ASSEMBLY INSTRUCTIONS

1. ROTOR END CLEARANCE (DISCHARGE END)

1.1 GRIND SPACERS REF XR12033-2,USING THE "DUMMY BEARING" METHOD, TO OBTAIN AN END CLEARANCE OF 0.090/0.065 AS SHOWN.

1.2 AIM FOR THE MINIMUM CLEARANCE OF 0.065 SINCE FINAL PRE-LOAD ON THRUST BEARING XR12101-3 WILL INCREASE THIS VALUE BY APPROXIMATELY 0.010mm

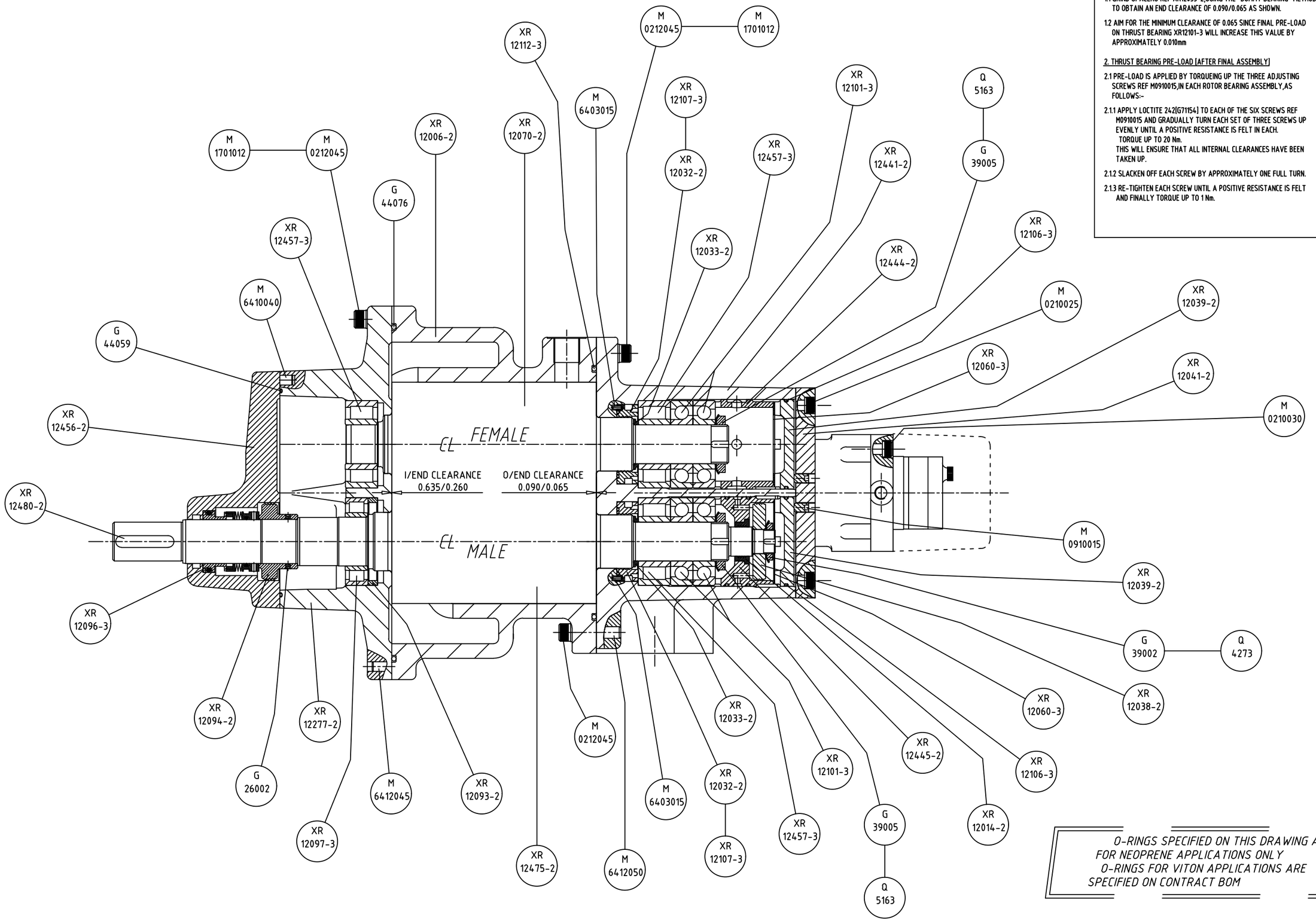
2. THRUST BEARING PRE-LOAD (AFTER FINAL ASSEMBLY)

2.1 PRE-LOAD IS APPLIED BY TORQUEING UP THE THREE ADJUSTING SCREWS REF M0910015,IN EACH ROTOR BEARING ASSEMBLY,AS FOLLOWS:-

2.1.1 APPLY LOCTITE 242(G71154) TO EACH OF THE SIX SCREWS REF M0910015 AND GRADUALLY TURN EACH SET OF THREE SCREWS UP EVENLY UNTIL A POSITIVE RESISTANCE IS FELT IN EACH.
TORQUE UP TO 20 Nm.
THIS WILL ENSURE THAT ALL INTERNAL CLEARANCES HAVE BEEN TAKEN UP.

2.1.2 SLACKEN OFF EACH SCREW BY APPROXIMATELY ONE FULL TURN.

2.1.3 RE-TIGHTEN EACH SCREW UNTIL A POSITIVE RESISTANCE IS FELT AND FINALLY TORQUE UP TO 1 Nm.



O-RINGS SPECIFIED ON THIS DRAWING ARE FOR NEOPRENE APPLICATIONS ONLY O-RINGS FOR VITON APPLICATIONS ARE SPECIFIED ON CONTRACT BOM

DO NOT SCALE FROM DRAWING.

MOD.	ZONE	MODIFICATION	SIGN DATE	MOD.	ZONE	MODIFICATION	SIGN DATE	MOD.	ZONE	MODIFICATION	SIGN DATE
9				6				3			
8				5				2			
7				4				1			

UNLIMITED MACHINED SIZES TO BE WITHIN ± 0.250

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DRN.	R.Mc	XRV/127 - R1 COMPRESSOR HORIZ / SECTIONAL ARRANGEMENT	SCALE:– 1 : 2
CHKD.	H.D.A.		DRAWING No. XR12660-0
DATE	14/05/01		MOD.

HOWDEN COMPRESSORS LIMITED, GLASGOW, U.K.