

SECTION C-C

3.0.0.M. SHOW QUANTITY FOR ONE ASSY. 3. SUCH ASSYS.
ARE THERE PER MILL.

NOTES: - (FOR ASSEMBLY PROCEDURE).

01. CENTRE INTERMEDIATE LINER SUPPORT PLATE (ITEM-01) BODY OPENING, MAINTAIN 60.2 VERTICAL DIMENSION BETWEEN SEPARATOR BODY FLANGE AS SHOWN AND WELD AS INDICATED.
02. CENTRE DEFLECTOR LINER SUPPORT PLATE (ITEM-02) BETWEEN INTERMEDIATE LINER SUPPORT PLATES (ITEM-02). MAINTAIN 60.2 VERTICAL DIMENSION BETWEEN SEPARATOR BODY FLANGE AS SHOWN & WELD AS INDICATED.
- NOTE1- GRIND INTERMEDIATE LINER SUPPORT PLATE IF REQUIRED TO INSERT DEFLECTOR LINER SUPPORT PLATE INTO POSITION.
03. INSTALL INTERMEDIATE LINERS (ITEM-3, 4 & 5) WORKING FROM LEFT TO RIGHT, MAINTAIN APPROX 3mm GAP BETWEEN LINERS.
04. INSTALL DEFLECTOR SIDE LINER (ITEM-06) MAINTAIN APPROX 3mm FROM SEPARATOR BODY & INTERMEDIATE LINER (ITEM-03). LOWER FACE OF SIDE LINER SHOULD BE FLUSH WITH INNER RADIUS OF ITEM-03).
05. INSTALL BOTTOM ROW OF DEFLECTOR LINERS (ITEM-07). INITIAL FIRST LINER ADJACENT TO INTERMEDIATE LINER (ITEM-03) & WORK FROM RIGHT TO LEFT, MAINTAIN APPROX 3mm GAP BETWEEN LINERS. TRIM LEFT HAND LINER IF NECESSARY.
06. INSTALL CENTRE TOP ROW OF DEFLECTOR LINERS (ITEM-8, 9 & 10) WORKING FROM RIGHT TO LEFT, MAINTAIN APPROX 3mm GAP BETWEEN LINERS. TRIM LEFT LINER (ITEM10) IF NECESSARY.
07. INSTALL TOP ROW OF DEFLECTOR LINERS (ITEM-11, 12 & 13) WORKING FROM RIGHT TO LEFT, MAINTAIN APPROX 3mm GAP BETWEEN LINERS. TRIM LEFT LINER (ITEM-13) IF NECESSARY.
08. INSTALL DEFLECTOR SIDE LINER (ITEM-14). FRONT EDGES OF DEFLECTOR LINERS ARE APPROX 3mm FROM THE BACK SIDE OF DEFLECTOR LINERS (ITEMS-13 & 10) AND THE SEF. BODY DEFLECTOR LINERS SHOULD OVERLAP APPROX 6mm.
09. APPLY SILICONE CEMENT (ITEM-19) TO CERAMIC PLUG (ITEM-17) & INSTALL AS SHOWN.
10. TO FILL ALL GAPS BETWEEN LINERS WITH RTV SEALER (ITEM-18) OR EQUIVALENT.
11. FOR JOURNAL FRAME LINER ASSY. INSTALLATION REFER DRG. No. 2-61-380-00446.
12. FOR WELD PLUG APPLICATION REFER DRG. No. 4-61-080-00610.

3.0.M. SHOWS QUANTITY FOR ONE ASSY. 3 SUCH ASSYS
ARE THERE PER MILL.


NOTES:- (FOR ASSEMBLY PROCEDURE)

01. CENTRE INTERMEDIATE LINER SUPPORT PLATE (ITEM-01) WITH JOURNAL, OPENING, MAINTAIN 60±3 VERTICAL DIMENSION BEYOND SEPARATOR BODY FLANGE AS SHOWN AND WELD AS INDICATED.
02. CENTRE DEFLECTOR LINER SUPPORT PLATE (ITEM-02) BETWEEN INTERMEDIATE LINER SUPPORT PLATES (ITEM-02), MAINTAIN 60±3 VERTICAL DIMENSION BEYOND SEPARATOR BODY FLANGE AS SHOWN & WELD AS INDICATED.
- NOTE:- GRIND INTERMEDIATE LINER SUPPORT PLATE IF REQUIRED TO INSERT DEFLECTOR LINER SUPPORT PLATE INTO POSITION.
03. INSTALL INTERMEDIATE LINERS (ITEM-3, 4 & 5) WORKING FROM LEFT TO RIGHT, MAINTAIN APPROX 3mm gap BETWEEN LINERS.
04. INSTALL DEFLECTOR SIDE LINER (ITEM-06) MAINTAIN APPROX 3mm FROM SEPARATOR BODY & INTERMEDIATE LINER (ITEM-03), LOWER FACE OF SIDE LINER SHOULD BE FLUSH WITH INNER RADIUS OF ITEM-03).
05. INSTALL BOTTOM ROW OF DEFLECTOR LINERS (ITEM-07). INSTALL FIRST LINER ADJACENT TO INTERMEDIATE LINER (ITEM-03) & WORK FROM RIGHT TO LEFT, MAINTAIN APPROX 3mm gap BETWEEN LINERS. TRIM LEFT HAND LINER IF NECESSARY.
06. INSTALL CENTRE TOP ROW OF DEFLECTOR LINERS (ITEM-8, 9 & 10) WORKING FROM RIGHT TO LEFT, MAINTAIN APPROX 3mm gap BETWEEN LINERS. TRIM LEFT LINER (ITEM10) IF NECESSARY.
07. INSTALL TOP ROW OF DEFLECTOR LINERS (ITEM-11, 12 & 13) WORKING FROM RIGHT TO LEFT, MAINTAIN APPROX 3mm gap BETWEEN LINERS. TRIM LEFT LINER (ITEM-13) IF NECESSARY.
08. INSTALL DEFLECTOR SIDE LINER (ITEM-14). FRONT EDGES OF DEFLECTOR LINER ARE APPROX 3mm FROM THE BACK SIDE OF DEFLECTOR LINERS (ITEMS-13 & 10) AND THE SEPR. BODY DEFLECTOR LINERS SHOULD OVERLAP APPROX 6mm.
09. APPLY SILICOE CEMENT (ITEM-19) TO CERAMIC PLUG (ITEM-17) & INSTALL AS SHOWN.
10. TO FILL ALL GAPS BETWEEN LINERS WITH RTV SEALER (ITEM-18) OR EQUIVALENT.
11. FOR JOURNAL FRAME LINER ASSY. INSTALLATION REFER DRG. No. 2-61-380-00446.
12. FOR WELD PLUG APPLICATION REFER DRG. No. 4-61-080-00010.

ITEM NO.	DESCRIPTION	DRAWING NO.	VAR NO.	RAW MATERIAL SIZE OR CASTING DRGNO. OR FORGING DRGNO.	MATERIAL CODE	MATERIAL SPECN.	NET WT. GROSS WT.	QUANTITY
19	SILICONE GEMENT	S/D					2.000	
18	FRY SEALER OR EQUIVALENT	SPEC. A-917			HR5530072046		5.000	1
17	CERAMIC PLUG (#36)	SPEC. A-900			DOW CORNING 3145		0.020	1
16	WELD PLUG-1"	4-61-162--00749			BA60115814245		49	
15	JOURNAL OPENING FRAME LINER ASSY.	2-61-380--00446			AA60117111168	0.130	134.02	49
14	DEFLECTOR SIDE LINER	2-61-380--00449			AA10111		49	
13	DEFLECTOR LINER	2-61-380--00451			ASSY		1	
12	DEFLECTOR LINER	2-61-380--00453			BA6114133601	7.220	15.200	1
11	DEFLECTOR LINER	2-61-380--00455			BA6114133628		15.200	1
10	DEFLECTOR LINER	2-61-380--00452			AA19741		18.700	1
09	DEFLECTOR LINER	2-61-380--00454			BA6114133660		15.400	2
08	DEFLECTOR LINER	2-61-380--00456			AA19741		13.900	1
07	DEFLECTOR LINER	3-61-380--00429			BA6114133610		10.900	4
06	DEFLECTOR SIDE LINER	2-61-380--00450			AA19741		10.200	1
05	INTERMEDIATE LINER	2-61-380--00460			BA621033110		14.000	1
04	INTERMEDIATE LINER	2-61-380--00459			AA19503		12.200	1
03	INTERMEDIATE LINER	2-61-380--00458			BA621033307		12.200	1
02	DEFLECTOR LINER SUPPORT PLATE	1-61-380--00205			AA19503		15.750	1
01	SUPPORT PLATE	2-61-380--00457			BA6210333098		1	
	DESCRIPTION	DRAWING NO.	VAR NO.	RAW MATERIAL SIZE OR CASTING DRGNO. OR FORGING DRGNO.	MATERIAL CODE	MATERIAL SPECN.	NET WT. GROSS WT.	QUANTITY

SECTION A-A

[illegible]

1	TO 0.7.	CODE	446		NTS	540.39	E-80-000/02	NO. 185
2	THE SURFACE ROUGHNESS MEETCR NOT SHOWN							NO. 186
3	SHALL BE TAKEN FROM THE SURFACE ROUGHNESS							NO. 187
4	SHOW OUT SIDE BACK STAGES GIVEN AT THE							NO. 188
5	TOP MOST RIGHT CORNER OF THE DRC.							NO. 189
6		TITLE	INTERMEDIATE, DEFLECTOR					
7			0-61-380-00111 04					
8		& JOURNAL FRAME LINER ASSY.						
9		DRAWING NO.						
10		REV.						
11		SHEET NO. 01	NO. OF SHEETS 01					