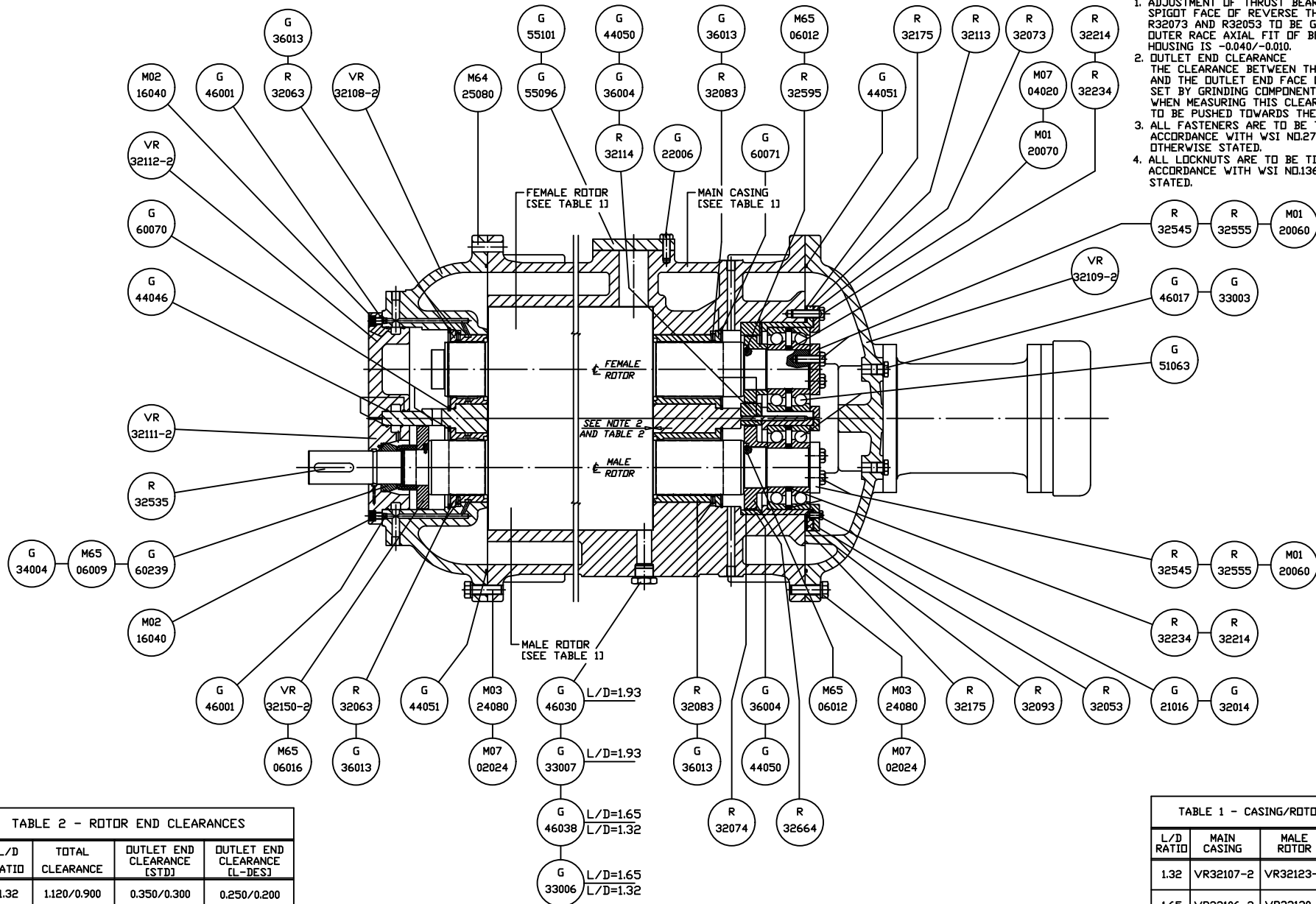


**GENERAL NOTES**

- ADJUSTMENT OF THRUST BEARINGS  
SPIGOT FACE OF REVERSE THRUST PLATES R32073 AND R32053 TO BE GRIND SO THAT THE OUTER RACE AXIAL FIT OF BEARINGS IN THEIR HOUSING IS  $-0.040/-0.010$ .
- 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.
- ALL LOCKNUTS ARE TO BE TIGHTENED UP IN ACCORDANCE WITH WSI NO.136 UNLESS OTHERWISE STATED.



**TABLE 2 - 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      | 1.120/0.900     | 0.350/0.300                | 0.250/0.200                  |
| 1.93      | 1.350/1.000     | 0.350/0.300                | 0.250/0.200                  |

**TABLE 1 - CASING/ROTOR DETAILS**

| L/D RATIO | MAIN CASING | MALE ROTOR | FEMALE ROTOR |
|-----------|-------------|------------|--------------|
| 1.32      | VR32107-2   | VR32123-2  | VR32124-2    |
| 1.65      | VR32106-2   | VR32120-2  | VR32121-2    |
| 1.93      | VR32105-2   | VR32117-2  | VR32118-2    |

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

UNLIMITED MACHINED SIZES TO BE WITHIN 2.

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DRN: GH  
CHKD:  
DATE: JAN 2001

VRV1/321-RANGE COMPRESSOR  
H/SECTIONAL ARRANGEMENT

SCALE:-  
DRAWING No. VR32101-0

HOWDEN COMPRESSORS LIMITED, GLASGOW, UK.