NOTES:

1. LOCATE FUEL PUMP SUPPORT (PT 2) TO DIMENSIONS GIVEN AND BOLT MOUNT TO MODULE BASE AS SPECIFIED. AFTER FIELD ALIGNMENT VERIFICATION/ADJUSTMENT, WELD PUMP MOUNT TO BASE, DIAGONALLY ON OPPOSITE CORNERS. WELD PER PBA-AG1 FIG. F-1, COL AB APPLICABILITY CLASS III, INSPECTION CODE- VISUAL UNLESS OTHERWISE SPECIFIED.

2. ASSEMBLE ELECTRIC CLUTCH (PT 5) TO ACCESSORY DRIVE NO. 3A SHAFT AND INTERGAL CLUTCH HOUSING USING EXISTING HARDWARE PROVIDED WITH CLUTCH. VERIFY CORRECT CLUTCH GAP SHOWN ON DRAWING. REMOVE 1.00 NPT PIPE PLUG IN CLUTCH HOUSING FOR ACCESS.

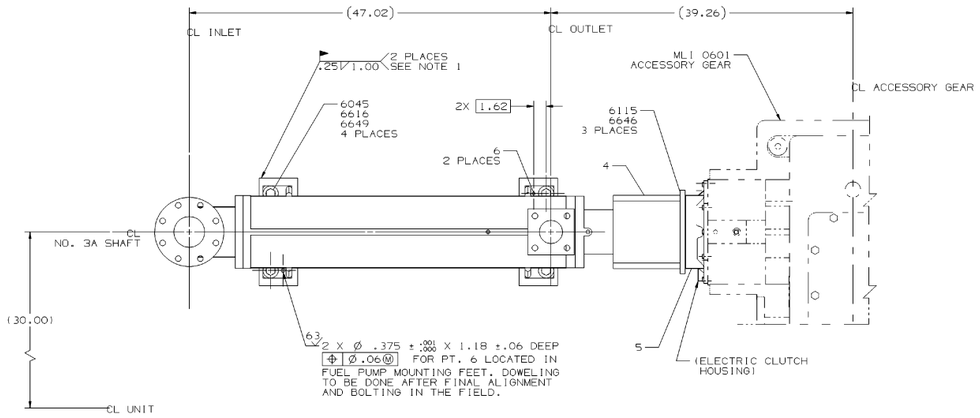
3. DISASSEMBLE ONE HUB FROM FLEXIBLE COUPLING (PT 1) BY REMOVING THE 4 BOLTS AT ONE END AND ASSEMBLE TO THE PUMP SO THAT THE END OF THE SHAFT IS FLUSH WITH THE FACE OF THE COUPLING. INSTALL THE BALANCE OF THE ASSEMBLY ON THE CLUTCH SHAFT SO THAT THE END OF THE CLUTCH SHAFT IS FLUSH WITH THE END OF THE COUPLING. PUT THE PUMP IN PLACE AND ADJUST THE COUPLING PARTS AXIALLY TO MEET WITHOUT DISC DISTORTION. TIGHTEN TAPER LOCK BUSHINGS. ALIGN TO PROVIDE TIR'S NOT IN EXCESS OF .008 AT OUTER RIM OF COUPLING HUBS FOR BOTH AXES. CONNECT COUPLING BY REINSTALLING THE 4 BOLTS.

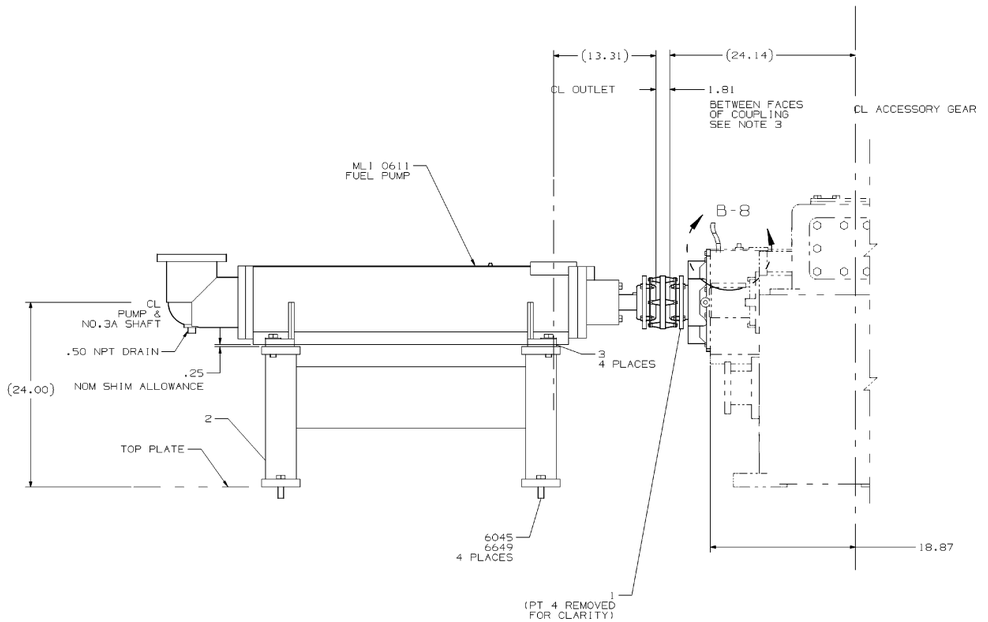
4. TORQUE ALL FUEL PUMP TIE DOWN BOLTS PER ITEM 2. DOWEL FUEL PUMP TO SUPPORT AS INSTRUCTED ON DRAWING. PUMP FEET (4 LOCATIONS) SHALL BE SHIMMED TO ALLOW A MAXIMUM CLEARANCE OF 0.002 INCHES. AFTER FINAL ALIGNMENT AND DOWELING RELEASE BOLTS. CHECK FOOT MOVEMENT ON LOOSENING 0.002 INCHES. SHIM IF NECESSARY. RETORQUE TO 50 FT-LBS.

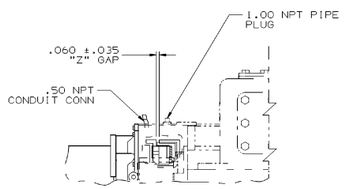
5. ASSEMBLE COUPLING GUARD (PT4) TO ELECTRIC CLUTCH FLANGE.

6. DOWELS TO HAVE 0.0003 ±0.0002 INTERFERENCE FIT AT ASSEMBLY.

7. DOWEL PIN HOLES TO BE 63 FINISH.







DETAIL B-8 (D-4)

(G5) PARTS TO PHILA. GEAR FOR INSTALLATION ON ACCY DRIVE.

(G4) INSTALLATION OF FUEL PUMP ASSY

(G3) ACCUMULATION OF GROUPS 4 AND 5.

(G2) SUMMARY SHEET

(G1) FUEL PUMP ARRANGEMENT WITH FOUR (4) BOLT PEDESTAL BASE

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
A	ADDED GROUPS 3,4 & 5 F.M. ROY	FMR 98-05-06	WAT DER
B	MP60722 OCR F09045 GENERAL CHANGES MITCH M. ORZA	00-08-02 MMO	JWT FFD

REVISE ON CAD ONLY
UG PART: 322B4308G007
(SPEC: 114E1789)

4	FUEL PUMP LUBE OIL REQ	342A2587
3	WELDING-GENERAL SPEC	PBA-AG1
2	BOLT & STUD TORQUING	246A4150
1	APPLIED PRACTICES	348A9200
IT.	NOMENCLATURE	IDENT

LIST OF COMPLEMENTARY DOCUMENTS

BOM ISSUED

UNLESS OTHERWISE SPECIFIED	SIGNATURES	DATE
DIMENSIONS ARE IN INCHES TOLERANCES ON: 2 PL DECIMALS ± .06 3 PL DECIMALS ± .03 ANGLES ± FRACTIONS ±	DRAWN KERRY W. CRAWFORD	97-08-14
	CHECKED KERRY W. CRAWFORD	97-08-14
	ENGRG DAN FREUDMANN	97-08-14
	ISSUED C. OMOHUY	98-08-18
APPLIED PRACTICES 348A9200	MFG ENGR DEAN YEOMAN	97-08-15
	SIM TOL 18B07530	

GE Power Generation — GENERAL ELECTRIC COMPANY GAS TURBINE Schenectady, NY

PUMP ARR, FUEL OIL

FIRST MADE FOR ML-7AIPEA1-13 0510

SIZE E | CAGE CODE | DWG NO 114E1789 | REV 01

SCALE NONE | SHEET 1 | 100%

THIRD ANGLE PROJECTION

DT-IN