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**INSTRUCTION MANUAL IM157**

**INSTALLATION OF WINDAGE/BALANCE PLUGS**  
**FOR**  
**GE TURBINE TENSIONED STUDS**

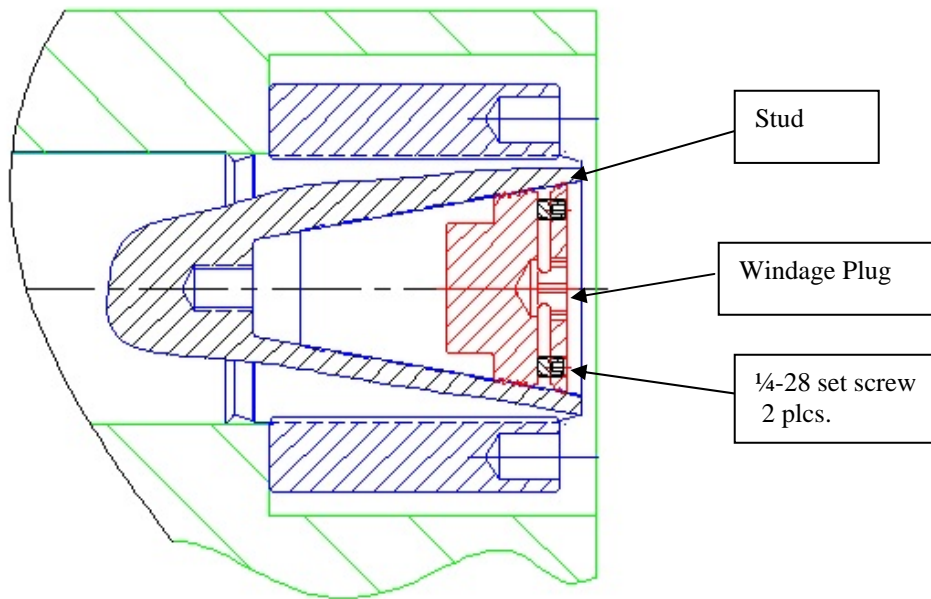
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New Hartford, NY 13413 Fax 315-768-4941

**Instruction Manual IM157  
Windage Plugs For  
GE Turbine Tensioned Studs  
Frame 9F and 7F**

WINDAGE PLUG 9F (HF-2322)



1. Insert Windage Plug Fully, Tighten to 200-250 in-lbs Torque
2. Tighten Set Screws to 80-90 in-lbs Torque
3. Caution Plug must rest a minimum of .06" (1.5 mm) below the face of the stud

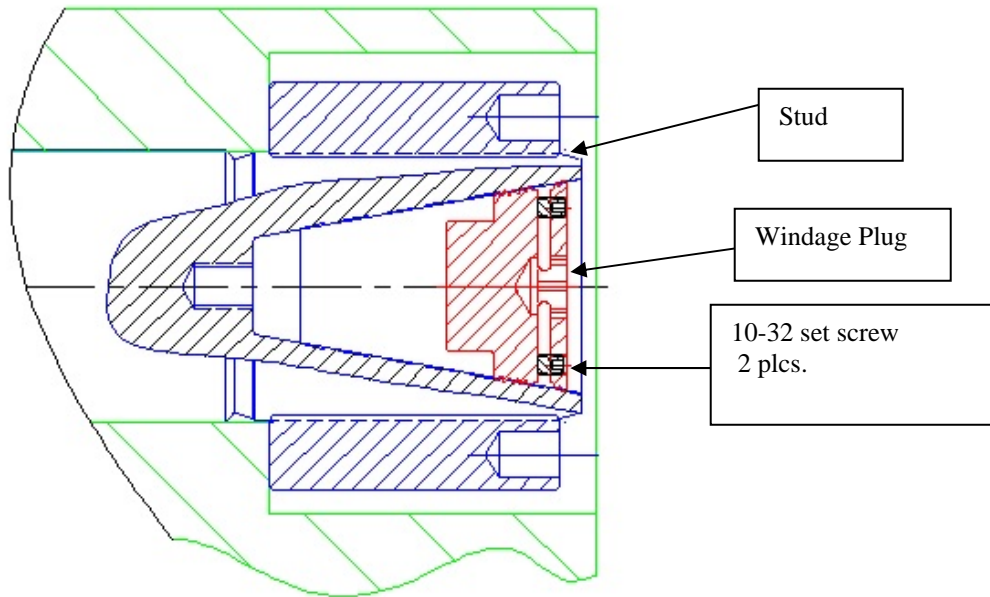
FIGURE 1



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**Windage Plugs For**  
**GE Turbine Tensioned Studs**  
**Frame 9F and 7F**

WINDAGE PLUG 7F or 9E (HF-3133)  
2 ¼" Stud, and 2 ¾ Stud (7001145 not 9F)



1. Insert Windage Plug Fully, Tighten to 200-250 in-lbs Torque
2. Tighten Set Screws to 25-35 in-lbs Torque
3. Caution Plug must rest a minimum of .06" (1.5 mm) below the face of the stud

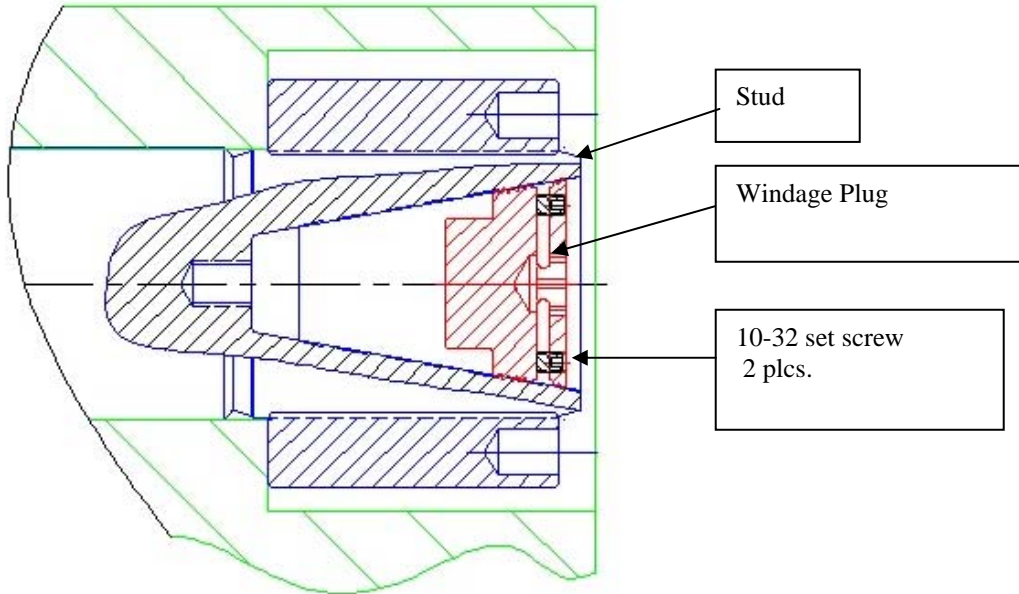
FIGURE 2



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**Frame 9F and 7F**

WINDAGE PLUG 7E (HF-3180)  
2" Stud or 2.5" Stud



7. Insert Windage Plug Fully, Tighten to 100-150 in-lbs Torque
8. Tighten Set Screws to 25-35 in-lbs Torque
9. Caution Plug must rest a minimum of .06" (1.5 mm) below the face of the stud

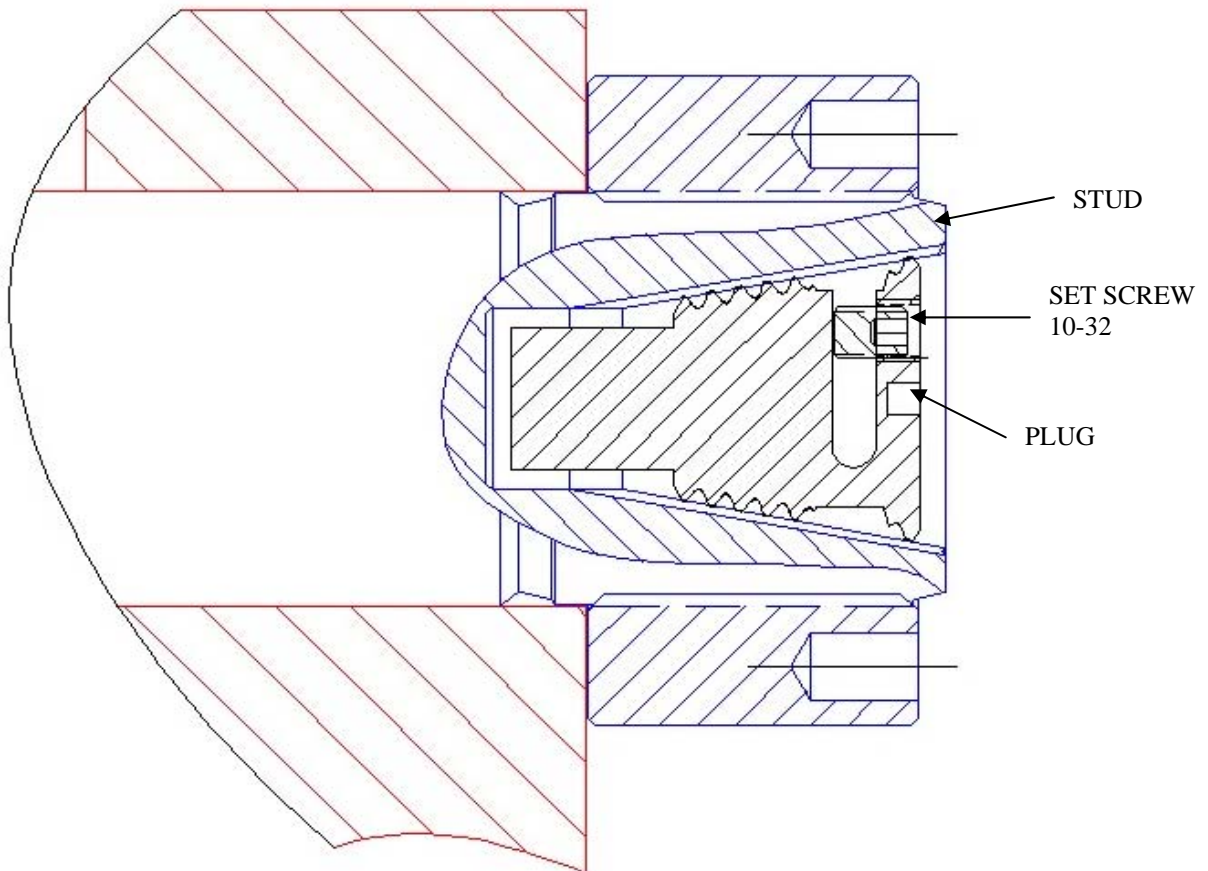
FIGURE 3



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**Frame 9F and 7F**

Windage/Balance Plug 6B or 6FA (HF-3503)  
1.125" Stud



1. Insert Windage Plug Fully, Tighten with screw driver firmly, making sure it is not cross threaded
2. Tighten Set Screws to 25-35 in-lbs Torque
3. Caution Plug must rest a minimum of .06" (1.5 mm) below the face of the stud

FIGURE 4



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