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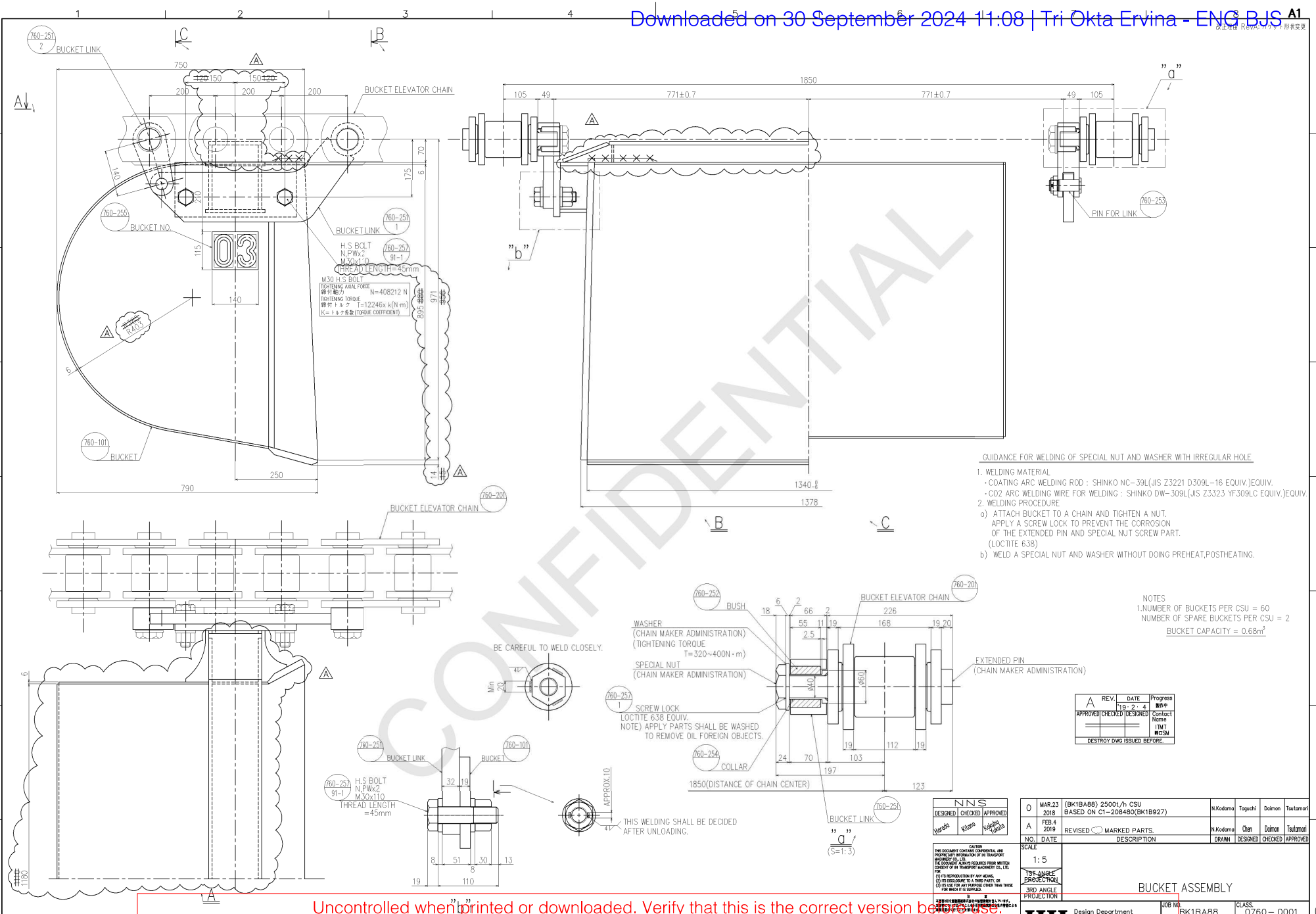

GUIDANCE FOR WELDING OF SPECIAL NUT AND WASHER WITH IRREGULAR HOLE

1. WELDING MATERIAL
   - COATING ARC WELDING ROD : SHINKO NC-39L(JIS Z3221 D309L-16 EQUIV.)EQUIV.
   - CO2 ARC WELDING WIRE FOR WELDING : SHINKO DW-309L(JIS Z3323 YF309LC EQUIV.)EQUIV.
2. WELDING PROCEDURE
   a) ATTACH BUCKET TO A CHAIN AND TIGHTEN A NUT. APPLY A SCREW LOCK TO PREVENT THE CORROSION OF THE EXTENDED PIN AND SPECIAL NUT SCREW PART. (LOCTITE 638)
   b) WELD A SPECIAL NUT AND WASHER WITHOUT DOING PREHEAT,POSTHEATING.

NOTES
1.NUMBER OF BUCKETS PER CSU = 60
NUMBER OF SPARE BUCKETS PER CSU = 2
BUCKET CAPACITY = 0.68m³

REV.	DATE	Progress
A	'19·2·4	製作中

APPROVED	CHECKED	DESIGNED	Contact Name
			ITMT 神CSM

DESTROY DWG ISSUED BEFORE.

NNS	DESIGNED	CHECKED	APPROVED
	Harada	Kitano	Yokoki Iizuka

NO.	DATE	DESCRIPTION	DRAWN	DESIGNED	CHECKED	APPROVED
0	MAR.23 2018	(BK1BA88) 2500t/h CSU BASED ON C1-208480(BK1B927)	N.Kodama	Taguchi	Daimon	Tsutamori
A	FEB.4 2019	REVISED ☁ MARKED PARTS.	N.Kodama	Chen	Daimon	Tsutamori

SCALE 1:5
1ST ANGLE PROJECTION
3RD ANGLE PROJECTION

BUCKET ASSEMBLY

IHI Design Department Materials Handling Systems Division

JOB NO. BK1BA88
CLASS. 0760-0001
DRAWING NO. C1-211069
REV. A
1/1

IHI Transport Machinery Co., Ltd.

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