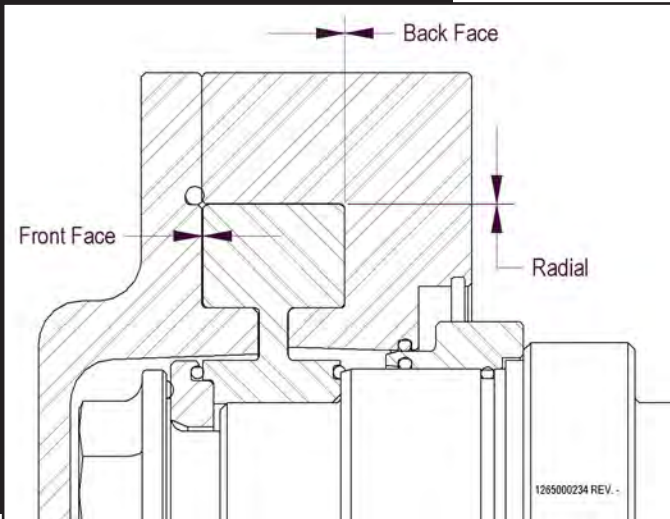


ROTOR CLEARANCE GUIDELINES

Dimensions are in millimeters (inches).						
Model	Rotor Material: Non-Galling Stainless Steel			Rotor Material: 316L & 17-4 Stainless Steel, Hastelloy, AL6XN		
	Rotor Clearances: Standard			Rotor Clearances: Standard		
	Back Face	Front Face	Radial	Back Face	Front Face	Radial
15	0.06 - 0.08 (0.0025" - 0.0030")	0.07 - 0.17 (0.0030" - 0.0065")	0.05 - 0.09 (0.0020" - 0.0035")	0.13 - 0.17 (0.0050" - 0.0065")	0.13 - 0.25 (0.0050" - 0.0100")	0.11 - 0.15 (0.0045" - 0.0060")
20	0.06 - 0.08 (0.0025" - 0.0030")	0.07 - 0.17 (0.0030" - 0.0065")	0.05 - 0.09 (0.0020" - 0.0035")	0.13 - 0.17 (0.0050" - 0.0065")	0.13 - 0.25 (0.0050" - 0.0100")	0.11 - 0.15 (0.0045" - 0.0060")
25	0.06 - 0.08 (0.0025" - 0.0030")	0.07 - 0.17 (0.0030" - 0.0065")	0.05 - 0.09 (0.0020" - 0.0035")	0.13 - 0.17 (0.0050" - 0.0065")	0.13 - 0.25 (0.0050" - 0.0100")	0.11 - 0.15 (0.0045" - 0.0060")
50	0.07 - 0.11 (0.0030" - 0.0045")	0.08 - 0.20 (0.0030" - 0.0080")	0.05 - 0.11 (0.0020" - 0.0045")	0.14 - 0.20 (0.0055" - 0.0080")	0.15 - 0.29 (0.0060" - 0.0115")	0.12 - 0.17 (0.0045" - 0.0065")
75	0.08 - 0.12 (0.0030" - 0.0045")	0.10 - 0.22 (0.0040" - 0.0085")	0.07 - 0.13 (0.0030" - 0.0050")	0.15 - 0.21 (0.0060" - 0.0085")	0.18 - 0.32 (0.0070" - 0.0125")	0.15 - 0.20 (0.0060" - 0.0080")
150	0.08 - 0.12 (0.0030" - 0.0045")	0.13 - 0.25 (0.0050" - 0.0100")	0.08 - 0.14 (0.0030" - 0.0055")	0.15 - 0.21 (0.0060" - 0.0085")	0.23 - 0.37 (0.0090" - 0.0145")	0.16 - 0.21 (0.0065" - 0.0085")
205	0.09 - 0.13 (0.0035" - 0.0050")	0.16 - 0.28 (0.0065" - 0.0110")	0.11 - 0.17 (0.0045" - 0.0065")	0.16 - 0.22 (0.0065" - 0.0085")	0.28 - 0.42 (0.0110" - 0.0165")	0.20 - 0.27 (0.0080" - 0.0105")
250	0.09 - 0.13 (0.0035" - 0.0050")	0.16 - 0.28 (0.0065" - 0.0110")	0.11 - 0.17 (0.0045" - 0.0065")	0.16 - 0.22 (0.0065" - 0.0085")	0.28 - 0.42 (0.0110" - 0.0165")	0.20 - 0.27 (0.0080" - 0.0105")
400	0.10 - 0.14 (0.0040" - 0.0055")	0.16 - 0.30 (0.0065" - 0.0120")	0.12 - 0.18 (0.0045" - 0.0070")	0.17 - 0.23 (0.0065" - 0.0090")	0.30 - 0.45 (0.0120" - 0.0175")	0.23 - 0.29 (0.0090" - 0.0115")
580/600	0.11 - 0.16 (0.0045" - 0.0065")	0.17 - 0.32 (0.0065" - 0.0125")	0.14 - 0.19 (0.0055" - 0.0075")	0.28 - 0.32 (0.0110" - 0.0126")	0.47 - 0.61 (0.0185" - 0.0240")	0.39 - 0.44 (0.0153" - 0.0173")
	Rotor Clearances: High Temperature			Rotor Clearances: High Temperature		
	Back Face	Front Face	Radial	Back Face	Front Face	Radial
15	0.11 - 0.14 (0.0045" - 0.0055")	0.11 - 0.23 (0.0045" - 0.0090")	0.08 - 0.12 (0.0030" - 0.0045")	0.18 - 0.22 (0.0070" - 0.0085")	0.18 - 0.30 (0.0070" - 0.0120")	0.15 - 0.19 (0.0060" - 0.0075")
20	0.11 - 0.14 (0.0045" - 0.0055")	0.11 - 0.23 (0.0045" - 0.0090")	0.08 - 0.12 (0.0030" - 0.0045")	0.18 - 0.22 (0.0070" - 0.0085")	0.18 - 0.30 (0.0070" - 0.0120")	0.15 - 0.19 (0.0060" - 0.0075")
25	0.11 - 0.14 (0.0045" - 0.0055")	0.11 - 0.23 (0.0045" - 0.0090")	0.08 - 0.12 (0.0030" - 0.0045")	0.18 - 0.22 (0.0070" - 0.0085")	0.18 - 0.30 (0.0070" - 0.0120")	0.15 - 0.19 (0.0060" - 0.0075")
50	0.12 - 0.17 (0.0045" - 0.0065")	0.13 - 0.27 (0.0050" - 0.0105")	0.09 - 0.15 (0.0035" - 0.0060")	0.19 - 0.25 (0.0075" - 0.0100")	0.21 - 0.34 (0.0085" - 0.0135")	0.15 - 0.20 (0.0060" - 0.0080")
75	0.13 - 0.18 (0.0050" - 0.0070")	0.16 - 0.30 (0.0065" - 0.0120")	0.12 - 0.18 (0.0045" - 0.0070")	0.20 - 0.26 (0.0080" - 0.0100")	0.25 - 0.39 (0.0100" - 0.0155")	0.20 - 0.25 (0.0080" - 0.0100")
150	0.13 - 0.18 (0.0050" - 0.0070")	0.21 - 0.35 (0.0085" - 0.0140")	0.13 - 0.19 (0.0050" - 0.0075")	0.20 - 0.26 (0.0080" - 0.0100")	0.32 - 0.46 (0.0125" - 0.0180")	0.21 - 0.26 (0.0085" - 0.0100")
205	0.14 - 0.19 (0.0055" - 0.0075")	0.26 - 0.40 (0.0100" - 0.0155")	0.18 - 0.24 (0.0070" - 0.0095")	0.21 - 0.27 (0.0085" - 0.0105")	0.38 - 0.51 (0.0150" - 0.0200")	0.25 - 0.31 (0.0100" - 0.0120")
250	0.14 - 0.19 (0.0055" - 0.0075")	0.26 - 0.40 (0.0100" - 0.0155")	0.18 - 0.24 (0.0070" - 0.0095")	0.21 - 0.27 (0.0085" - 0.0105")	0.38 - 0.51 (0.0150" - 0.0200")	0.25 - 0.31 (0.0100" - 0.0120")
400	0.15 - 0.20 (0.0060" - 0.0080")	0.27 - 0.43 (0.0105" - 0.0170")	0.20 - 0.26 (0.0080" - 0.0100")	0.22 - 0.28 (0.0085" - 0.0110")	0.40 - 0.55 (0.0155" - 0.0215")	0.27 - 0.33 (0.0105" - 0.0130")
580/600	0.17 - 0.23 (0.0065" - 0.0090")	0.30 - 0.44 (0.0120" - 0.0175")	0.22 - 0.28 (0.0085" - 0.0110")	TBD	TBD	TBD
	Rotor Clearances: Chocolate*					
	Back Face	Front Face	Radial			
15	0.26 - 0.38 (0.0100" - 0.0150")	0.21 - 0.49 (0.0085" - 0.0195")	0.22 - 0.30 (0.0085" - 0.0120")			
20	0.26 - 0.38 (0.0100" - 0.0150")	0.21 - 0.49 (0.0085" - 0.0195")	0.22 - 0.30 (0.0085" - 0.0120")			
25	0.26 - 0.38 (0.0100" - 0.0150")	0.21 - 0.49 (0.0085" - 0.0195")	0.22 - 0.30 (0.0085" - 0.0120")			
50	0.27 - 0.41 (0.0105" - 0.0160")	0.22 - 0.52 (0.0085" - 0.0205")	0.25 - 0.33 (0.0100" - 0.0130")			
75	0.28 - 0.42 (0.0110" - 0.0165")	0.23 - 0.53 (0.0090" - 0.0210")	0.28 - 0.36 (0.0110" - 0.0140")			
150	0.28 - 0.42 (0.0110" - 0.0165")	0.23 - 0.53 (0.0090" - 0.0210")	0.29 - 0.37 (0.0115" - 0.0145")			
205	0.29 - 0.43 (0.0115" - 0.0170")	0.27 - 0.57 (0.0105" - 0.0225")	0.37 - 0.46 (0.0145" - 0.0180")			
250	0.29 - 0.43 (0.0115" - 0.0170")	0.27 - 0.57 (0.0105" - 0.0225")	0.37 - 0.46 (0.0145" - 0.0180")			
400	0.30 - 0.44 (0.0120" - 0.0175")	0.30 - 0.62 (0.0120" - 0.0245")	0.44 - 0.53 (0.0175" - 0.0210")			
580/600	TBD	TBD	TBD			



*Chocolate rotor clearances apply to all rotor materials.