

TECHNICAL BULLETIN

TB NO. 1024
REV. 0

**SUBJECT: Field Replacement for Compressor Cylinder Liners
without Flanges for all High Pressure W-Series Compressors**

PROBLEM: Improper installation can lead to incorrect interference fit and operational problems with high pressure compressor cylinders.

SOLUTION: If you are a Superior W-Series Compressor owner/operator with high pressure cylinders (ranging from 2-3/4" to 3-1/8"), you understand the importance of the proper installation and fit of the compressor cylinder's liner. As you may note, these liners are completely finished, with the exception they are oversized on the outside diameter.

More specifically, in order to provide the proper fit, it is necessary for the customer to perform the following procedure:

Step 1: Inspect the existing cylinder bore to ensure that it is round and straight (i.e. not tapered) are within .001", concentric in relationship to the packing bore within .005", and ground for a maximum of 32 RMS surface finish.

Step 2: Measure the outside diameter (O.D.) of the compressor liner and the internal diameter (I.D.) of the cylinder bore. Calculate the amount of material to be removed via grinding from the liner O.D. to provide a .004" to .006" interference fit. Note that when grinding the liner, the O.D. must be held concentric within .002" in relation to liner bore I.D. and maintain a maximum of 32 RMS surface finish.

Step 3: Once the liner is installed, the lube oil holes' alignment should be confirmed and re-drilled as necessary.

For further information or questions concerning the installation of these type of liners or for the appropriate tools to assist in assembly, please contact **EnDyn's** Technical Service Department or your local **EnDyn PowerParts®** Distributor.

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