

G-3083-R-1

|                         |       |                                                    |               |       |                                          |                                      |          |
|-------------------------|-------|----------------------------------------------------|---------------|-------|------------------------------------------|--------------------------------------|----------|
| Chk'd<br>               | App'd | Customer                                           |               |       |                                          | List No. & Assem. No.<br>TM-340078-A |          |
| Recommend-<br>ed Spares |       | Name of Assembly<br>TYPE #2616 - EXPANDER ASSEMBLY |               |       |                                          | Page No.<br>1                        |          |
|                         |       |                                                    |               |       |                                          | Date:<br>3/21/67                     |          |
| Class                   |       |                                                    | Illus.<br>No. | Quan. | Name of Part                             | Drawing                              | Part No. |
| 1                       | 2     | 3                                                  |               |       |                                          |                                      |          |
| 1                       |       |                                                    |               | 1     | EXPANDER ASSEMBLY (2562F0555257513)      | 340078                               | A        |
| 2                       |       |                                                    |               |       | CONSISTING OF:                           |                                      |          |
| 3                       |       |                                                    | 1             |       | 1 - EXPANDER CASING                      | TM-338615-A                          |          |
| 4                       | 1     | 1                                                  | 2             |       | 1 - ROTOR ASSEMBLED                      | TM-340079-A                          |          |
| 5                       |       |                                                    | 3             |       | 1 - THRUST BEARING ASSEMBLED             | TM-337173-C                          |          |
| 6                       |       |                                                    | 4             |       | 1 - PLAIN BEARING ASSEMBLED              | TM-317651-C                          |          |
| 7                       |       |                                                    | 5             |       | 1 - STATOR CASING                        | TM-1182E6-A                          |          |
| 8                       | 1     | 1                                                  | 6             |       | 1 - H.P. PKG. SLEEVE ASSEMBLED           | TM-280C6-A                           |          |
| 9                       |       |                                                    | 7             |       | 1 - RADIATION SHIELD                     | 319557                               | A        |
| 10                      |       |                                                    | 8             |       |                                          |                                      |          |
| 11                      |       |                                                    | (9)           |       | 1 - INLET SCROLL (SPINNING & FABRICATION |                                      |          |
| 12                      |       |                                                    |               |       | 1167E6-A)                                | 1086E6                               | 2        |
| 13                      |       |                                                    | 10            |       | 1 - INLET FLANGE                         | 325959                               | 1        |
| 14                      | 1     | 1                                                  | 11            |       | 1 - L.P. PKG. SLEEVE ASSEMBLED           | TM-1909B6-A                          |          |
| 15                      |       |                                                    |               |       |                                          |                                      |          |
| 16                      |       |                                                    |               |       |                                          |                                      |          |
| 17                      |       |                                                    |               |       |                                          |                                      |          |
| 18                      |       |                                                    |               |       |                                          |                                      |          |
| 19                      | 1     | 1                                                  | 12            |       | 1 - STATOR MACHINING, 2ND STG.           | TM-319168-A                          |          |
| 20                      | 1     | 1                                                  | 13            |       | 1 - STATOR MACHINING, 3RD STG.           | TM-319599-A                          |          |
| 21                      |       |                                                    |               |       |                                          |                                      |          |
| 22                      |       |                                                    |               |       |                                          |                                      |          |
| 23                      |       |                                                    |               |       |                                          |                                      |          |
| 24                      |       |                                                    |               |       |                                          |                                      |          |
| 25                      |       |                                                    |               |       | (CONT'D ON PAGE #2)                      |                                      |          |

IMPORTANT - When ordering replacement parts be sure to include;  
 (1) Quantity (2) Illus. No.  
 (3) Drg. No. (4) Name of Part  
 (5) List No. given on top of page.

N. S. S. - Not sold separately

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|                         |       |                                                    |               |       |                                                      |                                      |          |
|-------------------------|-------|----------------------------------------------------|---------------|-------|------------------------------------------------------|--------------------------------------|----------|
| Chk'd                   | App'd | Customer                                           |               |       |                                                      | List No. & Assem. No.<br>TM-340078-A |          |
|                         |       |                                                    |               |       |                                                      | Page No. 2                           |          |
| Recommend-<br>ed Spares |       | Name of Assembly<br>TYPE #2616 - EXPANDER ASSEMBLY |               |       |                                                      | Date:<br>3/21/67                     |          |
| Class                   |       |                                                    | Illus.<br>No. | Quan. | Name of Part                                         | Drawing                              | Part No. |
| 1                       | 2     | 3                                                  |               |       |                                                      |                                      |          |
| 1                       |       |                                                    |               |       | (CONT'D FROM PAGE #1)                                |                                      |          |
| 2                       | 1     | 1                                                  | 14            |       | 1 - STATOR MACHINING, 4TH STG.                       | TM-318527-A                          |          |
| 3                       | 1     | 1                                                  | 15            |       | 1 - STATOR MACHINING, 5TH STG.                       | TM-319652-A                          |          |
| 4                       | 1     | 1                                                  | 16            |       | 1 - GASKET                                           | 334164                               | 2        |
| 5                       |       |                                                    | (17)          |       | 1 - INLET SCROLL GUIDE PIN                           | 333829                               | 4        |
| 6                       |       |                                                    | (18)          |       | 5 - SHOULDERED PIPE PLUG                             |                                      |          |
| 7                       |       |                                                    |               |       | (Mk. FR. 35A7S6)                                     | 333847                               | 1        |
| 8                       |       |                                                    | (19)          |       | 1 - 3/4" HEX. SOC. PIPE PLUG                         | 34A7B6 (SURE)                        |          |
| 9                       |       |                                                    | 20            |       | 1 - 1/4" DIA. x 20" LG. BAR                          | 340078                               |          |
| 10                      |       |                                                    | (21)          |       | 8 - 3/8"x1-1/2" HEX. HD. CAP SCREW                   | 35A21C115                            |          |
| 11                      |       |                                                    | 22            |       | 4 - 1"x2-3/4" HEX. SOC. HD. CAP SCREW                | 119A2A367                            |          |
| 12                      | 1     | 1                                                  | 23            |       | 1 - STATOR MACHINING, 1ST STG.                       | TM-329765-B                          |          |
| 13                      |       |                                                    |               |       |                                                      |                                      |          |
| 14                      |       |                                                    | (24)          |       | 2 - GUIDE PIN                                        | 24A13C4                              |          |
| 15                      |       |                                                    | (25)          |       | 10 - SPACER                                          | 334928                               | 1        |
| 16                      |       |                                                    | (26)          |       | 10 - 3/8" x 3" <sup>X-750</sup> SOC. HD. CAP SCREW   | 119A2X210                            |          |
| 17                      | 2     | 2                                                  | (27)          |       | 2 - CONFORMABLE SEGMENTAL STEP SEAL                  |                                      |          |
| 18                      |       |                                                    |               |       | RING (INCLUDING SPRING)                              | 333686                               | 1        |
| 19                      |       |                                                    | 28            |       | 2 - CAUTION PLATE                                    | 8A16X46                              |          |
| 20                      |       |                                                    | 29            |       | 8 - #6 DRIVE SCREW                                   | 122A2S78C                            |          |
| 21                      |       |                                                    | (30)          |       | 4 - INLET SCROLL GUIDE PIN                           | 333829                               | 2        |
| 22                      |       |                                                    | 31            |       | XXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXXX | XXXXXXXXXX                           |          |
| 23                      |       |                                                    | 32            |       | 2 - 1"x6-1/2" HEX. SOC. HD. CAP SCREW                | 119A2A462                            |          |
| 24                      |       |                                                    |               |       |                                                      |                                      |          |
| 25                      |       |                                                    |               |       |                                                      |                                      |          |

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(1) Quantity (2) Illus. No. (CONT'D ON PAGE #3)

(3) Drg. No. (4) Name of Part

(5) List No. given on top of page. N.S.S. - Not sold separately

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|                         |   |                                                    |               |          |                                         |                  |  |                                      |  |
|-------------------------|---|----------------------------------------------------|---------------|----------|-----------------------------------------|------------------|--|--------------------------------------|--|
| Chk'd<br>SK             |   | App'd                                              |               | Customer |                                         |                  |  | List No. & Assem. No.<br>TM-340078-A |  |
| Recommend-<br>ed Spares |   | Name of Assembly<br>TYPE #2616 - EXPANDER ASSEMBLY |               |          |                                         | Page No.<br>3    |  |                                      |  |
|                         |   |                                                    |               |          |                                         | Date:<br>3/21/67 |  |                                      |  |
| Class                   |   |                                                    | Illus.<br>No. | Quan.    | Name of Part                            | Drawing          |  | Part No.                             |  |
| 1                       | 2 | 3                                                  |               |          |                                         |                  |  |                                      |  |
| 1                       |   |                                                    |               |          | (CONT'D FROM PAGE #2)                   |                  |  |                                      |  |
| 2                       |   |                                                    | 33            |          | 5 - 3/8" x 3/4" HEX. SOC. SET SCREW     | 109A2A48         |  |                                      |  |
| 3                       |   |                                                    | 34            |          | 5 - 3/8" x 3/4" HEX. SOC. SET SCREW     | 112A2A48         |  |                                      |  |
| 4                       |   |                                                    | (35)          |          | 5 - SPECIAL SUPPORT PIN                 | 326079           |  | 1                                    |  |
| 5                       |   |                                                    | 36            |          | 5 - 1-1/4" HEX. SOC. PIPE PLUG          | 34A7A8           |  |                                      |  |
| 6                       |   |                                                    | 37            |          | 2 - 1" NUT                              | 38A4H10          |  |                                      |  |
| 7                       |   |                                                    |               |          |                                         |                  |  |                                      |  |
| 8                       |   |                                                    |               |          |                                         |                  |  |                                      |  |
| 9                       |   |                                                    |               |          |                                         |                  |  |                                      |  |
| 10                      |   |                                                    |               |          |                                         |                  |  |                                      |  |
| 11                      |   |                                                    |               |          |                                         |                  |  |                                      |  |
| 12                      |   |                                                    |               |          |                                         |                  |  |                                      |  |
| 13                      |   |                                                    |               |          |                                         |                  |  |                                      |  |
| 14                      |   |                                                    |               |          |                                         |                  |  |                                      |  |
| 15                      |   |                                                    |               |          |                                         |                  |  |                                      |  |
| 16                      |   |                                                    |               |          |                                         |                  |  |                                      |  |
| 17                      |   |                                                    |               |          |                                         |                  |  |                                      |  |
| 18                      |   |                                                    |               |          |                                         |                  |  |                                      |  |
| 19                      |   |                                                    |               |          |                                         |                  |  |                                      |  |
| 20                      |   |                                                    |               |          | FOR ASSEMBLY & DISASSEMBLY INSTRUCTIONS | FOR EXPANDER     |  |                                      |  |
| 21                      |   |                                                    |               |          | SEE DRG. 44206.                         |                  |  |                                      |  |
| 22                      |   |                                                    |               |          |                                         |                  |  |                                      |  |
| 23                      |   |                                                    |               |          |                                         |                  |  |                                      |  |
| 24                      |   |                                                    |               |          |                                         |                  |  |                                      |  |
| 25                      |   |                                                    |               |          |                                         |                  |  |                                      |  |

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|                                    |                  |
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| (1) Quantity                       | (2) Illus. No.   |
| (3) Drg. No.                       | (4) Name of Part |
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