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 Rev. E 06/25/08 Added GE Drawing

REVISION LETTER	GE ALTERATION NOTICE NUMBER

INSTRUCTION MANUAL IM157

INSTALLATION OF WINDAGE/BALANCE PLUGS

FOR

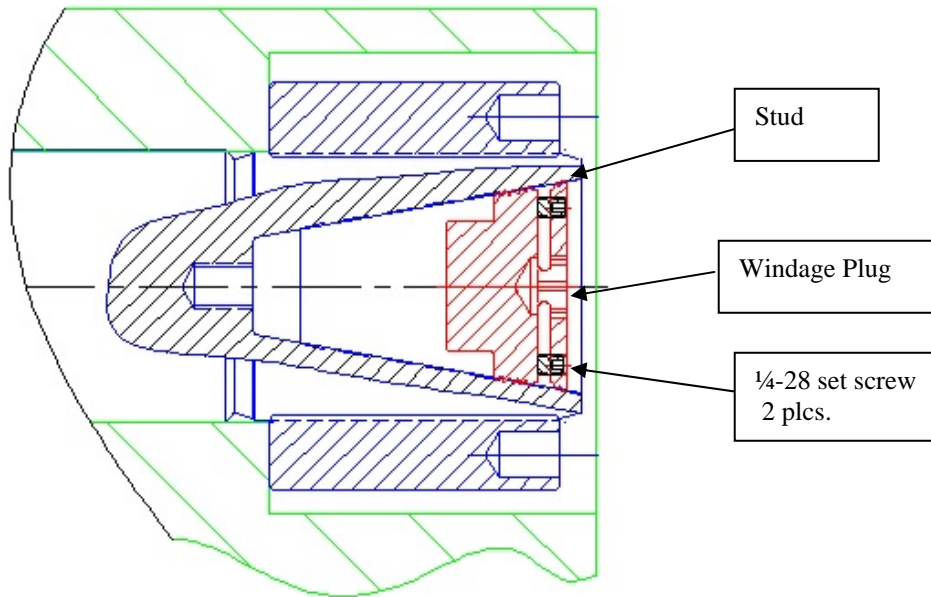
GE TURBINE TENSIONED STUDS

GE Power Generation		GENERAL ELECTRIC COMPANY Schenectady, NY	
<u>VENDOR SUPPLIED DRAWING</u>			
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**Instruction Manual IM157
Windage Plugs For
GE Turbine Tensioned Studs
Frame 9F and 7F**

WINDAGE PLUG 9F (HF-2322)



1. Insert Windage Plug Fully, Tighten to 200-250 in-lbs (22.6-28.2 Nm) Torque
2. Tighten Set Screws to 80-90 in-lbs (9-10 Nm) Torque
3. Caution Plug must rest a minimum of .06" (1.5 mm) below the face of the stud

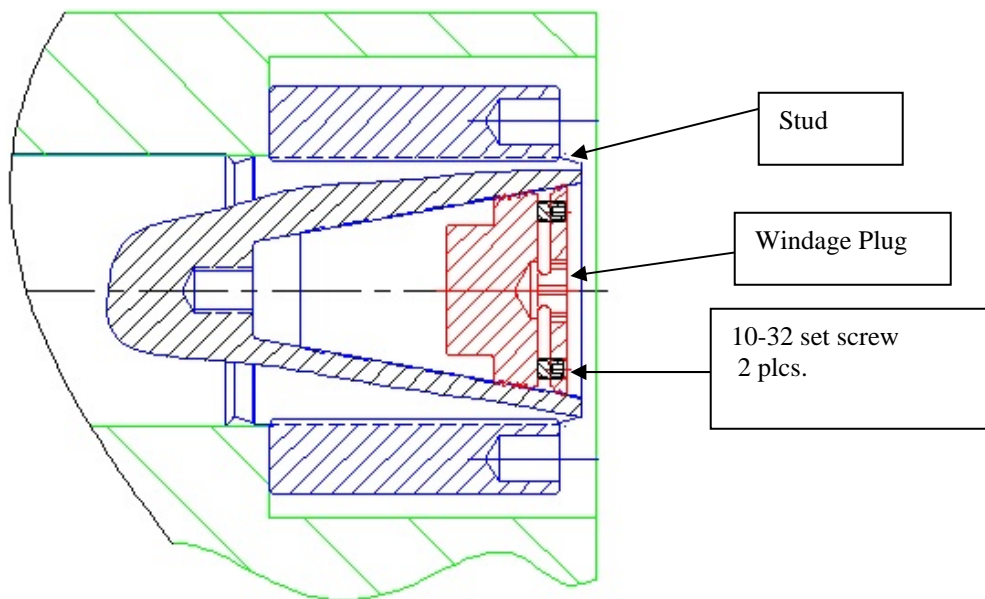
FIGURE 1



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**Instruction Manual IM157
Windage Plugs For
GE Turbine Tensioned Studs
Frame 9F and 7F**

WINDAGE PLUG 7F or 9E (HF-3133)
2 ¼" Stud, and 2 ¾ Stud (7001145 not 9F)



1. Insert Windage Plug Fully, Tighten to 200-250 in-lbs (22.6-28.2 Nm) Torque
2. Tighten Set Screws to 25-35 in-lbs (3-4 Nm) Torque
3. Caution Plug must rest a minimum of .06" (1.5 mm) below the face of the stud

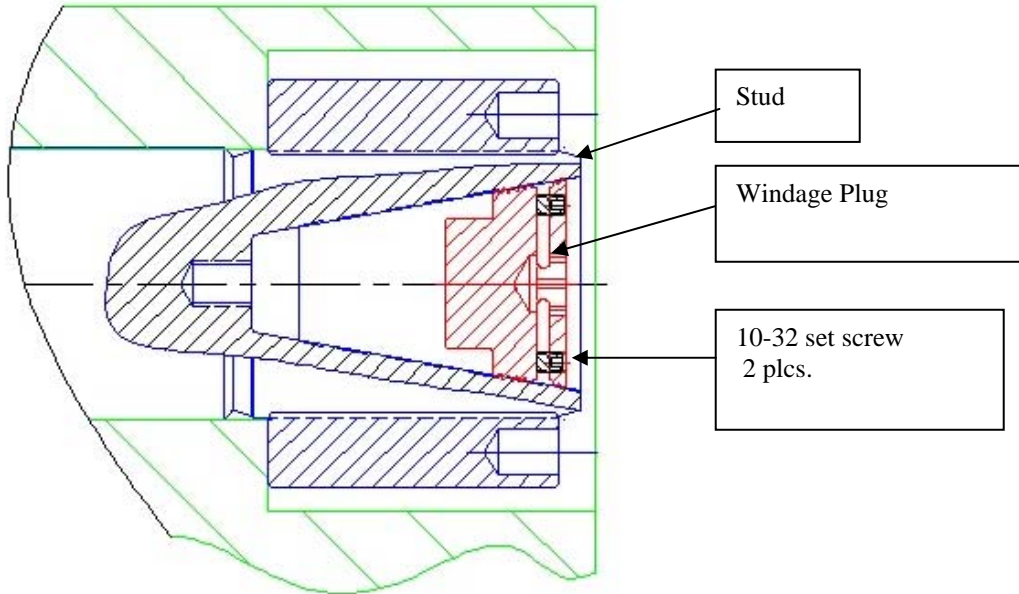
FIGURE 2



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Frame 9F and 7F

WINDAGE PLUG 7E (HF-3180)
2" Stud or 2.5" Stud



1. Insert Windage Plug Fully, Tighten to 100-150 in-lbs (11-17 Nm) Torque
2. Tighten Set Screws to 25-35 in-lbs (3-4 Nm) Torque
3. Caution Plug must rest a minimum of .06" (1.5 mm) below the face of the stud

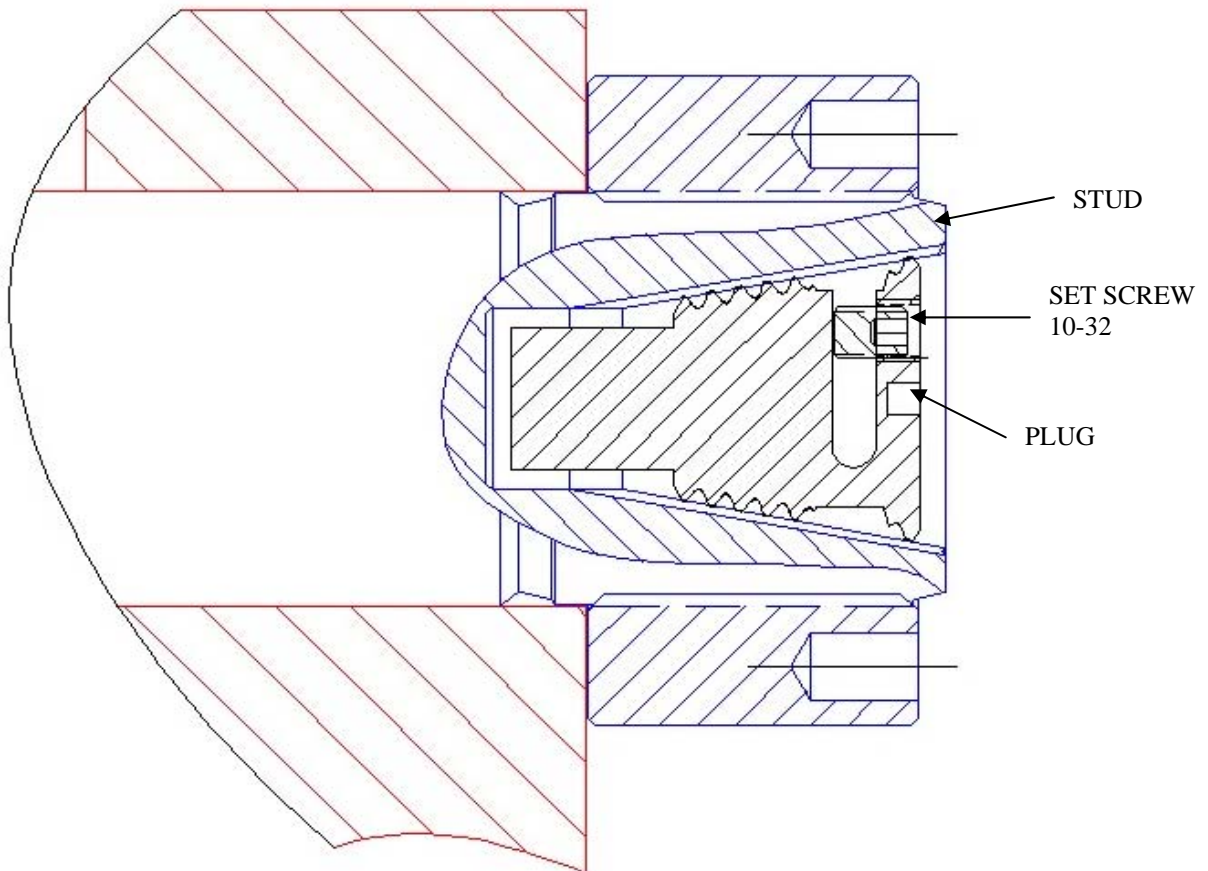
FIGURE 3



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Frame 9F and 7F

Windage/Balance Plug 6B or 6FA (HF-3503)
1.125" Stud



1. Insert Windage Plug Fully, Tighten with screw driver firmly, making sure it is not cross threaded
2. Tighten Set Screws to 25-35 in-lbs (3-4 Nm) Torque
3. Caution Plug must rest a minimum of .06" (1.5 mm) below the face of the stud

FIGURE 4



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