

TURBINE WI DEMO (assembly)

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

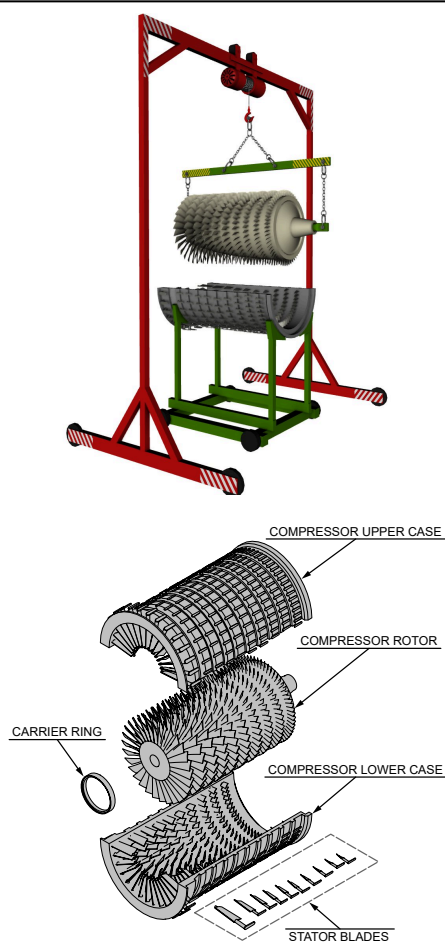
PREREQUISITES

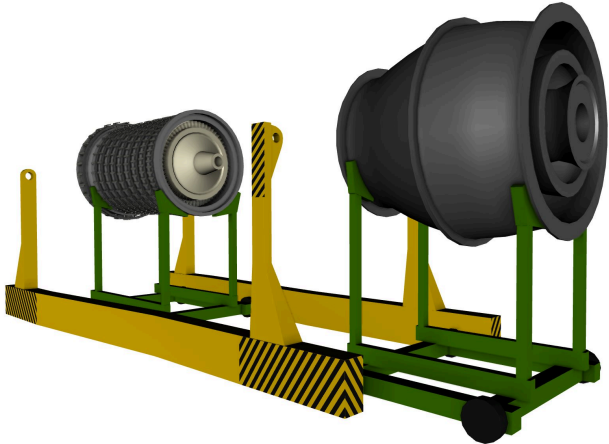
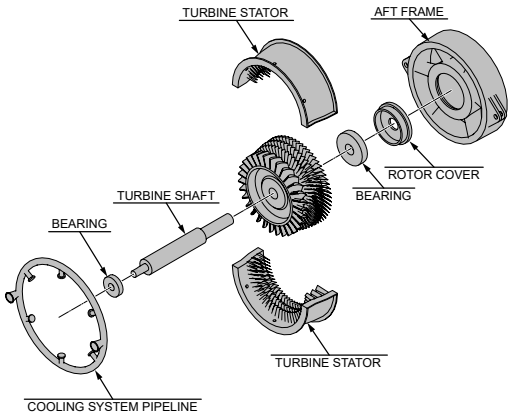
PARTS LIST

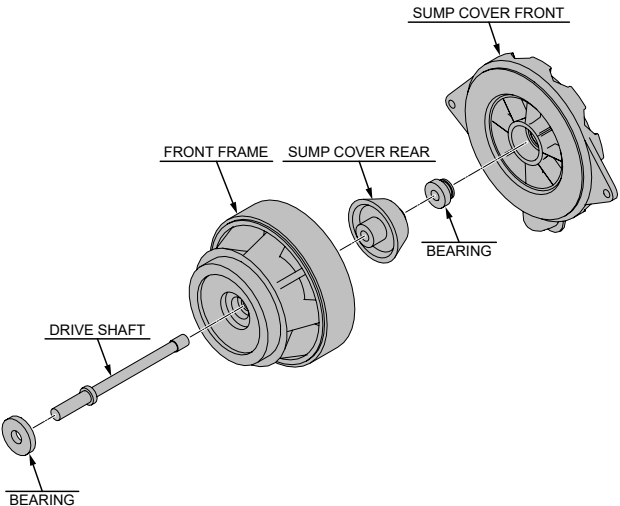
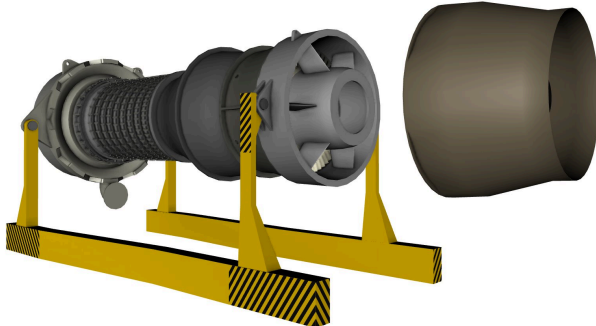
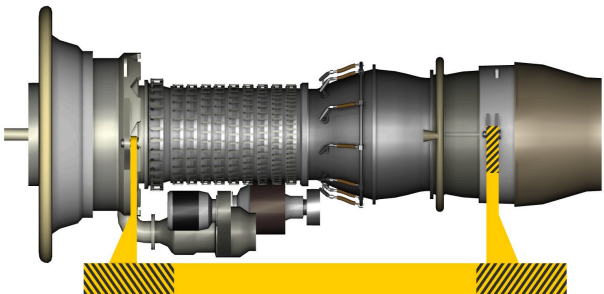
| Part number/ Alternative part number | Description | Quantity |
|---|---------------------------|----------|
| M-001 | Reductor Module | 1 |
| KOR-001 | Bolt | 1 |
| M-002 | Forward SUMP | 1 |
| M-003-001 | Compressor lower case | 1 |
| M-003-000-001 | 1 Stage compressor blades | 1 |
| RING_1 | Compressor 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 |

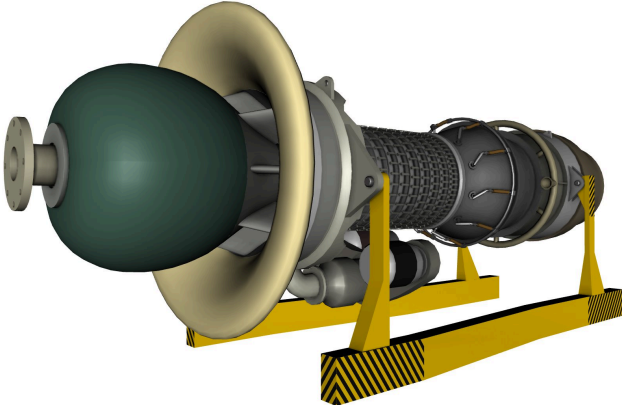
| Part number/ Alternative part number | Description | Quantity |
|---|------------------|----------|
| SHP_3 | Turbine Way Bolt | 1 |
| T_1 | T-1 | 1 |
| CRANE_1 | Crane 1 | 1 |
| T_2 | T-2 | 1 |
| T_3 | T-3 chain | 1 |

JOB

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

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

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

| № | Task | Illustration |
|---|---|--|
| 7 | <p>Bring in the Reductor Module, using the Crane and T-1</p> <p>Attach the Reductor Module.</p> <p>Install 10 bolts.</p> <p>Remove T-1 and the Crane.</p> <p>Install the Lower Reductor Cover.</p> <p>Install the Upper Reductor Cover.</p> |  A 3D CAD model of a large industrial reductor module. The module has a dark green, spherical front end and a long, cylindrical body with various flanges and bolts. It is being lifted by a yellow crane with two lifting straps. The crane is positioned below the module, and the module is suspended in the air. |