

GENERAL NOTES

1. OUTLET END CLEARANCE
 - 1.1 WITH ROTOR HARD TO INLET SET OUTLET END CLEARANCE TO TABLE 3, MACHINING MALE AND FEMALE ADJUSTING RINGS R25332 AND R25222 RESPECTIVELY.
 - 1.2 SET TH/BEARING CLEARANCE:- L/D=1.10/1.30/1.60/0.140J AND L/D=1.45/1.65/1.93/2.20/0.190/0.170J BY MACHINING MALE AND FEMALE THRUST BEARING ADJUSTING RINGS R25202 AND R25212 RESPECTIVELY.
 - 1.3 WITH ROTORS HARD TO OUTLET CHECK THAT OUTLET END CLEARANCE IS 0.055/0.025.
2. ALL SCREWS USED IN THRUST ASSEMBLY TO BE COATED WITH LOCTITE 242[G71154].
3. ALL FASTENERS ARE TO BE TIGHTENED UP IN ACCORDANCE WITH WSI NO.27 - CLASS 1 UNLESS OTHERWISE STATED.
4. CAP SCREWS G29007 IN COMPONENT R25372 TO BE CAREFULLY TIGHTENED TO AVOID DISTORTING SEAL.

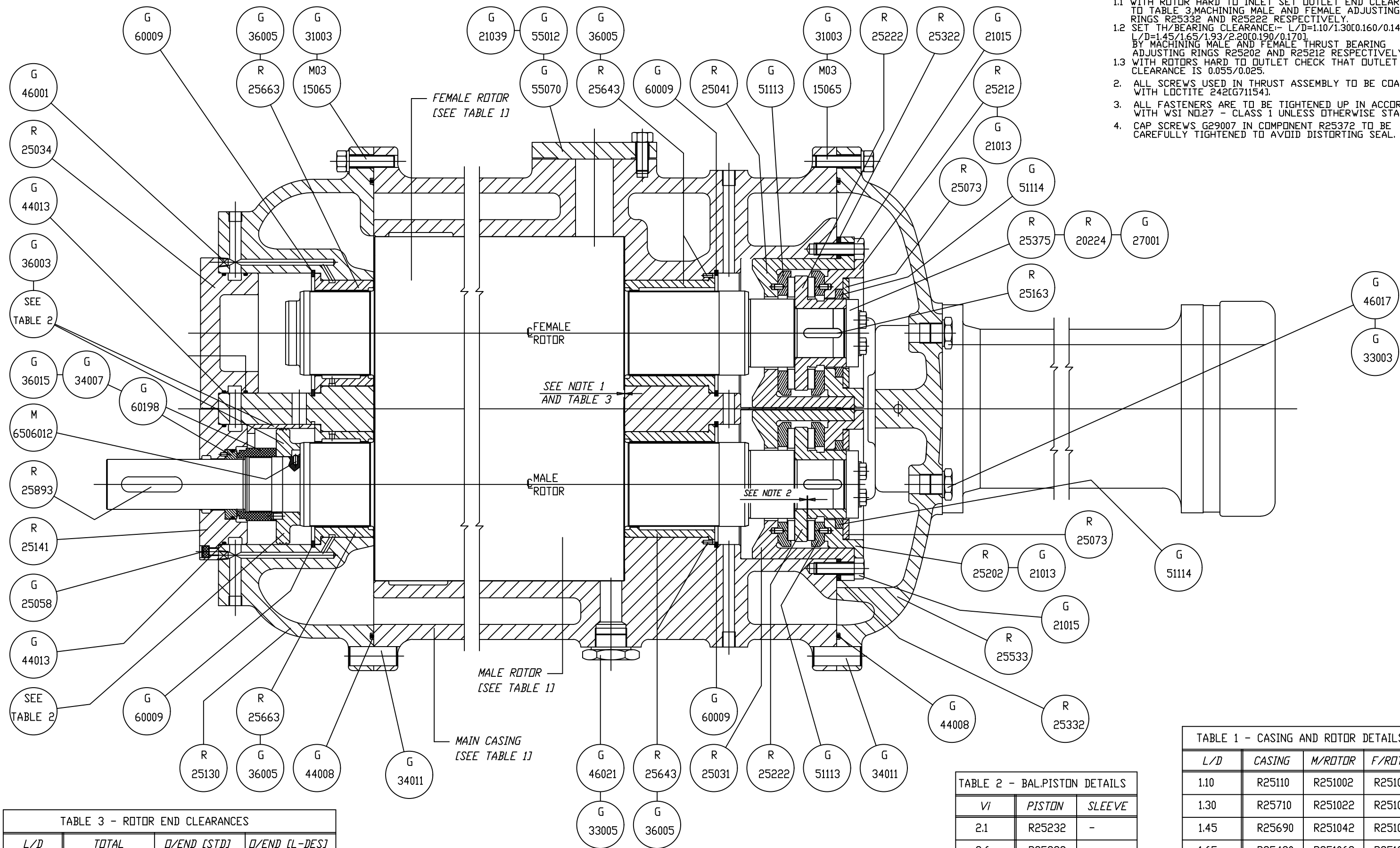


TABLE 3 - ROTOR END CLEARANCES

L/D	TOTAL	Ø/END [STD]	Ø/END [L-DES]
1.10	0.870/0.668	0.210/0.180	0.210/0.180
1.30	0.900/0.700	0.210/0.180	0.210/0.180
1.45	0.950/0.750	0.250/0.220	0.230/0.200
1.65	1.030/0.779	0.250/0.220	0.230/0.200
1.93	1.350/1.050	0.250/0.220	0.230/0.200
2.20	1.300/1.000	0.250/0.220	0.230/0.200

TABLE 2 - BAL.PISTON DETAILS

VI	PISTON	SLEEVE
2.1	R25232	-
2.6	R25232	-
3.6	R25232	-
5.0	R25282	R25302

TABLE 1 - CASING AND ROTOR DETAILS

L/D	CASING	M/ROTOR	F/ROTOR
1.10	R25110	R251002	R251012
1.30	R25710	R251022	R251032
1.45	R25690	R251042	R251052
1.65	R25430	R251062	R251072
1.93	R25750	R251082	R251092
2.20	R25510	R251102	R251112

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

UNLIMITED MACHINED SIZES TO BE WITHIN ± 0.250

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DRN. GH
CHKD.
DATE 95.09.12

WRVT/255-RANGE COMPRESSOR
H/SECTIONAL ARRANGEMENT

SCALE:-
DRAWING No. R251187

HOWDEN COMPRESSORS LIMITED, GLASGOW, U.K.