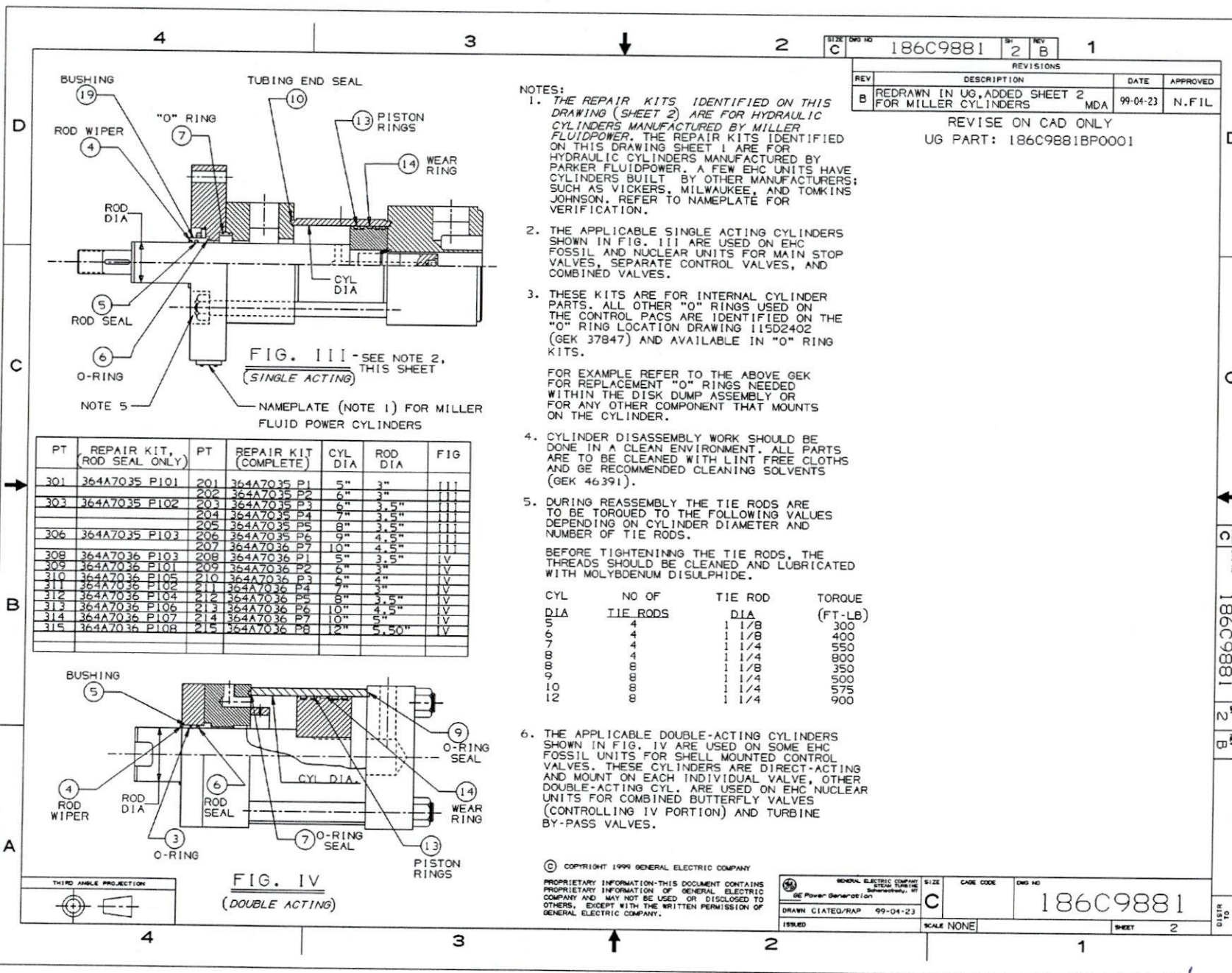




NOTES:

1. THE REPAIR KITS IDENTIFIED ON THIS DRAWING (SHEET 2) ARE FOR HYDRAULIC CYLINDERS MANUFACTURED BY MILLER FLUIDPOWER. THE REPAIR KITS IDENTIFIED ON THIS DRAWING SHEET 1 ARE FOR HYDRAULIC CYLINDERS MANUFACTURED BY PARKER FLUIDPOWER. A FEW EHC UNITS HAVE CYLINDERS BUILT BY OTHER MANUFACTURERS; SUCH AS VICKERS, MILWAUKEE, AND TOMKINS JOHNSON. REFER TO NAMEPLATE FOR VERIFICATION.

2. THE APPLICABLE SINGLE ACTING CYLINDERS SHOWN IN FIG. III ARE USED ON EHC FOSSIL AND NUCLEAR UNITS FOR MAIN STOP VALVES, SEPARATE CONTROL VALVES, AND COMBINED VALVES.

3. THESE KITS ARE FOR INTERNAL CYLINDER PARTS. ALL OTHER "O" RINGS USED ON THE CONTROL PACS ARE IDENTIFIED ON THE "O" RING LOCATION DRAWING 115D2402 (GEK 37847) AND AVAILABLE IN "O" RING KITS.

FOR EXAMPLE REFER TO THE ABOVE GEK FOR REPLACEMENT "O" RINGS NEEDED WITHIN THE DISK DUMP ASSEMBLY OR FOR ANY OTHER COMPONENT THAT MOUNTS ON THE CYLINDER.

4. CYLINDER DISASSEMBLY WORK SHOULD BE DONE IN A CLEAN ENVIRONMENT. ALL PARTS ARE TO BE CLEANED WITH LINT FREE CLOTHS AND GE RECOMMENDED CLEANING SOLVENTS (GEK 46391).

5. DURING REASSEMBLY THE TIE RODS ARE TO BE TORQUED TO THE FOLLOWING VALUES DEPENDING ON CYLINDER DIAMETER AND NUMBER OF TIE RODS.

BEFORE TIGHTENING THE TIE RODS, THE THREADS SHOULD BE CLEANED AND LUBRICATED WITH MOLYBDENUM DISULPHIDE.

CYL DIA	NO OF TIE RODS	TIE ROD DIA	TORQUE (FT-LB)
5	4	1 1/8	300
6	4	1 1/8	400
7	4	1 1/4	550
8	4	1 1/4	800
9	8	1 1/8	350
10	8	1 1/4	500
12	8	1 1/4	575
		1 1/4	900

6. THE APPLICABLE DOUBLE-ACTING CYLINDERS SHOWN IN FIG. IV ARE USED ON SOME EHC FOSSIL UNITS FOR SHELL MOUNTED CONTROL VALVES. THESE CYLINDERS ARE DIRECT-ACTING AND MOUNT ON EACH INDIVIDUAL VALVE. OTHER DOUBLE-ACTING CYL. ARE USED ON EHC NUCLEAR UNITS FOR COMBINED BUTTERFLY VALVES (CONTROLLING IV PORTION) AND TURBINE BY-PASS VALVES.

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GENERAL ELECTRIC COMPANY GE Power Generation	SIZE C	CAGE CODE	DWG NO 186C9881
ISSUED	SCALE NONE	SHEET 2	

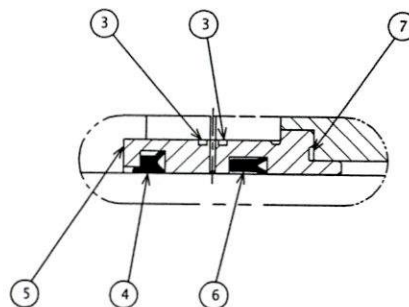
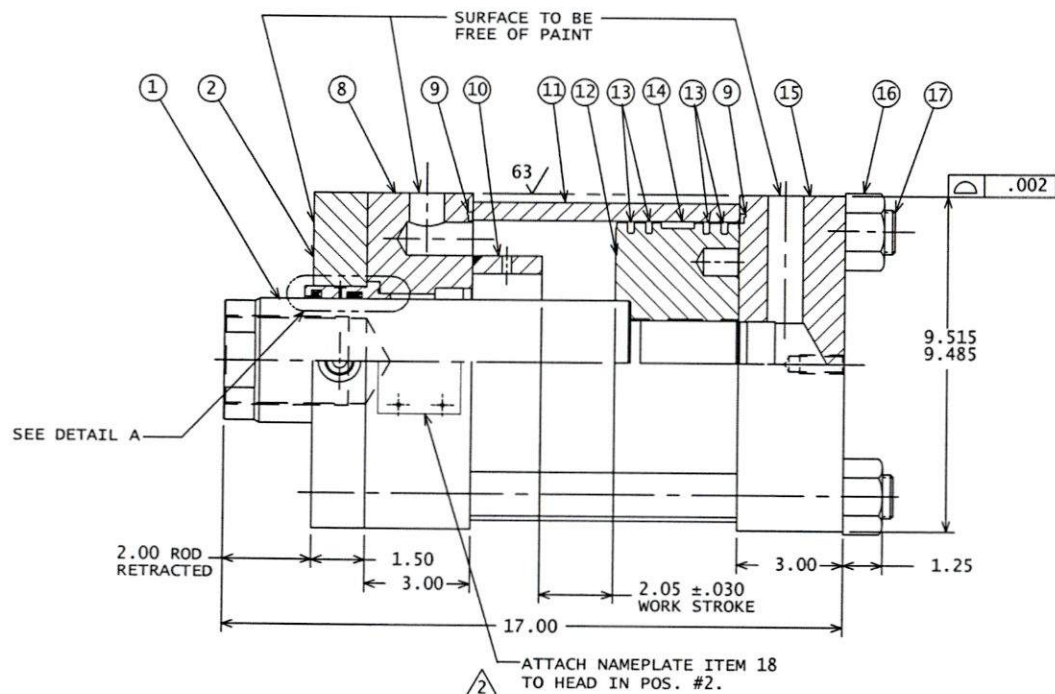
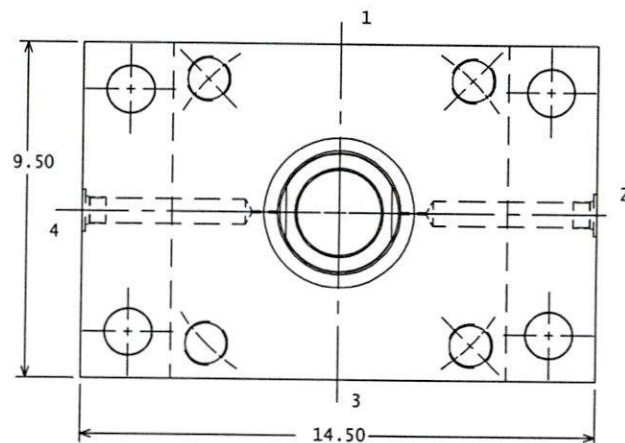
SIZE C	DWG NO 186C9881	REV 2	REV B	1
REV		DESCRIPTION	DATE	APPROVED
B	REDRAWN IN UG, ADDED SHEET 2 FOR MILLER CYLINDERS		MDA 99-04-23	N.FIL

REVISE ON CAD ONLY
UG PART: 186C9881BP0001

[Handwritten signature]

ITEM NO.	DESCRIPTION	QTY	MATERIAL	DWG NO. OR QIC NO.
1	PISTON ROD	1	STEEL	558144
2	FLANGE PLATE	1	T-1 TYPE C ASTM A514 Q	D10186603
3	O-RING	2	EPR	800857
4	ROD WIPER	1	VITON	135683
5	BUSHING	1	BRONZE	551042
6	ROD SEAL	1	VITON	107941
7	O-RING SEAL	1	VITON	107970
8	HEAD	1	STEEL	558141, 558142
9	END SEAL	2	EPR	801427
10	STOP TUBE	1	STEEL	D10186601B
11	CYLINDER TUBE	1	STEEL	D10186605
12	PISTON	1	STEEL	115984

ITEM NO.	DESCRIPTION	QTY	MATERIAL	DWG NO. OR QIC NO.
13	PISTON RING	4	CAST IRON	139321
14	WEAR RING	1	BRONZE OR TORLON	141786
15	CAP	1	STEEL	558143
16	TIE ROD NUT	4	STEEL	118360
17	TIE ROD	4	STEEL	D10186606
18	GE NAME PLATE	1	ALUMINIUM	YY353198A1



DETAIL A
SCALE 1 : 1

NOTES:

8.00" BORE
4.00" TOTAL STROKE
1.950" STOP TUBE TO GIVE
A 2.050" WORK STROKE
BEFORE TIGHTENING THE TIE RODS, THE THREADS SHOULD BE CLEANED
AND LUBRICATED WITH MOLYBDENUM DISULPHIDE OR EQUIVALENT.
TIE ROD TORQUE TO 790-810 FT-LB.

GRIND PORT SURFACES AFTER ASSY.
DO NOT USE GREASE TO ASSEMBLE.
USE PHOSPHATE ESTER FLUID FROM TS-22 ONLY TO LUBRICATE CYLINDER.

SPECIAL CLEANING PROCEDURE # 9469.
SPECIAL PAINT: 23R2 CARPOXY RED PRIMER
USE TEST FIXTURE # 897 (DWG NO. D101866-07).

63/ FINISH ON HEAD AND CAP ON PORT SIDE.
THESE SURFACES SHOULD BE FREE OF TOOL MARKS, ETC.

SURFACES MARKED WITH 63/ MUST BE PARALLEL AND IN THE
SAME PLANE WITH EACH OTHER WITHIN .002" AFTER TEST.

MAINTAIN DIMENSIONS PER G.E., DWG # 194D7821 P0006 REV C.

TEST WITH PHOSPHATE ESTER (TS-22)
CYCLE FULL LENGTH 25 TIMES MIN.
MEASURE LEAKAGE PAST PISTON ASSEMBLY AT 1600 PSI
FOR ONE MINUTE, RECORD FINDINGS.
PRESSURE CYLINDER TO 2000 PSI AND HOLD FOR 5 MINUTES BOTH ENDS.
MEASURE BREAKLOOSE IN STD. MANNER.
MEASURE STROKE, RECORD.

REV	DATE	DESCRIPTION	DR	CK	APP	DATE
0	10/01/00	(CB3142) REFERENCE DWG 558140	BA	BA	PJ	10/01/00
1	03/20/04	ADDED ITEM NO. 18; NAMEPLATE WAS AT POS				
2		# 3	JM	KG	CP	10/01/00
3						
4						
5						

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Miller FLUID POWER
800 N. YORK ROAD
BENSINGTON, IL 60006
(630) 766-3400

TITLE: ASSY - "H61" - 8.00" BORE
x ø 3.50" ROD x 2.05" WORK STROKE
USAGE: GENERAL ELECTRIC CO.
DWG NO. 194D7821 P0006 REV C

SURFACE TREATMENT: JON NO. SCALE: 1 : 2.5
C 503951 (REV. NO.) R- 2