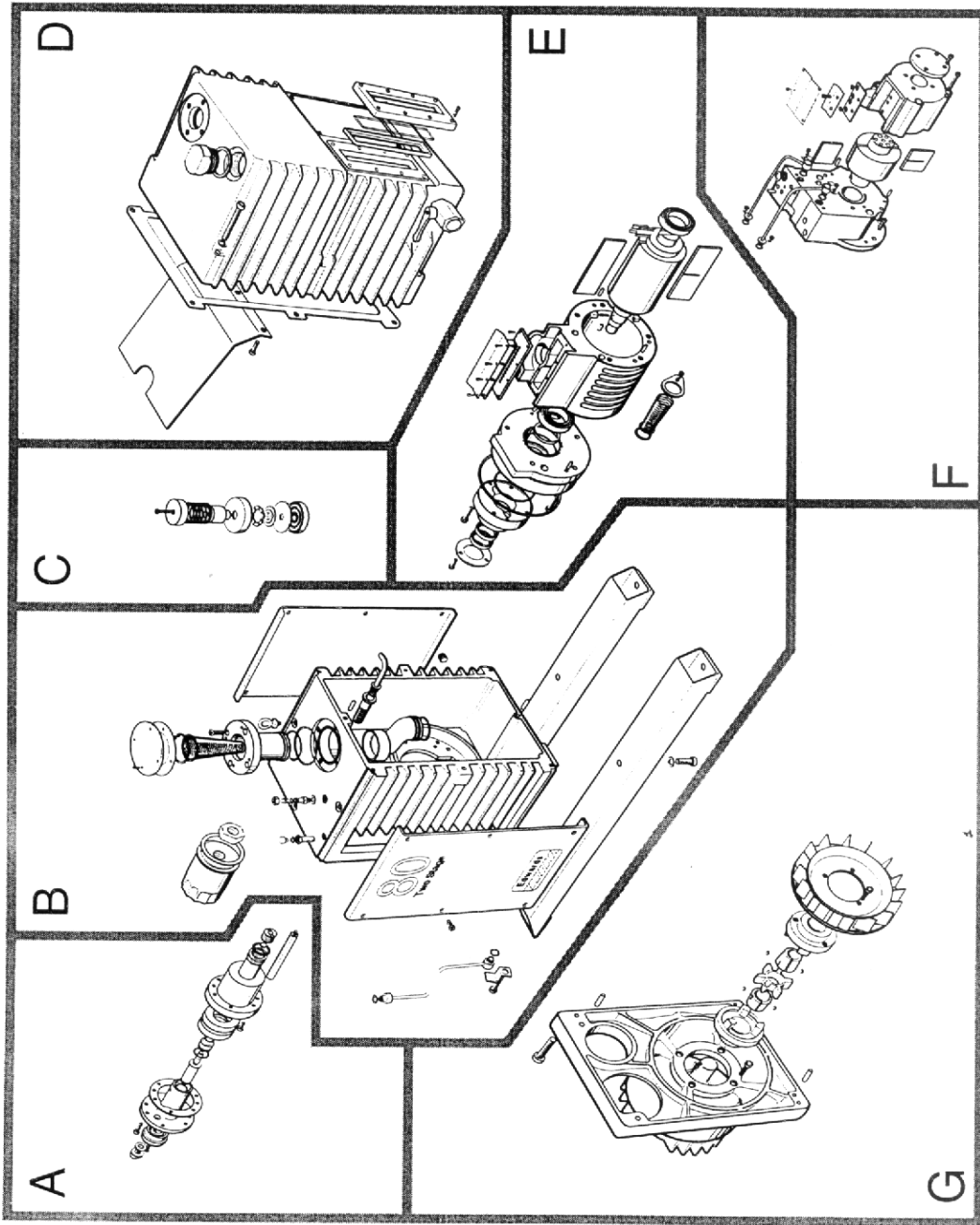


E2M80 MAJOR SUB-ASSEMBLIES



- A. Gas Ballast Valve Sub-assembly
- B. Adaptor Sub-assembly
- C. Oil Distributor Sub-assembly
- D. Oil Box Sub-assembly
- E. HV Stator Sub-assembly
- F. LV Stator Sub-assembly
- G. Motor Plate sub-assembly

Figure 23 - E2M80 major sub-assemblies

(A) E2M80 Gas ballast valve sub-assembly

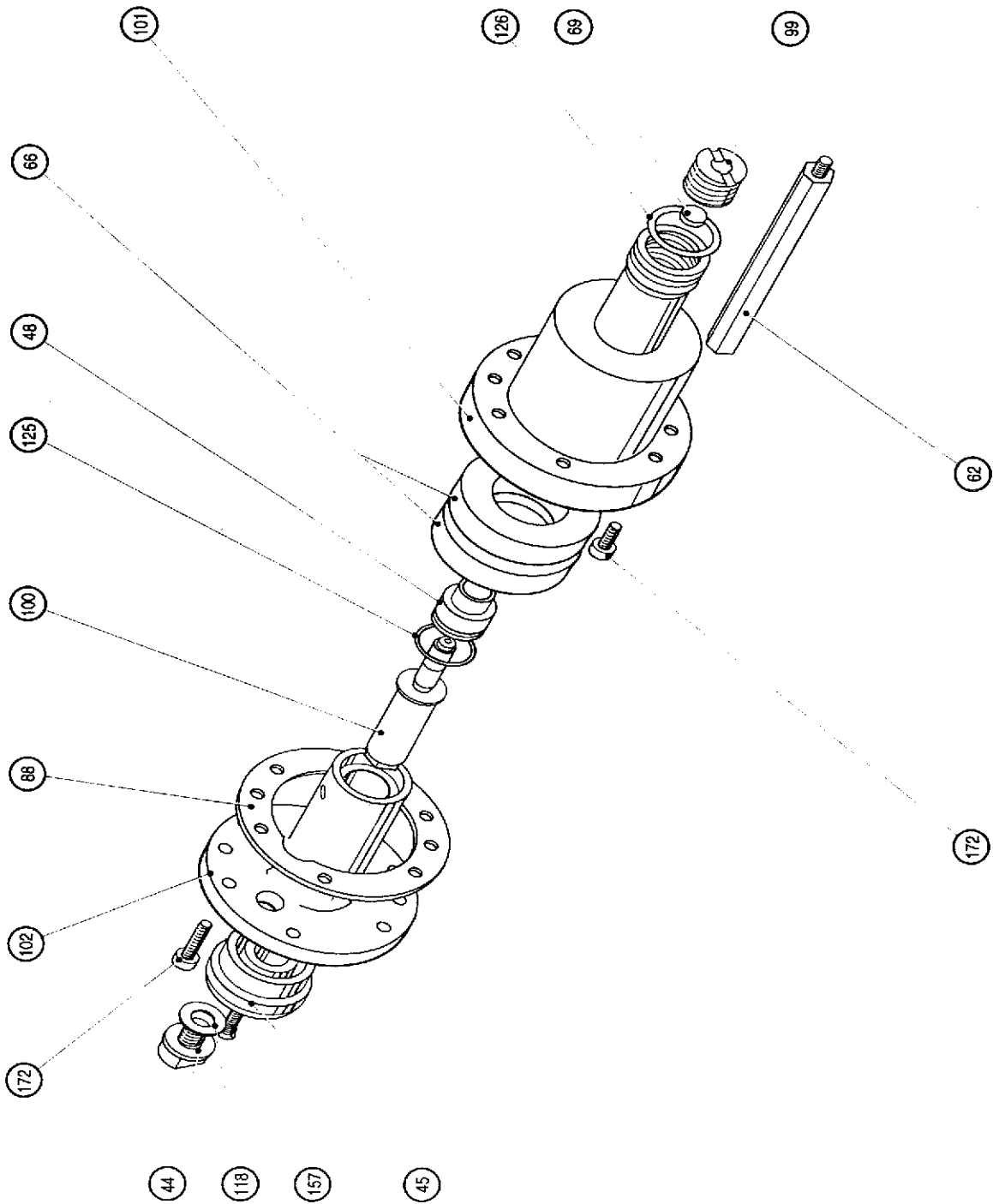


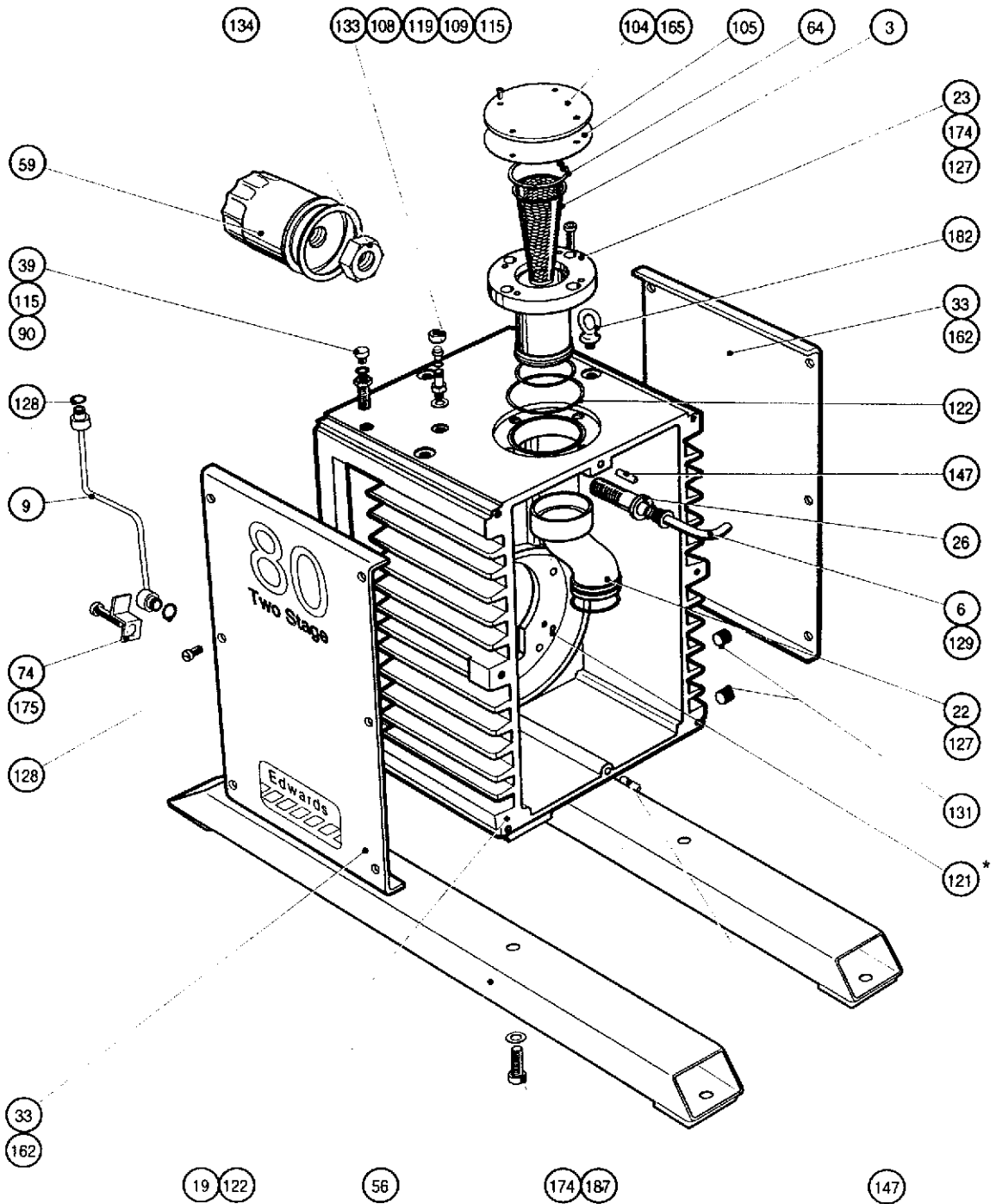
Figure 24 - (A) E2M80 Gas ballast valve sub-assembly

ITEM	DESCRIPTION	CODE No.	QTY.
44	Plug - 1/4inch BSP	A26002018	1
45	Ballast knob	A19201013	1
48	Ballast piston	A19201007	1
62	Support pillar	A22404006	2
66	Ballast filter	A22305041	2
69	Ballast valve	A25904601	1
88	Body gasket	A27159428	1
99	Ballast plug	A36601034	1
100	Ballast spindle	A36601036	1
101	Ballast valve body	A34401008	1
102	Ballast valve bearing	A34401009	1
118	Dowty seal - 1/4inch BSP	H02104002	1
125	'O' ring 7/16inch i/d x 3/32inch sect.	H02125011	1
126	'O' ring 3/4inch i/d x 1/8inch sect.	H02126020	1
157	C`sk hd. scr. M4 x 16 lg.	218032290	1
172	Soc. hd. cap scr. M6 x 16 lg.	218091370	8

Reference: EHVI General Arrangement drawing A36501000 (issue YA - five sheets)

Table 21 - E2M80 Gas ballast valve sub-assembly items

(B) E2M80 Adaptor sub-assembly



\* Used on item 15 (ref. Figure 28)

Figure 25 - (B) E2M80 Adaptor sub-assembly

ITEM	DESCRIPTION	CODE No.	QTY.
3	Filter assy. (inlet)	A22305035	1
6	Tube assy. (oil return)	A27879001	1
9	Tube assy. (oil pressure)	A27879007	1
19	Adaptor	A36501045	1
22	Inlet connection	A36501009	1
23	Inlet flange	A36501032	1
26	Filter outlet	A36501013	1
33	Side panel	A36501046	2
39	Plug - 1/8inch BSP	A01403074	1
56	Base runner	A20499015	2
59	Filter	A22304041	1
64	Circlip	A22426004	1
74	Clamp (oil pressure line)	A25970036	1
90	1/8inch BSP socket	A27911003	1
104	Protective cover	B21023019	1
105	Dust cover	B21024001	1
108	Blind tailpiece	C11001062	1
109	Adaptor - sc5mm x 1/8inch BSP	C11001180	1
115	Dowty seal - 1/8inch BSP	H02104001	2
119	'O' ring 6.5mm i/d x 2.4mm sect.	H02120027	1
121	'O' ring 12.42mm i/d x 1.78mm sect. Fluoro	H02124119	1
122	'O' ring 61.6mm i/d x 2.4mm sect.	H02120057	1
127	'O' ring 1 7/8inch i/d x 3/16inch sect.	H02125044	2
128	'O' ring 3/8inch i/d x 3/32inch sect.	H02125115	2
129	'O' ring 5/16inch i/d x 3/32inch sect.	H02125116	1
131	1/4inch BSP hollow taper pressure plug	H03517003	2
133	Union nut - 3/8inch BSP	M03400008	1
134	Locknut - 3/4inch x 16UNF ms. ni. pl.	216814314	1
147	Spring pin - Ø8 x 24 lg.	212170186	2
162	Pan hd. scr. ss M5 x 10	218221328	12
165	Hex hd. scr. M8 x 12 lg.	218072409	2
174	Soc. hd. cap scr. M8 x 20 lg.	218091411	8
175	Soc. hd. cap scr. M8 x 25 lg.	218091412	1
182	Eyebolt - M12	218790005	2
187	Plain washer	218980210	4

Reference: EHVI General Arrangement drawing A36501000 (issue YA - five sheets)

Table 22 - E2M80 Adaptor sub-assembly items

(C) E2M80 Oil distributor sub-assembly

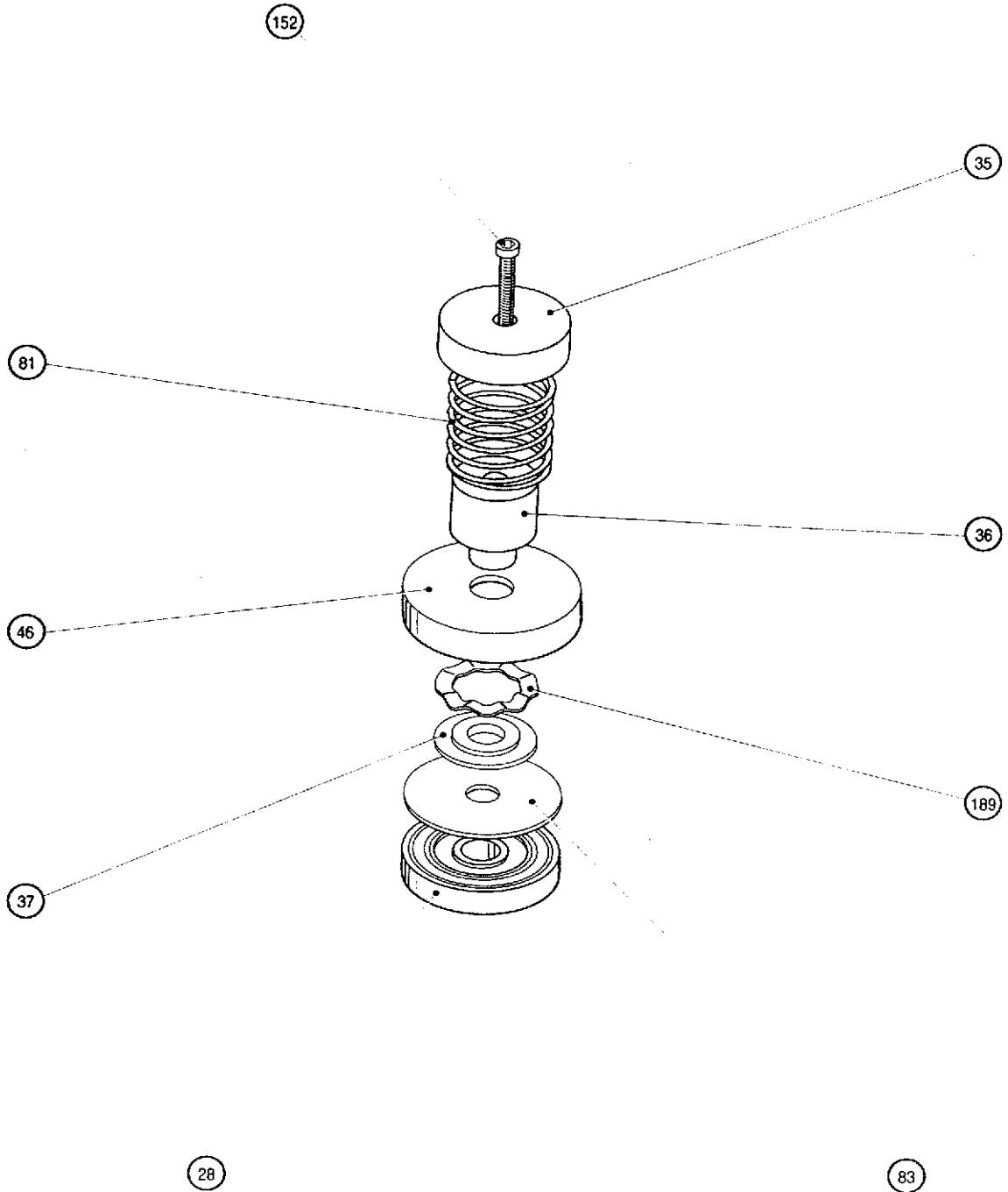


Figure 26 - (C) E2M80 Oil distributor sub-assembly

ITEM	DESCRIPTION	CODE No.	QTY.
28	Distributor body	A36501015	1
35	Spacer	A36401029	1
36	Distributor sleeve	A36401019	1
37	Distributor weight	A34301037	1
46	Cap	A36401028	1
81	Spring	A27102013	1
83	Rubber seal	A27159415	1
152	Hex hd. scr. ms. ni. pl. M5 x 60 lg.	218002339	1
189	Waved washer	218990201	1

Reference: EHVI General Arrangement drawing A36501000 (issue YA - five sheets)

Table 23 - E2M80 Oil distributor sub-assembly items

(D) E2M80 Oil box sub-assembly

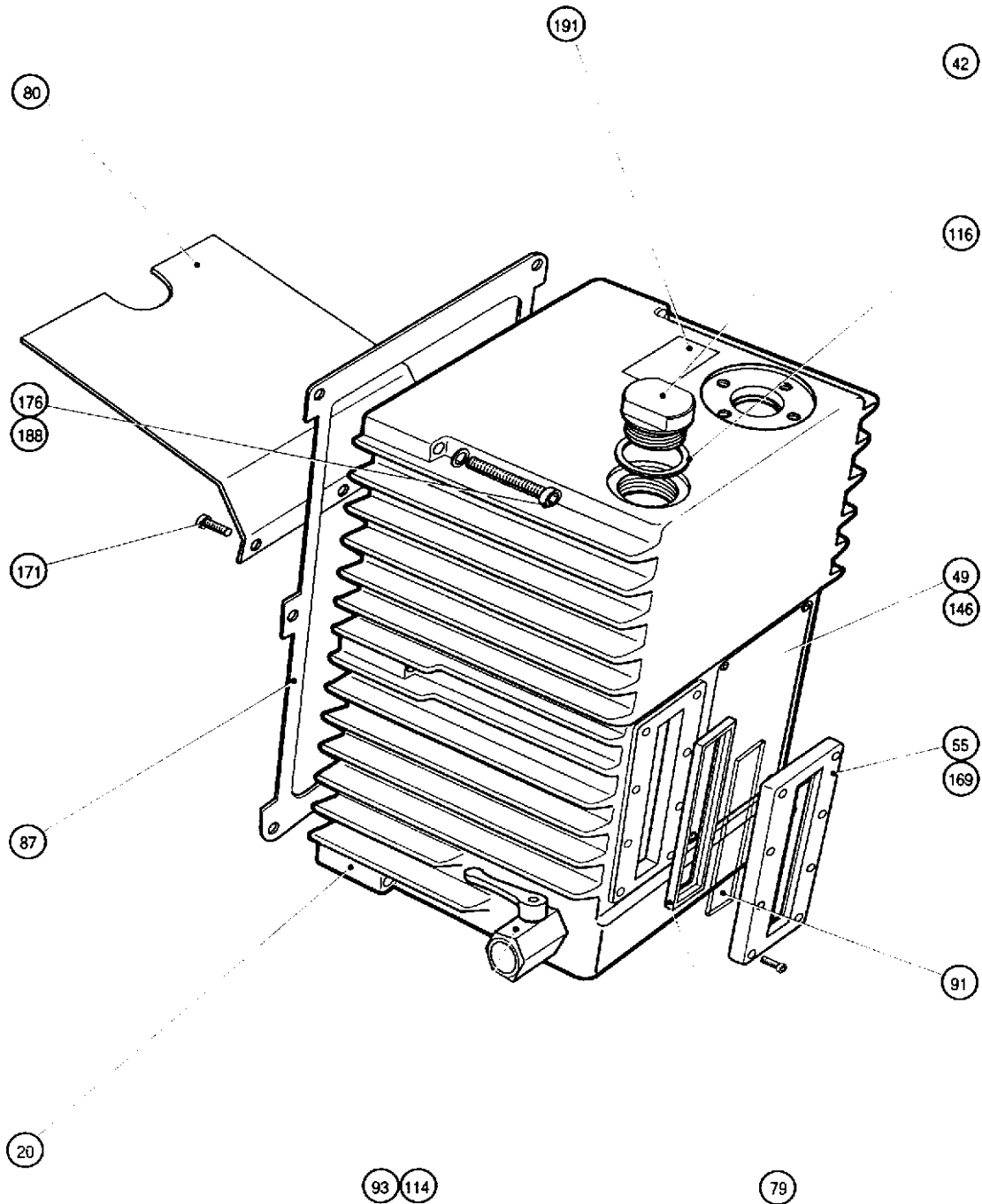


Figure 27 - (D) Oil box sub-assembly



ITEM	DESCRIPTION	CODE No.	QTY.
20	Oil box	A36501034	1
42	Filler plug - 1inch BSP	A26002022	1
49	Label	A20001063	1
55	Sight glass bezel	A20416002	1
79	Sight glass seal	A26501012	1
80	Spray baffle	A25976034	1
87	Oil box gasket	A27159618	1
91	Sight glass	A29201006	1
93	Ball valve - 1/2inch BSP	A28702003	1
114	Redcap - 1/2inch BSP	H01503333	1
116	Dowty seal - 1inch BSP	H02104008	1
146	Rivet	211430301	4
169	Soc. hd. cap scr. M5 x 16 lg.	218091330	8
171	Soc. hd. cap scr. M6 x 12 lg.	218091369	3
176	Soc. hd. cap scr. M8 x 45 lg.	218091416	6
188	Rect. sect. s/coil spring washer M8	218982710	6
191	Hazard warning label	A20001084	1

Reference: EHVI General Arrangement drawing A36501000 (issue YA - five sheets)

Table 24 - Oil box sub-assembly items

(E) E2M80 HV stator sub-assembly

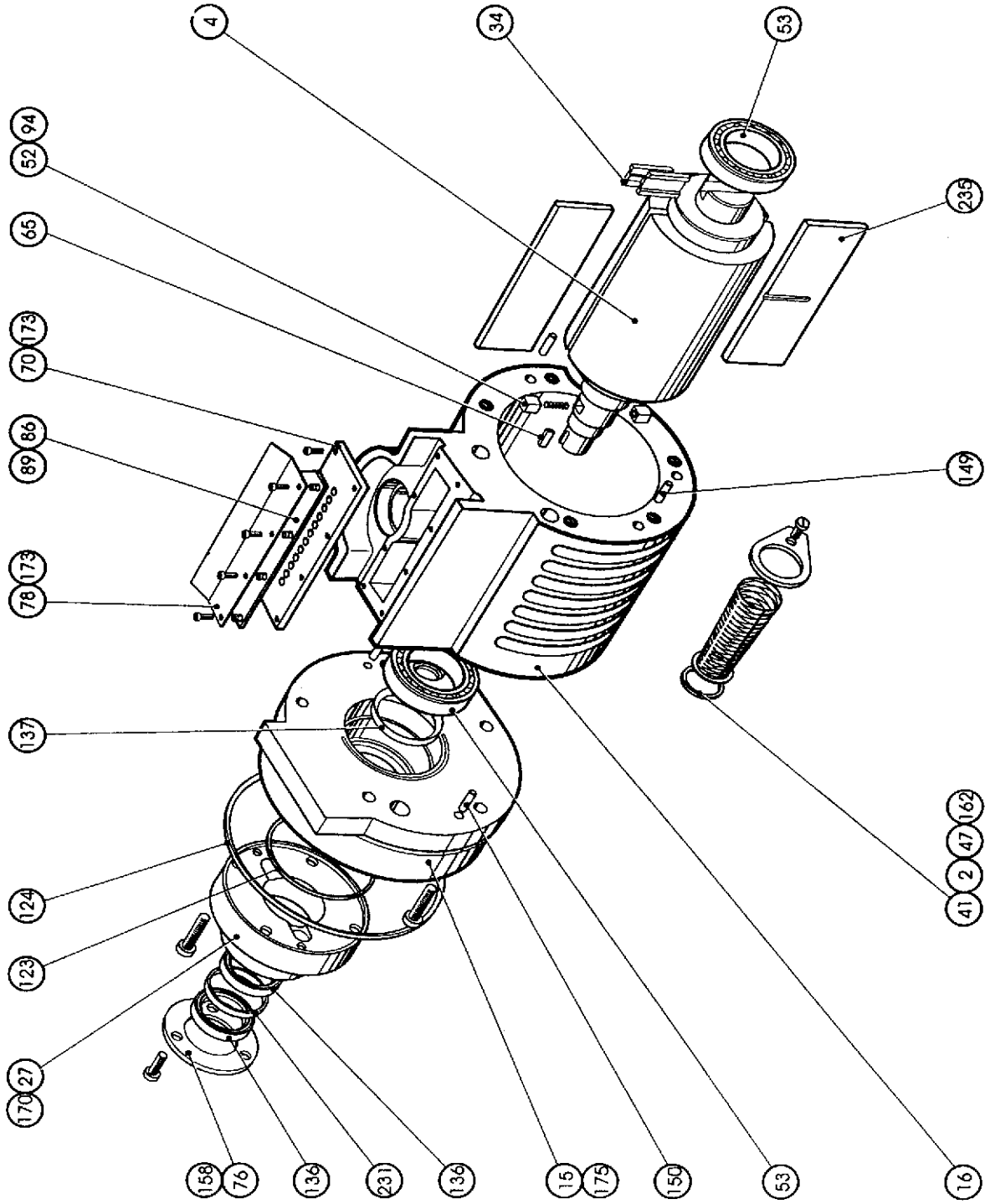


Figure 28 - (E) E2M80 HV stator sub-assembly

ITEM	DESCRIPTION	CODE No.	QTY.
2	Filter assy. (oil)	A22305050	1
4	Rotor - High Vac.	A26401119	1
15	Front bearing	A36501001	1
16	High Vac. stator	A36501002	1
27	Oil pump housing	A36501014	1
34	Drive member	A36501024	2
41	Filter seal	A01403030	1
47	Clamp ring	A36401031	1
52	Oil pump blade	A20402418	2
53	Roller bearing	A20404012	2
65	Key - 8 x 7 x 20 lg.	A24301008	1
70	Exhaust cover plate	A25942005	1
76	Seal retainer	A25971002	1
78	Exhaust valve plate	A25976005	1
86	Exhaust valve rubber	A27159509	1
89	Exhaust valve spacer	A27804004	4
94	Spring	A27102024	1
123	'O' ring 64.5mm i/d x 3.0mm sect.	H02120082	1
124	'O' ring 159.5mm i/d x 3.0mm sect.	H02120101	1
136	Oil seal 25 x 35 x 7mm	H02109094	2
137	Oil seal 30 x 40 x 7mm	H02109064	1
149	Taper pin Ø8 x 36 lg.	212192021	2
150	Taper pin Ø8 x 60 lg.	212192026	2
158	C`sk. hd. scr M5 x 10 lg.	218032328	3
162	Pan hd. scr. ssM5 x 10 lg.	218221328	1
170	Soc hd. cap scr. M5 x 25 lg.	218091332	4
173	Soc hd. cap scr. M6 x 20 lg.	218091371	8
175	Soc hd. cap scr. M8 x 25 lg.	218091412	5
231	Aluminium spacer	A26426001	1
235	High Vac. blade	A20402630	2

Reference: EHVI General Arrangement drawing A36501000 (issue YA - five sheets)

Table 25 - E2M80 HV stator sub-assembly items

(F) E2M80 LV stator sub-assembly

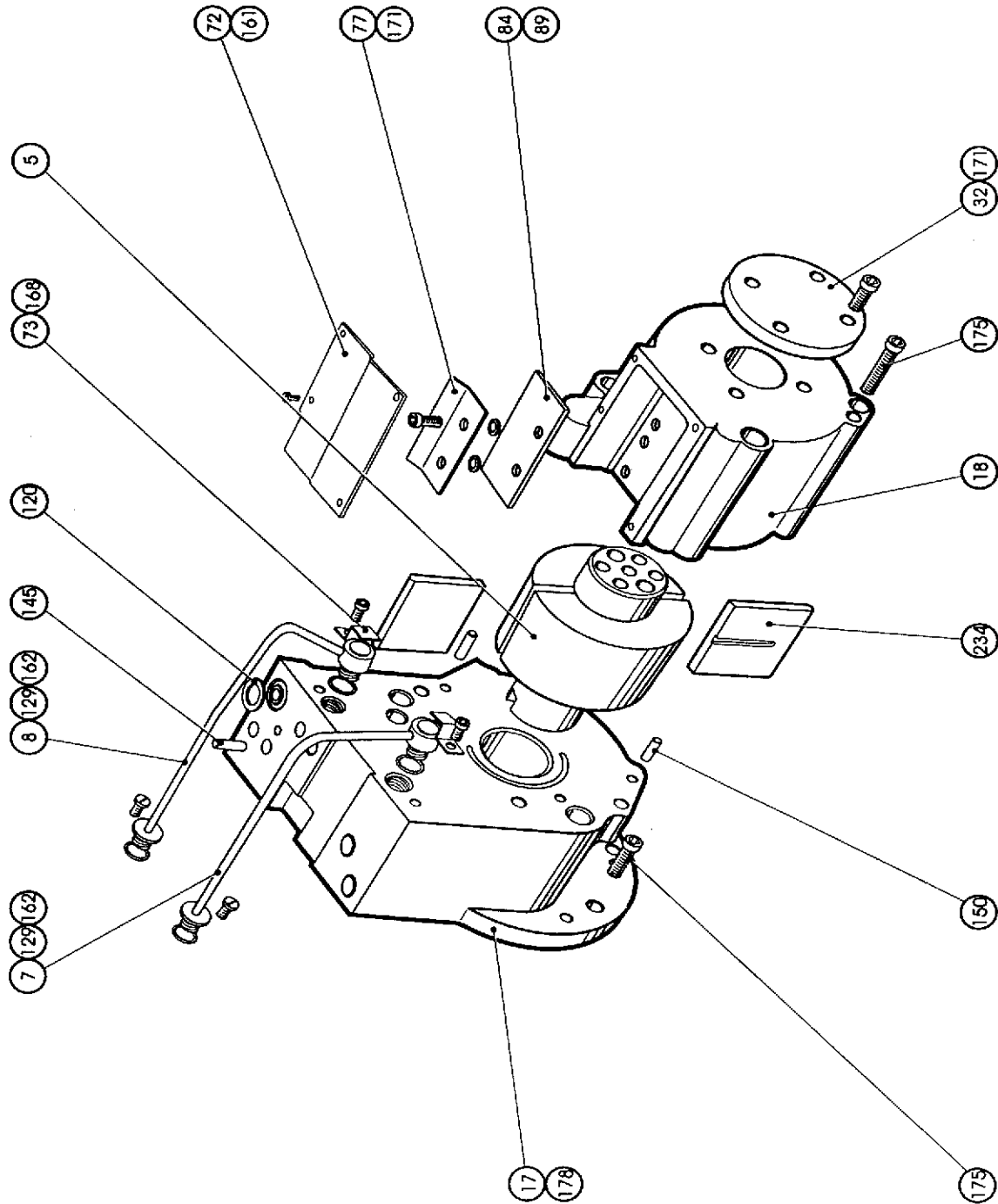


Figure 29 - (F) E2M80 LV stator sub-assembly

ITEM	DESCRIPTION	CODE No.	QTY.
5	Low Vac. rotor assy.	A26401042	1
7	Tube assy. (ballast)	A36501038	1
8	Tube assy. (oil delivery)	A36501036	1
17	Interstage	A36501035	1
18	Low Vac. stator	A36501044	1
32	Cover plate	A36501021	1
72	Low Vac. exhaust baffle	A25970070	1
73	Clamp (oil delivery line)	A25970035	2
77	Low vac exhaust valve plate	A25976048	1
84	Low Vac. exh. valve rubber	A27159541	1
89	Exh. valve spacer	A27804004	2
120	'O' ring 9.6mm i/d x 2.4mm sect.	H02120031	1
129	'O' ring 5/16inch i/d 3/32inch sect.	H02125116	4
145	Spring pin Ø 1/4inch x 1/2inch lg.	211174099	1
150	Taper pin Ø8 x 60 lg.	212192026	2
161	Pan hd. scr. M4 x 8 lg.	218042287	2
162	Pan hd. scr. sl. ss. M5 x 10 lg.	218221328	2
168	Soc hd. cap scr. M5 x 10 lg.	218091328	2
171	Soc hd. cap scr. M6 x 12 lg.	218091369	6
175	Soc hd. cap scr. M8 x 25 lg.	218091412	9
178	Soc set scr. cup pt. M10 x 12 lg.	218121449	1
234	Low Vac. blade	A20402628	2

Reference: EHVI General Arrangement drawing A36501000 (issue YA - five sheets)

Table 26 - E2M80 LV stator sub-assembly items



ITEM	DESCRIPTION	CODE No.	QTY.
21	Motor mounting	A36501027	1
43	E2M80 Motor - see Table 1d	-----	1
58	Fan	A22301003	1
67	Key - 8 x 5 x 20 lg.	A24301013	1
139	Flexible component	A21071033	1
140	Coupling flange	A21071037	1
141	Coupling flange	A21071038	1
142	Taper lock bush	A21071039	1
143	Taper lock bush	A21071040	1
148	Parallel dowel - Ø8 x 24 lg.	212181076	2
168	Soc. hd. cap scr. M5 x 10 lg.	218091328	3
175	Soc. hd. cap scr. M8 x 25 lg.	218091412	4
177	Soc. hd. cap scr. M8 x 40 lg.	218091415	4
192	Electrical warning label	E20001063	1
193	Direction label	A20001085	1

Reference: EHVI General Arrangement drawing A36501000 (issue YA - five sheets)

Table 27 - E2M80 Motor plate sub-assembly items