NOTES:

1. APPLY TWO LOCTITE 290 UNION GASKET COMPONETS BETWEEN BOTH CHAMBER AND GENERATOR SIDE DUCT PLATES TO ENSURE A TIGHT SEAL. NO RIVETS OR BOLTS TO BE USED.

2. LOCTITE SI5926 LIQUID GASKET TO BE APPLIED TO BOTH PLUG AND PLUG HOLE IN CHAMBER SIDE DUCT PLATE TO ENSURE A TIGHT SEAL. NO RIVETS OR BOLTS TO BE USED.

3. ALL HORIZONTAL BORING HOLES TO BE DRILLED TO THE EXACT SPECIFIED LOCATION AND SIZE.

4. TYPICAL GUIDE VANE CONFIGURATION. THIS ALSO APPLIES TO GENERATOR SIDE GUIDE VANES. ON ASSEMBLY GUIDE VANES TO BE BOLTED IN PLACE AND ITEM 19 M10 BONDED INSERTS TO BE BONDED USING ITEM 22 PLEXUS MA310 IN ACCORDANCE TO MANUFACTURERS INSTRUCTIONS.

5. ON ASSEMBLY HOLES FOR BOTH THE CHAMBER SIDE AND GENERATOR SIDE DUCT PLATES TO BE DRILLED. DUCT PLATES TO BE CLAMPED IN CORRECT POSITION AND ORIENTATION ENSURING CONCENTRICITY AND 18mm CLEARANCE HOLES DRILLED USING DUCT PLATES AS TEMPLATES.

6. ALL BORES WALLS TO BE SEALED AFTER DRILLING TO STOP WAER INGRESS WITH A PROPRIETARY SEALER.

7. APPROX MASS (DUE TO VARIATIONS IN DUCTS ALL MASS ARE APPROXIMATE):

- CHAMBER SIDE OUTER DUCT; 175KG
- CHAMBER SIDE INNER DUCT; 160KG
- GENERATOR SIDE OUTER DUCT; 142KG
- GENERATOR SIDE INNER DUCT; 155KG
- GUIDE VANE; 2.4KG
- CHAMBER SIDE DUCT PLATE; 43KG
- GENERATOR SIDE DUCT PLATE; 40KG
- TIP SUPPORT RING; 55KG
- CHAMBER SIDE OUTER DUCT INCLUDING FASTENERS; 1090KG
- CHAMBER SIDE INNER DUCT INCLUDING FASTENERS; 1000KG
- GENERATOR SIDE OUTER DUCT INCLUDING FASTENERS; 890KG
- GENERATOR SIDE INNER DUCT INCLUDING FASTENERS; 1000KG
- CHAMBER SIDE DUCT ASSY (INCLUDING GUIDE VANE, DUCT PLATE AND FASTENERS); 2300KG
- GENERATOR SIDE DUCT ASSY (INCLUDING GUIDE VANE, DUCT PLATE AND FASTENERS); 2100KG
- TOTAL INCLUDING TIP SUPPORT RING AND FASTENERS; 4472KG

8. THREAD SIZE TORQUE VALUE (Nm):

- M10 35
- M16 145
- M20 333

9. FOR SPECIFIC INFORMATION ON HOLES TO BE DRILLED SEE INDIVIDUAL DUCT DRAWINGS ITMS 1 THROUGH 4.

10. ONLY ONE CHAMBER SIDE OUTER DUCT SEGMENT (ITM 1) TO HAVE RTD HOLE DRILLED.

11. APPLIES TO ALL GUIDE VANES IN CORRESPONDING PLANE.

12. ALL HOLES TO BE DRILLED AFTER ASSEMBLY TO STOP WAER INGRESS WITH A PROPRIETARY SEALER.

13. ALL BORES WALLS TO BE SEALED AFTER DRILLING TO STOP WAER INGRESS WITH A PROPRIETARY SEALER.

14. TORQUE ALL FASTENERS ACCORDING TO TORQUE VALUES GIVEN IN TABLE UNLESS OTHERWISE STATED. THIS VALUE TAKES ACCOUNT OF THE LUBRICATION PROVIDED BY ITEM 24 LOCTITE 278.

15. FASTENERS TO BE TIGHTENED WITH LOW RPM'S ONLY WITHOUT INTERUPTION TO LIMIT THE RISK OF GALLING.

16. FOR SPECIFIC INFORMATION ON HOLES TO BE DRILLED SEE INDIVIDUAL DUCT DRAWINGS ITMS 1 THROUGH 4.

17. THREAD SIZE TORQUE VALUE (Nm):

- M10 35
- M16 145
- M20 333
HOLE TO BE DRILLED ON ASSEMBLY. SEE NOTE 7.

NOTE 7:
- HOLE TO BE DRILLED ON ASSEMBLY IN 1.65D CHAMBER SIDE OUTER DUCT ONLY.