

## TURBINE WI DEMO (assembly)

<b>Job code</b>	C3D-WI-TURBINE-DEMO-02
<b>Summary</b>	Turbine assembly Work Instructions
<b>Work type</b>	Assembly
<b>Role</b>	General Operative
<b>Expected time</b>	5 hours 27 minutes
<b>Work cell</b>	Hangars Nr. 17 - Nr. 29
<b>Previous job</b>	C3D-WI-TURBINE-DEMO-01
<b>Next job</b>	C3D-WI-TURBINE-DEMO-03
<b>Work order</b>	SRT-987 Rev. 4
<b>Revision</b>	A01

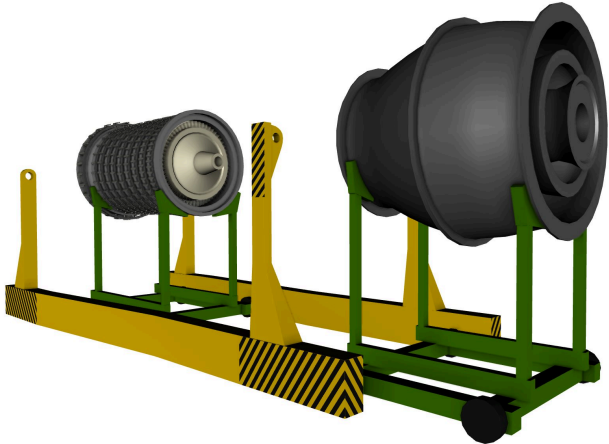
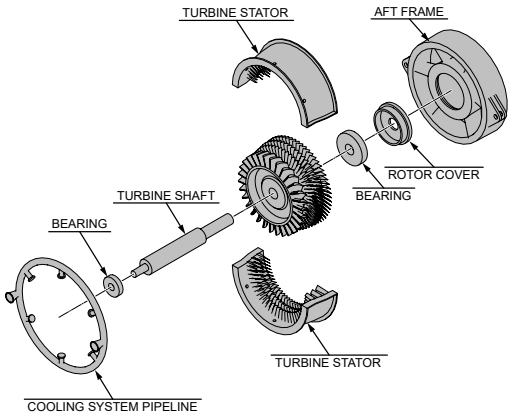
**PREREQUISITES****PARTS LIST**

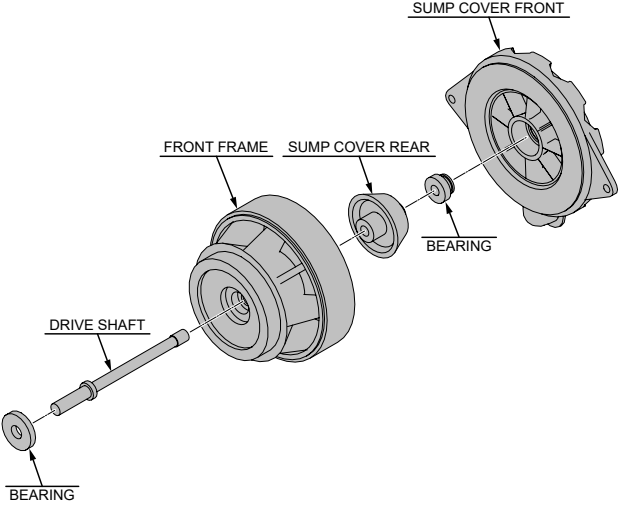
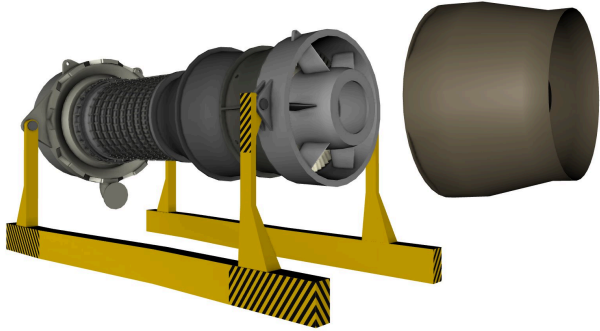
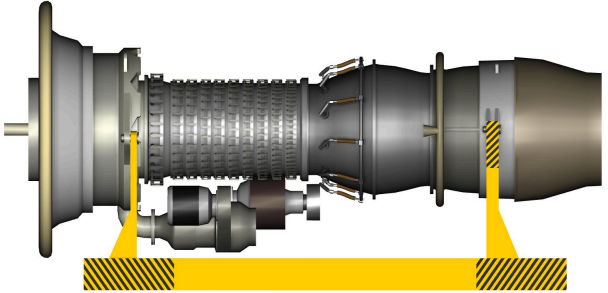
<b>Part number/ Alternative part number</b>	<b>Description</b>	<b>Quantity</b>
M-001	Reductor Module	1
KOR-001	Bolt	1
M-002	Forward SUMP	1
M-003-001	Compressor lower case	1
M-003-000-001	1 Stage compressor blades	1
RING_1	Compressor ring 1	1
	Compressor upper case	1
M-003-003	Compressor rotor	1
T_5	T 5 Rotor crane adaptor	1
M-004	Combustion Chamber	1
M-004-005	Fuel Nozzles	1
M-004-004	Fuel Pipeline	1
T-001	Cooling System Pipeline	1
M-005-005	LPT rotor	1
T_4	T-4	1
M-005-002-002	LPT lower case	1
M-005-000-003	3 Stage LPT blades	1
M-005-003	AFT frame	1
M-006	Outlet Nozzle Module	1
STARTER	Starter	1
RC-002	Reductor Cover (lower)	1
RC-001	Reductor Cover (upper)	1
IN-001	Inlet Nozzle Front	1
IN-002	Inlet Nozzle Rear	1
COMPRESSOR_WAY	Compressor module Way	1
WAY	LPT way	1
CC_WAY	Combustion chamber way	1
TURB_WAY	Turbine way	1

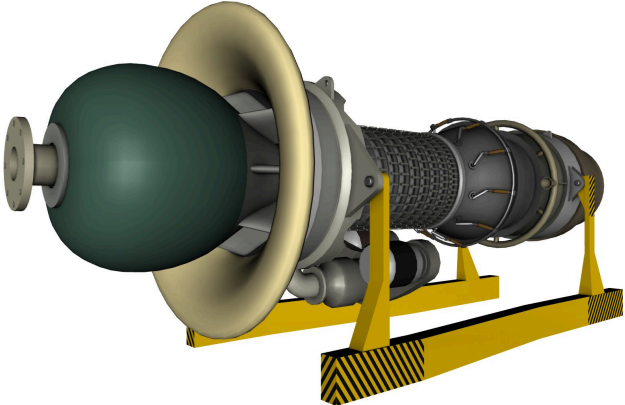
Part number/ Alternative part number	Description	Quantity
SHP_3	Turbine Way Bolt	1
T_1	T-1	1
CRANE_1	Crane 1	1
T_2	T-2	1
T_3	T-3 chain	1

## JOB

Nº	Task	Illustration
1	<p>Bring in the <a href="#">Compressor Lower Case</a> with <a href="#">Compressor blades</a> on the <a href="#">Compressor module Way</a>.</p> <p>Install <a href="#">Compressor Rotor</a>.</p> <p>Remove the <a href="#">T-5</a>. Remove the <a href="#">Crane</a>.</p> <p>Install the <a href="#">Compressor Upper Case</a>.</p> <p>Install the <a href="#">Compressor Rings</a>.</p>	

№	Task	Illustration
2	Attach the <a href="#">Combustion Chamber</a> , using <a href="#">Combustion Chamber Way</a> .	
3	<p>Place assembled modules in the <a href="#">Turbine Way</a>.</p> <p>Bring in the <a href="#">LPT Lower Case</a> with <a href="#">LPT Blades</a> on the <a href="#">LPT Way</a>.</p> <p>Bring in the <a href="#">Low Pressure Turbine rotor</a>, using the <a href="#">Crane</a> and <a href="#">T-4</a>.</p> <p>Install the <a href="#">LPT Rotor</a> on the <a href="#">LPT Lower Case</a> with <a href="#">LPT Blades</a>.</p> <p>Remove the <a href="#">T-4</a>. Remove the <a href="#">Crane</a>.</p> <p>Install the <a href="#">LPT Upper Case</a>.</p> <p>Move the <a href="#">LPT Way</a> and attach the <a href="#">Low pressure turbine</a> to the assembly.</p> <p>Bring in the <a href="#">AFT Frame</a>, using the <a href="#">Crane</a> and the <a href="#">Chain T-3</a>.</p> <p>Install the <a href="#">AFT Frame</a> using the <a href="#">Turbine WayBolts</a>.</p> <p>Remove the <a href="#">T-3</a> and the <a href="#">Crane</a>. Remove the <a href="#">LPT Way</a>.</p>	

№	Task	Illustration
4	<p>Bring in the <a href="#">Forward SUMP Assembly</a>, using the <a href="#">Crane</a> and <a href="#">T-2</a>.</p> <p>Attach the <a href="#">Forward SUMP</a> to the turbine assembly using Turbine Way <a href="#">Bolts</a>.</p> <p>Remove <a href="#">T-2</a> and the <a href="#">Crane</a>. Remove the <a href="#">Combustion Chamber Way</a>. Remove the <a href="#">Compressor Way</a>.</p>	
5	<p>Install the <a href="#">Outlet Nozzle Module</a>.</p> <p>Install the <a href="#">Inlet Nozzle Rear</a>.</p> <p>Install the <a href="#">Inlet Nozzle Front</a>.</p>	
6	<p>Install the <a href="#">Cooling System Pipeline</a>.</p> <p>Install <a href="#">Fuel Pipeline</a> together with preinstalled <a href="#">Fuel Nozzles</a>.</p> <p>Install the <a href="#">STARTER</a>.</p>	

№	Task	Illustration
7	<p>Bring in the <a href="#">Reductor Module</a>, using the <a href="#">Crane</a> and <a href="#">T-1</a></p> <p>Attach the <a href="#">Reductor Module</a>.</p> <p>Install 10 <a href="#">bolts</a>.</p> <p>Remove <a href="#">T-1</a> and the <a href="#">Crane</a>.</p> <p>Install the <a href="#">Lower Reductor Cover</a>.</p> <p>Install the <a href="#">Upper Reductor Cover</a>.</p>	 A 3D CAD illustration of a large industrial reductor module. The module is cylindrical with a large, dark green, hemispherical end on the left. It is supported by a yellow crane structure with two vertical beams and a horizontal base. The crane is lifting the module from the right side. The background is white.