

PT-944

P.O. # 330-12002-5

GENERAL  ELECTRIC

INSTRUCTIONS

STEAM TURBINE SETS

GEK-5743

RENEWAL PARTS SUPPLEMENT

GTD/Vulcan/Celanese Chemical Co.

Location: Bishop, Texas

Application: Starting Turbine

REQUISITION 087-BNWE-87348

CUSTOMER'S ORDER NO.

TURBINE NO. 123186

SMALL STEAM TURBINE DEPARTMENT

GENERAL  ELECTRIC

FITCHBURG, MASS.

RENEWAL PARTS
ORDERING AND RETURNING

I. INTRODUCTION

The inclusion of drawings as well as parts lists in this book is for your convenience in identifying parts, and in specifying the General Electric ordering number on your orders. Use of these numbers will result in quicker processing of your order.

This book is designed to insure completeness of information, and results in the occasional inclusion of fully dimensioned parts drawings. The General Electric Company takes no steps to insure the continuing accuracy of these dimensions to cover changes in parts used in this specific turbine. Any dimensioned drawings included in this book must not be considered to be up-to-date machining drawings, and are definitely not to be employed in the production of the parts described.

II. ORDERING PROCEDURE

When ordering an individual part or an assembly of parts, use the following procedure.

1. Refer to the "Model List" (ML), immediately following the cross-section drawing in this book, and find the drawing number of the assembly of which the required piece is a part.
2. Refer to the drawing for this assembly and determine the identifying call out number (Item No.) for the required part.
3. Refer to this item on the "Parts List" for the assembly drawing and determine the name and ordering drawing number of the required part.

As an example (see sample at the back of these instructions), assume a new Operating Valve Stem is required for a certain turbine. The Model List might show the Oper. & Throttle Valve Assembly drawing to be 101D155BB G1. Referring to drawing 101D115BB would show the required stem to be part 7. Referring to the Parts List for drawing 101D115BB would show the ordering drawing number for part 7 to be 101A152AS-1. The order should then be placed for V. Stem 101A152AS-1.

When ordering renewal parts, give the following data:

1. Complete address to which shipments of parts is to be made, including identification marking and method of shipment, if special.
2. The turbine Serial number. (G. E. Offices-Show user's name).
3. The order should have a separate item number for each part desired.

4. Customer stocking numbers, if shown, will be on invoice and on parts identification card included with the shipped part.

III. QUALIFICATIONS PERTAINING TO THE ORDERING OF PARTS

- A. Some parts shown on the assembly drawings should not be ordered separately. This may be due to one of the following reasons:

1. Their nature is such that they must be machined together to maintain concentricity. This category includes; the upper and lower halves of bearing liners, liner casings, bearing brackets, packing boxes, wheel casings, thrust rings.
2. Parts of welded assemblies. This category includes; bases, supports, torque tubes.
3. Parts requiring special tools for assembly. This category includes; intermediates, pilot valve assemblies, double lift control valves.
4. An assembly which normally calls for factory setting or testing. This includes the emergency governors and speed governors. For speed governors the factory recommends supplying a complete assembly. Parts will be supplied at purchaser's risk, and should be installed under direction of a General Electric Company field representative.

B. Emergency Governors

When ordering an emergency governor, be sure to specify the trip speed setting.

C. Nozzle Plates

When ordering a nozzle plate the order must refer to the turbine serial number in order to obtain the correct reaming specifications and rotation.

D. Rebucketting Material

When buckets are ordered for bucket wheels complete sets will be provided, including space blocks, locking pieces and bands. If they are for a two row wheel, give the number of the stage and the number of the row.

Bucket bands are furnished unpunched. A punch and die will be supplied with each set of rebucketting material unless otherwise specified. These punches and dies can be returned for credit in accordance with the sales agreement.

E. Intermediates

We do not recommend the rebucketting of intermediates, as it has been found that the cost of doing so about equals the cost of new intermediate assemblies.

F. Rotors, Main Shafts, and Trim (Thrust collars, oil deflectors, etc)

Rotor assemblies include bucketed wheels, shaft and trim, and the emergency governor assembly.

Where main shafts are ordered, all trim is included unless otherwise specified. Trim includes thrust collars and oil deflectors, which are shrunk on the shaft and finish machined for squareness.

Separate thrust collars are supplied with excess material to allow for machining the thrust face square with the shaft after assembly.

G. Carbon Packing, Springs and Clips

Carbon packing rings may be ordered in sets. A set is interpreted to mean a sufficient quantity of rings for both high and low pressure ends, unless otherwise specified, but no springs and clips.

Springs and clips for carbon rings should be called for as separate items.

IV. SUPPLEMENTARY INFORMATION

This book contains a copy of the turbine Model List and copies of assembly drawings and their associated parts lists.

A. Model List (hereafter referred to as ML)

Represents the assembly of the turbine and is the list of all the drawings from which the turbine was built.

1. Quantities shown are for one turbine only.
2. Fractional quantities occur when the model list applies to more than one turbine and the purchaser desired a lesser quantity of some components than the quantity of turbines.

Example: Three turbines are covered by the ML. Only one set of tools was desired to cover all three turbines. The quantity $1/3$ would appear beside "Tools". Had the quantity been $2/3$, two sets of tools would have been furnished for the three turbines.

3. A letter "S" appearing opposite (to the left of) certain items (e. g. driver and driven gears) indicates the item is a recommended maintenance part.
4. Asterisks (*) on the ML indicate that the component is used in one of the assemblies shown on the ML. The parts list of the applicable assembly will in turn say "See ML--".
5. Drawing numbers and ordering numbers.

For all practical purposes, a drawing number and ordering number are the same thing: the only difference is that not all drawings cover ordering of material. Such drawings are always prefaced by "X" or "-" in the quantity column.

Ordering numbers consist of two parts: the basic number and the applicable part or group number:

Example: 1) 101D115BB-G1

Basic No. Group No.

Example: 2) 101B124AS-3

Basic No. Part No.

Example: 3) N Series N20 P25016 Standard G. E. Co.
N405 P12 fasteners.

On a model list, Example 1) may be delineated as shown or may omit the dash (1).

On a model list, Example 2) will usually be given as shown or as 101B124AS P3, i. e. substituting the dash (-) with the "P".

On parts lists, Examples 1), 2), & 3) will always be given as shown above.

B. Assembly Drawings and Parts Lists

The assembly drawings and parts lists included are those shown on the ML plus sub-assemblies sufficient to insure complete renewal and recommended parts identification.

1. Drawing Numbers

The assembly drawing and its parts list will usually have the same number. Whenever the drawing number and parts list number differ, the parts list will contain an item that will say "Assem. to -----" and will give the number of the drawing to which assembly is made.

2. Quantity on Parts Lists

- a. Note: Quantities on parts lists are for one only of the particular assembly and for one turbine only. Reference should be made to the ML for total quantity of the particular assembly for one turbine.

Example: Assume carbon packing rings are required, and that the high and low pressure carbon packing assemblies are identical.

The ML would show a quantity of 2 for Packing Assembly. The parts list of the Packing Assembly may give a quantity of 3 for the carbon rings. Therefore, the total quantity of carbon rings for one turbine would be 6. If more than one turbine were covered by the ML, the quantity 6 would be multiplied by the quantity of turbines.

- b. AR - means "As Required" and usually applies to shims, spacers, wire markers, metal spray, lubricant, paint, welding electrodes, etc.

Of these, shims and spacers only may be required for renewal parts. Where "AR" appears, follow this rule:

Shims: - Where there are a maximum of two different shims in an assembly, assume the quantity of each as 10.

Where there are 3, assume the quantity of each as 6, 4, 2 for the thinnest to the thickest respectively.

Spacers: Assume the quantity as 2 each.

As for any other material falling into the "AR" category, G. E. recommends it be purchased locally.

3. Location of Assemblies

At the upper left hand corner of each parts list in the block titled "This Assembly Is Located On" will be a number similar in format to one of the following:

- a) PY125R40ML44
- b) 501E429AB-3

In a) the parts list covered on that page is located on line 44 of the ML.

In b) the parts list covered on that page is located as item 3 on drawing 501E429AB, which is also in the book.

Knowing the location of an assembly serves 1) as a check for accuracy in locating parts: 2) allows locating a small sub-assembly on a larger assembly until its final callout on the Model List.

C. Excluded Drawings

Certain drawings shown on the Model List are not included in this book. They fall into the following four categories:

1. Those items which have an "X" in the quantity column. These items are informational only and have no bearing on the ordering of renewal parts.
2. Those items which are not assemblies but rather individual parts. They can be identified by the lack of a "PL" preceding their drawing number. The drawing number on the "Model List" can be used for ordering purposes.
3. Those items which are welded assemblies and other parts not considered as wearing parts such as Metal Lagging, Base, Gage Board, Piping, Oil Tank, etc.
4. Vendor equipment which General Electric Company purchases from outside sources. These parts are identified, where possible, by vendor bulletins in the instruction book, and may be ordered direct from the vendor or through the General Electric Company.

D. Design Changes

Where parts are required to change the design of the turbine for a new set of operating conditions, complete data should be given to the local General Electric Office for review, and an engineering recommendation will be provided.

If an order is placed for parts to change the operation of a turbine which affects the stamping of the nameplate, the factory will send a new revised name plate automatically.

E. Turbines With Gears and/or Generators

Where parts are ordered for a turbine and associated gear and/or generator, separate the parts covering each piece of apparatus (turbine, gear, generator) so that the General Electric Company can then refer the correct items to the responsible component department. Individual serial numbers appear on the gears and generators and

your order for parts for these components should include the serial number for the component involved.

F. Repair

Before returning apparatus to the factory for repair, consult the nearest General Electric District Office for instructions.

Returned apparatus tags may be obtained from the District Offices and should be attached to all apparatus shipped to a General Electric plant, to avoid delay in starting repair work.

All parts returned to the factory for repair or replacement, shall be in accordance with the following instructions:

To GENERAL ELECTRIC CO. <small>Door - Bldg.</small>	
Dept. Small Turbine Dept.	
Street Putnam & Broad St.	
City-State Fitchburg, Mass.	
To be shipped from:	
G. E. Co. - 306 MacCorkle Ave.,	
Location Charleston, W. Va.	
Description of part	
1- 9052946-29 Punch	
1- 9052946-30 Die	
Misc. buckets & shroud bands	
Tag prepared	(Office - Date)
By <i>A.B. Smith</i>	Chas. W. Va. 11/11/58
References <i>SH 120103</i>	Invoice No.
REQN. No. <i>325-97786</i>	Dated
Return Authorized by	
See Reqn. No.	dated for details
Remarks Tools returned from E.I. DuPont, Belle, W. VA. for credit to reqn. 325-97786.	
If material to be disposed of to best advantage show	
A/C to be credited 325-801-091	
Disposition of expense by Sales Office if applicable	
Charge A/C Transp.	
Restkg.	
Reason for return: Accommodation; G. E. Error; Complaint; Repair; Replacement; For mounting or Shipt. with G. E. Equip.	
Reason	
RETURNED APPARATUS TAG NO. 140664	
ISSUING OFFICE { 1. Detach ORIGINAL and Carbon. 2. Mail ORIGINAL to factory BEFORE sending TAG to Customer.	
AF-274 (11-57) Rev.	

1. A returned apparatus tag, properly filled in as shown herewith, should be enclosed in each box or attached to each large piece which may be shipped as a separate item. On each tag, write the serial number of the apparatus or drawing number in the "References" block. If the customer's name is not given elsewhere, include it in the "Remarks" column.
2. When returning large parts, such as heavy castings, diaphragms, wheels, gears, etc., tags become lost or destroyed and so it is advisable to paint or stencil the name of the purchaser and an RA tag number on each of these large pieces in order to facilitate quick identification.
3. The method of shipment (car number and routing, if carload shipment is made) should be stated on the repair order and the various returned parts specifically listed to facilitate checking for shortage and prompt inspection of all material returned and preparations for repair.

THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
PY125R40ML 44			1	VALVE ASSY	101D115BBG 1	1
ITEM NO.	QUANTITY	MAINT PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
1	X		2	ASSY	101D115BB- 1	
2	3	X	2	CAP SCREW	8954954AA-85	
3	1		2	NUT HEX SLT	N216P21 -	
4	1		2	SPRG PL L	101A133AT- 1	
5	1	X	2	SPRING	101A141DT- 1	
6	3		2	SPACER	101A135AA- 1	
7	1	X	2	V STEM	101A152AS- 1	
8	1		2	V CHEST COV	101C190AN- 1	
9	1	X	2	BUSH SEG	101A298AF- 1	
10	1		2	OPER V	101B118CA- 2	
11	1		2	VLV SEAT	101C181AD- 1	
12	1		2	VALVE	101B113AA- 1	
13	1		1	ST STRAIN	101C193AA- 9	
14	1		2	SPRG PL	101A154AB- 1	
15	1		2	PIPE PLUG	9443133AA- 2	
16	1		2	PIN	101A316AM- 1	
17	1	X	2	NUT CPLG	101A206AA- 1	
18	1		2	PIN COT	N503P612 -	
19	4	X	2	CAP SCREW	N29P21008-	
20	1	X	2	BUSH SEG	101A298AH- 1	
28	4		2	WASH	N417P11 -	

122361
TURBINE SERIAL NO

6/24/63 *
DATE PRINTED

"SEE M/L" MEANS TO SEE MODEL LIST FOR ORDERING NUMBER

CODE NO. "1" INDICATES THE ITEM IS AN ASSEMBLY OF PARTS
CODE NO. "2" INDICATES THE ITEM IS A SINGLE PART

X INDICATES RECOMMENDED MAINTENANCE PARTS

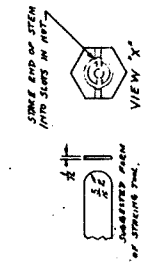
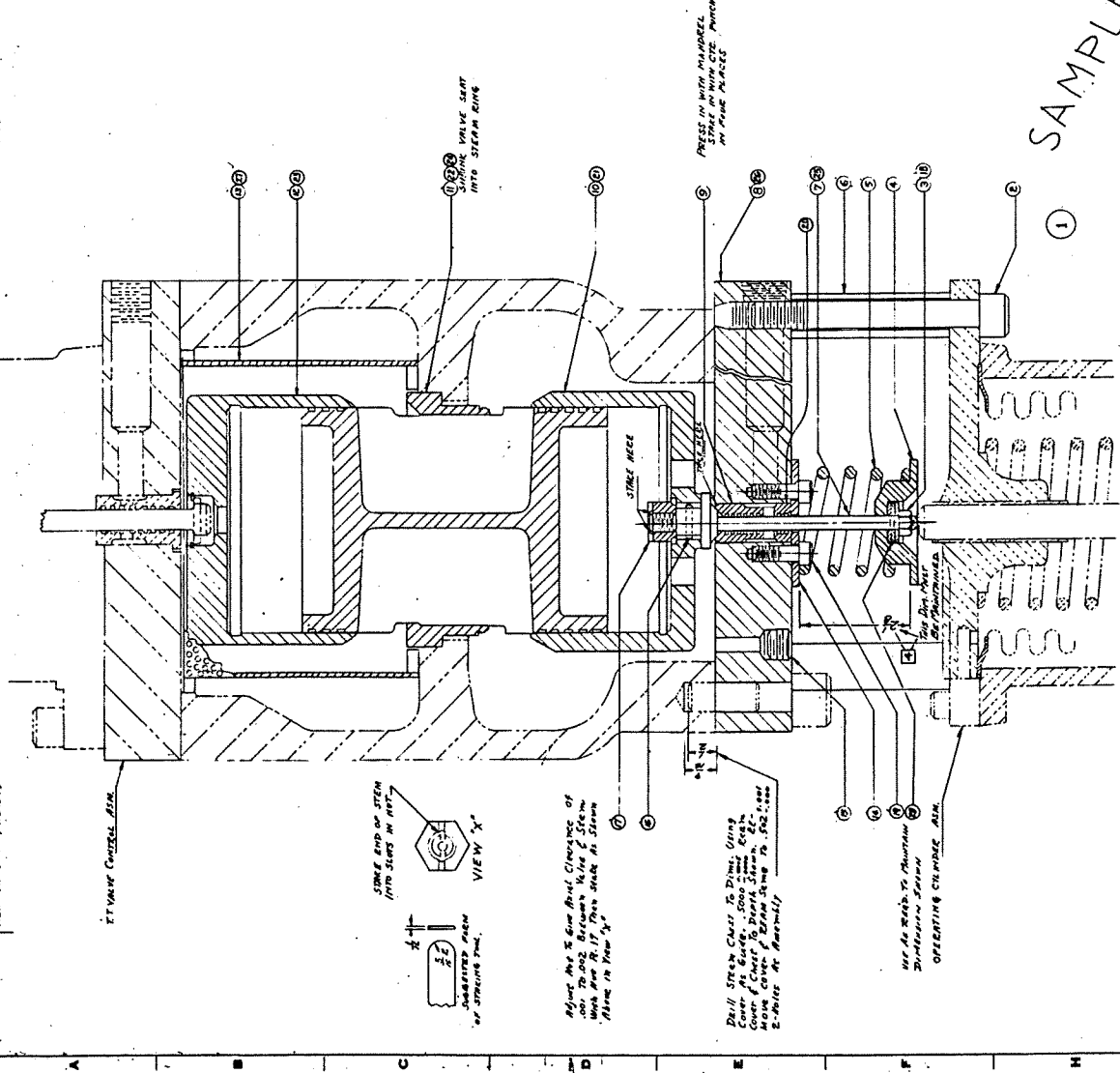
"X" MEANS FOR INFORMATION ONLY
A/R MEANS QUANTITY AS REQUIRED-REFER TO GE1-B4010 PAGE 5

SAMPLE

FOR: MODEL S. DP 100 DE SINGLE OR MULTI-STAGE
 IN CASE T, R, III & IIII H.B.P. UP TO
 7500 P.S.I. W. Valve Stem Assembly
 Valve Stem.

Case	Stem Size	Stem No.	Stem Assembly Reference
1	1/4" x 20"	1	7-11
2	1/4" x 20"	3	13-45
3	1/4" x 20"	1	5-0
4	1/4" x 20"	7	7-11
5	1/4" x 20"	3	13-45

FOR ENGRG. INFO
 FOR SUPPLY USE ONLY -
 USE 101D15EF



Adjust the 2.5mm (1/8") clearance of the 2.5mm (1/8") Stem into the 2.5mm (1/8") Stem.

Drill Stem Check to Dimension of 2.5mm (1/8") using Cover of Check to Drill Stem. Use Atom Cover of Effort 1/8" to 1/4" 2-1/2" at Assembly.

Use the 2.5mm (1/8") dimension to check the stem.

SAMPLE

101D15 BB
 OPERATING VALVE AND TRIP ASSEMBLY
 101D15 BB
 REF BY TTDY/NEEF
 1 2 3 4 5 6 7 8 9 10
 SIM TO 101D15AW
 ORIGINAL ELECTRIC
 101D15 BB
 OPERATING VALVE AND TRIP ASSEMBLY
 101D15 BB
 REF BY TTDY/NEEF

TURBINE SERIAL NUMBER 123186

WHERE USED	DESCRIPTION	DRAWING INDEX
509E121AXG 2	CLEVIS	101A195FF 11
101D115EFG 22	VALVE	101B119AF 18
DUY125R6 42	CSG WHL	101B149AE 17
DUY125R6 6	BEARING THR	101C174BAG 1
101D115EFG 22	SEAT VALVE	101C181BE 7
101C174BAG 1	RING THR	101C199BA 4
101C174BAG 1	RING THR	101C199CB 3
DUY125R6 4	BOX PKG	101C200AX 9
DUY125R6 60	BOX PKG	101C200AX 16
DUY125R6 41	PACKING CARB	101C201ABG 31
DUY125R6 34	TRIP OVSP	101C203AA 23
DUY125R6 23	ROTOR ASSY	101C319BC 1
DUY125R6 65	SWITCH MTG	101C363CFG 1
DUY125R6 64	MOUNTING	101C363DAG 1
101D112ARG 12	CONTROL TTV	101D112AR 35
DUY125R6 2	CONTROL TTV	101D112ARG 12
101D113BCG 2	BRKT BRG LP	101D113BC 1
DUY125R6 24	BRKT BRG LP	101D113BCG 2
DUY125R6 44	VALVE O+TT	101D115EFG 22
101D259AEG 8	CYL TRIP	101D259AE 1
DUY125R6 62	CYL TRIP	101D259AEG 8
DUY125R6 63	MECH TRIP	101D294ACG 7
101B149AE 17	CASING WHL	101F108AF 1
DUY125R6	MISC PARTS	101L441ABG 1
DUY125R6 66	EXTENSION	125D160AFG 2
509E121AXG 2	CLEVIS	165A223DY 1
501E439BCG 5	BRKT BRG HP	501E439BC 23
DUY125R6 1	BRKT BRG HP	501E439BCG 5

PRINTED IN U.S.A.

TURBINE SERIAL NUMBER 123186

WHERE USED

DESCRIPTION

DRAWING INDEX

DUY125R6

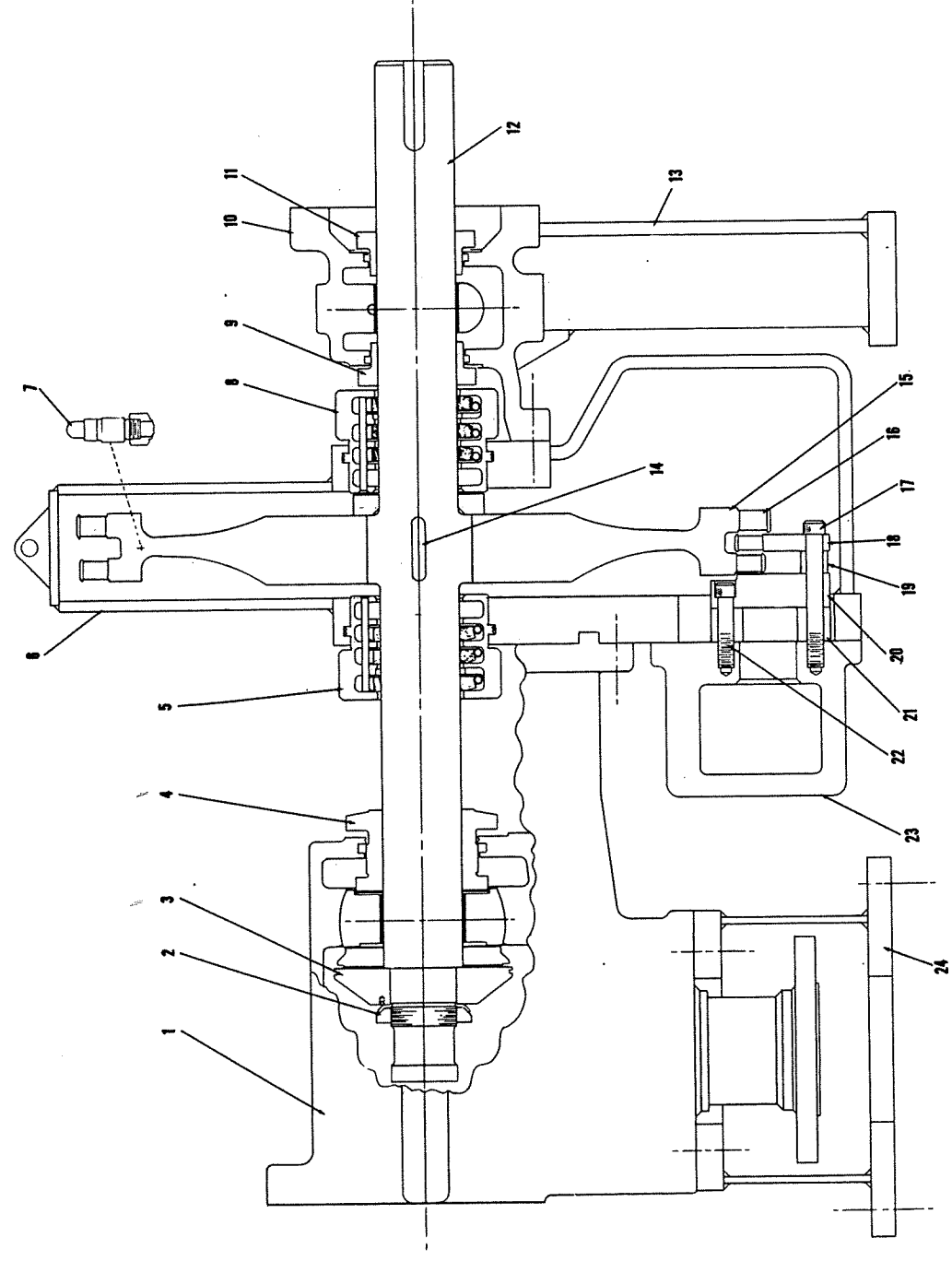
39

MTG AIR MOT

509E121AXG

2

8113
PRINTED IN U.S.A.



1. H. P. BEARING
2. H. P. SHAFT
3. TRUSET RUNNER
4. TRUSET RUNNER, OIL DEFLECTOR & BALANCING RING
5. WHEEL CASING BOX
6. WHEEL CASING
7. BENTONEL VALVE
8. BENTONEL VALVE BOX
9. OIL DEFLECTOR
10. L. P. BEARING BRACKET
11. OIL DEFLECTOR
12. SHAFT
13. L. P. SUPPORT
14. WHEEL
15. BUCKETS & BANDS
16. INTERMEDIATE
17. POST
18. INTERMEDIATE
19. NOZZLE PLATE
20. NOZZLE SPACER
21. SCREW
22. SCREW
23. H. P. SUPPORT
24. H. P. SUPPORT

16A5000P

FIG. 1 TURBINE ASSEMBLY

MODEL LIST - DP & DR SINGLE STAGE
(STANDARD)

PROD. COMP. DATE 9-23-65 NOT COMPLETE

COMP. BY & DATE		APPROVAL	CLASS	INLET	EXHAUST	RATING	ROT.	MODEL LIST NUMBER			
FR 8/12/65			3	No THR 6"	10" LEFT	1738	HPCW	TD UY125 R6			
REQ. NO. 087-BYME		CUSTOMER GTO/VULCANI		NON COND.		TD No.	NR. UNITS	TURBINE No.			
87348		CELANESE		23040			1	123186			
IT.	QTY	DESCRIPTION	MFG	PL	DRAWING NO. & G OR P	IT.	QTY	DESCRIPTION	MFG	PL	DRAWING NO. & G OR P
1	1	Brkt Brg HP	2	PL	501E439BCG5	47	1	Sp Noz Pl	2		101C161CA-1
2	1	Control TTV	3	PL	101D112ARG12	48	3	Intermediate	1	PL	101C149AA-7
3	1	Cyl Opr	3	PL	101B199	49	X	Diag Inter	3		101D102AA
4	1	Box Pkg (HP3")	3	PL	101C200AX-9	50	X	Diag N Clr	3		101A685AB
5	1	Support HP	2	PL	509E131BCG2	51	+	Pump/Sup Gov	3	PL	101D119
6	1	Brg Thr	3	PL	101C174BAG1	52	1	Base/Sole Pl	2	PL	101D110BR-1
7	+	Mech Trip	3	PL	101D114A	53	1	Pts Misc B	2	PL	101D110BR G-2
8	X	Plate Noz	2		101C134AA-1	54	1	Lag Met	4	PL	125D343FXG-1
10	1	Key No. 25-2			Nozzle Reaming Spec 1F7F5F7	55	1	Lag Plstc	4		K-9476508-1
13	1	Ampl Sp Cont	3	PL	101B175	56	-	Cplg HS	3		
14	+	Cooler Oil	3	PL		57	-	Cplg LS	3		
15	1	Plate Name	3	PL	165A479BXG2	58	-	Pump Asm Hand	3	PL	101B277A-1
16	1	Valve Sent	3	PL	101A126AD-16	59	1	CSG LINER	PL	101C300CC-3	
18	1	Mech Sp Cont	3	PL	101D121	60	1	BOX PKG LPS	PL	101C200AX-16	
19	1	Brkt Gov Con	3	PL	101B170AA	61					
20	1	Governor	3	PL	FUEL REG BY STD	62	1	CYL TRIP	PL	101D259AEG8	
21	1	Valve Pilot	3	PL	101A192AK	63	1	MECH TRIP	PL	101D294ACG7	
22	1	Conn Opr Vlv	3	PL	101B120AA	64	1	MTG SW (LOP)	PL	101C363DAG1	
23	1	Rotor Asm	1	PL	101C319BC-1	65	1	MTG SW (ND)	PL	101C363CEG1	
24	1	Brkt Brg LP	2	PL	101D113BCG2	66	1	EXTENSION (TRIP)	PL	125D160AFG2	
25	2	Bearing LPWP	3	PL	101C173AB-1	67	X	SHIP LOOSE	-	165A476RY-G1	
26	1	Support LP	2	PL	101C172AA-6	68					
27	1	Piping Drain	4	PL	101C178AAG-1	69					
28	1	Piping Oil	4	PL	125D9B2FXG4	70					
29	1	Brkt Spcr	2	PL		71					
30	1	Shaft Remach	1			72					
31	1	Brkt Spcr Asm	2	PL		73					
32	1	Gear Driver				74					
33	1	Gear Driver				75					
34	1	Trip OvSp	1	PL	101C203AA-23	76					
34A	X	Setting OvSp	1		5406	77					
35	1	Valve Hand	3	PL		78					
36	2	Cover HV	3	PL	101B145AB-1	79					
37	1	Wrench HV	3	PL		80	X	PAINT	4		
38	1	Motor Air	3	PL	101B270XR-1	81		Inst Ppg	4		
39	1	Mtg Air Mot	3	PL	509E121AXG2	82		Gear	3		
40	1	Parts Misc	3	PL	101L441ABG1	83	X	Outline Gear	3		
41	2	Packing Asm	3	PL	101C201ABG31	84	X	Diag Oil Flv	4	-	101B405XF
42	1	Casing Exh	2	PL	101B149AE-17	85	X	Inst Test	3		101A140BS
43	1	Piping St Sl	4	PL	101B170AA-6	86	X	Outline	3	-	101D164YD
44	1	Valve OTT	3	PL	101D115EFG22	87	X	Spec Eng	3		165A493AR
45	1	Ring Steam	2	PL	101F102AA-1	88	X	Books Inst	3		GEK 5743
46	1	Wheel Bkt	1	PL	101C145DE-10	89	-	Pts Spare	3	PL	
						90	1	Turb Asm	3		

THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
509E121AXG -			2	CLEVIS	101A195FF -	11
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
11	1		2	CLEVIS AG5	101A195FF - 11	
12	1	X	2	BEARING	101A771BC - 24	
13	1		2	CLEVIS	101A195FF - 13	

123186
TURBINE SERIAL NO.

01-05-66
DATE PRINTED

"SEE M/L" MEANS TO
SEE MODEL LIST FOR
ORDERING NUMBER

CODE NO. "1" INDICATES THE ITEM IS AN ASSEMBLY OF PARTS
 CODE NO. "2" INDICATES THE ITEM IS A SINGLE PART
 X INDICATES RECOMMENDED MAINTENANCE PARTS
 "X" MEANS FOR INFORMATION ONLY
 "A/R" MEANS QUANTITY AS REQUIRED - REFER TO GE I-84010 PAGE 5

40 R-4066015-381AB

GENERAL ELECTRIC

101A195FF

CONT ON SHEET - SH NO. 1

REV NO. 012
101A195FF

TITLE
CLEVIS

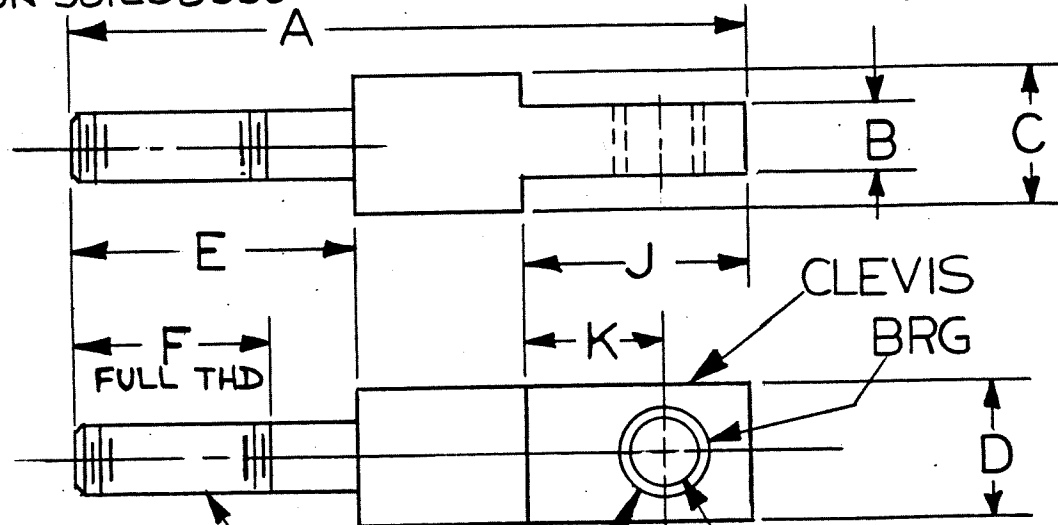
FIRST MADE FOR SO.122117 (7TDY125R208)

FCF ON 501E383BC

SIM TO 9475217AF

PL 155

REVISIONS



H THD (NC3/NF3)

+0005
L-0000

DIA THRU CLEVIS

M +0005
-0000 ID BRG
AFTER ASSY

CLEVIS 250 WHERE MACH EXCEPT AS SHOWN

	PT	A	B	C	D	E	F	H	J	K	L	M	NAME & DATE ADDED	REV
C STL	1	3 15/16	1/4	3/4	3/4	1 3/8	1"	3/8-24	1/16	1/16	.4375	.2498		0
SST	2													
C STL	3		1/2											
SST	4													
SST	11	4 1/4	3/4	1/4	1/4	1/4	1"	1/2-13	1/2	1"	.5625	.3755	R. J. HACHEY OCT. 21, 1964	1
SST	15	4 13/16	3/4	1/4	1/4	1/4	1"	1/2-13	1/2	1"	.5625	.3755	G. A. HACHEY MAY 3, 1965	2

11B
C
I
H
IND-9
PRINTS TO

MADE BY P. Lindero MAY 10, 1960

APPROVALS HRA

SM ST TURB

DIV OR DEPT.

101A195FF

F. Saunders May 26, 1960

FITCHBURG

LOCATION

CONT ON SHEET

SH NO. 1

FF-803-WA (4-60)
PRINTED IN U. S. A.

MICROFILM 10

THIS ASSEMBLY IS LOCATED ON				LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
101D115EFG - 22				2	VALVE	101B119AF - 18	1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION		ORDERING NUMBER	
18	1		2	VALVE AG18		101B119AF - 18	
33	1		2	VALVE		101B118AR - 2	
35	1	X	2	RING RET		101A134BA - 8	
38	1		2	STEM		134B111AD - 2	

123186
TURBINE SERIAL NO.

01-05-66
DATE PRINTED

"SEE M/L" MEANS TO
SEE MODEL LIST FOR
ORDERING NUMBER

CODE NO. "1" INDICATES THE ITEM IS AN ASSEMBLY OF PARTS
CODE NO. "2" INDICATES THE ITEM IS A SINGLE PART
X INDICATES RECOMMENDED MAINTENANCE PARTS
"X" MEANS FOR INFORMATION ONLY
"A/R" MEANS QUANTITY AS REQUIRED - REFER TO GE I-84010 PAGE 5

101B119AF
CONT ON SHEET

GENERAL ELECTRIC

101B119AF
CONT ON SHEET

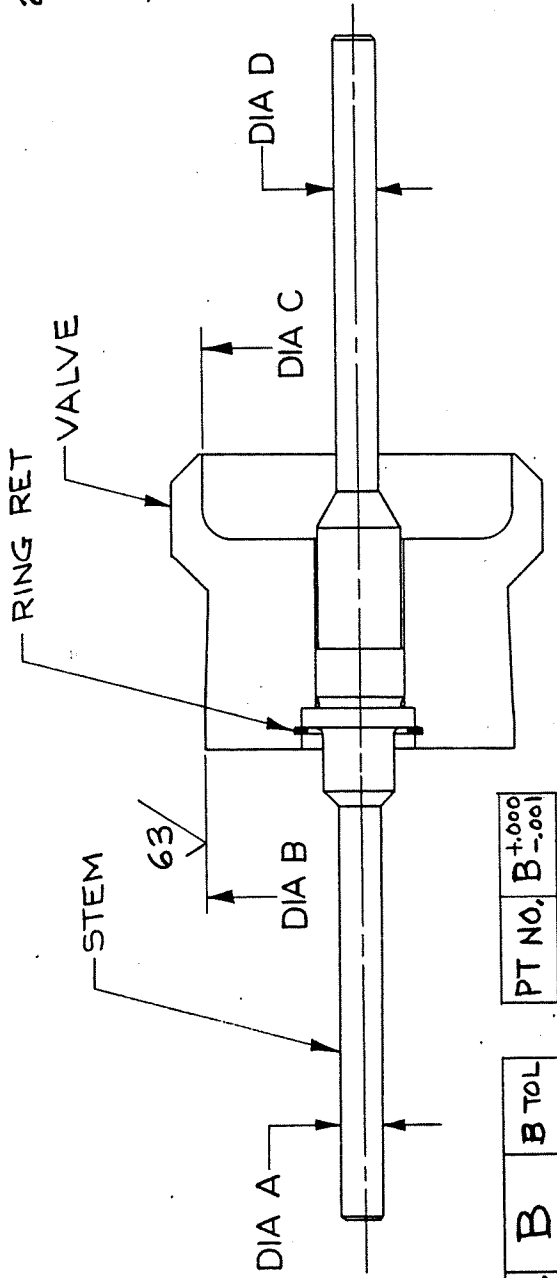
101B119AF
CONT ON SHEET

VALVE
FIRST MADE FOR DA-984

PL ISSUED

UNLESS OTHERWISE SPECIFIED USE THE FOLLOWING:
 SURFACES FRACTIONS DECIMALS ANGLES
 APPLIED PRACTICES 63

- NOTES
- HEAT VALVE TO 800°-900° F AND ASSEMBLE
 - DIA A, B, & D TO BE CONC WITHIN .001 TIR AFTER ASSY
 - DIA C TO BE CONC WITH DIA A & D WITHIN:
 - .002 TIR FOR PARTS 1 THRU 4 & 10 THRU 13
 - .003 TIR FOR PARTS 5 THRU 9 & 14 THRU 20



PT NO.	B	B TOL
1 & 10	1.0640	+ .0000 - .0005
2 & 11	1.2510	
3 & 12	1.501	
4 & 13	1.688	- .000 - .001
5 & 14	1.814	
6 & 15	2.064	

PT No.	B	TOL
7 & 16	2.314	+ .000 - .001
8 & 17	2.688	
9 & 18	3.251	
19	3.876	
20	5.001	

APPROVED	DATE
FILED	4/3/60
MADE	
CHECKED	

REVISIONS

1	TAB & C3 ADDED	118
2	NOTE 2 WAS "DIA A, B, C, & D etc."	40
3	NOTE 3 ADDED	104
		11

PRINTS TO

APPROVALS
 DIVISION: FEB 24, 1960
 DEPT: FITCHBURG
 LOCATION: CONT ON SHEET

101B119AF
CONT ON SHEET

THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
DUY125R6 - 42			1	CSG WHL 101B149AE - 17		1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
3	1		2	FLANGE EXH	101A169AC - 1	
14	1		1	CASING WHL	101F108AF - 1	
16	1		1	PLUG	101B376BA - 1	
17	1		2	CSG WHL AG5	101B149AE - 17	

123186
TURBINE SERIAL NO.

01-05-66
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101B149AE
DRAWING NO.
CONT. ON SHEET
SH. NO. 1

GENERAL ELECTRIC

101B149AE
DRAWING NO.
CONT. ON SHEET
SH. NO. 1

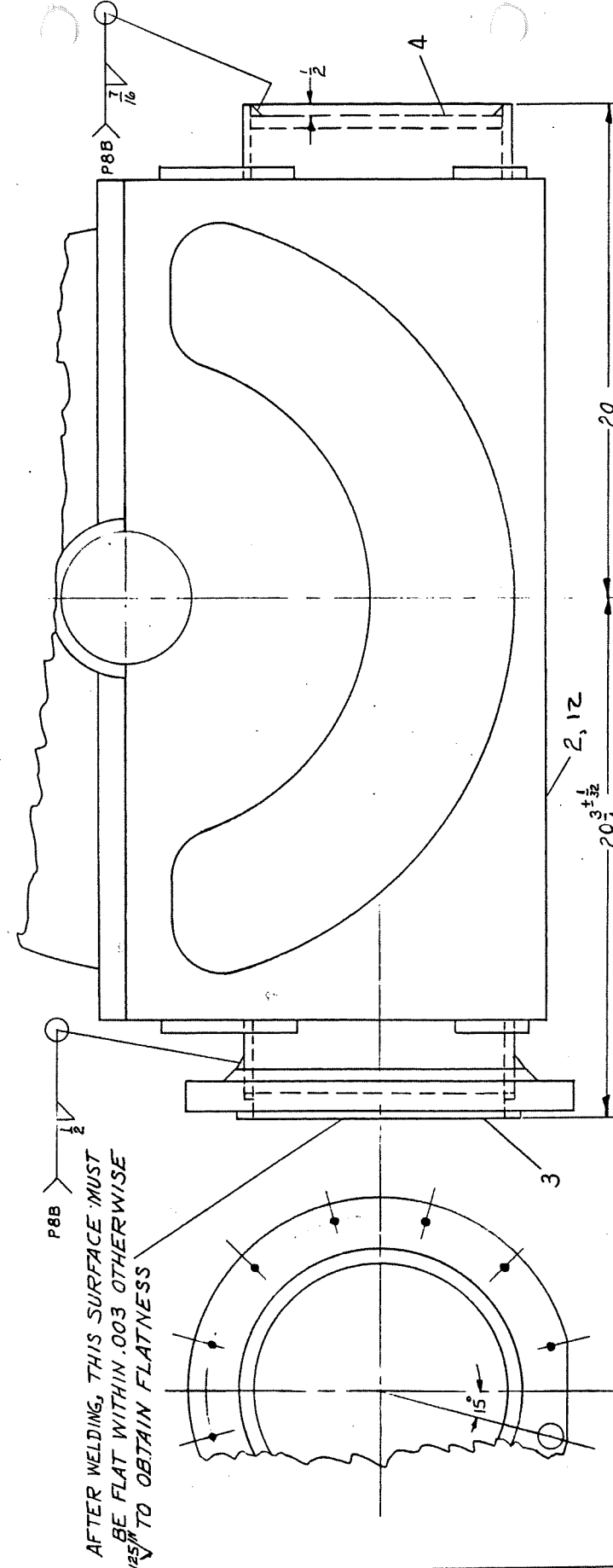
UNLESS OTHERWISE SPECIFIED USE THE FOLLOWING--			
APPLIED PRACTICES	SURFACES	TOLERANCES ON DECIMALS	TOLERANCES ON ANGLES
	✓	+ -	+ -

KEY & X-2
101B149AE
DRAWING NO.
CONT. ON SHEET
SH. NO. 1

TITLE
WHEEL CASING L.H.
FIRST MADE FOR G.E. TURBINE TYPE DP-25

SIM. TO 101B149AB

P. L. ISSUED



AFTER WELDING, THIS SURFACE MUST BE FLAT WITHIN .003 OTHERWISE TO OBTAIN FLATNESS

20 ^{±1/32}
2.12

20
2

20

PRINTS TO
102 C
I
U
R
M 118

REVISIONS	DATE	BY	REASON
1	JAN 26 1959	V. S. BARRY	ADDED P12.313
2	MAR 7 1964	W. J. BARRY	CRS 5863
3			ADD FLAT TO FLG

APPROVALS
 W. J. BARRY MAR 21 1964
 W. J. BARRY MAR 21 1964
 W. J. BARRY MAR 21 1964

SM. TURB. & SUPPLIES, DIV.
 FITCHBURG

101B149AE
 DRAWING NO.
 CONT. ON SHEET
 SH. NO. 1

MICROFILM

THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
DUY125R6 - 6			1	BEARING THR 101C174BAG-		1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
1	2		2	PIN	9443112AA - 285	
2	1		1	THR RING	101C199CB - 3	
4	1		1	RING THR	101C199BA - 4	
5	X		2	ASSY	101C174BA - 5	

123186
TURBINE SERIAL NO.

01-05-66
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101C174 BA
 1. L. H. H. NOV 27 1961
 2. ADDED P.T.S. 41, 42, 43
 3. L. H. H. JUN 6 1960
 4. ADDED P.T.S. 44, 45
 5. ADDED P.T.S. 46, 47, 48
 6. ADDED P.T.S. 49, 50

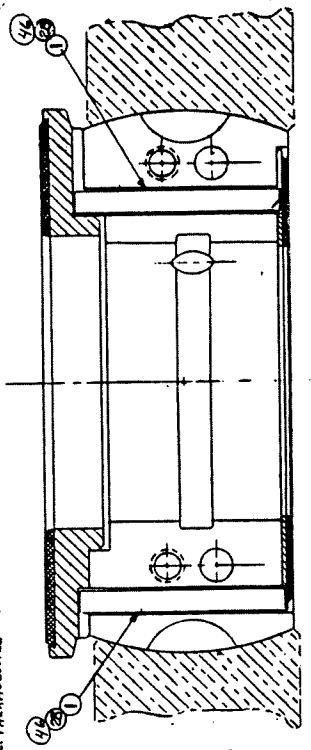
G14 - D3 - 6-13-22.6 TCCM / 72.46G
 G15 - D3 - 6-15-22.6 TCCM / WITH #16
 FLAT LAND INACTIVE
 G16 - D3 - 6-17 FLAT ACTIVE # INACTIVE
 G17 - D3 - 6-17 TAPER LAND CCW #4

GR.1 - D3 - 6-17 TCCM - #3
 GR.2 - D3 - 6-17 TCCM - #4
 GR.3 - D3 - 6-17 TCCM - #4
 GR.4 - D3 - 6-17 TCCM - #4
 GR.5 - D3 - 6-17 TCCM - #4
 GR.6 - D3 - 6-17 TCCM - #4
 GR.7 - D3 - 6-17 TCCM - #4
 GR.8 - D3 - 6-17 TCCM - #4
 GR.9 - D3 - 6-17 TCCM - #4
 GR.10 - D3 - 6-17 TCCM - #4
 GR.11 - D3 - 6-17 TCCM - #4
 G12 - D3 - 6-17 TCCM - #4
 G13 - D3 - 6-17 TCCM - #4

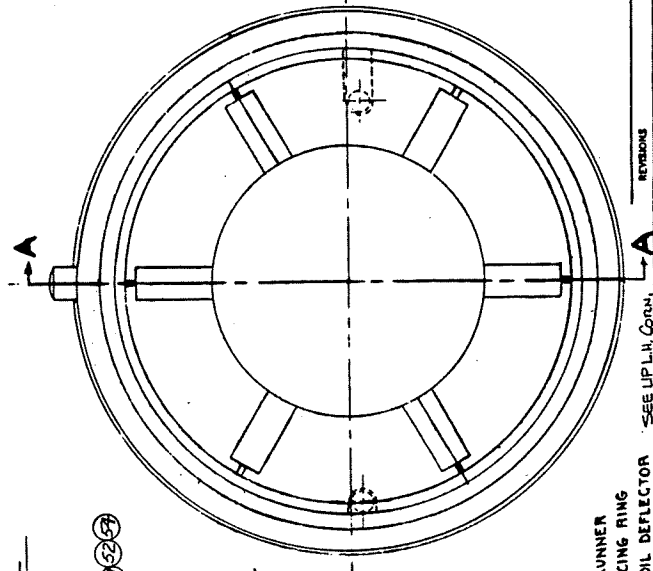
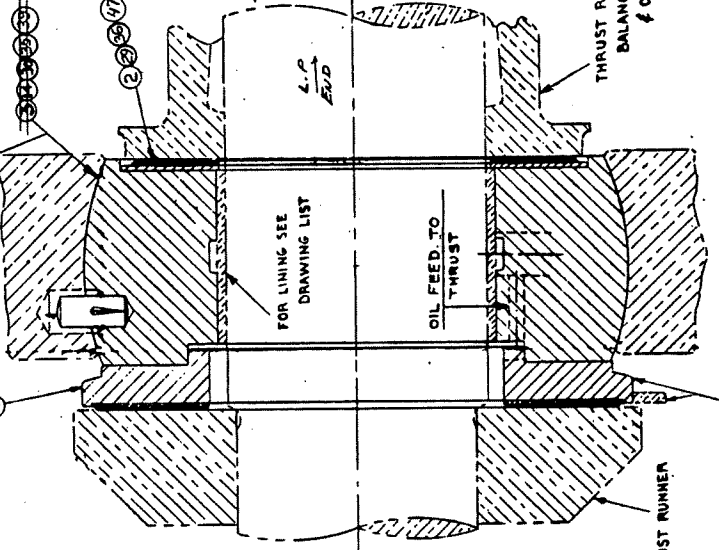
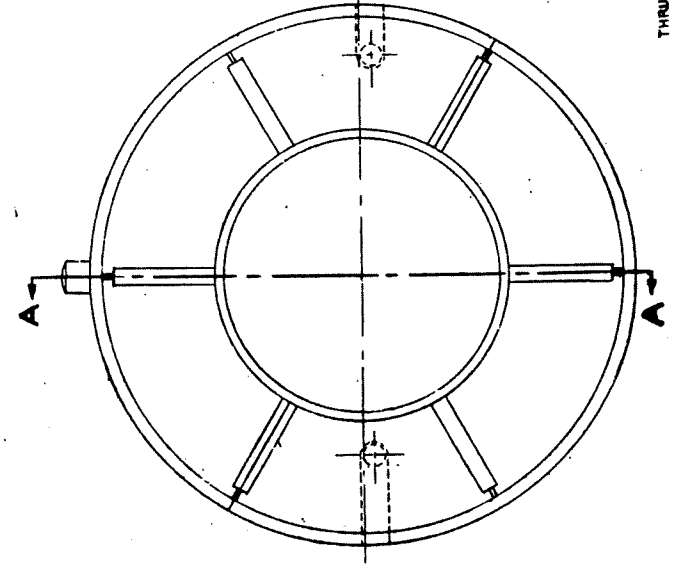
APPROVED BY	INITIALS	DATE
MILLER	3.00	3-18-51
MANUFACTURING	107	3-24-51
ENGINEER	1528	3-15-51

GENERAL ELECTRIC
101C174 BA
THRUST BEARING ASSEM,
 FIRST MADE FOR G.E. TURBINE, TYPE D, MULTI STAGE

P.L. ISSUED



PLAN VIEW OF LOWER HALF
 (SHOWING PINS IN PLACE)



THRUST RUNNER
 BALANCING RING
 OIL DEFLECTOR
 OIL FEED TO THRUST
 THRUST RUNNER

SECTION 'A-A' 33 35 37 38 39 40 41 42 43 44

REV.	DATE	DESCRIPTION
1	APR 14 1952	REVISED FOR COR. 14, 15, 16
2	MAY 14 1952	REVISED FOR COR. 14, 15, 16
3	JULY 12 1952	REVISED FOR COR. 14, 15, 16
4	AUG 14 1952	REVISED FOR COR. 14, 15, 16
5	SEP 14 1952	REVISED FOR COR. 14, 15, 16
6	OCT 14 1952	REVISED FOR COR. 14, 15, 16
7	NOV 14 1952	REVISED FOR COR. 14, 15, 16
8	DEC 14 1952	REVISED FOR COR. 14, 15, 16
9	JAN 14 1953	REVISED FOR COR. 14, 15, 16
10	FEB 14 1953	REVISED FOR COR. 14, 15, 16
11	MAR 14 1953	REVISED FOR COR. 14, 15, 16
12	APR 14 1953	REVISED FOR COR. 14, 15, 16
13	MAY 14 1953	REVISED FOR COR. 14, 15, 16
14	JUN 14 1953	REVISED FOR COR. 14, 15, 16
15	JUL 14 1953	REVISED FOR COR. 14, 15, 16
16	AUG 14 1953	REVISED FOR COR. 14, 15, 16
17	SEP 14 1953	REVISED FOR COR. 14, 15, 16
18	OCT 14 1953	REVISED FOR COR. 14, 15, 16
19	NOV 14 1953	REVISED FOR COR. 14, 15, 16
20	DEC 14 1953	REVISED FOR COR. 14, 15, 16

101C174 BA
 MICROFILM

THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
101D115EFG - 22			2	SEAT VALVE 101C181BE - 7		1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
1	1		1	SEAT VALVE	101C181BE - 1	
5	1	X	2	BUSHING	165A239AX - 1	
7	1		2	SEAT AG3	101C181BE - 7	

123186
TURBINE SERIAL NO.

01-05-66
DATE PRINTED

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THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE	
101C174BAG -			1	2	RING THR	101C199BA - 4	1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION		ORDERING NUMBER	
1	1		2	RING THR		101C199BA -	1
2	1		2	RING THR		101C199BA -	2
3	AR		2	BABBITT MET		101C199BA -	3
4	1	X	2	RING AG1		101C199BA -	4

123186
TURBINE SERIAL NO.

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10119668

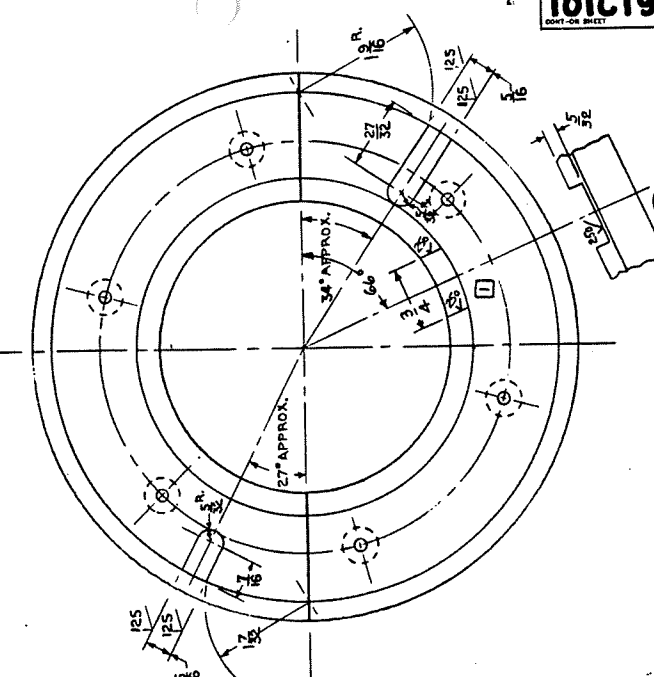
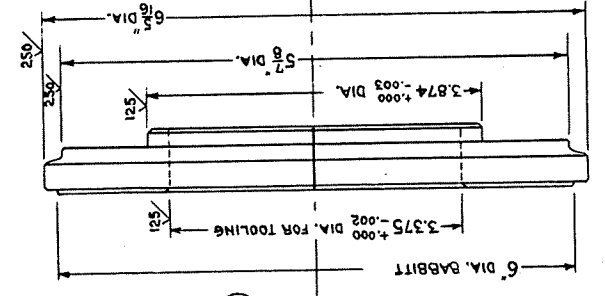
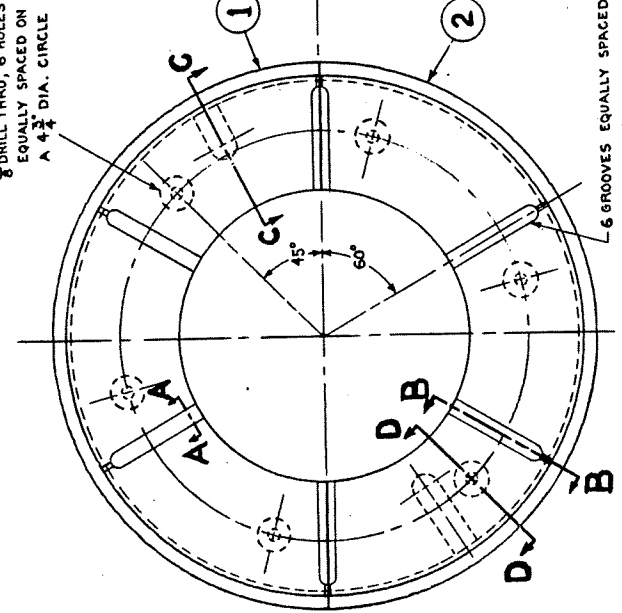
GENERAL ELECTRIC
101C199BA
 TITLE THURST RING
 ACTIVE
 FIRST MADE FOR G.E. TURBINE, TYPE D, MULTI STAGE

COMP. OF UNIT
 FLAT LAND
 D 3'-6"-17
 MULTI STAGE

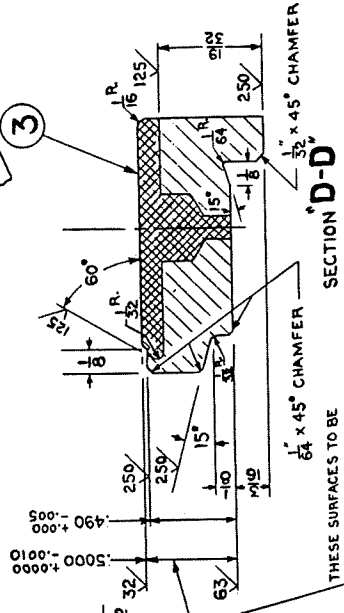
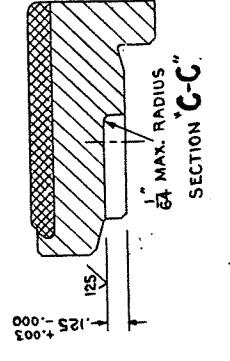
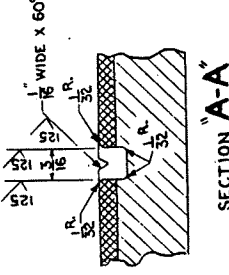
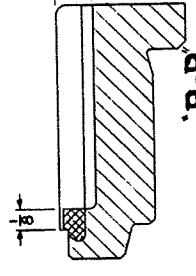
P.L. ISSUED

APPROVED BY	INITIALS	DATE
MANUFACTURING ENGINEER	J.V.	3-29-57
		3-5-57

3/8" DRILL, 3/16" DEEP.
 1/8" DRILL THRU, 6 HOLES
 EQUALLY SPACED ON
 A 4 1/2" DIA. CIRCLE



- NOTES-
1. STRESS RELIEF ANNEAL TO 101A-401AA AFTER ROUGH MACHINING
 2. HALVES TO BE STOCKED IN PAIRS



THESE SURFACES TO BE PARALLEL TO EACH OTHER WITHIN .0005

64 x 45° CHAMFER

36 x 45° CHAMFER

REVISIONS

NO.	DESCRIPTION
1	1. PAPER OUT OF STOCK FOR C-6

PRINTS TO

11B	
11	
10*	

10119668

PROJECT G. B. COMPANY JAN 22, 51
 AUX. TURBINE ENGR.
 FITCHBURG

101C199BA
 MICROFILM

THIS ASSEMBLY IS LOCATED ON				LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
101C174BAG - 1				2	RING THR 101C199CB - 3		1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER		
1	1		2	RING THR	101C199CB - 1		
2	1		2	RING THR	101C199CB - 2		
3	1	X	2	RING AG1	101C199CB - 3		

123186
TURBINE SERIAL NO.

01-05-66
DATE PRINTED

"SEE M/L" MEANS TO
SEE MODEL LIST FOR
ORDERING NUMBER

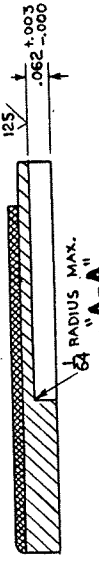
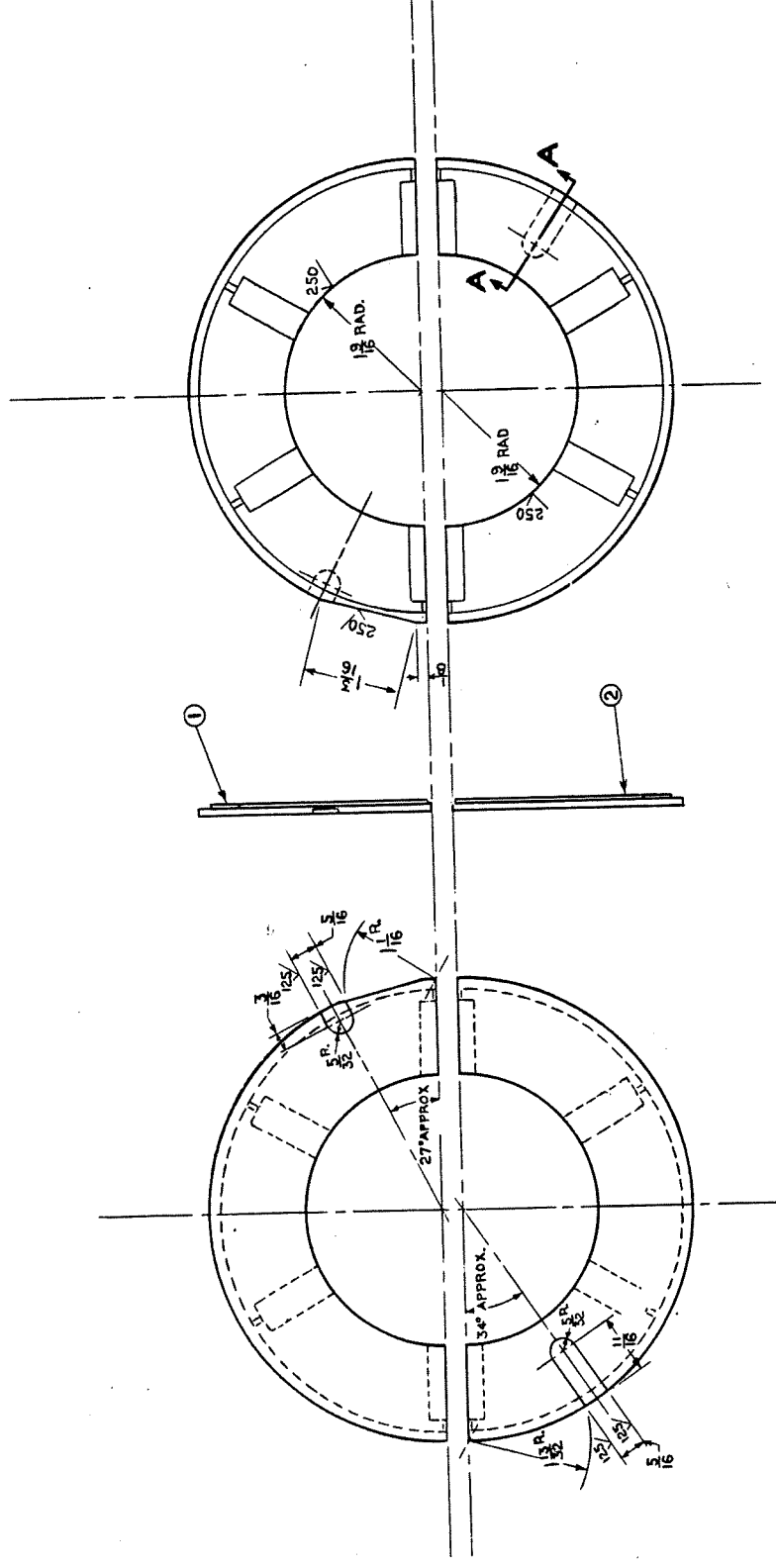
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956615101

101C199CB

GENERAL ELECTRIC
TITLE THRUST RING
INACTIVE
FIRST MADE FOR G.E. TURBINE TYPE D MULTI STAGE

P.L. ISSUED



NOTES -
1. HALVES TO BE STOCKED IN PAIRS

APPROVED BY	INITIALS	DATE
MATL. ENGR.	3.00	3-8-51
MANUFACTURING ENGINEER	3.00	3-29-51

REVISIONS

NO.	DESCRIPTION	DATE
1	REVISED TO SHOW CHANGES MADE	
2		
3		
4		
5		
6		

101C199CB
AUX. TURBINE ENGR. FITCHBURG
FEB. 13, 51

MICROFILM

PROPERTY OF G.E. GENERAL ELECTRIC COMPANY

THIS ASSEMBLY IS LOCATED ON				THIS PAGE COVERS PARTS FOR		PAGE
ITEM NO.	QUANTITY	MAINT. PARTS	LEVEL CODE	DESCRIPTION	ORDERING NUMBER	
125R6 - 4 1				BOX PKG	101C200AX -	9
4	2		2	ELBOW	165A267EC -	4
5	1		2	NIPPLES	165A277AA -	5
6	1		2	NIPPLE	101C200AX -	6
8	1		2	PLUG PIPE	9443133AA -	2
9	1		2	BOX AG3	101C200AX -	9
11	1		1	BOX PKG	101C200AH -	5

123186
TURBINE SERIAL NO.

01-05-66
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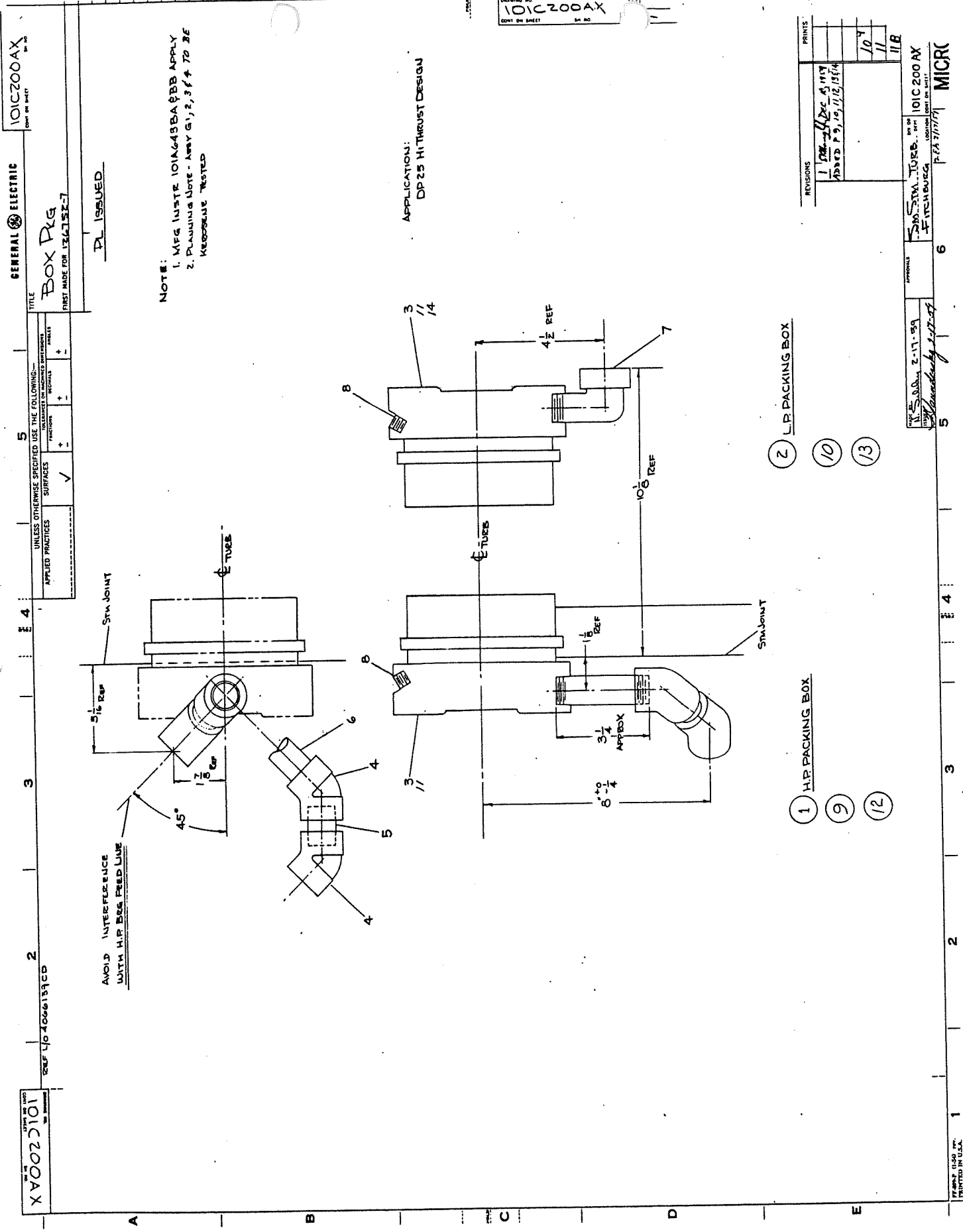
THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
DUY125R6 - 60			1	BOX PKG	101C200AX - 16	1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
7	1		2	STREET ELBO	165A275AA - 4	
8	1		2	PLUG PIPE	9443133AA - 2	
15	1		2	BOX PKG	101C200CD - 1	
16	1		2	BOX AG7	101C200AX - 16	

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- ① H.P. PACKING BOX
- ⑨
- ⑫

- ② L.P. PACKING BOX
- ⑩
- ⑬

REVISIONS	PRINTS
1 10/24/54	10
2 11/12/54	11
3 11/12/54	11B

DRAWN BY: *[Signature]*
 CHECKED BY: *[Signature]*
 DATE: 2-17-59
 APPROVED BY: *[Signature]*
 SPECIAL INSTRUCTIONS: *[Signature]*
 PART NO. 101C200AX
 QUANTITY: 1000
 DATE: 2/17/59
 MICR

THIS ASSEMBLY IS LOCATED ON				LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
DUY125R6 - 41				1	PACKING CAR 101C201ABG- 31		1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION		ORDERING NUMBER	
2	3	X	2	SPR CLIPS		9475255AA - 1	
6	X		2	ASSY		101C201AB - 6	
11	3	X	2	PACKING CAR		4856134AA - 51	
12	3	X	2	SPRING		101A150CA - 18	

123186
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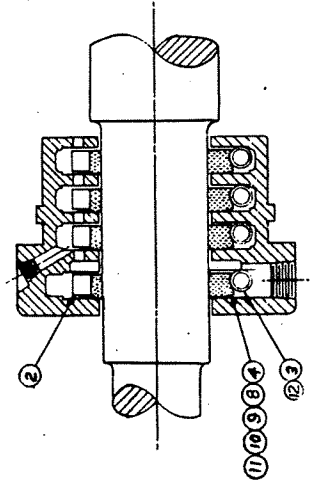
"SEE M/L" MEANS TO
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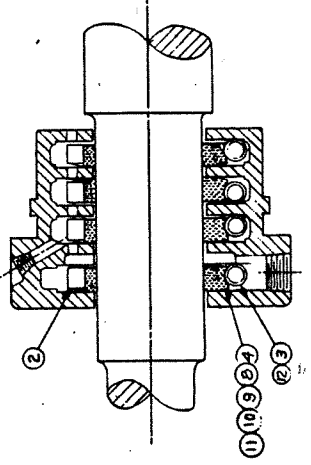
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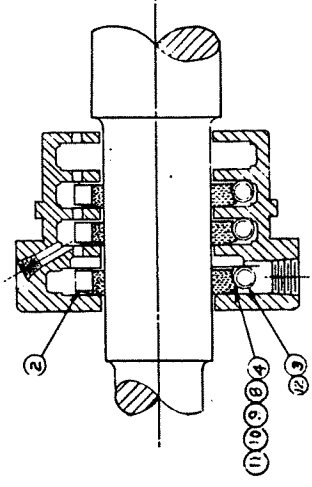
4 RINGS FOR PRESSURE

(1)



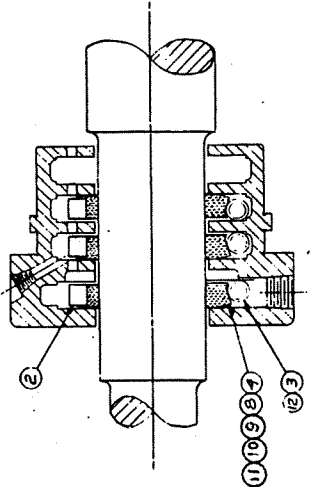
4 RINGS FOR PRESSURE & VACUUM

(5)



3 RINGS FOR PRESSURE

(6)



3 RINGS FOR VACUUM

(7)

REVISIONS

1	101C201AB	101C201AB	101C201AB
2	Added part B		
3	Added part C		
4	Added part D		
5	Added part E		

PRINTED IN U.S.A.

APPROVED BY	INITIALS	DATE
MAN'L ENGINEER		
MANUFACTURING ENGINEER		

H. J. ESCOB

GROUP	DESCR.	QTY.	UNIT
1	ASSEMBLY	1	ASSEMBLY
2	ASSEMBLY	1	ASSEMBLY
3	ASSEMBLY	1	ASSEMBLY
4	ASSEMBLY	1	ASSEMBLY
5	ASSEMBLY	1	ASSEMBLY
6	ASSEMBLY	1	ASSEMBLY
7	ASSEMBLY	1	ASSEMBLY

PISTON RINGS FOR GE. TURBINE TYPE D
 PART NO. 101C201AB
 MANUFACTURED BY GENERAL ELECTRIC WORKS
 101C201AB
 MICROFILM

THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
DUY125R6 - 34			1	TRIP OVSP 101C203AA - 23		1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
001	X		2	ASSY	101C203AA -	1
002	1		2	HOUSING	101A158AA -	1
003	1		2	PLNGR	101A159AA -	1
004	1		2	PIN	9443112AB -	1
005	AR		2	SPACER	101A135AF -	1
022	1		2	SPRING	101A141KL -	1
023	1	X	2	TRIP AG9	101C203AA -	23
024	AR		2	SPACER	101A135AF -	2
025	AR		2	SPACER	101A135AF -	3
026	AR		2	SPACER	101A135AF -	4
045	AR		2	SPACER	101A135AF -	5
046	AR		2	SPACER	101A135AF -	6
047	AR		2	SPACER	101A135AF -	7
069	AR		2	SPACER	101A135AF -	8
070	AR		2	SPACER	101A135AF -	9
071	AR		2	SPACER	101A135AF -	10
072	AR		2	SPACER	101A135AF -	11

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DATE PRINTED

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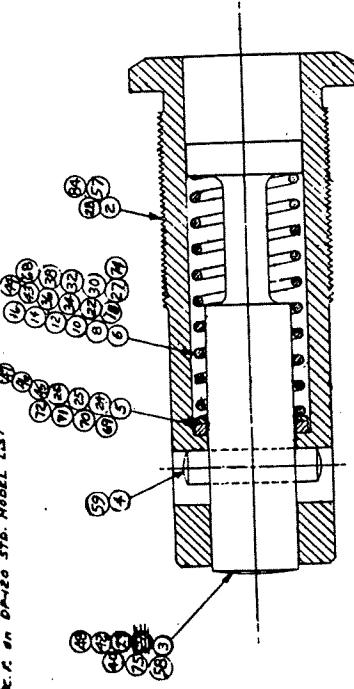
CODE NO. "1" INDICATES THE ITEM IS AN ASSEMBLY OF PARTS
 CODE NO. "2" INDICATES THE ITEM IS A SINGLE PART
 X INDICATES RECOMMENDED MAINTENANCE PARTS
 "X" MEANS FOR INFORMATION ONLY
 "A/R" MEANS QUANTITY AS REQUIRED - REFER TO GE I-84010 PAGE 5

101C203AA

THIRD ANGLE PROJECTION

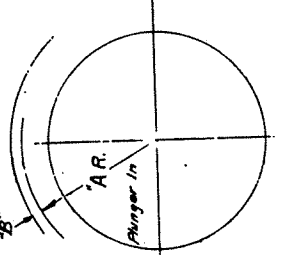
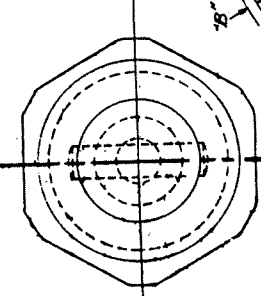
NOTES: 1- FOR ASSEMBLY AND TEST OF OVERSPEED GOVERNOR REFER TO "TURBINE INSTRUCTION" DWG-101A643AE.

REV. OF DWG STD. MODEL LIST



SECTION "AA"

1



SHAFT	1 7/8"	5/16"
PLUNGER	1 3/16"	3/16"
ROCKERS	1 3/16"	3/32"
ROCKERS	1 3/16"	5/16"

TRIP SPEED RANGE

G.25-3760-5260
G.26-4560-5750
G.27-5500-6000
G.28-6000-7000
G.29-7000-8000
G.30-8000-9000
G.41-4560-5750 (STAINLESS STL. HOUSING)

PL. ISSUED

OVERSPEED TRIP

112
11B
12NF
11
11

FIRST MADE BY G.E. TURBINE TYPE DP 114-129-118F
 MADE BY G.E. TURBINE TYPE DP 114-129-118F
 MADE BY G.E. TURBINE TYPE DP 114-129-118F
 MADE BY G.E. TURBINE TYPE DP 114-129-118F

GENERAL ELECTRIC
 101C203AA

REVISIONS

NO.	DATE	DESCRIPTION
1	7/26/60	REVISED FROM PROJECT
2	8/11/64	REVISED FROM PERM.
3	8/11/64	REVISED FROM PERM.

36 APPROV. GR. 41 R. M. 84

THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
DUY125R6 - 23			1	ROTOR ASSY 101C319BC - 1		1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
1	1	X	2	ROTOR AG1	101C319BC - 1	
2	1		2	SHAFT	101C371AF - 1	
3	1		2	NUT	134B353AA - 10	
4	1		2	WASHER	134B353AA - 110	
5	1		2	KEY	9443160AA - 103	
6	1	X	2	THR RUNNER	101A156BC - 1	
7	1	X	2	BAL RING	101B239AH - 1	
8	12		2	SCR SET	N70P2508 -	
9	6		2	SCR SET	N70P2510 -	
10	6		2	SCREW	N70P2512 -	
11	X		2	WHEEL	ML 46 -	
12	1		2	KEY	9443160AA - 253	
13	1		2	RING BAL	101B239AS - 1	
14	1		2	DEFL OIL	101A155BE - 1	
15	18		2	SCREW	N70P2504 -	
16	6		2	SCREW	N70P2505 -	
17	6		2	SCR SET	N70P2506 -	
18	1		2	KEY	165A130AC - 61	
19	1		2	KEY	165A130AC - 175	
20	X		2	TRIP OVSP	ML 34 -	

123186
TURBINE SERIAL NO.

01-05-66
DATE PRINTED

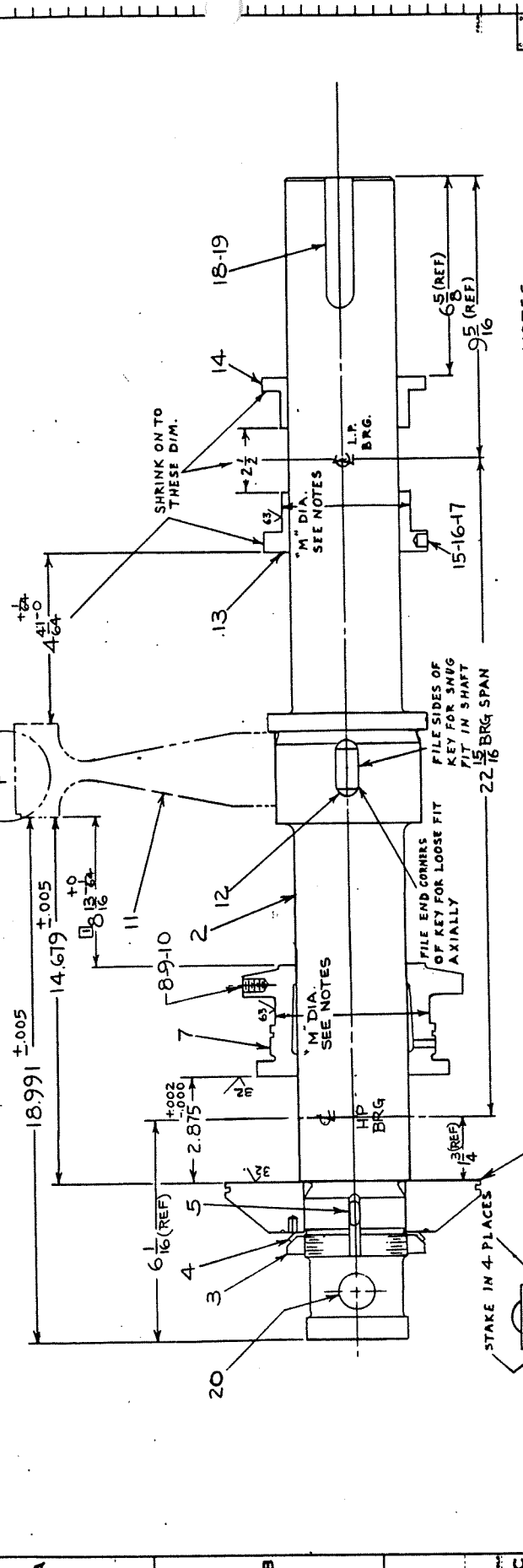
"SEE M/L" MEANS TO
SEE MODEL LIST FOR
ORDERING NUMBER

CODE NO. "1" INDICATES THE ITEM IS AN ASSEMBLY OF PARTS
CODE NO. "2" INDICATES THE ITEM IS A SINGLE PART

X INDICATES RECOMMENDED MAINTENANCE PARTS

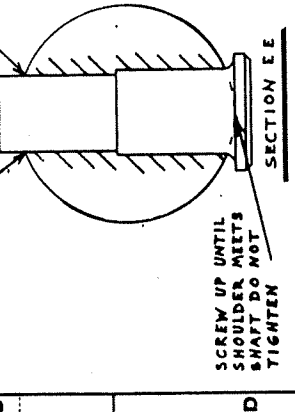
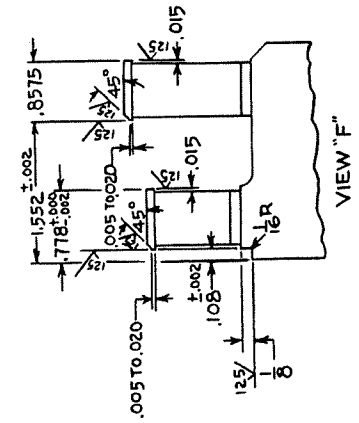
"X" MEANS FOR INFORMATION ONLY

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- NOTES
1. ROTOR TO BE MACH TO SFT RUNOUT TO 101A643AC
 2. ALL RIM DIM TO BE TAKEN IN LINE & ON THE SAME SIDE AS THE WHEEL KEY.
 3. 3" M DIA TO BE MACH CONC. WITH JOURNAL. WITHIN .0005 T.I.R. AFTER ASSY. DO NOT REMOVE MORE THAN .002 ON DIA OF OIL DEFL.
 4. TEST INSTR FOR OVERSPEED GOVERNOR USE 101A643AE.
 5. AFTER ASSY ALL BALANCE PLUGS ON BAL RING & OIL DEFL MUST BE STAKED.
 6. TEST INSTR FOR COUPLING KEY 101A643AR
 7. DYNAMIC BALANCE ROTOR AFTER ASSY

①



REV NO	REV	DATE	BY	CHKD	APP'D
1					
2					
3					
4					
5					
6					
7					

THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
DUY125R6 - 65			1	SWITCH MTG	101C363CFG-	1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
1	X		2	ASSY	101C363CF -	1
2	1		2	SWITCH	134B191AD -	1
3	2		2	SCR MACH	N51P16006 -	
4	3		2	L WASH SPG	N405P11 -	
5	3		2	CAPSCREW	N22P21010 -	
6	1		2	BRACKET	101B240EY -	1

123186 TURBINE SERIAL NO.
01-05-66 DATE PRINTED

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F.C.F. ON 77DRY125R283

UNLESS OTHERWISE SPECIFIED USE THE FOLLOWING—
 APPLIED PRACTICES SURFACES FINISHES
 ✓ + - ✓ + - ✓ + - ✓ + -
 1/16 RA066017-13 C.F.F.D.Y.

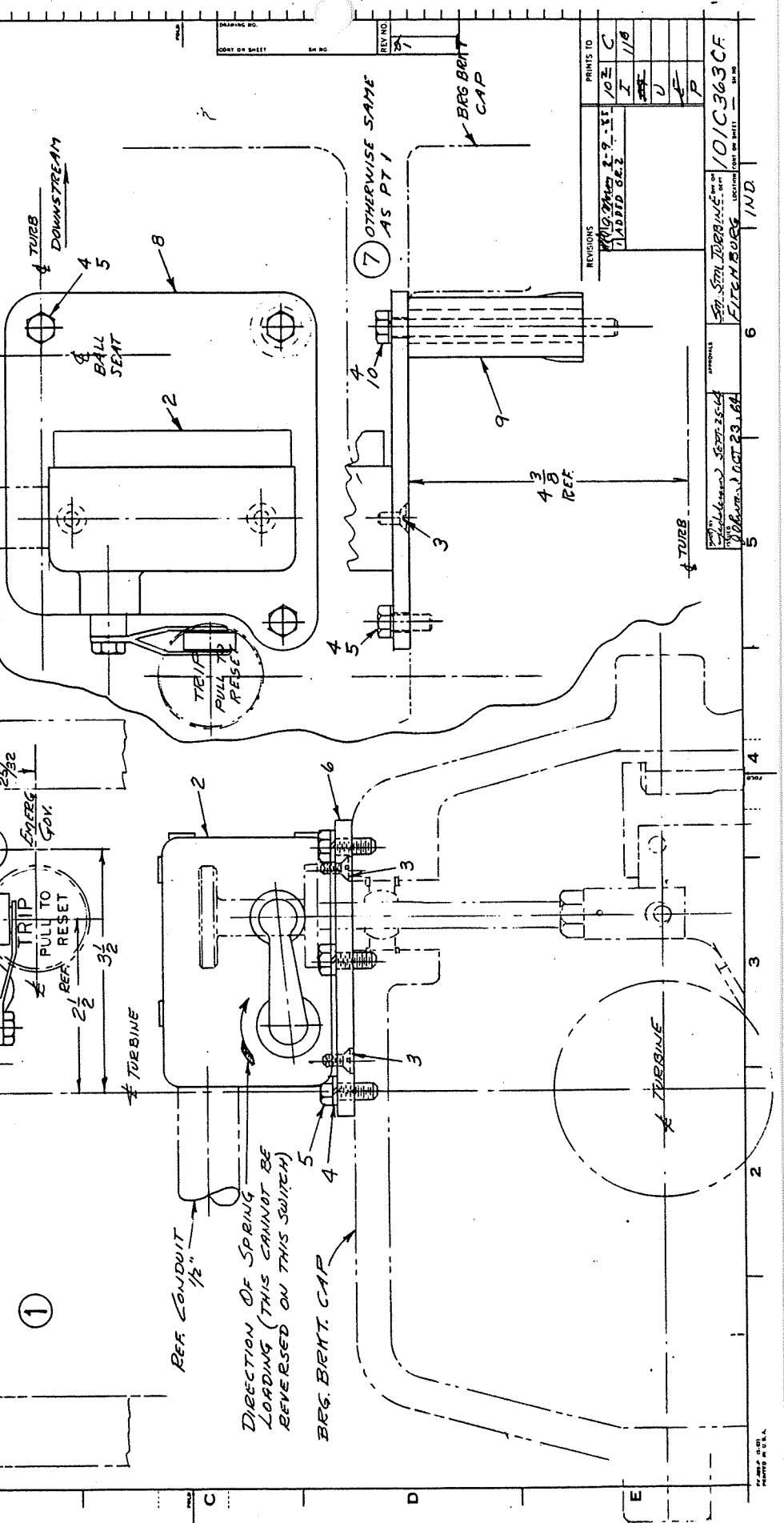
GENERAL ELECTRIC
 MOUNTING, S.W. (EXPL. PROOF)
 FIRST MADE FOR S.D.-123091
 P.L. ISSUED

101C363CF
 SHEET NO. 1

DESCRIPTION:
 G.1 FOR SPECIAL "D" BEG. FRONT END.
 MICRO. SWITCH.
 G.2 FOR "D" BEG. BRNT.

NOTE
 SET LIMIT SWITCH TO ACTIVATE
 WHEN TURBINE IS TRIPPED BY
 ADJUSTING SWITCH LEVER ARM.

1/4-20 NC 3-3/8 DEEP
 DO NOT DRILL THEM
 3 HOLES IN BEG.
 BRNT. CAP AT ASSY.



REF. CONDUIT 1/2"
 DIRECTION OF SPRING
 LOADING (THIS CANNOT BE
 REVERSED ON THIS SWITCH)

BEG. BRNT. CAP

7 OTHERWISE SAME
 AS PT 1

REV. NO.	DATE	BY	CHKD.	APP'D.	DESCRIPTION
1	1-2-55	J.E.	J.E.	J.E.	ADDED G.E. 2
2					
3					
4					
5					
6					

101C363CF
 SHEET NO. 1
 GENERAL ELECTRIC
 MADE IN U.S.A.

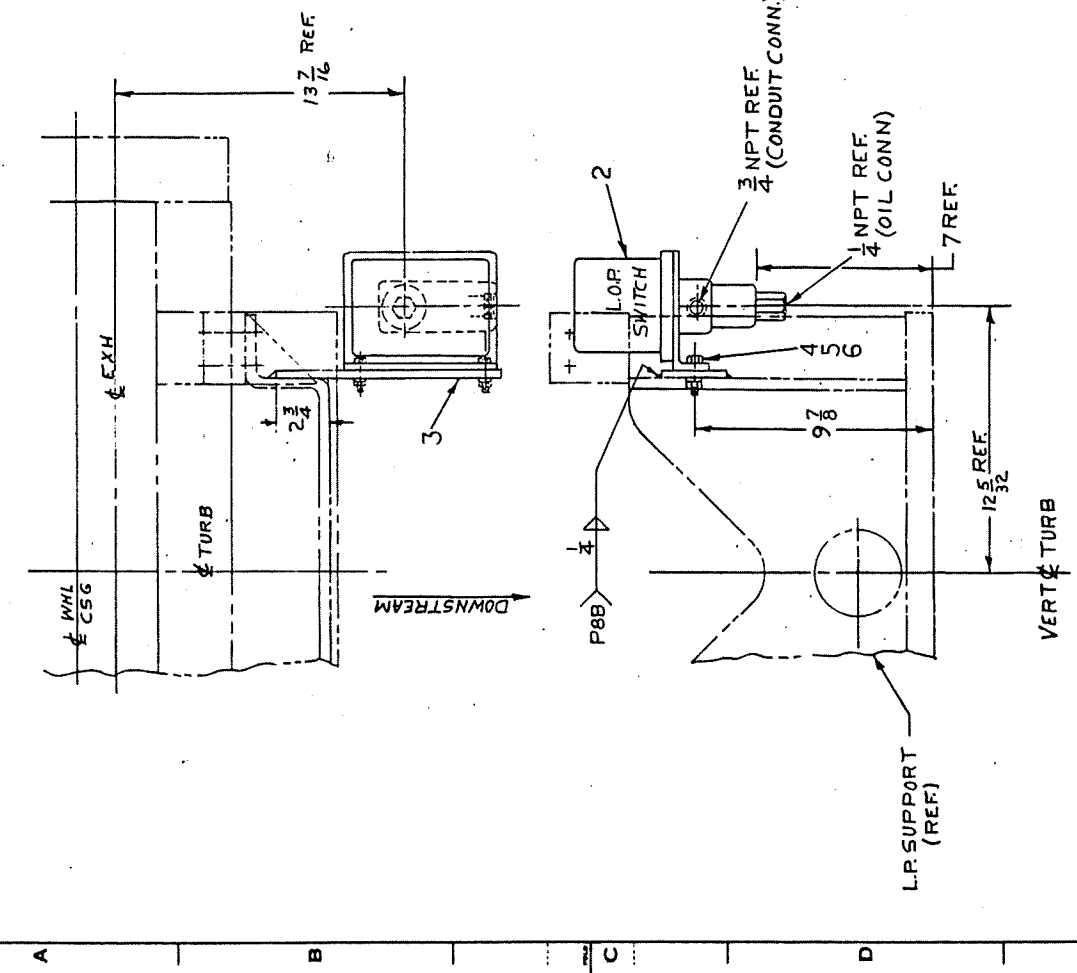
THIS ASSEMBLY IS LOCATED ON				LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
DUY125R6 - 64				1	MOUNTING	101C363DAG-	1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER		
1	X		2	ASSY	101C363DA -	1	
2	1		2	SWITCH	165A312AC -	4	
3	1		2	BRACKET	101A373CD -	1	
4	2		2	CAPSCREW	N22P25020 -		
5	2		2	WASHER LOCK	N405P13 -		
6	2		2	NUT HEX	8954958AA -	3	

123186
TURBINE SERIAL NO.

01-05-66
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(1)

NOTES.
1. PRESS SWITCH TO BE SET IN ACCORDANCE WITH ENGR'S INSTR. SHEET.

GROUP DESCRIPTION
1. LOW OIL PRESS. SWITCH MOUNTED ON LOW PRESS. SUPPORT, L.O.P. SWITCH EQUIPPED WITH SPDT SWITCH.

REV. NO.	REV. TO
0	1/1-9
	C
	I
	U
	1/0 E

REV. NO. 0
DRAWING NO. 101C363DA
SM. ST. TURBINE
FITZBURG
6 IND
APPROVALS
DATE 11/14/65
BY [Signature]

THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
101D112ARG - 12			2	CONTROL TTV	101D112AR - 35	1
ITEM NO.	QUANTITY	MAINT PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
4	1		2	HANDLE	101B127AY - 1	
5	1	X	2	SPINDLE	101A137AF - 1	
6	1		2	SCR SET	N70P2106 -	
7	1		2	SPACER	9443155AA - 276	
8	1	X	2	RET RNG	N901P112 -	
9	1	X	2	BRG BALL	101A777AB - 9	
10	1	X	2	BLOCK LATCH	101B126AE - 1	
11	1		2	BONNET	101D111AA - 1	
12	1	X	2	TRP LTCH PI	101A143AA - 1	
14	1		2	L NUT	101A138AA - 1	
15	1	X	2	SPRING	101A141EB - 1	
16	1		1	SPRG PL	101A139AH - 10	
17	1		2	PIN GRV	N510P1324B-	
20	3		2	SCREW	N170P29020-	
22	AR		2	LUB	101A892AA - 1	
23	1	X	2	BUSHING	101B124CA - 1	
25	1		2	PIN	N522P3820 -	
27	1		2	PIN GRV	N514P2516B-	
28	2		2	PIN DOWEL	9443141AA - 83	
29	1		2	SPACER	101A135AD - 2	
30	1		2	SPACER	101A135AE - 2	
31	1		2	PIN	N504P1724 -	
32	1		2	HND TRP LVR	101B130AB - 1	
35	1		2	CONTROL AG1	101D112AR - 35	
37	1	X	2	STEM	101A153AR - 3	
38	1		2	V CHEST COV	101C191AB - 1	
61	1		2	KEY WODRF	N3400P404 -	
62	1		2	NUT	9443522AD - 5	

123186
TURBINE SERIAL NO.

01-05-66
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THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
DUY125R6 - 2			1	CONTROL TTV	101D112ARG-	12 1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
19	2		2	PIN DWL	9443141AA - 205	
35	1		1	CONTROL TTV	101D112AR - 35	
39	12	X	2	CAPSCREW	8954954AA - 101	

TURBINE SERIAL NO. 123186 DATE PRINTED 01-05-66

↑ ↑ ↑ ↓

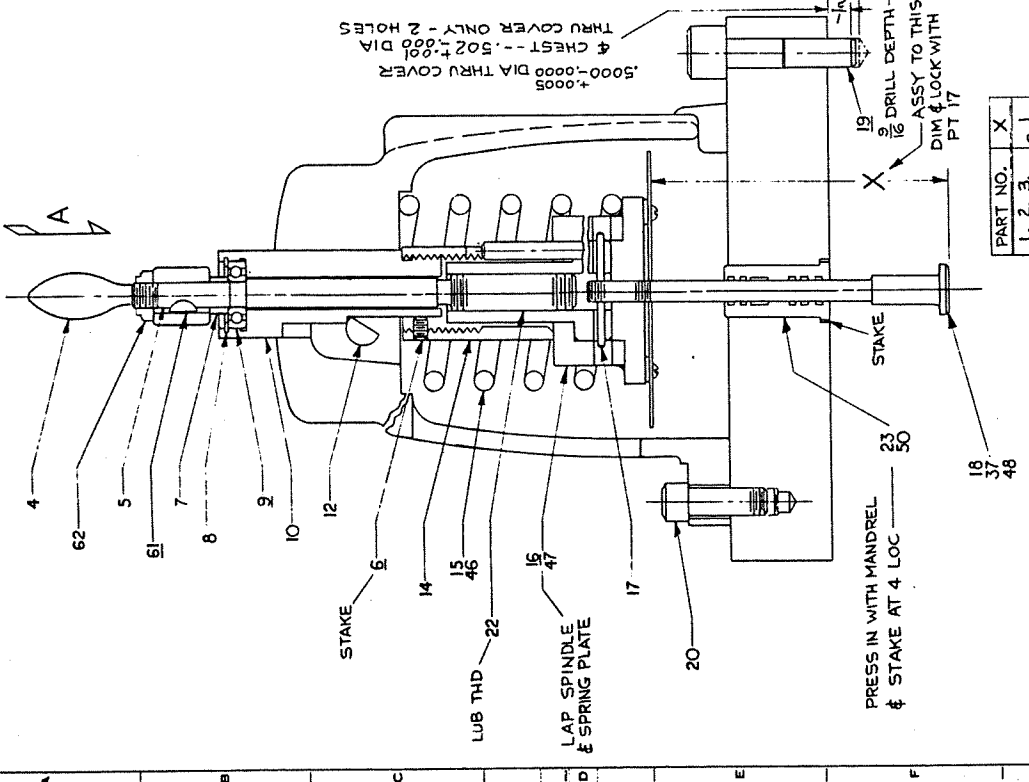
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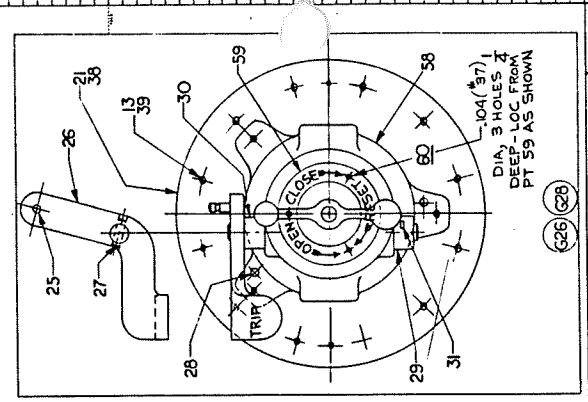
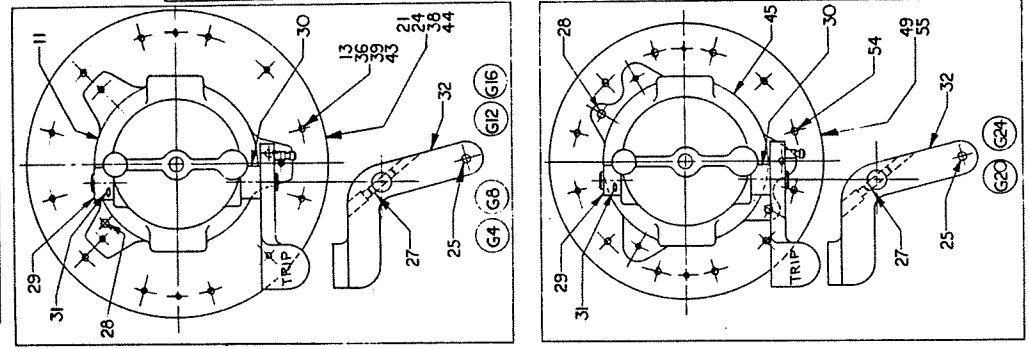
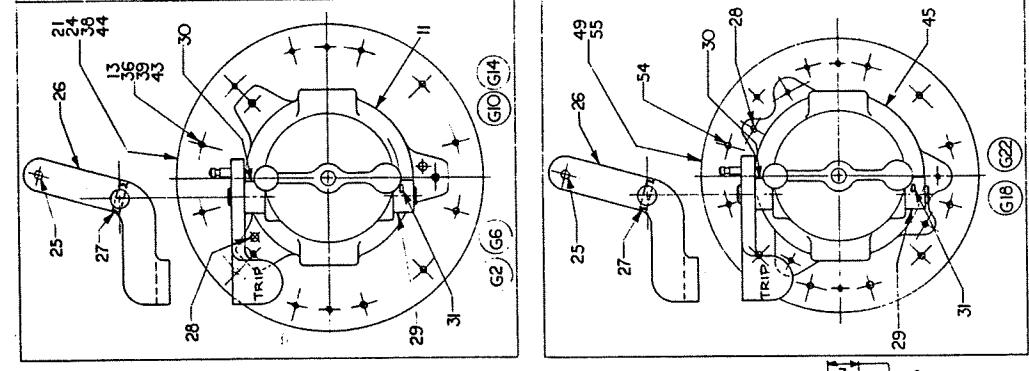
X INDICATES RECOMMENDED MAINTENANCE PARTS

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CONTROL TRIP THROTTLE VALVE



PART NO.	X
1, 2, 3	3 1/2
33, 4, 56	3
34, 35, 40, 51, 6	5 1/6
41, 4, 57	5 1/6
42, 51, 52, 4, 53	5 3/8



GROUP DESCRIPTION

PL 155

GROUP NUMBER	DP-DR20	DP-DR25	DP-DR20Z15
CL I, II & III	CL I, II & III	CL I, II & III	CL I, II & III
UP TO 151 TO 151 TO 151 TO 151 TO	UP TO 151 TO 151 TO 151 TO 151 TO	UP TO 151 TO 151 TO 151 TO 151 TO	UP TO 151 TO 151 TO 151 TO 151 TO
BRG 1750°F B25°F	BRG 1750°F B25°F	BRG 1750°F B25°F	BRG 1750°F B25°F
STD A 2 6 10 14 18 22	STD A 2 6 10 14 18 22	STD A 2 6 10 14 18 22	STD A 2 6 10 14 18 22
HBP B 4 8 12 16 20 24	HBP B 4 8 12 16 20 24	HBP B 4 8 12 16 20 24	HBP B 4 8 12 16 20 24
ALL A 2 6 10 14 18 22	ALL A 2 6 10 14 18 22	ALL A 2 6 10 14 18 22	ALL A 2 6 10 14 18 22
DRSHELL 12 16 20 24	DRSHELL 12 16 20 24	DRSHELL 12 16 20 24	DRSHELL 12 16 20 24

APPLICATION: CARBON STEEL OR STAINLESS STEEL (ALL GROUPS)

VIEWS IN DIRECTION OF ARROW A (A-4)

APPROVED	DATE
DESIGNED BY	
CHECKED BY	
DRAWN BY	
MATERIAL	
FINISH	
QUANTITY	
REVISIONS	

REVISED BY: [Signature]

DATE: 2/19/60

PL 155

101D112AR

THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
101D113BCG -			2	BRKT BRG LP	101D113BC -	1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
1	1		2	BRKT AG1	101D113BC -	1
2	1		2	BRKT BRG	101D113BC -	2
3	1		2	CAP BRG	101D113BC -	3
4	2		2	PIN DWL	9443141AA -	127
5	4	X	2	CAPSCREW	8954954AA -	71
6	1		2	PIPE PLG ST	9443133AA -	6

123186
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THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
DUY125R6 - 24			1	BRKT BRG LP	101D113BCG-	2
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
1	1		1	BRKT BRG LP	101D113BC -	1
7	4	X	2	SCR SOC HD	N170P33032-	
8	2		2	PIN DWL THD	9443142AA -	6

123186 TURBINE SERIAL NO.	01-05-66 DATE PRINTED
------------------------------	--------------------------

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THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
DUY125R6 - 44			1	VALVE O+TT	101D115EFG-	22 1
ITEM NO.	QUANTITY	MAINT PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
1	X		2	ASSY	101D115EF -	1
2	1	X	2	RING RET A	101A134BA -	6
3	1		2	PIN A	101A316AM -	2
4	1		2	PIN B	101A316CA -	3
5	1		2	PLATE	101A252BE -	1
6	1	X	2	RING RET B	101A134BA -	10
7	2		2	PIN DWL C	9443141AA -	205
8	1		2	PLUG PIPE	9443133AA -	2
17	1	X	2	BUSHING	101B124EB -	1
25	1		2	PLATE SPRIN	101A133AY -	1
41	1		1	SEAT VALVE	101C181BE -	7
43	1		2	VALVE B	101B113AC -	3
48	1		1	ST STRAIN	101C193AB -	10
57	1		1	VALVE A	101B119AF -	18
62	1		1	COVER	101B258AR -	18
111	8	X	2	CAPSCREW	8954954AA -	99

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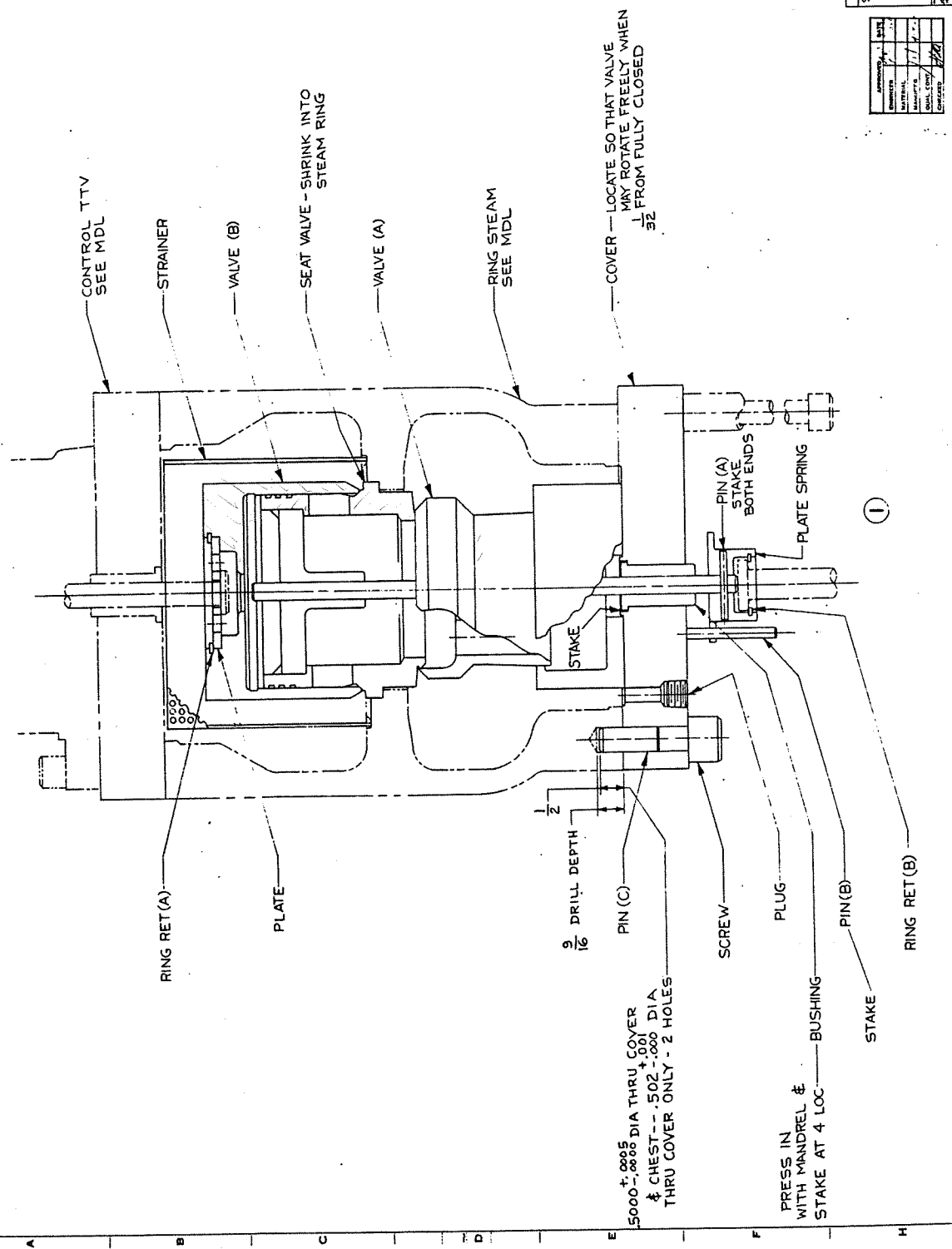
X INDICATES RECOMMENDED MAINTENANCE PARTS

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GROUP DESCRIPTION:

VALVE NO.	GROUP NUMBER
1	25
2	26
3	27
4	28
5	29
6	30
7	31
8	32
9	33
10	34
11	35
12	36
13	37
14	38
15	39
16	40
17	41
18	42
19	43
20	44
21	45
22	46
23	47
24	48



DESCRIPTION OF GROUP	GROUP NUMBER	GROUP NAME
SEE TAB. ABOVE		

GROUP NUMBER	GROUP NAME
25	CL I II III
26	CL I II III
27	CL I II III
28	CL I II III
29	CL I II III
30	CL I II III
31	CL I II III
32	CL I II III
33	CL I II III
34	CL I II III
35	CL I II III
36	CL I II III
37	CL I II III
38	CL I II III
39	CL I II III
40	CL I II III
41	CL I II III
42	CL I II III
43	CL I II III
44	CL I II III
45	CL I II III
46	CL I II III
47	CL I II III
48	CL I II III

THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
101D259AEG - 8			2	CYL TRIP 101D259AE - 1		1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
1	1		2	CYL AG1	101D259AE - 1	
3	X		2	WELDING	125D980AA - 1	
4	1		2	COVER	101A422BR - 1	
5	2	X	2	GASKET	101A172CW - 1	
6	1		2	SHAFT	101A209BA - 1	
7	1		2	PISTON	101A409AE - 1	
8	1		1	CYL	101C328AC - 1	
9	1	X	2	SPRING	101A141LC - 1	
10	1		2	NUT HEX	N210P25 -	
11	1		2	PIN GRV	N514P610 -	
12	1		2	COVER	101A422BC - 1	
13	8		2	SCREW SOC H	N29P25016 -	
14	8		2	L WASH SPG	N405P13 -	
15	1		1	FLANGE	101A619AE - 1	
16	1		1	FLANGE	101A619AD - 1	
20	1	X	2	SEAL OIL	101A165AC - 5	

123186
TURBINE SERIAL NO.

01-05-66
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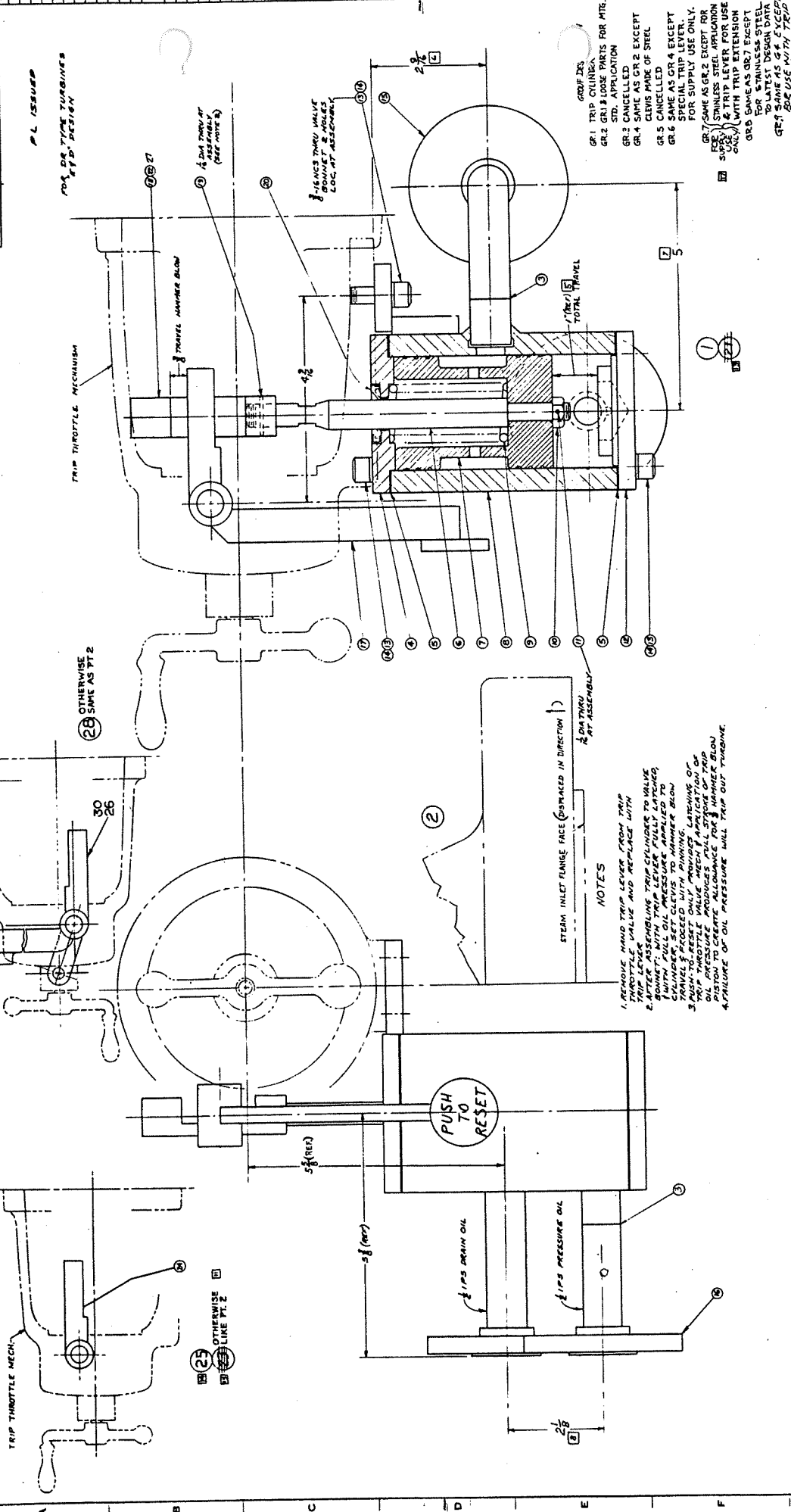
"A/R" MEANS QUANTITY AS REQUIRED - REFER TO GE I-84010 PAGE 5

THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
DUY125R6 - 62			1	CYL TRIP	101D259AEG-	8
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
1	1		1	CYL TRIP	101D259AE -	1
13	2		2	SCREW SOC H	N29P25016 -	
14	2		2	WASHER LOCK	N405P13 -	
19	1		2	PIN GRV	N514P614B -	
27	1		2	CLEVIS	101A195AS -	2
28	X		2	ASSY	101D259AE -	28
30	1		1	LEVER	101C317BD -	6

123186 TURBINE SERIAL NO.
01-05-66 DATE PRINTED

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NOTES

1. REMOVE HAND TRIP LEVER FROM TRIP CYLINDER AND REPLACE WITH TRIP LEVER.
2. AFTER ASSEMBLING LEVER FULLY LATCHED WITH FULL OIL PRESSURE APPLIED TO CHAMBER SET OLDS TO ZERO.
3. PUSH TO RESET ONLY PROVIDES LATCHING OF TRIP THROTTLE MECHANISM.
4. FAILURE OF OIL PRESSURE WILL TRIP OUT TURBINE.

STEAM INLET FLANGE FACE (COMPARED IN DIRECTION OF ARROW) AT ASSEMBLY

GR1 TRIP COILINGS
 GR2 TRIP COILINGS
 GR3 CANCELLED
 GR4 SAME AS GR2 EXCEPT OLDS CANCELLED
 GR5 CANCELLED
 GR6 SPECIAL TRIP LEVER FOR SUPPLY USE ONLY
 GR7 SAME AS GR2 EXCEPT FOR STAINLESS STEEL APPLICATION
 GR8 TRIP LEVER FOR USE ONLY WITH TRIP EXTENSION
 GR9 SAME AS GR2 EXCEPT FOR STAINLESS STEEL TO LATEST DESIGN DATA
 GR10 SAME AS GR2 EXCEPT FOR STAINLESS STEEL TO LATEST DESIGN DATA

REV.	DATE	DESCRIPTION	BY	CHKD.
1	11/13/58	ISSUED FOR PRODUCTION	J. J. ...	J. J. ...
2	11/13/58
3	11/13/58
4	11/13/58
5	11/13/58
6	11/13/58
7	11/13/58
8	11/13/58
9	11/13/58
10	11/13/58

THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
DUY125R6 - 63			1	MECH TRIP 101D294ACG-		7 1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
2	1		1	TRP BDY	101C314AA -	1
3	1		2	PLUNGER	101A323AB -	1
4	1		1	TRP FNCR AS	101A430AA -	1
5	1	X	2	TRIC BRG	101A403AA -	1
6	2		2	LINK	9443150AA -	23
10	1		2	PIN	9443112AA -	88
12	2		2	PIN	9443106AA -	229
13	1	X	2	SPRING	101A141BR -	1
14	1		2	SCR SET	N70P2520 -	
15	2		2	SCR MACH	N30P16012 -	
16	12		2	SHIM	101A144AJ -	1
18	1		2	NUT HEX	N203P25 -	
19	2		2	WASH	9475242AA -	10
20	6		2	PIN COT	N503P908 -	
24	1	X	2	GSKT	101A172AT -	1
25	6		2	CAPSCREW	N29P25020 -	
26	1		2	WASHER LOCK	N405P13 -	
36	1		2	HANDLE	101A407AR -	1
37	1		2	PIN GRV	N517P608 -	
38	1		2	SPACER	9443155AB -	64
39	2	X	2	RET RNG	N901P100 -	
40	1	X	2	UNIRAL BRG	9443134AA -	6
41	1		2	ROD THR	101A404BF -	1
42	1		2	NUT HEX	8954958AA -	3
43	1		2	PIN GRV	N510P612B -	
44	1		2	CLEVIS	9475217AA -	90
45	X		2	ASSY	101D294AC -	45
46	1		2	PIN	9443106AA -	232

123186
TURBINE SERIAL NO.

01-05-66
DATE PRINTED

"SEE M/L" MEANS TO
SEE MODEL LIST FOR
ORDERING NUMBER

CODE NO. "1" INDICATES THE ITEM IS AN ASSEMBLY OF PARTS
CODE NO. "2" INDICATES THE ITEM IS A SINGLE PART

X INDICATES RECOMMENDED MAINTENANCE PARTS

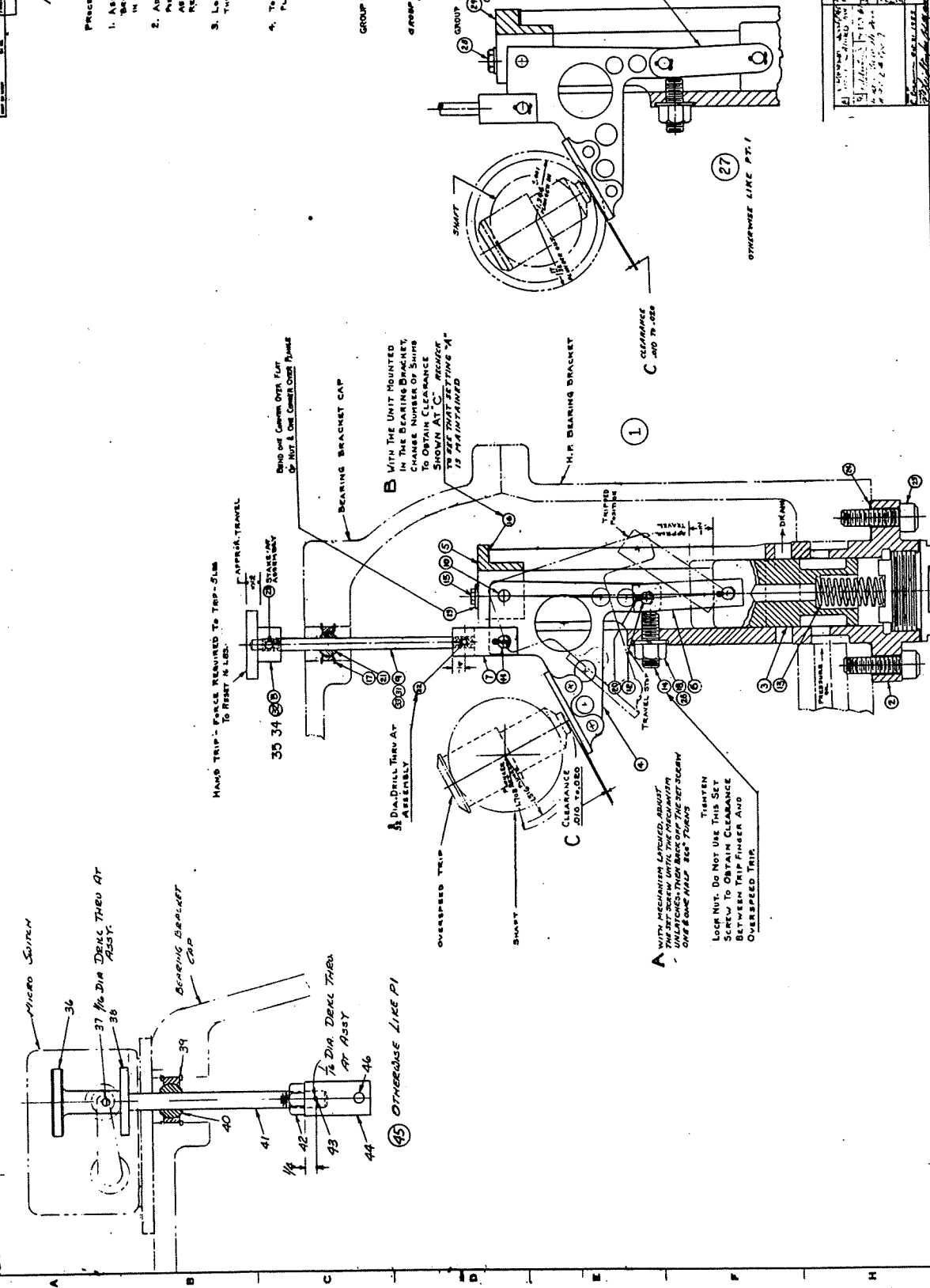
"X" MEANS FOR INFORMATION ONLY

"A/R" MEANS QUANTITY AS REQUIRED - REFER TO GE I-84010 PAGE 5

FOR OUTDOOR USE

- PROCEDURE FOR ASSEMBLY AND ADJUSTMENT:
1. ASSEMBLE THE PARTS IN PLACE AS SHOWN WITH WAS. BRKT. CAP REMOVED AND WIPPER HANDLE IN PLACE.
 2. ADJUST SET SCREW TO EXTENSIBLE LOCKED POSITION AND LOCK WITH WAS. BRKT. CAP. WIPPER HANDLE REMOVED AT "B" TO PROVIDE CLEARANCE REQUIRED AT "C".
 3. LOWER WAS. BRKT. CAP IN PLACE INSERTING TURNSIDE SEE THIRD VILL.
 4. TO REPLACE DEFECTIVE SPRING REMOVE PIPE PLUG AT BOTTOM.

- GROUP DESCRIPTION
- GROUP 1-DRY TURBINE-HEAVY DUTY I.E. 1000 RPM (70 BRACKET)
 - GROUP 2-DRY TURBINE-MEDIUM DUTY I.E. 1500 RPM (70 BRACKET)
 - GROUP 3-DRY TURBINE-LIGHT DUTY I.E. 1500 RPM (70 BRACKET)
 - GROUP 4-SAME AS GR. 3 EXCEPT NOT "S" SET ROD FOR TRIP HANDLE
 - GROUP 5-SAME AS GR. 2 EXCEPT STAINLESS STEEL TRIP HANDLE & ROD
 - GROUP 6-SAME AS G3 EXCEPT FOR SST HANDLE.
 - GROUP 7-SAME AS GR. 4 EXCEPT USE WITH MICRO S.



NO.	DESCRIPTION	QTY.	UNIT	REVISION
1	GROUP 1-DRY TURBINE-HEAVY DUTY I.E. 1000 RPM (70 BRACKET)	1	ASSEMBLY	
2	GROUP 2-DRY TURBINE-MEDIUM DUTY I.E. 1500 RPM (70 BRACKET)	1	ASSEMBLY	
3	GROUP 3-DRY TURBINE-LIGHT DUTY I.E. 1500 RPM (70 BRACKET)	1	ASSEMBLY	
4	GROUP 4-SAME AS GR. 3 EXCEPT NOT "S" SET ROD FOR TRIP HANDLE	1	ASSEMBLY	
5	GROUP 5-SAME AS GR. 2 EXCEPT STAINLESS STEEL TRIP HANDLE & ROD	1	ASSEMBLY	
6	GROUP 6-SAME AS G3 EXCEPT FOR SST HANDLE.	1	ASSEMBLY	
7	GROUP 7-SAME AS GR. 4 EXCEPT USE WITH MICRO S.	1	ASSEMBLY	

THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
101B149AE - 17			2	CASING WHL	101F108AF - 1	1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
1	1		2	CSG WHL AG1	101F108AF - 1	
2	1		1	CAS WHL LH	101F108AA - 1	
3	1		1	WHEEL CAS+N	101F108AA - 11	
4	28	X	2	CAPSCREW	8954954AA - 98	
5	4	X	2	PIN TPR STD	9443140AA - 41	
6	1		2	PIPE PLUG	9443133AA - 4	

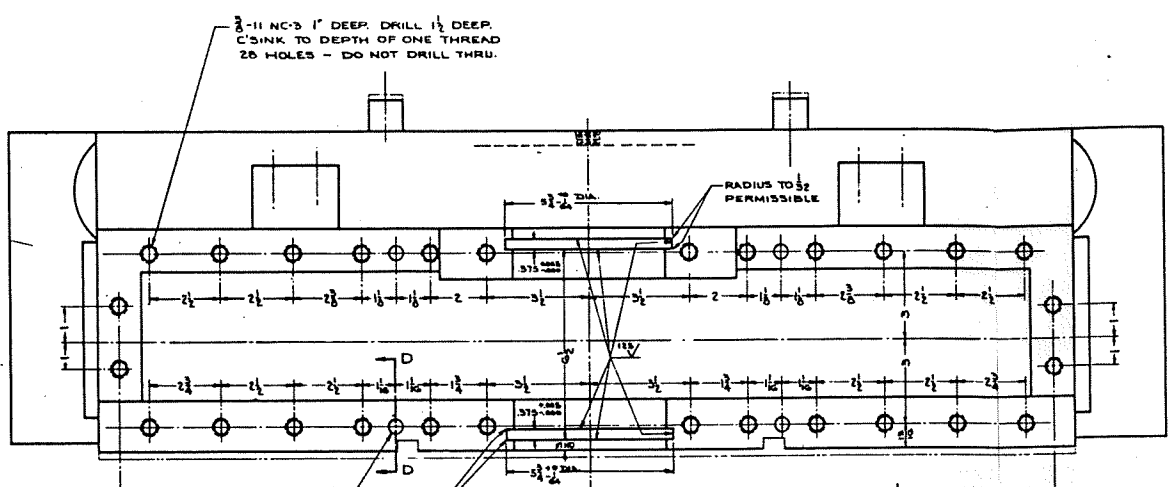
123186
TURBINE SERIAL NO.

01-05-66
DATE PRINTED

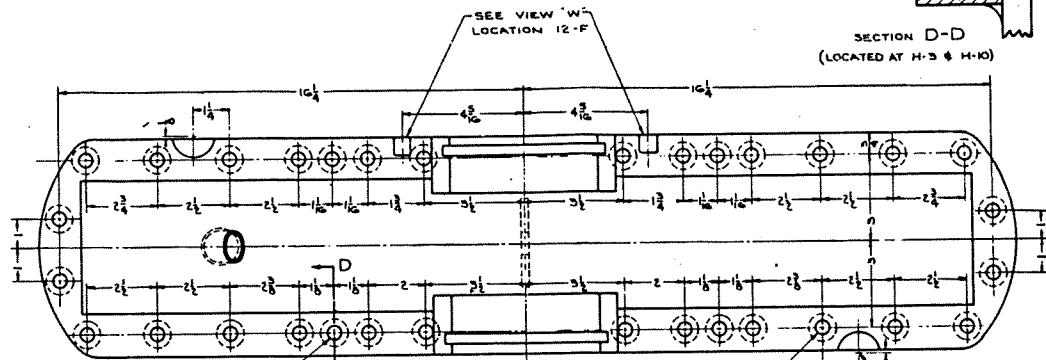
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F.C.F. ON 101B149 AD

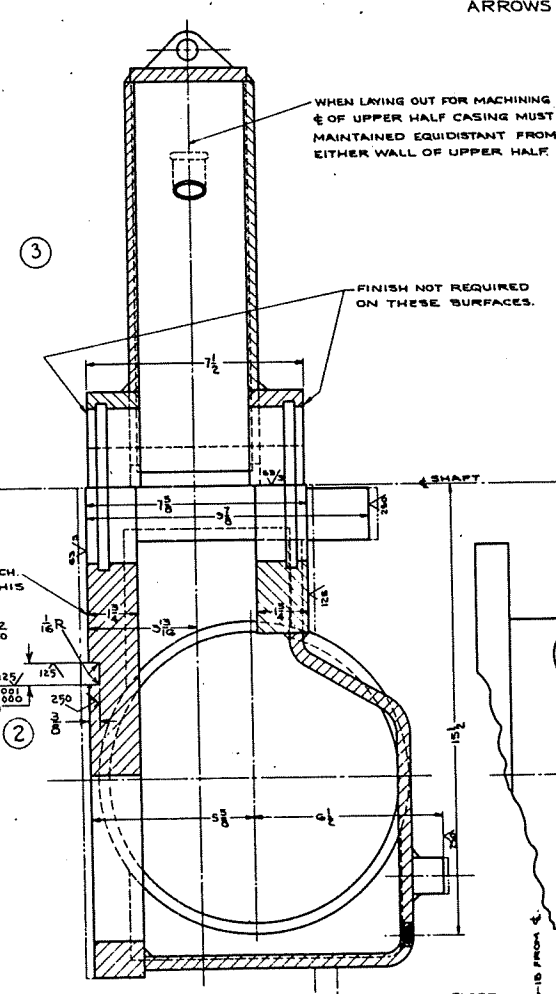
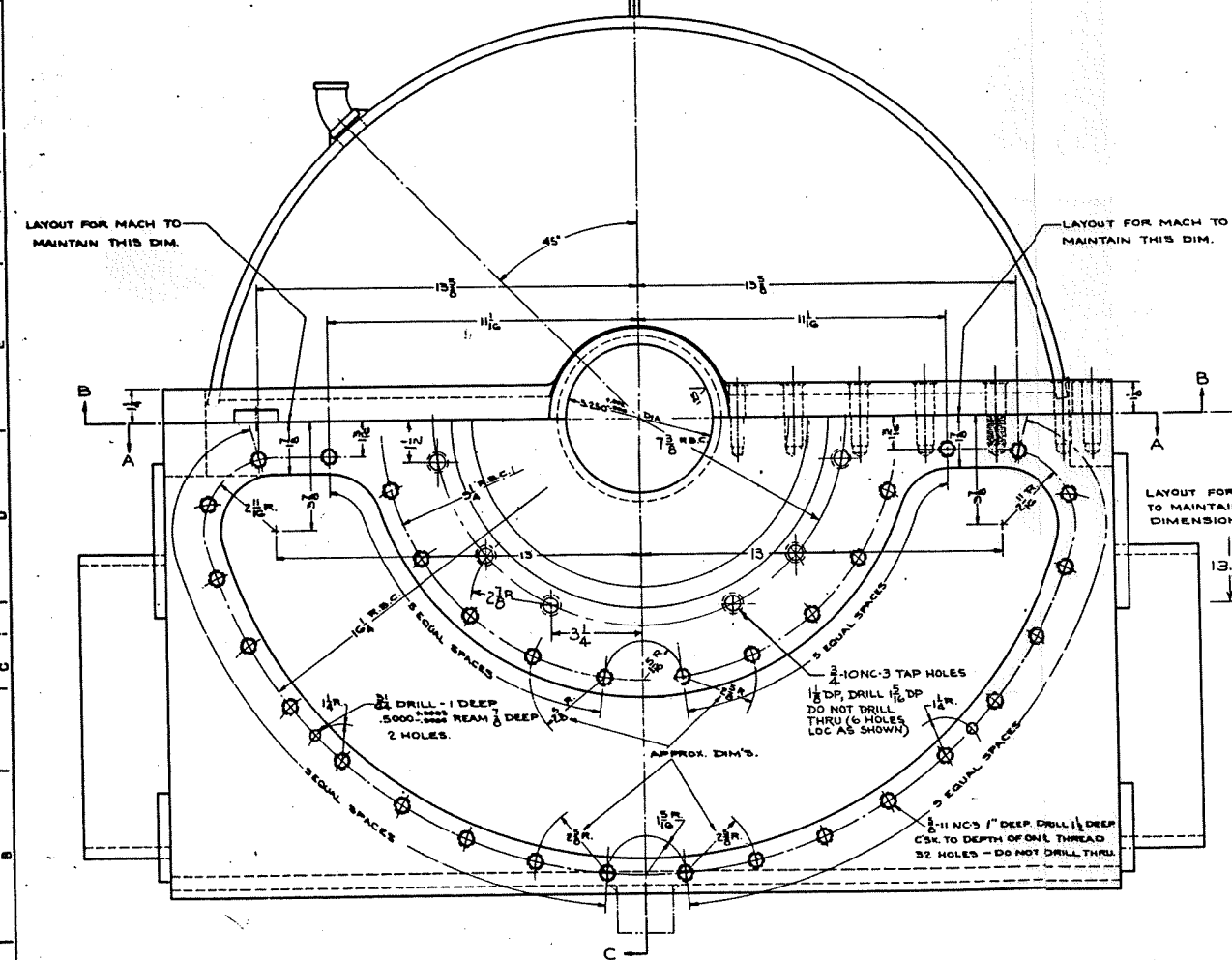


LOWER HALF
VIEW IN DIRECTION OF
ARROWS 'A-A'

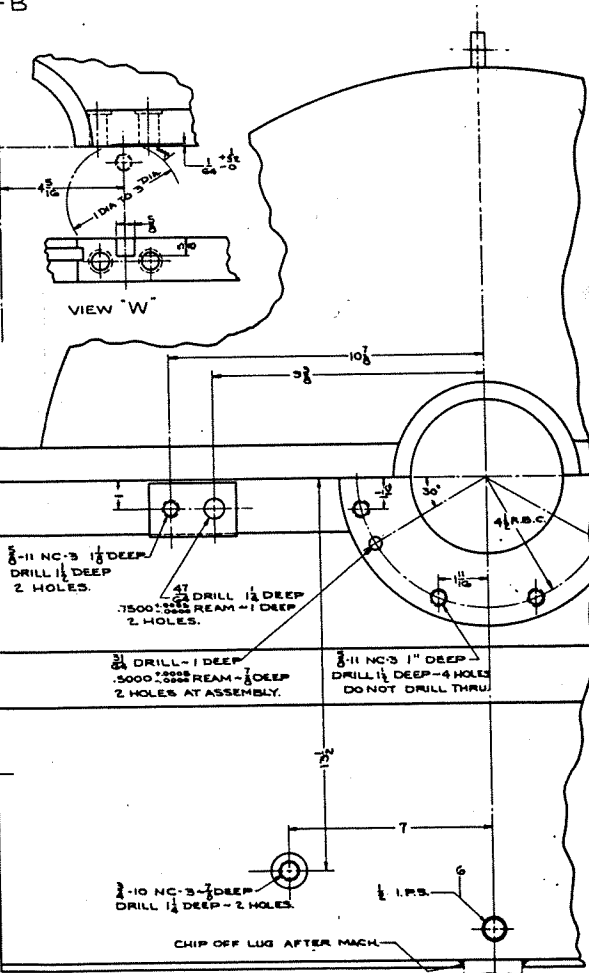


UPPER HALF
VIEW IN DIRECTION OF
ARROWS 'B-B'

SECTION D-D
(LOCATED AT H-3 & H-10)



SECTION C-C'



NOTE #2: AFTER FINISH MACHINING HYDROSTATIC TEST 15 MINUTES AT 150 P.S.I.G.

P.L. ISSUED

X	P-11	101F108AF	3 WHEEL CASING U.H.
X	P-11	101F108AF	2 WHEEL CASING L.H.
X			1 ASSEMBLY

CASING WHEEL (FABRICATED)
(MACH. DRWG.)

FIRST MADE FOR S.O. 123150 (DU-85 1/2 THRU)

DESIGNED BY S.O. 123150 (DU-85 1/2 THRU)

TRACED BY S.O. 123150 (DU-85 1/2 THRU)

INSPECTED BY S.O. 123150 (DU-85 1/2 THRU)

GENERAL ELECTRIC WORKS 101F108AF

GENERAL ELECTRIC

PARTS LIST FOR
101L441AB

CONT ON SHEET — SH NO. 1

REV NO. 012		SH NO.		TITLE		
PARTS LIST FOR				PARTS, MISC		
CONT ON SHEET		SH NO.		FIRST MADE FOR S.O. 123165 (DU-25 CL 3 HI-THR)		
GROUP NO. AND QUANTITY				PART NO.	NAME	DRAWING NO., DESCRIPTION, MATERIAL, WEIGHT
S		32	32	1	SCREW	(ST RING TO CSG) K-8954954 P.98
		2	2	2	PIN	(ST RING TO CSG) K-9443141 P.205
S		8	8	3	SCREW	(H.V OR PLATES) K-8954954 P.98
		-	-	4	SCREW	(H.P. BRKT TO CSG) 101A634BBP.64
		-	-	5	SHIM	(H.P. BRKT TO CSG) PL-101A185AC G1
S		1	1	6	'O' RING	(HP BRKT) K-9443135 P.10
		-	-	7	SCREW	(L.P. BRKT TO CSG) N170 P.33032
		-	-	8	PIN	(L.P. BRKT TO CSG) M-9443142 P.6
S		2	2	9	SCREW	(H.P. SUPP TO BRKT) K-8954954 P.94
S		2	2	10	SCREW	(L.P. SUPP TO CSG) K-8954954 P.98
		2	2	11	PIN	(L.P. SUPP TO CSG) M-9443141 P.245
		2	2	12	STUD	(L.P. SUPP TO CSG) K-8954942 P.1127
		6	6	13	NUT	(L.P. SUPP. TO CSG) K-8954958 P.8
		4	4	14	PACKING	(PKG BOX TO CSG) 101A247AA P1
		2	2	15	PIN	(PKG STOP PIN) M-9443141 P.107
S		16	16	16	SCREW	(NP. SP. TO ST. RING) K-8954954 P.100
S		15	15	17	SCREW	(NP. SP. TO ST. RING) K-8954954 P.104
		2	2	18	PIN	(NOZ SP TO ST RING) M-9443141 P.210
		15	15	19	WASHER	(NP. SP TO ST RING) N404 P.62
		3	3	20	WASHER	(INTER TO NOZ PL) N404 P.50
S		3	3	21	SCREW	(ORDER QTY PER } K-8954954 P.77
EE		3	3	22	SPACER	(INTER-MDL IT. 48) 101A135AC P1
		1		23	FLANGE (BLANK)	(EXH FLG) K-9443577AAP.16
		12		24	BOLT	(EXH FLG) K-8954948 P.263
		12		25	NUT	(EXH FLG) K-8954958 P.9
EE S		1		26	GASKET	(EXH FLG) K-9475136AAP.34

TO ORDER PARTS FROM THIS LIST, REFER FIRST TO THE MODEL LIST FOR THE CORRECT GROUP NUMBER AND ORDER ONLY FROM THAT GROUP.

THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
DUY125R6 - 66			1	EXTENSION	125D160AFG-	2
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
1	X		2	ASSY	125D160AF -	1
4	1	X	2	SPRING	165A324AD -	1
5	1		2	PLATE TRIP	101A147AC -	1
8	1		2	ROD	165A228BF -	3
10	1		2	SCRFW	N70P2104C -	
13	1		2	CLEVIS	101A195DX -	2
15	1		2	PIN	101A493AA -	5
16	1		2	BUTTON	101A794AE -	3
17	2		2	WASH	N400P43 -	
18	1		2	COLI AR	101A424AF -	2
19	3		2	PIN GRV	N517P1314 -	
20	1		2	NUT	N229P29 -	
21	2	X	2	RING RET	101A134AM -	4
22	4		2	NUT	N226P16 -	
23	4		2	SCREW	N54P16010 -	

123186
TURBINE SERIAL NO.

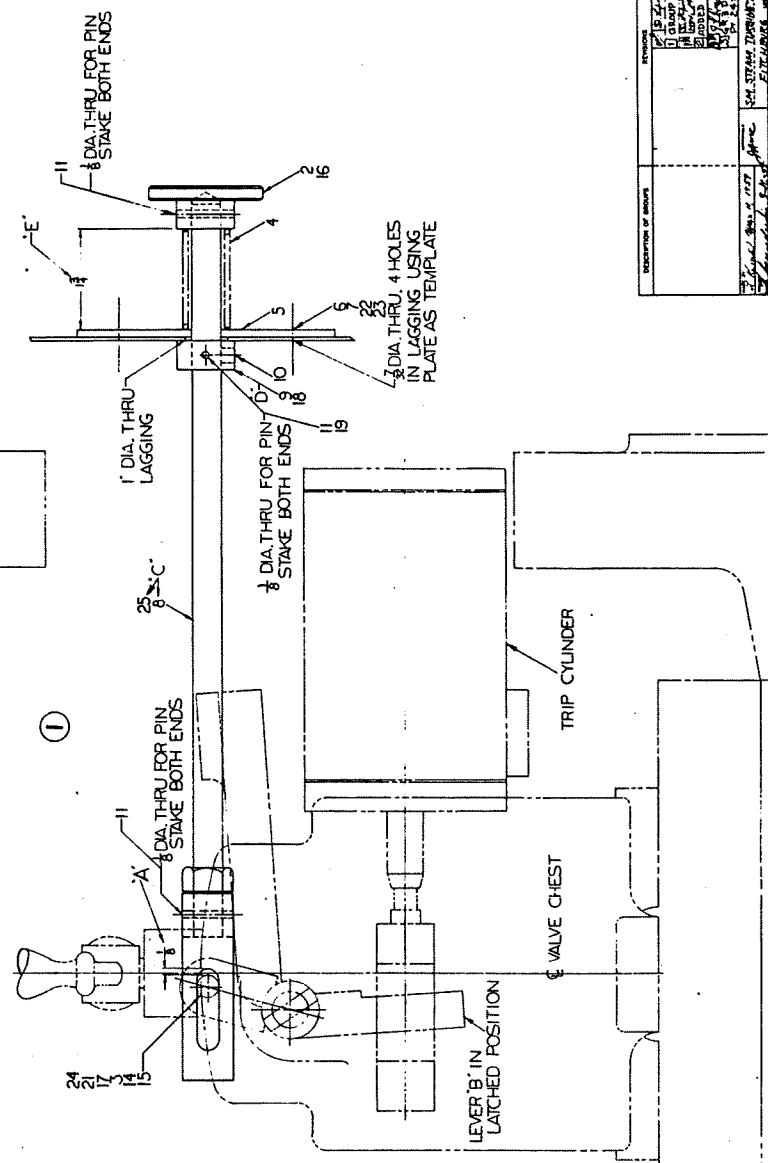
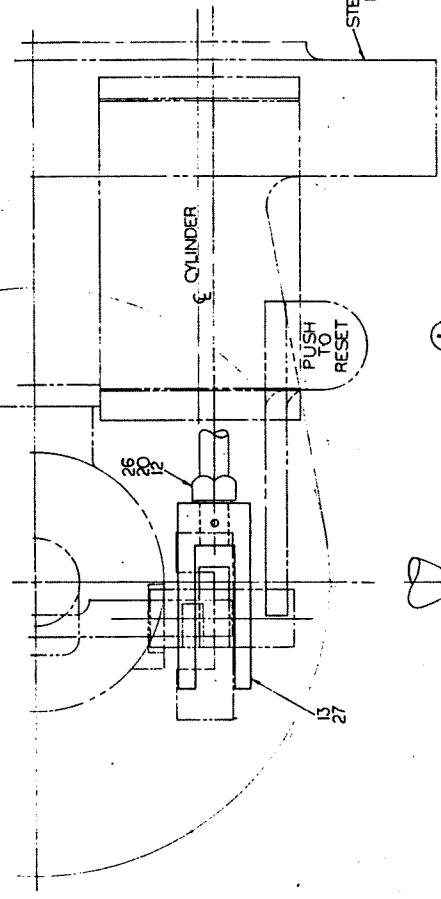
01-05-66
DATE PRINTED

"SEE M/L" MEANS TO SEE MODEL LIST FOR ORDERING NUMBER

- CODE NO. "1" INDICATES THE ITEM IS AN ASSEMBLY OF PARTS
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NOTES
 1. WITH LEVER 'B' IN LATCHED POSITION AND 'A' SET AS SHOWN, CUT ROPE TO OBTAIN DIM'E. ADJUST COLLAR 'D' TO MAINTAIN 'A' AND 'E'.

GROUP DESCRIPTION
 GR.1: SST APPLICATION FOR USE ON D.H.P.BRG. PRKTS. WITH TRIP CYL. MOUNTED ON T.V.BOX FOR SUPPLY USE ONLY.
 GR.2: SST APPLICATION SAME AS GR.1 EXCEPT TO LATEST DESIGN DATA.
 GR.3: SAME AS GR.1 EXCEPT FOR C'S TL APPLICATION

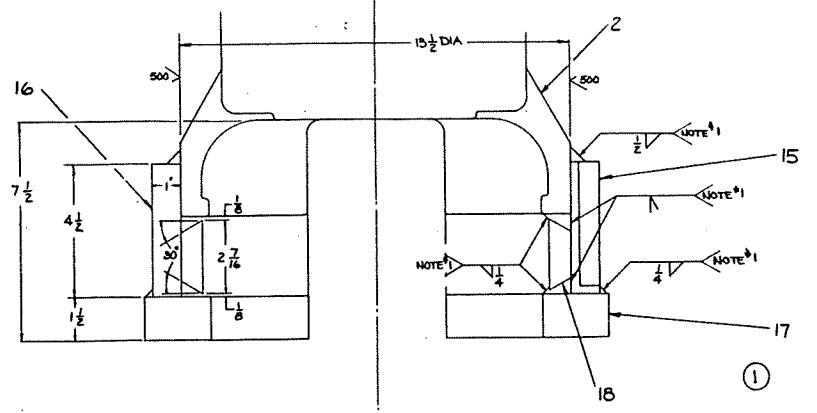


REVISION	DATE	BY	CHKD
1			
2			
3			
4			
5			
6			
7			
8			
9			
10			

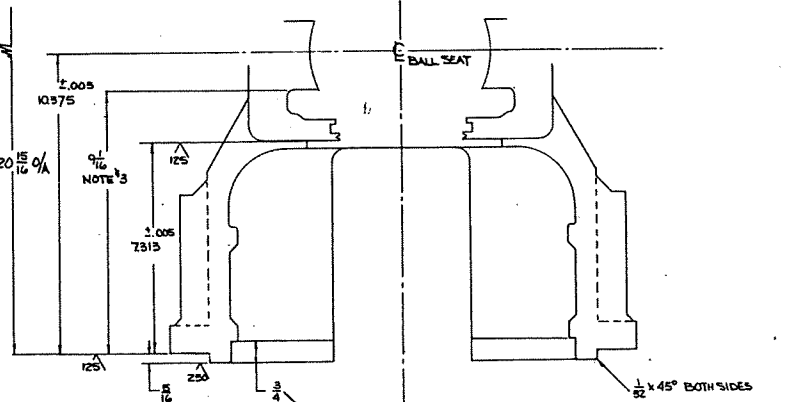
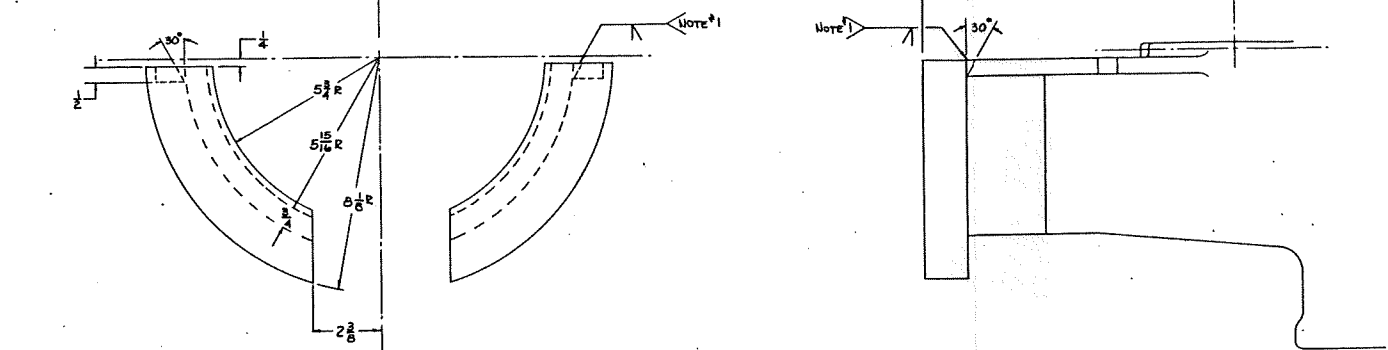
125D160AF
 MICROFILM

PL ISSUED

UNLESS OTHERWISE SPECIFIED USE THE FOLLOWING			
APPROVED PRACTICES	SURFACES	FINISHES	PROPERTIES OF MATERIALS
✓			



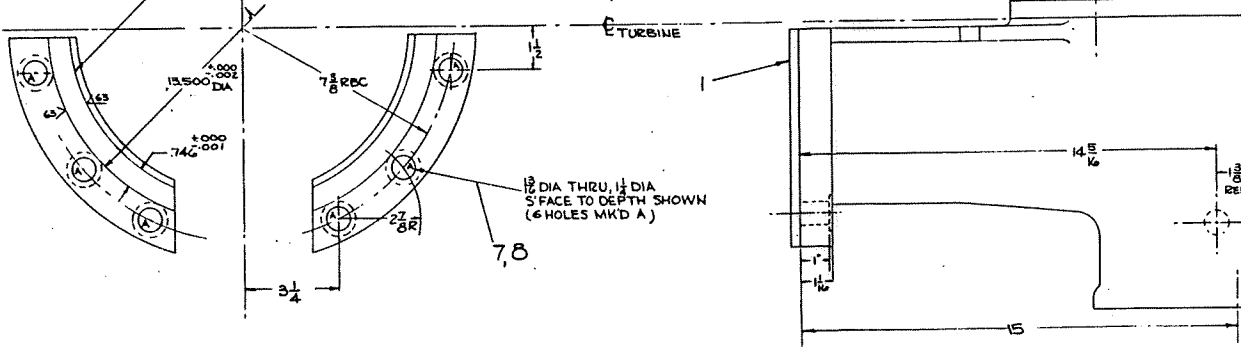
- FABRICATION NOTES**
1. ALL WELDS TO BE IN ACCORD WITH 101A643KW
 2. ALL WELDS UNLESS OTHERWISE SPECIFIED TO BE ANNEALED TO 101A643EC BEFORE MACH



- MACHINING NOTES**
3. LAYOUT BRKT FOR MACH. TO MAINTAIN THIS DIM

- (19) ASSY G2 OTHERWISE SAME AS 501E439 BB G1
- (23) ASSY G4 OTHERWISE SAME AS 501E439 BX G1

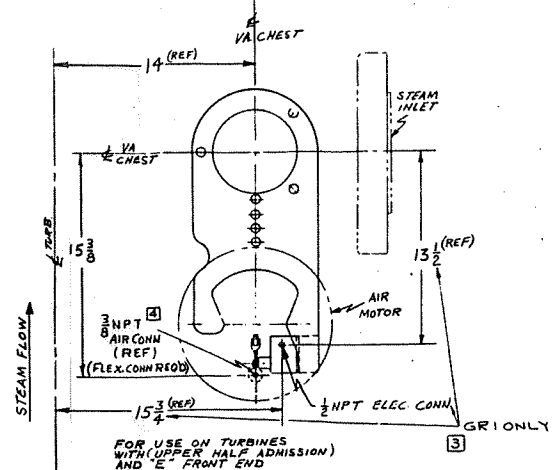
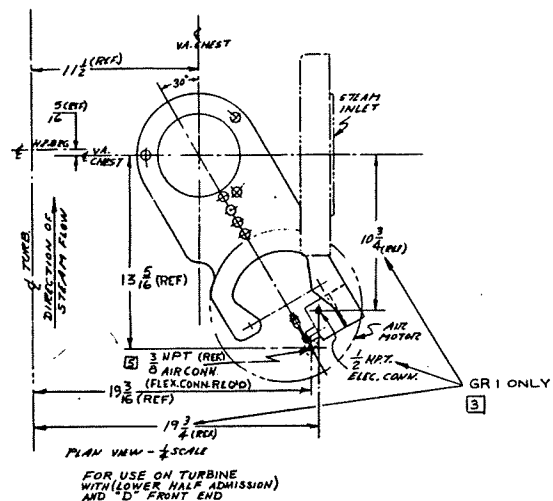
FINISH THIS DIA TO DEPTH SHOWN



REVISED	APPROVED	DATE	BY	CHK'D	DATE

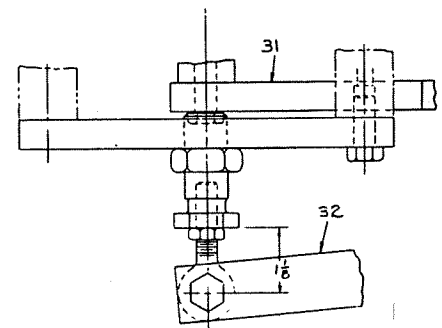
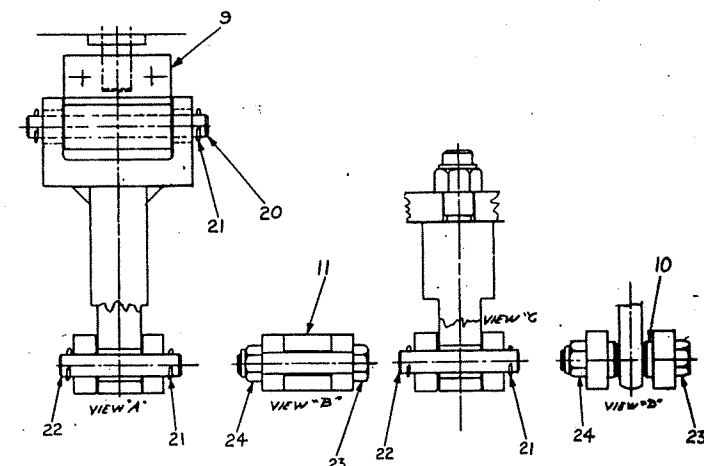
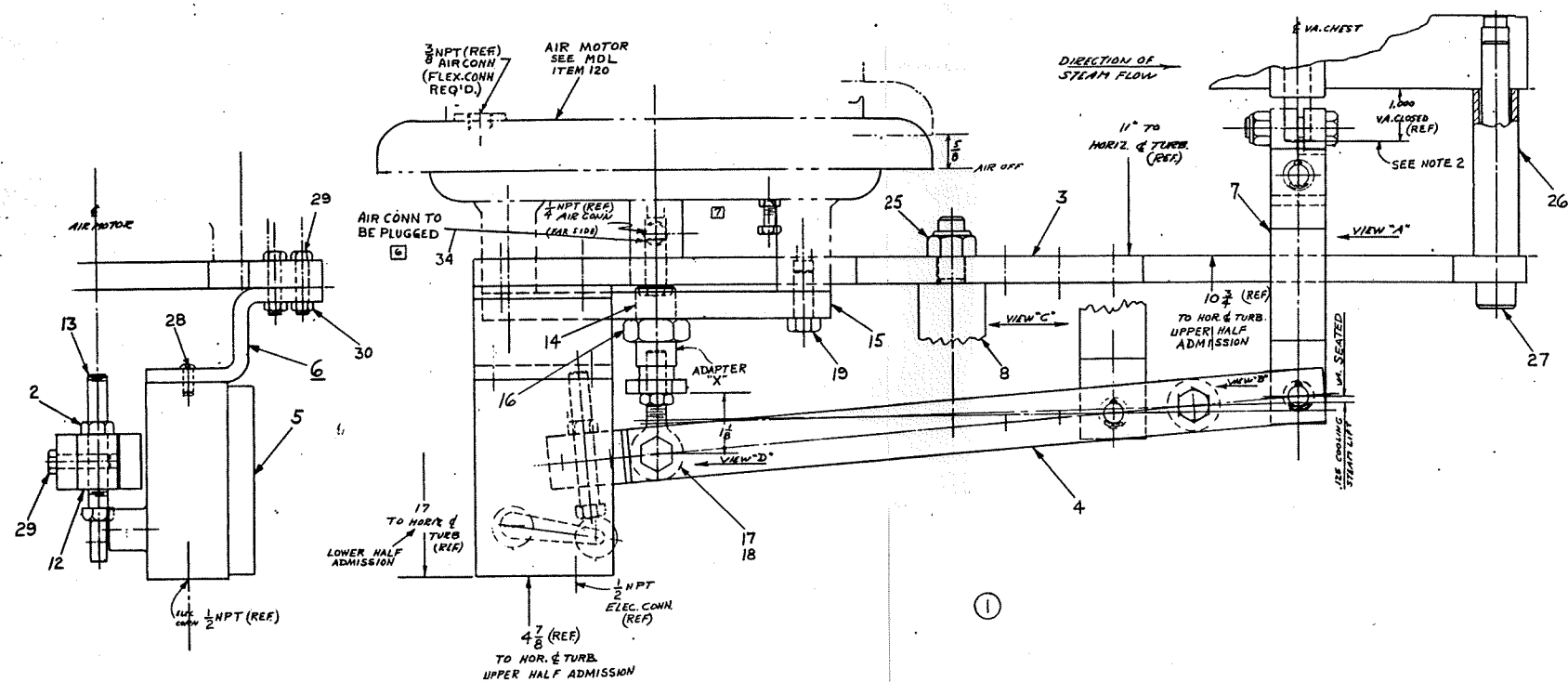
GROUP DESCRIPTION
 GR 1. INCREASE AIR PRESSURE=INCREASE TURBINE SPEED
 STAINLESS STEEL LINKAGE
 "D" AND "E" FRONT END
 LIMIT SWITCH TO INDICATE "VALVE CLOSED"
 GR 2. SAME AS GR1 EXCEPT NO LIMIT SWITCH

FOR FULL LOAD MINUS COOLING STEAM LIFT	RECOMMENDED HOLE NO.
.176 TO .1	1
.151 TO .125	2
.100 TO .125	3
0 TO .107	4



1. SEE ENGR. SPEC. SHEET FOR PROPER HOLE SELECTION.
 ALIGN LEVERS BEFORE TIGHTENING FULCRUM TO PLATE.
 2. VALVE STEM TO BE BOTTOMED IN HOLE IN CLEVIS.
 3. ADJUST ADAPTER "X" SO THAT VALVE IS AT COOLING STEAM LIFT WITH AIR MOTOR IN "AIR-OFF" POSITION.
 4. SET AIR MOTOR STOPS TO LIMIT AIR MOTOR TRAVEL TO 3/8".
 5. SET AIR MOTOR SPRING PRELOAD SO THAT AIR MOTOR BREAKS AWAY AT MIN. AIR PRESSURE CALLED FOR ON ENGR. SPEC. SHEET.
 6. SET LIMIT SWITCH SO THAT IT OPERATES WHEN THE AIR MOTOR IS WITHIN 1/32 OF ITS TRAVEL IN "AIR-OFF" DIRECTION.

* USE "VALVE SEALED" AS POSITIVE STOP WHEN COOLING STEAM LIFT IS NOT SPECIFIED.



33. OTHERWISE SAME AS P (D FRONT END)
 (ENGR REF: NO LIMIT SWITCH)
 1

REV	DESCRIPTION	DATE	BY
1	DELETED 10/6/11/14 REF. DIMS. TO HORIZ & TURB. ZONE P-5		
2	ADDED 10/27/11/14 CONNECT, RELOCATE AIR CONN. FROM P-5 TO P-7		
3	ADDED 10/27/11/14 CONNECT, RELOCATE AIR CONN. FROM P-5 TO P-7		
4	ADDED 10/27/11/14 CONNECT, RELOCATE AIR CONN. FROM P-5 TO P-7		
5	ADDED 10/27/11/14 CONNECT, RELOCATE AIR CONN. FROM P-5 TO P-7		

THIS ASSEMBLY IS LOCATED ON			LEVEL	THIS PAGE COVERS PARTS FOR		PAGE
DUY125R6 - 39			1	MTG AIR MOT	509E121AXG-	2 1
ITEM NO.	QUANTITY	MAINT. PARTS	CODE	DESCRIPTION	ORDERING NUMBER	
7	1		1	CLEVIS	165A223DY -	1
8	1		1	CLEVIS	101A195FF -	11
9	1		1	CLAMP	165A101CC -	1
10	2		2	SPACER	5546854AA -	9
11	1		2	SPACER	9443155AB -	65
14	1		2	ADAPTER	101A611DR -	1
15	1		2	ADAPTER	101A289BE -	1
16	1	X	2	NUT	N229P35 -	
17	1	X	2	BEARING	9443134AA -	172
18	1		2	NUT	N229P24 -	
19	4		2	SCREW	N24P25016 -	
20	1		2	PIN	101A316AX -	145
21	6		2	PIN	N504P1212 -	
22	2		2	PIN	101A316AX -	144
23	2		2	BOLT	N24P25032 -	
24	2		2	NUT	9443522AC -	3
25	1		2	NUT	9443522AC -	5
26	3		2	SPACER	101A135AA -	5
27	3		2	SCREW	8954954AA -	86
31	1		2	BRACKET	101C221FB -	1
32	1		2	LEVER	101B279RB -	1
33	X		2	ASSY	509E121AX -	33
34	1		2	PLUG PIPE	9443133AA -	2

123186
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