

SERVICE TECHNICIANS INSTRUCTION

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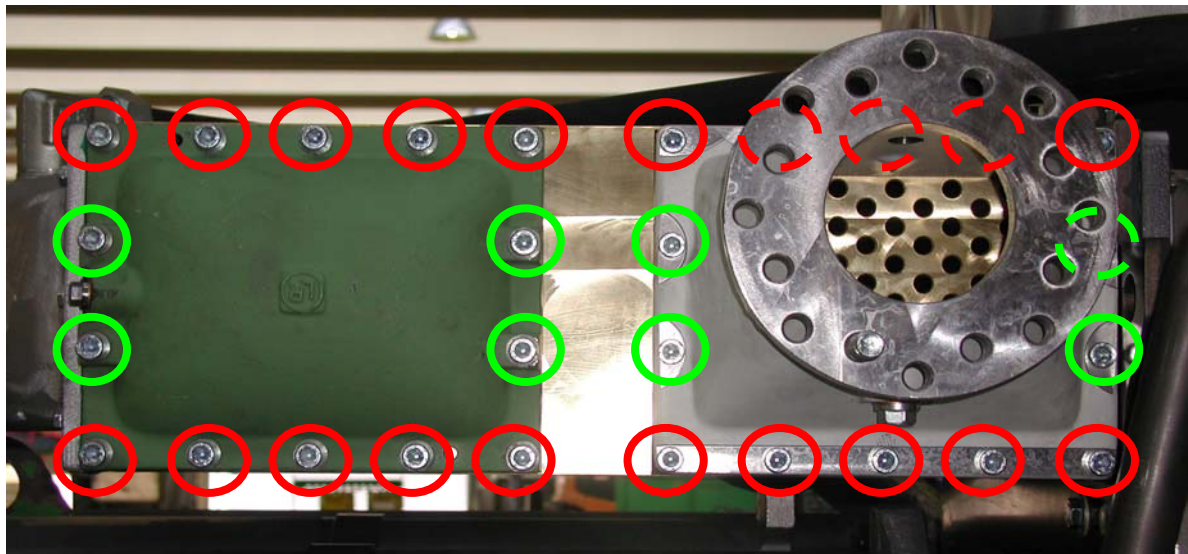
Date

GE Jenbacher
H. Sonnerer | Service
tel 2168 - fax 42168

from

Mounting of type 3 mixture cooler's covers at water side

To avoid leakages at type 3 mixture coolers, jointly with the manufacturer we set up a tightening instruction. As two different types of bolts are applied, two different tightening torques have to be used as well.



Cylindric bolt M 10 x 45, stability class 10.9 (p/n 115242)



Tightening torque: 65 Nm

These bolts are screwed into the steel-side section.

Cylindric bolt M 10 x 30, stability class 8.8 minimum (p/n 115239)



Tightening torque: 45 Nm max (screwed into the brass section)

As these are through-holes to the suction tract, the threads have to be sealed by Loctite 243!

This is effective for both, single-stage and double-stage mixture coolers. For further improvement of the seal we are testing a modified gasket between bottom and side section at the moment.