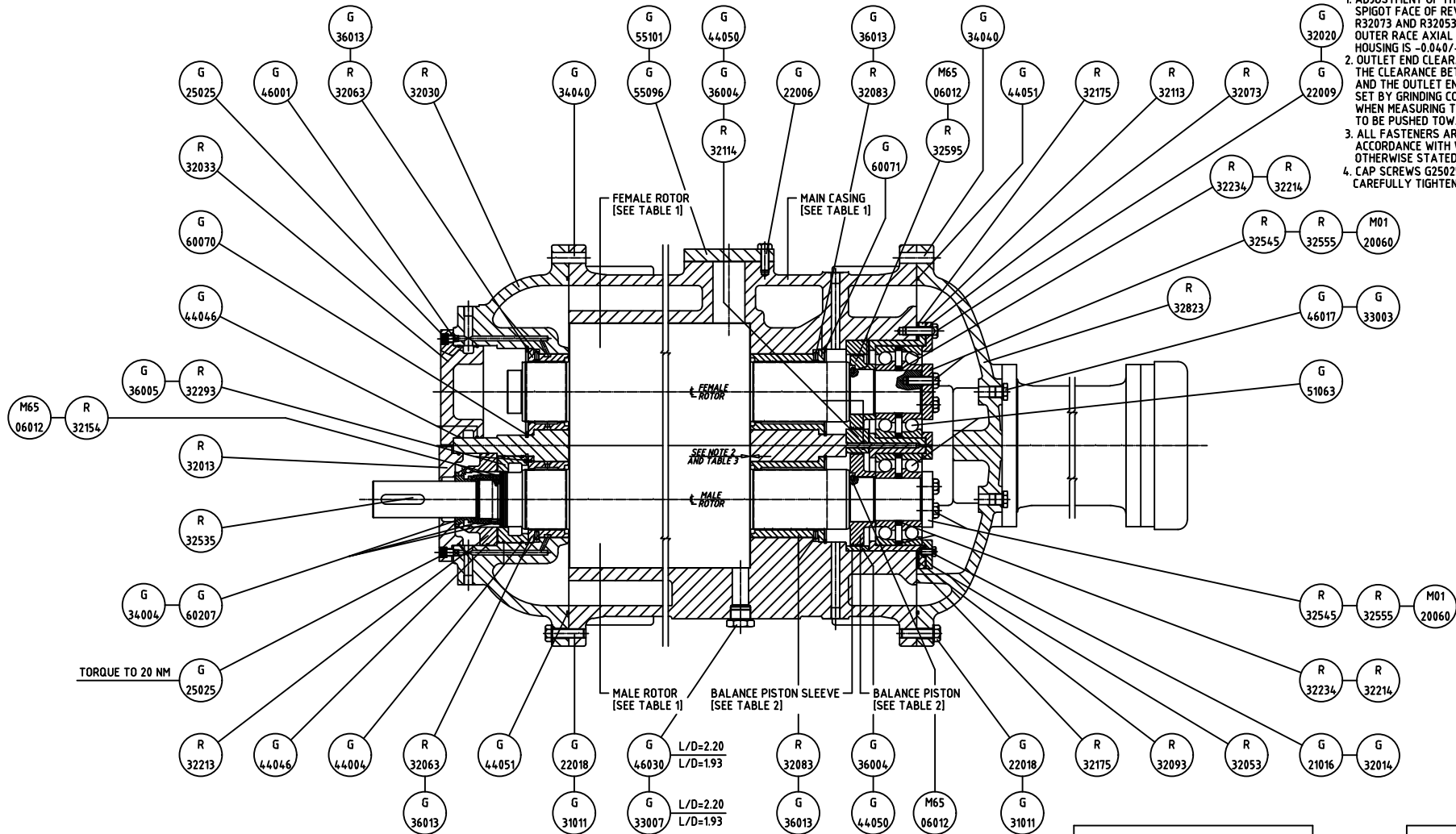


**GENERAL NOTES**

- ADJUSTMENT OF THRUST BEARINGS  
- SPIGOT FACE OF REVERSE THRUST PLATES R32073 AND R32053 TO BE GROUND SO THAT THE OUTER RACE AXIAL FIT OF BEARINGS IN THEIR HOUSING IS  $-0.04/0 - 0.010$ .
- OUTLET END CLEARANCE  
THE CLEARANCE BETWEEN THE ROTOR END PLANES AND THE OUTLET END FACE OF THE MAIN CASING IS SET BY GRINDING COMPONENTS R32175. WHEN MEASURING THIS CLEARANCE THE ROTORS ARE TO BE PUSHED TOWARDS THE INLET END.
- ALL FASTENERS ARE TO BE TIGHTENED UP IN ACCORDANCE WITH WSI NO.27 - CLASS 1 UNLESS OTHERWISE STATED.
- CAP SCREWS G25025 IN COMPONENT R32013 TO BE CAREFULLY TIGHTENED TO AVOID DISTORTING SEAL.



**TABLE 3 - ROTOR END CLEARANCES**

L/D RATIO	TOTAL CLEARANCE	OUTLET END CLEARANCE (STD)	OUTLET END CLEARANCE (L-DES)
1.32	1.120/0.900	0.350/0.300	0.250/0.200
1.65	1.170/0.940	0.350/0.300	0.250/0.200
1.93	1.350/1.070	0.350/0.300	0.250/0.200
2.20	1.430/1.150	0.350/0.300	0.250/0.200

**TABLE 2 - BALANCE PISTON DETAILS**

V <sub>i</sub> RATIO	BALANCE PISTON		BAL. PISTON SLEEVE	
	WRV	WRVH	WRV	WRVH
2.1	R32664	R32654	R32074	R32184
2.6	R32664	R32654	R32074	R32184
3.6	R32664	R32664	R32074	R32074
5.0	R32664	R32674	R32074	R32224

**TABLE 1 - CASING/ROTOR DETAILS**

L/D RATIO	MAIN CASING	MALE ROTOR	FEMALE ROTOR
1.32	R32710	R32375	R32385
1.65	R32730	R32395	R32405
1.93	R32370	R32415	R32425
2.20	R32770	R32435	R32445

L/D=2.20  
L/D=1.93  
L/D=2.20  
L/D=1.93  
L/D=1.65  
L/D=1.32  
L/D=1.65  
L/D=1.32

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

UNLIMITED MACHINED SIZES TO BE WITHIN

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 INVOLVED TO ANY OTHER PARTY OR USED FOR MANUFACTURE OR ANY OTHER PURPOSE WITHOUT THE EXPRESS WRITTEN PERMISSION OF THE COMPANY.

**WRV(H)/321-RANGE COMPRESSOR**  
H/SECTIONAL ARRANGEMENT

SCALE - DRAWING No. R32867

DATE 06.01.96

HOWDEN COMPRESSORS LIMITED, GLASGOW, U.K.