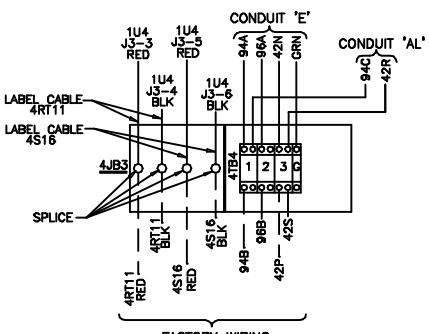
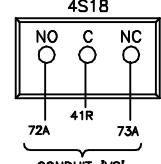


THREE PIECE UNIT - CONNECTIONS				
CONNECTION (BALLOON #)	RESPONSIBILITIES - FOR VARIOUS SHIPPING OPTIONS			
	FACTORY	CONTRACTOR (JOBSITE)		
DAUF & EAUF ONLY	DDU & EDU ONLY	DISASSEMBLY DAUF & EAUF ONLY	REASSEMBLY ALL	
PIPING				
1			GRIND OUT GROOVE WELDS SEE CONTRACTOR NOTE	PROVIDE GROOVE WELD AT EACH CONNECTION TYPE 5G WELD SEE CONTRACTOR NOTE 5
2				
3				
4				
5				
6			REMOVE FILLET WELDS SEE DETAIL 'B' SEE CONTRACTOR NOTE	PROVIDE FILLET WELD AT EACH CONNECTION TYPE 4F WELD SEE CONTRACTOR NOTE 5
7				
8				
9			REMOVE FILLET WELDS SEE DETAIL 'A' SEE CONTRACTOR NOTE	PROVIDE FILLET WELD AT EACH CONNECTION TYPE 2F WELD SEE CONTRACTOR NOTE 5
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				
TIE PLATES				
20	ASSEMBLE TIE PLATES	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
21				
22				
23				
ELECTRICAL				
4R1				
4R2				
4R3				
4RT8				
4RT9				
4RT17		REMOVE SENSORS FROM BULBWELLS AND TAPE TO EVAP AT CONVENIENT LOCATION SEE FACTORY NOTE 2		INSTALL SENSORS IN BULBWELLS USING HEAT CONDUCTIVE LUBE SENSORS (4RT17, 4RT18 & 4RT19) MUST BE COVERED WITH INSULATION PROVIDED IN LOOSE PARTS BOX
4RT18				
4RT19				
4RT22				
CONDUIT SS		DISCONNECT CONDUIT SS & 4S17 (CABLE 3) AND ROLL UP & TAPE TO EVAP SEE FACTORY NOTE 2	NO DISASSEMBLY REQUIRED	INSTALL CONDUIT SS TO ENERGY VALVE 4B11 & CANNABLE 3 (4S17) TO BPI SW, SEE DETAIL 'F'
4S17		DISCONNECT CONDUIT VS AND ROLL UP & TAPE TO EVAP, SEE FACTORY NOTE 2		INSTALL CONDUIT VS TO PRESS SW (4S18), SEE DETAIL 'D'
4S18				
CONDUITS E & AL		DISCONNECT CONDUIT E, AL, 4RT11 & 4S16 AT 4JB3 AND ROLL UP & TAPE TO EVAP SEE FACTORY NOTE 2		INSTALL CONDUIT E, AL, 4RT11 & 4S16 INTO 4JB3 SEE DETAIL 'C'
4RT11				
4S16				



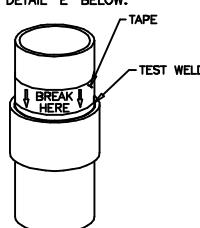
DFTAIU 'C'

PURGE REFRIGERANT COMPRESSOR
JUNCTION BOX
2 & 3-PIECE SPLIT



DETAIL 'D'

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

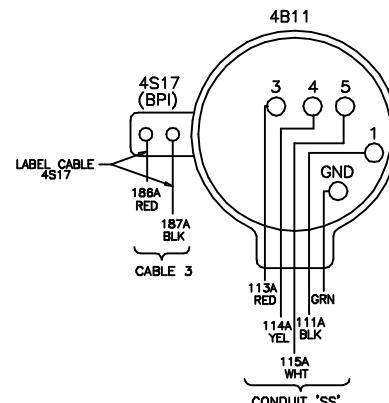


DETAIL 'E'

TWO PIECE UNIT - CONNECTIONS				
CONNECTION (BALLON #)	RESPONSIBILITIES - FOR VARIOUS SHIPPING OPTIONS			
	FACTORY	DDG & EDG ONLY	DISASSEMBLY DAGF & EAGF ONLY	REASSEMBLY ALL
2	PROVIDE A TEST WELD AT EACH JOINT FOR TESTING & SHIPMENT SEE FACTORY NOTES 1 & 3	PROVIDE A TEST WELD AT EACH JOINT FOR TESTING & SHIPMENT SEE FACTORY NOTES 1 & 3	REMOVE FILLET WELDS SEE DETAIL 'B' SEE CONTRACTOR NOTE 1	PROVIDE FILLET WELD AT EACH CONNECTION TYPE 4F WELD SEE CONTRACTOR NOTE 5
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
TIE PLATES				
22	ASSEMBLE TIE PLATES	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 4-5/8 DIA BOLTS, NUTS & JOIN 1/2" UNION
23				
ELECTRICAL				
4R1	REMOVE SENSORS FROM BULBWELLS AND TAPE TO EVAP AT CONVENIENT LOCATION SEE FACTORY NOTE 2	NO DISASSEMBLY REQUIRED	INSTALL SENSORS IN BULBWELLS USING HEAT CONDUCTIVE LUBE, SENSORS (4R17, 4RT18 & 4RT19) MUST BE COVERED WITH INSULATION PROVIDED IN LOOSE PARTS BOX	
4R2				
4R3				
4RT8				
4RT9				
4RT17				
4RT18				
4RT19				
4RT22				
CONDUIT SS				
4S17				
4S18				
CONDUITS E & AL	DISCONNECT CONDUIT SS & 4S17 (CABLE 3) AND ROLL UP & TAPE TO EVAP SEE FACTORY NOTE 2	NO DISASSEMBLY REQUIRED	INSTALL CONDUIT SS TO ENERGY VALVE 4B11 & CONN CABLE 3 (4S17) TO BPI SW, SEE DETAIL 'F'	
4RT11				
4S16				
4S18				
CONDUITS E & AL	DISCONNECT CONDUIT E, AL, 4RT11 & 4S16 AT 4JB3 AND ROLL UP & TAPE TO EVAP SEE FACTORY NOTE 2		INSTALL CONDUIT E, AL 4RT11 & 4S16 INTO 4JB3 SEE DETAIL 'C'	
4S16				

FACTORY NOTES:

1. PREPARE UNIT FOR SHIPPING, PER SALES ORDER REQUIREMENTS.
UNIT MAY BE SHIPPED AS AN ASSEMBLED UNIT FOR FIELD 2 OR 3 PIECE DISASSEMBLY & REASSEMBLY OR AS A 2 OR 3 PIECE DISASSEMBLED UNIT FOR FIELD REASSEMBLY.
SEE TABLE FOR INSTRUCTIONS
2. AFTER TESTING UNIT, DISCONNECT ELECTRICAL CONNECTIONS AND SENSORS AS INDICATED IN TABLES. TAG END OF ALL CONDUITS & SENSOR CABLES WITH PROPER IDENTIFICATION. COVER ALL CONDUITS & SENSOR ENDS WITH A PLASTIC BAG AND SECURE TO ENDS WITH TAPE.
3. FOR UNITS THAT SHIP ASSEMBLED (DAUF, EAUF, DAGF, EAGF), IDENTIFY ALL BREAK APART PIPING JOINTS AS DEFINED IN TABLE BY APPLYING TAPE AROUND THE WHOLE JOINT, (CODE X39001214-01) SEE DETAIL "E" BELOW.



DETAIL 'E'

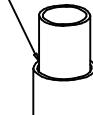
DETAIL 1
STEAM ENERGY VALVE STEPPER
2 & 3-PIECE SPLIT

CONTRACTOR NOTES:

- 1. UNITS THAT SHIP ASSEMBLED**
CONTRACTOR MUST FIRST BREAK VACUUM THEN DISASSEMBLE AND REASSEMBLE. ALL PIPE JOINTS TO BE BROKEN ARE IDENTIFIED WITH WHITE TAPE INDICATING THE WELD TO BE REMOVED. SEE DETAIL "E" BELOW.
- UNITS THAT SHIP DISASSEMBLED (2 OR 3 PIECE)**
CONTRACTOR TO REASSEMBLE UNIT.
- 2. REFER TO THIS DRAWING (SHEETS 1 & 2) FOR GENERAL INFORMATION.**
REFER TO UNIT INSTALLATION MANUAL FOR SPECIFIC STEP BY STEP INSTRUCTIONS.
- 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. ALSO CARE MUST BE TAKEN TO PROTECT SENSOR WIRING AND ELECTRICAL CONDUIT FROM GRINDING AND WELDING DAMAGE.**
 - e. LEAK TEST USING 10 PSI NITROGEN AND A LEAK DETECTOR TO CONFIRM WELDS**

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0.0000000298023223876953125	0.0000000298023223876953125	REF. 23	NOTES ARE THE PROPERTY OF AMERICAN MANUFACTURED INC.

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



DETAIL 'A'

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



DETAIL 'B'

CONTRACTOR BREAK APART PIPING JOINTS

