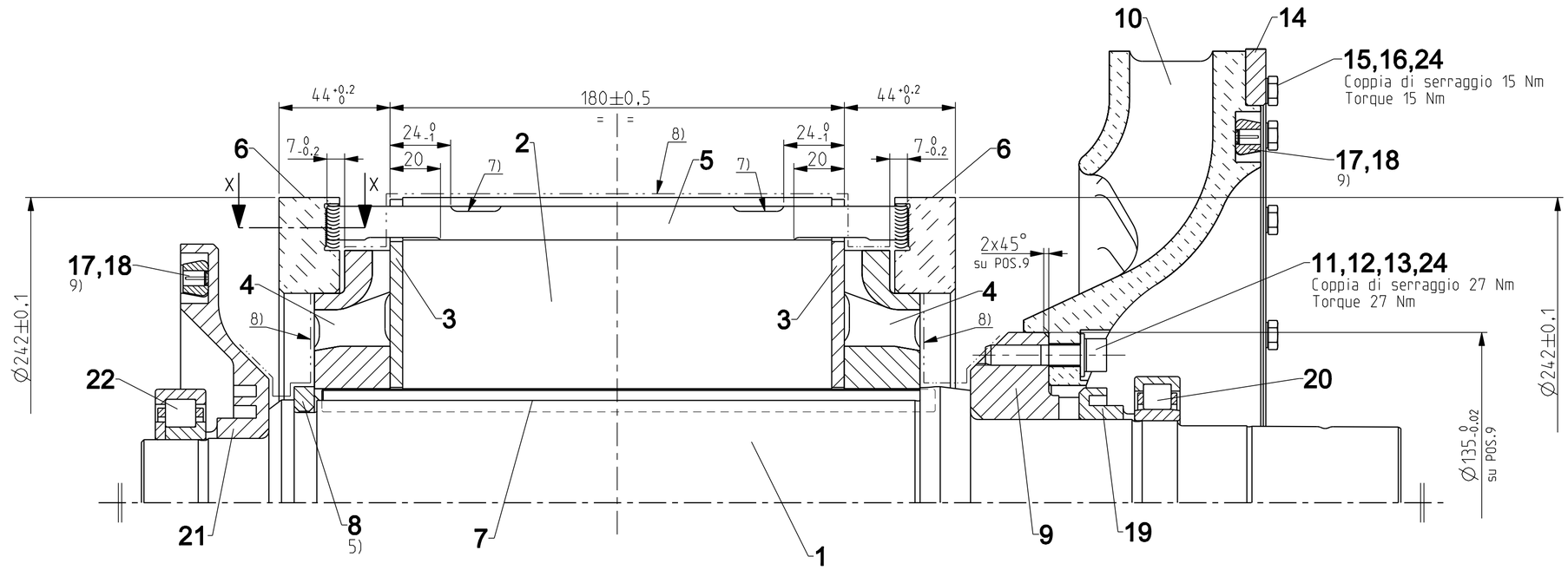
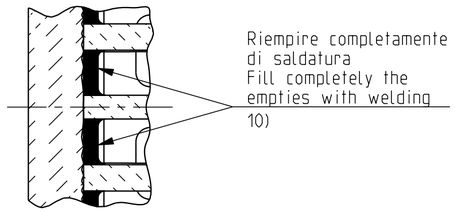
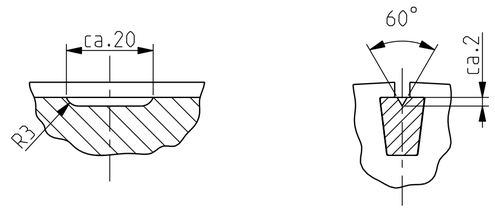




SEZIONE X-X



PARTICOLARE CIANFRINATURA BARRE
BARS CAULKING DETAIL

NOTE :

1) Forza di pressatura in preformatura del pacco 35t, forza di pressatura finale 20t
2) Temperatura di calettamento del pacco e del sostegno ventola 150°C
3) Temperatura di calettamento bussola POS.21 120°C
4) Temperatura di calettamento piste cuscinetto 110°C
5) Unire i due semianelli POS.8 con saldatura tipo V̂ 3-8E D3, secondo AQU-10-006
6) Le barre devono essere montate leggermente forzate sull'altezza delle cave
7) Eseguire 2 cianfrinature per barra prima della tornitura come indicato in figura
8) Verniciare dove indicato — · · — · · — · · — · · — con POS.25
9) Bilanciare dinamicamente il rotore usando le POSS.17 e 18 cos ì da ottenere uno squilibrio massimo di 1g
10) Saldobrasatura a forte secondo QUA-10-119

NOTES :

1) Pressing force on rotor pack preforming 35 tons, final pressing force 20 tons
2) Rotor package and fan support shrinking temperature 150°C
3) Bush POS.21 shrinking temperature 120°
4) Bearing inner ring shrinking temperature 110°
5) Join the two half-ring POS.8 with welding type V̂ 3-7E D3, according to AQU-10-006
6) Bars must be assembled in the slot with a soft shrinking in height
7) Caulk the bars before turning as indicated in the figure
8) Varnish with POS.25 the surfaces indicated with — · · — · · — · · — · · —
9) Balance dimamically the rotor using the POSS.17 and 18 as so to obtain a maximum unbalance of 1g
10) Brazing according to QUA-10-119

Geometrical Tolerances ISO 2768 - mK ISO 13920 - B				
Mass 95,000 kg DC	Department CPN/MOT	Revision Description		
Material				
1:1.5	Created	12/04/2011	Maiello	ROTORE FINITO E BILANCIATO ROTOR ASSEMBLY
	Checked	26/04/2011	Maiello	
	Approved	26/04/2011	Beneduce	
		Date	Name	
AnsaldoBreda		it/en	mm	
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