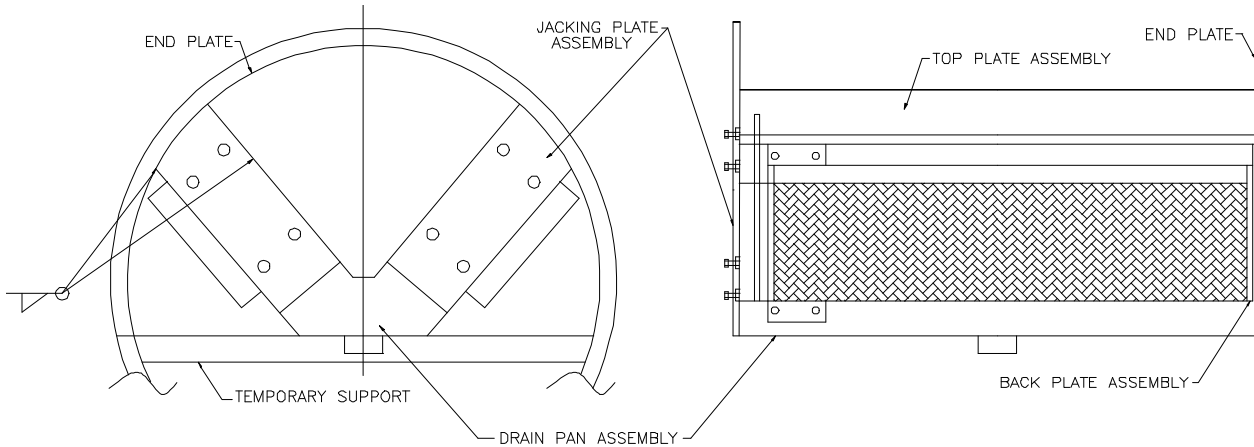


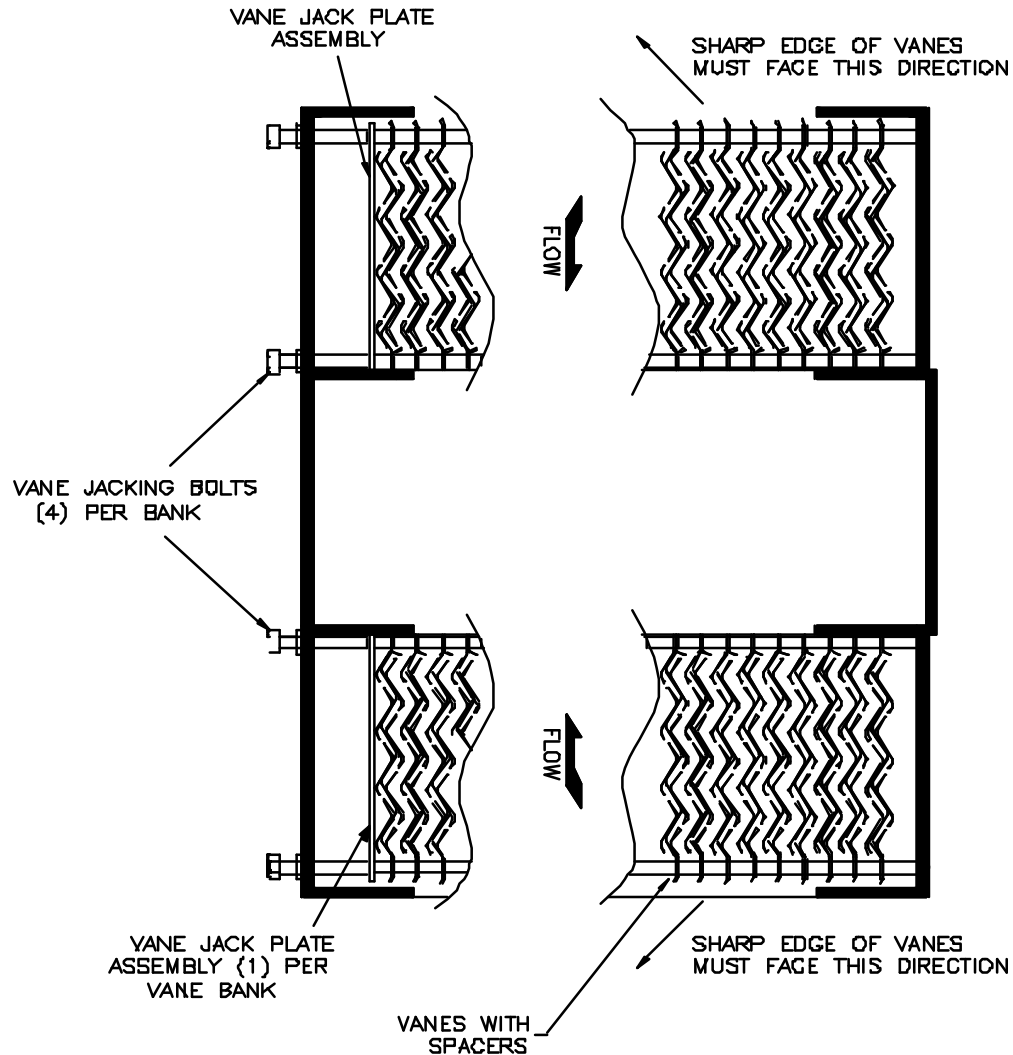
DOUBLE BANK VANE BUNDLE INSTALLATION INSTRUCTIONS



A. BUNDLE INSTALLATION

1. VANE UNIT WILL BE SHIPPED FULLY ASSEMBLED, TACK WELDED TOGETHER AND MATCH MARKED.
2. REVIEW ASSEMBLY TO FAMILIARIZE YOURSELF WITH THE COMPONENT PIECES PRIOR TO DISASSEMBLY.
3. INSTALL TWO TEMPORARY SUPPORT BEAMS IN VESSEL TO SUPPORT BOTTOM PAN AT PROPER LOCATION.
4. LOOSEN JACKING BOLTS (6 PER BANK) TO RELEASE TENSION AND REMOVE THE TOP AND BOTTOM COVER PLATES. **NOTE HOW VANES ARE ORIENTATED.** REMOVE VANES.
5. CAREFULLY CUT THE TACK WELDS TO DISASSEMBLE THE BOXING COMPONENTS. THERE ARE TWO EACH END PLATE, TOP PLATE, JACKING PLATE AND BACK PLATE ASSEMBLIES, AND ONE DRAIN PAN ASSEMBLY.
6. INSTALL DRAIN PAN IN VESSEL ON TEMPORARY SUPPORTS AND TACK WELD. INSTALL JACKING PLATE, BACK PLATE AND TOP PLATE ASSEMBLIES. CHECK FOR SQUARENESS. USE A VANE TO CHECK FOR VANE CLEARANCE IN BOX. THERE SHOULD BE APPROXIMATELY 1/8" CLEARANCE BETWEEN VANE AND BOXING.
7. WELD UNIT TOGETHER USING CONTINUOUS SEAL WELDS.
8. INSTALL END PLATES AND SEAL WELD TO BOXING, SEAL WELD UNIT TO SHELL.

DOUBLE BANK VANE BUNDLE INSTALLATION INSTRUCTIONS



B. BUNDLE INSTALLATION

VANES ARE FURNISHED WITH SPACERS. EACH SET OF VANES REQUIRES A VANE JACK PLATE ASSEMBLY TO BE INSTALLED NEXT TO VANE JACKING BOLTS. WHEN INSTALLING VANES, BE SURE THAT SHARP EDGE OF VANES FACES DIRECTION SHOWN ABOVE.

1. LOOSEN JACKING BOLTS SO THAT VANE JACK PLATE ASSEMBLY MAY BE INSTALLED IN JACKING SPACE AGAINST BOXING. BE SURE JACK PLATE IS AGAINST BOX.
2. INSTALL VANES IN BOX. BE SURE VANE SHARP EDGE FACES IN DIRECTION SHOWN ABOVE.
3. INSTALL VANE ACCESS PLATES (2 PER BANK). REPLACEMENT ACCESS PLATES MUST BE DRILLED TO MATCH DRILLING ON BOXING.
4. TIGHTEN VANE JACKING BOLTS TO SECURE VANES IN BOX. DO NOT OVER TORQUE.