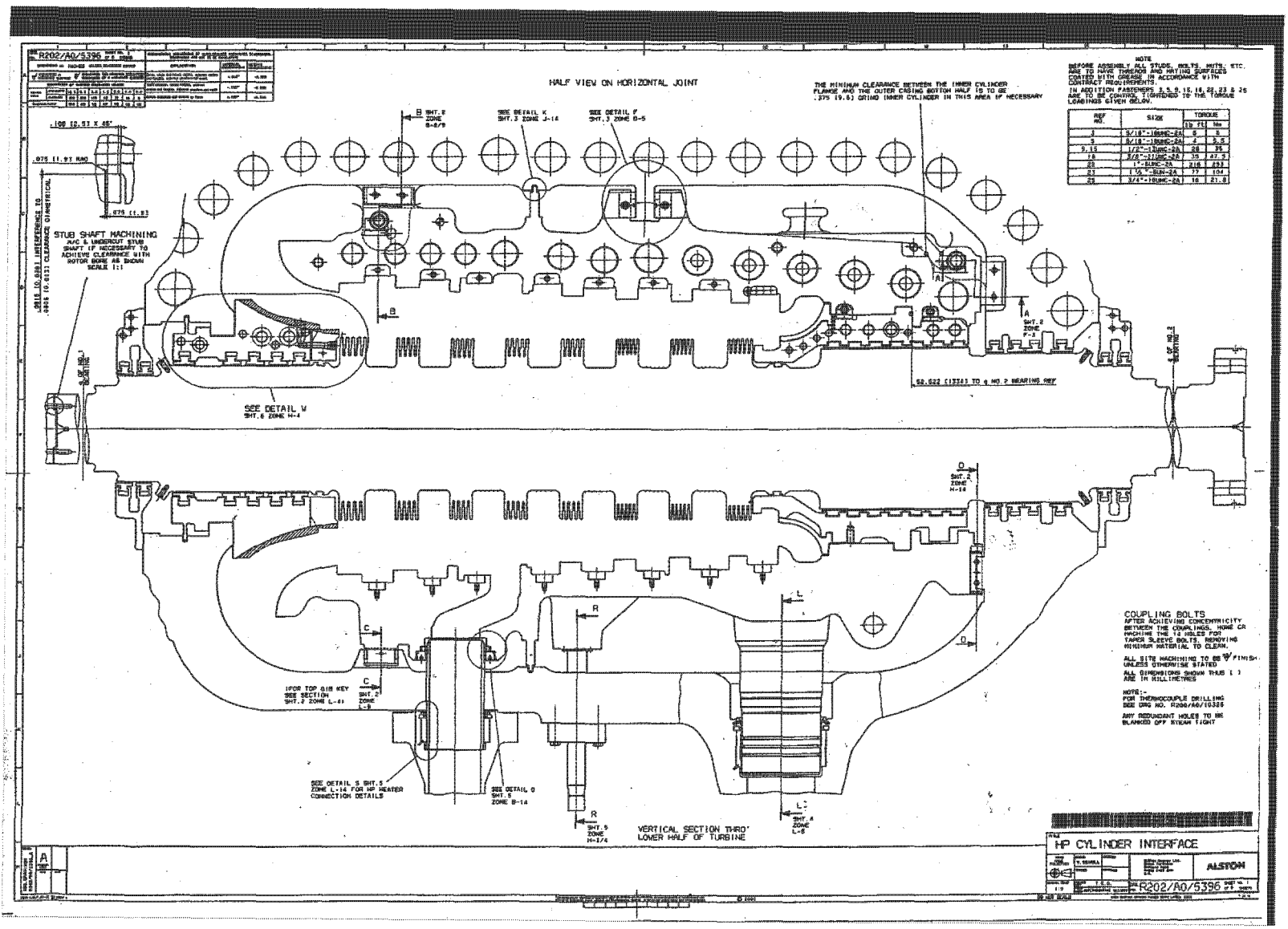
R202/A0/5396
HALF VIEW ON HORIZONTAL JOINT
THE MINIMUM CLEARANCE BETWEEN THE INNER CYLINDER FLANGE AND THE OUTER CASING BOTTOM HALF IS TO BE .375 (9.5) GRIND INNER CYLINDER IN THIS AREA IF NECESSARY
NOTE
BEFORE ASSEMBLY ALL STUDS, BOLTS, NUTS, ETC. ARE TO HAVE THREADS AND MATING SURFACES COATED WITH GREASE IN ACCORDANCE WITH CONTRACT REQUIREMENTS.
IN ADDITION FASTENERS 3, 5, 9, 15, 16, 22, 23 & 25 ARE TO BE CONTROL TIGHTENED TO THE TORQUE LOADINGS GIVEN BELOW.
REF NO. | SIZE | TORQUE lb ft | Nm
3 | 5/16"-18UNC-2A | 6 | 8
5 | 5/16"-18UNC-2A | 4 | 5.5
9, 15 | 1/2"-13UNC-2A | 28 | 35
16 | 3/8"-11UNC-2A | 35 | 47.5
22 | 1"-8UNC-2A | 216 | 293
23 | 1 1/2"-8UN-2A | 77 | 104
25 | 3/4"-10UNC-2A | 16 | 21.8
.100 (2.53 X 45°
.075 (1.93 RAD
.075 (1.93
STUB SHAFT MACHINING
A/C & UNDERCUT STUB SHAFT IF NECESSARY TO ACHIEVE CLEARANCE WITH ROTOR BORE AS SHOWN SCALE 1:1
.0015 (0.038) INTERFERENCE TO .0005 (0.013) CLEARANCE DIAMETRICAL
SEE DETAIL K SHT.3 ZONE J-14
SEE DETAIL F SHT.3 ZONE D-5
SEE DETAIL W SHT.6 ZONE H-4
SEE DETAIL S SHT.5 ZONE L-14 FOR HP HEATER CONNECTION DETAILS
SEE DETAIL O SHT.5 ZONE B-14
VERTICAL SECTION THRO' LOWER HALF OF TURBINE
COUPLING BOLTS
AFTER ACHIEVING CONCENTRICITY BETWEEN THE COUPLINGS, HOWE CR MACHINE THE 14 HOLES FOR TAPER SLEEVE BOLTS, REMOVING MINIMUM MATERIAL TO CLEAN.
ALL SITE MACHINING TO BE FINISH UNLESS OTHERWISE STATED
ALL DIMENSIONS SHOWN THUS [ ] ARE IN MILLIMETRES
NOTE:-
FOR THERMOCOUPLE DRILLING SEE DRG NO. R200/A0/10326
ANY REDUNDANT HOLES TO BE BLANKED OFF STEAM TIGHT
HP CYLINDER INTERFACE
ALSTON
R202/A0/5396

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