



VEGA LTD. IS NOT RESPONSIBLE FOR ANY FAILURE IF THE ASSEMBLING INSTRUCTIONS AND THE DRAWING ARE NOT STRICTLY RESPECTED.

ANY ADDITIONAL WELD CAN INDUCE UNDESIRABLE STRESSES IN THE FRAME AND MUST BE PROHIBITED.

ALL THE WELDS MUST BE PERFORMED ONLY WITH THE ELECTRODE TYPE SPECIFIED IN THE INSTALLATION INSTRUCTIONS TO THE EXCLUSION OF ANY OTHER TYPE, EXCEPT WITH THE WRITTEN AGREEMENT OF VEGA LTD.

THIS DRAWING IS ONLY VALID FOR A MILL RUNNING COUNTER CLOCKWISE WHEN LOOKING FROM INLET TOWARDS OUTLET.

THE SIZE OF THE MINIMUM RECTANGULAR OPENING, NECESSARY TO INTRODUCE THE FRAME PARTS INTO THE MILL IS 550 X 260 MM.

IF THE FRAME PARTS CAN NOT BE INTRODUCED THROUGH THE MANHOLE THEY MUST BE INTRODUCED THROUGH THE MILL INLET TRUNNION.

THE WEARING PARTS, SUCH AS GRATE PLATES OR BACK SIDE PLATES, CAN PASS THROUGH THE MANHOLE OPENING.

MAX. PERMISSIBLE TORQUE FOR LCD OR O/L DIAPHRAGM GRATE PLATE OR BACK PLATE BOLTS 800 NTR.

TOTAL WEIGHT OF DIAPHRAGM 5178.0 kgs. (APPROX)

SR.NO.	QTY	DESCRIPTION	REF.	REMARKS/DRG.NO.	UNIT WEIGHT
40					
39					
38					
37					
36					
35					
34					
33	163	Hexagonal nut	107-1	M16 Din934-B	0.03
32	80	Safety washer	107-4	NMG 452 #16	0.02
31	83	Hexagonal head bolt	107	M16x65 Din933-B.8	0.13
30	42	Safety nut	300	M33 x 2	0.35
29	14	Hex. head bolt	33325	M33x2x335 Din960	2.9
28	28	Rd. ctsk. reversed key head plow bolt	364	M33x2x20x335 Din792	2.8
27					
26	40	Safety washer		NMG 452 For M30	0.05
25	20	Hexagonal nut		M30x2	0.3
24	20	Plain washer		NMG 451 For M30	0.15
23					
22	20	Rd. ctsk. reversed key head plow bolt	33122	M30x2x5x125L Din792	0.9
21					
20	2	Balls ejector	102	W5/B61/50_B	11
19	3	Cover	104		4
18	5	Cylindrical Lifter	103	W5/1064/49	14
17	1	Air passage screen	6		68
16	1	Flange	6-1	W5/1075/23_A	27
15	14	Grate plate (slot size= 6mm)	21-6	V/STD/77_A	105.6
14	14	Back side plate	9	V/STD/79	97
13					
12					
11	16	Erection fish-plate	1-1	W5/628/009	0.5
10	20	Post	5		7
9					
8	2	Central frame section (3/14)	2	W5/5041/10	114
7	2	Central frame section (4/14)	1		150
6	2	Peripheral frame section (3/14)	14		214
5	2	Peripheral frame section (4/14)	13	W5/5077/7	291
4	36	Adjusting shim 5mm thick	13-6		1.0
3	26	Adjusting shim 3mm thick	13-5	W5/803/51	0.6
2	26	Adjusting shim 2mm thick	13-4		0.4
1	26	Adjusting shim 1mm thick	13-3		0.2

BILL OF MATERIAL

REV	DATE	DESCRIPTION	ZONE	BY
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VEGA INDUSTRIES LTD.

HEIDELBERG CEMENT, GEORGIA-KASPI

CM #1 ; 2550 x 13040 L.

GENERAL ARRANGEMENT FOR

LEVEL CONTROL DIAPHRAGM.

DRG. NO. W5/5073/141

REF.DRG. NO.

SCALE 1:7.5

REV. 00

CAD