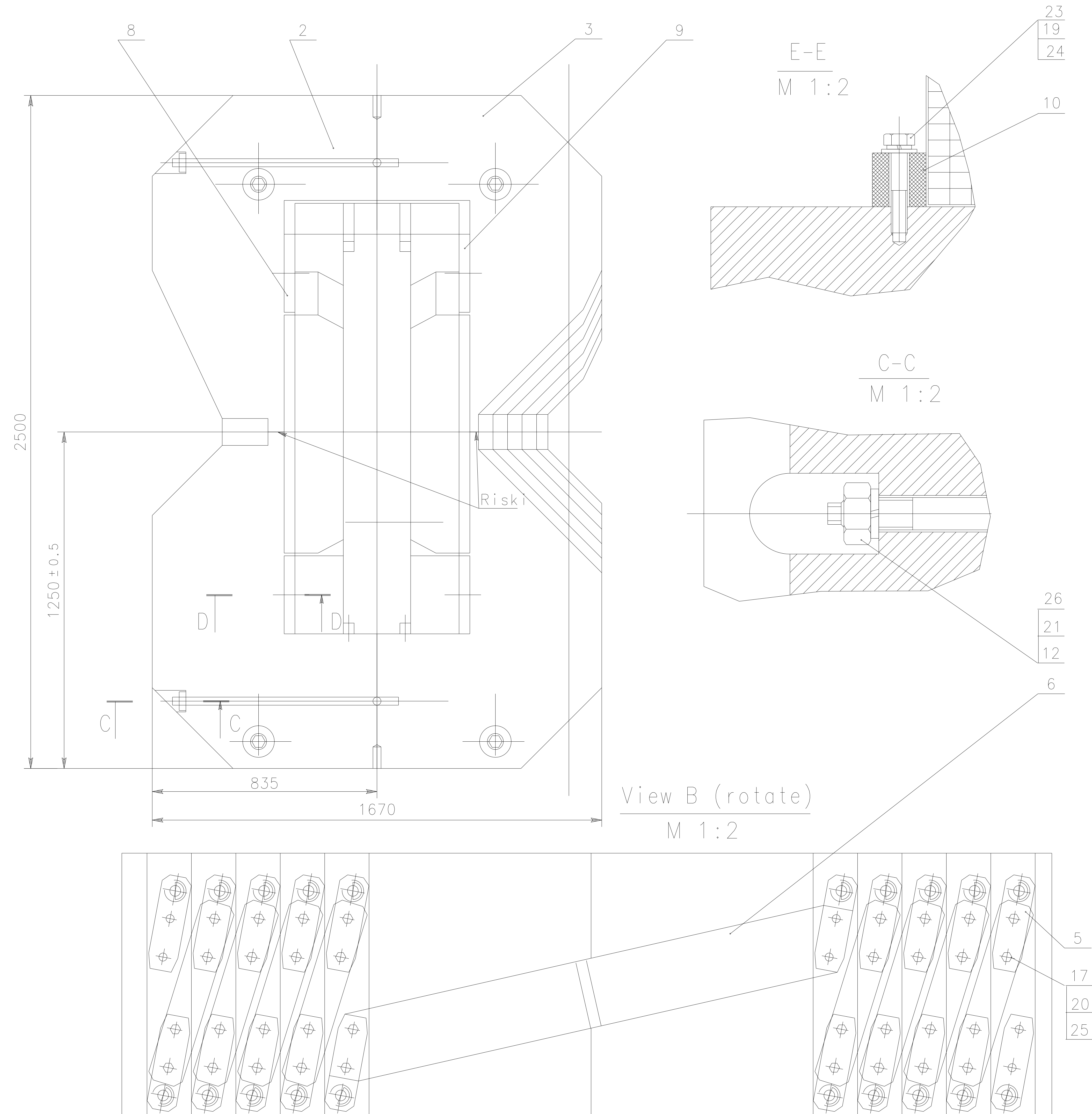
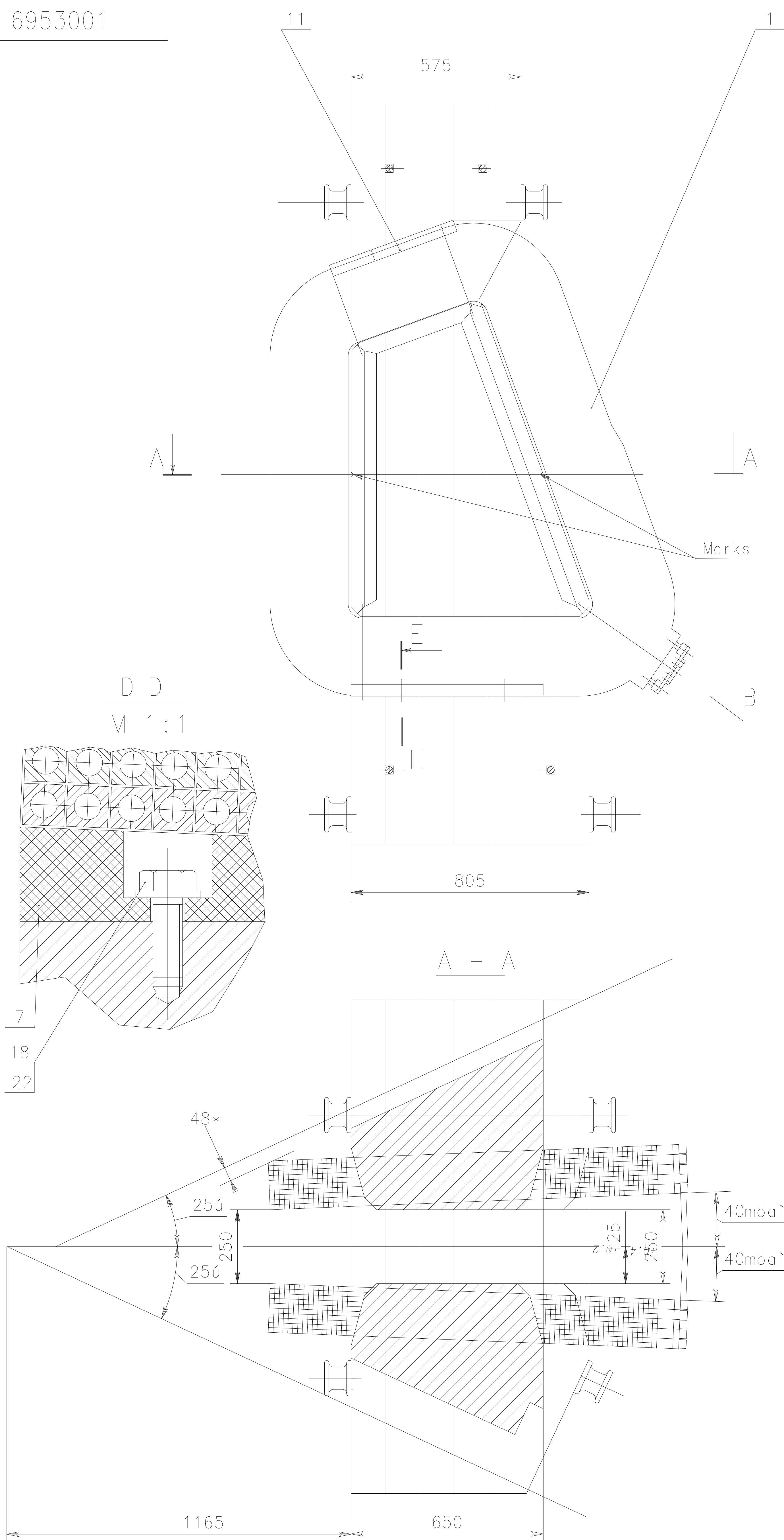


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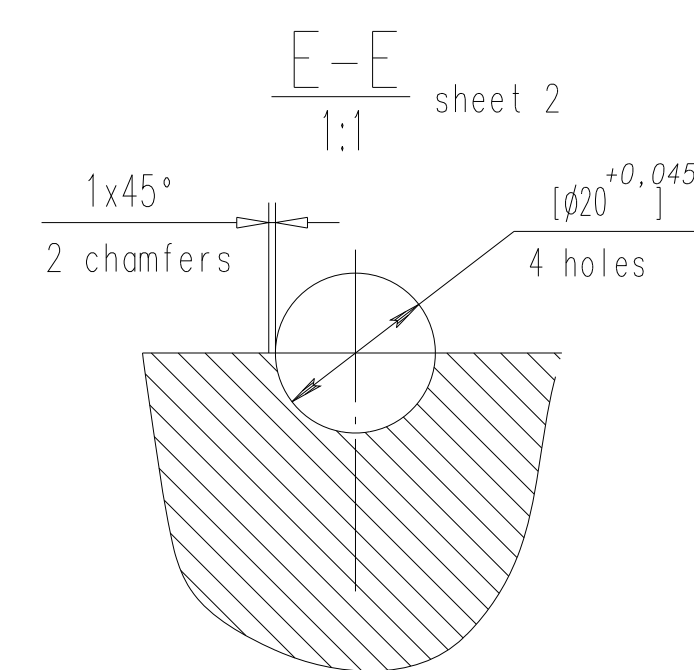
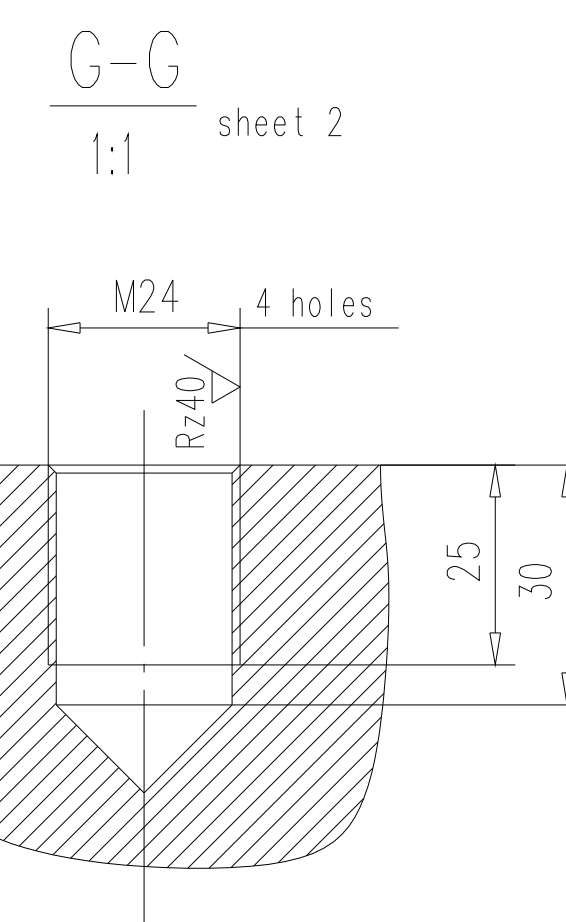
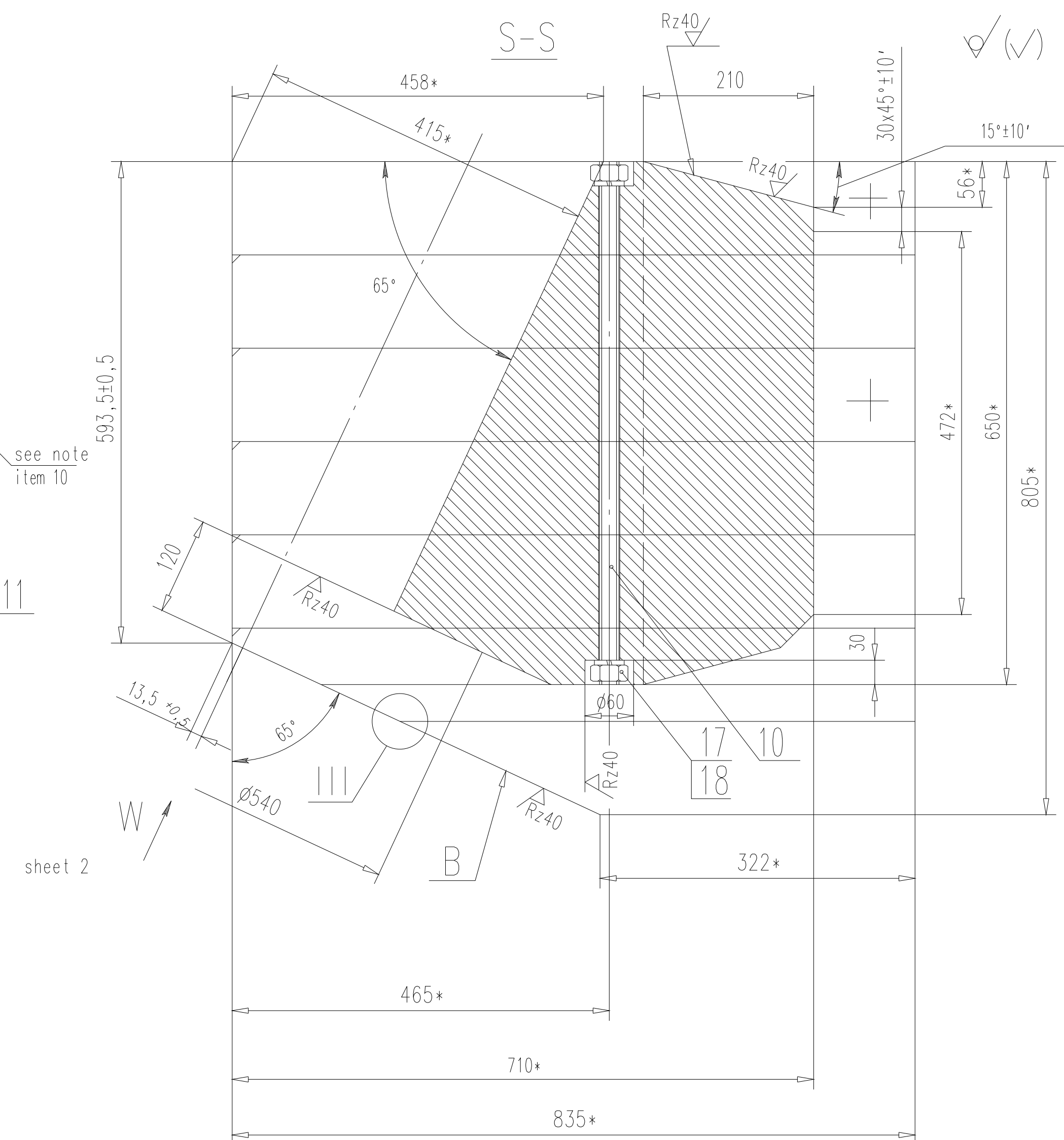
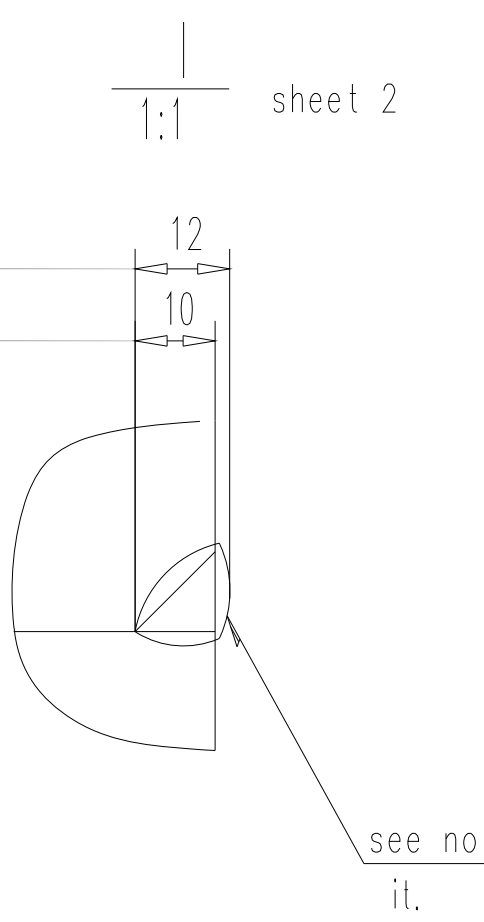
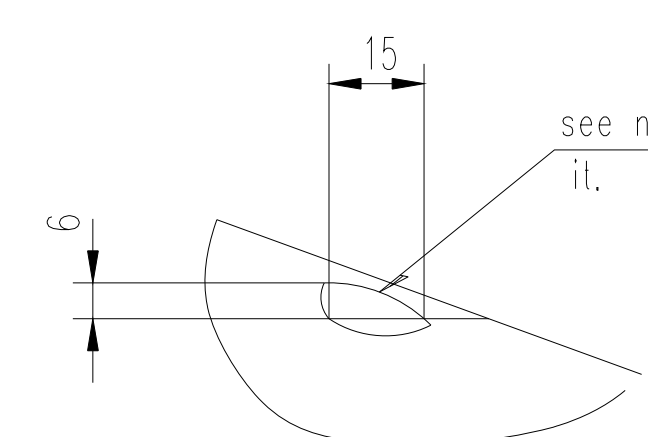
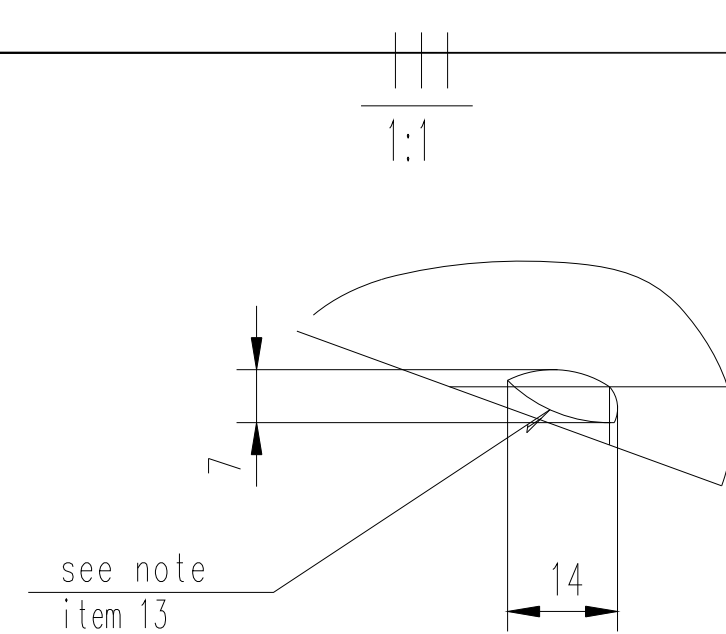
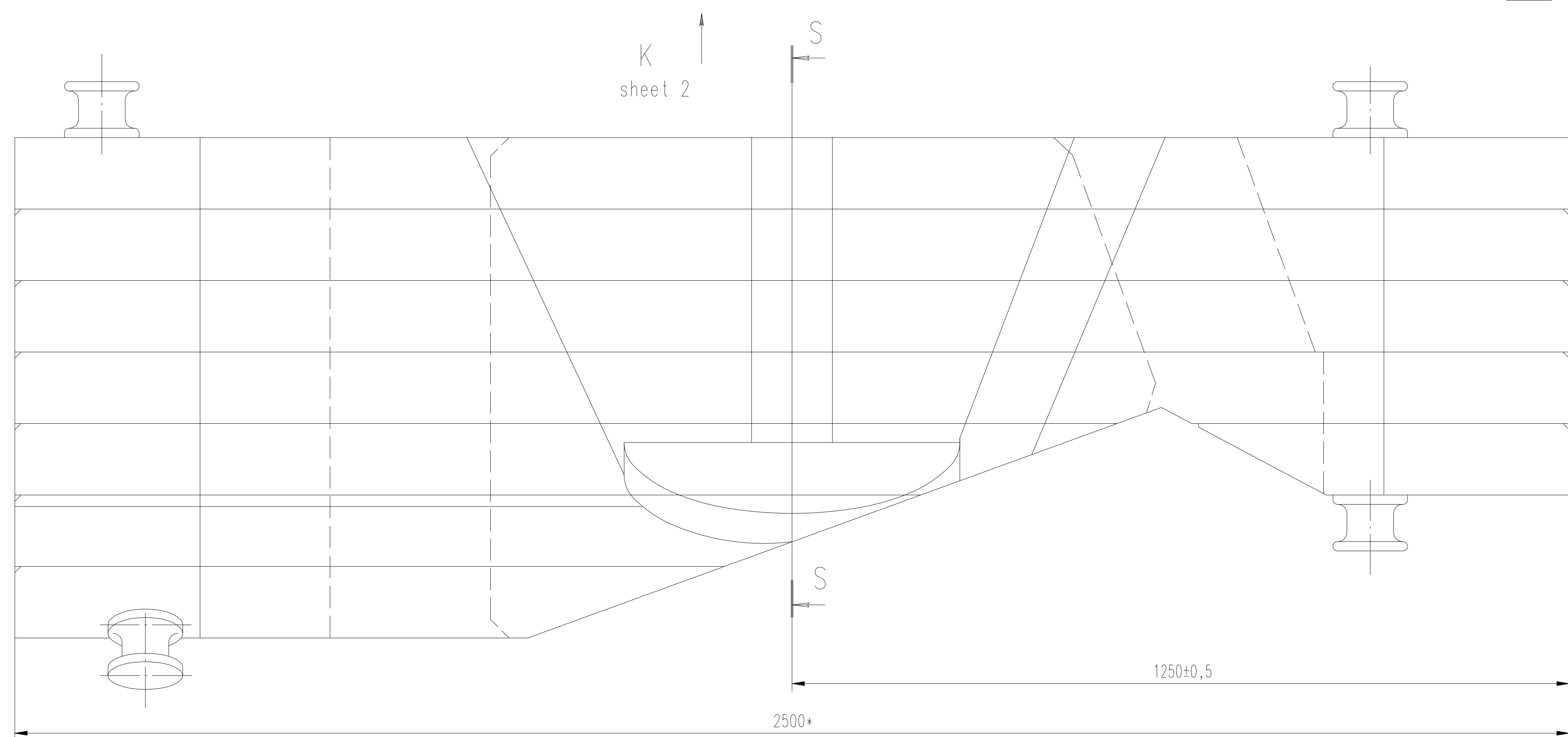


Technical characteristic

- | | |
|--------------------------|------------------------|
| 1. Gap between the poles | Z=250mm |
| 2. Field in the gap | H=12 kGs |
| 3. Current | I=740A |
| 4. Number of windings | W=360 |
| 5. Power consumption | P=120kVt |
| 6. Voltage | V=162V |
| 7. Difference of input | p=4,2bar |
| 8. Total water flux | G=3.5m ³ /h |

1. Forge studs to 2400kG sm.
2. Mark width 0.1-0.2mm.

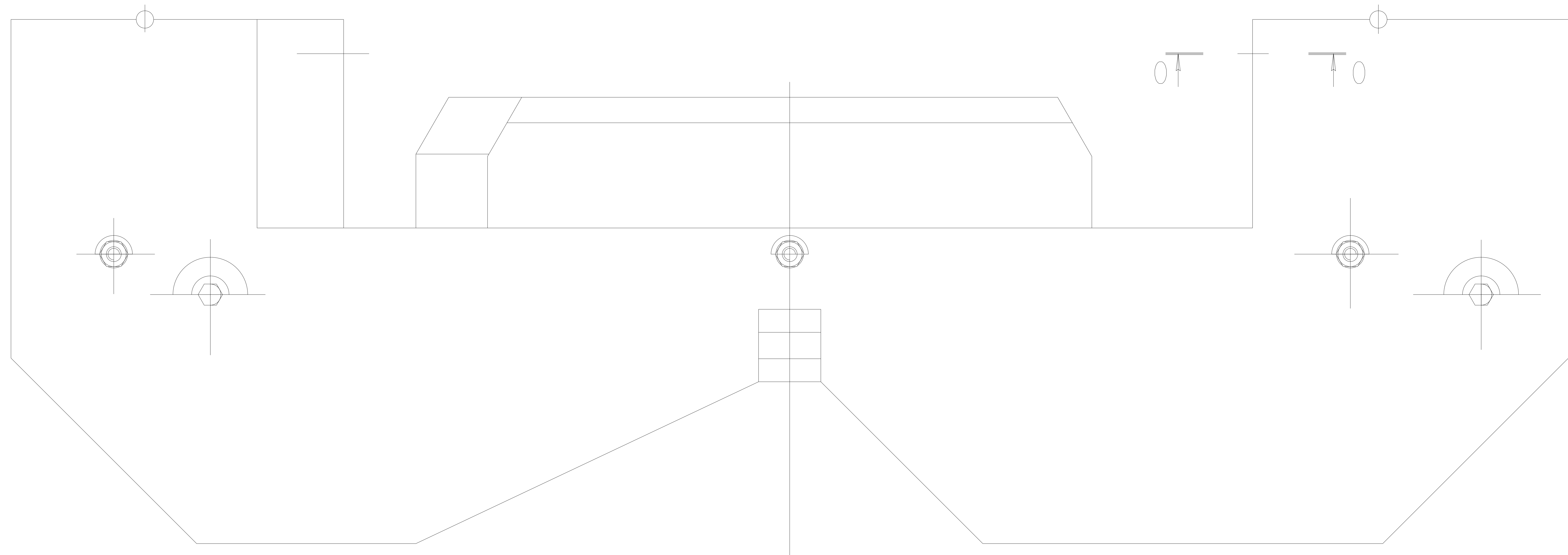
[illegible]

[illegible]

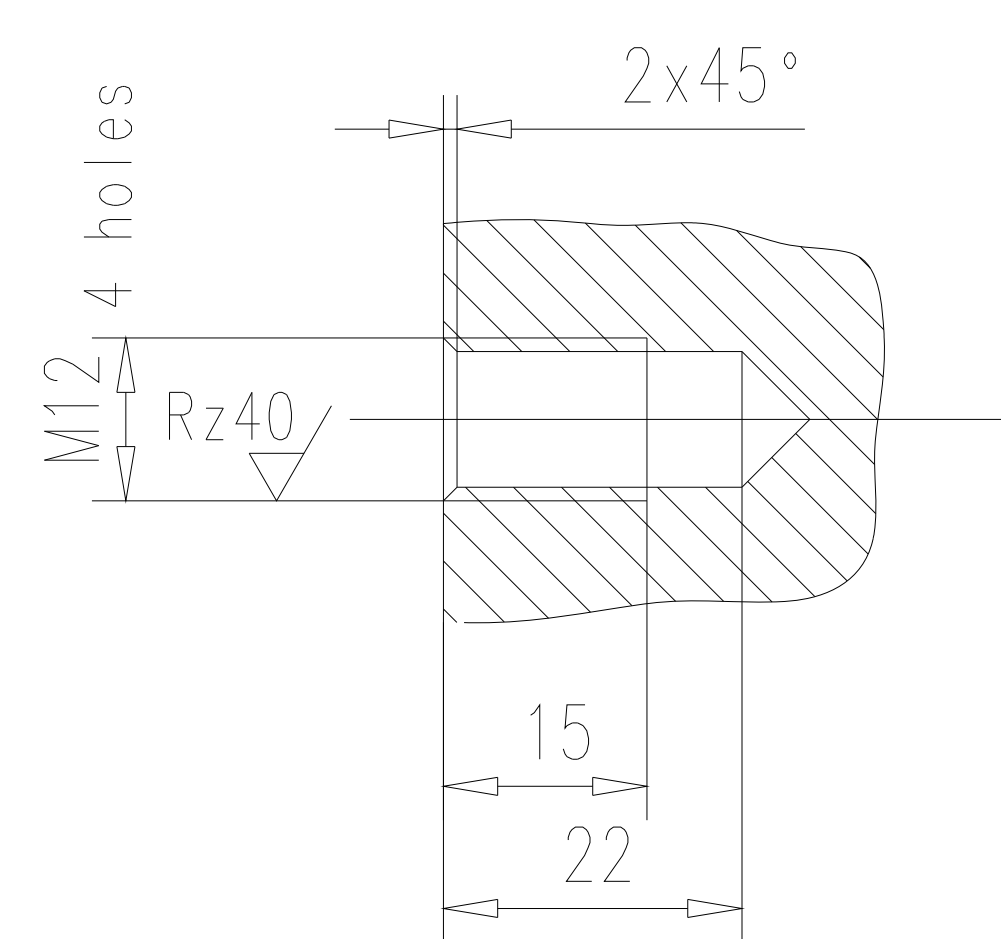
1. Use surfaces "A" and "B" as reference for plates item 1, 2, 3, 4, 5, 6, 7, 8 alignment.
2. The gap between plates shall not be more than 0,2mm.
3. Do not let emulsion penetrate into gaps.
4. Use FWE.002.02.00SB as a jig for four holes M24 cutting.
5. Weld joints shall be made according to STD.020-87 specification.
6. Coat all surfaces except "D" with brown primer FL-03-K and light blue enamel ML-152. Coat surfaces "D" with thin layer of rust-preventive compound CIATIM-201.
7. Tightening torque for bolts (item 16) is 1200 kgf cm, for studs (item 9, 10, 11)-1800 kgf cm.
8. *Dimensions for reference.
9. Unless otherwise specified tolerances are A7, B7, CM7.
10. Manual arc welding. Weld penetration is 10 mm. Remove the weld reinforcement.
11. Manual arc welding. Weld penetration is 15 mm.
12. The extra 4 mm of material is for machining of "B" surface.
13. Manual arc welding. Weld penetration is 14 mm.

[illegible]

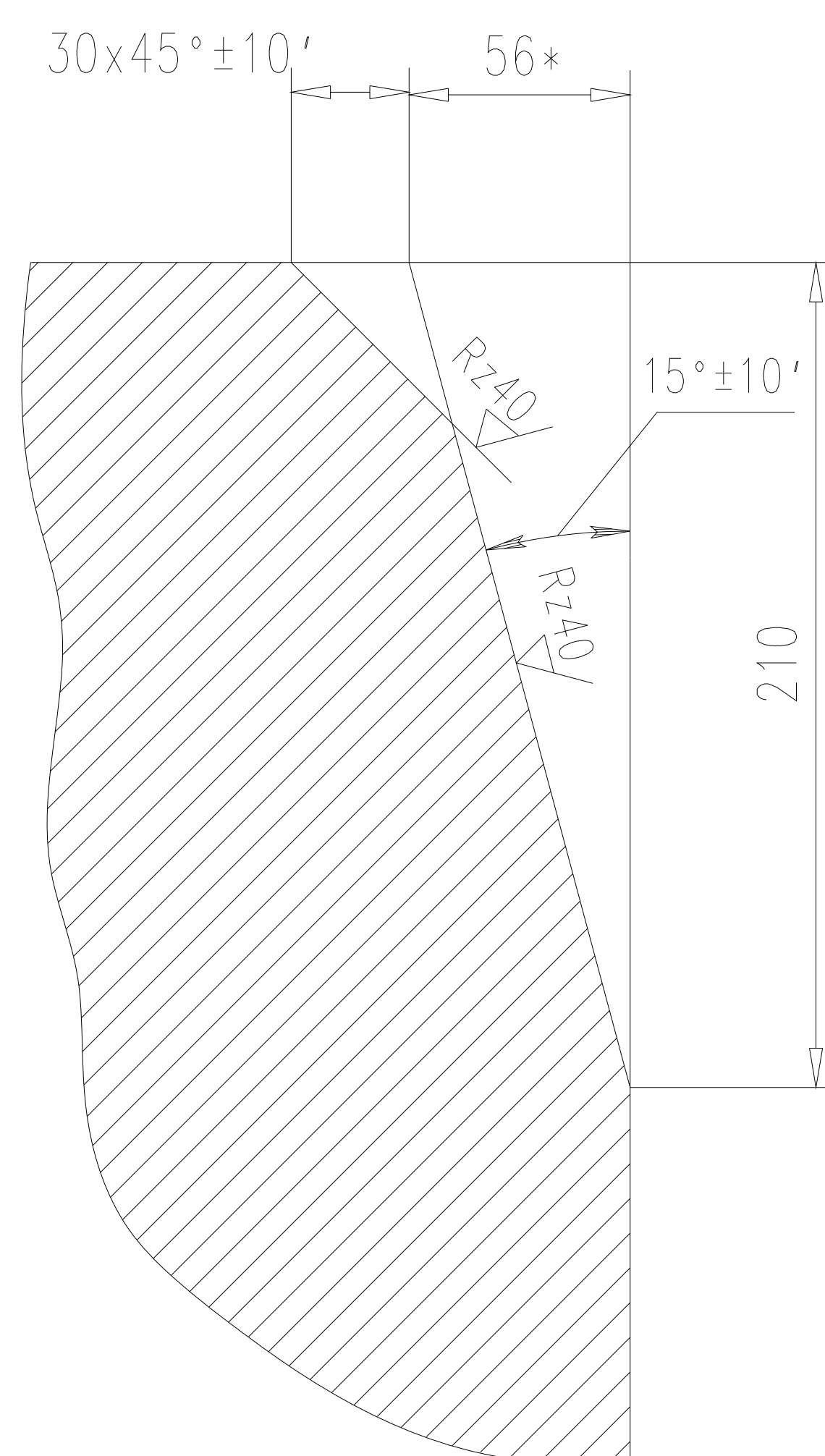
View K_{sheet 1}



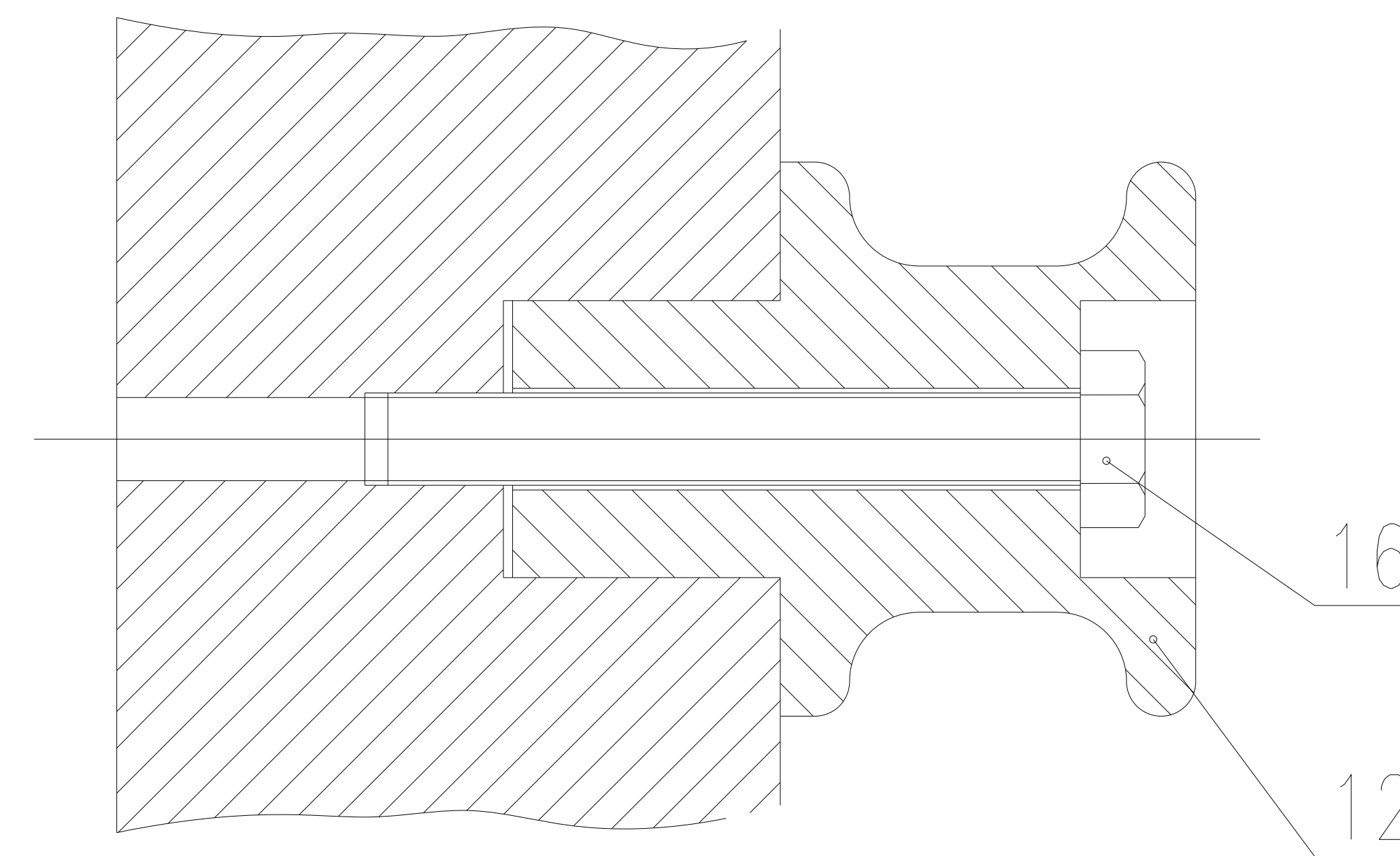
O-O
1:1



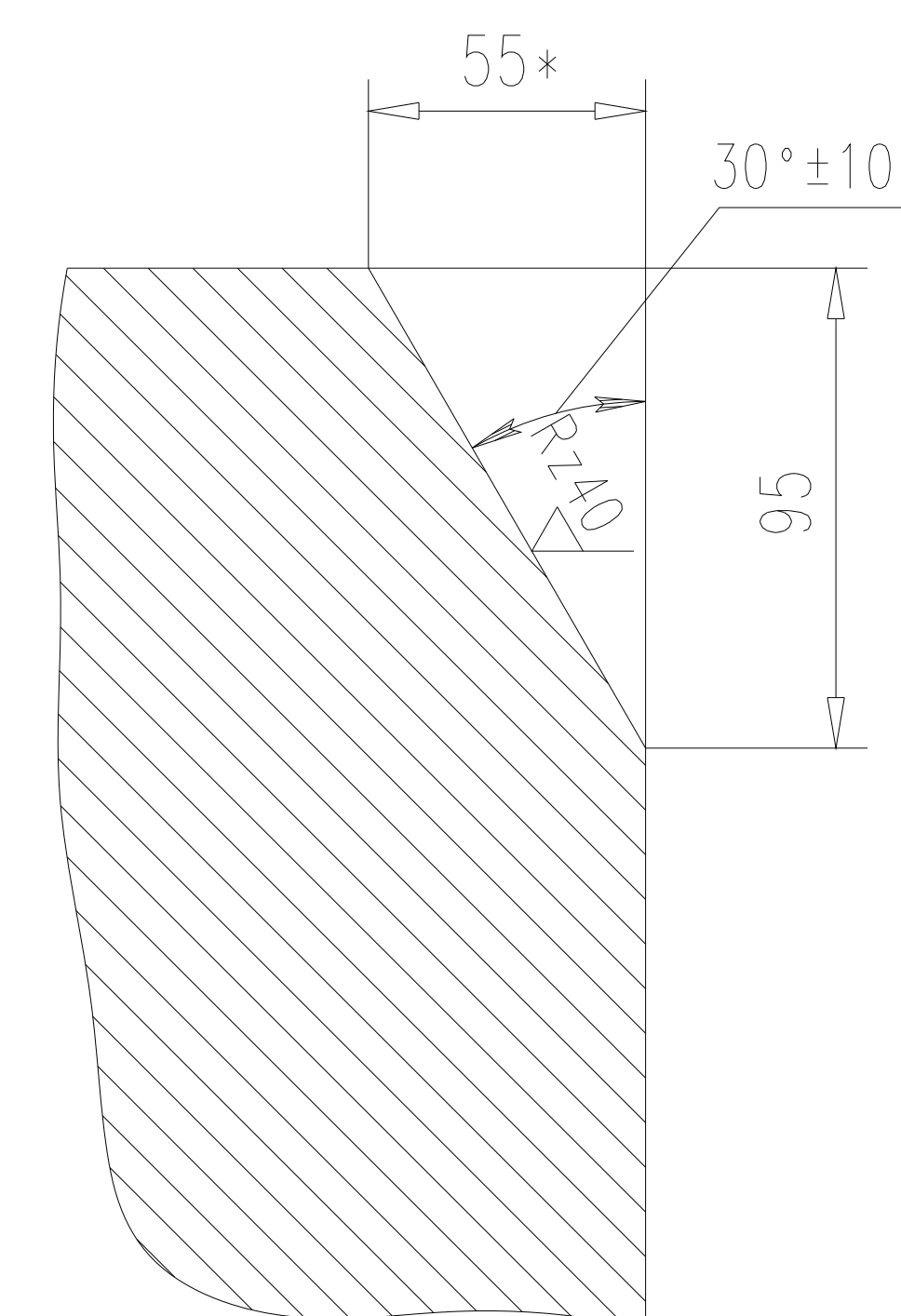
A-A rotated
1:2, 5_{sheet 1}



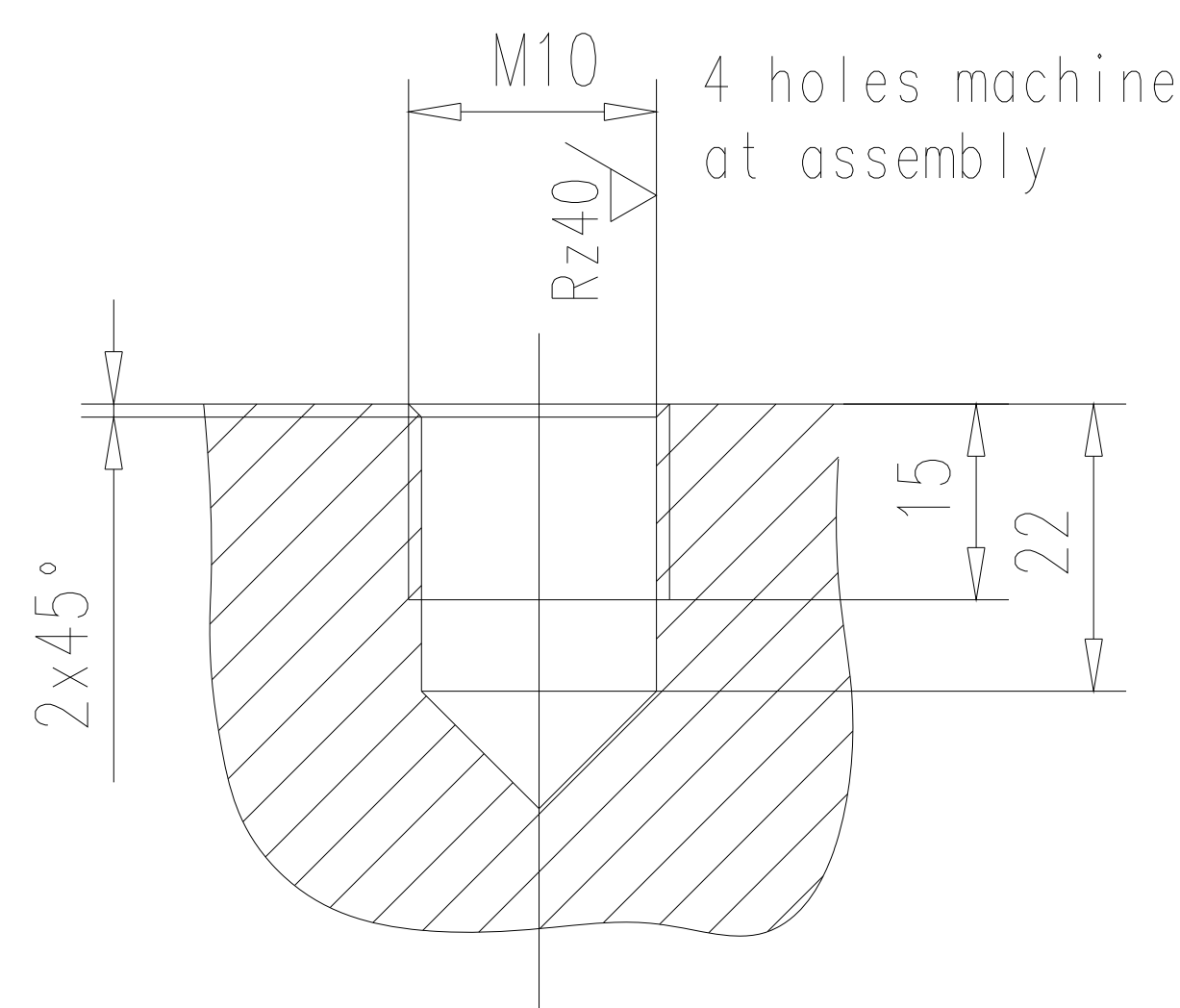
T-T
1:2 sheet 1



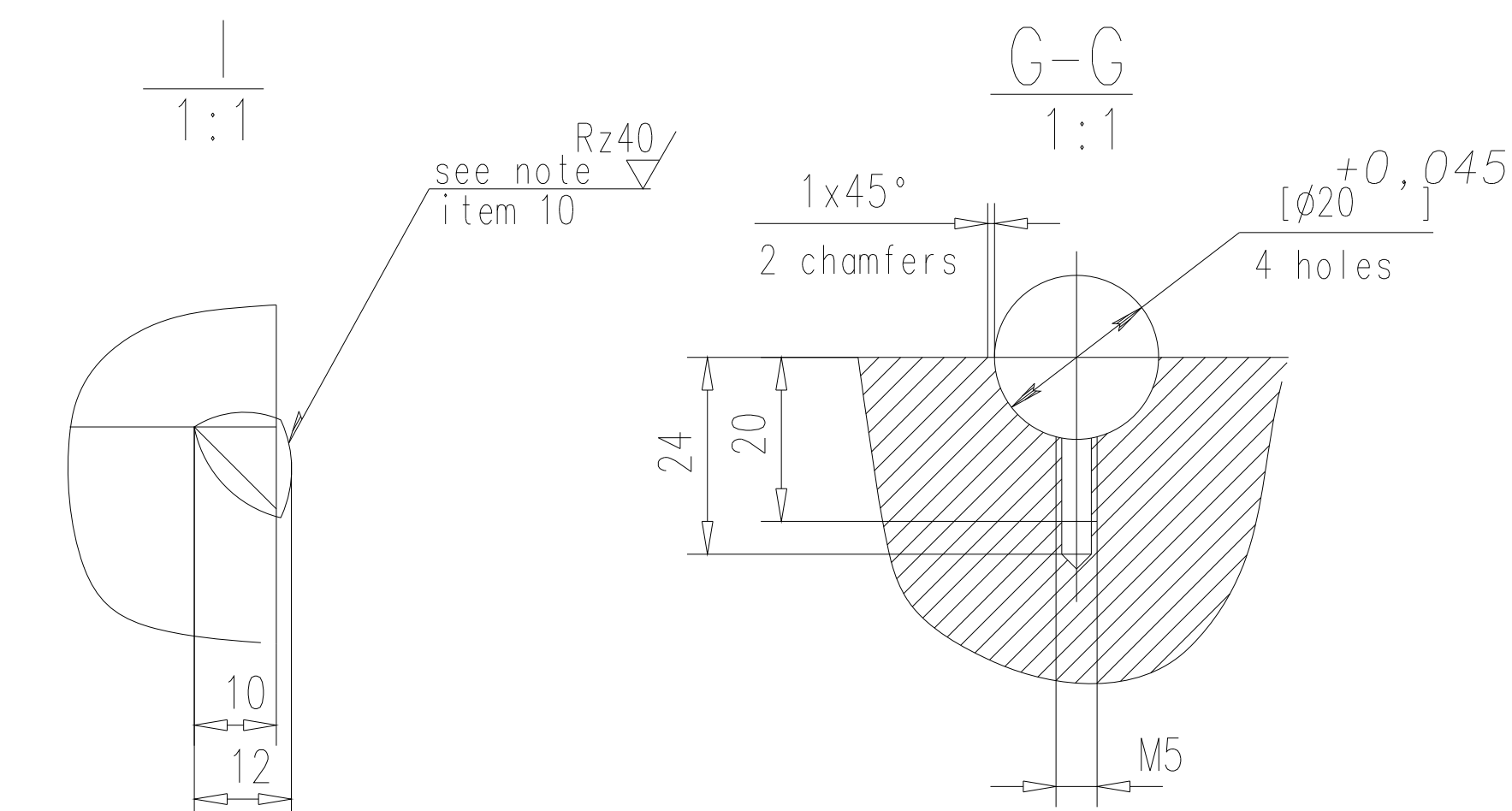
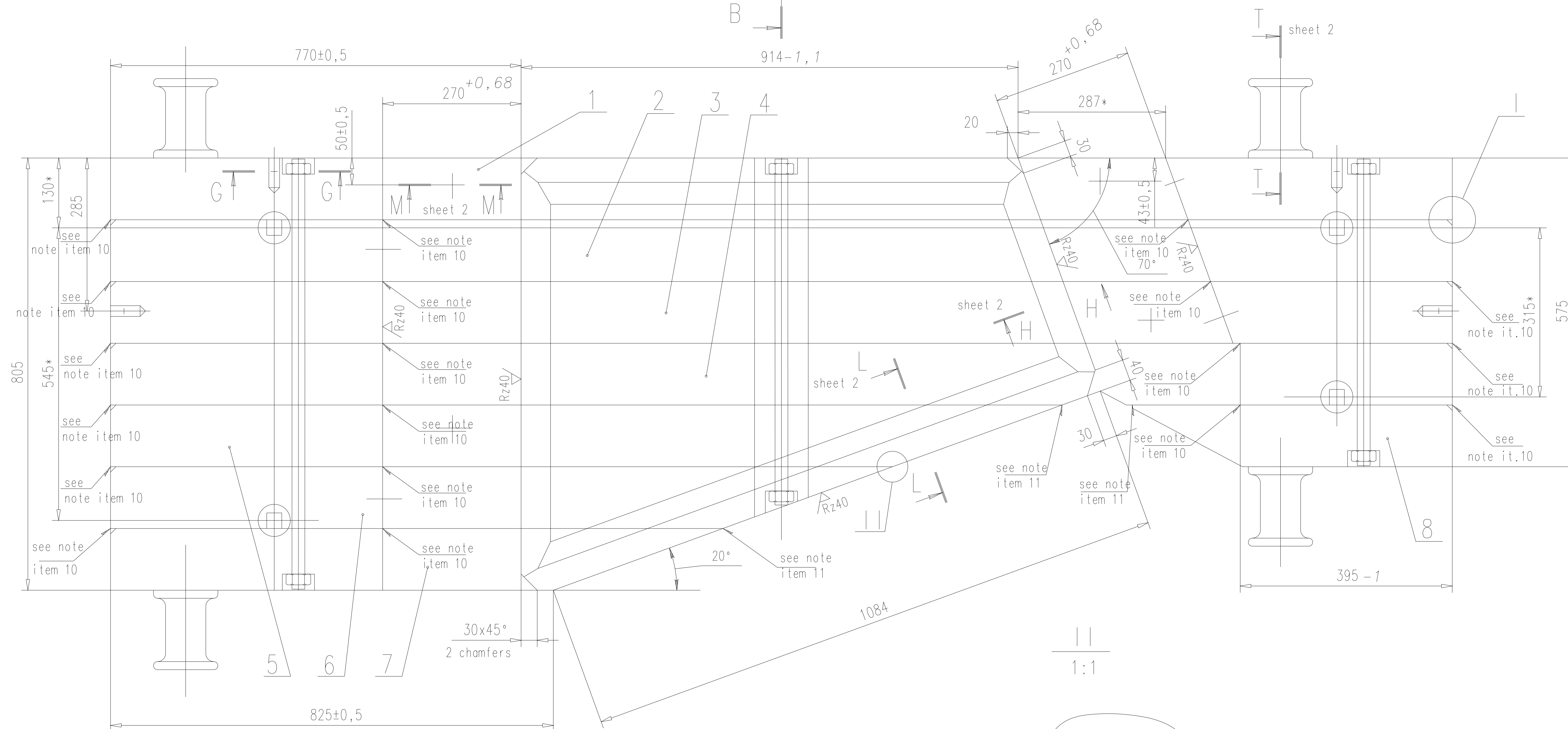
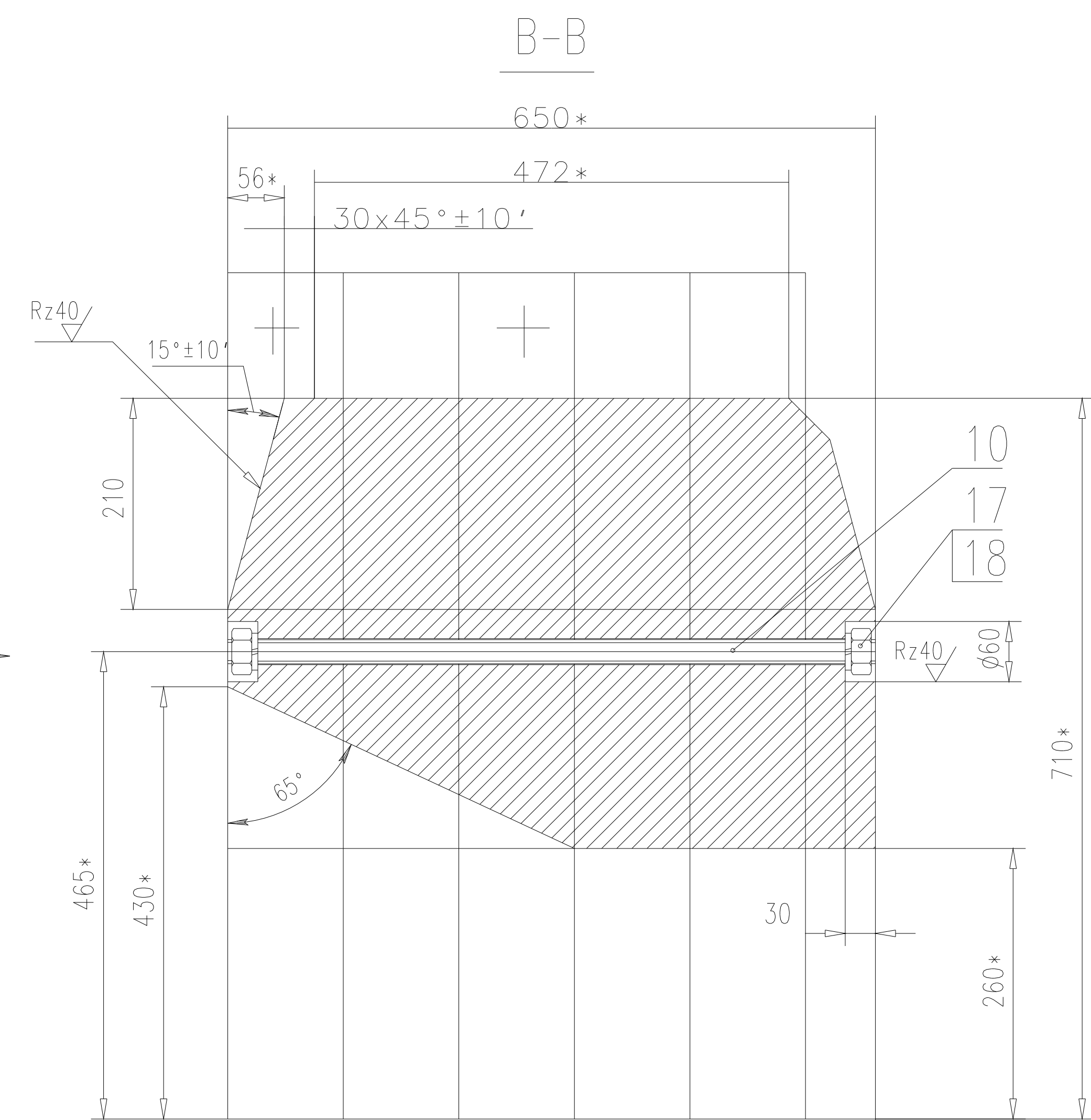
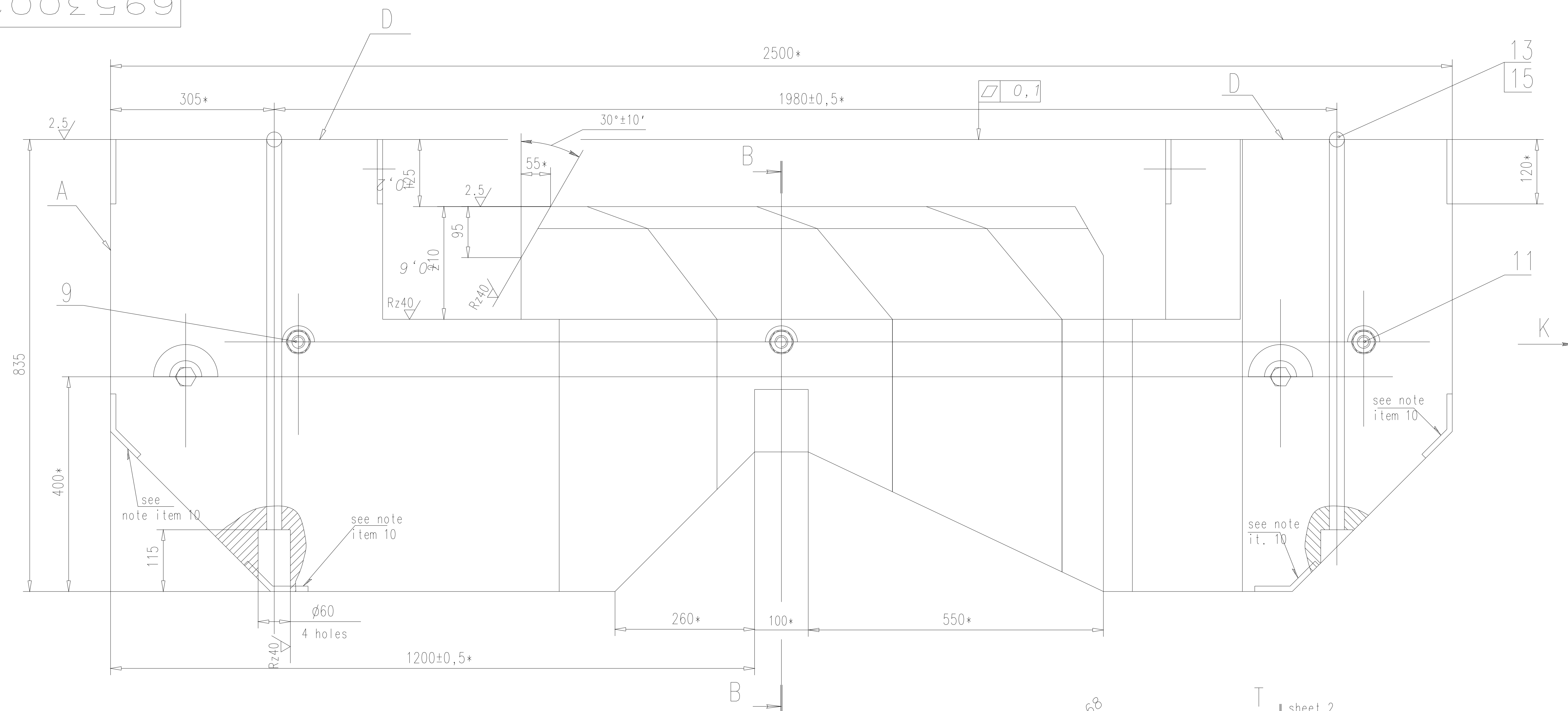
H-H rotated
1:2 sheet 1



M-M
1:1 sheet 1

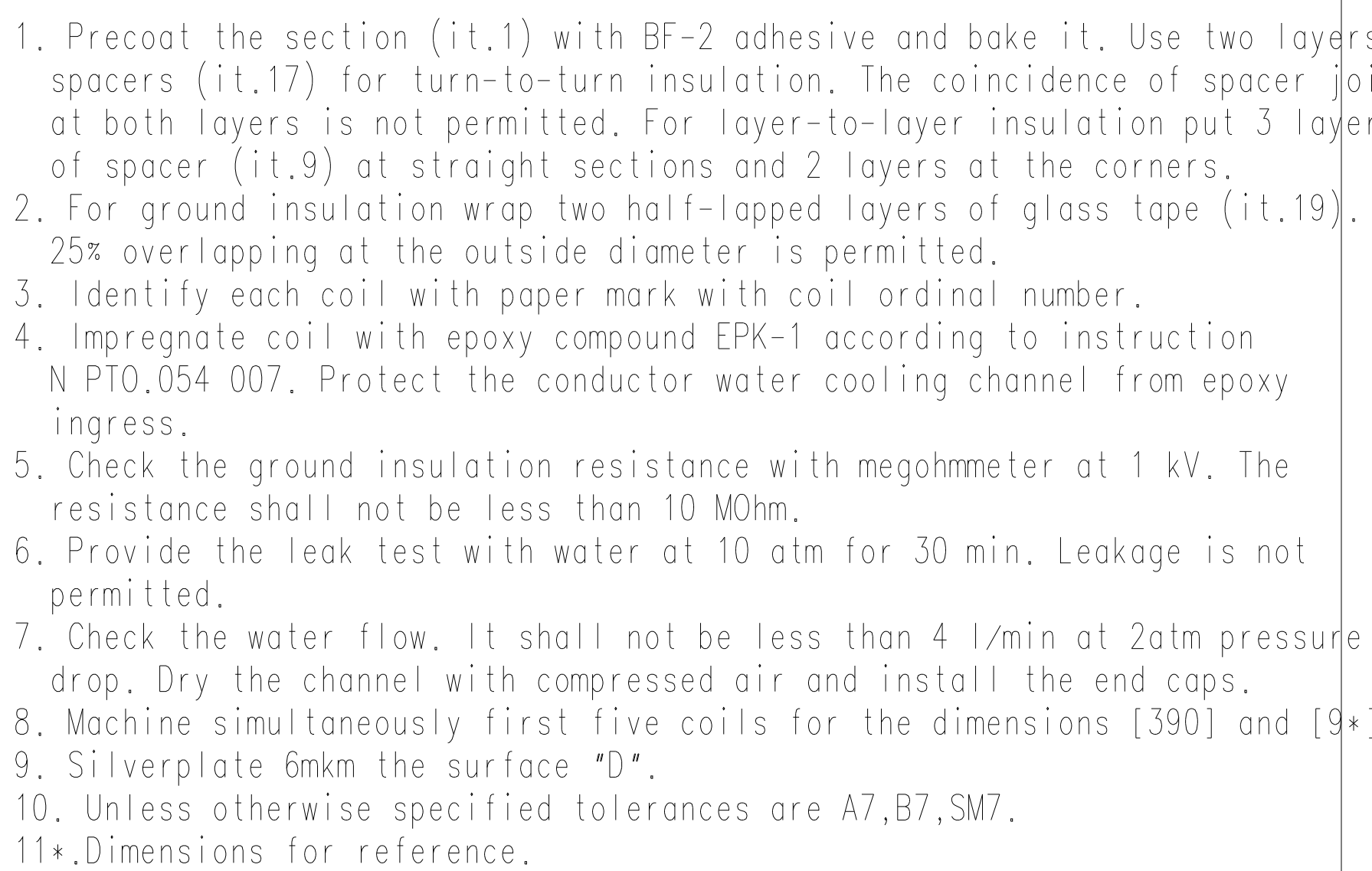
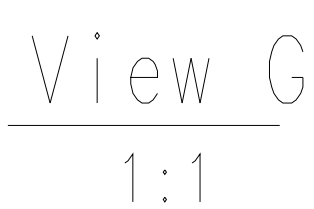
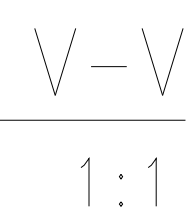
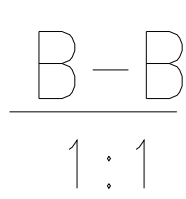
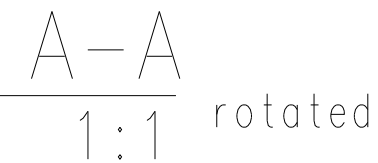


Rev.	Sheet	Docum. No	Signat.	Date



1. Use surfaces "A" and "B" as reference for plates item 1, 2, 3, 4, 5, 6, 7, 8 alignment.
2. The gap between plates shall not be more than 0,2 mm.
3. Do not let emulsion penetrate into gaps.
4. Machine the dimensions in square brackets jointly with FWE.002.02.00SB.
5. Weld joints shall be made according to STP.020-B7 specification.
6. Coat all surfaces except "D" with brown primer FL-03-K and light blue enamel ML-152. Coat surfaces "D" with thin layer of rust-preventive compound CIATIM-201.
7. Tightening torque for bolts (item 16) is 1200kgf cm, for studs (item 9, 10, 11)-1800kgf cm.
- 8.*Dimensions for reference.
9. Unless otherwise specified tolerances are A7, B7, CM7.
10. Manual arc welding. Weld penetration is 10 mm. Remove the weld reinforcement.
11. Manual arc welding. Weld penetration is 15 mm.

[illegible]

[illegible]