

3-PIECE SPLIT

(HIGH TEMP GENERATOR - LOW TEMP GEN/COND - EVAP/ABS)



TWO & THREE PIECE UNIT - CONNECTIONS				
CONNECTION (BALLON #)	RESPONSIBILITIES - FOR VARIOUS SHIPPING OPTIONS			
	FACTORY		CONTRACTOR (JOBSITE)	
	DAUF & EAUF ONLY	DDU & EDU ONLY	DISASSEMBLY DAUF & EAUF ONLY	REASSEMBLY ALL
PIPING				
2	PROVIDE A TEST WELD AT EACH JOINT FOR TESTING & SHIPMENT SEE NOTE 1	PROVIDE A TEST WELD AT EACH JOINT FOR TESTING, AFTER ALL TESTS ARE COMPLETE, REMOVE WELDS AND BREAK UNIT INTO 2 OR 3-PIECES FOR SHIPMENT ALL PIPE CONN'S ON EACH SECT TO BE CAPPED WITH A PLASTIC PLUG & TAPED SECURELY TO SEAL CONN FOR SHIPMENT SEE NOTE 1	REMOVE FILLET WELDS SEE DETAIL 'B' SEE NOTE 1	PROVIDE FILLET WELD AT EACH CONNECTION TYPE 4F WELD SEE NOTE 5
3				
4				
5				
6			REMOVE FILLET WELDS SEE DETAIL 'A' SEE NOTE 1	PROVIDE FILLET WELD AT EACH CONNECTION TYPE 2F WELD SEE NOTE 5
7				
8				
9				
10				
11				
12			REMOVE 4 - 5/8 DIA BOLTS, NUTS & GASKET UNSCREW 1/2" UNION	INSTALL GASKET, 4-5/8 DIA BOLTS, NUTS & JOIN 1/2" UNION
13				
ELECTRICAL				
	FACTORY - ALL SHIP OPTIONS		CONTRACTOR - REASSEMBLY	
4R1	REMOVE SENSORS FROM BULB WELL AND TAPE TO EVAP AT CONVENIENT LOCATION SEE NOTE 2	CONTRACTOR NO FIELD DISASSEMBLY REQUIRED	INSTALL SENSORS USING HEAT CONDUCTIVE LUBE. SENSORS (4RT17, 4RT18 & 4RT19 MUST BE COVERED WITH INSULATION PROVIDED IN LOOSE PARTS BOX	
4RT8				
4RT9				
4RT17				
4RT18				
4RT19				
4RT22				
CONDUIT S	DISCONNECT CONDUIT S & 4S17 (CABLE 3) AND ROLL UP & TAPE TO EVAP SEE NOTE 2		INSTALL CONDUIT S TO ENERGY VALVE 4B11 & CONN CABLE 3 (4S17) TO BPI SW, SEE DETAIL E	
4S17				
4S18	DISCONNECT CONDUIT V AND ROLL UP & TAPE TO EVAP, SEE NOTE 2			INSTALL CONDUIT V TO PRESS SW (4S18), SEE DETAIL D
CONDUITS E, AL & AM	DISCONNECT CONDUIT E, AL, AM, 4RT11 & 4S16 AT 4JB3 AND ROLL UP & TAPE TO EVAP SEE NOTE 2		INSTALL CONDUIT E, AL, AM, 4RT11 & 4S16 INTO 4JB3 SEE DETAIL 'D'	
4RT11				
4S16				

CONNECTION (BALLON #)		
	DAGF & EAGF ONLY	
TIE PLATES		
22	ASSEMBLE TIE PLATES	R
23		R
		PI

CONNECTION (BALLON #)		
	DAUF & EAUF ONLY	
PIPING		
1	PROVIDE A TEST WELD FOR TESTING & SHIPMENT SEE NOTE 1	PR TE A WE 3 PIF S
TIE PLATES		
20	ASSEMBLE TIE PLATES	R
21		RI
22		PI
23		PI

# FACTORY NOTES:

1. PREPARE UNIT. UNIT MAY BE S & REASSEMBLY SEE TABLE FOR
2. AFTER TESTING INDICATED IN 1 PROPER IDENT PLASTIC BAG A

REMOVE TEST WELD FOR DISASSEMBLY & SEE NOTE 5 FOR REASSEMBLY (TYPE 2F WELD)

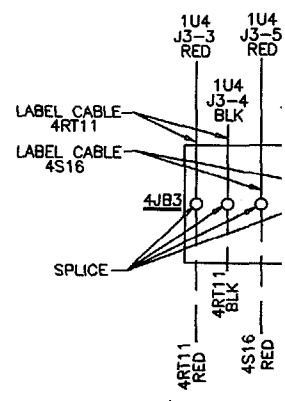


DETAIL 'A'

REMOVE TEST WELD FOR DISASSEMBLY & SEE NOTE 5 FOR REASSEMBLY (TYPE 4F WELD)



DETAIL 'B'



FACTORY

DET.

PURGE REFRIG JUNCT 2 & 3-

## TWO PIECE UNIT - CONNECTIONS

### RESPONSIBILITIES - FOR VARIOUS SHIPPING OPTIONS

FACTORY	CONTRACTOR (JOBSITE)	
DDG & EDG ONLY	DISASSEMBLY DAUF & EAUF ONLY	REASSEMBLY ALL
REMOVE 10 - 7/8 DIA BOLTS & NUTS REMOVE 4 - 1 1/4 DIA BOLTS & NUTS PLACE IN BAG AND PUT IN LOOSE PARTS BOX	REMOVE 10 - 7/8 DIA BOLTS & NUTS REMOVE 4 - 1 1/4 DIA BOLTS & NUTS	INSTALL 10 - 7/8 DIA BOLTS & NUTS INSTALL 4 - 1 1/4 DIA BOLTS & NUTS

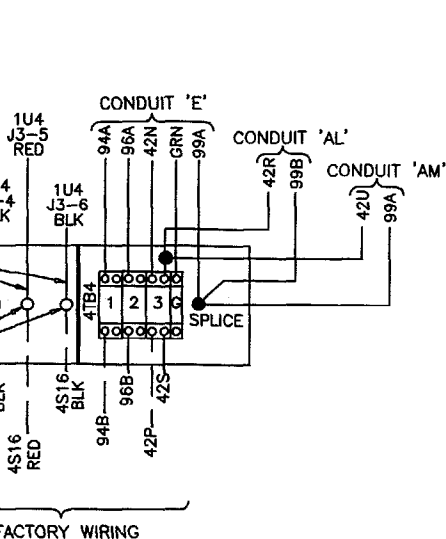
## THREE PIECE UNIT - CONNECTIONS

### RESPONSIBILITIES - FOR VARIOUS SHIPPING OPTIONS

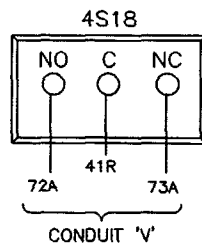
FACTORY	CONTRACTOR (JOBSITE)	
DDU & EDU ONLY	DISASSEMBLY DAUF & EAUF ONLY	REASSEMBLY ALL
PROVIDE A TEST WELD FOR TESTING, AFTER ALL TESTS ARE COMPLETE, REMOVE WELD AND BREAK UNIT INTO 3-PIECES FOR SHIPMENT, PIPE CONN'S ON EACH SECT TO BE CAPPED WITH A PLASTIC PLUG & TAPED SECURELY TO SEAL CONN FOR SHIPMENT SEE NOTE 1	GRIND OUT GROOVE WELDS SEE NOTE 1	PROVIDE GROOVE WELD AT EACH CONNECTION TYPE 5G WELD SEE NOTE 5
REMOVE 15 - 7/8 DIA BOLTS & NUTS REMOVE 6 - 1 1/4 DIA BOLTS & NUTS PLACE IN BAG AND PUT IN LOOSE PARTS BOX	REMOVE 15 - 7/8 DIA BOLTS & NUTS REMOVE 6 - 1 1/4 DIA BOLTS & NUTS	INSTALL 15 - 7/8 DIA BOLTS & NUTS INSTALL 6 - 1 1/4 DIA BOLTS & NUTS

UNIT FOR SHIPPING, PER SALES ORDER REQUIREMENTS.  
BE SHIPPED AS AN ASSEMBLED UNIT FOR FIELD 2 OR 3 PIECE DISASSEMBLY  
OR AS A 2 OR 3 PIECE DISASSEMBLED UNIT FOR FIELD REASSEMBLY.  
SEE INSTRUCTIONS

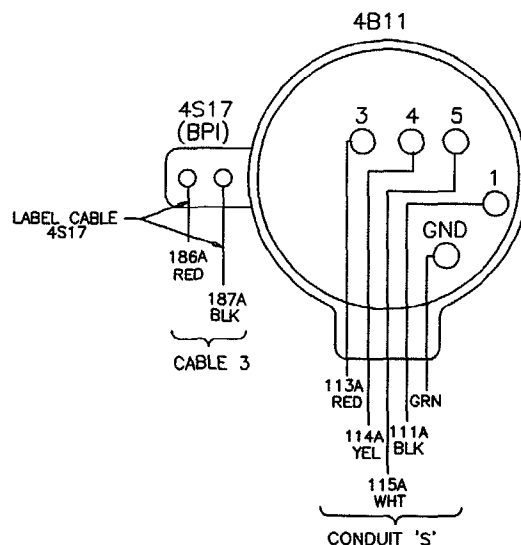
TESTING UNIT, DISCONNECT ELECTRICAL CONNECTIONS AND SENSORS AS  
SHOWN IN TABLES. TAG END OF ALL CONDUITS & SENSOR CABLES WITH  
IDENTIFICATION. COVER ALL CONDUITS & SENSOR ENDS WITH A  
CAP AND SECURE TO ENDS WITH TAPE.



**DETAIL 'D'**  
REFRIGERANT COMPRESSOR  
JUNCTION BOX  
& 3-PIECE SPLIT



**DETAIL 'D'**  
HI TEMP GEN - HI PRESSURE CUTOFF SW  
2 & 3-PIECE SPLIT



**DETAIL 'E'**  
STEAM ENERGY VALVE STEPPER  
2 & 3-PIECE SPLIT

IF UNITS TOLERANCE: TRAME STD ESH02002 UNLESS OTHERWISE SPECIFIED	CAD SCALE: PLY 1 SCALE: PLY 1 DRAWN BY: K. BREYER DATE: 4-3-96 SIMILAR TO:	TRAME COMPANY A DIVISION OF AMERICAN STANDARDS INC. 2630-1510 BREAK APART 2 OR 3 PIECE SECTIONS (SHEET 2 OF 2) ABTF ABSORPTION
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NOTE: SEE SHEET 2 FOR ALL DETAILS

### CONTRACTOR NOTES:

- UNITS THAT SHIP TO JOBSITE AS A FULLY ASSEMBLED UNIT, CONTRACTOR MUST FIRST BREAK VACUUM THEN DISASSEMBLE AND REASSEMBLE PER INSTRUCTIONS IN TABLE.  
UNITS THAT SHIP 2 OR 3 PIECE DISASSEMBLED, REQUIRE THE CONTRACTOR TO REASSEMBLE PER INSTRUCTIONS IN TABLE.  
REFER TO UNIT INSTALLATION MANUAL FOR SPECIFIC DETAILS.
- REFER TO TABLES AND FOLLOWING NOTES FOR DETAILS.
- USE FOUR POINT LIFT ON EACH SECTION.
- ALL PIPING WELDS MUST BE COMPLETED BY AN ASME OR AWS CERTIFIED WELDER TO INSURE A VACUUM TIGHT SEAL.
- WELD NOTES:
  - RECOMMENDED WELDING - STICK USING E7018 FILLER ROD OR TIG (GTAW) USING ER70S-6 ELECTRODE.
  - ALL GROOVE WELDS: - CARBON STEEL PIPE, ALL AROUND, FULL PENETRATION
  - ALL FILLET WELDS: - CARBON STEEL PIPE, ALL AROUND
    - 1/2" THRU 1 1/2" NPS = .10 FILLET
    - 2" THRU 4" NPS = .20 FILLET
    - GREATER THAN 4" NPS = .25 FILLET
  - CARE MUST BE TAKEN DURING WELD REMOVAL AND REWELDING TO INSURE THAT INTERIOR OF PIPING IS KEPT AS CLEAN AS POSSIBLE.
  - LEAK TEST USING 10 PSI NITROGEN AND A LEAK DETECTOR TO CONFIRM WELDS.