

HydroTex Dynamics, Inc.
6320 Cunningham Road
Houston, Texas 77041
713 937 9001



Verso Paper Holding LLC

Wisconsin Rapids

Wisconsin

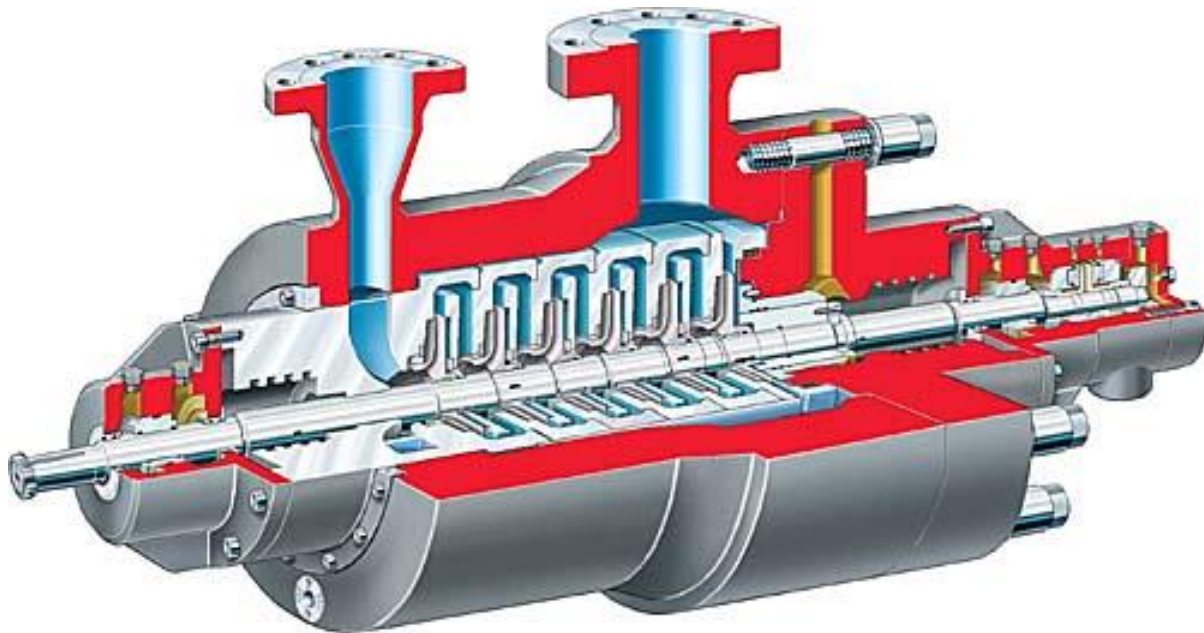
Pacific 8X 7Stage

New Boiler Feed Pump

HydroTex Job No. 17151

Purchase Order Number 4551394660

June 30, 2020



FINAL INSPECTION REPORT

July 7, 2020



**Verso Paper Holding LLC
700 Durabeauty Lane
Wisconsin Rapids
Wisconsin 54495**

Attention: Mr. Joe Hardina

**Subject: Pacific 8X 7 Stage
New Boiler Feed Pump
P.O. No. 4551394660
HydroTex Job No.17151**

Gentlemen:

The Verso supplied inner Boiler Feed Pump element assembly and (1) one Seal Housing was received at our Houston repair center with no apparent visible damage in transit with the order to facilitate these components into the construction of a new boiler feed pump to be built at HydroTex in Houston.

The attached Final Inspection Report shows overall engineering construction data, dimensional data, running clearances, NDT report and rotor dynamic balance results at the time of final assembly of the new boiler feed pump as well as a set of photographs recorded during the course of the pump manufacturing and assembly process.

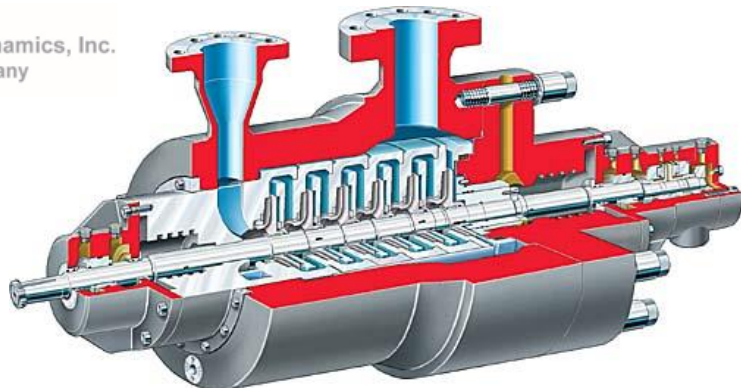
We sincerely appreciate this opportunity to be of service to you and your company and look forward to working with you on any future projects you might have. Should you have any questions, please let us know.

Respectfully submitted,
HydroTex DYNAMICS, INC.

Otto Halek

A handwritten signature in black ink, appearing to read "Otto Halek", written in a cursive style.

6320 Cunningham Road
Houston, Texas 77041
713 937 9001



Pump Assembly

Customer	Verrso paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/22/20

Measurements at Assembly	INBOARD	OUTBOARD
Radial Bearing Clearance	0.004	0.004
Bearing Housing to Brg. Sleeve Cl.	0.0015	0.0015
Oil Seal (Labyrinth) Clearance	0.011	0.011
Throat Bushing Clearance	0.030	0.030

Rotor Axial Clearance Float	0.433
Rotor Axial Clearance Thrust	0.014
Rotor Running Position	0.191" From IB END
Impeller Eye Radial Clearance	0.016 - 0.017
Impeller Hub Radial Clearance	0.017 - 0.018
Pressure Reducing Sleeve Radial Clearance	0.013

As Built

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/22/20

Radial Clearance

	0°	90 °
Thrust End	0.016	0.016
Coupling End	0.016	0.016

Axial Clearance

Stage No.	In Diffuser	With Cover	Center
1	0.515	0.433	0.242 From OB
2	0.523	0.523	0.250
3	0.593	0.593	0.320
4	0.598	0.598	0.325
5	0.605	0.605	0.332
6	0.605	0.605	0.332
7	N/A	0.605	0.332

Please Note: Position rotor at **0.191" +/- 0.005"** from Coupling End (IB) for optimum center of impellers to center of diffusers.

As Built

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/04/20

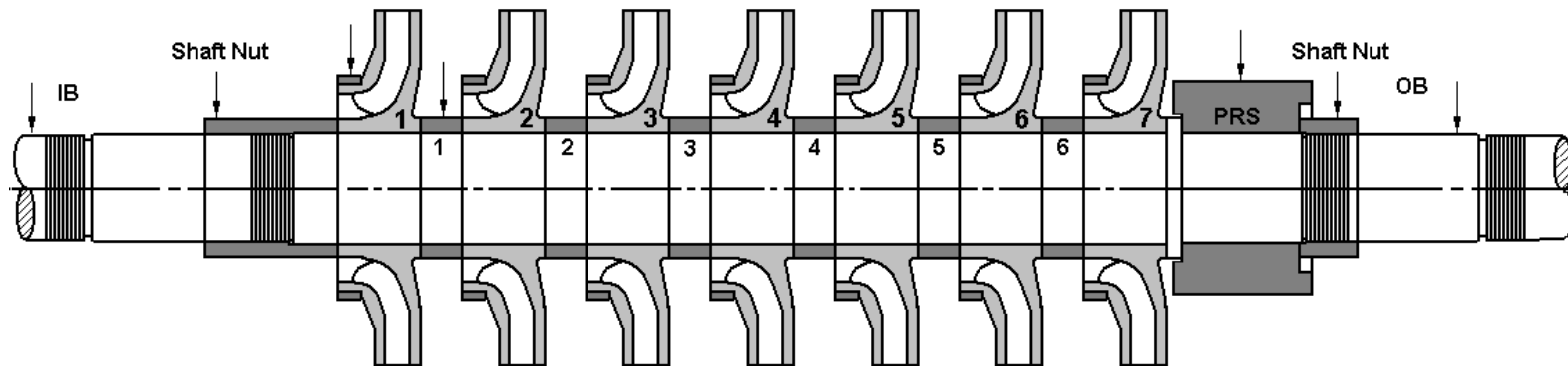
Running Clearances & Fits

Stg	Wear Ring ID	Imp. Eye OD	Clearance	Bushing ID	Spacer Sleeve OD	Clearance	Impeller ID	Shaft OD	Cl./Int.
1	9.1155	9.099	0.0165	4.251	4.233	0.018	3.629	3.6295	0.0005 I
2	8.351	8.334	0.017	4.2495	4.233	0.0165	3.635	3.635	0
3	8.350	8.334	0.016	4.251	4.233	0.018	3.6405	3.640	0.0005 C
4	8.350	8.334	0.016	4.250	4.233	0.017	3.645	3.645	0
5	8.349	8.334	0.015	4.250	4.233	0.017	3.651	3.650	0.001 C
6	8.3495	8.334	0.0155	4.2505	4.2335	0.017	3.655	3.655	0
7	8.3495	8.334	0.0155	7.750	PRS 7.737	0.013	3.660	3.660	0

As Built

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/02/20

Rotor Diameters & TIR

[illegible]

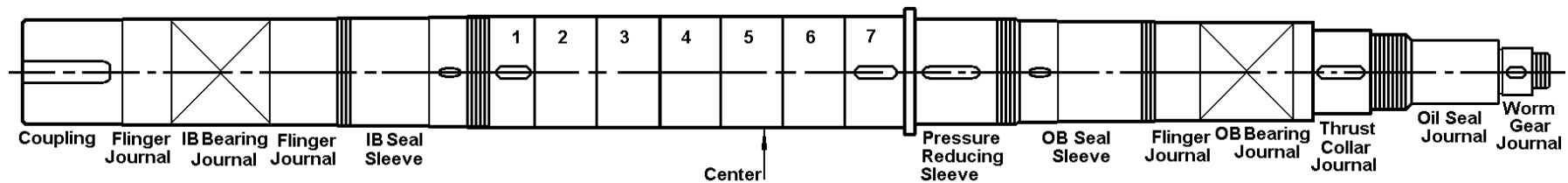


Hydro

As Built

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/04/20

Shaft Diameters & TIR

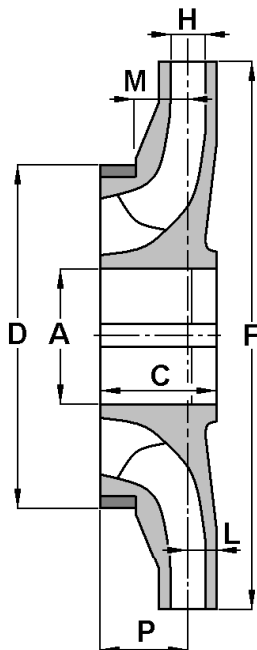


Journal	Coupling	Flinger Journal	IB Bearing	Flinger Journal	IB Seal Sleeve	Center	Pressure Red. Slv.	OB Seal Sleeve	Flinger Journal	OB Bearing	Thrust Collar	Oil Seal Journal	Worm Gear Journal
Diameter	3.3695	3.3745	3.375	3.3745	3.500	3.650	3.625	3.505	3.125	3.125	2.000	1.875	1.375
					3.505			3.500					
TIR	0	0	0	0	0.0005	0.0005	0.0005	0.0005	0	0	0	0	0
Impeller Fit	1	2	3	4	5	6	7						
Diameter	3.6295	3.635	3.640	3.645	3.650	3.655	3.66						
TIR	0.0005	0.0005	0.0005	0.0005	0.0005	0.0005	0.0005						

As Built

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/04/20

Impeller Dimensional Data

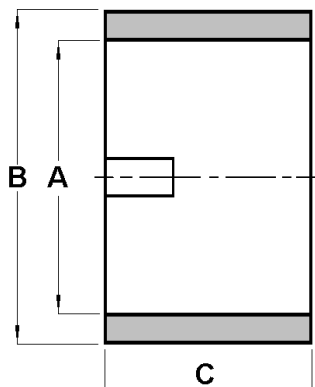


Stg	A	Shaft OD	Cl./Int.	C	D	F	H	L	M	P
1	3.629	3.6295	0.0005 I	3.117	9.099	13.010	1.037	0.760	1.107	2.316
2	3.635	3.635	0	3.104	8.334	12.937	0.988	0.757	0.907	2.297
3	3.6405	3.640	0.0005 C	3.105	8.334	13.005	0.994	0.732	0.909	2.305
4	3.645	3.645	0	3.119	8.334	13.002	0.992	0.759	0.920	2.306
5	3.651	3.650	0.001 C	3.118	8.334	13.008	1.018	0.756	0.980	2.292
6	3.655	3.655	0	3.115	8.334	13.005	1.014	0.761	0.991	2.299
7	3.660	3.660	0	3.124	8.334	13.010	1.022	0.761	0.989	2.302

As Built

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/20/20

Impeller Spacer Sleeves

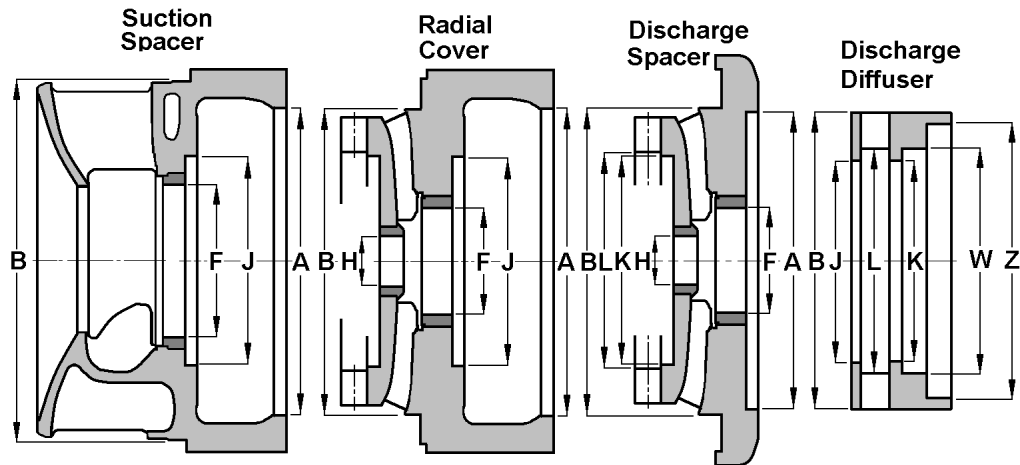


Stage	A	Shaft OD	Cl.	B	Bushing ID	Cl.	C
1	3.6305	3.6295	0.001	4.236	4.251	0.018	2.626
2	3.6355	3.635	0.0005	4.236	4.2495	0.0165	2.626
3	3.341	3.640	0.001	4.236	4.251	0.018	2.627
4	3.6455	3.645	0.0005	4.236	4.250	0.017	2.626
5	3.6515	3.650	0.0015	4.236	4.250	0.017	2.626
6	3.6555	3.655	0.0005	4.236	4.2505	0.017	2.626

As Built

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/20/20

Cover Diameters



Cover Sequence					Stage Sequence							
	A		B	Cl.		F	Imp.	H	Hub	J	K	L
	ID		OD	Int.		W.R. ID	Cl.	Bush. ID	Cl.	'A' Gap	'A' Gap	'B' Gap
1	18.642 18.6425	2	18..643 18.6435	0.0005 I 0.0015 I	1	9.1155	0.0165	4.251	0.018	13.074	13.068	13.150
2	18.6295 18.630	3	18.631 18.6315	0.001 I 0.002 I	2	8.351	0.017	4.2495	0.0165	13.088	13.065	13.200
3	18.628 18.630	4	18.631	0.001 I 0.003 I	3	8.350	0.016	4.251	0.018	13.092	13.065	13.200
4	18.6295 18.630	5	18.631 18.632	0.001 I 0.0025 I	4	8.350	0.016	4.250	0.017	13.075	13.067	13.182
5	18.634 18.635	6	18.632	0.002 I 0.003 I	5	8.349	0.015	4.250	0.017	13.070	13.035	13.220
6	18.629 18.630	7	18.626 18.627	0.002 I 0.004 I	6	8.3495	0.0155	4.2505	0.017	13.105	13.069	13.145
7	18.500 18.5005	D D	18.499	0.001 C 0.0015 C	7	8.3495	0.0155	----	----	N/A	N/A	N/A

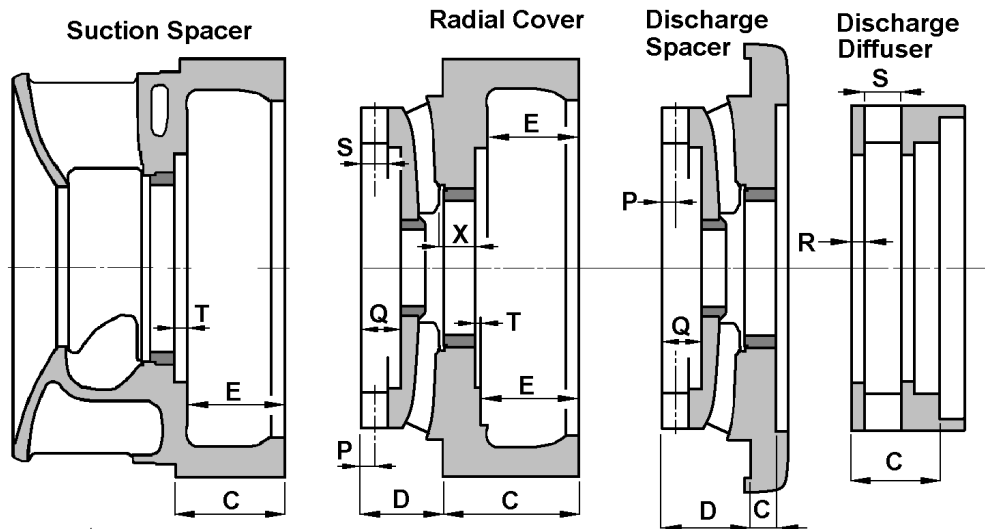
Case Fit	Discharge Diffuser	
B	W	Z
21.748	16.250	17.252



As Built

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/20/20

Cover Lengths

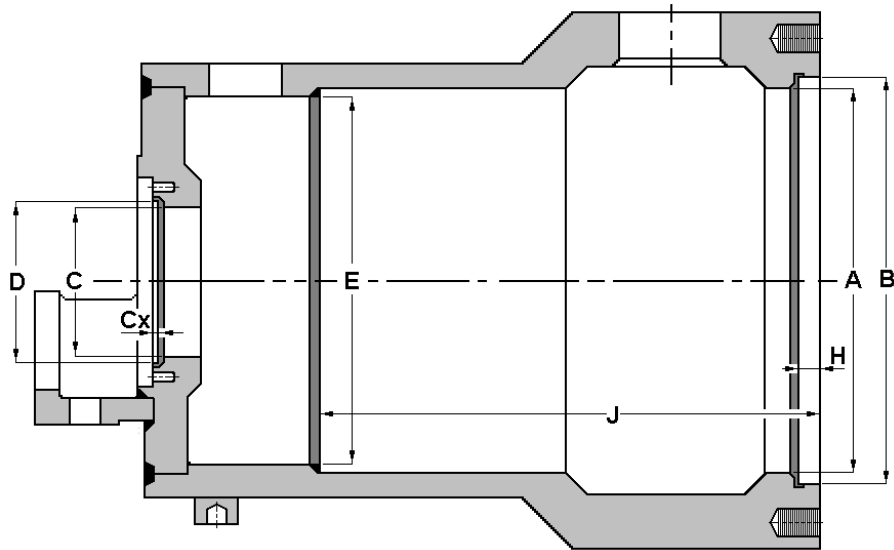


Stage Sequence								
	C	D	E	Cl.	P	Q	S	T
1	5.115	4.807	4.815	0.008	0.568	1.642	1.137	0.694
2	5.741	4.808	4.813	0.005	0.561	1.641	1.123	0.687
3	5.741	4.805	4.816	0.009	0.582	1.638	1.164	0.679
4	5.743	4.802	4.814	0.012	0.547	1.632	1.096	0.692
5	5.740	4.804	4.814	0.010	0.547	1.631	1.095	0.693
6	5.355	4.429	4.443	0.014	0.557	1.650	1.114	0.687
7	0.616	----	----	----	1.255	----	1.130	0
R 10	0.690							

As Built

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/20/20

Case

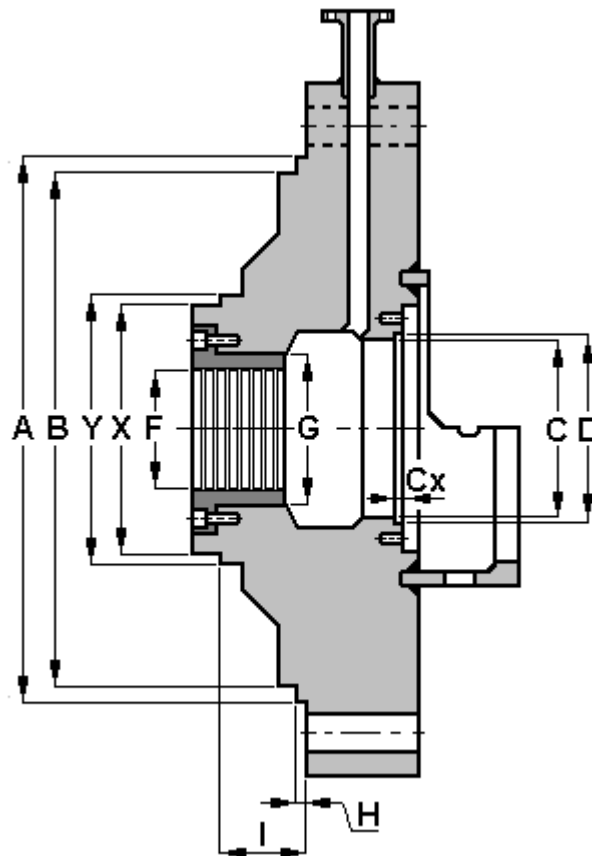


	A	B	C	Cx	D	E	H	J
Dia. Dim.	23.500	25.252	8.500	0.100	9.750	21.751	2.000	44.125

AsBuilt

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/20/20

Discharge Head

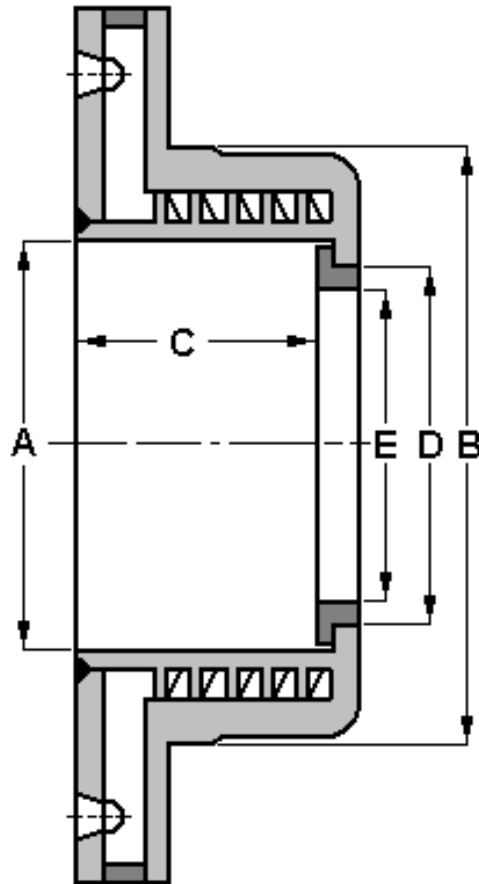


	A	B	C	Cx	D	F	G	H	I	X	Y
Dia Dim	25.249	23.496	8.500	0.100	9.750	7.750	9.125	1.875	6.125	16.248	17.250

As Built

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/20/20

Seal Housing/Packing Box

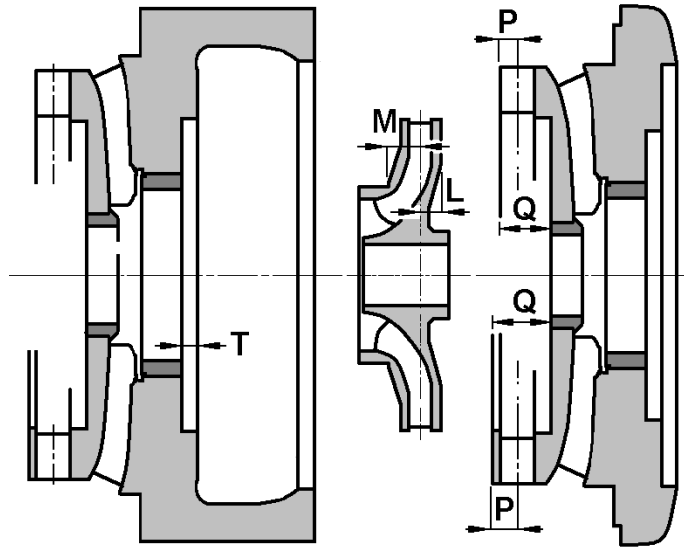


	A	B	C	D	E
	ID	OD	Depth	ID	OI
IB	5.500	8.4990	5.000	4.450	4.005
OB	5.500	8.4990	5.000	4.450	4.005

As Built

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/20/20

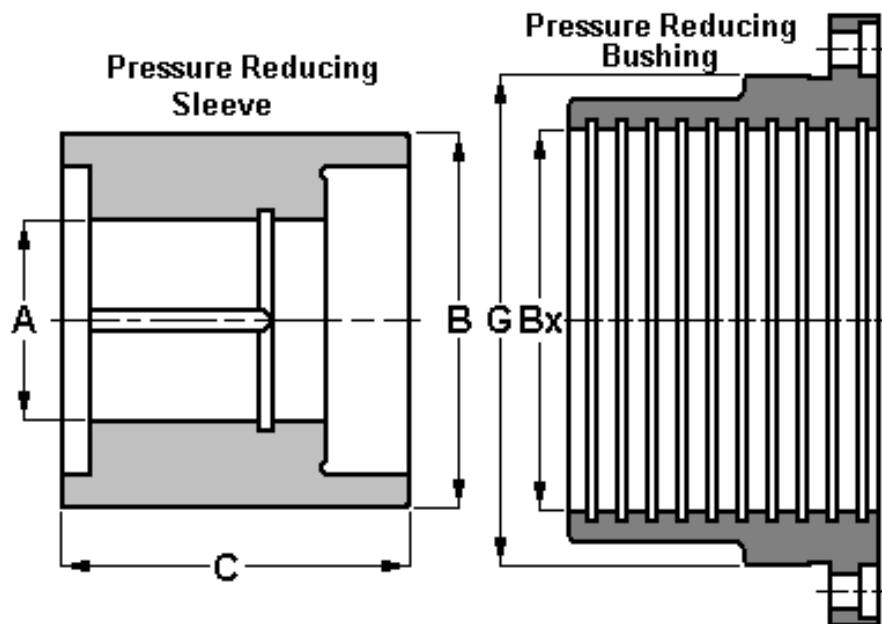
Impeller Axial Running Clearances



Stg	T	+P	-M	Front Axial Clearance	Q	-P	-L	Back Axial Clearance
1	0.694	0.568	1.107	0.155	1.642	0.568	0.760	0.314
2	0.687	0.561	0.907	0.341	1.641	0.561	0.757	0.323
3	0.679	0.582	0.909	0.352	1.638	0.582	0.732	0.324
4	0.692	0.547	0.920	0.319	1.632	0.547	0.759	0.326
5	0.693	0.547	0.980	0.260	1.631	0.547	0.756	0.328
6	0.687	0.557	0.991	0.253	1.650	0.557	0.761	0.332
7	0.616	1.255	0.989	0.266	----	N/A	----	----

As Built

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/20/20



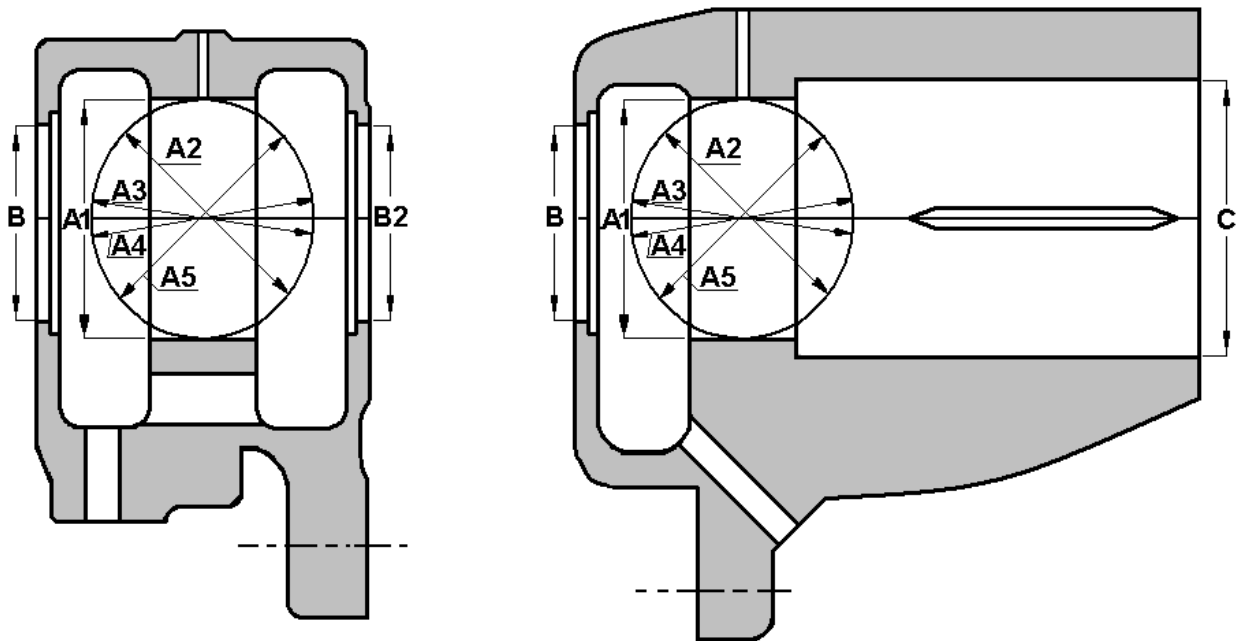
A	Shaft	Clearance	B	Bx	Clearance	C	G	Disch. Head	Clearance
ID	OD		OD	ID		Width	OD	ID	
3.6260	3.6250	0.001 C	7.737	7.750	0.013	7.00	9.124	9.125	0.001

Hardness Rc	
P R Sleeve	30.0
P R Bushing	42.2

As Built

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/20/20

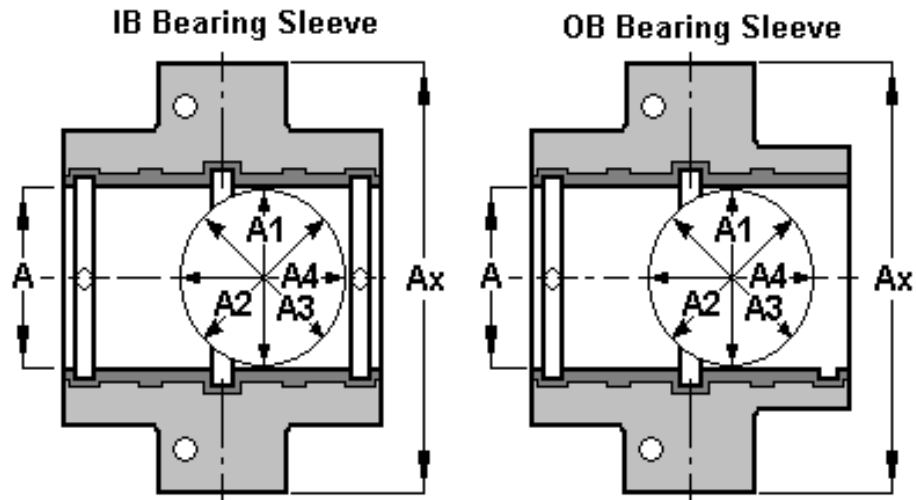
IB & OB Bearing Housing



Radial Bearing Housing	A1	A2	A3	A4	A5	B	B2	Split Line Gasket
	6.250	6.250	6.2505	6.2505	6.250	4.128	4.126	None
Thrust Bearing Housing	A1	A2	A3	A4	A5	B	C	Split Line Gasket
	6.2505	6.2505	6.250	6.250	6.2505	4.125	8.376	None

As Built

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/20/20

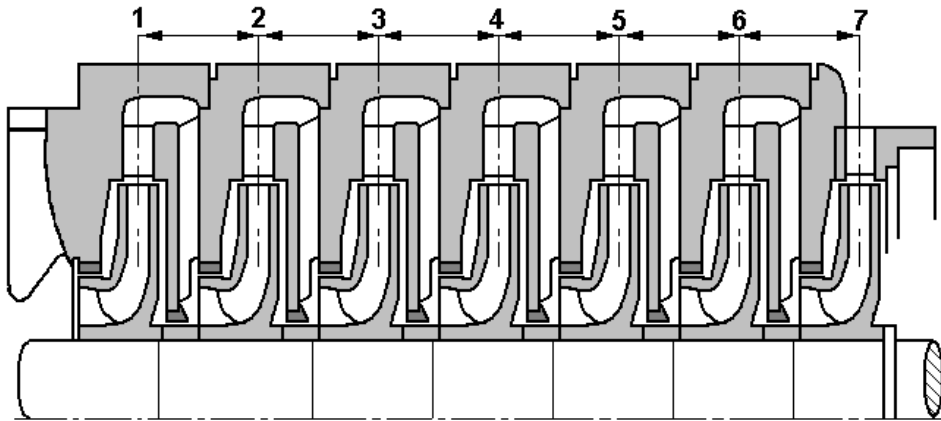


Inboard	A	A1	A2	A3	A4	Shaft OD	Clearance	Ax	Bearing Hsg. ID	Cl./Int.
IB Bearing Sleeve	3.381	3.3805	3.3805	3.381	3.3805	3.3750	0.004 0.0045	6.2495	6.2510	0.0015
Outboard	A	A1	A2	A3	A4	Shaft OD	Clearance	Ax	Bearing Hsg. ID	Cl./Int.
OB Bearing Sleeve	3.129	3.1295	3.1295	3.1290	3.1290	3.129	0.004 0.0045	6.249	6.2505	0.0015

As Built

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/20/20

Diffuser to Diffuser Center Spacing Calculation

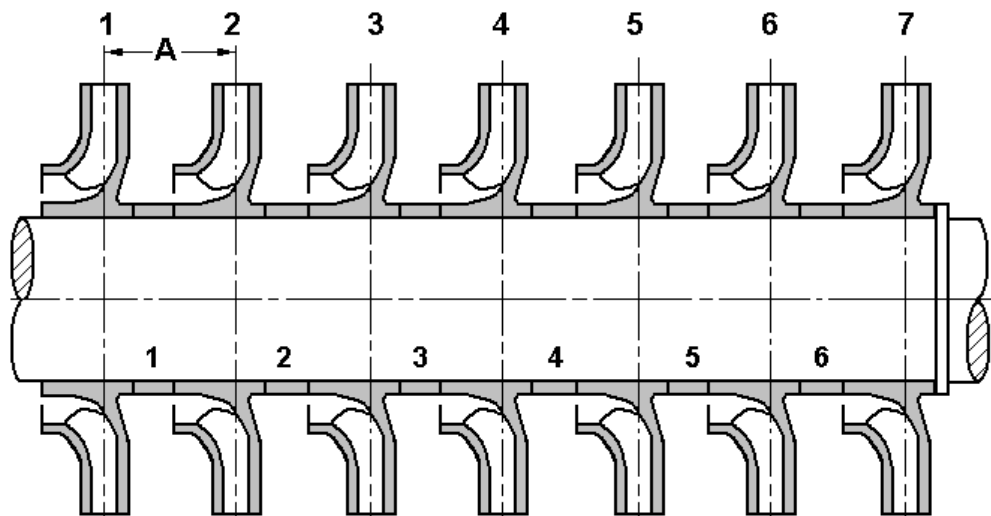


1- 2	$D1-P1+C2-D2+P2=$	$4.807-0.568+5.741-4.808+0.561=5.733$
2- 3	$D2-P2+C3-D3+P3=$	$4.808-0.561+5.741-4.805+0.582=5.765$
3- 4	$D3-P3+C4-D4+P4=$	$4.805-0.582+5.743-4.802+0.548=5.712$
4- 5	$D4-P4+C5-D5+P5=$	$4.802-0.548+5.740-4.804+0.547=5.737$
5- 6	$D5-P5+C6-D6+P6=$	$4.804-0.547+5.355-4.429+0.557=5.740$
6- 7	$D6-P6+C7+P7=$	$4.429-0.557+0.616+1.255=5.743$

As Built

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/20/20

Impeller Spacing



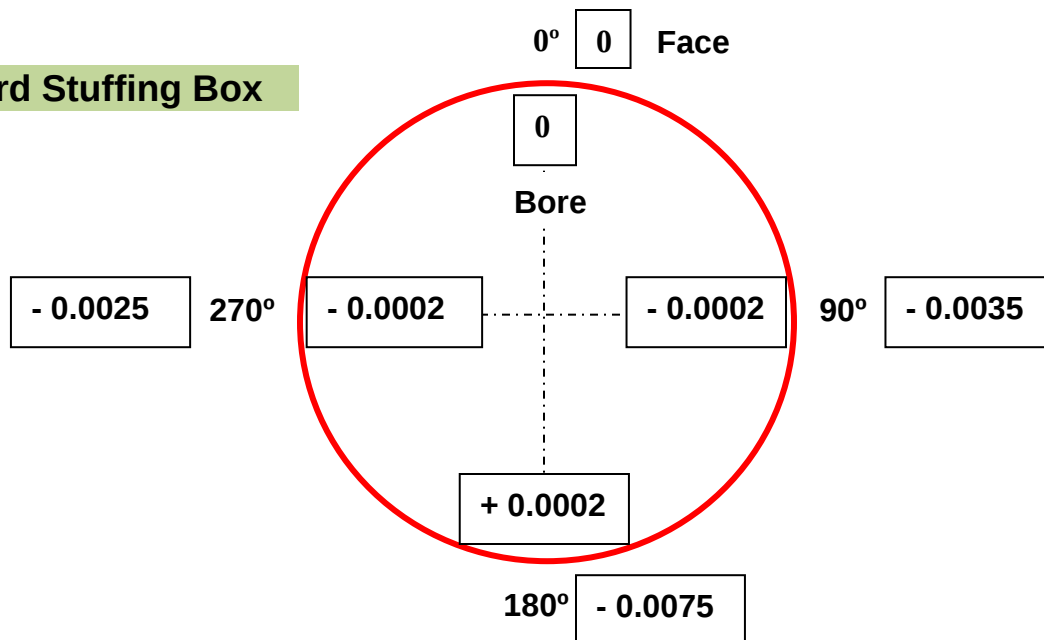
	1-2	2-3	3-4	4-5	5-6	6-7
'A' Impeller With Spacer Sleeves	5.724	5.738	5.733	5.731	5.752	5.744
Discharge Diffuser Centers	5.733	5.765	5.712	5.737	5.740	5.743

As Built

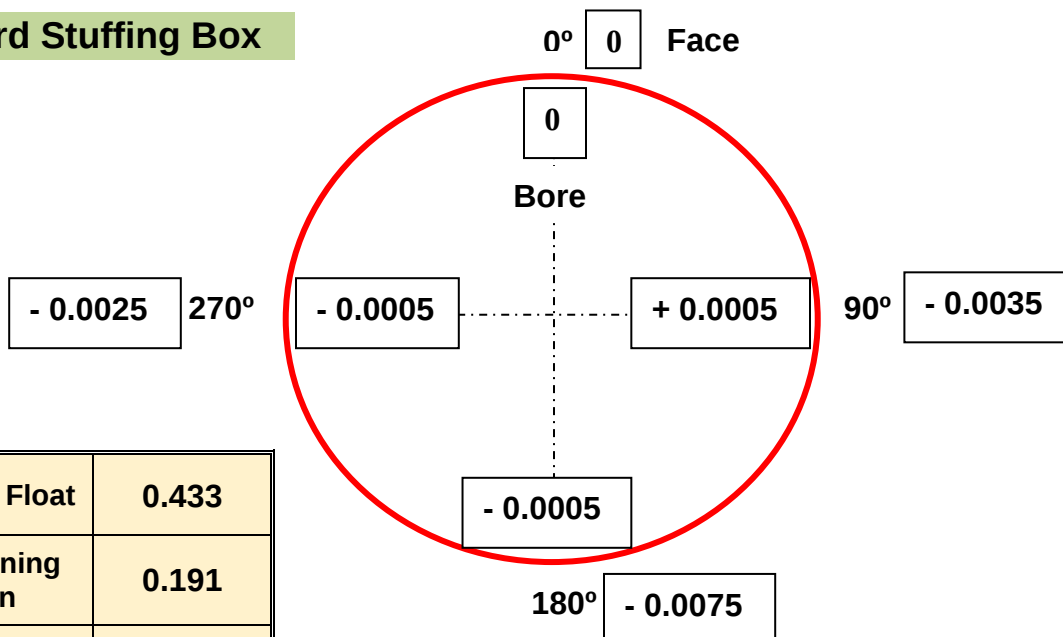
Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/22/20

Stuffing Box Alignment Readings

Inboard Stuffing Box

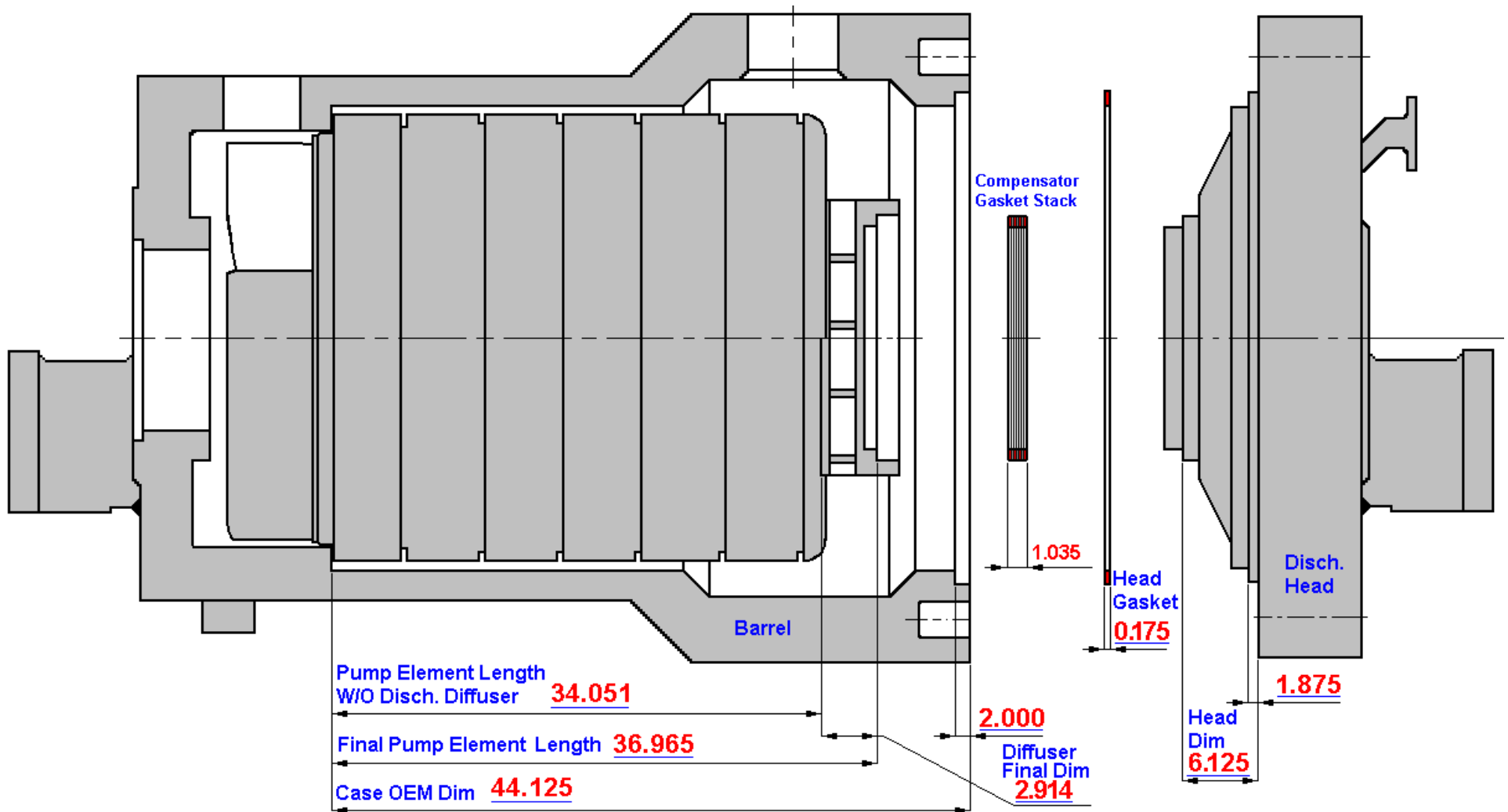


Outboard Stuffing Box



Rotor Total Float	0.433
Rotor Running Position	0.191
Total Thrust	0.014

Pump Element Length Dimensional Data



Customer: **Verso Paper**

Job No.: **17151**

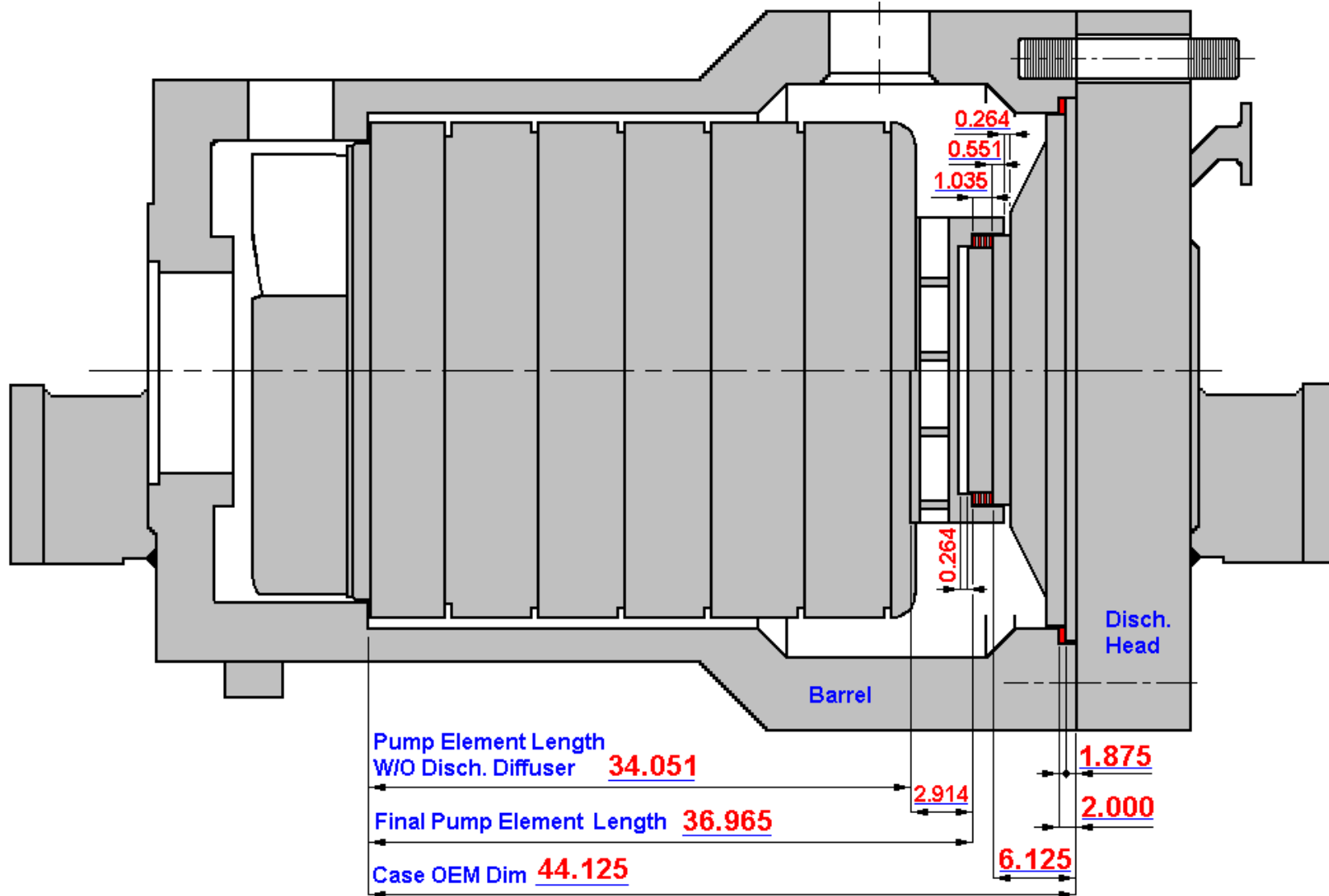
Model:
Pacific 8X 7Stg.



HydroTex
DYNAMICS, INC.

Date:
06/20/20

Pump Assembly Dimensional Data



Customer: Verso Paper

Job No.: 17151

Model:
Pacific 8X 7Stg.



HydroTex
DYNAMICS, INC.

Date:
06/20/20

As Received/As Built

Customer	Verso Paper	P.O. Number	4551394660
Pump Mfr.	Pacific	Job Number	17151
Model	8X 7Stg.	Date	06/20/20

Hardness Readings (Rc)

Stage	Impeller Eye Wear Ring	Cover Wear Ring	Impeller Spacer Sleeve	Cover Bushing
1	30.5	43.0	20.1	41.2
2	30.3	42.5	20.0	41.6
3	30.5	42.0	20.3	41.4
4	30.2	42.8	20.0	41.2
5	29.8	42.3	20.3	41.2
6	30.5	42.0	20.0	41.4
7	29.6	41.0	22.4	

T-N-T TURBO NON-DESTRUCTIVE TESTING INC.**INVOICE / TEST REPORT**Business / Cell **713.263.4303**

Mailing Address:

P.O. Box 56

Kemah, Texas 77565

Fax 713.433.2365

Physical Address:

25 Southbelt Industrial Dr. "B"

Houston, Texas 77047

www.turbondt.com

N°

60805

DATE 4/30/20

**BILL
TO**HYDROTEX DYNAMICS
6320 CUNNINGHAM DRIVE
HOUSTON, TEXAS 77041
ATTN: ACCOUNTS PAYABLE**END
CUSTOMER**

P.O. #	JOB #	EQUIP.-MFG.	EQUIP.-MODEL	EQUIP.-S/N#	UNIT #:	DATE RECEIVED	DATE COMPLETED
24251	17151	PACIFIC	8S			4-30-20	SAME

QUANTITY	PART # / ITEM #	PART, MATERIAL OR ITEM DESCRIPTION	TOTAL COST
1		BARREL CASE	

NDE METHOD**METHOD PROCESS FORM INCLUDED** ☐**TERMS: NET 30**

[MT - MAGNETIC PARTICLE]

[PT - PENETRANT]

[UT - ULTRASONIC]

[OTHER]

MAGNAGLO - WET CONTINUOUS ☐FLUORESCENT ZYGLO ☐STRAIGHT BEAM ☐HARDNESS ☐MAGNAFLUX - DRY CONTINUOUS ☐VISIBLE RED DYE ☐ANGLE BEAM ☐CRACK DEPTH ☐DEMAGNETIZE ☐

SPECIFICATION: MT PER ASME - ASTM E709 -2015 / DC WET FLUORESCENT CONTINUOUS METHOD

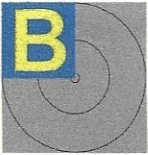
TEST RESULTS:

THERE WERE NO MAGNAGLO INDICATIONS OF RELEVANT DISCONTINUITIES PRESENT IN THE ACCESSIBLE SURFACES OF THE CASE. THE CASE WAS DEMAGNETIZED TO TWO GAUSS OR LESS AFTER INSPECTION.

CUSTOMER REPRESENTATIVE

SCOTT THOMPSON LEV II #3

INSPECTOR SIGNATURE



DYNAMIC BALANING TEST CERTIFICATE

BalanceMaster EasyBalance 2.2, Date: 2020-05-04, Time: 16:47

Machine name: BalanceMaster

HydroTex Dynamics

6320 Cunningham Road

Houston, TX 77041

Phone: 713-937-9001

Fax:

HT 17151

No Key compensation

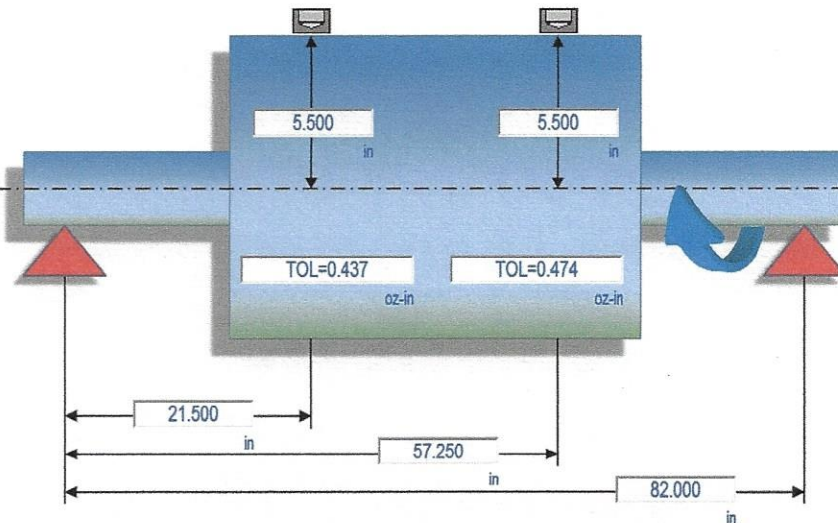
No Tooling Compensation

Balancing Quality Standard:

API 610, 4W/n

Rotor mass Left:

290.000 lb



Service speed:

3600 RPM

Rotor mass Right:

320.000 lb

INITIAL RESULT:

474 RPM

Correction mass:

Unbalance:

Reject (6.75 x Tol)

Left

- 0.5361 oz at 218°

2.948 oz-in

Reject (3.92 x Tol)

Right

- 0.3384 oz at 151°

1.861 oz-in

CURRENT RESULT:

642 RPM

Correction mass:

Unbalance:

OK (0.11 x Tol)

Left

- 0.0089 oz at 62°

0.049 oz-in

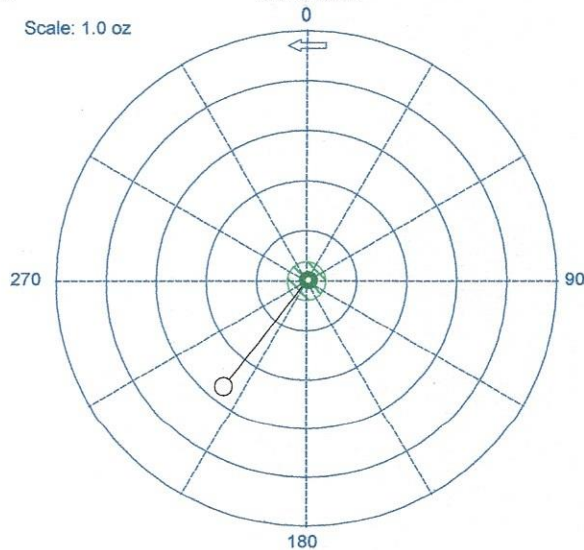
OK (0.10 x Tol)

Right

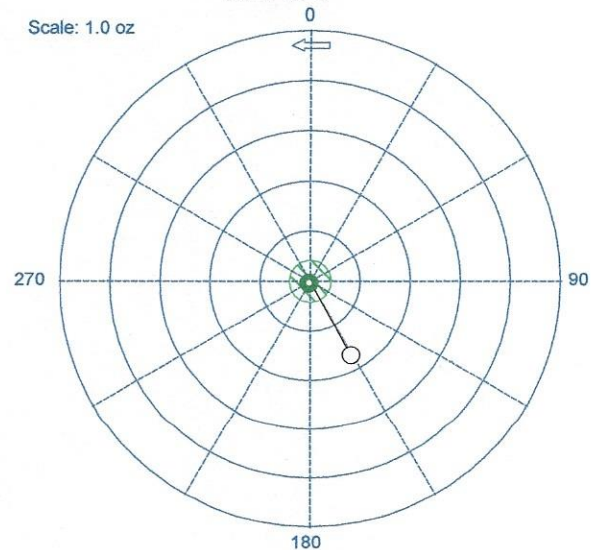
- 0.0088 oz at 215°

0.049 oz-in

Scale: 1.0 oz



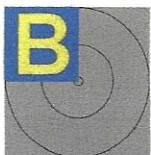
Scale: 1.0 oz



Operator: HYDRO

Test Certificate

Software version: 9.12.0.11



DYNAMIC BALANING TEST CERTIFICATE

BalanceMaster EasyBalance 2.2, Date: 2020-05-04, Time: 16:47

Machine name: BalanceMaster

HydroTex Dynamics

6320 Cunningham Road

Houston, TX 77041

Phone: 713-937-9001

Fax:

HT 17151

No Key compensation

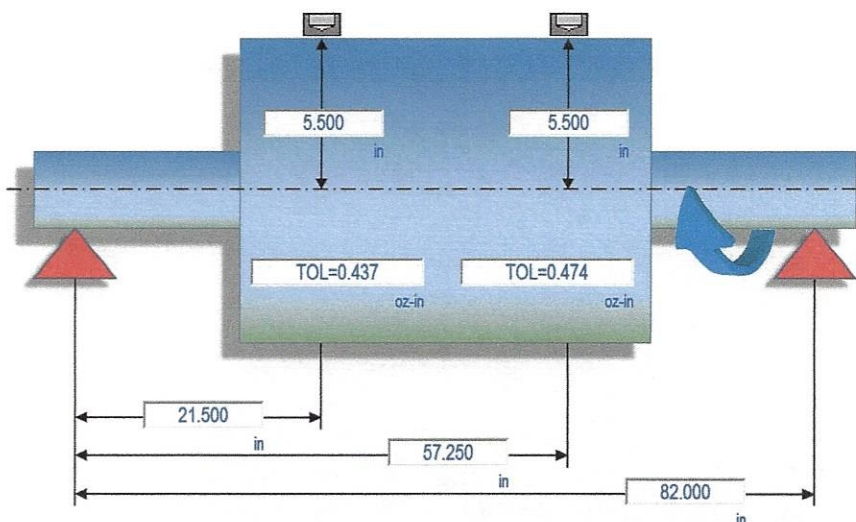
No Tooling Compensation

Balancing Quality Standard:

API 610, 4W/n

Rotor mass Left:

290.000 lb



Service speed:

3600 RPM

Rotor mass Right:

320.000 lb

INITIAL RESULT:

474 RPM

Correction mass:

Unbalance:

Reject (3.22 x Tol)

COUPLE Left

- 0.2554 oz at 255°

1.405 oz-in

Reject (6.92 x Tol)

STATIC

- 0.8531 oz at 193°

4.692 oz-in

Reject (2.96 x Tol)

COUPLE Right

- 0.2554 oz at 75°

1.405 oz-in

CURRENT RESULT:

642 RPM

Correction mass:

Unbalance:

OK (0.11 x Tol)

COUPLE Left

- 0.0086 oz at 49°

0.048 oz-in

OK (0.03 x Tol)

STATIC

- 0.0040 oz at 137°

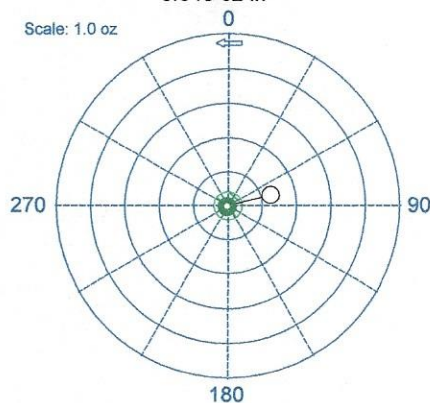
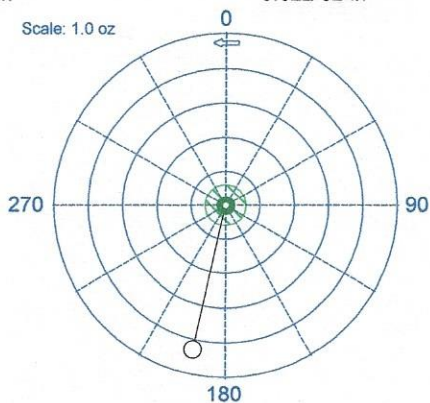
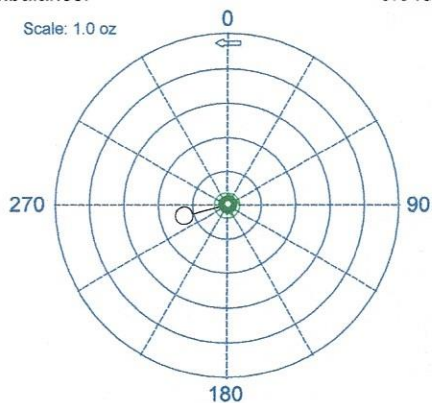
0.022 oz-in

OK (0.10 x Tol)

COUPLE Right

- 0.0086 oz at 229°

0.048 oz-in



Operator: HYDRO

Test Certificate

Software version: 9.12.0.11

BARREL FORGING AS RECIEVED



BARREL FORGING AS RECEIVED



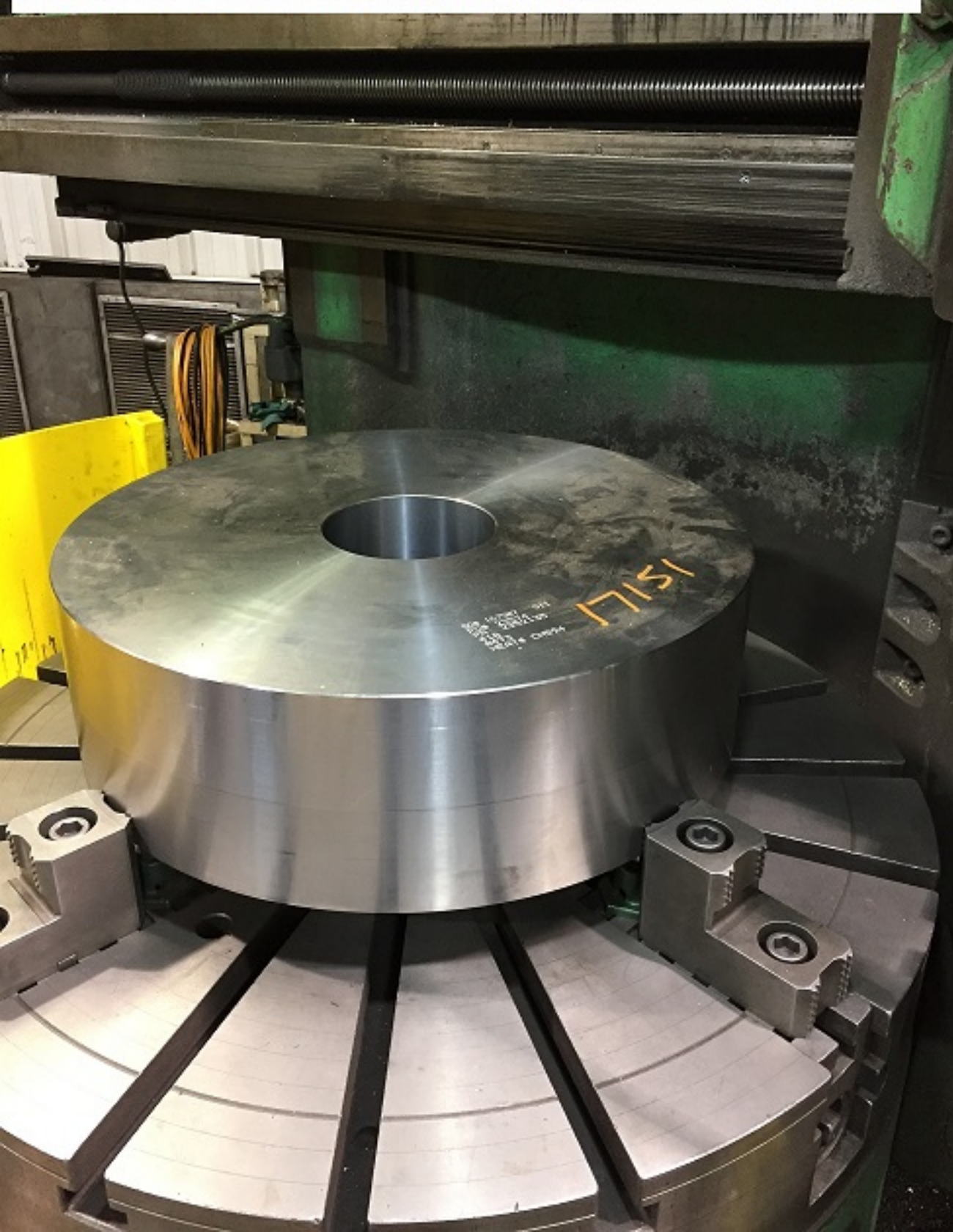
BARREL FORGING AS RECEIVED



BARREL SUCTION COVER AND DISCHARGE HEAD FLANGE MATERIAL



MACHINING THE DIFFUSER SPACER FORGING - DISCHARGE HEAD



FINISH MACHINING THE DISCHARGE HEAD



WELDING THE DRIP POCKET INTO THE DISCHARGE HEAD



DISCHARGE HEAD AFTER WELDING



WELDING DRIP POCKET INTO BARREL SUCTION END COVER



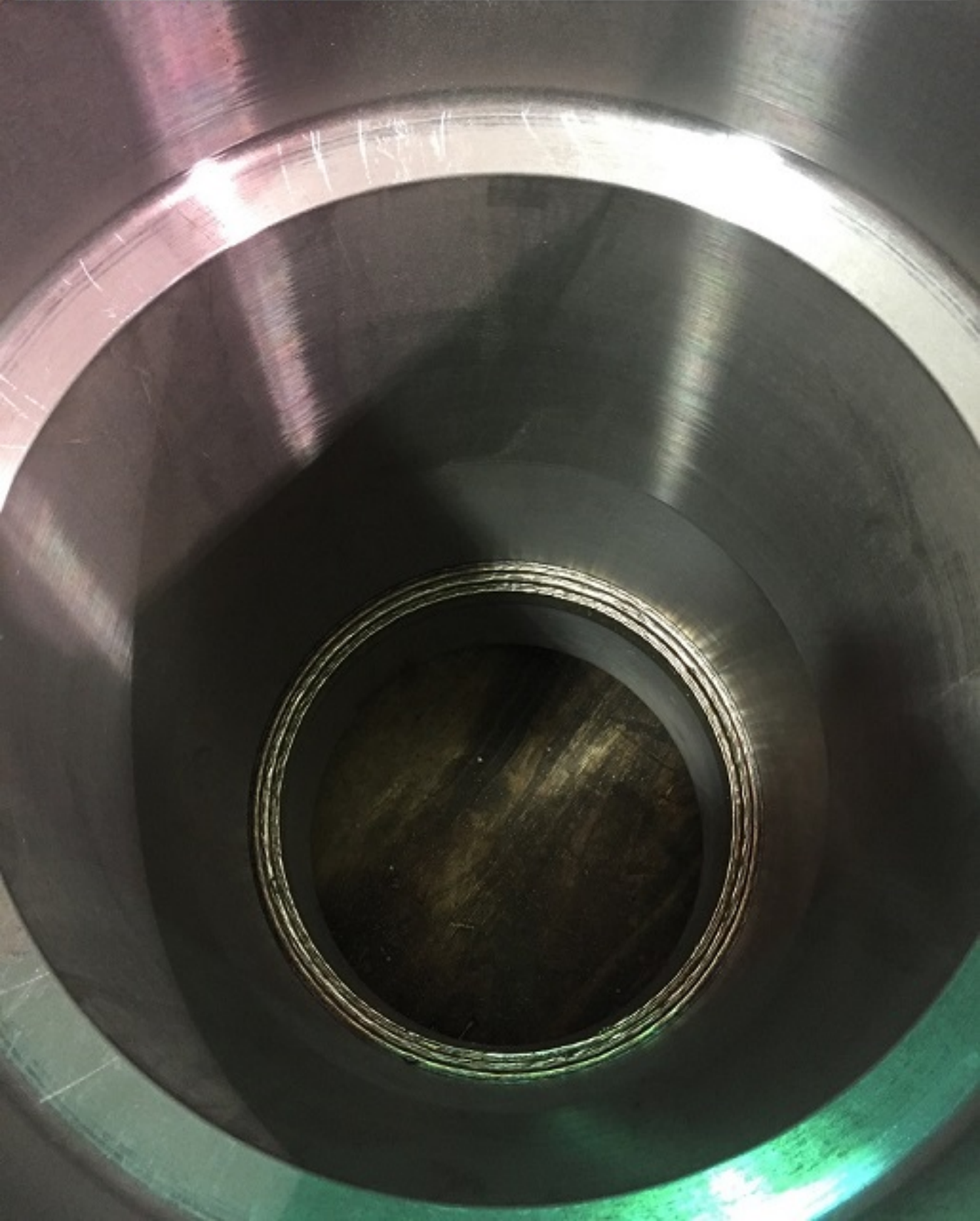
DISCHARGE HEAD DRIP POCKET PRIOR TO INSTALLATION



DISCHARGE HEAD AFTER WELDING DIFFUSER SPACER



**BARREL LP SEAL FACE AND REGISTER FIT AFTER WELDING
THE 309-L OVERLAY**



WELDING THE 309-L OVERLAY INTO THE BARREL



WELDING IN THE SUCTION END COVER OF THE BARREL



MACHINING THE SUCTION NOZZLE HOLE INTO THE BARREL



SUCTION NOZZLE PREP OF THE BARREL



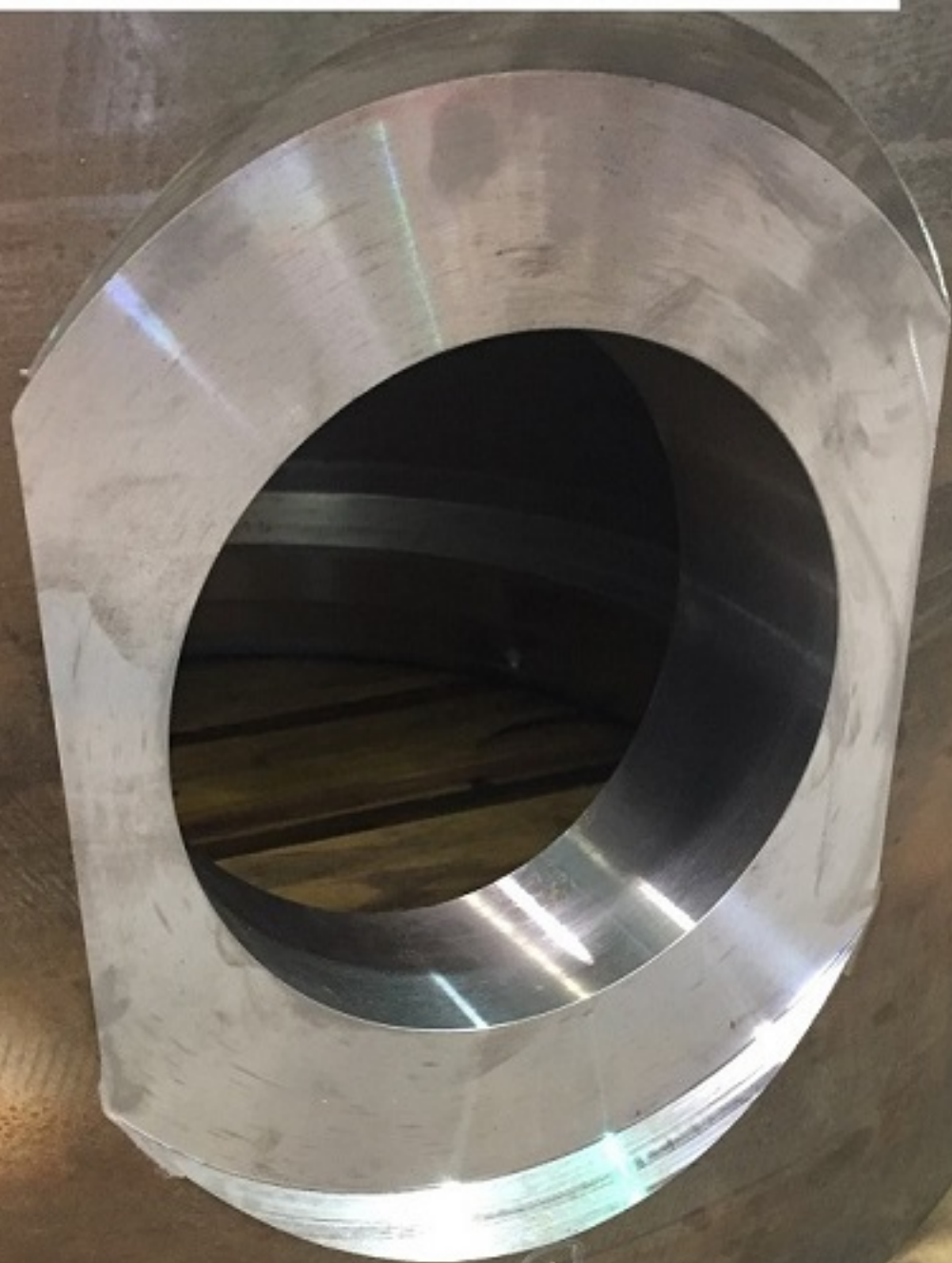
MILLING DISCHARGE NOZZLE PREP ON THE BARREL



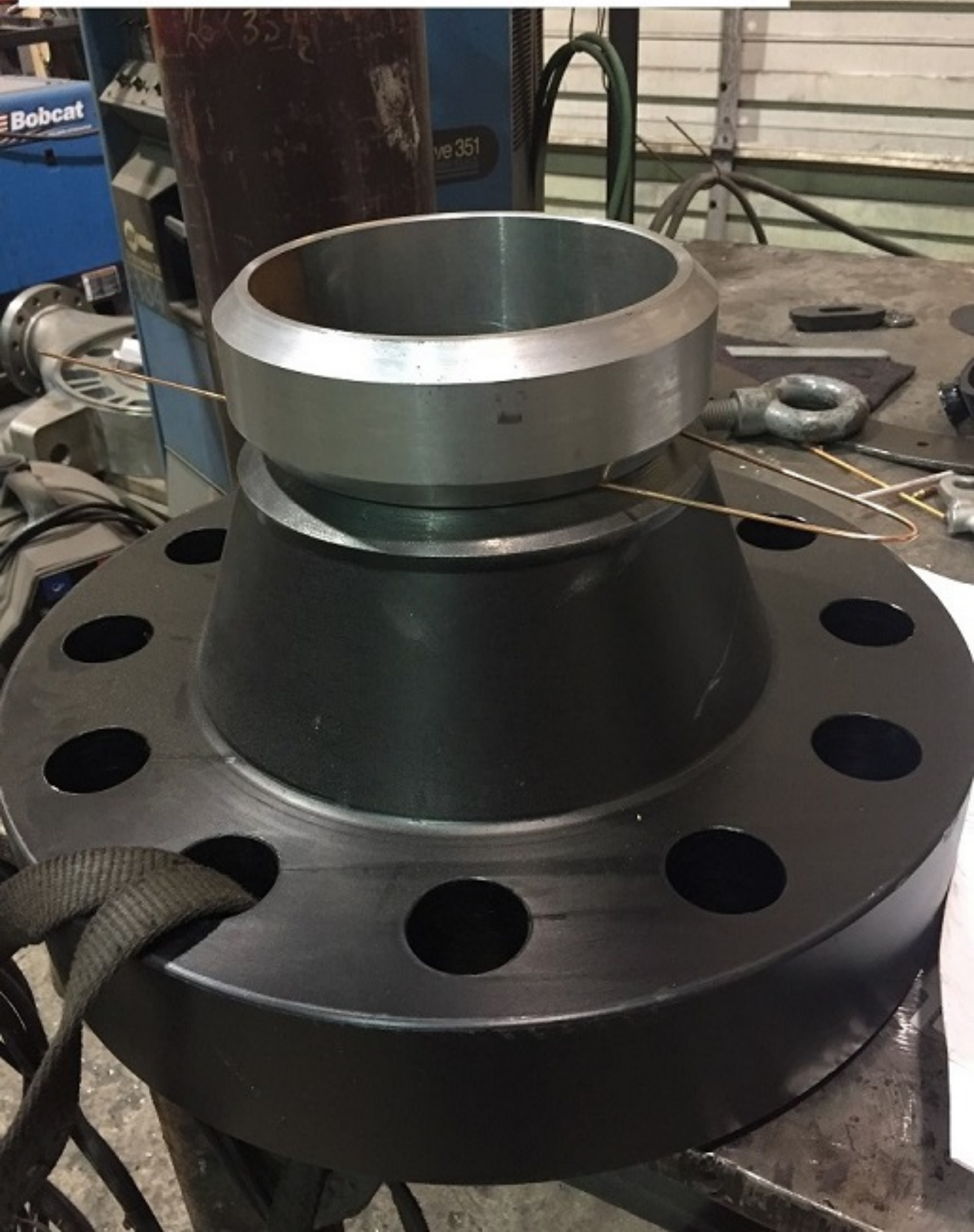
SUCTION NOZZEL AS FABRICATED



DISCHARGE NOZZLE PREP OF THE BARREL



PREPARING TO WELD THE DISCHARGE NOZZLE



BARREL AS WELDED PRIOR TO STRESS RELIEVE



DISCHARGE NOZZLE AFTER WELDING



WELDING THE FEET ON TO THE BARREL



WELDING IN THE SUCTION END COVER



BARREL AS WELDED PRIOR TO STRESS RELIEVE



MACHINING THE BARREL INSIDE DIAMETERS



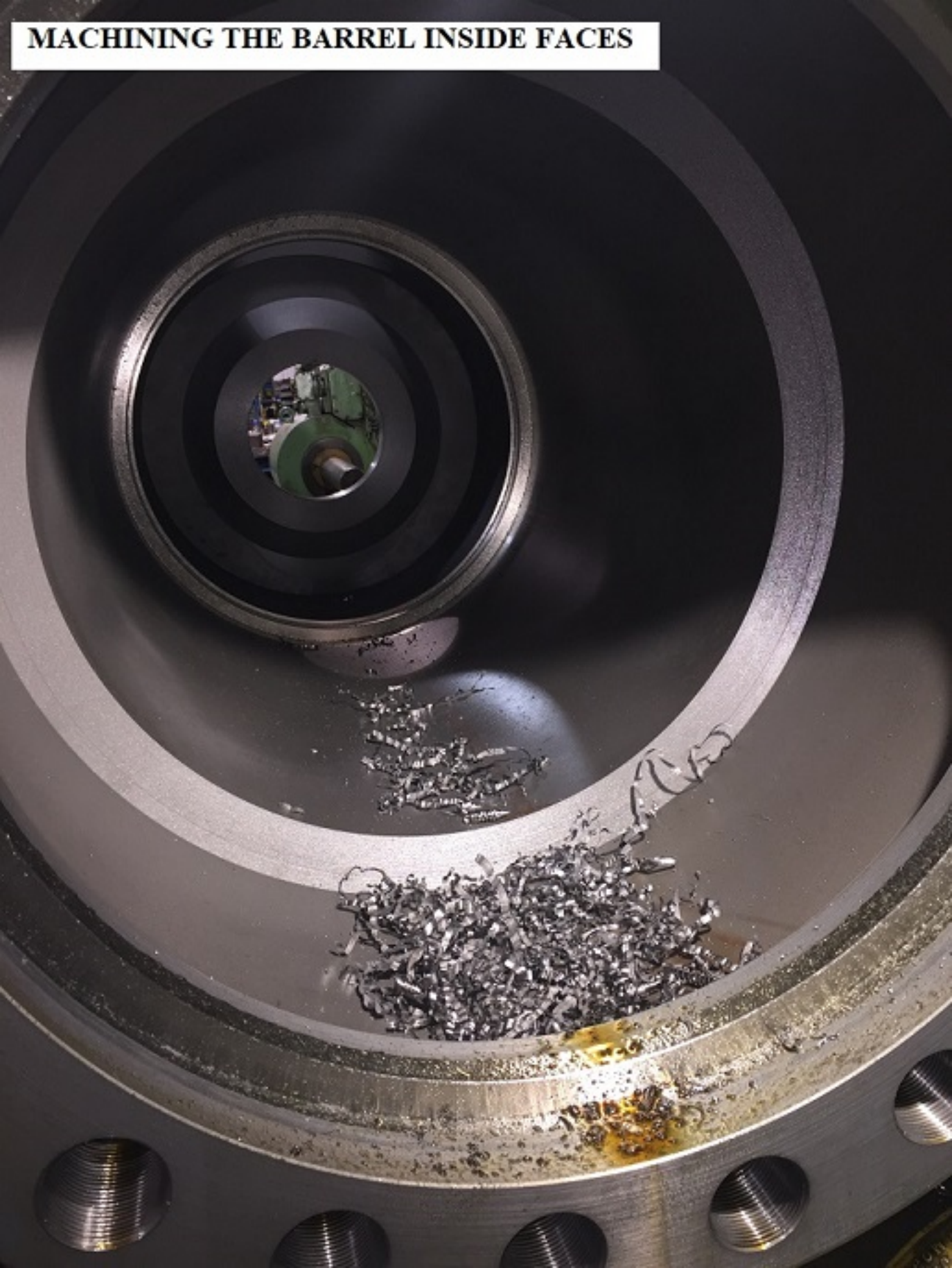
MACHINING THE BARREL INSIDE DIAMETERS



MILLING THE BARREL FEET



MACHINING THE BARREL INSIDE FACES



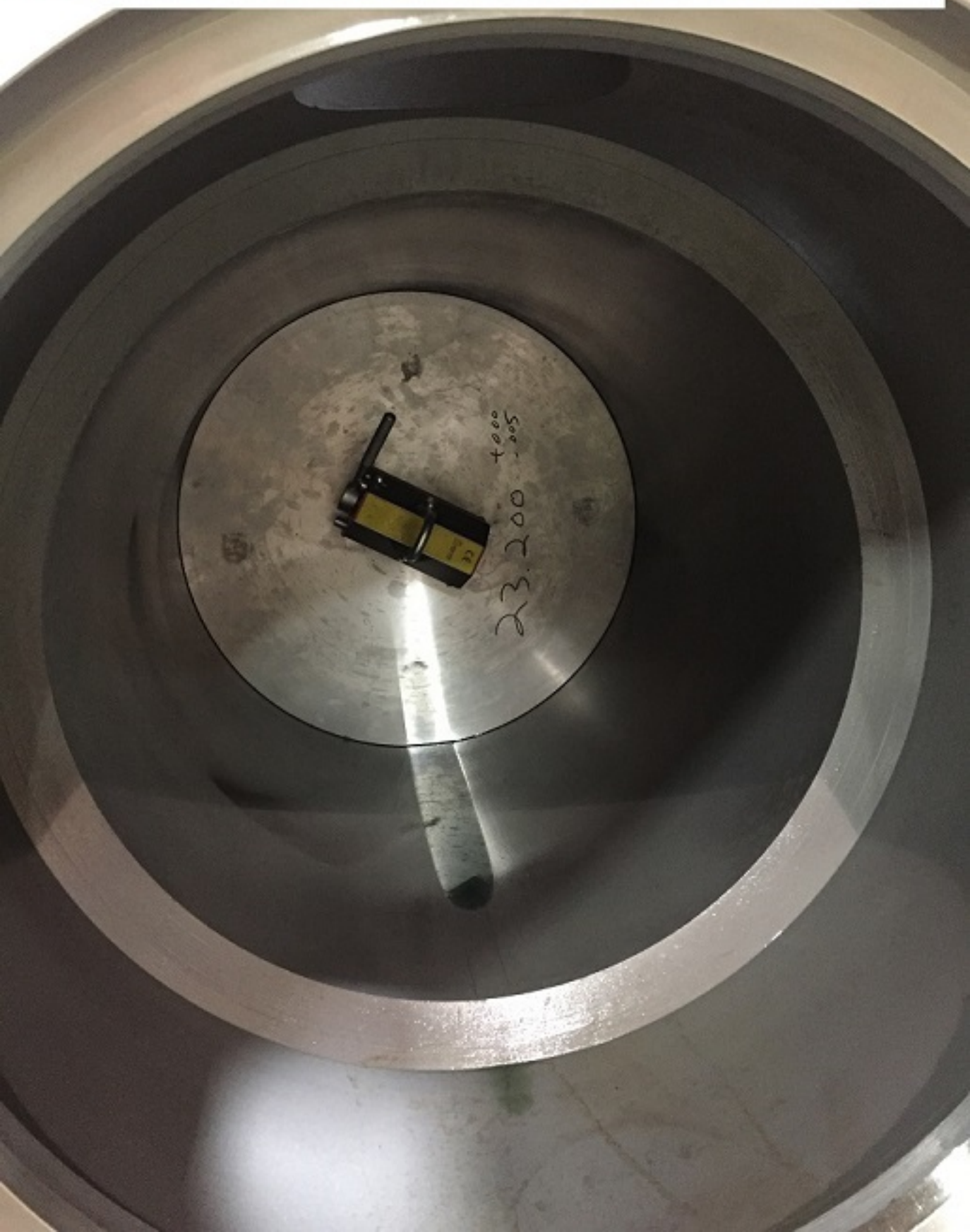
DISCHARGE HEAD STUD HOLE AFTER DRILL AND TAP



DRILLING AND TAPPING DISCHARGE HEAD STUD HOLES



HYDRO PLATE ISOLATING THE HP AND LP BARREL AREAS



HYDRO PLATE SEALING THE BARREL SUCTION END



BARREL HYDRO, 3300 PSI HP, 675 PSI LP



BARREL HYDRO, 3300 PSI HP, 675 PSI LP



THRUST BRG HOUSING END COVER AFTER FABRICATION



DISCHARGE DIFFUSER PRIOR TO WELDING THE PLATE



DISCHARGE DIFFUSER PRIOR TO WELDING



DISCHARGE DIFFUSER AFTER WELDING



PACKING HOUSING AFTER WELDING THE INSERT



ROTOR ASSEMBLY DYNAMIC BALANCING



**SETTING UP
FOR THE PUMP
ELEMENT
REASSEMBLY**



FINAL ELEMENT ASSEMBLY





**MONITORING ROTOR
& IMPELLER RUNNING
POSITION AT THE
PUMP ELEMENT
REASSEMBLY**



SETTING UP FOR FINAL ROTOR HORIZONTAL LIFT CHECKS

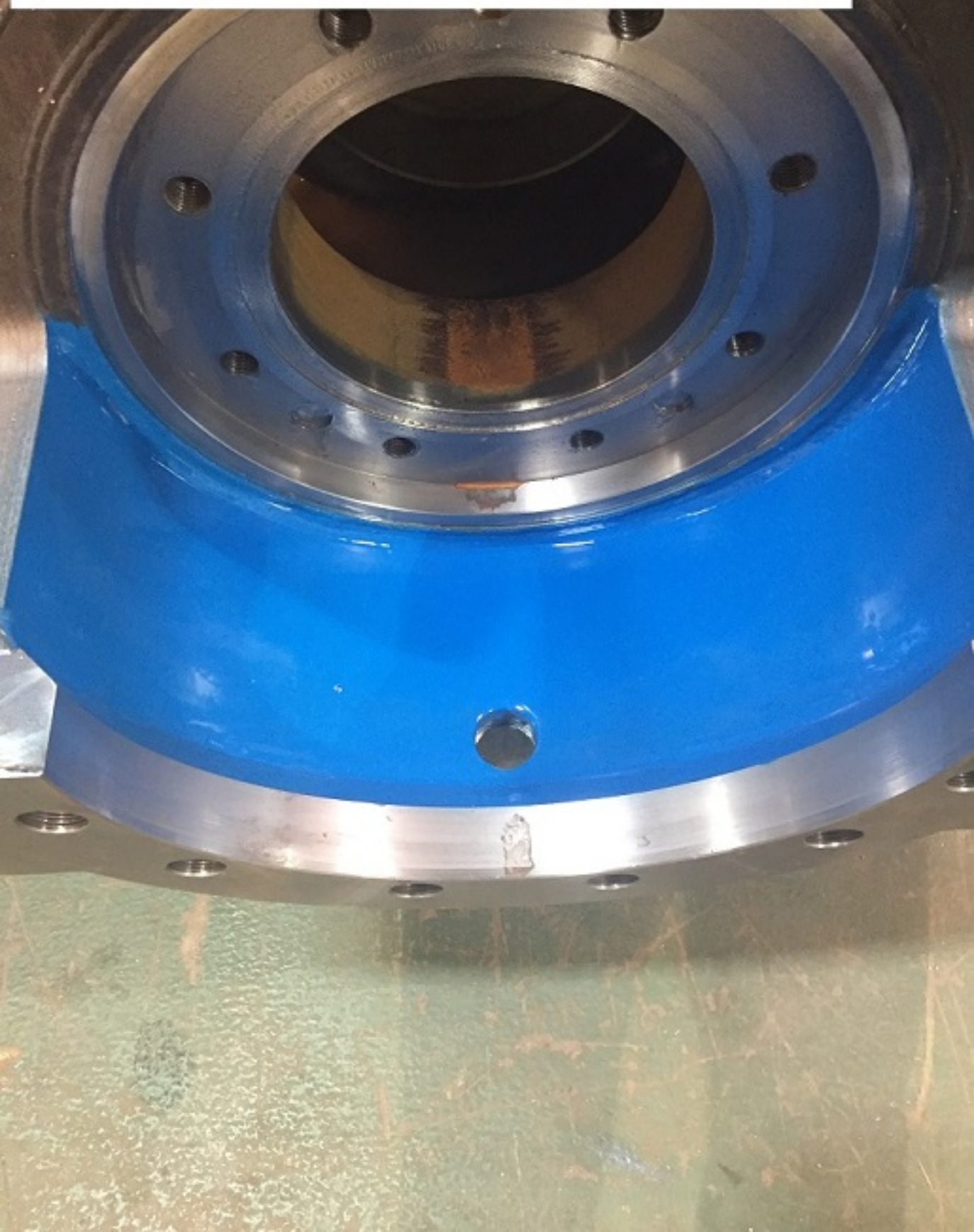


**FINAL ROTOR LIFT
CHECK INSPECTION
AT COUPLING END**

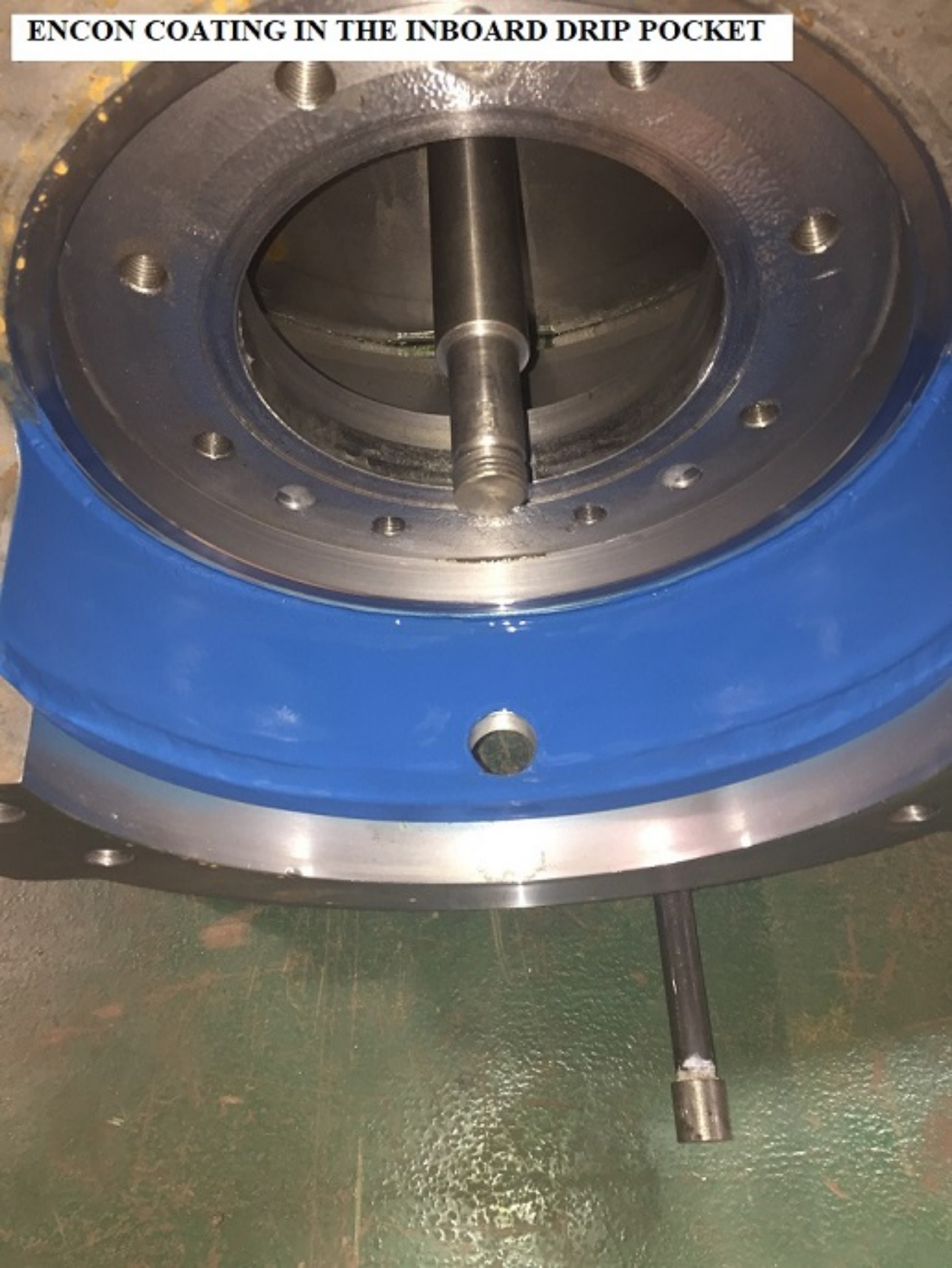


**FINAL ROTOR LIFT CECK
INSPECTION AT THRUST END**

ENCON COATING IN THE OUTBOARD DRIP POCKET



ENCON COATING IN THE INBOARD DRIP POCKET



**ROTOR RADIAL ALIGNMENT
INSPECTION AFTER
ELEMENT INSTALLED**



PUMP ASSEMBLY PREPPED FOR SHIPMENT



PUMP ASSEMBLY PREPPED FOR SHIPMENT

