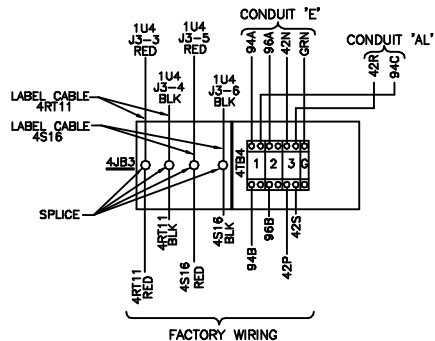
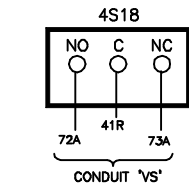


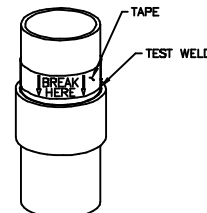
THREE PIECE UNIT – CONNECTIONS				
CONNECTION (BALLON #)	RESPONSIBILITIES – FOR VARIOUS SHIPPING OPTIONS			
	FACTORY		CONTRACTOR (JOBSITE)	
	DAUF & EAUF ONLY	DDU & EDU ONLY	DISASSEMBLY DAUF & EAUF ONLY	REASSEMBLY ALL
PIPING				
1	PROVIDE A TEST WELD AT EACH JOINT FOR TESTING. AFTER ALL TESTS ARE COMPLETE, 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 SEE CONTRACTOR NOTE 1	PROVIDE GROOVE WELD AT EACH CONNECTION TYPE 5G WELD SEE CONTRACTOR NOTE 5	
2				
3				
4			PROVIDE FILLET WELD AT EACH CONNECTION TYPE 4F WELD SEE CONTRACTOR NOTE 5	
5				
6				
7				
8				
9			PROVIDE FILLET WELD AT EACH CONNECTION TYPE 2F WELD SEE CONTRACTOR NOTE 5	
10				
11				
12				
13				
14			REMOVE 4 – 5/8 DIA BOLTS, NUTS & GASKET UNSCREW 1/2" UNION	
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		PLACE IN BAG AND PUT IN LOOSE PARTS BOX		
ELECTRICAL				
4R1	UNPLUG CABLES FROM TRANSDUCERS AND TAPE TO EVAP AT CONVENIENT LOCATION SEE FACTORY NOTE 2		NO DISASSEMBLY REQUIRED	PLUG CABLES INTO TRANSDUCERS (4R1, 4R2 & 4R3)
4R2				
4R3				
4RT9				
4RT17				
4RT18				INSTALL SENSORS IN BULBWELLS USING HEAT CONDUCTIVE LUBE. SENSORS (4RT17, 4RT18 & 4RT19) MUST BE COVERED WITH INSULATION PROVIDED IN LOOSE PARTS BOX
4RT19				
4RT22				
CONDUIT SS	DISCONNECT CONDUIT SS & 4S17 (CABLE 3) AND ROLL UP & TAPE TO EVAP SEE FACTORY NOTE 2			INSTALL CONDUIT SS TO ENERGY VALVE 4B11 & CONN CABLE 3 (4S17) TO BPI SW. SEE DETAIL 'F'
4S17				
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				



PURGE REFRIGERANT COMPRESSOR JUNCTION BOX 2 & 3-PIECE SPLIT



HI TEMP GEN – HI PRESSURE CUTOFF SW 2 & 3-PIECE SPLIT



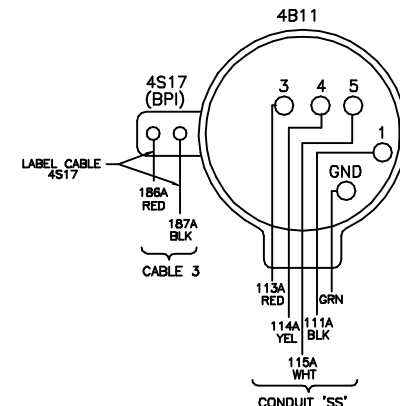
DETAIL 'E'

- FACTORY NOTES:
- 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
 - 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.

TWO PIECE UNIT – CONNECTIONS				
CONNECTION (BALLON #)	RESPONSIBILITIES – FOR VARIOUS SHIPPING OPTIONS			
	FACTORY		CONTRACTOR (JOBSITE)	
	DAGF & EAGF ONLY	DDG & EDG ONLY	DISASSEMBLY DAGF & EAGF ONLY	REASSEMBLY ALL
2	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 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	PROVIDE 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 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	UNPLUG CABLES FROM TRANSDUCERS AND TAPE TO EVAP AT CONVENIENT LOCATION SEE FACTORY NOTE 2		NO DISASSEMBLY REQUIRED	PLUG CABLES INTO TRANSDUCERS (4R1, 4R2 & 4R3)
4R2				
4R3				
4RT9				
4RT17				
4RT18	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 (4RT17, 4RT18 & 4RT19) MUST BE COVERED WITH INSULATION PROVIDED IN LOOSE PARTS BOX
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 & CONN CABLE 3 (4S17) TO BPI SW. SEE DETAIL 'F'
4S17				
4S18				
DISCONNECT CONDUIT VS AND ROLL UP & TAPE TO EVAP, SEE FACTORY NOTE 2		DISCONNECT CONDUIT VS AND ROLL UP & TAPE TO EVAP, SEE FACTORY NOTE 2	NO DISASSEMBLY REQUIRED	INSTALL CONDUIT VS TO PRESS SW (4S18), SEE DETAIL 'D'
CONDUITS E & AL				
4RT11				
4S16	DISCONNECT CONDUIT E, AL, 4RT11 & 4S16 AT 4JB3 AND ROLL UP & TAPE TO EVAP SEE FACTORY NOTE 2		NO DISASSEMBLY REQUIRED	INSTALL CONDUIT E, AL, 4RT11 & 4S16 INTO 4JB3 SEE DETAIL 'C'
4RT11				
4S16				

IF UNITS TO BE SHIPPED, TRANS. STD. ENHANCED UNLESS OTHERWISE SPECIFIED	ALTOGAD DO NOT SCALE PRINT	THIS DRAWING COMPANY 2630-1543	BREAK APART 2 OR 3 PIECE SECTIONS (SHEET 1 OF 3) ASST 600-1150 10N ABSORPTION
UNITS TO BE SHIPPED, TRANS. STD. ENHANCED UNLESS OTHERWISE SPECIFIED	DO NOT SCALE PRINT	2630-1543	BREAK APART 2 OR 3 PIECE SECTIONS (SHEET 1 OF 3) ASST 600-1150 10N ABSORPTION

- 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.



STEAM ENERGY VALVE STEPPER 2 & 3-PIECE SPLIT

DETAIL 'A'

DETAIL 'B'

CONTRACTOR BREAK APART PIPING JOINTS

IF UNIT'S TELEGRAPHED, THESE TWO SECTIONS UNLESS OTHERWISE SPECIFIED J. = 1/2 JX = 3/8 JOK = 1/2 ANGLE = 1/2 * HOLE DIA = 1/2 FINISH ✓	ALYDOND DO NOT SCALE PRINT DRAWN BY K. MEYER DATE 2-18-67 SCALE 1/2" = 1'-0"	THE TRUSS COMPANY 1000 E. 10TH ST. ALBANY, N.Y. 12219 TEL. 518-869-1111	2630-1543 BREAK APART 2 OR 3 PIERCE SECTIONS (SHEET 2 OF 2) ART. 800-1180 TON APPROX.

