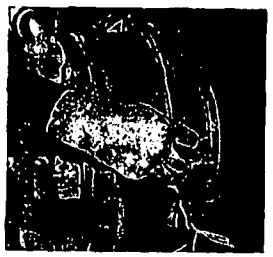
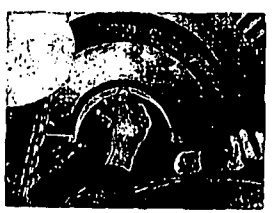
Careful work, with every man doing his job right until machine is "buttoned up," will keep this unit running many months until the next major overhaul

Use cylinder oil and graphite sparingly or it will end up in the boilers



PLACE top half of carbon-ring casing carefully in place over coated joint



POSITION carbon-ring segments into the diaphragms against the spring as shown



COAT diaphragm's joint face with graphite and cylinder oil before lowering in place



DIAPHRAGMS are all in place between these moving blades



HEALTHY SMACK against wood block helps seat diaphragms

CLOSING the turbine means an anxious period because many things can go wrong to cause delay. From around casing, clear all tools and small parts that might fall in, making you lift cover again—*or, worse yet, that might go unnoticed* until turbine is turned over with steam. That's why you should use only responsible mechanics.

Before spreading sealing compound on casing joint, *again* vacuum the joint surface so tiny foreign particles dropping on joint will be removed, instead of shoved inside. Compound used here on joint is Copaltite. Apply only when casing is ready to be lowered after asbestos string is placed as shown. On very large turbines, compound is usually applied with a short, stiff paint brush. Here, it was spread thin by hand to cover surfaces evenly and without smearing on the other parts, such as studs, carbon rings, rotors, etc.

Asbestos twine gives body to compound, and makes a triple seal for steam to work through if there are low spots in the joint surface.

After casing is lowered, *take up on all* nuts evenly, only hand-tight. Then tighten nuts by staggering from one side of the casing to the other, instead of starting with one nut and going all around.

Scheduled maintenance, as shown in these photos, is the only answer to preventive maintenance. But, again, I should remind you that unless you are set up to do the work, it will pay to have one of the manufacturer's field engineers supervise the job. *Before opening a* turbine, always have on hand spare parts that might be needed—in good shape.



COAT outside of all diaphragms with graphite and cylinder oil as shown here



RUN this fine asbestos string, three turns, all around the coated casing



CASING joint is well-coated with sealing compound—asbestos string placed

"LOWER AWAY, and here's smooth sailing because this turbine is shipshape"

