

164B1816

GENERAL ELECTRIC

164B1816  
CONT. ON SHEET

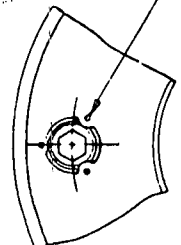
UNLESS OTHERWISE SPECIFIED USE THE FOLLOWING:

|                   |          |                                 |          |        |
|-------------------|----------|---------------------------------|----------|--------|
| APPLIED PRACTICES | SURFACES | TOLERANCES ON MACHINED SURFACES |          |        |
| SEE ITEM 1        | ✓        | FRACTIONS                       | DECIMALS | INCHES |
|                   |          | + -                             | + -      | + -    |

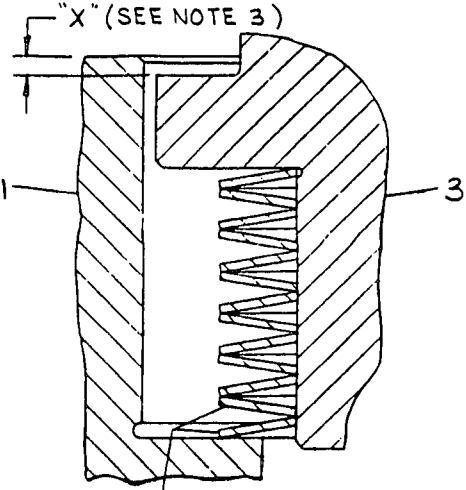
164B1816  
CONT. ON SHEET

TITLE  
VALVE & PILOT VALVE ASM.  
FIRST MADE FOR 7L7A1PA  
P.L. ISSUED

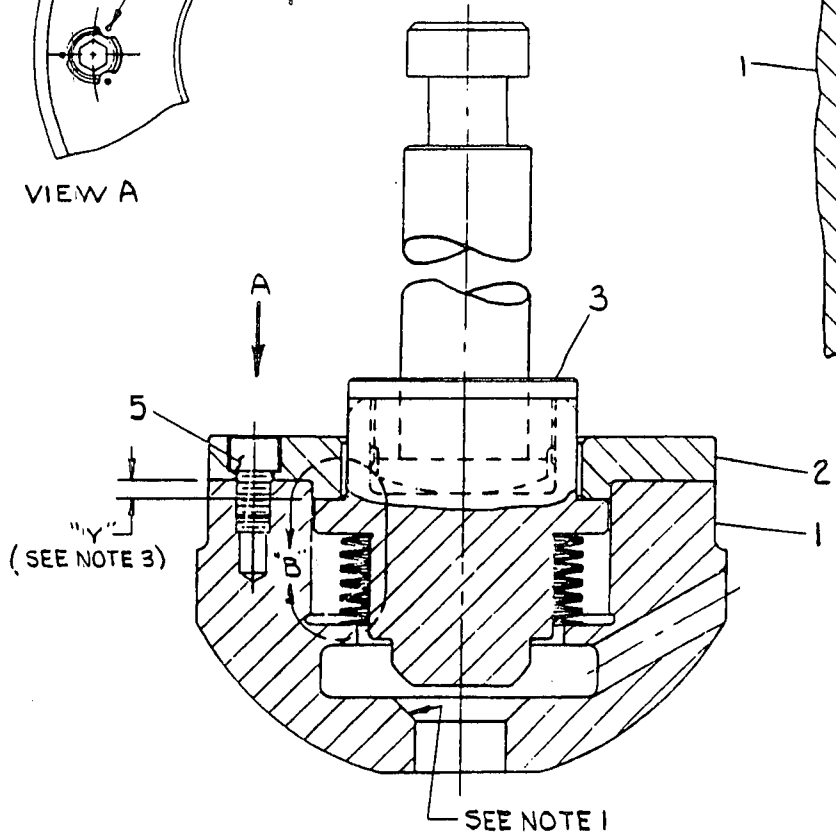
STAKE EACH BOLT, (6 TOTAL)  
IN 3 PLACES AS SHOWN.  
(18 PLACES TOTAL).



VIEW A



4 (SEE NOTE 2)  
ENLARGED VIEW B



"Y" (SEE NOTE 3)

SEE NOTE 1

NOTES:

- BEFORE ASM. SPRINGS (PT. 4) & RETAINER (PT. 2) LAP PILOT VALVE (PT. 3) ON SEAT SURFACE OF VALVE (PT. 1) LIGHTLY UNTIL FULL CIRCUMFERENTIAL CONTACT IS OBTAINED.
- FIRST SPRING (PT. 4) MUST BE ASSEMBLED AS SHOWN (VIEW B) AND EACH ADDITIONAL SPRING STACKED IN REVERSE TO THE ONE BEFORE IT.
- AFTER ASSEMBLING PT'S. 1, 3 & 4, CHECK DIMENSION "X" (VIEW B) AND DIMENSION "Y" ON RETAINER (PT. 2). DIMENSION "Y" MUST EXCEED DIMENSION "X" BY .025 OR GREATER. IF "Y" DOES NOT EXCEED "X" BY .025, SUBSTITUTION OF DIFFERENT SPRINGS (PT. 4) MAY BE TRIED UNTIL .025 OR GREATER IS OBTAINED.
- AFTER ASSEMBLY, BUT BEFORE STAKING, SEE INSTRUCTIONS PER ITEM 2.

| GR. NO. | PILOT VALVE TRAVEL | DATE ADDED |
|---------|--------------------|------------|
| 1       | .390 - .370        |            |
| 2       | .390 - .370        | 8.22.69    |

|                            |             |                  |
|----------------------------|-------------|------------------|
| 2                          | INST. ASM.  | 223A7131         |
| 1                          | APPL. PRAC. | 244A250          |
| ITEM                       | DESCRIPTION | REFERENCE NUMBER |
| LIST OF REFERENCE DRAWINGS |             |                  |
| SIMILAR TO: 164B1412       |             | APPROX. WT. LBS. |

| REVISIONS  | PRINTS TO |
|--|-----------|
| CHANGED LOCATION BLOCK PER LATEST DFTG STD<br>11/24/77 |           |
|  |           |
|  |           |
|  |           |

PROPRIETARY INFORMATION  
This document includes proprietary information of the General Electric Company and may not be used for purposes other than that for which it was originally furnished, except with written permission from the GAS TURBINE DEPARTMENT General Electric Company.

|                                  |                      |                |                           |          |
|----------------------------------|----------------------|----------------|---------------------------|----------|
| MADE BY<br>R.D. Linn<br>12/13/69 | DATE<br>Nov 24, 1969 | APPROVED<br>DG | GAS TURBINE<br>GREENVILLE | 164B1816 |
|----------------------------------|----------------------|----------------|---------------------------|----------|

0323