

SLIDE VALVE STOP
[SEE TABLE 1]

SLIDE VALVE
[SEE TABLE 2
& NOTE 4]

PISTON ROD
[SEE TABLE 1]

INJECTION TUBE
[SEE TABLE 1]

GENERAL NOTES

1. FOR INSTRUMENTATION SEE BILL OF MATERIALS.
2. AFTER ALIGNMENT OF INJECTION TUBE AND CAP SCREWS, DRILL 2-OFF 6.8mm DIA x 5/16" DEEP HOLES IN COVER USING 2 HOLES IN FLANGE AS DRILL JIG. REAM TO 0.3128"/0.3126" AND FIT DOWELS. [CHECK THAT WITHDRAWAL HOLES IN TUBE CORRESPOND WITH SPOTFACES IN COVER BEFORE FITTING].
3. C-DESIGNATED UNITS HAVE PLUGGED/UNDRILLED OIL INJECTION HOLES IN SLIDE VALVE.
4. REFRIGERANT TYPE LOCTITE TO BE USED WHEN FITTING PTFE SLEEVE INTO PISTON ROD. AFTER ASSEMBLY, CLEARANCE BETWEEN BORE OF PTFE SLEEVE AND INJECTION TUBE TO BE CHECKED TO ENSURE A DIAMETRAL CLEARANCE OF 0.050/0.025mm IS ACHIEVED.
5. DRILL AND REAM TO 0.2506"/0.2503" AFTER ADJUSTMENT OF THE ANGULAR POSITION OF SLIDE VALVE.

G 26029 TO BE COATED WITH REFRIGERANT TYPE LOCTITE

R 20204 SEE NOTE 5

G 34049 SEE NOTE 3

G 44034

G 25058

R 20184

G 46013

G 36009

R 25885

G 34015 SEE NOTE 6

G 46018

R 25655

R 20085

G 39007

G 44020

R 25093

G 21032

G 46014

R 25055

Q 5163

R 25145

G 44001

G 32014

G 33008

R 25065

ACTUATOR CYLINDER
[SEE TABLE 1]

ACTUATOR STOP
[SEE TABLE 1]

ACTUATOR SPINDLE
[SEE TABLE 1]

G 25004

R 25133

G 25011

R 25012

G 51001

G 44005

G 60004

G 60005

G 26019

G 46014

G 25029

G 44075

G 33008

R 25125

G 44002

R 25094

R 25353

TABLE 2 - SLIDE VALVE DETAILS

L/D RATIO	Vi = 2.1	Vi = 2.6	Vi = 3.6	Vi = 5.0
1.10	R25693	R25703	R25723	R25811
1.30	R25421	R25351	R25361	R25371
1.45	R25341	R25321	R25331	R25391
1.65	R25341	R25321	R25331	R25391
1.93	R25651	R25641	R25631	R25621
2.20	R25702	R25530	R25550	R25570

TABLE 1 - SLIDE VALVE/CAPACITY CONTROL ASSEMBLY DETAILS

L/D RATIO	S'VALVE STOP	INJECTION TUBE	PISTON ROD	ACTUATOR CYLINDER	ACTUATOR SPINDLE	ACTUATOR STOP
1.10	R25683	R25801	R25431	R25112	R20034	R25673
1.30	R25441	R25042	R25431	R25112	R20034	R25233
1.45	R25381	R25292	R25173	R25112	R20034	R25535
1.65	R25252	R25033	R25173	R25112	R20034	R25535
1.93	R25711	R25033	R25661	R25112	R20034	R25535
2.20	R25512	R25043	R25053	R25511	R25714	R25535

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. GH
CHKD.
DATE 95.08.25

WRV(T)255 RANGE COMPRESSOR
V/SECTIONAL ARRANGEMENT

SCALE:-
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