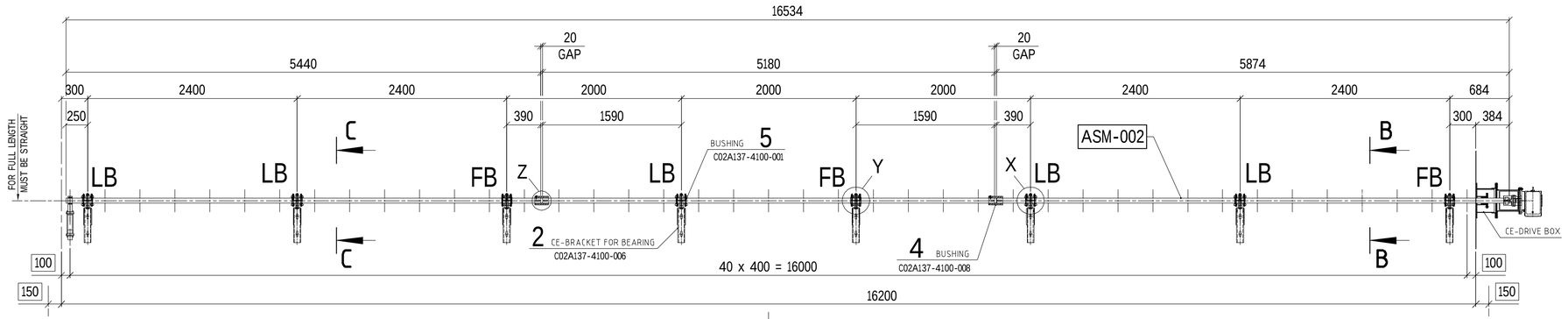
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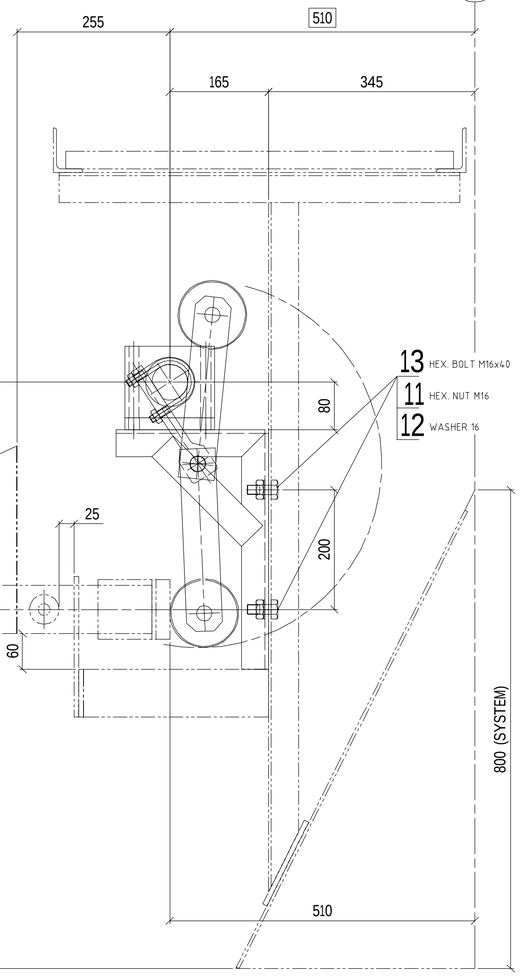
A-A
M 1:30



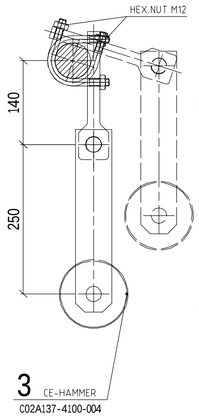
E3 E3 | E2 E4 | E1 E5

EE ED EB EA

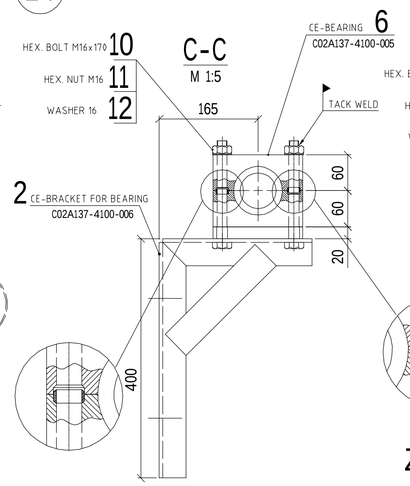
E
M 1:5



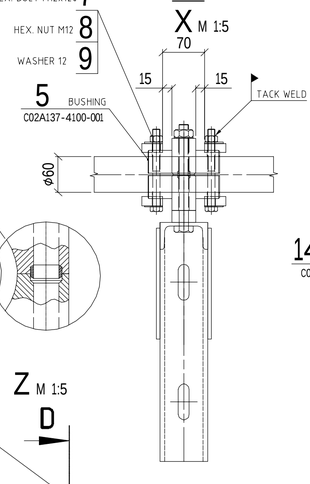
B-B
M 1:5



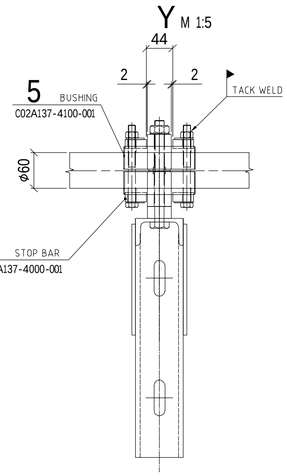
C-C
M 1:5



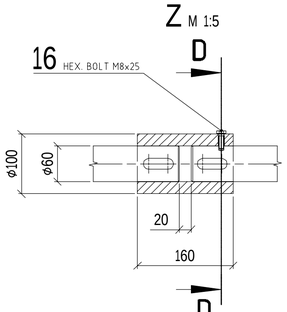
LOOSE BEARING LB
X M 1:5



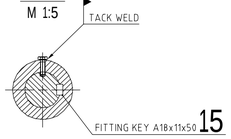
FIXED BEARING FB
Y M 1:5



Z M 1:5

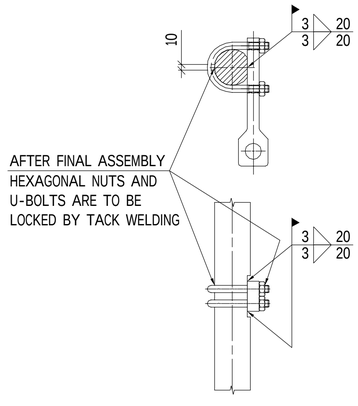


D-D
M 1:5

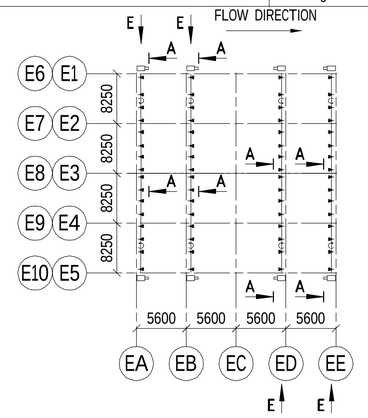


ALL BOLT CONNECTIONS ARE TO BE LOCKED BY TACK WELDING AFTER ADJUSTMENTS/ALIGNMENTS

ATTENTION ERECTION



BILL OF MATERIAL	TOTAL WEIGHT FOR ONE BOILER =				881.93x8=7055.44 Kg	
Sl NO	DESCRIPTION	MAT'L SPEC	UNIT WEIGHT	QTY	TOTAL WEIGHT	REMARKS
	ASM-002	JIS S45C	366.09	1	366.09	C02A137-4140-002
2	CE-bracket for bearing	JIS SS400	5.66	8	45.28	C02A137-4100-006
3	CE-Hammer	JIS SS400	9.5	41	389.5	C02A137-4100-004
4	Bushing	JIS S20C	6.17	2	12.34	C02A137-4100-008
5	Bushing	JIS S45C	1.96	8	15.68	C02A137-4100-001
6	CE-Bearing	JIS S45C	4.45	8	35.6	C02A137-4100-005
7	Hex.Bolt M12X120	JIS B1180 (4.6)	0.14	16	2.24	
8	Hex.Nut M12	JIS B1181 (5)	0.02	16	0.32	
9	Washer 12	JIS B1256	0.01	16	0.16	
10	Hex.Bolt M16X170	JIS B1180 (4.6)	0.33	16	5.28	
11	Hex.Nut M16	JIS B1181 (5)	0.33	32	0.96	
12	Washer 16	JIS B1256	0.0113	32	0.3616	
13	Hex.Bolt M16X40	JIS B1180 (4.6)	0.12	16	1.92	
14	Stop bar	JIS SS400	0.093	32	2.976	C02A137-4000-001
15	Fitting Key A18x11x50	JIS S45C	0.02	5	0.1	
16	Hex.Bolt M8X25	JIS B1180 (4.6)	0.02	2	0.04	
TOTAL WEIGHT = 881.93 Kg						



Daelim Industrial Co., Ltd.	
job No.	110180
	A – APPROVED
	B – APPROVED WITH COMMENTS
	C – RETURNED FOR CORRECTION
	D – REJECTED
	N – NOT APPLICABLE (REFERENCE ONLY)
SIGNED BY :	DATE :

DIC'S PERMISSION TO PROCEED OR REVIEW TAKEN ON VENDOR PRINTS SHALL NOT RELIEVE VENDOR FROM ITS RESPONSIBILITIES OR LIABILITIES UNDER THE PURCHASE ORDER.

DOCUMENT SUBMISSION STATUS : FF

NOTE:
1. ALL DIMENSIONS SHOWN ARE IN MILLIMETERS(mm)
2. REFERENCE TO DRAWING NO: TB2-SDC.VP126-00HDE-M-M9-DRD-4140-01
3. Erector Notes
   - After final adjustments are completed, hex nits are to be tack welded.
   - After adjustments are completed, U-bolts have to be tack welded to Hammer Arm & Shaft.
   - After installation, all rapper hammers to be checked for freedom of movement.

REV	DATE	DESCRIPTION	PREP	CHKD	APRD	APRD
2	16.Aug.2016	REVISED AS MARK	S.M LEE	S.M CHO	B.I KIM	K.H YI
1	30.Jun.2015	REVISED AS COMMENT	S.M LEE	S.M CHO	B.I KIM	K.H YI
0	23.Jun.2014	FOR FINAL	H.B CHOI	S.M CHO	B.I KIM	K.H YI

DIMENSIONS HAVE TO BE CHECKED
DIMENSIONS NOT VALID FOR MACHINING
SURFACE QUALITY ACC. DIN EN ISO 1302
DIMENSIONS WITHOUT TOLERANCES ACC. TO TABLE GENERAL TOLERANCES

t..	3	4	5	6	7	8
a	2	3	3	4	4	5
t.	3	4	5	6	7	8
b	4	5	6	8	9	10

Stiffener: t2, a, nx60-150, t1
Flange connection: b, t1, t2

General tolerances:
Welded plate constructions: DIN EN ISO 13920 - class B / E
Prefabricated steel components: DIN 18203-2
Mechanically worked parts: DIN ISO 2768 - class m / K
Connecting flanges: Hole axis and distance ±1.0 mm
Welding quality according to QA- and QI-Plan related to order

WELDING DETAILS:
GENERAL: Welding coordination acc. to AWS A03.0
Quality requirements for weldings : AWS B02.1
Welding joint preparation acc. to AWS A02.4
Welding joint preparation for site welds must be implemented in the workshop!
All screw and weld connections in contact with flue gas must be welded gas-tight.
All fillet welds a = 3mm, if not otherwise indicated.
Welding information: Symbolic representation
Site weld
Shop weld

Sheet metal connections:

t	3	4	5	6	7	8
a	2	3	3	4	4	5

t ≤ 4
To put sheets together cross joint are inadmissible!
Sheets have to be arranged in an offset pattern

OWNER: VIETNAM OIL AND GAS GROUP (PVN)
OWNER'S CONSULTANT: FICHTNER; PV POWER PCC
EPC CONTRACTOR: PETROVIETNAM CONSTRUCTION JOINT STOCK CORPORATION (PVC)
EPC CONSTRACTOR'S CONSULTANT: WORLEYPARSONS
POWER ISLAND PACKAGE SUPPLIER: SOJITZ CORPORATION
DAELIM INDUSTRIAL CO., LTD.

PROJECT TITLE: THAI BINH2 THERMAL POWER PLANT 2 x 600MW

DRAWING TITLE: CE-RAPPING for ESP, Sheet 2/2

VENDOR NAME: **Hamon Korea Co., Ltd.**
Hamon Plaza, 33-2, 20Gil, Banpodaero
Seocho-Gu, Seoul, Korea
Tel: +82-70-4367-2483
Fax: +82-2-3473-5378

FUNCTION	NAME	SIGN	DATE
DRWN	S.M LEE	서상민	16.Aug.2016
CHKD	S.M CHO	조상목	16.Aug.2016
APPD	B.I KIM		16.Aug.2016
APPD	K.H YI		16.Aug.2016

DRAWING NO. TB2-SDC.VP126-00HDE-M-M9-DRD-4140-02
JOB NO. 110180
SCALE 1/30
REV.NO. 2

FILE NAME : C02A137-4140-000-A-02-S02

A1 (594mm x 842mm)