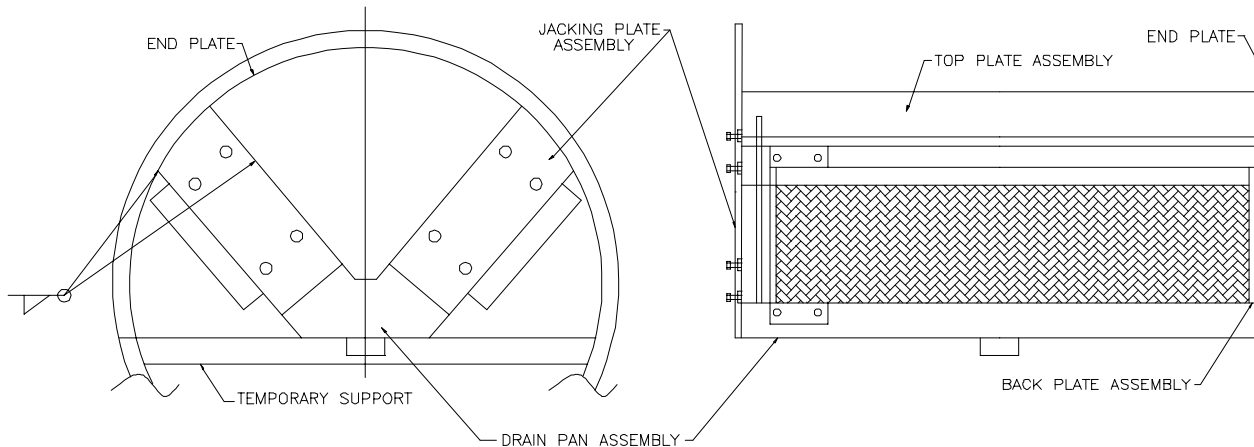


DOUBLE BANK VANE BUNDLE INSTALLATION INSTRUCTIONS



A. BUNDLE INSTALLATION

1. VANE UNIT WILL BE SHIPPED FULLY ASSEMBLED, TACK WELDED TOGETHER AND MATCH MARKED.
2. REVIEW ASSEMBLY TO FAMILIARIZE YOURSELF WITH THE COMPONENT PIECES PRIOR TO DISASSEMBLY.
3. INSTALL TWO TEMPORARY SUPPORT BEAMS IN VESSEL TO SUPPORT BOTTOM PAN AT PROPER LOCATION.
4. LOOSEN JACKING BOLTS (6 PER BANK) TO RELEASE TENSION AND REMOVE THE TOP AND BOTTOM COVER PLATES. **NOTE HOW VANES ARE ORIENTATED.** REMOVE VANES.
5. CAREFULLY CUT THE TACK WELDS TO DISASSEMBLE THE BOXING COMPONENTS. THERE ARE TWO EACH END PLATE, TOP PLATE, JACKING PLATE AND BACK PLATE ASSEMBLIES, AND ONE DRAIN PAN ASSEMBLY.
6. INSTALL DRAIN PAN IN VESSEL ON TEMPORARY SUPPORTS AND TACK WELD. INSTALL JACKING PLATE, BACK PLATE AND TOP PLATE ASSEMBLIES. CHECK FOR SQUARENESS. USE A VANE TO CHECK FOR VANE CLEARANCE IN BOX. THERE SHOULD BE APPROXIMATELY 1/8" CLEARANCE BETWEEN VANE AND BOXING.
7. WELD UNIT TOGETHER USING CONTINUOUS SEAL WELDS.
8. INSTALL END PLATES AND SEAL WELD TO BOXING, SEAL WELD UNIT TO SHELL.

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