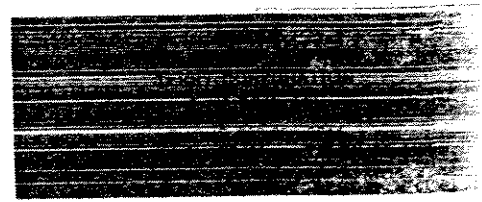




TERRY CORPORATION

LAMBERTON ROAD • WINDSOR, CONNECTICUT U.S.A.
A SUBSIDIARY OF INGERSOLL-RAND



DI NO. 1

FIELD DESIGN IMPROVEMENT

PURCHASER _____
ORDER NO. _____
JOB NO. _____
ULTIMATE USER _____
PROJECT NAME _____
LOCATION _____
SERVICE _____
ITEM NO. _____
TERRY FILE NO. _____
TURBINE SERIAL NO. _____
TURBINE TYPE _____

Accordingly, in the interests of the customer and Terry policy, the attached instructions are supplied as a supplementary requirement to aid and guide in the implementation of design improvements for the equipment listed above.

THE TERRY STEAM TURBINE COMPANY

WRITTEN BY: J. H. Crawford

APPROVED BY: _____

DI NO. 1

FIELD DESIGN IMPROVEMENT R.C.I.C. UNITS.

TERRY "GS" TURBINE WOODWARD GOVERNOR EG-R ACTUATOR OIL SUMP SUPPORT
(REFERENCE DWGS. 101516C & 111240C)

The oil sump support is a fabricated bracket made from flat steel bar. It provides support in addition to the existing tubing & piping connections. This improvement increases the overall reliability of the equipment.

1. Cut piece of flat bar approximately nine to ten inches long, three eighths of an inch thick and one inch wide.
2. At a point four and three eights inches from one end, scribe a line and form a ninety degree bend ("L" shaped).
3. On completion of forming the bend (2), a ninety degree twist is then put in the four and three eighth inch section.
4. Cut a piece of flat bar three and a half inches long. A quarter of an inch thick and one inch wide.
5. At a point one and a half inches from one end, scribe a line across all sides. At a point one inch from the opposite end, scribe a line across all sides.
6. Clamp the three and a half inch piece length wise across and against the one inch end of the twisted four and three eighths section to form a "T". Align pieces square to each other and ensure that the marked off one and a half inch section is off-set and pointing away from the ninety degree flat section of the "L" shaped support piece.
7. On satisfactory location, weld in position on three sides.
8. Hold the bracket in position with the horizontal cross piece up against the oil sump (see photo) and the angled flat section of "L" shaped piece, on the nearest appropriate hexagon headed cap screw in the horizontal joint flange of the upper and lower pump brackets.
9. Mark off the position of the five sixteenth of an inch clearance holes for the quarter inch threaded "U" bolt. Distance between centers two and eleven sixteenths of an inch.

Mark off location for the thirteen thirty seconds of an inch clearance hole for attaching the support bracket to the horizontal joint flange of the upper pump bracket.

NOTE: When attaching bracket to the upper pump bracket, a longer cap screw (3/8" x 16 T.P.I. x 1-5/16" long) must be used in place of the one removed.

10. The "U" bolt can be purchased or made from a piece of quarter inch diameter steel rod 8-1/2" long. It is formed around a piece of two inch pipe until the two legs are parallel and of the same length. Each leg is then threaded one and three quarters inches from each end for a quarter inch times twenty threads per inch hexagon nut.

FIELD DESIGN IMPROVEMENT R.C.I.C. UNITS.

11. Assemble "U" bolt around oil sump passing the threaded ends through the clearance holes drilled in the cross piece of the support bracket. Assemble nuts and tight evenly until oil sump is rigidly held to the support. Assure no pre-load is put in any attaching piping or tubing.

Design Imp.: R.C.I.C. Units, Type GS Turbines, Rev. 1, 1977.

FIELD DESIGN IMPROVEMENT R.C.I.C. UNITS

Reference Dwgs 101516C, Rev A & 11240C, Rev 0



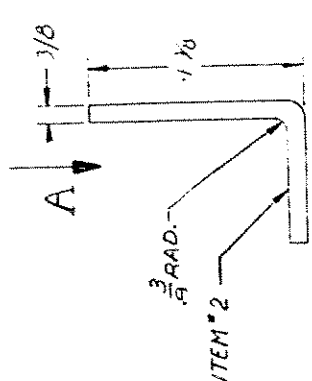
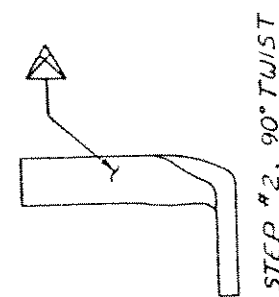
106249A05

89769D

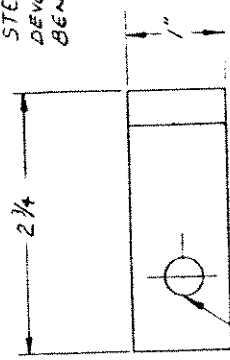
75199A01

111240C03

DESIGN IMPROVEMENT: R.C.I.C. UNITS, TYPE GS
TURBINES, REV. 1, 1977 3 OF 5



STEP #1, 90° BEND
DEVELOPED LENGTH 8" APPROX.
BEND LINE 3" APPROX.



13/32 DIA. THRU
LOCATE AT ASSY
REF. DWG NO. 101516C

ITEM NO.	ITEM NO.	ITEM NO.	MAT'L SPEC.
111240003	111240001	111240002	EM-90 ASTM 106

MAKE IDENT. TERRY
SPEC. SP-179

FAMILY NO. LOCATION K-51

TERRY CORPORATION
A Division of Ingersoll-Rand

SUMP BLACKET

PC NO. DATE MATERIAL DATE

CASTING/FORGING NO.

STANDARD PRACTICE

SCALE 1/16" = 1" CHECKED DATE 7/5/77

ENGINEERING APPROVAL APPROVED

MANUFACTURING APPROVAL DATE

TYPE DATE DATE

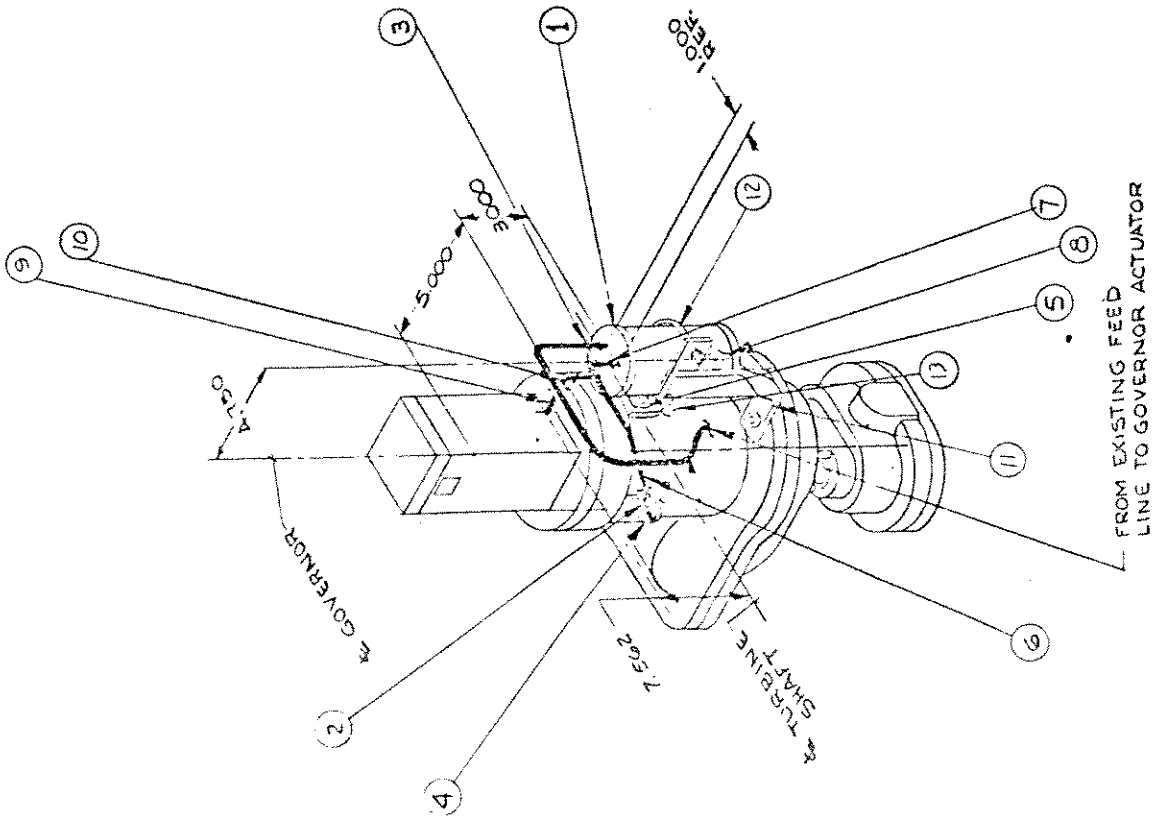
DRAWING NO. 1112400

STANDARD TOLERANCE UNLESS OTHERWISE SPECIFIED	DRAWING SYMBOLS
MACHINED DIMENSIONS ± 1/4	FLATNESS
ANGLES ± 0°-30'	PARALLELISM
BREAK SHARP EDGES 0.05 MAX	PERPENDICULARITY
MINIMUM WALL THICKNESS	ANGULARITY
MAXIMUM WALL THICKNESS	CONCENTRICITY
	CONTOUR
	TRUE POSITION
	BENDOUT
	FINISH

REVISED	DESCRIPTION	DATE	APPROVED	ECN#
1	ADDED ITEMS 11, 12, 13	7/2/77	A. M.	1754
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				

PARTS LIST

ITEM#	PIECE No.	DESCRIPTION	QTY.	MATL.
1	89769D	EGR SUMP ASSY	1	STL
2	75265A09	ELBOW, MALE 5/8-2/8	1	STL
3	75133A12	CONNECTOR, MALE 2/8	1	STL
4	75475A10	BUSHING, 2/8 x 1	1	MI
5	75318A07	PLUG, FLUSH PIPE 1"	1	STL
6	75334A01	TUBE - 3/8 X .045 WALL	4R	CONJTL
7	100520C	ORIFICE FITTING ASSY	1	STL
8	75151A03	PLUG, PIPE 3/8	1	STL
9	75313A01	PIPE, 1/8 SCH 40 2 1/4	1	EM-10G
10	75A47A01	ELBOW 1/8 NPT	1	STL
11	111240C03	SUMP BRACKET	1	EM-910
12	106299A05	U" BOLT (2 1/2 ID 1/4-20UNC)	1	CPN STL
13	75199A01	NUTS FOR U" BOLT	2	STL



CONFIGURATION CONTROL DIAGRAM

FAMILY NO 19T.2.00 LOCATION W-52

TERRY
WINDSOR, CONN. U.S.A.

TITLE INSTALLATION -
GOV. AUX. OIL SUMP

STANDARD PRACTICE

SCALE 1/4" = 1"

DATE 7-2-70

ENGINEER [Signature] CHECKED [Signature] APPROVED [Signature]

ENGINEERING APPROVAL

SIGNED [Signature] DATE [Signature]

TYPE EGR REF DWG NO

DRAWING NO 1045160