COMPRESSOR ASSEMBLY CLEARANCES		
CLEARANCE (DESCRIPTION AND/OR LOCATION)*	MINIMUM	MAXIMUM
ROTOR TO HOUSING CLEARANCE BEFORE INSTALLATION OF THRUST BEARINGS (TOTAL HOUSING TO HOUSING CLEARANCE)	.025	.033
ROTOR TO HOUSING CLEARANCE AFTER INSTALLATION OF THRUST BEARING (DISCHARGE END CLEARANCE)	.0065	.0095
MEASURED SHAFT MOTION WITH SEAL HOUSING INSTALLED	.001	.0049
MALE BALANCE PISTON TO BALANCE PISTON SLEEVE CLEARANCE	.002	.003 *

* DIAMETRICAL CLEARANCES ARE SPECIFIED

TORQUE SPECCIFICATIONS FOR GRADE 8.8 REGULAR PITCH METRIC FASTENERS									
NOMINAL DIAMETER	(M4x0.7)	(M5x0.8)	(M6x1.0)	(M8x1.25)	(M12x1.75)	(M16x2.0)	(M20x2.5)	(M22x2.5)	(M24x3.0)
POUND-FEET	2	4	7	18	58	144	280	368	470

STRAIGHT THREAD O-RING PORT WITH CORRESPONDING O-RING SIZE	
PORT THREAD	O-RING SIZE
5/16-24UNF-2B	902
3/8-24UNF-2B	903
7/16-20UNF-2B	904
1/2-20UNF-2B	905
9/16-18UNF-2B	906
3/4-16UNF-2B	908
7/8-14UNF-2B	910
1 1/16-12UN-2B	912
1 3/16-12UN-2B	914
1 5/16-12UN-2B	916
1 5/8-12UN-2B	920
1 7/8-12UN-2B	924
2 1/2-12UN-2B	932

MANUFACTURING & MAINTENANCE INSTRUCTION BULLETINS	
M.M.I.B. #	DESCRIPTION
4.6.5.5	TORQUE PROCEDURE
4.9.7.11	PAINTING PARAMETERS FOR HIGH SOLID MATERIALS
4.11.9.13	PNEUMATIC TESTING OF COMPLETELY ASSEMBLED TDS, GDS, GRAM AND YORK COMPRESSORS (ALL HIGH STAGE AND BOOSTER)
4.11.9.18	EVACUATION AND CHARGING OF BARE SCREW COMPRESSORS
4.11.9.21	USE OF COMPRESSOR EVACUATION PUMP MANIFOLD ASSEMBLY
4.13.2.2	UNIT TEST SEQUENCE
4.13.3.1	OUTSIDE STORAGE OF BARE COMPRESSORS
4.13.4.1	STANDARD EXPORT BOXING PROCEDURES

ASSOCIATED REFERENCE DRAWINGS	
DRAWING #	DESCRIPTION
534C1053	NAMEPLATE STAMPING PROCEDURE
534E0544	COMPRESSOR DIMENSIONAL OUTLINE
534D0523	SLIDE VALVE INDICATION MECHANISM ASSEMBLY
534D0450	NAMEPLATE AND LABEL LOCATIONS
534A0350	TORQUE SPECIFICATIONS
534C0899	SLIDE VALVE INDICATION MECHANISM TEST PROCEDURE
534E0598	SHAFT SEAL INSTALLATION INSTRUCTIONS

RECOMMENDED SPARE PARTS/SERVICE REPLACEMENT PARTS KITS	
ITEM MASTER #	DESCRIPTION
11100042682	THRUST BEARING KIT
539M0054G01	O-RING AND GASKET KIT
534D0523G02	SLIDE VALVE POTENTIOMETER REPLACEMENT KIT
534A0122G01	MACHINE TOOL KIT

NOTES:

1. MAIN OIL INJECTION ORIFICE PLUG SHALL BE INSTALLED IN PORT SM-1. REFER TO DIMENSIONAL OUTLINE DRAWING FOR PORT LOCATION.
2. ALL OPENINGS SHALL BE CLOSED TO PREVENT DIRT AND FOREIGN MATERIALS FROM ENTERING THE COMPRESSOR DURING TRANSPORT BETWEEN MANUFACTURING DEPARTMENTS.
3. INSTALL CAPLUG IN PORT DESIGNATED AS SC-2. REFER TO DIMENSIONAL OUTLINE DRAWING FOR PORT LOCATIONS (ELECTRICAL CONNECTIONS).
4. INSTALL ADAPTER AND CHARGING VALVES IN PORTS SC-1, SC-2, AND SC-5. REFER TO DIMENSIONAL OUTLINE DRAWING FOR PORT LOCATIONS.
5. TORQUE SPECIFICATIONS FOR THE BWM-06 LOCKNUTS THAT ATTACH THE SPINDLE PISTON AND SLIDE VALVE TO THE SPINDLE IS 113 TO 138 FOOT POUNDS.
6. PRODUCT STRUCTURE IDENTIFIES ADJUSTING WASHER AS 11100040002 & 11100040266
7. ROTOR PAIR – G01 (MANUFACTURED WITH PURCHASED ROTOR BLANK PAIR) MAY BE USED IN PLACE OF FRICK MANUFACTURED ROTOR PAIR – G02.
8. INSTALL CAPLUG IN .196 BLEED HOLE IN CYLINDER COVER.
9. PARKER N1173-70 HYDROGENATED NITRILE O-RINGS SHALL BE COLOR CODED WITH A WHITE PAINT MARK FOR IDENTIFICATION.
10. PARKER C0873-70 CHLOROPRENE RUBBER O-RINGS SHALL BE COLOR CODED WITH A YELLOW PAINT MARK FOR IDENTIFICATION.

ALL SHEETS ARE THE SAME REVISION STATUS

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DO NOT SCALE DRAWING	[redacted]	YORK INTERNATIONAL Northwood Plant, Dept. 2 Wichita, Ks. 67228	
DR. D. LOUDERS		COMPRESSOR, SCREW, 163, YCCH	
DES. R.A.WILLIS JR.			
APR. R.A.WILLIS			
		23567	534E0513	0
		SHEET 2 OF 2	