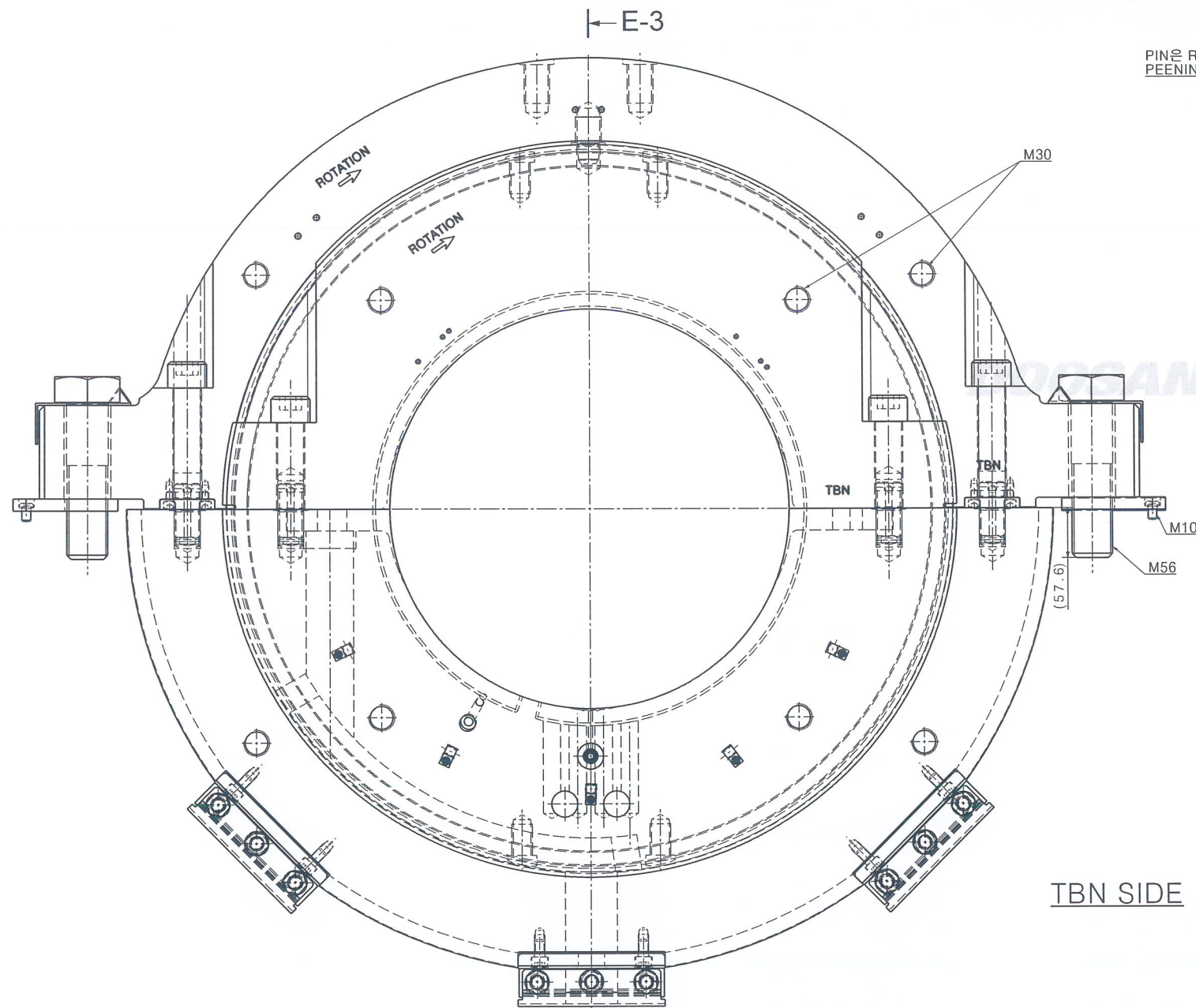
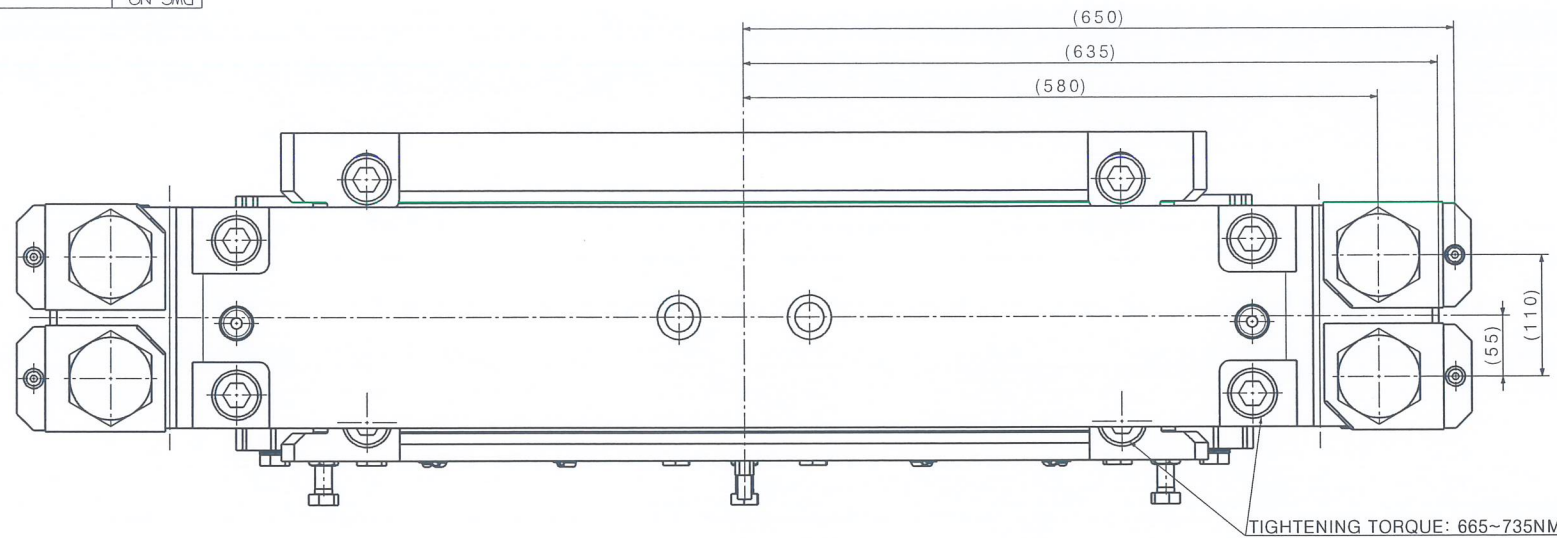


9\*02046

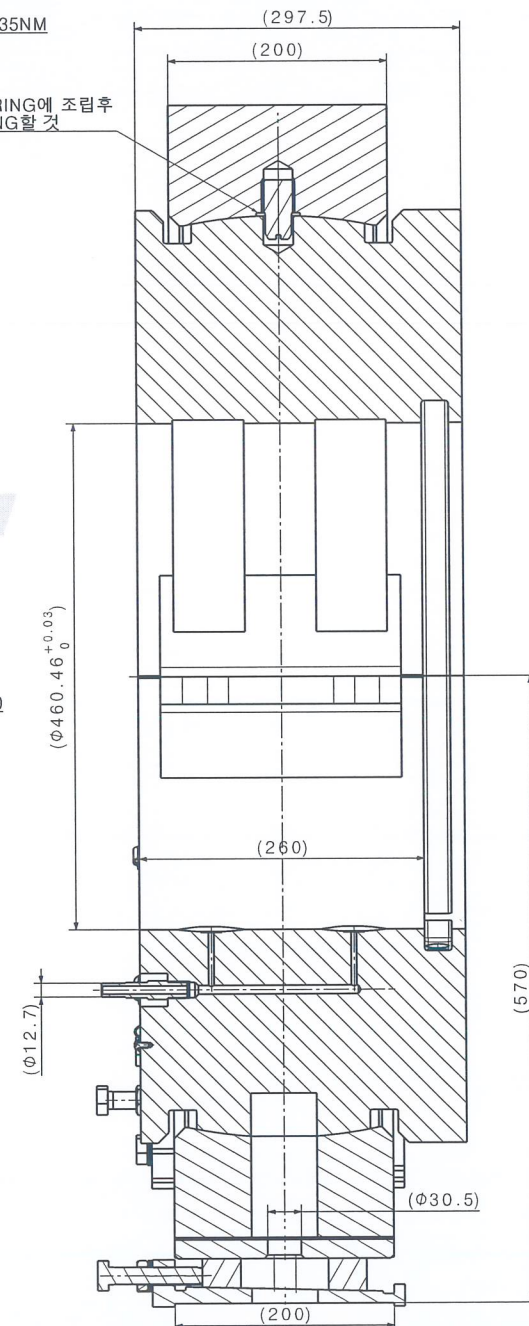
DWG NO.

(525)

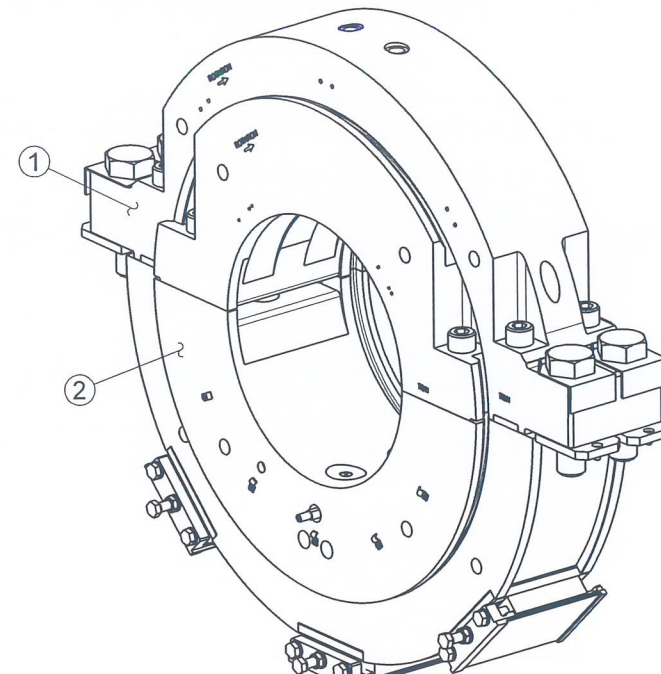
표면처리기 SURFACE FINISHES	적용 규정 APPLY PRACTICES	가공도면상 GENERAL TOLERANCES (IN MILLIMETERS) DIMENSIONS	선형치수 LINER DIMENSIONS		각도 ANGLE		편직도 STRAIGHTNESS		NO.	DESCRIPTION	MATERIAL	SIZE, DWG. NO.	Q'TY	WT. (kg)		REMARK
			기준치수 (mm) DIMENSION RANGE (D.R.)	허용공차 (mm) TOLERANCE	기준치수 (mm) DIMENSION RANGE (D.R.)	허용공차 (mm) TOLERANCE	기준치수 (mm) DIMENSION RANGE (D.R.)	허용공차 (mm) TOLERANCE						UNIT	TOTAL	
6.3	ISO2768-mK		0 < D.R. ≤ 125	±0.2	0 < D.R. ≤ 10	±1°	0 < D.R. ≤ 300	±0.4	1	BEARING RING ASSY		TD0062047	1	559		
			125 < D.R. ≤ 400	±0.3	10 < D.R. ≤ 50	±0° 30'	300 < D.R. ≤ 1000	±0.6	2	BEARING CASING ASSY		TD0062048	1	819		
			400 < D.R.	±0.5	50 < D.R.	±0° 20'	1000 < D.R. ≤ 3000	±0.8								



TBN SIDE

PIN은 RING에 조립후  
PEENING할 것

SECTION E-3



ISO VIEW

제작용

## NOTES

- 베어링 제작과 시험은 PDM002에 따라 수행할 것
  - 명시하지 않은 STAMPING은 TD0060731을 따를 것
  - 조립시, TORQUE TABLE TD0060700에 따라 작업할 것
  - CTQ(CRITICAL TO QUALITY)는 TD0060732를 따를 것
  - BABBITT 소재는 ASTM B23 GR.2사용할 것
  - BEARING과 PEDESTAL간의 접촉면적은 80%이상이며 오일 공급부와 배유부에서는 100%접촉되어야 함. (SITE SCOPE)
  - BALL 토크 시험은 타원형 베어링이며 TD0060733 TYPE B를 따를 것 (두산 SCOPE)
- FOLLOW PDM002 FOR BEARING MANUFACTURE AND TEST
  - FOLLOW TD0060731 FOR NOT COMMENTED STAMPING
  - FOLLOW BEARING TORQUE TABLE PER TD0060700
  - FOLLOW CTQ(CRITICAL TO QUALITY) PER TD0060732
  - BABBITT MATERIAL IS ASTM B23 GR.2
  - CONTACT AREA BETWEEN BEARING AND PEDESTAL IS MIN. 80% AND 100% AT OIL FEED AND DRAIN HOLE(SITE SCOPE)
  - FOLLOW TD0060733 TYPE B AS BALL TORQUE TEST FOR ELLIPTICAL BEARING (DOOSAN SCOPE)

REV	NAME	DATE	NAME	DATE	NAME	DATE
(25)	(25)	(25)	(25)	(25)	(25)	(25)
PREPARED BY	(25)	REVIEWED BY	(25)	APPROVED BY	(25)	

PROJECT

DOOSAN Enerbility

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PROJ	UNIT	SCALE	ITEM NO.	TITLE	DWG NO	REV	SHEET
(25)	(25)	(25)	(25)	(25)	(25)	(25)	(25)
				T7 BEARING ASSY (460X260)	TD0062046	A	1/1

신규작성

DESCRIPTION OF REVISION (개입사유)

REF. DWG NO. (도면번호) : REV. NO. : XX

CONT. NO. (도면번호)