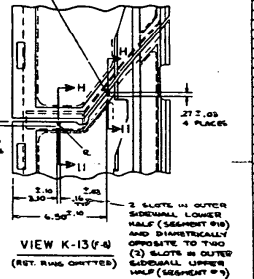


- NOTES:**
- DO NOT USE ANTI-SIETS PER ITEM 1 ON THE FITS BETWEEN THE NOZZLE & RETAINING RING.
 - WELD PER ITEM 8, CLASS 1, INSPECT PER ITEM 8.
 - AT ASSEMBLY GRIND ONLY THE LOWER SURFACE OF THE NOZZLE SUPPORT (P1) TO ALIGN THE NOZZLE WITH TOLERANCES SPECIFIED ON THE ALIGNMENT DRAWING (HL-YEAR 000).
 - AFTER LATERAL ALIGNMENT OF NOZZLE, ADJUSTING SCREWS (P18) AND LOCK AS SHOWN IN VIEW 9-6. DO NOT ATTEMPT TO ALIGN NOZZLE BY USING THE SCOTTISH PIN.
 - AREA CHECK PER ITEM 7.
 - DESIGN REFERENCE AREAS:
 COLD FRONT AREA (OUTER) = 233.2%
 COLD FRONT AREA (INNER) = 231.302
 TOTAL COLD AREA NOZZLE = 464.502
 TOTAL HOT AREA NOZZLE = 472.950 (FRAM LOC.)
 - ASSEMBLY INSTRUCTIONS PER P18 19-22. TO BE DONE AFTER ALIGNMENT PER NOTE 4 IS COMPLETE.
 A. ASSEMBLE SCOTTISH SCREW (P17) TO HOLE IN SUP. RING WITH ANTI-SIETS AND WOODRUM PIN.
 B. ROTATE SCREW SO THAT HOLE IN SCREW IS (1) IN THE OUTBOARD HALF OF THE CIRCLE OF SCOTTISH (2) IN LINE WITH NOZZLE SLOT. INSPECT FOR OUTBOARD LOCATION. IF HOLE IS NOT LOCATED IN OUTBOARD (FROM AREA 4) HALF OF THE CIRCLE OF SET OF SCOTTISH (P17), KETCHER PLATE (P13) WILL NOT ASSEMBLE.
 C. APPLY ANTI-SIETS TO PIN (P17) AND ASSEMBLE INTO SCOTTISH SCREW (SCREW) & NOZZLE. INSERT ALL SCOTTISH (P17) PINS.
 D. AFTER ALL AREAS & COMPLETE FOR ENTIRE RING, PERFORM ALIGNMENT IN POSITION BY USE OF PERMANENT TOOL TO UPSET THE METAL FROM SUPPORT RING INTO THE SLOTS IN THE NOZZLE. DO FOR FOUR (4) SLOTS, TWO (2) OF WHICH MUST BE IN OPPOSITE POSITION WITH BOLT (P13). AFTER THAT TIME BOLT (P13) LOCK BOLT BY BENDING APPROPRIATE TABLES OF RETAINING PLATE AGAINST BOLT HEAD PLATE TO PREVENT P17 FROM TURNING.

LOCATION	OUTER		INNER	
	JOINT T1 REP.	JOINT P1 REP.	JOINT T2 REP.	JOINT P2 REP.
B-B (A)	1.878	0.064	1.848	7.984
D-D (A)	1.603	7.834	1.573	7.422
F-F (A)	1.340	4.992	1.315	4.930

VIEW M-8 (M)
 TYPICAL VIEW SHOWING THROAT AND PITCH RELATIONSHIPS - SEE NOTES 916 (OUTER SIDEWALL ONLY)

COL. 8A
 WELD WIRE TO SUB-MOUNT GRIND PLURA WITH NOZZLE SURFACES. WELD SHALL NOT PROTRUDE INTO NOZZLE JOINT GAPS. SEAL STRIPS MUST BE BOTTOMED IN THE SLOTS PRIOR TO WELDING PINS IN PLACE (TYPICAL 8 PLACES)



VIEW K-13 (F-A)
 (RET. RING OMITTED)

NO.	DATE	BY	CHKD.	APP.	REVISION
1	10/1/54				