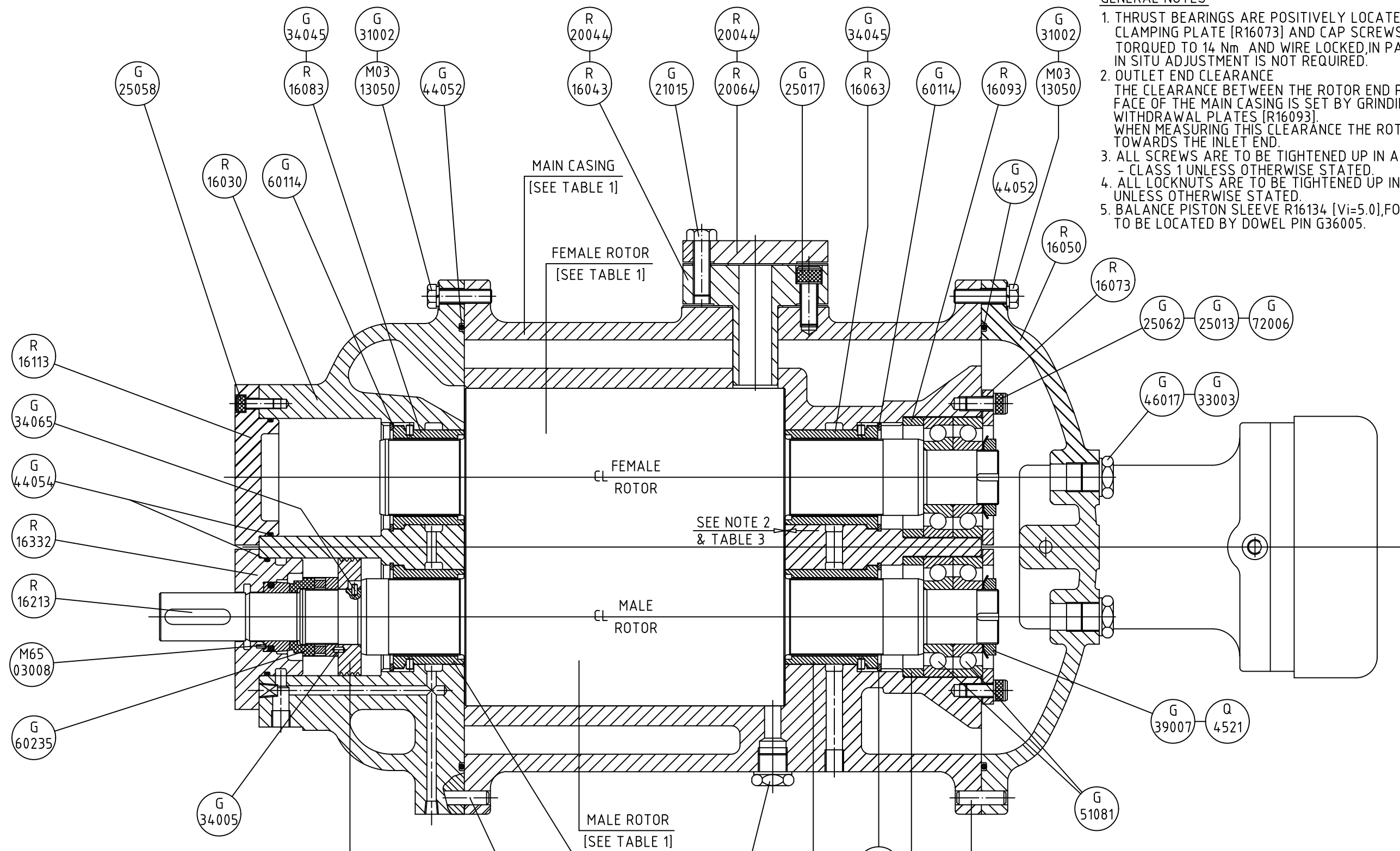


**GENERAL NOTES**

1. THRUST BEARINGS ARE POSITIVELY LOCATED IN AXIAL DIRECTION BY CLAMPING PLATE [R16073] AND CAP SCREWS [G25062] WHICH ARE TORQUED TO 14 Nm AND WIRE LOCKED, IN PAIRS, TO G25013. 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 THRUST BEARING WITHDRAWAL PLATES [R16093]. 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.
5. BALANCE PISTON SLEEVE R16134 [Vi=5.0], FOR WRVH MACHINES, TO BE LOCATED BY DOWEL PIN G36005.



**TABLE 2 - BALANCE PISTON DETAILS**

Vi RATIO	BALANCE PISTON		BAL.PISTON SLEEVE	
	WRV	WRVH	WRV	WRVH
2.1	R16074	R16074	-	-
2.6	R16074	R16074	-	-
3.6	R16074	R16074	-	-
5.0	R16074	R16064	-	R16134

**TABLE 3 - ROTOR END CLEARANCES**

L/D RATIO	TOTAL CLEARANCE	OUTLET END
1.45	0.575/0.375	0.075/0.050
1.80	0.590/0.390	0.075/0.050

**TABLE 1 - CASING AND ROTOR DETAILS**

L/D RATIO	MAIN CASING	MALE ROTOR	FEMALE ROTOR
1.45	R16070	R16105	R16115
1.80	R16010	R16125	R16135

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

UNLIMITED MACHINED SIZES TO BE WITHIN ± 0.250

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DRN. GH  
CHKD.  
DATE 99.01.18

WRV[H]163/RANGE COMPRESSOR  
H/SECTIONAL ARRANGEMENT

SCALE:-  
DRAWING No. R16367  
MOD.

HOWDEN COMPRESSORS LIMITED, GLASGOW, U.K.