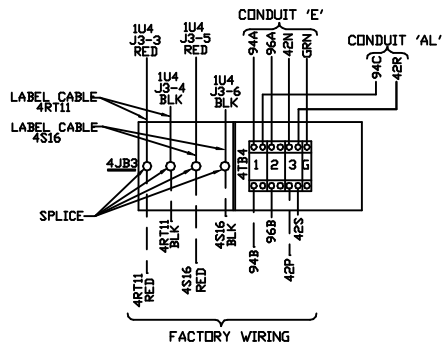
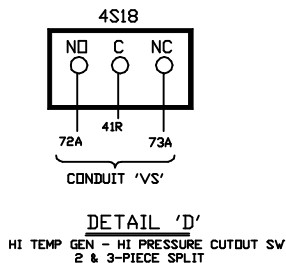


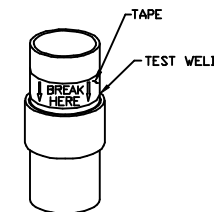
THREE PIECE UNIT - CONNECTIONS				
CONNECTION (BALLON #)	RESPONSIBILITIES - FOR VARIOUS SHIPPING OPTIONS			
	FACTORY		CONTRACTOR (JOBSITE)	
	DAUF & EAUF ONLY	DDU & EDU ONLY	DISASSEMBLY DAUF & EAUF ONLY	REASSEMBLY ALL
PIPING				
1	PROVIDE A TEST WELD AT EACH JOINT FOR TESTING. AFTER ALL TESTS ARE COMPLETE, 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 AT EACH CONNECTION. PROVIDE GROOVE WELD AT EACH CONNECTION TYPE 5G WELD. SEE CONTRACTOR NOTE 5	REMOVE FILLET WELDS AT EACH CONNECTION TYPE 4F WELD. SEE CONTRACTOR NOTE 5	REMOVE FILLET WELD AT EACH CONNECTION TYPE 2F WELD. SEE CONTRACTOR NOTE 5
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
TIE PLATES				
20	ASSEMBLE TIE PLATES	REMOVE 20 - 7/8 DIA BOLTS & NUTS	REMOVE 20 - 7/8 DIA BOLTS & NUTS	INSTALL 20 - 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 BULBWELLS AND TAPE TO EVAP AT CONVENIENT LOCATION. SEE FACTORY NOTE 2	DISCONNECT CONDUIT SS & 4S17 (CABLE 3) AND ROLL UP & TAPE TO EVAP. SEE FACTORY NOTE 2	NO DISASSEMBLY REQUIRED	INSTALL SENSORS IN BULBWELLS USING HEAT CONDUCTIVE LUBE. SENSORS (4RT17, 4RT18 & 4RT19) MUST BE COVERED WITH INSULATION PROVIDED IN LOOSE PARTS BOX
4R2				
4R3				
4RT8				
4RT9				
4RT17				
4RT18				
4RT19				
4RT22				
CONDUIT SS				
4S17	INSTALL CONDUIT VS TO PRESS SW (4S18), SEE DETAIL 'D'			
4S18	INSTALL CONDUIT E, AL, 4RT11 & 4S16 INTO 4JB3. SEE DETAIL 'C'			
CONDUITS E & AL				
4RT11				
4S16				



DETAIL 'C'
PURGE REFRIGERANT COMPRESSOR
JUNCTION BOX
2 & 3-PIECE SPLIT



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



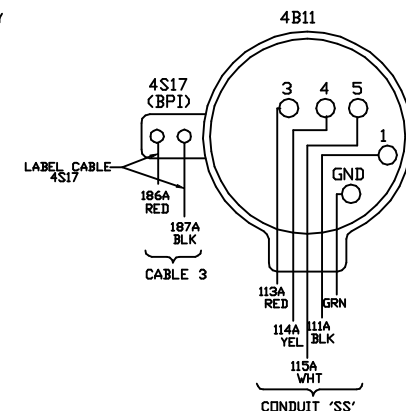
DETAIL 'E'

TWO PIECE UNIT - CONNECTIONS				
CONNECTION (BALLON #)	RESPONSIBILITIES - FOR VARIOUS SHIPPING OPTIONS			
	FACTORY		CONTRACTOR (JOBSITE)	
	DAFG & EAGF ONLY	DDG & EDG ONLY	DISASSEMBLY DAFG & EAGF ONLY	REASSEMBLY ALL
2	PROVIDE A TEST WELD AT EACH JOINT FOR TESTING & BREAK UNIT INTO 2-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	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 CONN'S ON EACH SECT TO BE CAPPED WITH A PLASTIC PLUG & TAPED SECURELY TO SEAL CONN FOR SHIPMENT. SEE FACTORY NOTE 1	REMOVE FILLET WELDS SEE DETAIL 'B' SEE CONTRACTOR NOTE 1	REMOVE FILLET WELD AT EACH CONNECTION TYPE 4F WELD SEE CONTRACTOR NOTE 5
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
13				
14				
TIE PLATES				
22	ASSEMBLE TIE PLATES	REMOVE 15 - 7/8 DIA BOLTS & NUTS	REMOVE 15 - 7/8 DIA BOLTS & NUTS	INSTALL 15 - 7/8 DIA BOLTS & NUTS
23		REMOVE 4 - 1 1/4 DIA BOLTS & NUTS PLACE IN BAG AND PUT IN LOOSE PARTS BOX	REMOVE 4 - 1 1/4 DIA BOLTS & NUTS	INSTALL 4 - 1 1/4 DIA BOLTS & NUTS
ELECTRICAL				
4R1	REMOVE SENSORS FROM BULBWELLS AND TAPE TO EVAP AT CONVENIENT LOCATION SEE FACTORY NOTE 2	INSTALL SENSORS IN BULBWELL USING HEAT CONDUCTIVE LUBE. SENSORS (4RT17, 4RT18 & 4RT19) MUST BE COVERED WITH INSULATION PROVIDED IN LOOSE PARTS BOX	NO DISASSEMBLY REQUIRED	INSTALL CONDUIT SS TO ENERGY VALVE 4B11 & CONN CABLE 3 (4S17) TO BPI SW. SEE DETAIL 'F'
4R2				
4R3				
4RT8				
4RT9				
4RT17				
4RT18				
4RT19				
4RT22				
CONDUIT SS				
4S17	DISCONNECT CONDUIT SS & 4S17 (CABLE 3) AND ROLL UP & TAPE TO EVAP SEE FACTORY NOTE 2	INSTALL CONDUIT VS TO PRESS SW (4S18), SEE DETAIL 'D'		
4S18	DISCONNECT CONDUIT VS AND ROLL UP & TAPE TO EVAP, SEE FACTORY NOTE 2	INSTALL CONDUIT VS TO PRESS SW (4S18), SEE DETAIL 'D'		
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				

- FACTORY NOTES:**
- PREPARE UNIT FOR SHIPPING, PER SALE'S 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
 - 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.
 - 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.

IF UNITS TOLERANCE TRAILER STD 10102002 UNLESS OTHERWISE SPECIFIED		CAD	THIS TRANS COMPANY	2630-1526
SCALE	1" = 1'	1" = 1'	1" = 1'	1" = 1'
DATE	10-1-98	DATE	10-1-98	DATE
REV. A001		REV. A001		REV. A001
ANGLER	0	HOLE DIA	0	0
REF. ANSI	Y14.5M-1982	REF. ANSI	Y14.5M-1982	REF. ANSI

- CONTRACTOR NOTES:**
- 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.
 - REFER TO THIS DRAWING (SHEETS 1 & 2) FOR GENERAL INFORMATION. REFER TO UNIT INSTALLATION MANUAL FOR SPECIFIC STEP BY STEP INSTRUCTIONS.
 - 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. ALSO CARE MUST BE TAKEN TO PROTECT SENSOR WIRING AND ELECTRICAL CONDUIT FROM GRINDING AND WELDING DAMAGE.
 - LEAK TEST USING 10 PSI NITROGEN AND A LEAK DETECTOR TO CONFIRM WELDS.



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

IF UNITS TO BE DRAWN, THESE SHD. BE ENTERED UNLESS OTHERWISE SPECIFIED		CAD	THIS FIRM'S COMPANY	2630-1526	B C
JL = 1/8" JOK = 1/4" JOKK = 3/8"	FINISH ✓	SCALE 1/2" = 1'-0" DATE 10-1-95	A DIVISION OF HARRIS ENGINEERING INC. _____ 		

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



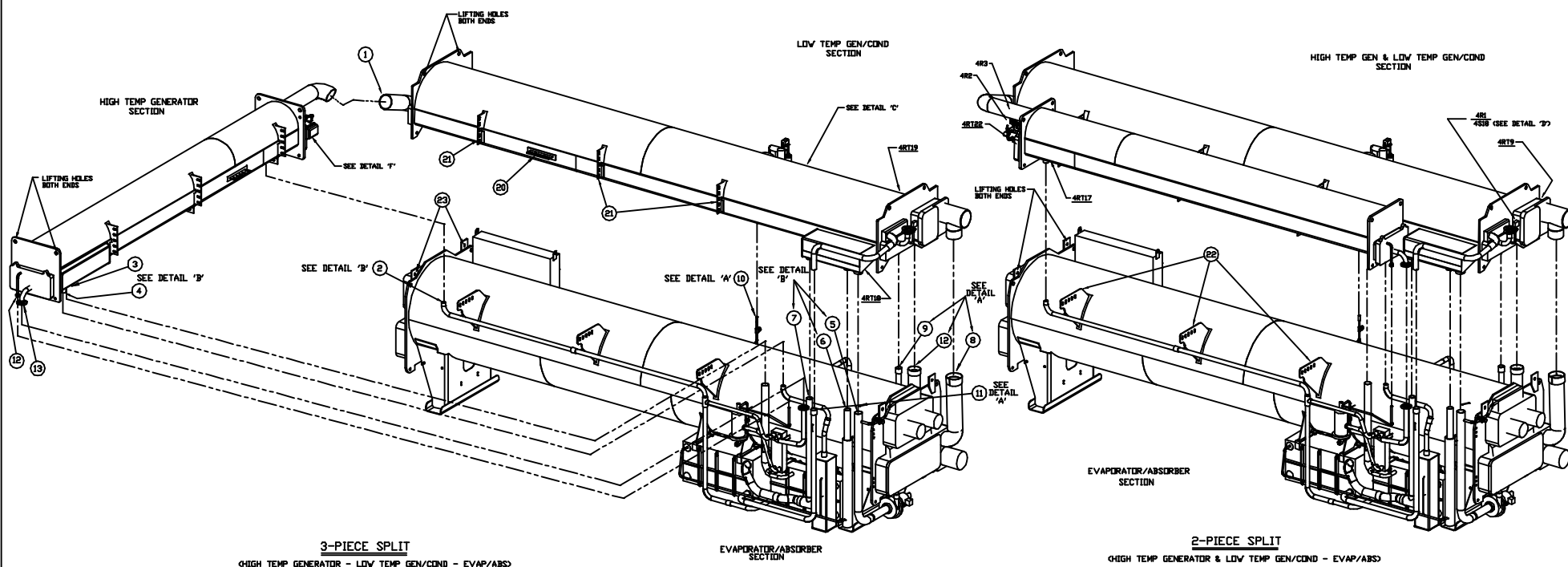
DETAIL 'A'

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



DETAIL 'B'

CONTRACTOR BREAK APART PIPING JOINTS



3-PIECE SPLIT

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

EVAPORATOR/ABSORBER SECTION

2-PIECE SPLIT

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