

Remove HP front lower half transport device gradually and ensure no movement between HP casing and rotor. If necessary adjust shims of HP casing front packers.

During loading of bearing always ensure that the rotor is not fouling inside the casing with the shaft seals. This may be ensured by checking with feeler gauge also.

Check axial position of HP rotor in front side on left; right and top position from the rotor reference point to the HPC as given in the shop protocol.

Insert and load the bearing in HP rear end in similar way as carried out in case of HP front end and record axial position of rotor as per shop protocol.

Lock axially HP rotor with some fixture along with the arrangement of jacking screw for movement of rotor. This fixture may be mounted on rear pedestal. Before locking of rotor ensure axial position of the shaft.

Center HP shaft with reference to HP casing front and rear spigot. If necessary, move the casing readily to achieve the centering. A fixture can be fabricated at site for mounting the dial gauge on both the end of the rotor to check the centering of the shaft.

Use thick oil during rotation of shaft on the bearing.

Protect bearing from any of the dust particles. It is recommended to place upper half of bearing in position to avoid dust and any other damage to the shaft journal.

Realign the rotor shaft with respect to pedestal seal bore and if necessary adjust the shims below spherical support of the bearing.

Care should be taken during alignment that radial and axial clearances between rotor and casings does not get bridged.

Check HP rotor radial run out on journal and coupling.

Check axial run out on thrust collar and both the coupling faces of HP rotor.

Check axial float of the rotor. Compare values with shop protocol values. (Ref. T1-08-0802G). Deviations to be reported to Manufacturing Unit.

PREPARATION OF IP ROTOR FOR ALIGNMENT

The IP module is also to be prepared in line with the HP module. However as IP rotor is provided with one side bearing and opposite side is coupled with the HP rotor without a bearing, extra care is necessary during alignment of rotor in IP casing. The additional point which are to be taken care are explained below :

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