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Service Technican Instruction ST – 037 6. Februar 2006

Tightening of the cylinder head nuts with hydraulic tool for type 2, 3 and 4.

Summary:

Stop re-tightening of the cylinder head nuts at the maintenance <100 OH, effective immediately. Re-tightening can cause overstress for the cylinder head bolts. This change is valid for all new installations, short-blocks and cylinder head replacements if it was done with the hydraulic tightening device as well as the conventional torque-angle method. The documentation for new installations is already updated.

Each final inspection report includes information about this change. The P/N for the hydraulic device to tighten cylinder head nuts is listed in the GE Jenbacher catalogue for special tools. The description to operate the hydraulic device can be found in the maintenance instruction W8053.

The installations listed in appendix A are already assembled with this hydraulic device.

Updated documents:

- TA 1902-0212 Screwing and tightening torque for type 2 and 3
- TA 1902-0213 Screwing and tightening torque for type 4
- W 1000 0 Maintenance after first start-up
 - Refrain form re-tightening of the cylinder head nuts fort he <100 OH maintenance.
- W 8053 M0 Cylinder head replacement
 - Additional information for operating the hydraulic device for tightening the cylinder head nuts.
- W8053 M4 Cylinder head replacement

- Additional information for operating of the hydraulic device for tightening the cylinder head nuts.

Appendix A:

Typ	Keyword	Engine No.	Drawing No.
312	Envitec 2005/19	2103014	C394
312	Envitec 2005/23	2130574	C398
312	Envitec 2005/24	2130588	C399
320	Novatex Ltd.	2172457	C498
312	BGA Nordholz 1	2128815	C592
312	BGA Nordholz 2	2128827	C592
320	Kedrion 2	2140844	C628
320	Biokraft (1)	444736	C632
320	Biokraft (2)	444863	C632
320	Flex 1A	2136986	C655
320	AK Schweringen	2146781	C679
208	KA Traismauer	2142009	C681
320	Kassim Textile 3	2140374	C690
320	Olympia Power 2	2138541	C691
320	Olympia Power 3	2138553	C692
320	Reliance Cotton Extensio 1	2140362	C695
316	Severn Trent 2005/1	2144200	C696
320	Hobart	447657	C697
320	CEI 05-002	2144125	C700
320	Shujabad Mills Ltd. 1	2143980	C702
320	Shujabad Mills Ltd. 2	2143993	C702
320	Natural Palm Oil	2143335	C703
320	BGD 001/ CSK Ltd.	2143080	C704
320	BGD 002	2143093	C705
320	BGD 003 (MAGNA TEXT.MILLS)	2143105	C706
312	BGA Dermbach	2146707	C719
320	Aben B.V.	2149128	C720
320	AB Energy 3	2151325	C730
320	Nur Woolwears	2156086	C751
320	Indigo Textile (1)	449747	C762
320	Indigo Textile 2	2157318	C762
320	Hassan Board	2161297	C763
208	Ozz Canada East	2158121	C775
320	N.Z. Textile Limited 1	2172470	C818
320	N.Z. Textile Limited 2	2172482	C818
320	Paradise Spinning Mills 1	2172494	C821
320	Paradise Spinning Mills 2	2172506	C821
320	Paradise Spinning Mills 3	2172518	C821
320	Amber Cotton Mills LTD 2 (PARTEX ROTOR MILLS LTD-1/2)	2178626	C826
320	Amber Cotton Mills LTD 1 (PARTEX ROTOR MILLS LTD-1/1)	2178613	C827
312	BGA Neubauer	2191802	C931