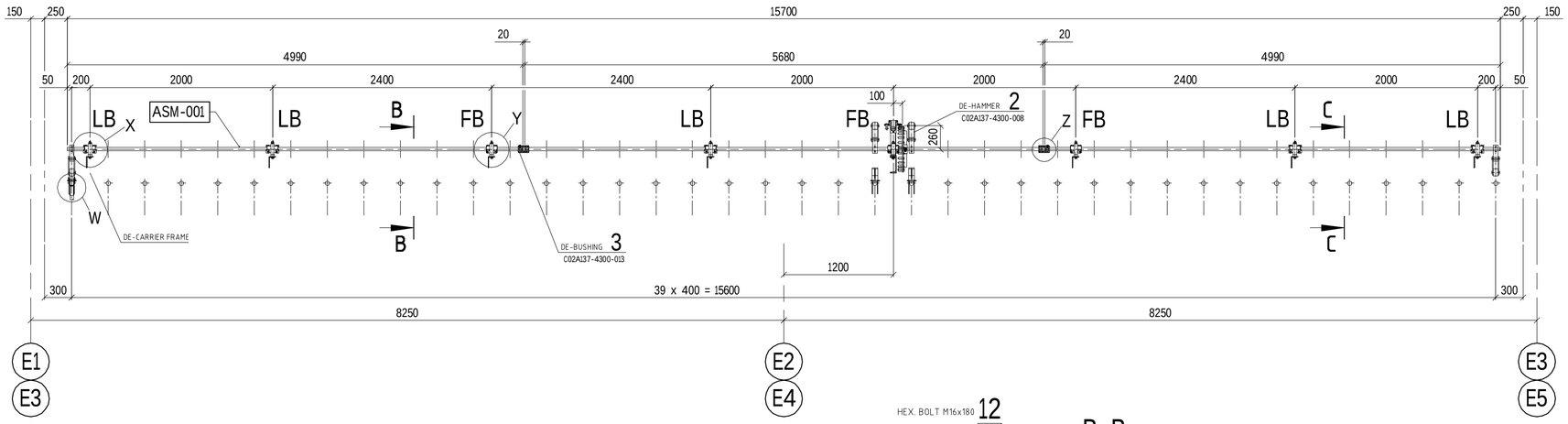
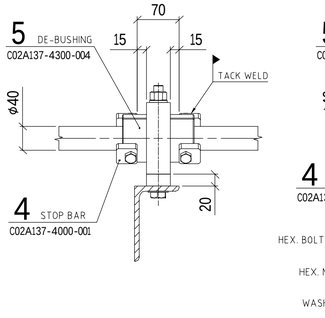
C02A137-4375-000-A-02-S01

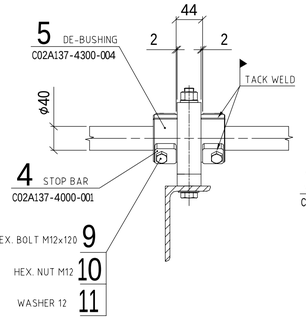
M 1:25



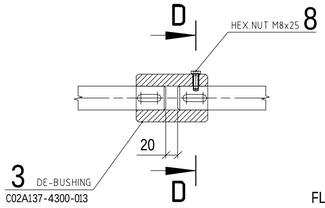
LOOSE BEARING
LB
X M 1:5



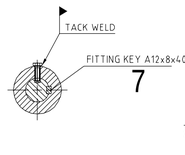
FIXED BEARING
FB
Y M 1:5



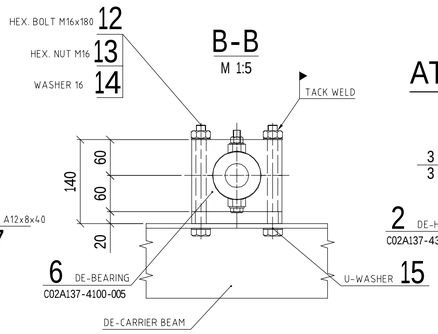
Z M 1:5



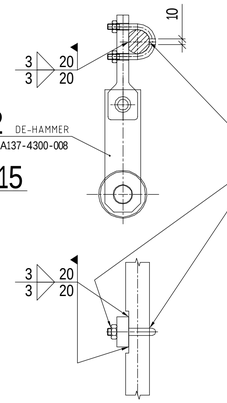
D-D
M 1:5



B-B
M 1:5

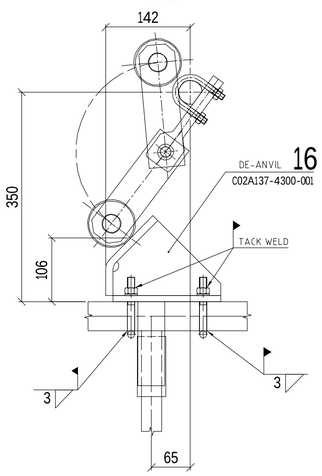


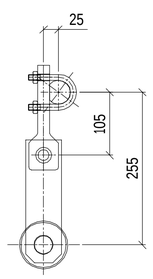
ATTENTION ERECTION



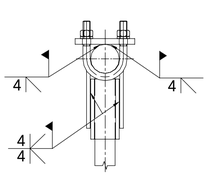
AFTER FINAL ASSEMBLY
HEXAGONAL NUTS AND
U-BOLTS ARE TO BE
SECURED BY TACK WELDING

C-C
M 1:5

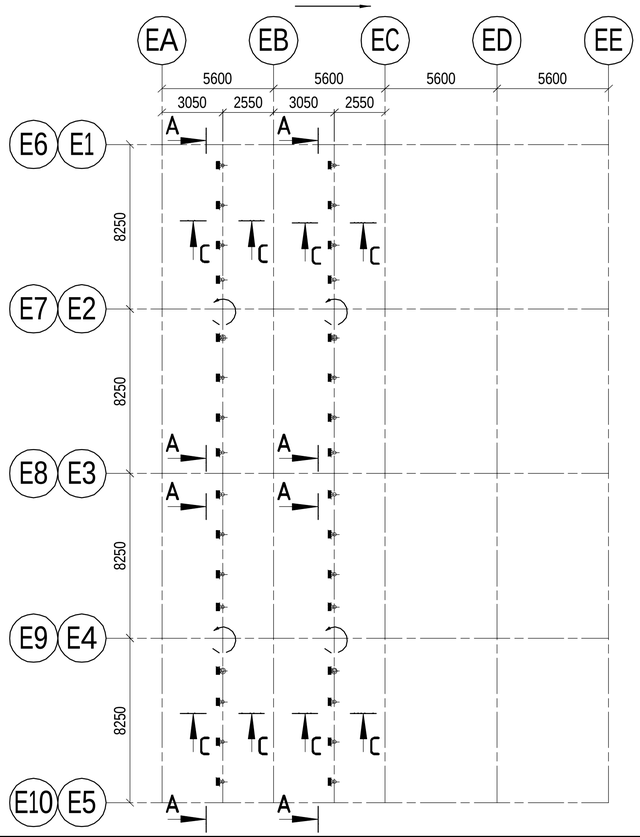




W M 1:5



FLOW DIRECTION



	BILL OF MATERIAL		TOTAL WEIGHT FOR ONE BOILER =	687.81x8 = 5502.48			
Sl No	DESCRIPTION		MATL.SPEC.	UNIT WEIGHT	Q'TY	TOTAL WEIGHT	REMARKS
1	ASM 002			154.47	1	154.47	C02A137-4375-001
2	DE Hammer			5.97	40	238.8	
	PLATE	50x50x175					C02A137-4300-008
	FLAT BAR	60x10x205					
	ROUND BAR	ø85x46					
	ROUND BAR	ø25x72					
	ROUND BAR	ø10x190					
	HEX.NUT	M10					
	PLATE	50x50x2					
3	DE Bushing			3.55	2	7.1	C02A137-4300-013
4	STOP BAR			0.093	32	2.976	C02A137-4000-001
5	DE Bushing			6.8	8	54.4	C02A137-4300-004
6	BEARING			4.836	8	38.6	C02A137-4100-005
7	FITTING KEY	A12x8x40	JIS S45C	0.03	4	0.12	
8	Hex.Bolt	M8x25	JIS B1180(4.6)	0.03	2	0.06	
9	Hex.Bolt	M12x120	JIS B1180(4.6)	0.12	16	1.92	
10	Hex.Nut	M12	JIS B1181(5)	0.02	16	0.32	
11	WASHER	12	JIS B1256	0.01	16	0.16	
12	Hex.Bolt	M16x180	JIS B1180(4.6)	0.31	16	4.96	
13	Hex.Nut	M16	JIS B1181(5)	0.03	16	0.48	
14	WASHER	16	JIS B1256	0.01	16	0.16	
15	U-Washer	17.5	JIS B1256	0.03	16	0.48	
16	DE Anvil			4.57	40	182.8	C02A137-4300-001
				TOTAL WEIGHT =		687.81Kg	

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-4375-02
3. Eractor Notes
   – After final adjustments are completed, hex nuts 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

ALL BOLT CONNECTIONS ARE TO BE SECURED BY TACK WELDING AFTER ADJUSTMENTS/ALIGNMENT

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_m	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: nx60-150 / nx60-150 / nx60-150 / nx60-150

Stiffener: nx60-150 / nx60-150

Flange connection: nx60-150

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

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 CONTRACTOR'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	DE-RAPPING for ESP, Sheet 1/2

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	이상민	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-4375-01
JOB NO. 110180
SCALE 1/25
REV.NO. 2
FILE NAME : C02A137-4375-000-A-02-S01

A1 (594mm x 841mm)