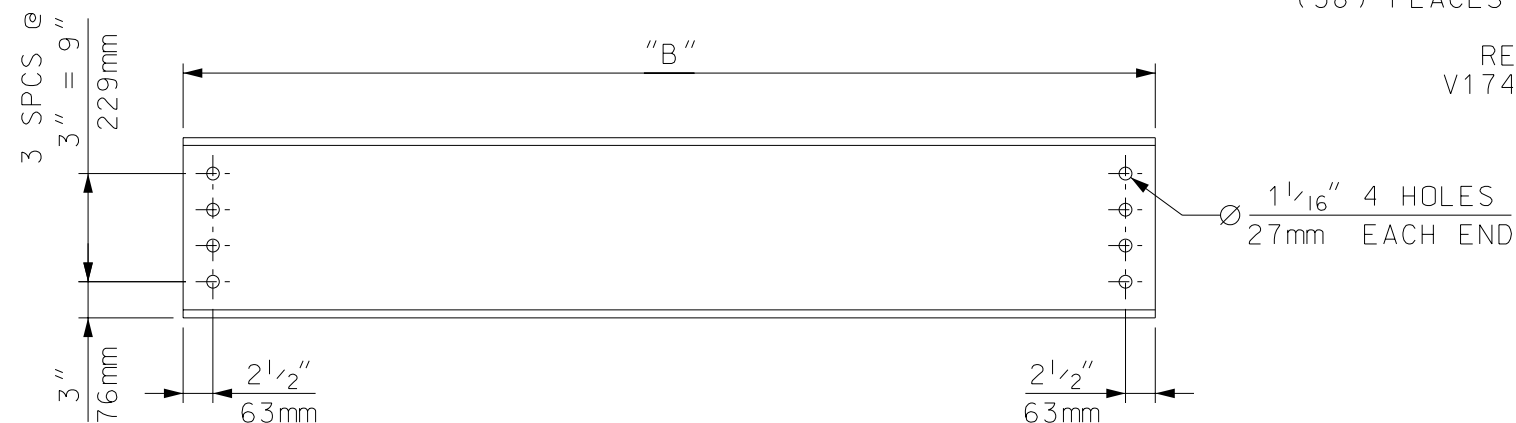


1. INSTALL ROD COUPLING & HANGER ROD ASS'Y MAKING SURE THREADS ARE FULLY ENGAGED $\pm 1/4"$.
2. ENSURE HANGER RODS ARE CENTERED AND PLUMB ON SUPPORT CHANNELS.
3. REMOVE TACK WELDS ATTACHING ROD BELLOWES AND SEAL RINGS TO TOP CASING.
4. TRANSFER THE MODULE LOADS TO THE TOP TRANSVERSE BEAM BY TIGHTENING THE NUTS IN A SEQUENCE TO LIFT THE MODULES SLOWLY TOGETHER.
5. CAREFULLY ADJUST MODULE BANK TO THE PROPER ELEVATION USING STUB PIPE AND MODULE HEADER CENTERLINES AS REFERENCE POINTS.
6. REMOVE TEMPORARY SUPPORT CLIPS, CHANNELS, AND HARDWARE. DO NOT LOOSEN TEMPORARY SUPPORT NUT UNTIL TEMPORARY SUPPORT CHANNELS ARE READY TO BE REMOVED.
7. FINALIZE PROCEDURE BY SECURELY TIGHTENING TOP HEX NUT.
8. REALIGN ROD BELLOWES AND SEAL RINGS TO HANGER ROD AND SEAL WELD AS SHOWN.

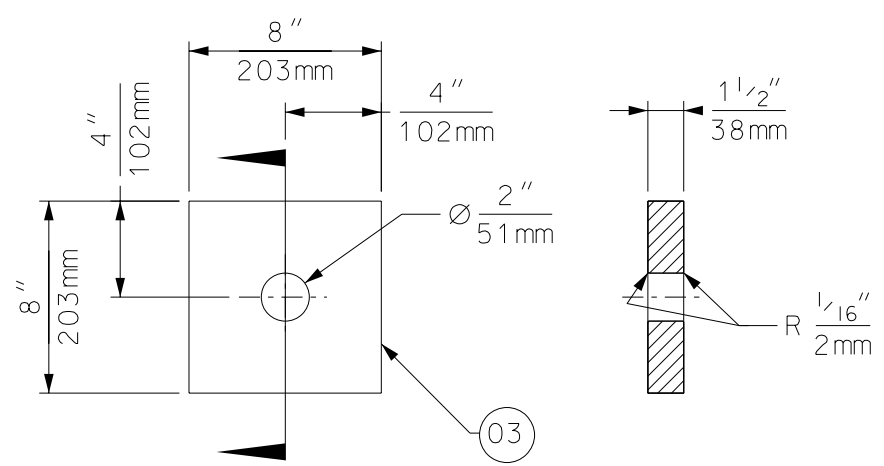


SUPPORT CHANNEL *

101	102
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SCALE: $\frac{3}{4}" = 1' - 0"$

REMOVE MODULE SUPPORTS BETWEEN
PIPE & BELOW BOTTOM LINER
(38) PLACES x (6) PLACES ACROSS.
(SEE NOTE 6).
REFER TO DETAIL 103 ON
V17494-ERND-0004 DRAWING



Technical drawing of a mechanical part showing front and side views with dimensions.

Front View Dimensions:

- Overall width: 8" (203mm)
- Overall height: 8" (203mm)
- Top flange width: 4" (102mm)
- Top flange thickness: 4" (102mm)
- Central hole diameter: $\varnothing 2\frac{1}{4}"$ (57mm)
- Surface texture symbol: 0.4

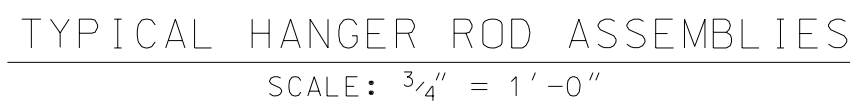
Side View Dimensions:

- Overall width: 1 3/4" (44mm)
- Radius: R 1/16" (2mm)

GAS FLOW



Diagram illustrating the removal of washers from the spring assembly. The assembly consists of a central spring (15 OR 16) mounted on a hanger rod (2) using heavy hex nuts. The diagram shows the removal of washers from the spring assembly (SEE NOTE 3).



MATERIAL LIST - ERECTION (BY VPI)

PART & ASSY NUMBERS ARE TO HAVE THE PREFIX OF "ER80".
FOR EXAMPLE, PART NUMBER "01" WOULD BE "ER8001",
ASSY NUMBER "201" WOULD BE "ER80201".

1. ALL WELDS IN ACCORDANCE WITH AWS D1.1
STRUCTURAL WELDING CODE.
2. ALL HOLES TO BE PUNCHED OR DRILLED.
3. SPRING ASSEMBLIES ARE PRELOADED: DO NOT
ADJUST OR REMOVE BOLTS/NUTS ON ASSEMBLIES
BEFORE OR AFTER INSTALLATION.
4. DIMENSION "A" EQUALS THE DISTANCE FROM THE
C_o OF COLUMN AT THE FRONT OF EACH MODULE BOX
TO THE C_o OF EACH HANGER ROD.
5. SEE DRAWING V17494-ERND-0080 FOR FIELD
INSTALLED /ADJUSTED BELLOWS & BOX PIPING (ER35).
6. REMOVE BOTTOM SUPPORTS ONLY AFTER ALL
INSTALLATION OF RODS, TOP PLATES, & MODULE
SPRINGS ON BACK TO BACK SUPPORT CHANNELS.
7. ALL WELDS ARE P1-P12, UNLESS NOTED OTHERWISE.
8. * SURFACE PREP & COATING TO BE PER PAINT
SYSTEM P1 & P2 ON V17494-EBNC-0001 PAINTING
SPECIFICATION.
9. QUANTITIES SHOWN ARE FOR (1) ONE UNIT:
-(1) ONE UNIT REQUIRED FOR MIDDLETOWN PROJECT.
-(1) ONE UNIT REQUIRED FOR KINGS MOUNTAIN
PROJECT.

V17494-ERND-0001 - FIELD CONNECTIONS - LOCATION MAP
V17494-ERND-0004 - FIELD CONNECTIONS - SHIPPING STEEL
REMOVAL
V17494-ERND-0080 - FIELD CONNECTIONS - FIELD INSTALLED
FIELD ADJUSTED BELLOWS & BOX PIPING

V17494-MAXD-5000 - MODULE SPRING ASSEMBLY HPSH3
V17494-MAXD-5001 - MODULE SPRING ASSEMBLY HPSH4

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for NTE ENERGY and GEMMA POWER SYSTEMS VOGT POWER PROJECTS V17494 & V17495	Scale: $\frac{3}{16}'' = 1'-0''$
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Internal Drawing Status	Size	Drawing No.	Rev.
FOR RECORD	D	V17494-ERND-0012	00