



GENERAL NOTES

1. THRUST BEARINGS ARE POSITIVELY LOCATED IN AXIAL DIRECTION BY CLAMPING PLATE (R20392) AND CAP SCREWS (G29012) WHICH ARE TORQUED TO 14NM AND WIRE LOCKED IN PAIRS, TO G29011. IN SITU ADJUSTMENT IS NOT REQUIRED
2. OUTLET END CLEARANCE: THE CLEARANCE BETWEEN THE ROTOR END PLANES AND THE OUTLET END FACE OF THE MAIN CASING IS SET BY GRINDING THE BALANCE PISTONS (R20552) AND (R20572). WHEN MEASURING THIS CLEARANCE THE ROTORS ARE TO BE PUSHED TOWARDS THE INLET END
3. ALL SCREWS ARE TO BE TIGHTENED UP IN ACCORDANCE WITH WSI NO.27 - CLASS 1 UNLESS OTHERWISE STATED
4. ALL LOCKNUTS ARE TO BE TIGHTENED UP IN ACCORDANCE WITH WSI NO.136 UNLESS OTHERWISE STATED

TABLE 3 - ROTOR END CLEARANCES

L/D RATIO	TOTAL CLEARANCE	OUTLET END
1.10	0.570/0.350	0.075/0.050
1.45	0.600/0.400	0.075/0.050
1.65	0.630/0.410	0.075/0.050
1.93	0.660/0.440	0.075/0.050

TABLE 2 - BAL. PISTON DETAILS

V1 RATIO	BALANCE PISTON	B/PISTON SLEEVE
2.1	R20732	R20532
2.6	R20732	R20532
3.6	R20742	R20402
5.0	R20752	R20412

TABLE 1 - CASING AND ROTOR DETAILS

L/D RATIO	MAIN CASING	MALE ROTOR	FEMALE ROTOR
1.10	R20190	R20654	R20655
1.45	R20170	R20664	R20665
1.65	R20200	R20674	R20675
1.93	R20210	R20684	R20685

NO.	MOD.	ZONE	MODIFICATION	DATE	NO.	MOD.	ZONE	MODIFICATION	DATE
9					6				
8					5				
7					4				

UNLIMITED MACHINED SIZES TO BE WITHIN

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DRW. GH
CHKD.
DATE 2004/01/10

WRV204/RANGE COMPRESSOR
H/SECTIONAL ARRANGEMENT

SCALE:-
DRAWING No. R20917

HOWDEN COMPRESSORS LIMITED, GLASGOW, UK.