



- GENERAL NOTES**
- ADJUSTMENT OF THRUST BALL BEARINGS.
SPIGOT FACE OF REVERSE THRUST PLATES R25674 AND R25614 TO BE GRIND SO THAT THE OUTER RACE AXIAL FIT ON THE BEARINGS IN THE HOUSING IS $-0.100/-0.038$.
 - OUTLET END CLEARANCE
THE CLEARANCE BETWEEN THE ROTOR END PLANES AND THE OUTLET END FACE OF THE MAIN CASING IS SET BY GRINDING THE THRUST WASHERS REFERENCE R25135.
WHEN MEASURING THIS CLEARANCE THE ROTORS ARE TO BE PUSHED TOWARDS THE INLET END
 - ALL SCREWS ARE TO BE TIGHTENED UP IN ACCORDANCE WITH WSI NO.27 - CLASS 1 UNLESS OTHERWISE STATED
 - ALL LOCKNUTS ARE TO BE TIGHTENED UP IN ACCORDANCE WITH WSI NO.136 UNLESS OTHERWISE STATED
 - CAP SCREWS IN PART R25634 TO BE CAREFULLY TIGHTENED TO 20Nm TO AVOID DISTORTION OF SEAL.

TABLE 3 - ROTOR END CLEARANCES

L/D	TOTAL	D/END [STD]	D/END [L-DES]
1.10	0.670/0.468	0.100/0.075	0.075/0.050
1.30	0.700/0.500	0.100/0.075	0.075/0.050
1.45	0.750/0.550	0.100/0.075	0.075/0.050
1.65	0.830/0.579	0.100/0.075	0.075/0.050
1.93	1.150/0.850	0.100/0.075	0.075/0.050
2.20	1.100/0.800	0.250/0.200	0.075/0.050

TABLE 2 - BAL.PISTON DETAILS

Vi	PISTON	SLEEVE
2.1	R25853	-
2.6	R25853	-
3.6	R25823	R25815
5.0	R25843	R25064

TABLE 1 - CASING AND ROTOR DETAILS

L/D	CASING	M/ROTOR	F/ROTOR
1.10	R25110	R25882	R25892
1.30	R25710	R25902	R25912
1.45	R25690	R25922	R25932
1.65	R25430	R25942	R25952
1.93	R25750	R25962	R25972
2.20	R25510	R25982	R25992

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(H)/255-RANGE COMPRESSOR
H/SECTIONAL ARRANGEMENT

SCALE:-
DRAWING No. R251167
MOD.

HOWDEN COMPRESSORS LIMITED, GLASGOW, U.K.