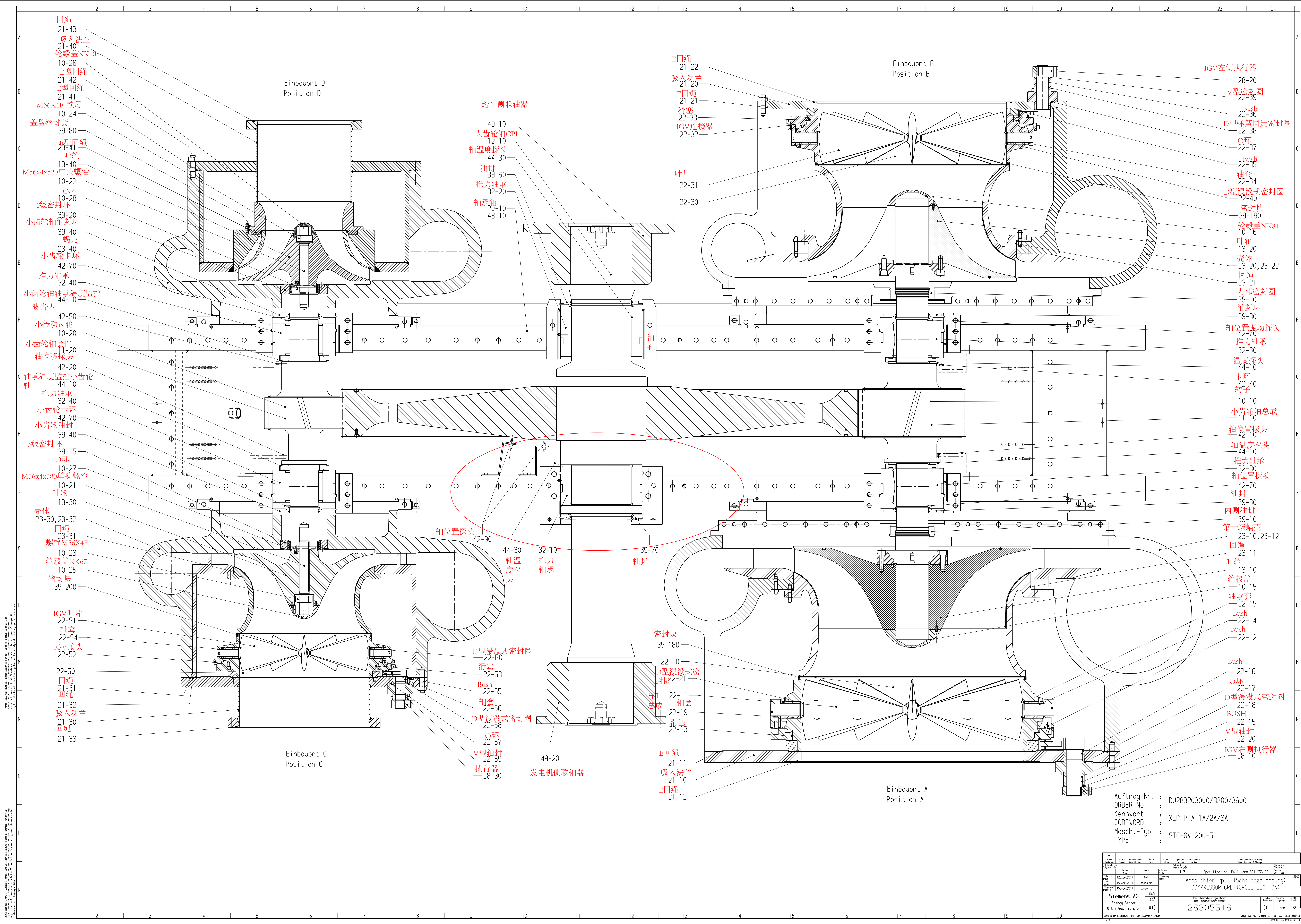
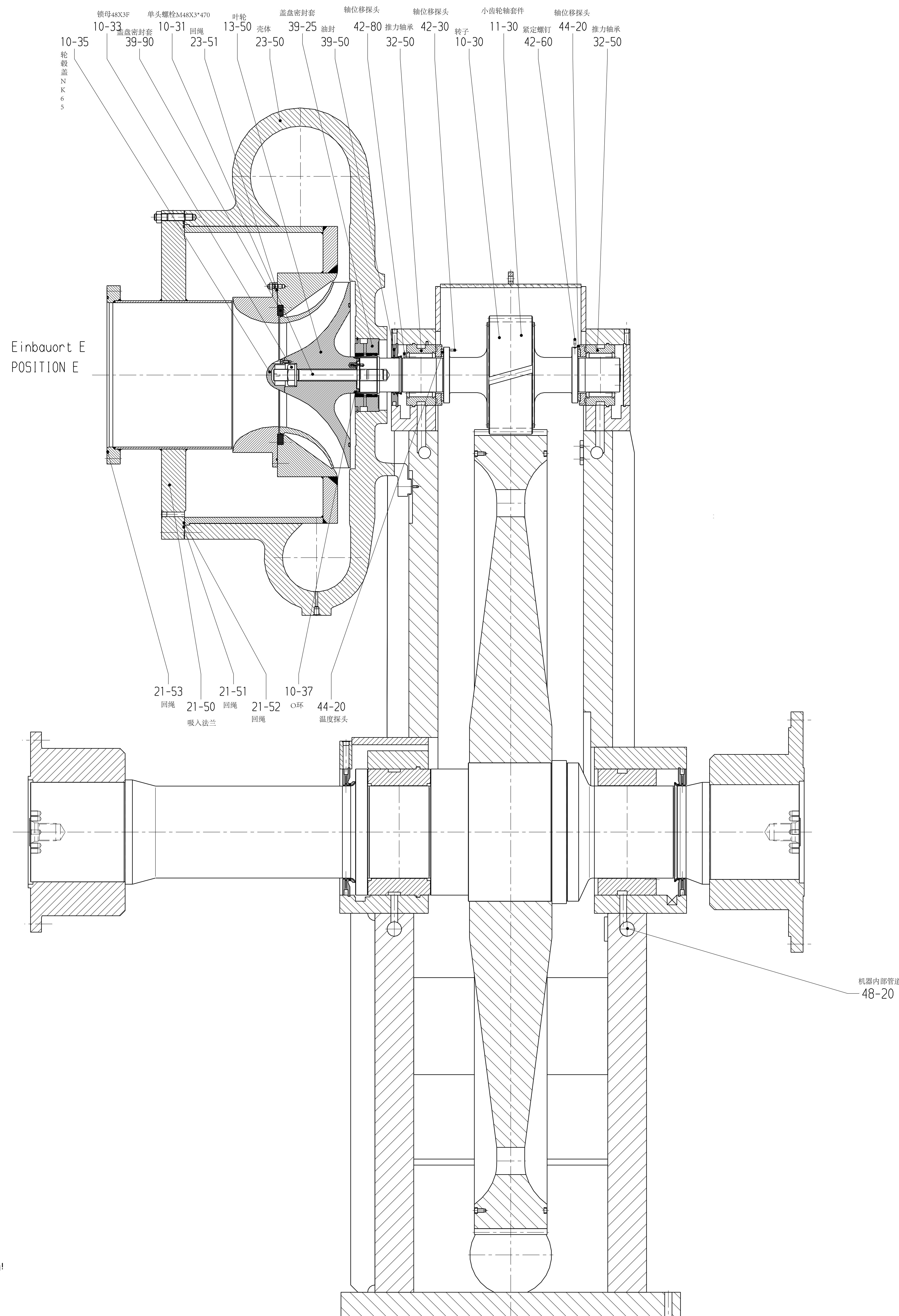






| Tightening torque for bolted connections    |                  |      |          |      |       |       |
|---------------------------------------------|------------------|------|----------|------|-------|-------|
| Strength class to DIN-ISO 898 Part 1        |                  |      |          |      |       |       |
| Thread                                      | 5.6              | 8.8  | 10.9     |      | A2-70 | A4-70 |
| Tightening torque MA in Nm                  |                  |      |          |      |       |       |
| Anziehdrehmomente für Schraubenverbindungen |                  |      |          |      |       |       |
| Festigkeitsklasse nach DIN-ISO 898 T.1      |                  |      |          |      |       |       |
| Gewinde                                     | 5.6              | 8.8  | 10.9     |      | A2-70 | A4-70 |
|                                             | Anziehdrehmoment |      | Ma in Nm |      |       |       |
| M6                                          | 6                | 13   | 18       | 4    | 9     |       |
| M8                                          | 14               | 30   | 44       | 9    | 9     |       |
| M10                                         | 21               | 44   | 64       | 14   | 14    |       |
| M12                                         | 35               | 75   | 110      | 24   | 25    |       |
| M16                                         | 85               | 180  | 265      | 57   | 59    |       |
| M20                                         | 165              | 360  | 520      | 110  | 115   |       |
| M22                                         | 220              | 495  | 680      | 147  | 154   |       |
| M24                                         | 285              | 630  | 890      | 189  | 199   |       |
| M27                                         | 415              | 910  | 1300     | 277  | 291   |       |
| M30                                         | 570              | 1250 | 1800     | 378  | 397   |       |
| M33                                         | 760              | 1700 | 2400     | 508  | 533   |       |
| M36                                         | 980              | 2150 | 3100     | 655  | 687   |       |
| M39                                         | 1250             | 2800 | 3950     | 844  | 886   |       |
| M42                                         | 1550             | 3450 | 4900     | 1046 | 1098  |       |
| M45                                         | 1950             | 4300 | 6100     | 1296 | 1365  |       |
| M48                                         | 2400             | 5200 | 7400     | 1576 | 1655  |       |
| M52                                         | 3000             | 6700 | 9500     | 2020 | 2121  |       |
|                                             | 1                | 2    |          |      |       |       |

Die Oberteile der Pos. 39-50, 39-60, 39-70, 39-80 bei der Montage im Getriebegehäuse - Oberteil bzw. Lagerdeckel mit Kleber CASCO 187 eingeklebt!

The upper parts of items 39-50, 39-60, 39-70, 39-80 are to be glued into the gear casing upper part and bearing cap with CASCO 187 glue during assembly.

Die Schrauben der mit Hylomar abgedichteten Flächen sind ein Tag später nachzuziehen!

Screws with Hylomar sealing surfaces are to be retightened one day later!

Auftrag-Nr. : DU283203000/3300/3600  
ORDER No :  
Kennwort : XLP PTA 1A/2A/3A  
CODEWORD :  
Masch.-Typ : STC-GV 200-5  
TYPE :

[illegible]

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                |                                                                     |                                                                |                   |                        |                                                |                                               |                |  |  |  |  |  |                  |  |  |  |  |  |  |  |  |  |  |  |  |  |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------|---------------------------------------------------------------------|----------------------------------------------------------------|-------------------|------------------------|------------------------------------------------|-----------------------------------------------|----------------|--|--|--|--|--|------------------|--|--|--|--|--|--|--|--|--|--|--|--|--|
| <b>Siemens AG</b><br>Power Generation<br>Oil & Gas and<br>Industrial Applications                                                                                                                                                                                                                                                                                                                                                                                        |                | <b>Teileliste für Verdichter und Ersatzteil</b><br><b>Part List</b> |                                                                |                   |                        |                                                |                                               |                |  |  |  |  |  |                  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| <div><div><div><div><div><div></div><div>Auftrag-Nr.:</div></div><div><div></div><div>Kennwort:</div></div><div><div></div><div>Typ:</div></div></div><div><div><div> / Order-No.: DU283203000</div><div> / Codeword: XLP PTA 1A</div><div> / Type: STC-GV (200-5)</div></div></div></div><div><div><div>Maschinen-Nr.:</div><div>Schnittzeichn.:</div></div><div><div> / Compressor-No.: 100484</div><div> / Sectional Draw.No.: 26305516</div></div></div></div></div> |                |                                                                     |                                                                |                   |                        |                                                |                                               |                |  |  |  |  |  |                  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| <table><tr><td colspan="7">XIANG LU PETROCHEMICALS (ZHANGZHOU) CO., LTD.</td></tr><tr><td colspan="7">XLP2 PTA PROJECT</td></tr><tr><td colspan="7"></td></tr></table>                                                                                                                                                                                                                                                                                                   |                |                                                                     |                                                                |                   |                        |                                                | XIANG LU PETROCHEMICALS (ZHANGZHOU) CO., LTD. |                |  |  |  |  |  | XLP2 PTA PROJECT |  |  |  |  |  |  |  |  |  |  |  |  |  |
| XIANG LU PETROCHEMICALS (ZHANGZHOU) CO., LTD.                                                                                                                                                                                                                                                                                                                                                                                                                            |                |                                                                     |                                                                |                   |                        |                                                |                                               |                |  |  |  |  |  |                  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| XLP2 PTA PROJECT                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                |                                                                     |                                                                |                   |                        |                                                |                                               |                |  |  |  |  |  |                  |  |  |  |  |  |  |  |  |  |  |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                |                                                                     |                                                                |                   |                        |                                                |                                               |                |  |  |  |  |  |                  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 1                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                | 15.04.11                                                            | spona00e                                                       | loosen1a          |                        | Doc-No and Sectional-drw. No revised.          |                                               |                |  |  |  |  |  |                  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| -                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                | 15.04.11                                                            | spona00e                                                       | loosen1a          |                        | Änderungsbeschreibung<br>Description of Change |                                               |                |  |  |  |  |  |                  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Index<br>Revision                                                                                                                                                                                                                                                                                                                                                                                                                                                        | Blatt<br>Sheet | Datum<br>Date                                                       | erstellt<br>drawn                                              | geprüft<br>review | freigegeben<br>checked | Entstanden aus:<br>Original of:                |                                               |                |  |  |  |  |  |                  |  |  |  |  |  |  |  |  |  |  |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                | Format<br>Size                                                      | Ident-Nummer/Unterlagen-Nummer<br>Ident-Number/Document-Number |                   |                        | Klassifikation:<br>Classification:             |                                               |                |  |  |  |  |  |                  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Klass. Nr.:<br>Class. No.:                                                                                                                                                                                                                                                                                                                                                                                                                                               |                | A4                                                                  | 26305616                                                       |                   |                        | Index<br>Revision                              | Sprache<br>Language                           | Blatt<br>Sheet |  |  |  |  |  |                  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Dok.-Art:<br>Doc.-Type                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                |                                                                     |                                                                |                   |                        | 01                                             | de/en                                         | 1/4            |  |  |  |  |  |                  |  |  |  |  |  |  |  |  |  |  |  |  |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                |                                                                     |                                                                |                   |                        |                                                |                                               |                |  |  |  |  |  |                  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Handhabung: Nur für internen Gebrauch                                                                                                                                                                                                                                                                                                                                                                                                                                    |                |                                                                     |                                                                |                   |                        |                                                |                                               |                |  |  |  |  |  |                  |  |  |  |  |  |  |  |  |  |  |  |  |  |
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| Number | Identifier | Name                                  | Material       |
|--------|------------|---------------------------------------|----------------|
| 10-10  | 31102116   | ROTOR CPL EBO AB                      |                |
| 10-15  | 55604115   | Hub cap NK 82                         | X3CrNiMo13-4   |
| 10-16  | 51226315   | Hub cap NK 81                         | X3CrNiMo13-4   |
| 10-20  | 31102216   | ROTOR CPL EBO CD                      |                |
| 10-21  | 31187416   | STUD BOLT M64x4x580                   | 26NiCrMoV11-5  |
| 10-22  | 66248015   | STUD BOLT M56x4x520                   | 26NiCrMoV11-5  |
| 10-23  | 72980415   | NUT M64x4 F                           | 26NiCrMoV11-5  |
| 10-24  | 46214715   | NUT M56x4F                            | 26NiCrMoV11-5  |
| 10-25  | 31964916   | HUB CAP NK 67                         | X3CrNiMo13-4   |
| 10-26  | 10418816   | HUB CAP NK 108                        | X3CrNiMo13-4   |
| 10-27  | 75591698   | O-ring F 164,77 x 2,62 -165           | FKM 70         |
| 10-28  | 71909298   | O-ring F 152,07 x 2,62 -163           | FKM 70         |
| 10-30  | 31102316   | ROTOR CPL EBO E                       |                |
| 10-31  | 10502216   | Stud bolt M48X3X470                   | 26NiCrMoV11-5  |
| 10-33  | 43007515   | NUT M48x3F                            | 26NiCrMoV11-5  |
| 10-35  | 46961115   | HUB CAP NK 65                         | X5CrNiCuNb16-4 |
| 10-37  | 71914498   | O-ring F 133,02 x 2,62 -160           | FKM 70         |
| 11-10  | 27566616   | PINION SHAFT COMPLETE                 | 55NiCrMoV7     |
| 11-20  | 27566716   | PINION SHAFT COMPL                    | 55NiCrMoV7     |
| 11-30  | 27566816   | PINION SHAFT COMPL                    | 55NiCrMoV7     |
| 12-10  | 29740716   | BULL GEAR SHAFT CPL                   |                |
| 13-10  | 26982116   | IMPELLER 1500-R-65 GA3                | X3CrNiMo13-4   |
| 13-20  | 26982216   | IMPELLER 1315-L-65 GA3                | X3CrNiMo13-4   |
| 13-30  | 26982316   | IMPELLER 890-R-65 GA3                 | X3CrNiMo13-4   |
| 13-40  | 26982416   | IMPELLER 835-L-50 GB2                 | X3CrNiMo13-4   |
| 13-50  | 26982516   | IMPELLER 765-R-50 GB2                 | X3CrNiMo13-4   |
| 20-10  | 30393916   | Gear case complete                    |                |
| 21-10  | 28952216   | SUCTION FLANGE DL1500/1415/N/2009 SI  | P355N          |
| 21-11  | 75702998   | Round Cord E 7                        | FKM 70         |
| 21-12  | 75702998   | Round Cord E 7                        | FKM 70         |
| 21-20  | 28892416   | SUCTION FLANGE DL1400/1200/N/2009 BDF | S355J2+N       |
| 21-21  | 75702998   | Round Cord E 7                        | FKM 70         |
| 21-22  | 75702998   | Round Cord E 7                        | FKM 70         |
| 21-30  | 30443416   | SUCTION FLANGE DL890/825/M/2009 ACE   | P355N          |
| 21-31  | 75702998   | Round Cord E 7                        | FKM 70         |
| 21-32  | 75702998   | Round Cord E 7                        | FKM 70         |
| 21-33  | 75702998   | Round Cord E 7                        | FKM 70         |
| 21-40  | 30408816   | SUCTION FLANGE CPL DL835/595/M/2009   | P355N          |
| 21-41  | 75702998   | Round Cord E 7                        | FKM 70         |
| 21-42  | 75702998   | Round Cord E 7                        | FKM 70         |
| 21-43  | 75702998   | Round Cord E 7                        | FKM 70         |
| 21-50  | 30408916   | SUCTION FLANGE CPL DL765/595/H/2009   | P355N          |
| 21-51  | 75702998   | Round Cord E 7                        | FKM 70         |
| 21-52  | 75702998   | Round Cord E 7                        | FKM 70         |
| 21-53  | 75702998   | Round Cord E 7                        | FKM 70         |
| 22-10  | 27320616   | ELA 1415 2010 ASSEMBLY                |                |
| 22-11  | 28429816   | GUIDE VANE COMPLETE 1415 SI           |                |
| 22-12  | 28948016   | JOINT FOR IGV 1415 SI                 | X17CrNi16-2    |
| 22-13  | 97826715   | SLIDE PLUG 1415 SI                    | PEEK           |
| 22-14  | 70411698   | Bush 75 B 80 x 40                     | P1-BC-J1P      |
| 22-15  | 76547998   | Bush 38 B 42 x 30                     | P1-BC-J1P      |
| 22-16  | 75623598   | Bush 100 B105 x 60                    | P1-BC-J1P      |
| 22-17  | 76373498   | O-ring F 132,72 x 5,33 -355           | NBR 90         |
| 22-18  | 76446898   | Spring-held Seal Ring D 100F          | PTFE / Elgiloy |
| 22-19  | 97837615   | BEARING SLEEVE 1415 SI                | X6CrNiTi18-10  |
| 22-20  | 70965698   | Shaft sealing Ring V 135 - 144        | FKM            |
|        |            |                                       |                |

| Number | Identifier | Name                                  | Material                 |
|--------|------------|---------------------------------------|--------------------------|
| 22-21  | 75618698   | Spring-held Seal Ring D 92F           | PTFE / Elgiloy           |
| 22-30  | 28818516   | IGV 1200 Assembly left side 2010      |                          |
| 22-31  | 28819416   | IGV Blade 2010 cpl left side 2010     |                          |
| 22-32  | 22032616   | Joint For IGV 1200 2010               | X17CrNi16-2              |
| 22-33  | 21656816   | Sliding plug 1200 2010                | PEEK                     |
| 22-34  | 71339698   | Collar bush 60 B 65 x 36              | P1-BC-J1P                |
| 22-35  | 71704698   | Bush 28 B 32 x 20                     | P1-BC-J1P                |
| 22-36  | 70411698   | Bush 75 B 80 x 40                     | P1-BC-J1P                |
| 22-37  | 75524598   | O-ring F 107,32 x 5,33 -347           | FKM 70                   |
| 22-38  | 71620198   | Spring-held Seal Ring D 75P           | PTFE / Elgiloy           |
| 22-39  | 71704798   | Shaft Sealing Ring V 98 - 104         | FKM                      |
| 22-40  | 71620198   | Spring-held Seal Ring D 75P           | PTFE / Elgiloy           |
| 22-50  | 23879316   | IGV 825 Assembly 2010                 |                          |
| 22-51  | 23885716   | IGV Blade 825 cpl right side          |                          |
| 22-52  | 23914316   | Joint For IGV 825 2010                | X17CrNi16-2              |
| 22-53  | 24091316   | Sliding plug IGV 825 2010             | PEEK                     |
| 22-54  | 70114598   | Collar bush 45 B 50 x 26              | P1-BC-J1P                |
| 22-55  | 70114098   | Bush 25 B 28 x 15                     | P1-BC-J1P                |
| 22-56  | 71339698   | Collar bush 60 B 65 x 36              | P1-BC-J1P                |
| 22-57  | 71146698   | O-ring F 100,97 x 5,33 -345           | NBR 90                   |
| 22-58  | 71077798   | Spring-held Seal Ring D 60F           | PTFE / Elgiloy           |
| 22-59  | 71704798   | Shaft Sealing Ring V 98 - 104         | FKM                      |
| 22-60  | 71620098   | Spring-held Seal Ring D 58F           | PTFE / Elgiloy           |
| 23-10  | 27939616   | VOLUTE CASING COMPLETE POS A          |                          |
| 23-11  | 75702998   | Round Cord E 7                        | FKM 70                   |
| 23-12  | 75703498   | Round Cord E 5,33                     | FKM 70                   |
| 23-20  | 27939716   | VOLUTE CASING COMPLETE POS B          |                          |
| 23-21  | 75702998   | Round Cord E 7                        | FKM 70                   |
| 23-22  | 75703498   | Round Cord E 5,33                     | FKM 70                   |
| 23-30  | 27939816   | VOLUTE CASING COMPLETE POS C          |                          |
| 23-31  | 75702998   | Round Cord E 7                        | FKM 70                   |
| 23-32  | 75703498   | Round Cord E 5,33                     | FKM 70                   |
| 23-40  | 27939916   | VOLUTE CASING COMPLETE POS D          |                          |
| 23-41  | 75703498   | Round Cord E 5, FKM 70                |                          |
| 23-50  | 27940016   | VOLUTE CASING COMPLETE POS E          |                          |
| 23-51  | 75703498   | Round Cord E 5,33                     | FKM 70                   |
| 28-10  | 31167216   | Actuator cpl. IGV1415 SI right side   |                          |
| 28-20  | 29880616   | Actuator clp. IGV 1200 left side      |                          |
| 28-30  | 31057916   | Activator cpl. IGV825 H250 ri. 2010   |                          |
| 32-10  | 66349915   | Comb. journal & thrust bearing cpl.   | N/A                      |
| 32-20  | 66349815   | Journal bearing bull gear shaft       |                          |
| 32-30  | 28660316   | Comb.journal&thrust bearing           |                          |
| 32-40  | 28665116   | Comb. journal & thrust bearing cpl.   |                          |
| 32-50  | 28670316   | Comb. journal & thrust bearing cpl.   |                          |
| 39-10  | 73077915   | Sealing insert F1K0                   | ENAW-AlMg4,5Mn0,7        |
| 39-15  | 30580216   | Sealing insert carbon 1K0/H168        | C45E Elektrografit FE45S |
| 39-20  | 73308515   | Sealing insert carbon 1K0/H153        | C45E Elektrografit FE45S |
| 39-25  | 81377415   | sealing insert carbon 2K10/H138       | C45E Elektrografit FE45S |
| 39-30  | 72504315   | Oil sealing ring 5/200                | ENAW-AlMg4,5Mn0,7        |
| 39-40  | 66376315   | Oil sealing ring pinion shaft 5/180   | ENAW-AlMg4,5Mn0,7        |
| 39-50  | 31908416   | Oil sealing ring pinion shaft 3/140   | ENAW-AlMg4,5Mn0,7        |
| 39-60  | 51443215   | Oil sealing ring bullgear shaft 5/380 | ENAW-AlMg4,5Mn0,7        |
| 39-70  | 81971115   | Oil sealing ring bullgear shaft 5/380 | ENAW-AlMg4,5Mn0,7        |
| 39-80  | 27596315   | Sealing insert for cover disc DSP543  | S355J2+N/AL99F23         |
| 39-90  | 27586315   | Sealing insert for cover disc DSP482  | ENAW-AlMg4,5Mn0,7        |
| 39-180 | 71693598   | Block Seal 1375                       | FKM 70                   |
| 39-190 | 71632898   | Block seal 1165                       | FKM 70                   |
| 39-200 | 71632698   | Block seal 805                        | FKM 70                   |
| 42-10  | 31892216   | SHAFT POSITION GK5-DS400/200-B/D=1,0  |                          |

| Number | Identifier | Name                                       | Material |
|--------|------------|--------------------------------------------|----------|
| 42-20  | 31892416   | Shaft position GK5-DS400/180-B/D1.0        |          |
| 42-30  | 31892016   | Shaft position GK5-DS250/140-B/D=0,7       |          |
| 42-40  | 31892516   | Pick-Up keyphaser GK5-DS400/200-B/D=1.0    |          |
| 42-50  | 31892616   | Pick-Up keyphaser GK5-DS400/180-B/D=1,0    |          |
| 42-60  | 89093315   | Pick-up keyphaser EB0 E/F                  |          |
| 42-70  | 73518515   | Pick-up vibration pinion shaft (S5)EB0 A-D |          |
| 42-80  | 73309515   | Pick-up vibration pinion shaft (S4)EB0 E/F |          |
| 42-90  | 99428215   | Pick-up shaft position/speed bull gear     |          |
| 44-10  | 81610715   | Bearing temp. monit. pinion shaft          |          |
| 44-20  | 81468115   | BEARING TEMP. MONIT. PINION SHAFT          |          |
| 44-30  | 89093615   | Bearing temp. monit bull gear shaft        |          |
| 48-20  | 34575216   | Internal piping for machine                |          |
| 49-10  | 27329416   | Coupling cpl. gearbox/compressor           |          |
| 49-20  | 27326916   | Coupling cpl. compressor/motor             |          |