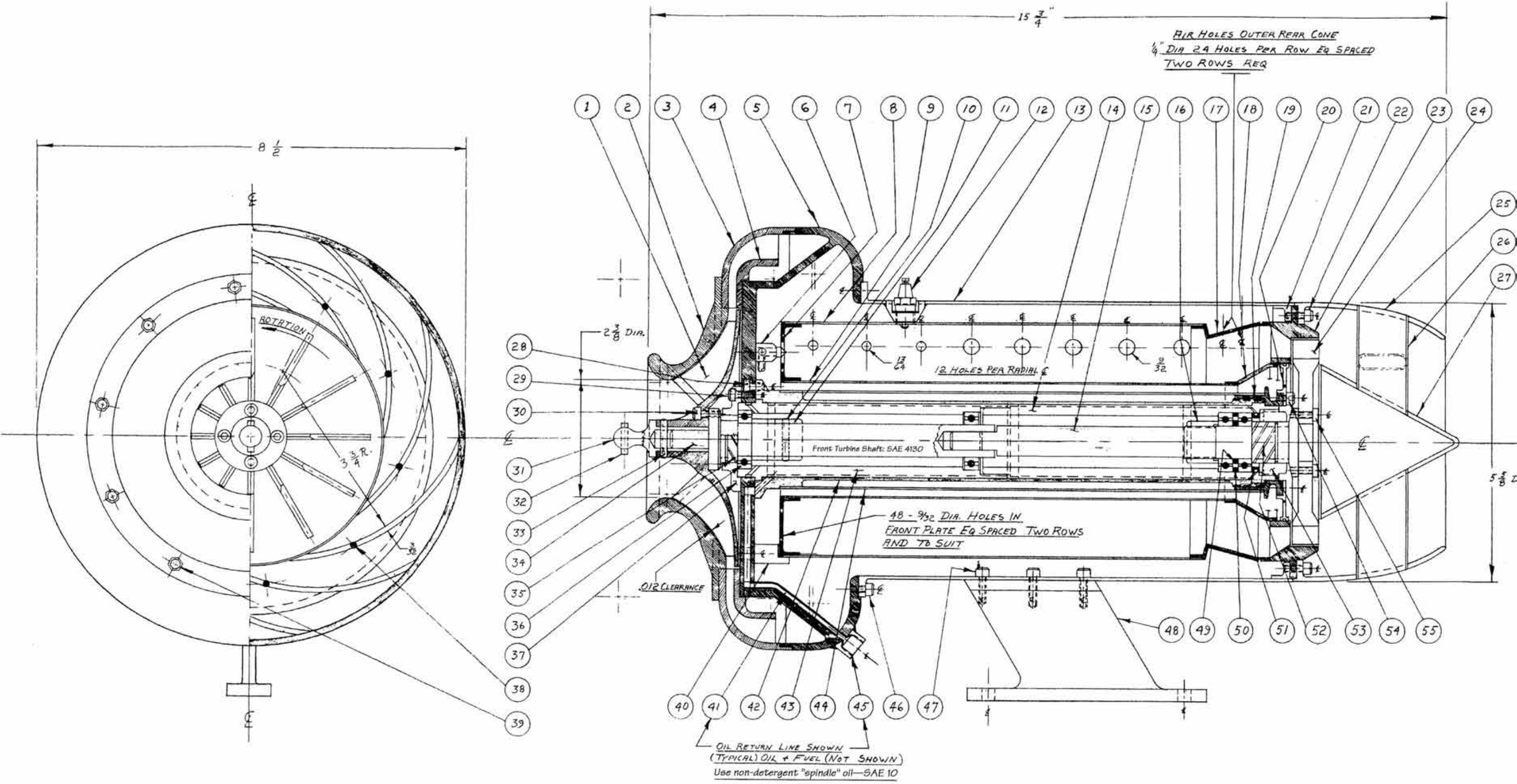
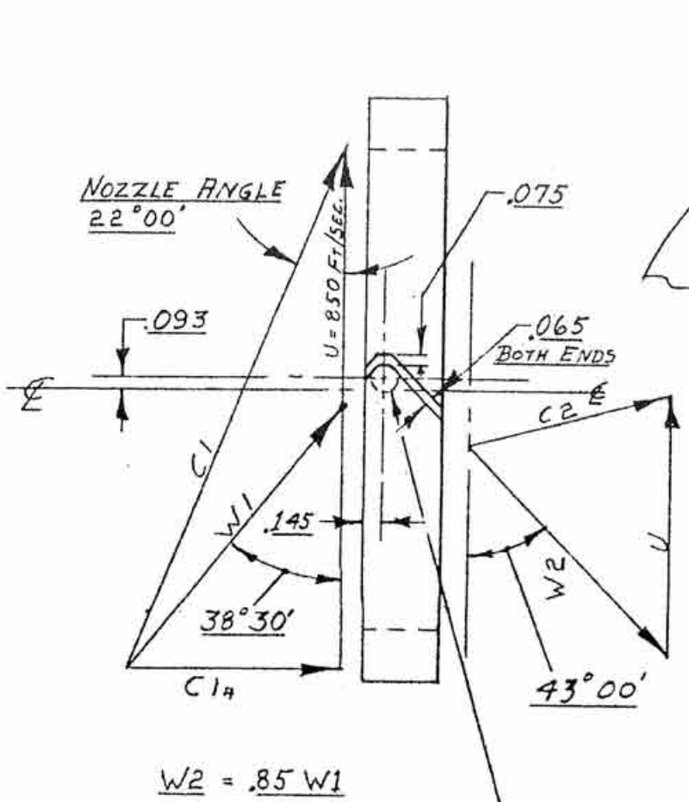
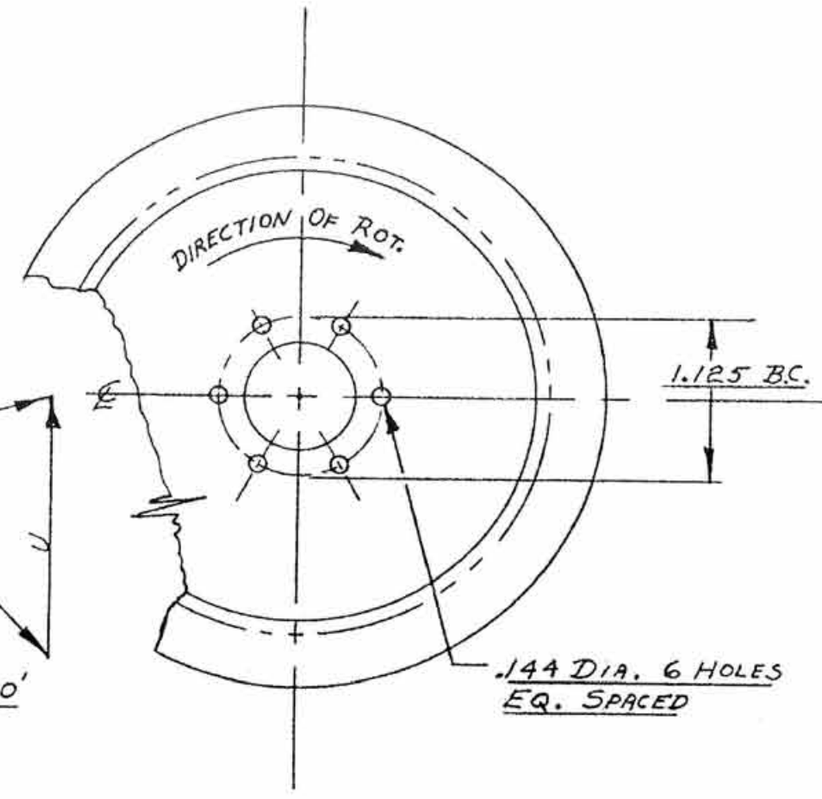
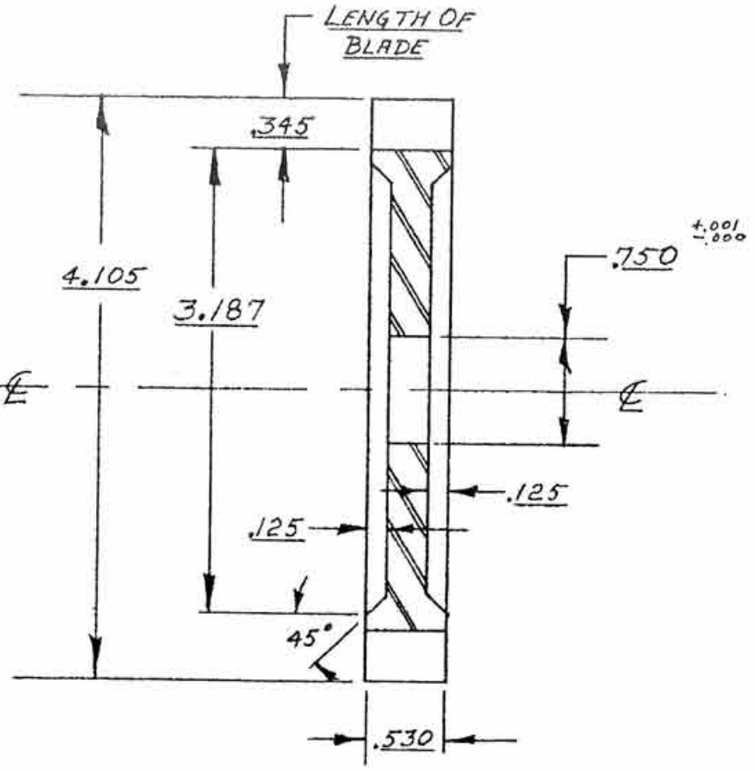

8 1/2
ROTATION
3 3/4 R.
3/32
15 3/4"
AIR HOLES OUTER REAR CONE
1/4" DIA 24 HOLES PER ROW EQ SPACED
TWO ROWS REQ
2 3/8 DIA.
13/64
12 HOLES PER RADIAL ℄
9/32
Front Turbine Shaft: SAE 4130
48 - 9/32 DIA. HOLES IN
FRONT PLATE EQ SPACED TWO ROWS
AND TO SUIT
.012 CLEARANCE
5 5/8
OIL RETURN LINE SHOWN
(TYPICAL) OIL + FUEL (NOT SHOWN)
Use non-detergent "spindle" oil—SAE 10



W2 = .85 W1

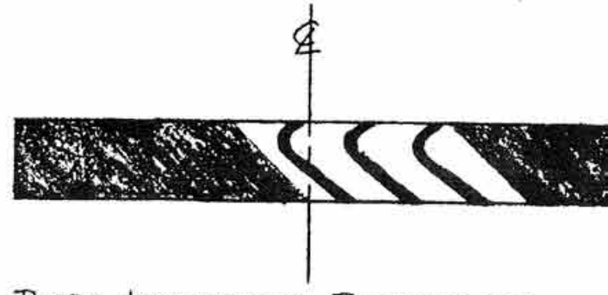
BLADES ARE MACHINED WITH .187 DIA. END MILL ONCE PROPER SETTING IS MADE NO MOVEMENT OF END MILL IS PERMITTED EXCEPT WHEN MOVING OVER TO MACHINE .065 THICKNESS OF BLADE END MILL IS SET TO MACHINE FULL LENGTH OF BLADE ALSO END MILL SHOULD HAVE .020-.030 RADIUS NO SHARP CORNERS AT BOTTOM OF BLADE





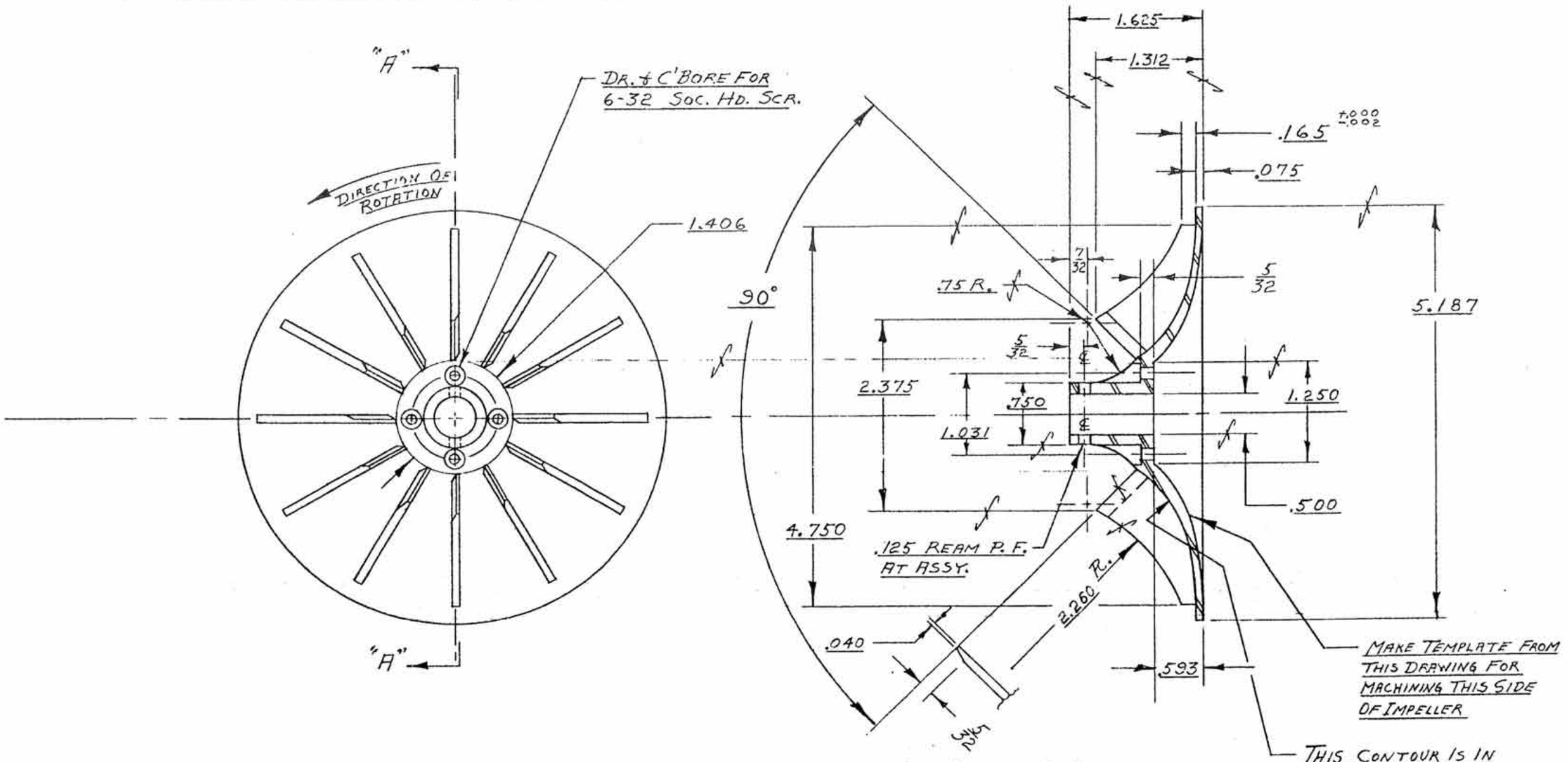
(24) TURBINE (IMPULSE) ONE REQUIRED

NO. OF BLADES. 28
ANNULAR AREA 3.9 IN²
PRESS. RATIO 2-1
WT. OF GAS 0.5 LBS/SEC
MATERIAL: "UNIVERSAL CYCLOPS" (A 286 OR 1753)
HEAT TREAT PER MFG. SPEC.
BALANCE TURBINE: MAX. OUT BALANCE .005 GRAM AT OUT SIDE DIA. (STATIC BALANCE ONLY)

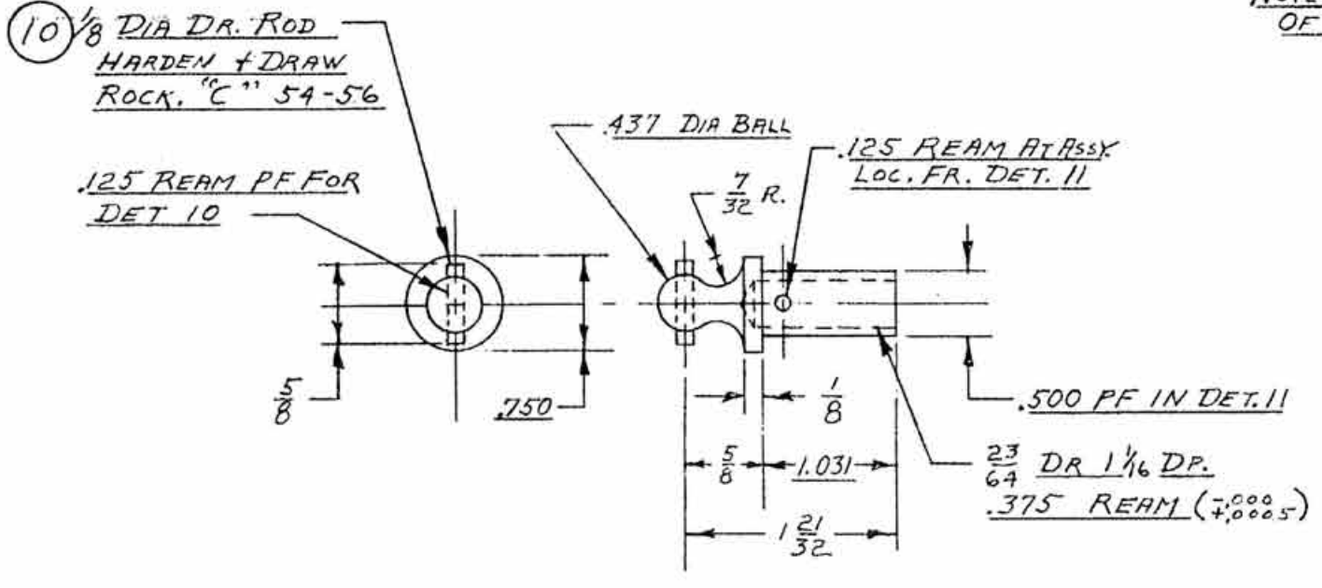


BLADE IMPRESSIONS PRINTED BY ROLLING TURBINE DIA. OVER DRAWI
BOTTOM VIEW IMPRESSION + (THICKNESS DUE TO INK + ROLLING IS OVERSIZE)

(31) UNIVERSAL BALL COUPLER ONE REQ
MATERIAL D.R. HDN. & DRAW ROCK. "C" 54-56

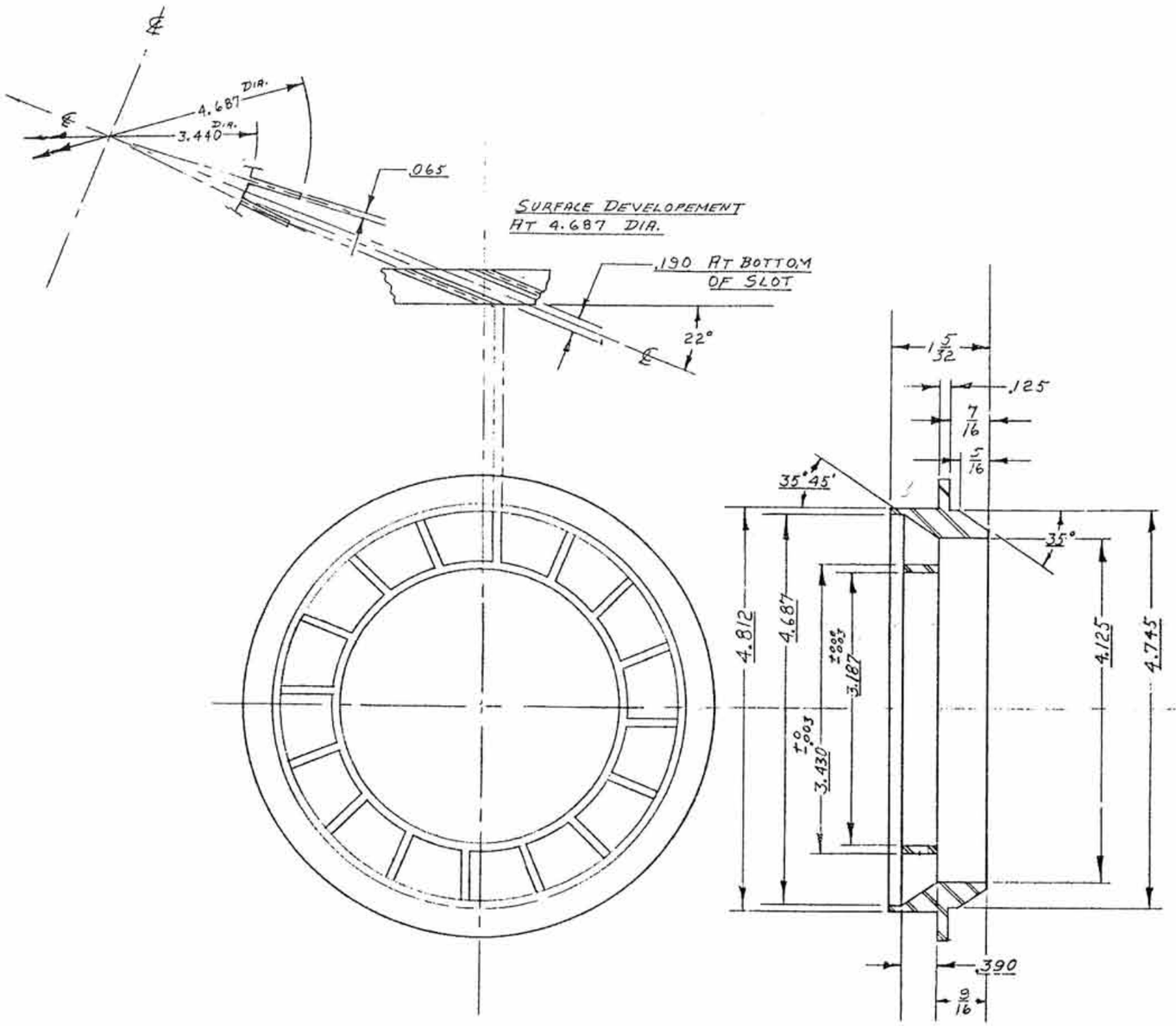


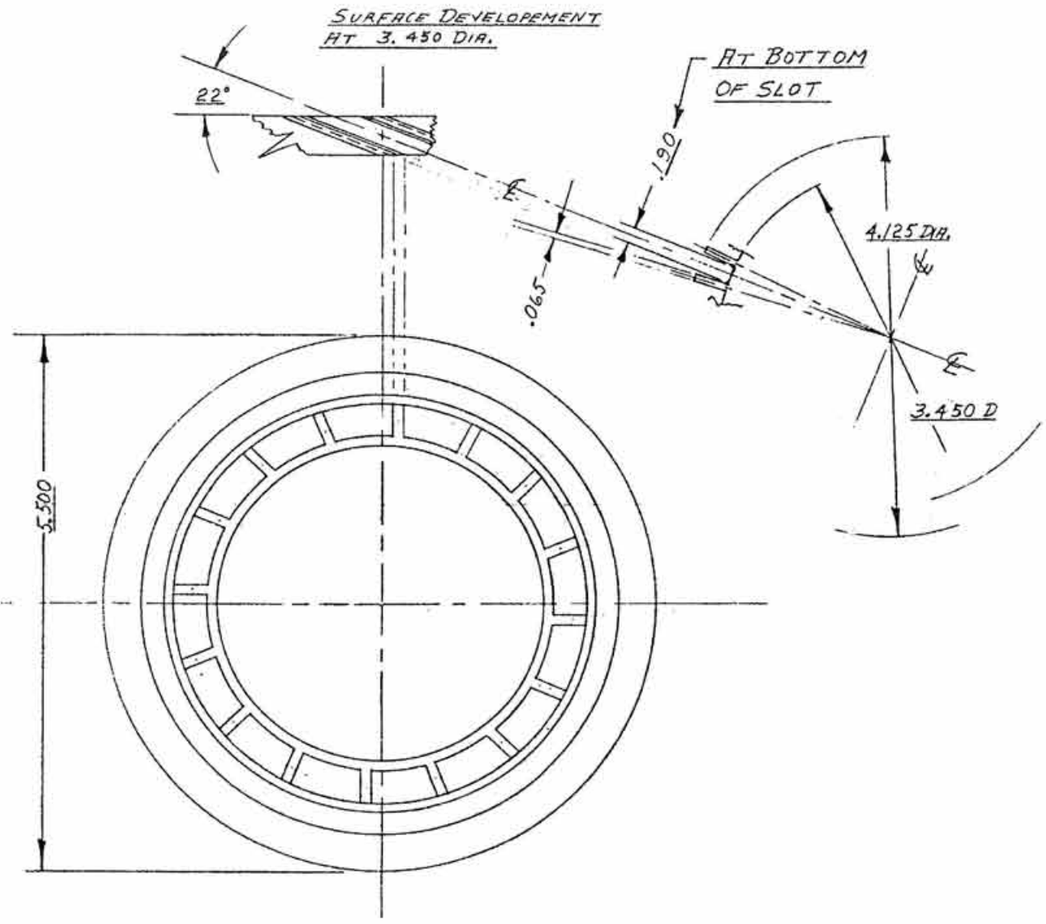
SECTION "A A"



(1) COMPRESSOR IMPELLER ONE REQ.
MAT. ALUM ALLOY (356-T6) CASTING

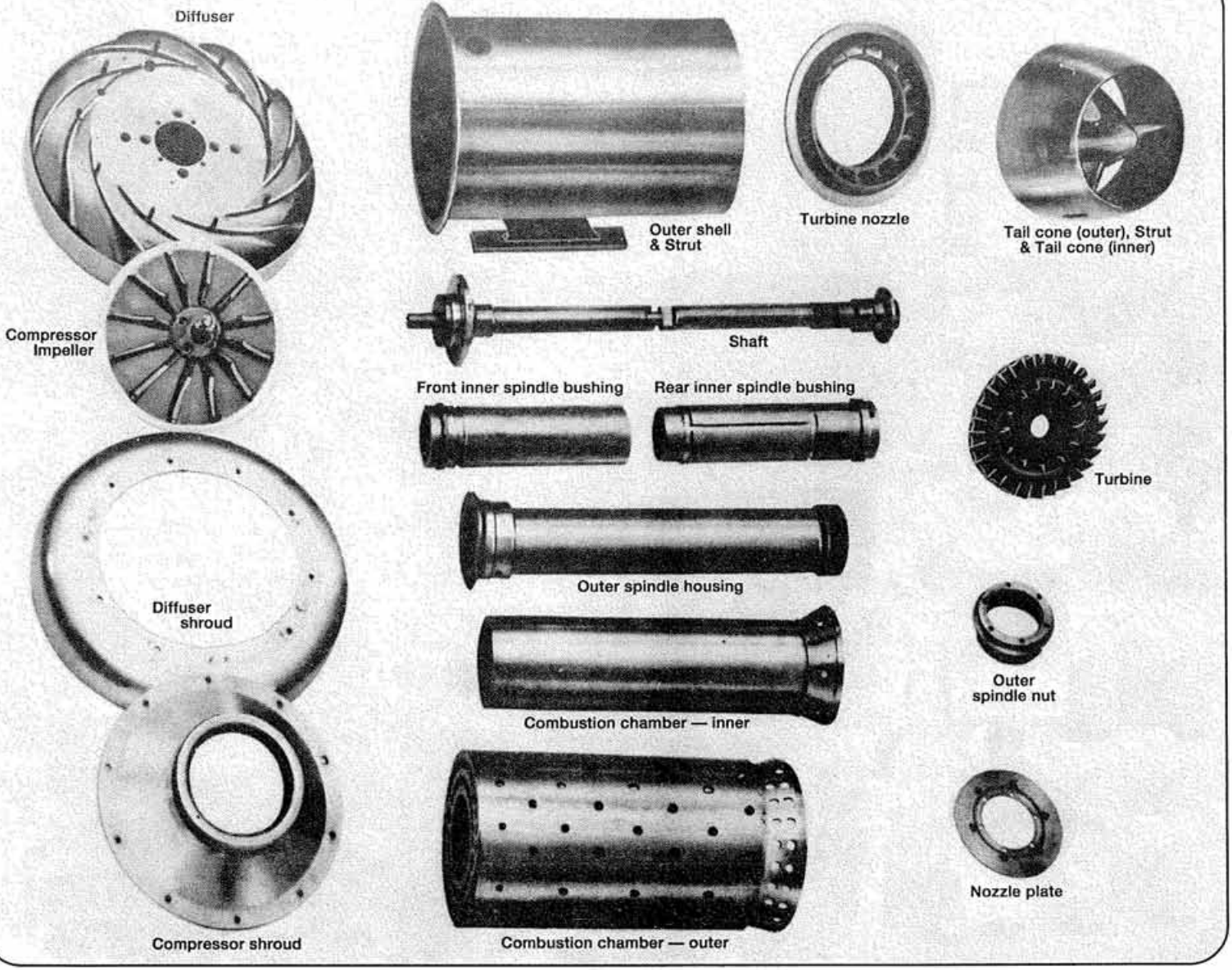
"STATIC BALANCE": MOUNT ON BAL. SHAFT USING HARDEN & GROUND KNIFE EDGES PERFECTLY HORIZONAL AND 60 CYCLE VIBRATOR: BALANCE FOR ZERO DISPLACEMENT





NOTE: BOTTOM OF
SLOT MUST HAVE .025 - 030 RADIUS

(23) GAS TURBINE NOZZLE
16 BLADES EQ. SPACED
MAT. 321 STAINLESS ST.


Diffuser
Compressor Impeller
Diffuser shroud
Compressor shroud
Outer shell & Strut
Turbine nozzle
Tail cone (outer), Strut & Tail cone (inner)
Shaft
Front inner spindle bushing
Rear inner spindle bushing
Turbine
Outer spindle housing
Outer spindle nut
Combustion chamber — inner
Combustion chamber — outer
Nozzle plate