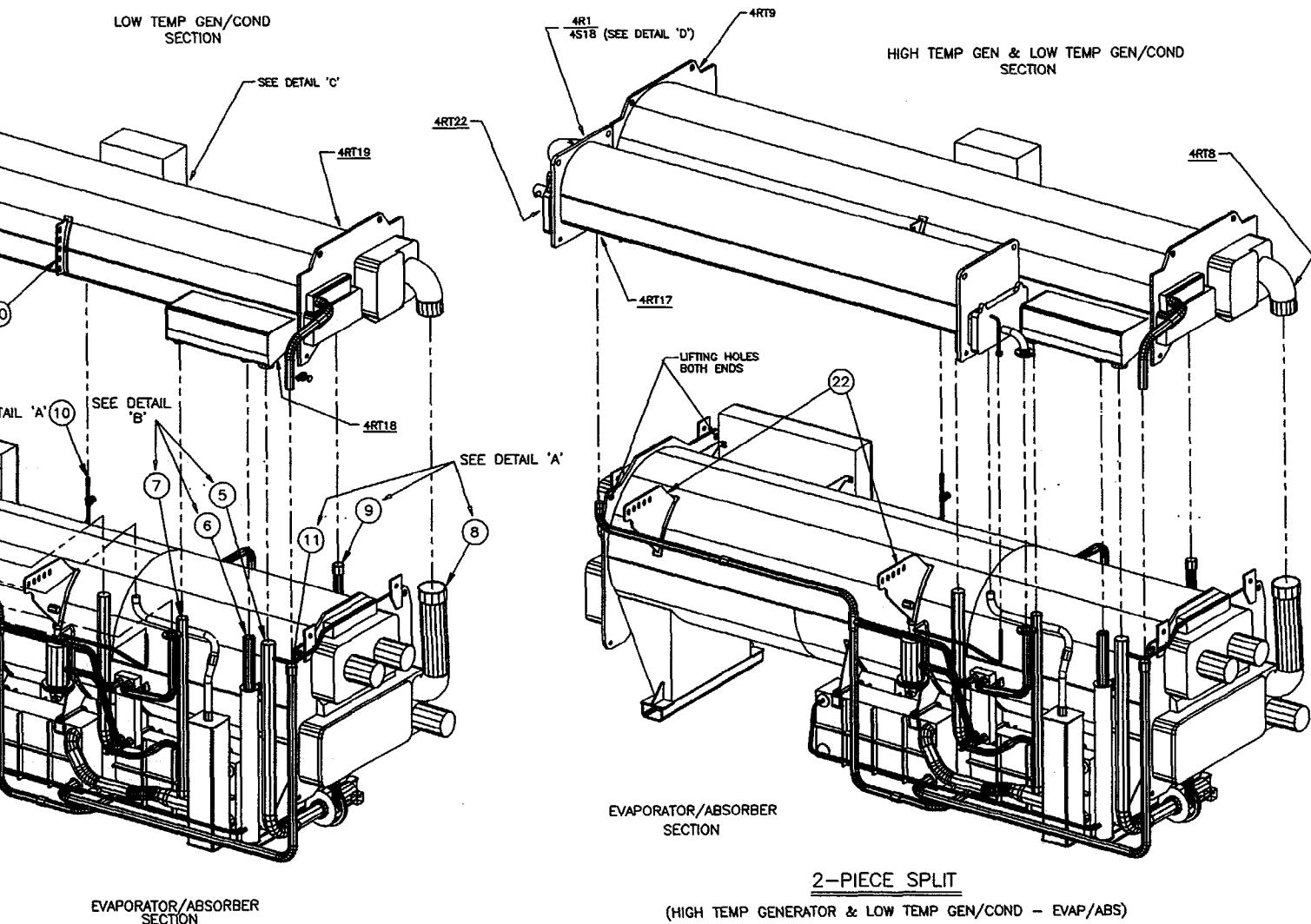


3-PIECE SPLIT

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

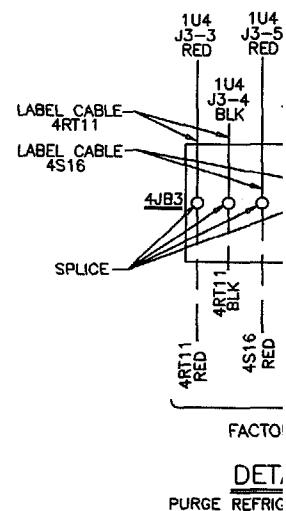
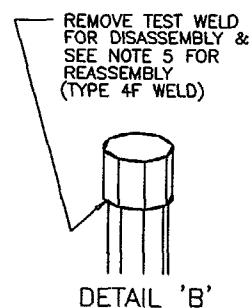
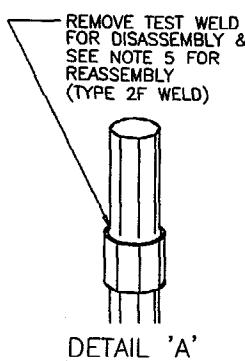


TWO & THREE PIECE UNIT - CONNECTIONS				
CONNECTION (BALLOON #)	RESPONSIBILITIES - FOR VARIOUS SHIPPING OPTIONS			
	FACTORY		CONTRACTOR (JOBSITE)	
DAUF & EAUF ONLY	DDU & EDU ONLY	DISASSEMBLY DAUF & EAUF ONLY	REASSEMBLY ALL	
PIPING				
2				
3				
4				
5				
6	PROVIDE A TEST WELD AT EACH JOINT FOR TESTING.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

CONNECTION (BALLOON #)			
	DAGF & EAGF ONLY		
TIE PLATES			
22	ASSEMBLE TIE PLATES	R	R
23		P	
PIPING			
1	PROVIDE A TEST WELD FOR TESTING & SHIPMENT SEE NOTE 1	P	T
20			
21			
22			
23			

FACTORY NOTES:

1. PREPARE UNIT  
UNIT MAY BE SHIPPED  
& REASSEMBLED  
SEE TABLE FOR DETAILS
2. AFTER TESTING  
INDICATED IN TABLE  
PROPER IDENTIFICATION  
PLASTIC BAG A



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 & TAPE  
SECURELY TO SEAL CONN  
FOR SHIPMENT  
SEE NOTE 1

GRIND OUT  
GROOVE WELDS  
SEE NOTE 1

PROVIDE GROOVE WELD  
AT EACH CONNECTION  
TYPE SG 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

IP UNITS TOLERANCE: TRAME STD EST102002  
UNLESS OTHERWISE SPECIFIED

X = ±  
.001 = ±  
.002 = ±  
.003 = ±  
ANGLES = ± \* HOLE DIA = ±  
REF. ANSI Y14.5M-1982

FINISH ✓

CAD  
SCALE  
PLT 1  
PM 1  
KODAK  
DATE 4-3-98  
SHEET 1 OF 1  
THIN ANGLE  
PROJECTION

THE TRAME COMPANY  
A DIVISION OF  
AMERICAN STANDARD INC.

REV A  
2630-1510  
BREAK APART  
2 OR 3 PIECE SECTIONS  
(SHEET 2 OF 2)  
ABTF ABSORPTION

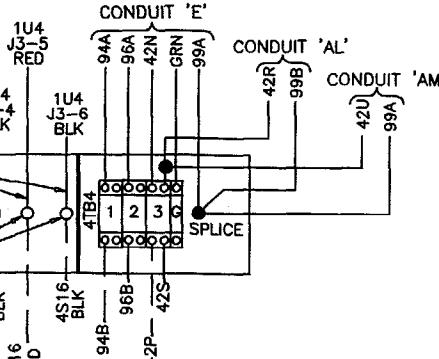
NOTE: SEE SHEET 2 FOR ALL DETAILS

CONTRACTOR NOTES:

1. 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.
2. REFER TO TABLES AND FOLLOWING NOTES FOR DETAILS.
3. USE FOUR POINT LIFT ON EACH SECTION.
4. ALL PIPING WELDS MUST BE COMPLETED BY AN ASME OR AWS  
CERTIFIED WELDER TO INSURE A VACUUM TIGHT SEAL.
5. WELD NOTES:
  - a. RECOMMENDED WELDING - STICK USING E7018 FILLER ROD OR  
TIG (GTAW) USING ER70S-6 ELECTRODE.
  - b. ALL GROOVE WELDS: - CARBON STEEL PIPE, ALL AROUND,  
FULL PENETRATION
  - c. 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
  - d. CARE MUST BE TAKEN DURING WELD REMOVAL AND REWELDING TO  
INSURE THAT INTERIOR OF PIPING IS KEPT AS CLEAN AS POSSIBLE.
  - e. LEAK TEST USING 10 PSI NITROGEN AND A LEAK DETECTOR TO  
CONFIRM WELDS.

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

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

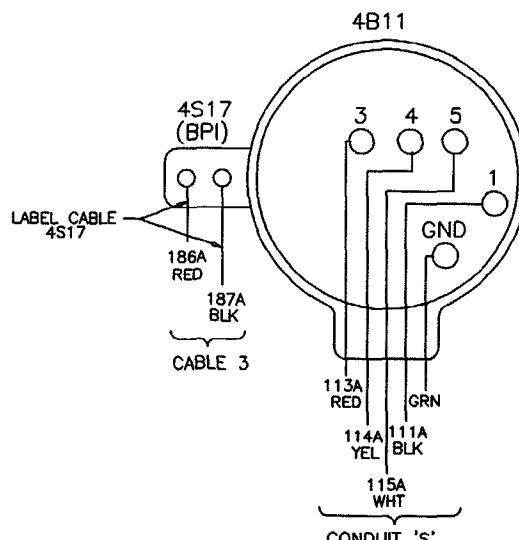


FACTORY WIRING

DETAIL 'D'

REFRIGERANT COMPRESSOR  
JUNCTION BOX  
& 3-PIECE SPLIT

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



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