



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 R32463 AND R32473 RESPECTIVELY.
- 1.2 SET THRUST BEARING CLEARANCE FOR WRV=0.260/0.240 WLV=0.210/0.190 BY MACHINING MALE AND FEMALE THRUST BEARING ADJUSTING RINGS R32483 AND R32493 RESPECTIVELY.
- 1.3 WITH ROTORS HARD TO OUTLET CHECK THAT OUTLET END CLEARANCE IS 0.110/0.040.
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 G25025 IN COMPONENT R32333 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	0.300/0.250
1.65	1.170/0.940	0.350/0.300	0.300/0.250
1.93	1.350/1.070	0.350/0.300	0.300/0.250
2.20	1.430/1.150	0.350/0.300	0.300/0.250

TABLE 2 - BAL. PISTON DETAILS

Vi	PISTON	SLEEVE
2.1	R32543	-
2.6	R32543	-
3.6	R32543	-
5.0	R32563	R32573

TABLE 1 - CASING/ROTOR DETAILS

L/D RATIO	MAIN CASING	MALE ROTOR	FEMALE ROTOR
1.32	R32710	R32455	R32465
1.65	R32730	R32475	R32485
1.93	R32370	R32495	R32505
2.20	R32770	R32515	R32525

9	6	3	UNLIMITED MACHINED SIZES TO BE WITHIN	<small>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.</small>
8	5	2		<small>DRW. GH</small> <small>CHD.</small> <small>DATE 06.01.96</small>
7	4	1	WRVT/321-RANGE COMPRESSOR H/SECTIONAL ARRANGEMENT	<small>SCALE-</small> <small>DRAWING No.</small> R32887
MOD. ZONE	MOD. ZONE	MOD. ZONE	<small>HOWDEN COMPRESSORS LIMITED, GLASGOW, U.K.</small>	<small>MOD.</small>