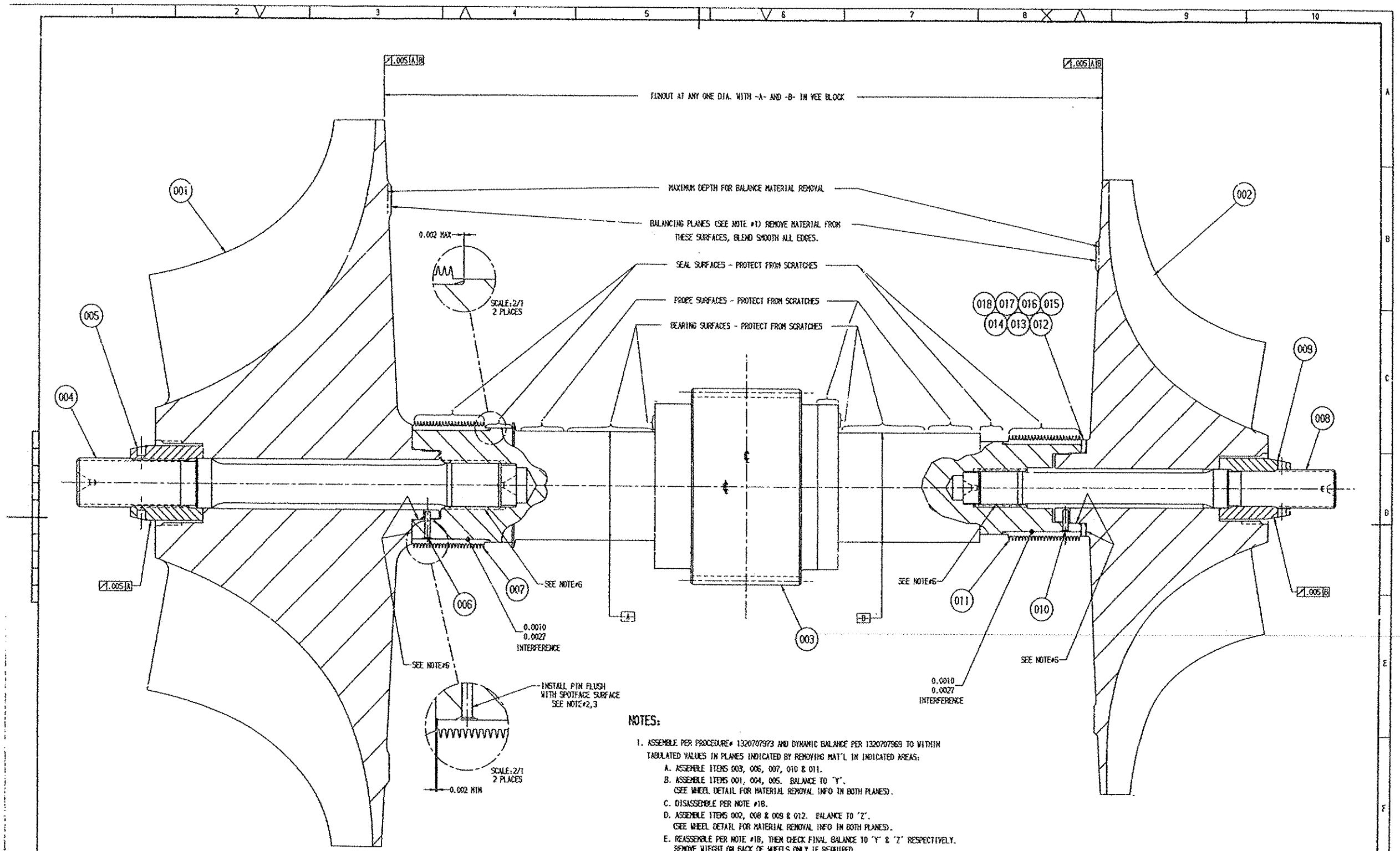

0.026 OZ./IN	0.013 OZ./IN	190.0 LBS
'Y'	'Z'	ROTOR WEIGHT
BALANCE TO		

NOTES:

1. ASSEMBLE PER PROCEDURE# 1320707973 AND DYNAMIC BALANCE PER 1320707969 TO WITHIN TABULATED VALUES IN PLANES INDICATED BY REMOVING MAT'L IN INDICATED AREAS:
   A. ASSEMBLE ITEMS 003, 006, 007, 010 & 011.
   B. ASSEMBLE ITEMS 001, 004, 005. BALANCE TO 'Y'. (SEE WHEEL DETAIL FOR MATERIAL REMOVAL INFO IN BOTH PLANES).
   C. DISASSEMBLE PER NOTE #1B.
   D. ASSEMBLE ITEMS 002, 008 & 009 & 012. BALANCE TO 'Z'. (SEE WHEEL DETAIL FOR MATERIAL REMOVAL INFO IN BOTH PLANES).
   E. REASSEMBLE PER NOTE #1B, THEN CHECK FINAL BALANCE TO 'Y' & 'Z' RESPECTIVELY. REMOVE WTEIGHT ON BACK OF WHEELS ONLY IF REQUIRED.
2. DOWEL PINS(ITEMS 006&010) MUST BE PRESSED IN PLACE FROM OUTSIDE, BEFORE SLEEVES(ITEMS 007 & 011) ARE INSTALLED.
3. TO INSALL SLEEVES(ITEMS 007 & 011), HEAT TO 475°F AND PLACE IN POSITION IN PINION(ITEM 003) AND HOLD.
4. GRINDING OR BLENDING OF BEARING SURFACES MUST BE APPROVED BY ENGINEERING IN ADVANCE.
5. STRETCH TIE BOLTS(ITEMS 004 & 008) PER INSTRUCTIONS 1320707988 & 1320707989.
6. MOLYCOAT SURFACES INDICATED, DO NOT APPLY TO AXIAL FACE.

MEDUSA Rev. 7.05 CAD Drawing — LOW PRECISION SHEET

CAD produced drawing originals shall be stored electrically and be accessible by the drawing number. No manually made changes are allowed on this drawing.

ATLAS COPCO STANDARD/Classic/Cross — ISSUE/ — 1162 87

ROTOR ASSEMBLY MB SCH2 1ST/2ND STAGE

CAD

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS .XXX ±/- .XX ±/- ANGLES ±/- ALL SURFACES ✓ SHARP CORNERS & BEARING .005 R

JOB # MB-40150

Atlas Copco — Date 1/1 — Drawn KAD — Checked — Approved — Scale — Sheet — Size A1 — Rev. — Dig. Dwgs. ENG.

1320704610 — 1 of 1

D — Rev. Ident. — Rev. Text — Date Name — Rev. Index