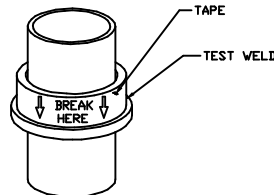


THREE PIECE UNIT - CONNECTIONS					
CONNECTION (BALLON #)	RESPONSIBILITIES - FOR VARIOUS SHIPPING OPTIONS				
	FACTORY		CONTRACTOR (JOBSITE)		
	DAUF & EAUF ONLY	DDU & EDU ONLY	DISASSEMBLY DAUF & EAUF ONLY	REASSEMBLY ALL	
PIPING					
1 (2X)	PROVIDE A TEST WELD AT EACH JOINT FOR TESTING. AFTER ALL TEST ARE COMPLETE, REMOVE WELDS AND BREAK UNIT INTO 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 FACTORY NOTES 1 & 3		GRIND OUT GROOVE WELDS SEE CONTRACTOR NOTE 1	PROVIDE GROOVE WELD AT EACH CONNECTION TYPE 5G WELD SEE CONTRACTOR NOTE 6	
2			REMOVE FILLET WELDS SEE DETAIL 'A' SEE CONTRACTOR NOTE 1	PROVIDE FILLET WELD AT EACH CONNECTION TYPE 2F WELD SEE CONTRACTOR NOTE 6	
3					
4			REMOVE FILLET WELDS SEE DETAIL 'B' SEE CONTRACTOR NOTE 1	PROVIDE FILLET WELD AT EACH CONNECTION TYPE 4F WELD SEE CONTRACTOR NOTE 6	
5					
6			REMOVE FILLET WELDS SEE DETAIL 'C' SEE CONTRACTOR NOTE 1	PROVIDE FILLET WELD AT EACH CONNECTION TYPE 2F WELD SEE CONTRACTOR NOTE 6	
7					
8					
9					
10					
11					
16					
TIE PLATES					
20	ASSEMBLE TIE PLATES	REMOVE 18 - 7/8 DIA BOLTS & NUTS	REMOVE 18 - 7/8 DIA BOLTS & NUTS	INSTALL 18 - 7/8 DIA BOLTS & NUTS	
21		REMOVE 4 - 1 1/4 DIA BOLTS & NUTS	REMOVE 4 - 1 1/4 DIA BOLTS & NUTS	INSTALL 4 - 1 1/4 DIA BOLTS & NUTS	
22		REMOVE 4 - 1 1/4 DIA BOLTS & NUTS	REMOVE 4 - 1 1/4 DIA BOLTS & NUTS	INSTALL 4 - 1 1/4 DIA BOLTS & NUTS	
23		REMOVE 4 - 1 1/4 DIA BOLTS & NUTS	REMOVE 4 - 1 1/4 DIA BOLTS & NUTS	INSTALL 4 - 1 1/4 DIA BOLTS & NUTS	
ELECTRICAL					
4R1	REMOVE SENSORS FROM BULBVELLS AND TAPE TO EVAP AT CONVENIENT LOCATION SEE FACTORY NOTE 2	NO DISASSEMBLY REQUIRED		INSTALL SENSORS IN BULBVELLS USING HEAT CONDUCTIVE LUBE. SENSORS (4RT18 & 4RT19) MUST BE COVERED WITH INSULATION PROVIDED IN LOOSE PARTS BOX	
4RT5					
4RT9					
4RT18					
4RT19					
4RTD1	REMOVE WIRES @ BCP 3TB1-57 & 3TB1-58 & TAPE TO GEN SEE FACTORY NOTE 2			INSTALL WIRES IN BCP TO 3TB1-57 (VHT) & 3TB1-58 (RED). SEE DETAIL 'K'	
4TC1	REMOVE WIRES @ 4JB4, 4U3-TC+ & 4U3-TC- & TAPE TO GEN SEE FACTORY NOTE 2			INSTALL WIRES IN 4JB4 TO 4U3-TC+ (RED) & 4U3-TC- (VHT) SEE DETAIL 'G'	
CONDUITS V, Y & AA	DISCONNECT CONDUITS AT BURNER & ROLL UP & ATTACH TO EVAP SEE FACTORY NOTE 2			INSTALL CONDUITS SEE DETAILS 'L', 'M' OR 'N' (SEE S.O. FOR CORRECT VARIATION)	
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 'D'
4RT11					
4S16					

TWO PIECE UNIT - CONNECTIONS				
RESPONSIBILITIES - FOR VARIOUS SHIPPING OPTIONS				
CONNECTION (BALLON #)	FACTORY		CONTRACTOR (JOBSITE)	
	DAGF & EAGF ONLY	DDG & EDG ONLY	DISASSEMBLY DAGF & EAGF ONLY	REASSEMBLY ALL
PIPING				
1 (2X)	PROVIDE A TEST WELD AT EACH JOINT FOR TESTING. AFTER ALL TESTS ARE COMPLETE, REMOVE WELDS AND BREAK UNIT INTO 2-PIECES FOR SHIPMENT. ALL PIPE CONNS ON EACH SECT TO BE CAPPED WITH A PLASTIC PLUG & TAPED SECURELY TO SEAL CONN FOR SHIPMENT. SEE FACTORY NOTE 1		GRIND OUT GROOVE WELDS SEE CONTRACTOR NOTE 1	PROVIDE GROOVE WELD AT EACH CONNECTION TYPE 5G WELD SEE CONTRACTOR NOTE 6
2			REMOVE FILLET WELDS SEE DETAIL 'A' SEE CONTRACTOR NOTE 1	PROVIDE FILLET WELD AT EACH CONNECTION TYPE 2F WELD SEE CONTRACTOR NOTE 6
3				
4				
TIE PLATES				
20	ASSEMBLE TIE PLATES	REMOVE 18 - 7/8 DIA BOLTS & NUTS PLACE IN BAG AND PUT IN LOOSE PARTS BOX	REMOVE 18 - 7/8 DIA BOLTS & NUTS	INSTALL 18 - 7/8 DIA BOLTS & NUTS
21				
22				
ELECTRICAL				
4RT5	REMOVE SENSOR FROM BULBVELL AND TAPE TO EVAP AT CONVENIENT LOCATION SEE FACTORY NOTE 2	NO DISASSEMBLY REQUIRED		INSTALL SENSOR IN BULBVELL USING HEAT CONDUCTIVE LUBE.
4RTD1	REMOVE WIRES @ BCP 3TB1-57 & 3TB1-58 & TAPE TO CONN SEE FACTORY NOTE 2			INSTALL WIRES IN BCP TO 3TB1-57 (VHT) & 3TB1-58 (RED) SEE DETAIL 'K'
4TC1	REMOVE WIRES @ 4J84, 4U3-TC+ & 4U3-TC- & TAPE TO CONN SEE FACTORY NOTE 2			INSTALL WIRES IN 4J84 TO 4U3-TC- (RED) & 4U3-TC- (VHT) SEE DETAIL 'G'
CONDUITS V, Y & AA	DISCONNECT CONDUITS AT BURNER & ROLL UP & ATTACH TO EVAP SEE FACTORY NOTE 2			INSTALL CONDUITS SEE DETAILS 'L', 'M' OR 'N' (SEE S.D. FOR CORRECT VARIATION)

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 ENTIRE JOINT. (CODE X39001214-01) SEE DETAIL 'E' BELOW.



DETAIL 'E'

UNLESS OTHERWISE SPECIFIED		CAD	FILE TRANSFER COMPANY	2630-1525	C
X = 2	SCALE	PLT 1	ASSEMBLY	BREAK APART	
Y = 2	SCALE	PLT 1	ASSEMBLY	2 OR 3 PIECE SECTIONS	
Z = 2	SCALE	PLT 1	ASSEMBLY	(SHEET 1 OF 3)	
ANNOLES = 2	* HOLE DIA = 2	SCALE	PLT 1	ASSEMBLY	
REF. ANNO 114-24-1982		SCALE	PLT 1	ASSEMBLY	

CONTRACTOR NOTES:

1. UNITS THAT SHIP ASSEMBLED.
CONTRACTOR MUST FIRST BREAK VACUUM THEN DISASSEMBLE AND REASSEMBLE UNIT. 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 & 3) FOR GENERAL INFORMATION. REFER TO UNIT INSTALLATION MANUAL FOR SPECIFIC STEP BY STEP INSTRUCTIONS.
3. USE FOUR POINT LIFT ON EACH SECTION.
4. FOR 3 PIECE UNIT, THE DIRECT FIRED GENERATOR SECTION MUST BE DISASSEMBLED BEFORE AND REASSEMBLED AFTER THE GENERATOR/CONDENSER SECTION.
5. ALL PIPING WELDS MUST BE COMPLETED BY AN ASME OR AWS CERTIFIED WELDER TO INSURE A VACUUM TIGHT SEAL.
6. 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.

