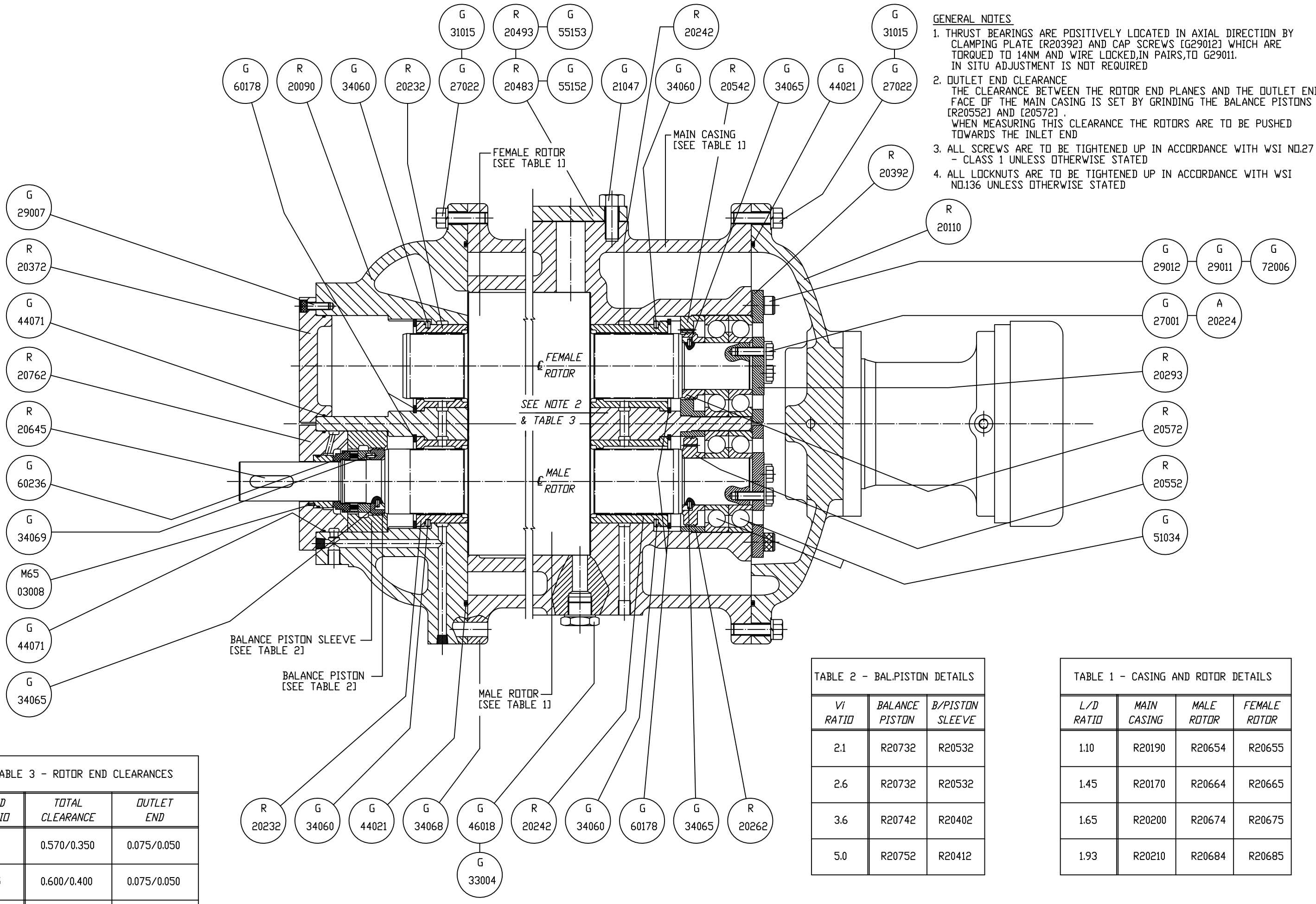


GENERAL NOTES

1. THRUST BEARINGS ARE POSITIVELY LOCATED IN AXIAL DIRECTION BY CLAMPING PLATE [R20392] AND CAP SCREWS [G29012] WHICH ARE TORQUED TO 14NM AND WIRE LOCKED,IN PAIRS,TO G29011. IN SITU ADJUSTMENT IS NOT REQUIRED
2. OUTLET END CLEARANCE
   THE CLEARANCE BETWEEN THE ROTOR END PLANES AND THE OUTLET END FACE OF THE MAIN CASING IS SET BY GRINDING THE BALANCE PISTONS [R20552] AND [20572] .
   WHEN MEASURING THIS CLEARANCE THE ROTORS ARE TO BE PUSHED TOWARDS THE INLET END
3. ALL SCREWS ARE TO BE TIGHTENED UP IN ACCORDANCE WITH WSI NO.27 - CLASS 1 UNLESS OTHERWISE STATED
4. ALL LOCKNUTS ARE TO BE TIGHTENED UP IN ACCORDANCE WITH WSI NO.136 UNLESS OTHERWISE STATED

TABLE 3 - ROTOR END CLEARANCES

| *L/D RATIO* | *TOTAL CLEARANCE* | *OUTLET END* |
|---|---|---|
| 1.10 | 0.570/0.350 | 0.075/0.050 |
| 1.45 | 0.600/0.400 | 0.075/0.050 |
| 1.65 | 0.630/0.410 | 0.075/0.050 |
| 1.93 | 0.660/0.440 | 0.075/0.050 |

TABLE 2 - BAL.PISTON DETAILS

| *Vi RATIO* | *BALANCE PISTON* | *B/PISTON SLEEVE* |
|---|---|---|
| 2.1 | R20732 | R20532 |
| 2.6 | R20732 | R20532 |
| 3.6 | R20742 | R20402 |
| 5.0 | R20752 | R20412 |

TABLE 1 - CASING AND ROTOR DETAILS

| *L/D RATIO* | *MAIN CASING* | *MALE ROTOR* | *FEMALE ROTOR* |
|---|---|---|---|
| 1.10 | R20190 | R20654 | R20655 |
| 1.45 | R20170 | R20664 | R20665 |
| 1.65 | R20200 | R20674 | R20675 |
| 1.93 | R20210 | R20684 | R20685 |

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

UNLIMITED MACHINED SIZES TO BE WITHIN ±

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|---|---|
| DRN. | GH |
| CHKD. | |
| DATE | 99.01.18 |

WRV204/RANGE COMPRESSOR
H/SECTIONAL ARRANGEMENT

SCALE:-
DRAWING No. R20917
MOD.

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