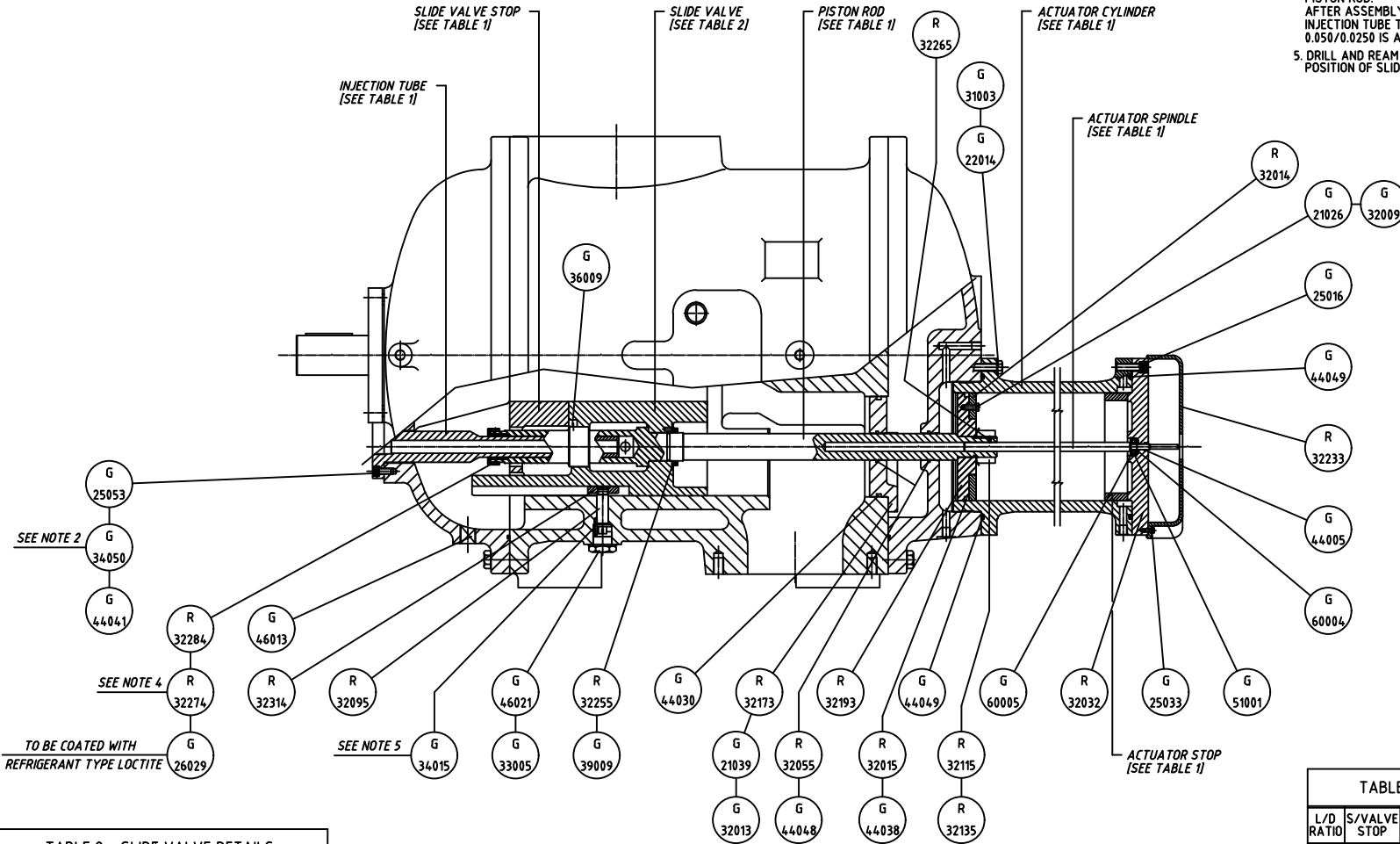


GENERAL NOTES

- FOR INSTRUMENTATION SEE BILL OF MATERIALS.
- AFTER ALIGNMENT OF INJECTION TUBE AND CAP SCREWS, DRILL 2-OFF 8.4 DIA x 13 DEEP HOLES IN COVER USING 2 HOLES IN FLANGE AS DRILL JIG. REAM TO 9.532/9.528 DIA AND FIT DOWELS (CHECK THAT WITHDRAWAL HOLES IN TUBE CORRESPOND WITH SPOTFACES IN COVER PRIOR TO FITTING).
- C-DESIGNATED UNITS HAVE PLUGGED/UNDRILLED OIL INJECTION HOLES IN SLIDE VALVE.
- 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 0.050/0.0250 IS ACHIEVED.
- DRILL AND REAM TO 0.2506"/0.2503" AFTER ADJUSTMENT OF THE ANGULAR POSITION OF SLIDE VALVE.



L/D RATIO	Vi = 2.1	Vi = 2.6	Vi = 3.6	Vi = 5.0
1.32	R32101	R32192	R32232	R32252
1.65	R32220	R32050	R32070	R32230
1.93	R32282	R32342	R32332	R32312
2.20	R32704	R32752	R32762	R32772

L/D RATIO	S/VALVE STOP	INJECTION TUBE	PISTON ROD	ACTUATOR CYLINDER	ACTUATOR SPINDLE	ACTUATOR STOP
1.32	R32212	R32223	R32313	R32031	R32174	R32344
1.65	R32012	R32203	R32163	R32031	R32174	R32034
1.93	R32292	R32533	R32523	R32031	R32174	R32034
2.20	R32712	R32802	R32792	R32732	R32794	R32034

9		6		3		UNLIMITED MACHINED SIZES TO BE WITHIN 5	THIS DRAWING IS CONFIDENTIAL AND IS THE PROPERTY OF HOWDEN COMPRESSORS LTD. THE DRAWING OR ANY PART THEREOF MUST NOT BE COPIED OR OTHERWISE REPRODUCED, OR INVALED TO ANY OTHER PARTY OR USED FOR MANUFACTURE OR ANY OTHER PURPOSE WITHOUT THE EXPRESS WRITTEN PERMISSION OF THE COMPANY. DRW. GH CHD. DATE 95.11.14 WRV(H)/321-RANGE COMPRESSOR V/SECTIONAL ARRANGEMENT SCALE- DRAWING No. R32877 HOWDEN COMPRESSORS LIMITED, GLASGOW, U.K.
8		5		2			
7		4		1			
MOD. ZONE	MODIFICATION	DATE	MOD. ZONE	MODIFICATION	DATE		