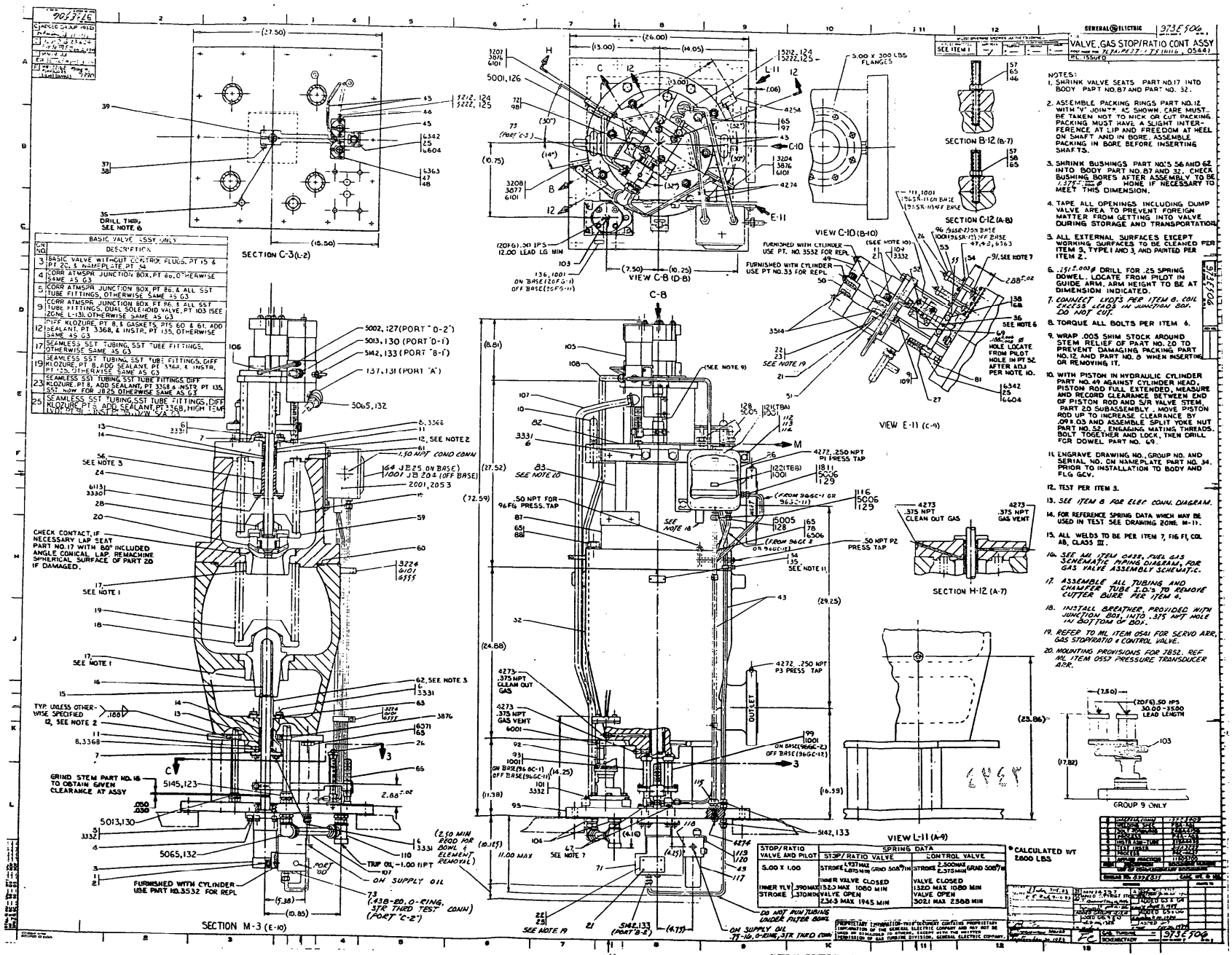

BASIC VALVE ASSY ONLY	
CR NO.	DESCRIPTION
3	BASIC VALVE WITHOUT CONTROL PLUGS, PT 15 & PT 20, & NAMEPLATE, PT 34
4	CORR ATMSPR JUNCTION BOX, PT 86, OTHERWISE SAME AS G3
5	CORR ATMSPR JUNCTION BOX, PT 86, & ALL SST TUBE FITTINGS, OTHERWISE SAME AS G3
9	CORR ATMSPR JUNCTION BOX, PT 86, & ALL SST TUBE FITTINGS, DUAL SOLENOID VALVE, PT 103 (SEE ZONE L-13), OTHERWISE SAME AS G3
12	DIFF KLOZURE, PT 8, & GASKETS, PTS 60 & 61, ADD SEALANT, PT 3368, & INSTR, PT 135, OTHERWISE SAME AS G3
17	SEAMLESS SST TUBING, SST TUBE FITTINGS, OTHERWISE SAME AS G3
19	SEAMLESS SST TUBING, SST TUBE FITTINGS, DIFF KLOZURE, PT 8, ADD SEALANT, PT 3368, & INSTR, PT 135, OTHERWISE SAME AS G3
23	SEAMLESS SST TUBING, SST TUBE FITTINGS, DIFF KLOZURE, PT 8, ADD SEALANT, PT 3368, & INSTR, PT 135, SST NOW FOR JB25 OTHERWISE SAME AS G3
25	SEAMLESS SST TUBING, SST TUBE FITTINGS, DIFF KLOZURE, PT 8, ADD SEALANT, PT 3368, HIGH TEMP LVDT, PT 91, INSTR, PT 135

NOTES:

1. SHRINK VALVE SEATS PART NO.17 INTO BODY PART NO.87 AND PART NO. 32.
2. ASSEMBLE PACKING RINGS PART NO.12 WITH "V" JOINTS AS SHOWN. CARE MUST BE TAKEN NOT TO NICK OR CUT PACKING. PACKING MUST HAVE A SLIGHT INTERFERENCE AT LIP AND FREEDOM AT HEEL ON SHAFT AND IN BORE. ASSEMBLE PACKING IN BORE BEFORE INSERTING SHAFTS.
3. SHRINK BUSHINGS PART NO'S 56 AND 62 INTO BODY PART NO.87 AND 32. CHECK BUSHING BORES AFTER ASSEMBLY TO BE 1.375 +.000 -.000 ⌀ HONE IF NECESSARY TO MEET THIS DIMENSION.
4. TAPE ALL OPENINGS INCLUDING DUMP VALVE AREA TO PREVENT FOREIGN MATTER FROM GETTING INTO VALVE DURING STORAGE AND TRANSPORTATION.
5. ALL EXTERNAL SURFACES EXCEPT WORKING SURFACES TO BE CLEANED PER ITEM 5, TYPE I AND 3, AND PAINTED PER ITEM 2.
6. .251 ±.003 ⌀ DRILL FOR .25 SPRING DOWEL. LOCATE FROM PILOT IN GUIDE ARM. ARM HEIGHT TO BE AT DIMENSION INDICATED.
7. CONNECT LVDTS PER ITEM 8. COIL EXCESS LEADS IN JUNCTION BOX. DO NOT CUT.
8. TORQUE ALL BOLTS PER ITEM 6.
9. WRAP .005 SHIM STOCK AROUND STEM RELIEF OF PART NO. 20 TO PREVENT DAMAGING PACKING PART NO.12 AND PART NO. 8 WHEN INSERTING OR REMOVING IT.
10. WITH PISTON IN HYDRAULIC CYLINDER PART NO. 49 AGAINST CYLINDER HEAD, PISTON ROD FULL EXTENDED, MEASURE AND RECORD CLEARANCE BETWEEN END OF PISTON ROD AND S/R VALVE STEM, PART 20 SUBASSEMBLY. MOVE PISTON ROD UP TO INCREASE CLEARANCE BY .09 ±.03 AND ASSEMBLE SPLIT YOKE NUT PART NO. 52, ENGAGING MATING THREADS. BOLT TOGETHER AND LOCK, THEN DRILL FOR DOWEL PART NO. 69.
11. ENGRAVE DRAWING NO., GROUP NO. AND SERIAL NO. ON NAMEPLATE PART NO. 34. PRIOR TO INSTALLATION TO BODY AND FLG GCV.
12. TEST PER ITEM 3.
13. SEE ITEM 8 FOR ELEC. CONN. DIAGRAM.
14. FOR REFERENCE SPRING DATA WHICH MAY BE USED IN TEST SEE DRAWING ZONE M-11.
15. ALL WELDS TO BE PER ITEM 7, FIG F1, COL AB, CLASS III.
16. SEE ML ITEM 0422, FUEL GAS SCHEMATIC PIPING DIAGRAM, FOR GAS VALVE ASSEMBLY SCHEMATIC.
17. ASSEMBLE ALL TUBING AND CHAMFER TUBE I.D.'s TO REMOVE CUTTER BURR PER ITEM 4.
18. INSTALL BREATHER, PROVIDED WITH JUNCTION BOX, INTO .375 NPT HOLE IN BOTTOM OF BOX.
19. REFER TO ML ITEM 0541 FOR SERVO ARR, GAS STOP/RATIO & CONTROL VALVE.
20. MOUNTING PROVISIONS FOR JB52. REF ML ITEM 0557 PRESSURE TRANSDUCER ARR.

STOP/RATIO VALVE AND PILOT	SPRING DATA	
	STOP/RATIO VALVE	CONTROL VALVE
5.00 X 1.00	STROKE 1.937 MAX 1.875 MIN GRAD 508 #/IN	STROKE 2.500 MAX 2.375 MIN GRAD 508 #/IN
INNER VLV STROKE .390 MAX .370 MIN	INNER VALVE CLOSED 1320 MAX 1080 MIN VALVE OPEN 2345 MAX 1945 MIN	VALVE CLOSED 1320 MAX 1080 MIN VALVE OPEN 3021 MAX 2388 MIN

* CALCULATED WT 2800 LBS

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