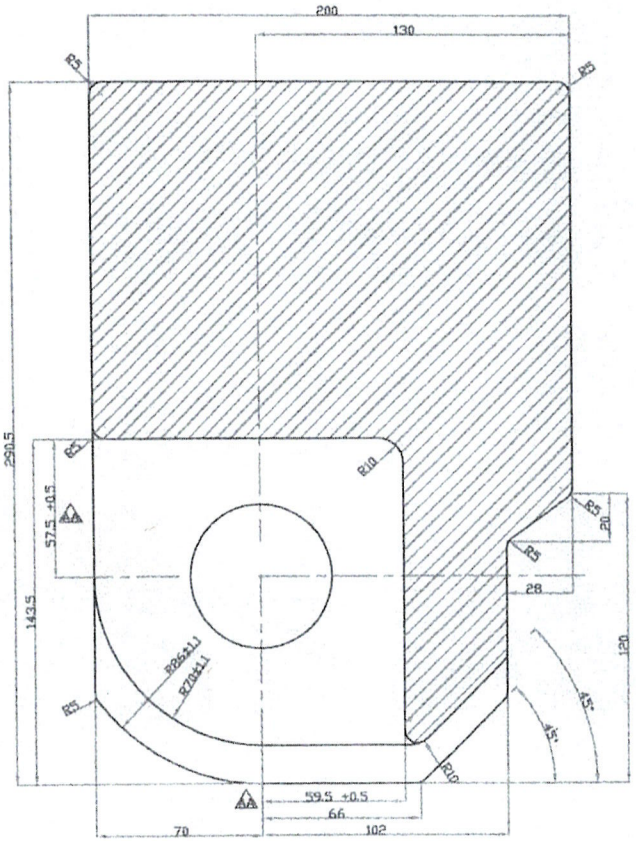
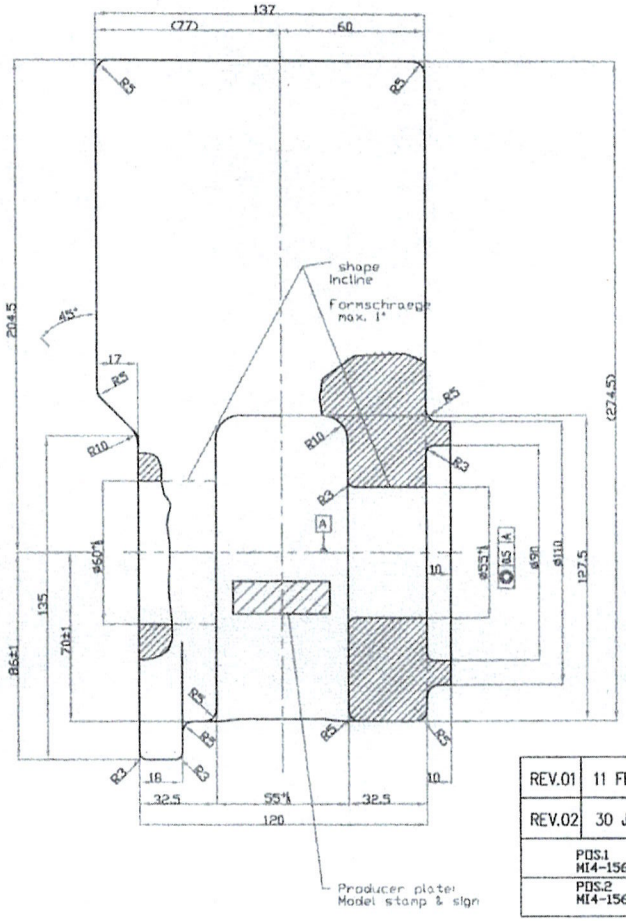
A-A





Borings cast properly and round.
All radii not dimensioned R= 3mm.
Exceptionto fit the casting requirements.

Beater heads classified in weigth classes of up to 50 g difference
and marked in different colours depending on te weight class.

Weight one beater heads: 40.0 kg

Material: GS34CrNiMo6, DIN 17205
material-No.: 16582

Cast properly free of shrink holes and plaws.

With :
- Inspection certificate 3.1 B as per EN 10204,
- chemical analysis and HB-test at 20°C.

Dimensional tolerances and machining allowances: DIN ISO 8062 - CT11.

Surface crack-tested in the area of the radii 90 mm around the central hole.

REV.01	11 FEB 2013	POSITIONS, PART AND MANUF. DRWG NUMBERS ADDED
REV.02	30 JUL 2013	MATERIAL CHANGE
POS.1 MI4-15639-R		Construction as shown for right-hand (clockwise) rotation mills
POS.2 MI4-15640-L		Construction mirror inverted for left-hand (counter clockwise) rotation mills

ΔΕΗ ΑΗΣ ΜΕΓΑΛΟΠΟΛΗΣ Β'

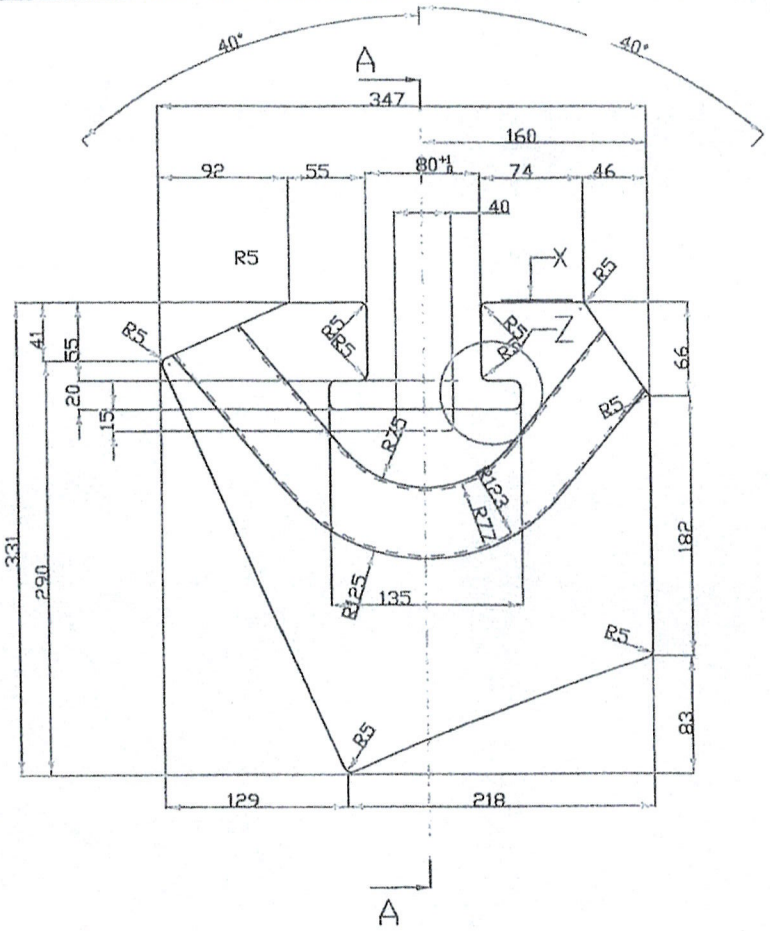
ΥΠΟΤΟΜΕΑΣ ΜΗΧΑΝΟΛΟΓΙΚΗΣ ΣΥΝΤΗΡΗΣΗΣ

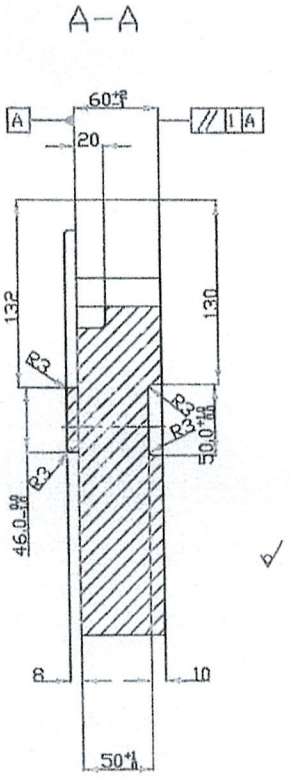
ΣΧΕΔΙΑΣΤΗΚΕ	ΜΕΛΕΤΗΘΗΚΕ	ΕΓΚΡΙΘΗΚΕ	ΗΜΕΡΟΜΗΝΙΑ	ΚΛΙΜΑΚΑ
-	-	-	-	

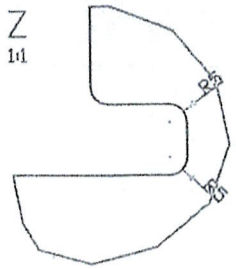
Lignite Mills Unit IV
Beater head

ΣΧΕΔΙΑΣΤΗΚΕ ΜΕ ΤΗ ΧΡΗΣΗ ΤΟΥ ΠΡΟΓΡΑΜΜΑΤΟΣ AUTOCAD

ΑΡΙΘΜΟΣ ΣΧΕΔΙΟΥ ΚΑΤ ΕΤΑΙΡΕΙΑΣ	ΑΡΙΘΜΟΣ ΣΧΕΔΙΟΥ CONSORTIUM	ΑΡΙΘΜΟΣ ΣΧΕΔΙΟΥ ΑΗΣΜ ΜΟΝ.Ι
H151077-M-D77-IG04-00008-AA		Σ783 Rev 02







casted in raised letters (1,5 mm)
in area "X"

Pattern-no.	Cfz 22-14671
Material (DIN EN 1564)	GS34CrNiMo6
Weight per piece	33.1 kg
Number per mill	24
All non dimensioned radij	R=3
Casting dimensions without tolerance acc. to tolerance zone	DIN ISO 8062 CT11
Surface quality	ISO 1302

REV.02	19 AUG 2013	MATERIAL CHANGE
REV.01	11 FEB 2013	MANUFACTURER DRWG NUMBER ADDED

ΔΕΗ ΑΗΣ ΜΕΓΑΛΟΠΟΛΗΣ Β'

ΥΠΟΤΟΜΕΑΣ ΜΗΧΑΝΟΛΟΓΙΚΗΣ ΣΥΝΤΗΡΗΣΗΣ

ΣΧΕΔΙΑΣΤΗΚΕ	ΜΕΛΕΤΗΘΗΚΕ	ΕΓΚΡΙΘΗΚΕ	ΗΜΕΡΟΜΗΝΙΑ	ΚΛΙΜΑΚΑ
-	-	-	-	-

Lignite Mills Unit IV
Corner cladding

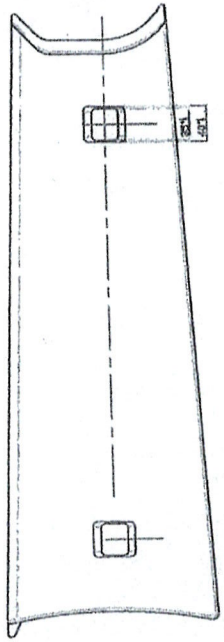
ΣΧΕΔΙΑΣΤΗΚΕ ΜΕ ΤΗ ΧΡΗΣΗ ΤΟΥ ΠΡΟΓΡΑΜΜΑΤΟΣ AUTOCAD

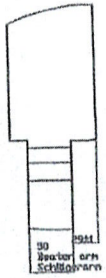
ΑΡΙΘΜΟΣ ΣΧΕΔΙΟΥ ΚΑΤ ΕΤΑΙΡΕΙΑΣ	ΑΡΙΘΜΟΣ ΣΧΕΔΙΟΥ CONSORTIUM	ΑΡΙΘΜΟΣ ΣΧΕΔΙΟΥ ΑΗΣΜ MON-IV
B151027-M-025-IG04-00002-AA		Σ.736 - Rev.02

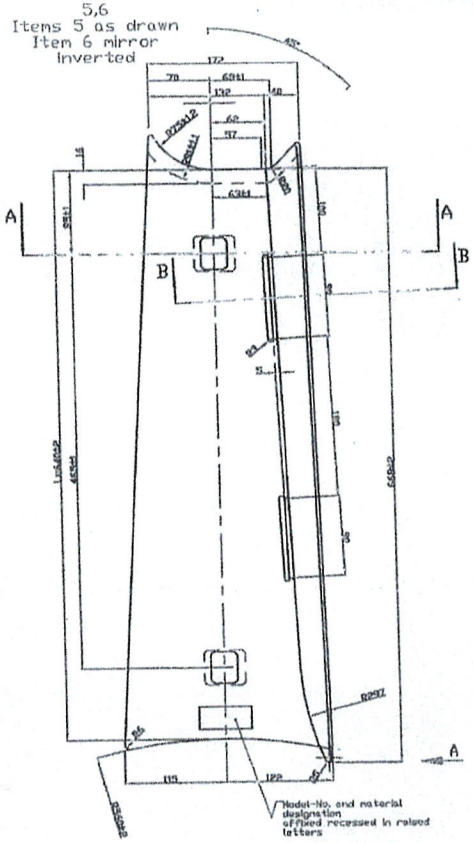
5,6
Items 5 as drawn
Item 6 mirror inverted

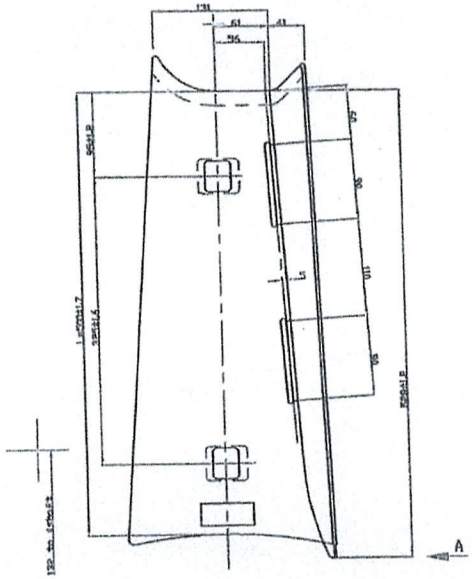
3,4
Item 3 as drawn
Item 4 mirror inverted
(missing dimensions see Item 3)

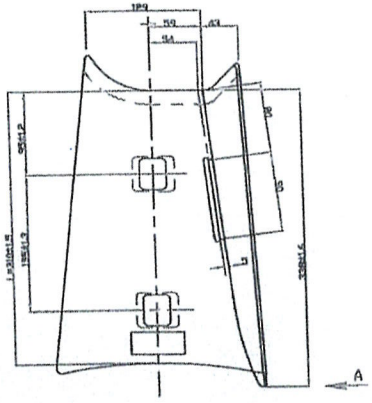
1,2
Item 1 as drawn
Item 2 mirror inverted
(missing dimensions see Item 3)









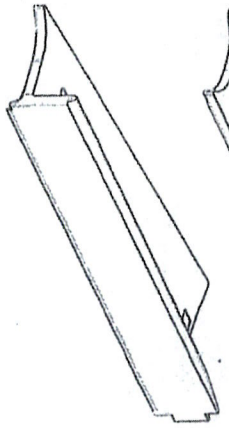


drawn.

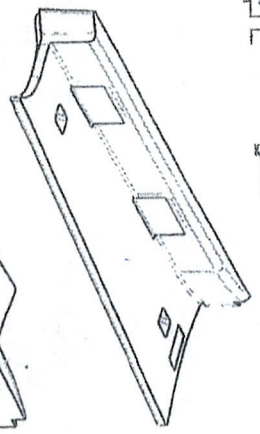
Rigth-hand construction

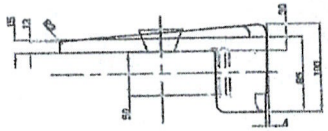
Left-hand construction
mirror-inverted.

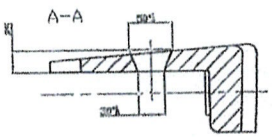
Left turning
mill (L)

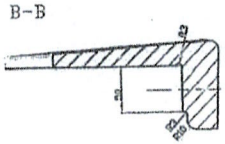


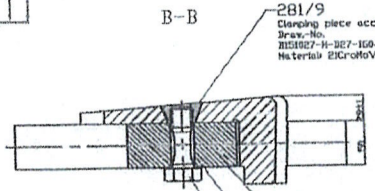
Right turning
mill (R)











281/9
Clamping piece acc.
Drw.-No.
D151027-H-027-1G04-00812
Material 21CrMoV57

280/1-4

281/10
Washer with external tap 25
DIN 432, Steel

281/11
Hexagon head screw M24x70 acc.
Drw.-No.
D151027-H-027-1G04-00813
Material 21CrMoV57

Item Position	model No. Modell-Nr.	length mm	weight kg/pc	remark
1	1H4-15641-R	310	15.2	for right-hand mill
2	1H4-15642-L	310	15.2	for left-hand mill, mirror inverted Item 1
3	1H4-15643-R	580	24.6	for right-hand mill
4	1H4-15644-L	580	24.6	for left-hand mill, mirror inverted Item 3
5	1H4-15645-R	640	31.3	for right-hand mill
6	1H4-15646-L	640	31.3	for left-hand mill, mirror inverted Item 5

Attention!
Original drawing! 492446.9
Actual drawing with deviations to the original drawing.
Dimensions added.

REV.01 11	FEB 2013	MANUFACTURER DRWG NUMBER ADDED

ΔΕΗ ΑΗΣ ΜΕΓΑΛΟΠΟΛΗΣ Β'

ΥΠΟΤΟΜΕΑΣ ΜΗΧΑΝΟΛΟΓΙΚΗΣ ΣΥΝΤΗΡΗΣΗΣ

ΣΧΕΔΙΑΣΤΗΚΕ	ΜΕΛΕΤΗΘΗΚΕ	ΕΠΙΒΛΕΦΘΗΚΕ	ΕΠΕΞΕΡΓΑΣΘΗΚΕ	ΚΑΛΚΑΘΗΚΕ

Lignite Mills Unit IV
Beater arm protection L1-L2-L3

ΣΧΕΔΙΑΣΤΗΚΕ ΜΕ ΤΗ ΧΡΗΣΗ ΤΟΥ ΠΡΟΓΡΑΜΜΑΤΟΣ AUTOCAD			
ΑΡΙΘΜΟΣ ΣΧΕΔΙΟΥ ΚΑΤ ΕΚΔΟΣΗΣ	ΑΡΙΘΜΟΣ ΣΧΕΔΙΟΥ ΠΡΟΗΓΟΥΜΕΝΟΥ	ΑΡΙΘΜΟΣ ΣΧΕΔΙΟΥ ΑΗΣ ΜΟΝΑΔ	
D151021-H-027-1G04-00011			Σ.738 - Rev.01