GENERAL ELECTRIC 166D1184

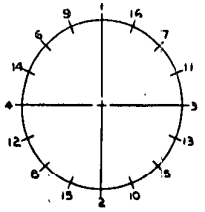
UNLESS OTHERWISE SPECIFIED USE THE FOLLOWING:					
APPLIED PRACTICES	SURFACES	TOLERANCES for machined dimensions: FRACTIONS	DECIMALS	ANGLES	166D1184
SEE ITEM 1	125	±	±	±	

TITLE: ROTOR ASSY COMPRESSOR (1303)

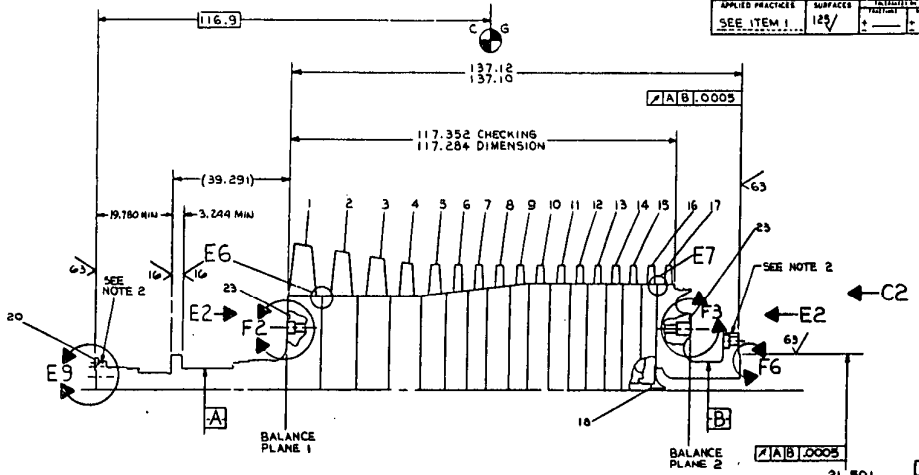
FIRST MADE FOR M & 900/A

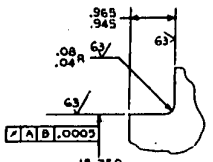
P.L. ISSUED

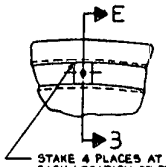
NOTES:
1. SEE ITEM 2 (SEC. 1, 2 & 5) FOR ASSEMBLY PROCEDURE. ALL RUNOUT REQUIREMENTS ARE TO BE RELATIVE TO DATUMS -A- & -B-.
2. MEASURE RUNOUT OF FLANGE FACE RELATIVE TO AXIS -A- & -B- ON A RADIAL LINE THRU BOLT HOLE NEAREST POINT WHERE RUNOUT SHOWS THE SURF. TO BE AT ITS MMC. LOW STRESS STAMP RUNOUT VALUE ON THE FLANGE OD (TO NEAREST FOURTH DECIMAL PLACE) FOLLOWED BY LETTER 'F'. SEE ZONE B4 & B8
3. LOW STRESS STAMP DWG NO., GR NO. & REV. NO. ON OD OF AFT FLANGE.
4. SEE ITEM 2 (SEC. 4) FOR ASSEMBLY INSTR. ON MARRIAGE OF COMPRESSOR ROTOR TO TURBINE ROTOR.



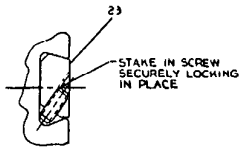
VIEW C-2 (B-8)
BOLT TIGHTENING SEQUENCE



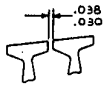




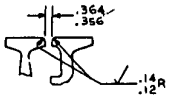
VIEW E-2 (B-4), (B-8)



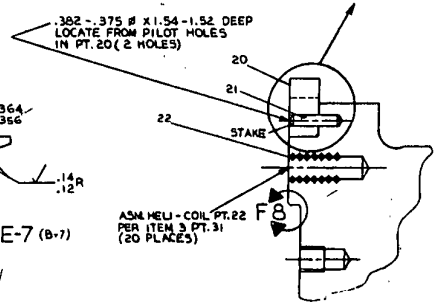
SECTION E-3 (D-2)



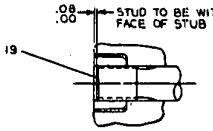
DETAIL E-6 (C-8)
(APPLIES 15 PLACES)



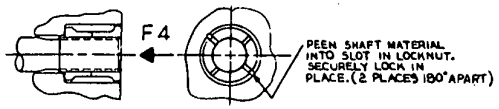
DETAIL E-7 (B-7)



DETAIL E-9 (C-4)

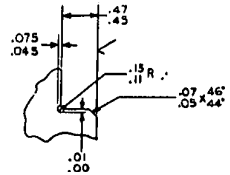


DETAIL F-2 (B-5)
ASSEMBLE WITH CHAMFERS IN POSITION SHOWN

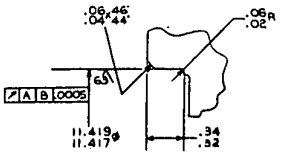


DETAIL F-3 (B-7)
APPLIES 16 PLACES

VIEW F-4 (E-3)



DETAIL F-6 (C-8)



DETAIL F-8 (E-9)

3	INSTR	164C2823
2	ASSY PROCESS	298A8331
1	APPLIED PRACTICE	11808700
ITEM	DESCRIPTION	DOCUMENT NUMBER

LIST OF COMPLEMENTARY DOCUMENTS

SIMILAR TO 143D7324 CALC. WT. 1000 LBS

REVISIONS

PRINTS TO

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GAS TURBINE DIV. SCHENECTADY

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