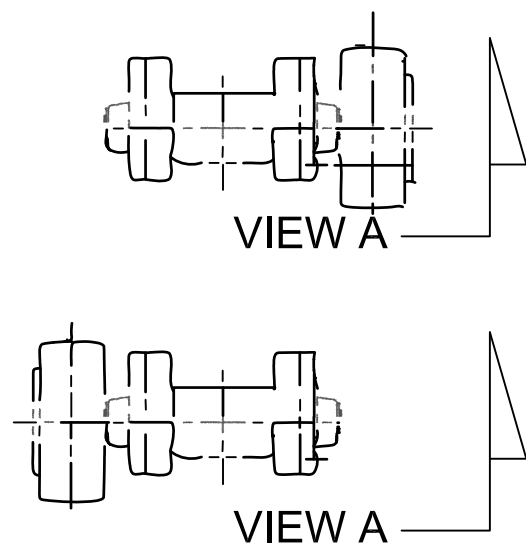
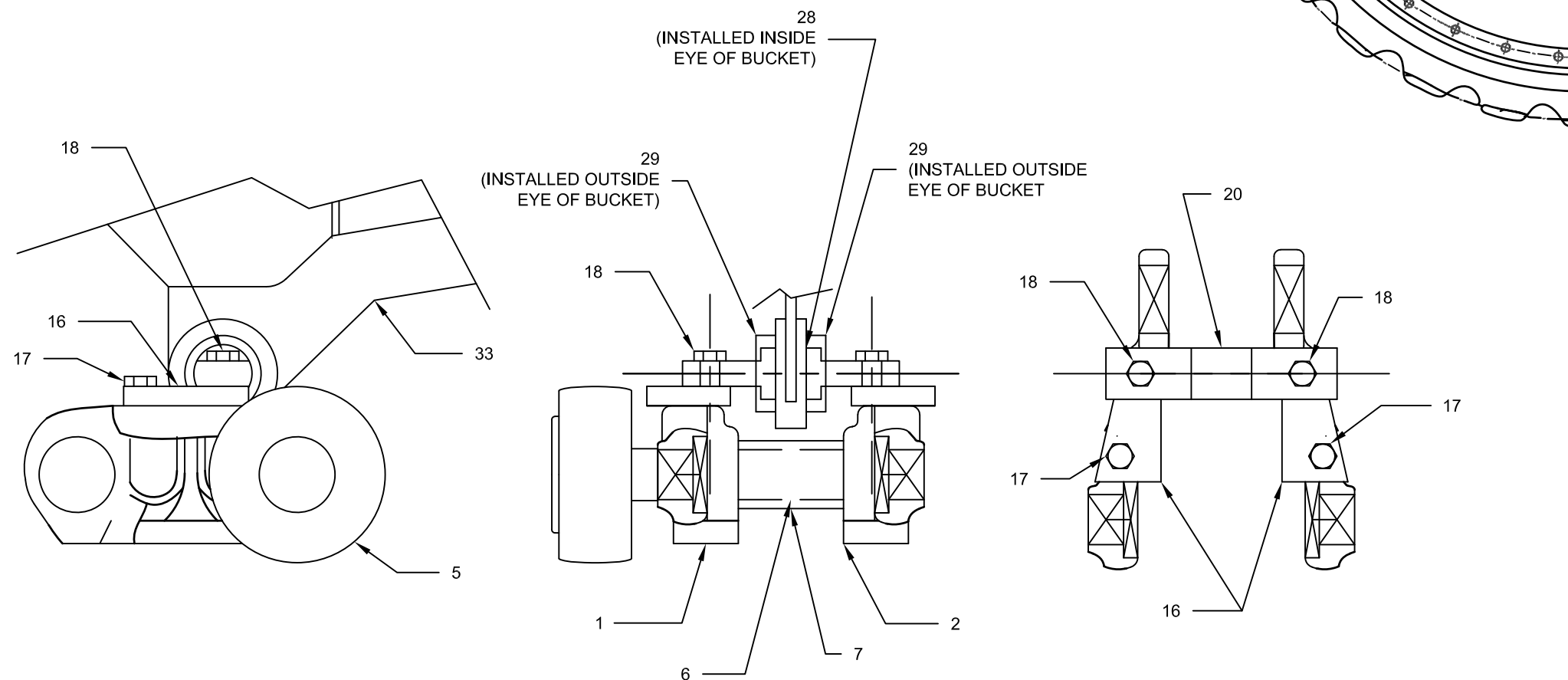
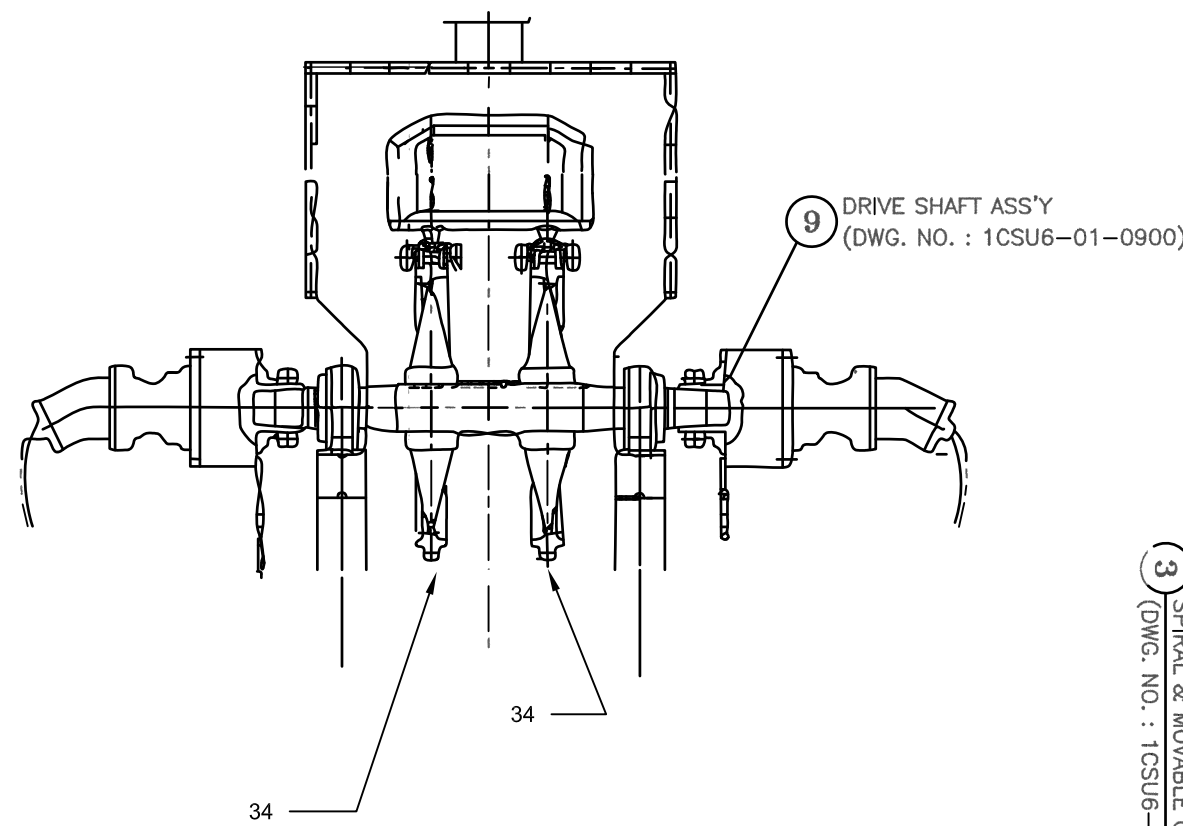
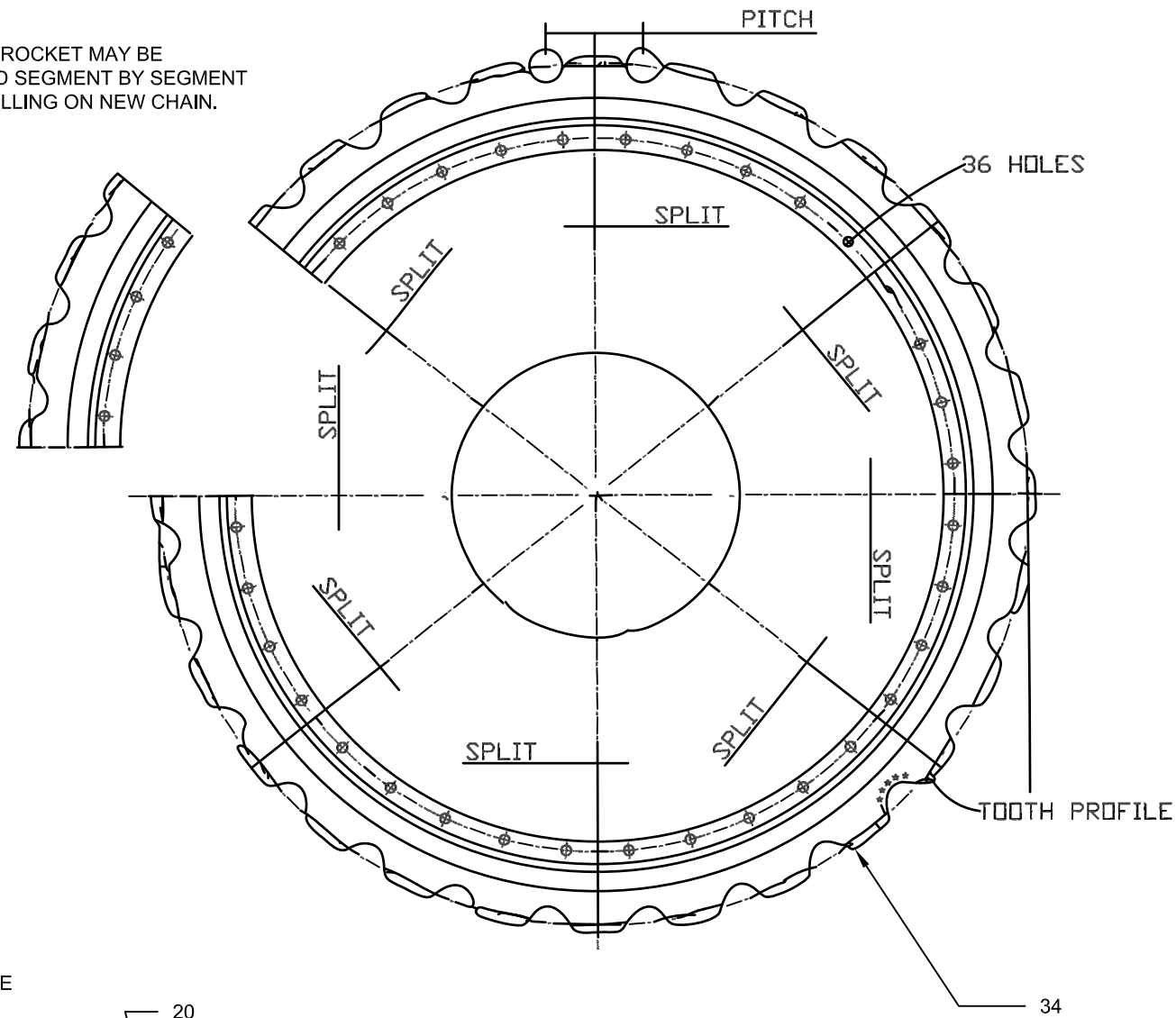


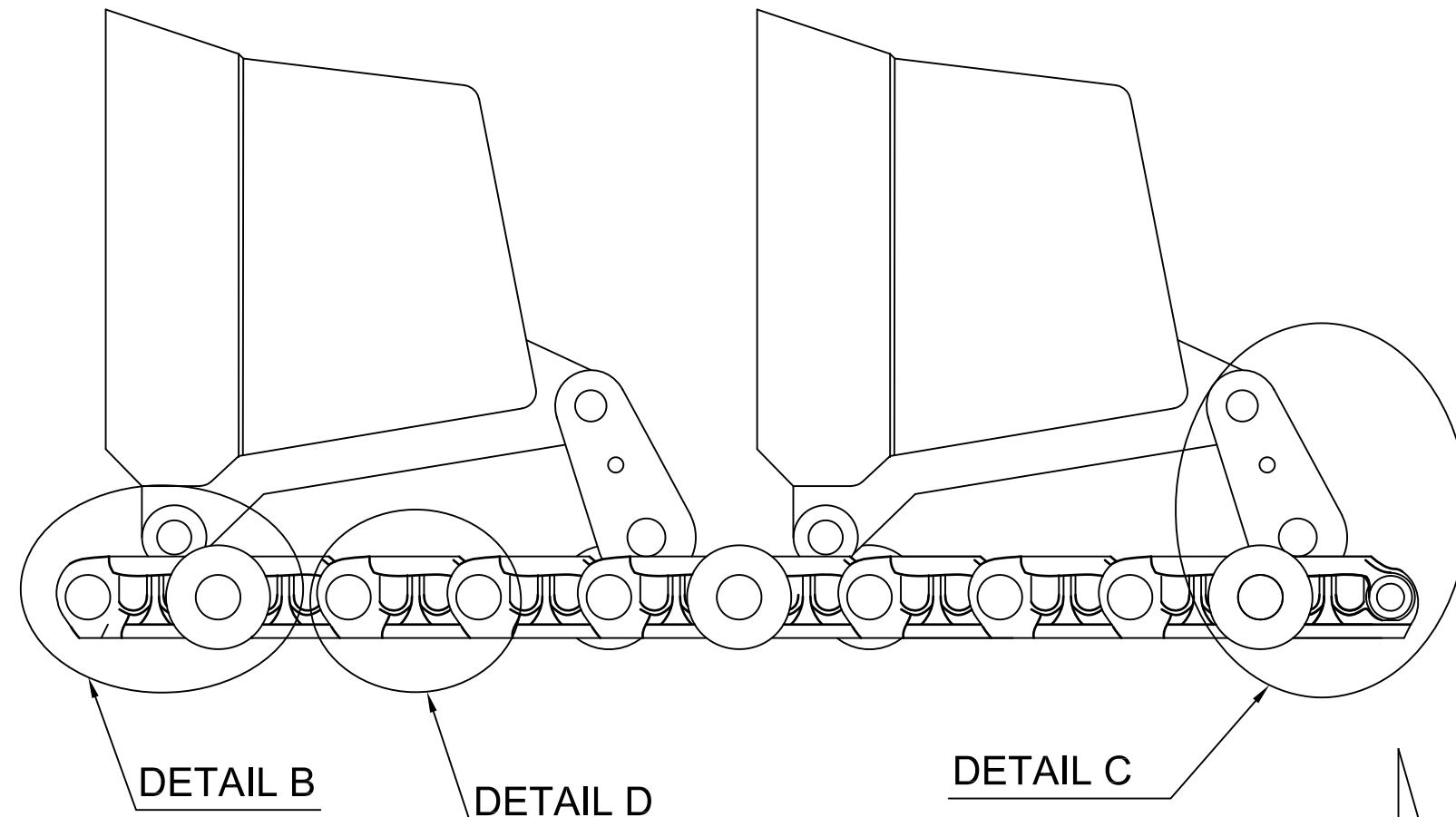
NOTE: CHAIN GUIDE ROLLER ASSEMBLY USES IDENTICAL PARTS FOR EITHER SIDE OF INSTALLATION.



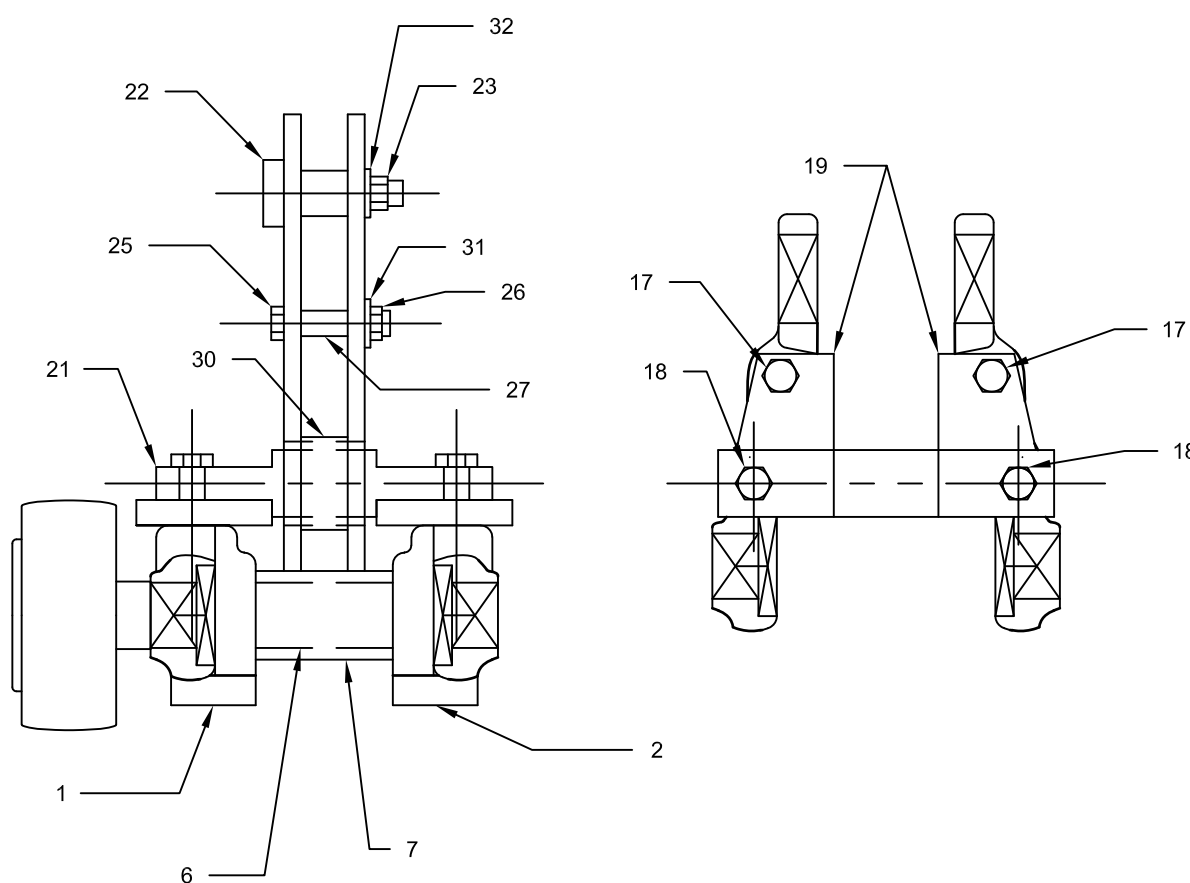
NOTE: SPROCKET MAY BE REPLACED SEGMENT BY SEGMENT WHILE ROLLING ON NEW CHAIN.



DETAIL B



VIEW A

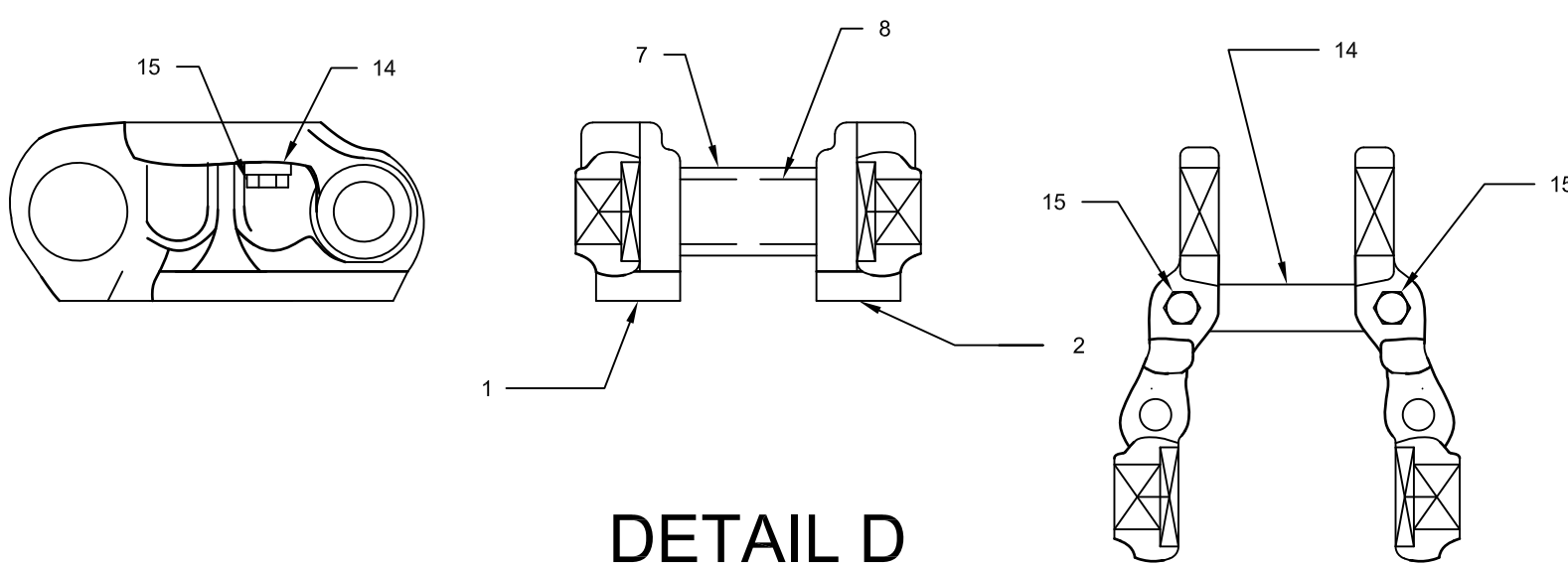
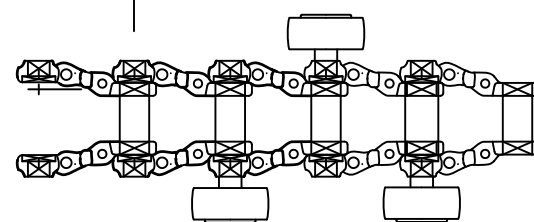


DETAIL C

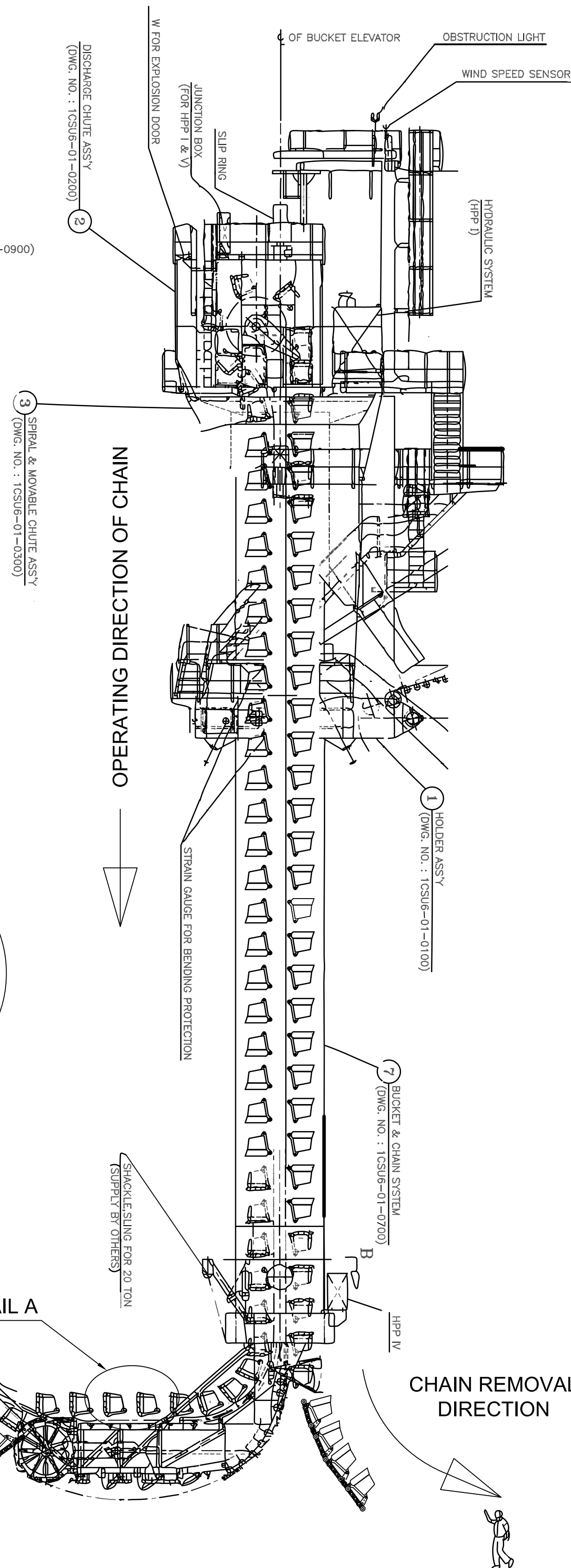
ASSEMBLY NOTES:
WHEN LOADING NEW CHAIN, BREAK THE EXISTING CHAIN AT A SECTION THAT MATCHES THE PATTERN OF THE NEW SECTION.
ASSEMBLE ALL HARDWARE AND BUCKETS ONTO THE NEW CHAIN. LOAD THE NEW CHAIN AND BUCKET ASSEMBLY BY RUNNING THE CSU IN THE REVERSE DIRECTION. CHECK THE ALIGNMENT OF THE CHAIN AS IT PROCEEDS OVER THE TOP OF THE FOOT.

CHAIN LOADING DIRECTION

NEW CHAIN EXISTING CHAIN



DETAIL D



DISASSEMBLY NOTES:
REMOVE EXISTING CHAIN AND BUCKETS BY PULLING AWAY FROM THE FOOT OF THE CSU AND PLACING ON DOCK.

- NOTES:
- DRAWING IS NOT TO SCALE AND IS PROVIDED FOR ASSEMBLY INFORMATION ONLY.
 - CHAIN LINK HARDNESS SHALL BE BRINELL 2.7-3.0
 - STANDARD ROLLER ASSEMBLY PATTERN WILL FOLLOW THE PATTERN OF TWO (2) STANDARD PINS. SEE DWG 1CSU6-02-0002.
 - ALL ITEMS LISTED IN THIS DRAWING BOM ARE PROVIDED IN QUANTITIES TO ASSEMBLE TWO 425 LINK CHAINS WITH ATTACHMENT HARDWARE AND BUCKETS. 850 LINKS OF CHAIN TOTAL.
 - FABRICATION METHODS SHALL FOLLOW THE BEST ACCEPTED PRACTICE WITHIN THE INDUSTRY AND SHALL BE IN ACCORDANCE WITHIN THE AISI "SPECIFICATION FOR DESIGN, FABRICATION AND ERECTION OF STRUCTURAL STEEL FOR BUILDING," LATEST EDITION.
 - ROLLED MATERIAL SHALL BE IN ACCORDANCE WITH THE TOLERANCES SPECIFIED IN ASTM A6. STRAIGHTENING SHALL BE DONE BY METHODS THAT WILL NOT INJURE OR WEAKEN THE MATERIAL.
 - WELDING SEQUENCE AND PROCEDURES AND WELDER AND TACKER CERTIFICATES OF QUALIFICATION SHALL BE IN ACCORDANCE WITH AWS D1.1. ONLY CERTIFIED WELDERS SHALL PERFORM THE WORK.
 - THE FOUR (4) ATTACHMENT POINTS ON THE BUCKET ARE DIMENSIONALLY CRITICAL FOR INSTALLATION. A BUCKET CAN BE LOANED TO THE SUCCESSFUL BIDDER TO INSURE DIMENSIONAL COMPLIANCE.
 - ALL ATTACHMENT BOLTS, NUTS, AND WASHERS ARE TO BE GRADE 8, ZINC PLATED.
 - NO PAINTING IS REQUIRED FOR THE COMPONENTS DURING ASSEMBLY.
 - ALL FABRICATIONS AND MATERIALS SHALL BE STAGED FOR INSTALLATION AT THE JEA FACILITY SPECIFIED IN THE SCOPE OF WORK.

BILL OF MATERIAL

ITEM	DESCRIPTION	ITEM
01	CHAIN LINK SIDE 1	850
02	CHAIN LINK SIDE 2	850
03	NA	NA
04	NA	NA
05	CHAIN GUIDE ROLLER ASSM.	410
06	40MM PIN	410
07	STANDARD ROLLER	850
08	STANDARD PIN	440
09	SMALL SPACER	880
10	LARGE SPACER	880
11	SEAL	880
12	LUBRICATION FITTING	850
13	LUBRICATION CAP	850
14	THREADED BRACKET	510
15	3/4"-10 x 1.5" BOLT	1020
16	SMALL WEDGE	170
17	3/4"-10 x 2.5" BOLT	680
18	3/4"-10 x 4.0" BOLT	680
19	LARGE WEDGE	170
20	SHORT SHAFT	170
21	LONG SHAFT	170
22	SHOULDER BOLT	170
23	1 1/8" - 7 HEX NUT	170
24	STEERING ARM	340
25	3/4"-10 x 3.5" HEX BOLT	170
26	3/4" - 10 HEX NUT	1530
27	0.78" BUSHING	170
28	1.35" BUSHING	170
29	2.00" BUSHING	340
30	STEPPED BUSHING	170
31	3/4" FLAT WASHER	170
32	1 1/8" FLAT WASHER	170
33	300L BUCKET	2
34	28 T SEGMENTAL SPROCKET	2
35	M20-1.5 X 110 DIN610 BOLTS	72
36	M20 WASHERS	72
37	M20-1.5 NUTS	72
38	DUMMY PINS	2

CONTROL NUMBER: 309529

REV	NO.	DRWN	BY	DATE	DESCRIPTION	APPR	BY
DSE-186-20-1					CSU SPROCKET REPLACEMENT		
67 059/15-1					HANJUNG ; BUCKET ELEVATOR DISP. DRIVE SHAFT		
1CSU6-01-0702					HANJUNG ; BUCKET 300L SHEET 2/2		
1CSU6-01-0702					HANJUNG ; BUCKET 300L SHEET 1/2		
1CSU6-07-0004					JE A ; CHAIN & BUCKET HARDWARE		
1CSU6-01-0703					HANJUNG ; CHAIN GUIDE ROLLER		
228-2735					CATERPILLAR ; LINE /TRACK		
1CSU6-07-0002					JE A ; CSU CHAIN ARRANGEMENT		
1CSU6-01-0001					HANJUNG ; BUCKET ELEVATOR ASSY		
1CSU6-01-0001					HANJUNG ; CSU GENERAL ARRANGEMENT		
REFERENCE DRAWINGS							

CONTINUOUS SHIP UNLOADER CHAIN, BUCKET, AND SPROCKET REPLACEMENT



JACKSONVILLE ELECTRIC AUTHORITY

NORTHSIDE GENERATING STATION

UNIT: N00
PROJECT DEF: 060-194
GEMS NO: N0#-##
SCALE: NTS
SHT. 1 OF 5

DWG. NO: 1CSU6-07-0001