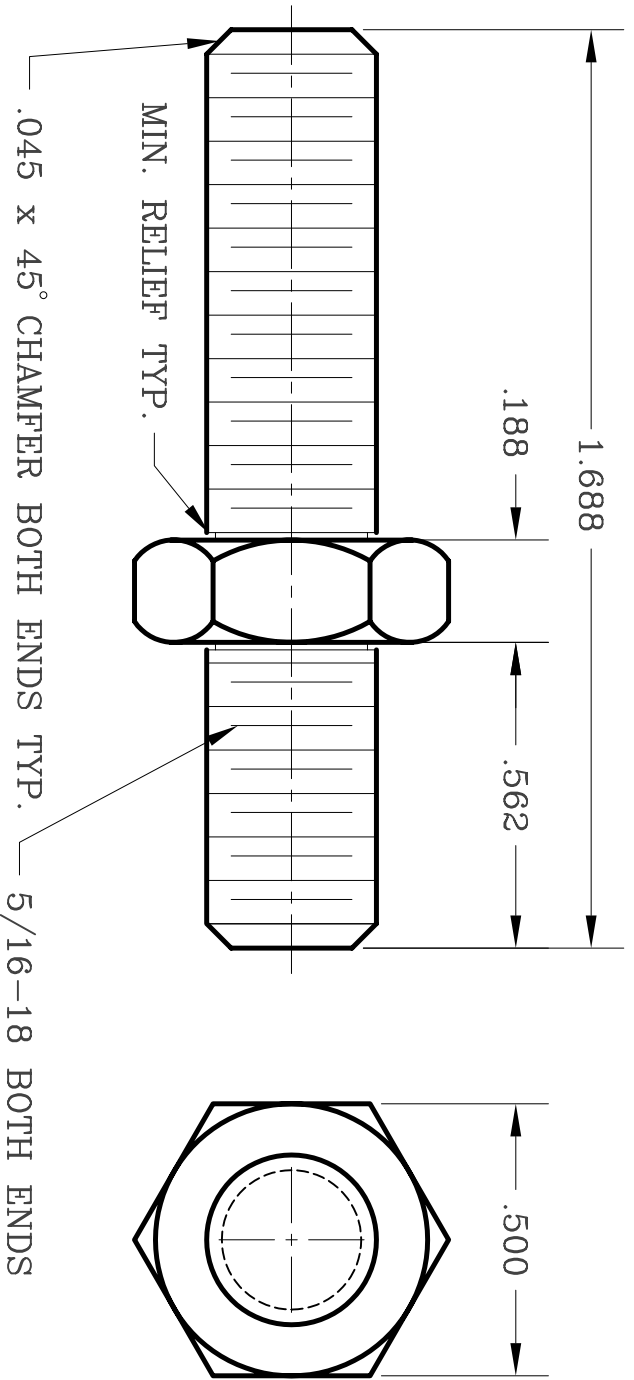


MAT'L 12 GA MILD STEEL OR STAINLESS STEEL 1 REQ'D

2

|             |                  |       |                      |               |
|-------------|------------------|-------|----------------------|---------------|
| DWG FILE    | A:24             | TITLE | RADIANT HEAT BAFFLIE |               |
| DRAWN BY    | T.L. HABY ± .015 | SCALE | L-60-1               | DATE          |
|             |                  | NTS   |                      | 14JAN2004     |
|             |                  |       |                      | DRAWING NO    |
|             |                  |       |                      | A-6-6376-11-Z |
| <b>ASTM</b> |                  |       |                      |               |



MAT'L TYPE 303 OR 304 SS 4 REQ'D

REVISION NO. 2

DWG FILE A:35  
 DRAWN BY T.L. HABY ± .010

**L-60-1**

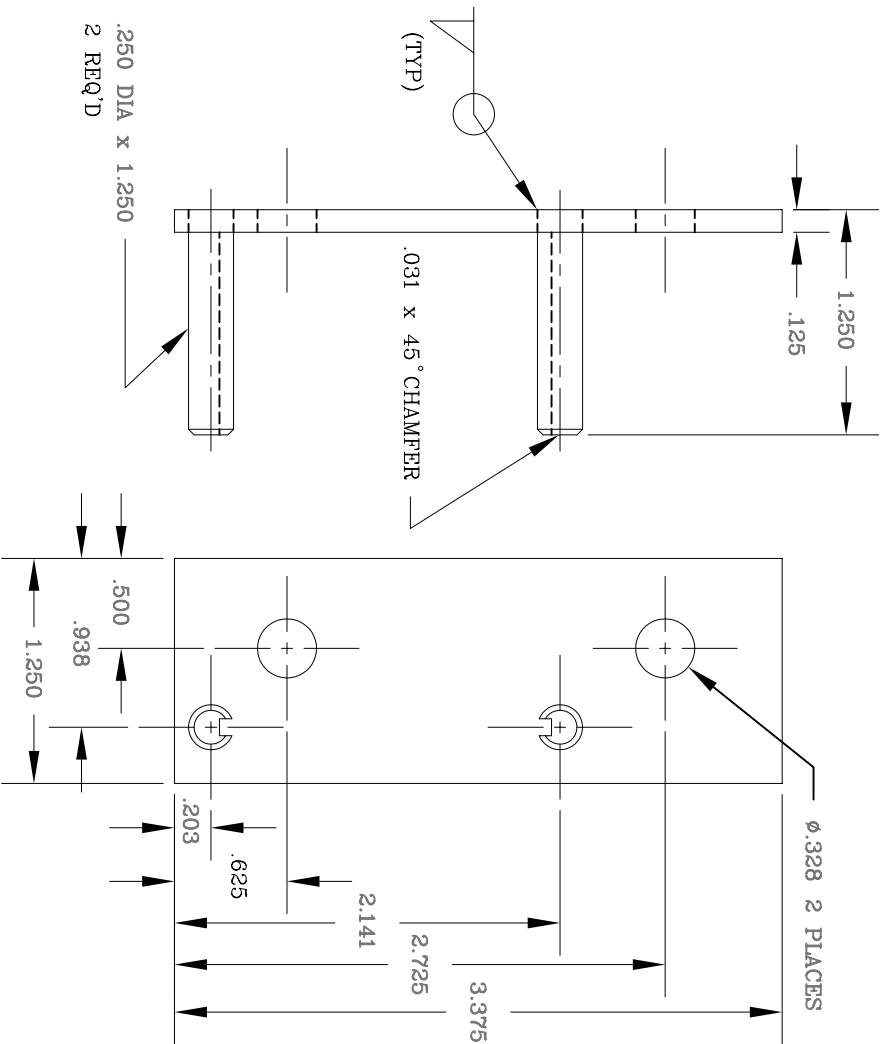
TITLE SEAL PLATE BOLTS

**ASTM**

SCALE 3=1

DATE 15JAN2004

DRAWING NO A-6-6376-19-Z



.250 DIA x 1.250  
2 REQ'D

(TYP)

.031 x 45° CHAMFER

1.250  
.125

Ø .328 2 PLACES

3.375

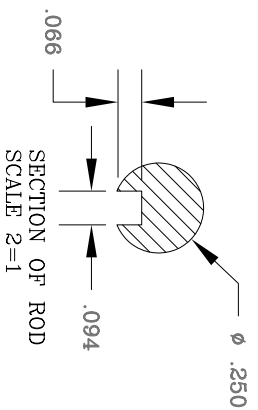
2.725

2.141

.625

.203

.500  
.938  
1.250



NOTE 1: TOLERANCES ARE FOR FABRICATION PURPOSES ONLY  
NOTE 2: TYPE 303 OR 304 20 GA. 1 REQ'D

REVISION NO. 1

DWG FILE A:32

DRAWN BY T.L. HABY ± .005

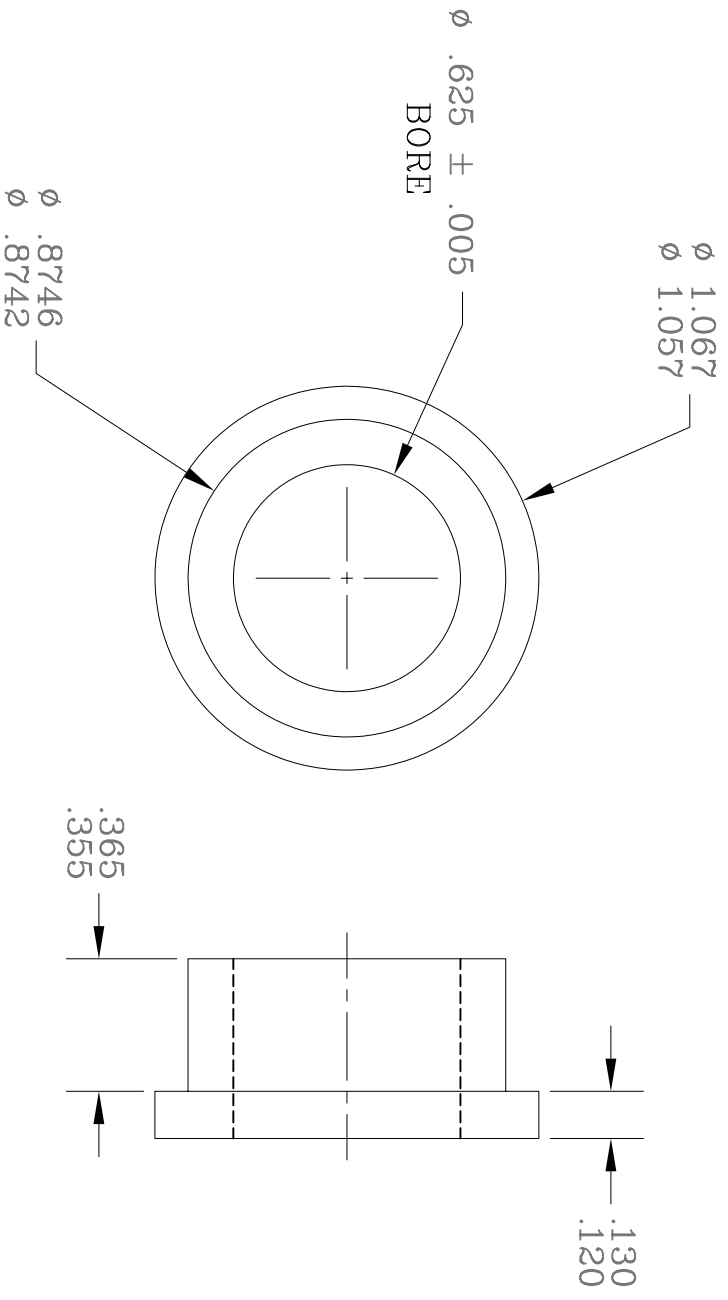
L-60-1  
SCALE  
1=1

TITLE  
CATALYST HOLDER

DATE  
15JAN2004

DRAWING NO  
A-6-6376-23-Z

**ASTM**



NOTE 1: TOLERANCES ARE FOR FABRICATION PURPOSES ONLY  
 NOTE 2: TYPE 303 OR 304 20 GA. 1 REQ'D

REVISION NO. 1

DWG FILE A:33  
 DRAWN BY T.L. HABY ±

L-60-1  
 SCALE 2=1

TITLE TEST BEARING BUSHING

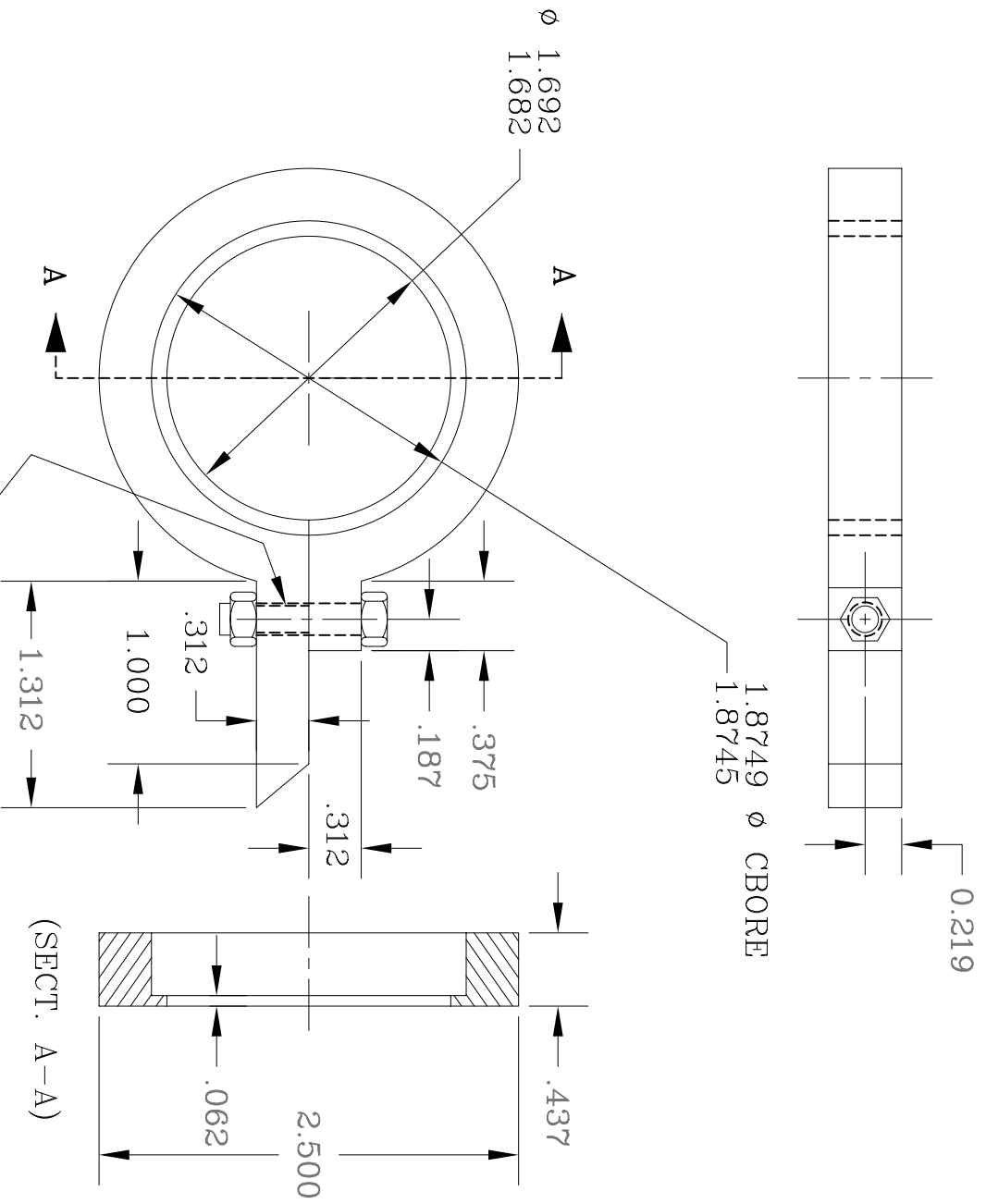
SCALE 2=1

DATE 15JAN2004

DRAWING NO A-6-6376-24-Z

**ASTM**

NOTE 1: TOLERANCES ARE FOR FABRICATION PURPOSES ONLY  
 NOTE 2: TYPE 303 OR 304 20 GA. 1 REQ'D



- NOTE—
1. SAW OUT PART & ROUGH BORE
  2. SLOT & CLAMP TIGHTLY WITH CLAMP SCREW
  3. FINISH MACHINE BORE

REVISION NO. 1

DWG FILE A:27

DRAWN BY T.L. HABY ± .005

L-60-1

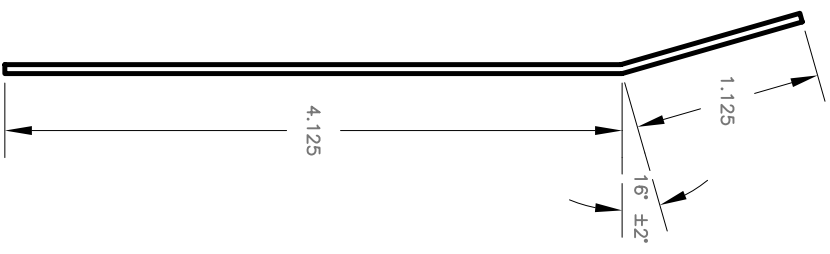
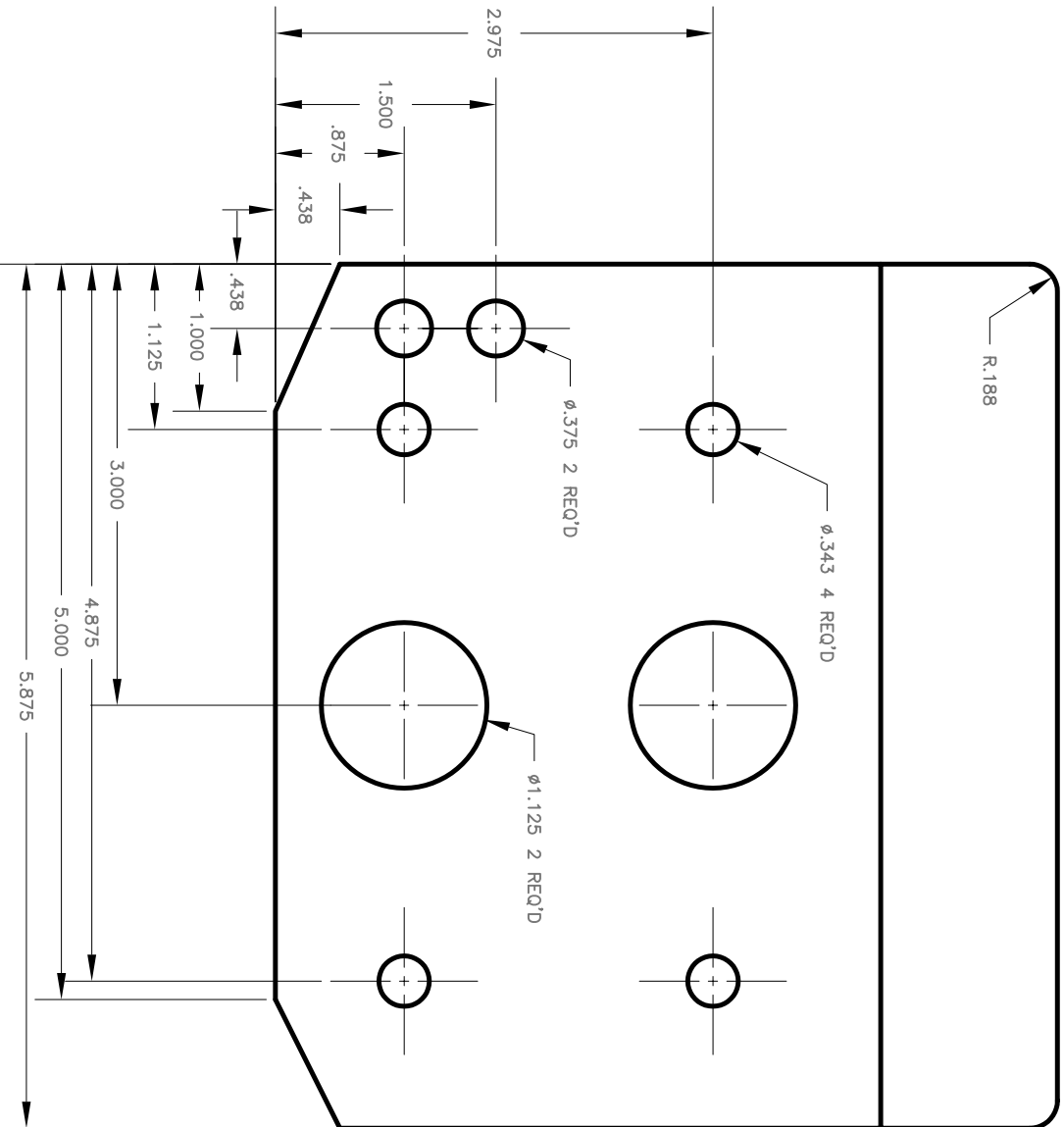
SCALE  
1=1

TITLE  
TEST BEARING CLAMP

DATE  
15JAN2004

DRAWING NO  
A-6-6376-25-Z

**ASTM**



NOTE 1: TOLERANCES ARE FOR FABRICATION PURPOSES ONLY  
 NOTE 2: TYPE 303 OR 304 20 GA. 1 REQ'D

MAT'L TYPE 304 20 GA 1 REQ'D

REVISION NO. 2

DWG FILE A:34

DRAWN BY T.L. HABY ± .010

L-60-1

SCALE  
NTS

TITLE

BAFFLE PLATE

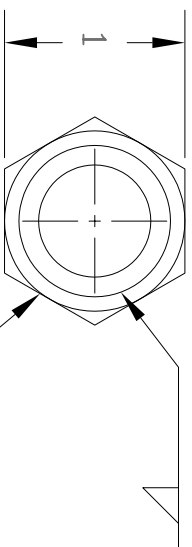
DATE

15JAN2004

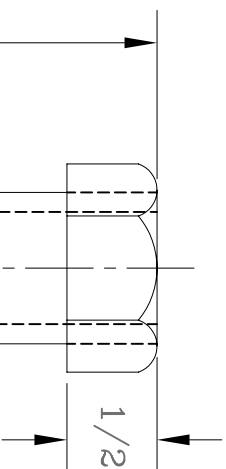
DRAWING NO

A-6-6376-27-Z

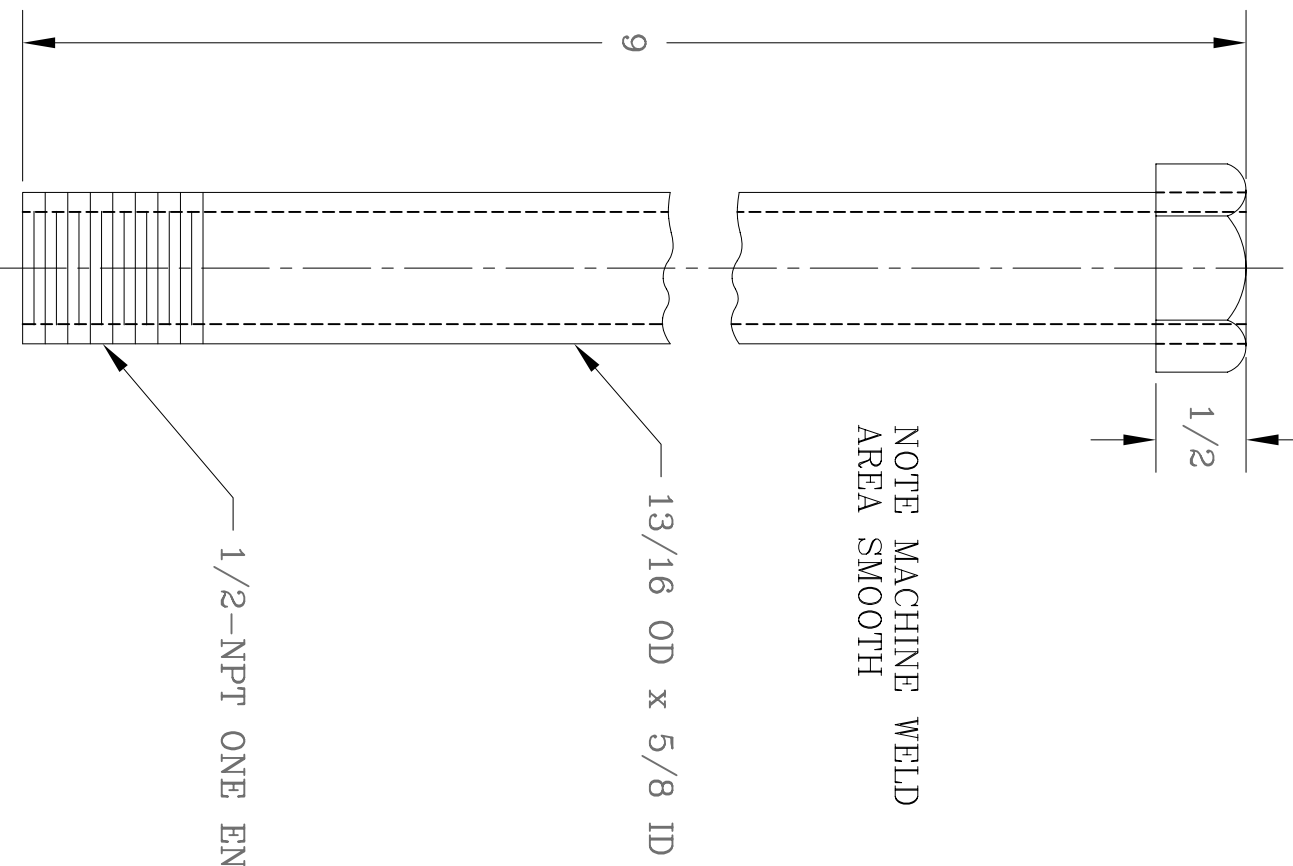
**ASTM**



HEX HEAD OPTIONAL



NOTE MACHINE WELD  
AREA SMOOTH



MAT'L 1/2 SCHED 40 STAINLESS PIPE

REVISION NO. 1

DWG FILE A:39  
DRAWN BY T.L. HABY ± 1/16

L-60-1

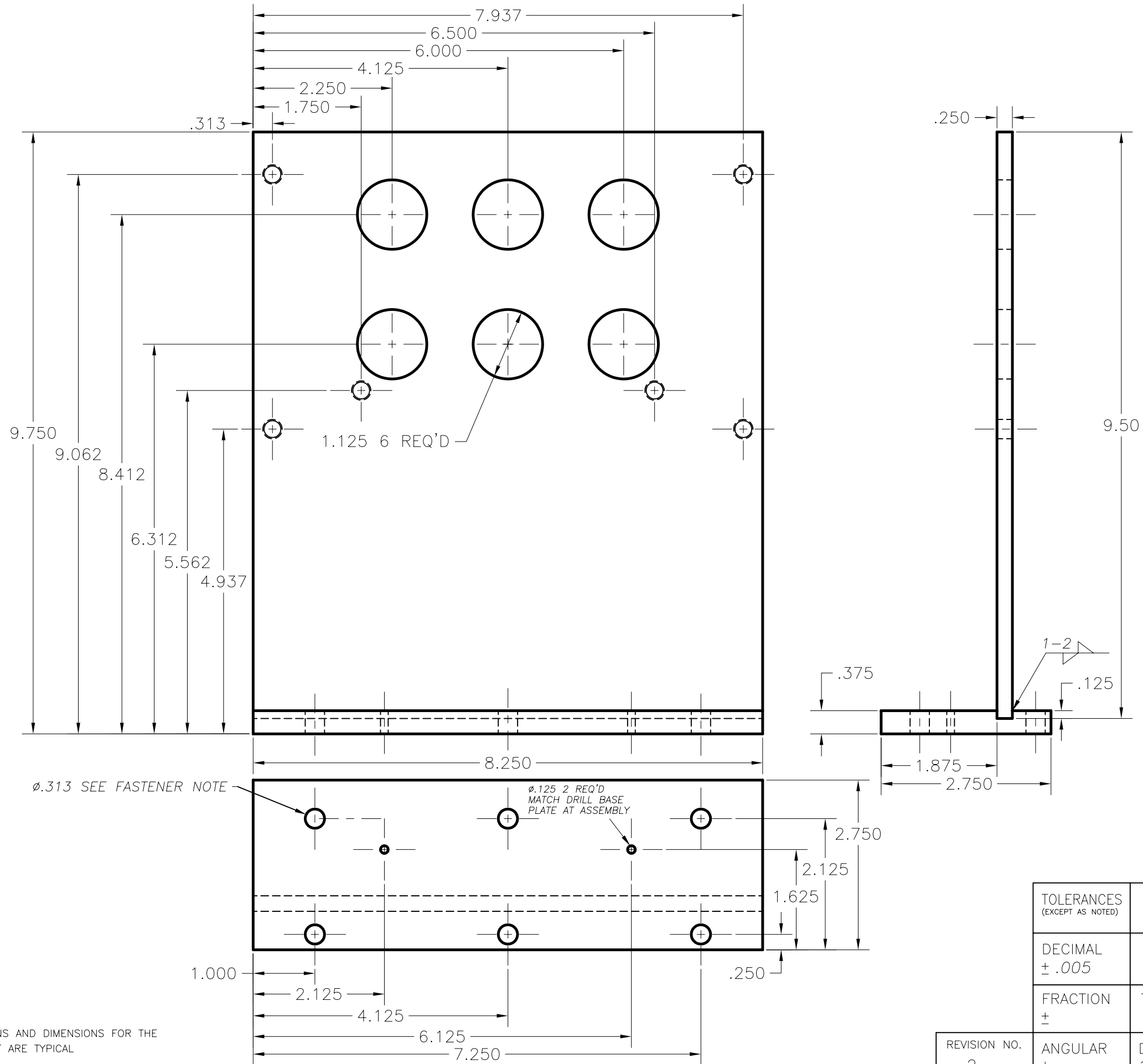
TITLE  
VENT TUBE

SCALE  
1=1

DATE  
14JAN2004

DRAWING NO  
A-6-6376-36-Z

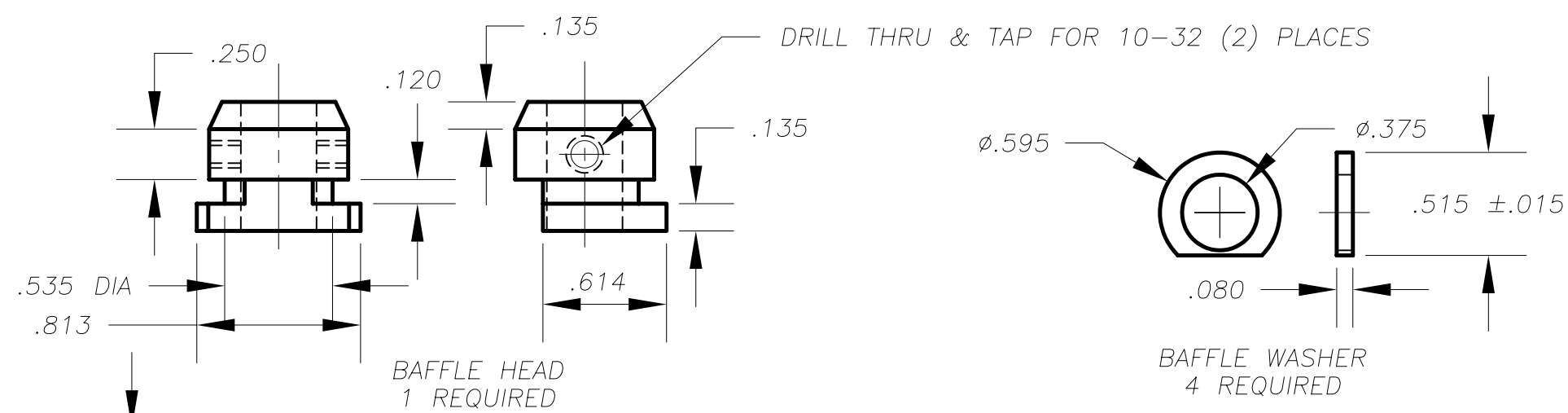
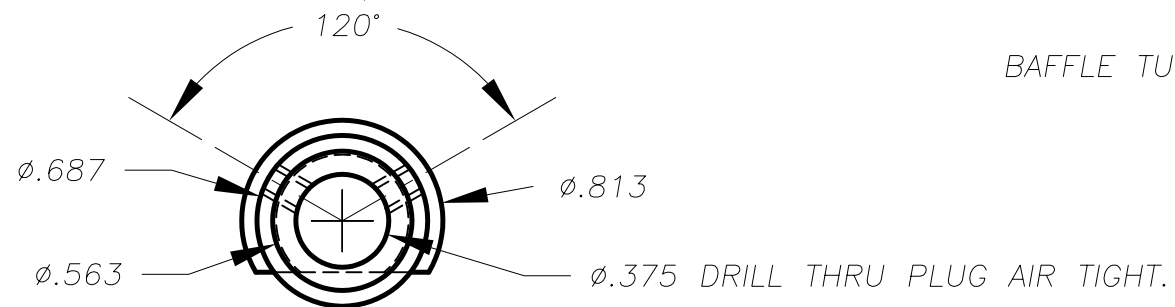
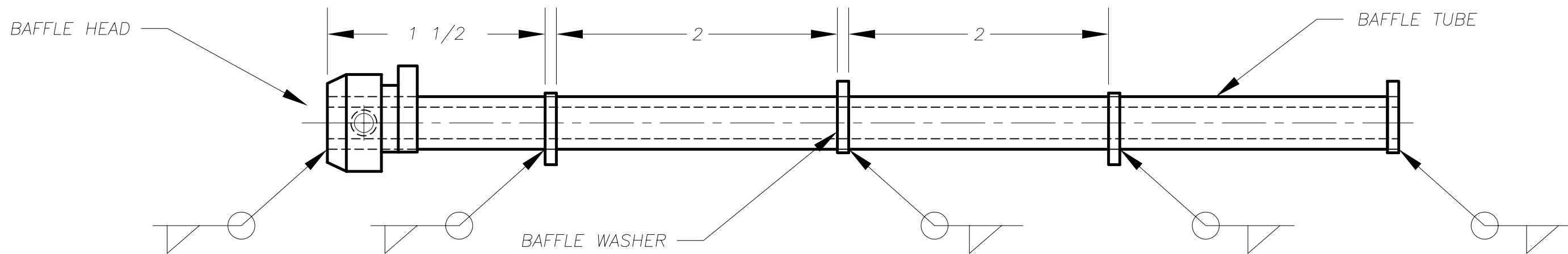
**ASTM**



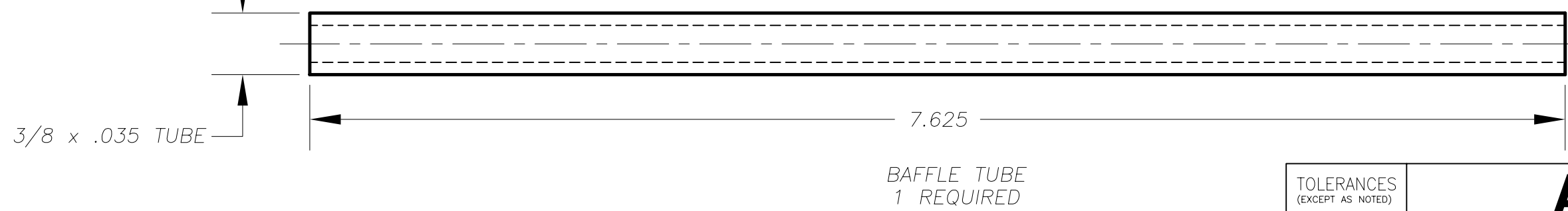
NOTE:  
ALL HOLE LOCATIONS AND DIMENSIONS FOR THE  
BASE PLATE MOUNT ARE TYPICAL

|                                 |                            |                   |                              |
|---------------------------------|----------------------------|-------------------|------------------------------|
| TOLERANCES<br>(EXCEPT AS NOTED) | <b>ASTM</b>                |                   | DWG FILE<br>76A              |
| DECIMAL<br>± .005               | L-60-1                     | SCALE<br>NTS      | DRAWN BY T. HABY             |
| FRACTION<br>±                   | TITLE<br>GEAR CASE SUPPORT |                   |                              |
| REVISION NO.<br>2               | ANGULAR<br>±               | DATE<br>14JAN2004 | DRAWING NO.<br>B-6-6376-18-Z |

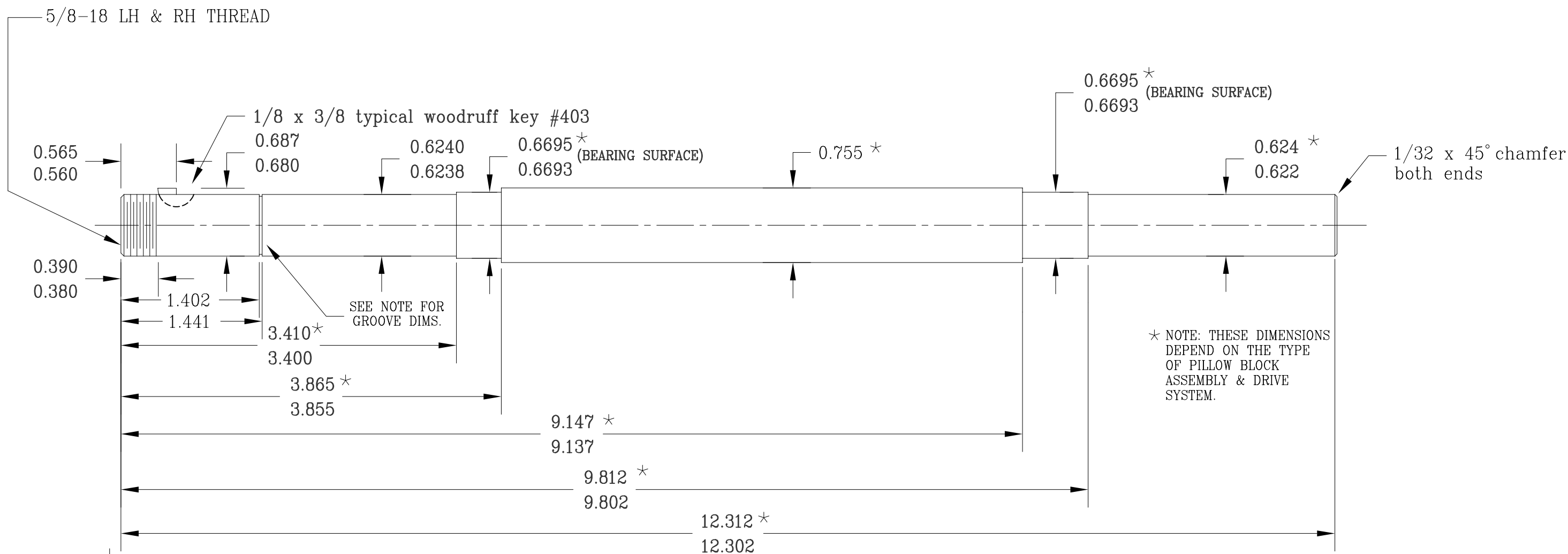




NEW BAFFLES BUILT AFTER  
JULY 30, 2004 MAY BE  
BUILT WITH SOLID STEEL.



|                                 |                           |                   |   |
|---------------------------------|---------------------------|-------------------|---|
| TOLERANCES<br>(EXCEPT AS NOTED) | <b>ASTM</b>               |                   | DWG FILE<br>66A                                     |
|                                 | DECIMAL<br>± 0.010        | L-60-1            | SCALE<br>NTS<br>DRAWN BY T. HABY<br>MATERIAL 304 SS |
| FRACTION<br>± 1/16              | TITLE<br>VENT TUBE BAFFLE |                   |   |
| REVISION NO.<br>1               | ANGULAR<br>± 1°           | DATE<br>13MAY2004 | DRAWING NO.<br>B-6-6376-35-Z                        |



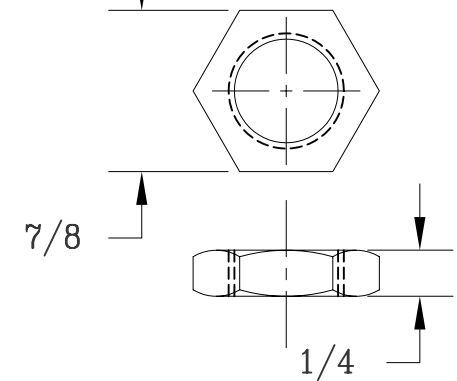
\* NOTE: THESE DIMENSIONS  
DEPEND ON THE TYPE  
OF PILLOW BLOCK  
ASSEMBLY & DRIVE  
SYSTEM.

note- .015 rad all corners

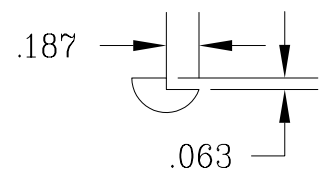
- 1 SHAFT-5/8-18 RH THREAD (DRIVER)
- 1 SHAFT-5/8-18 LH THREAD (DRIVEN)

GROOVE DIMENSIONS

DEPTH: .019 ±.001  
WIDTH: .039 ±.002

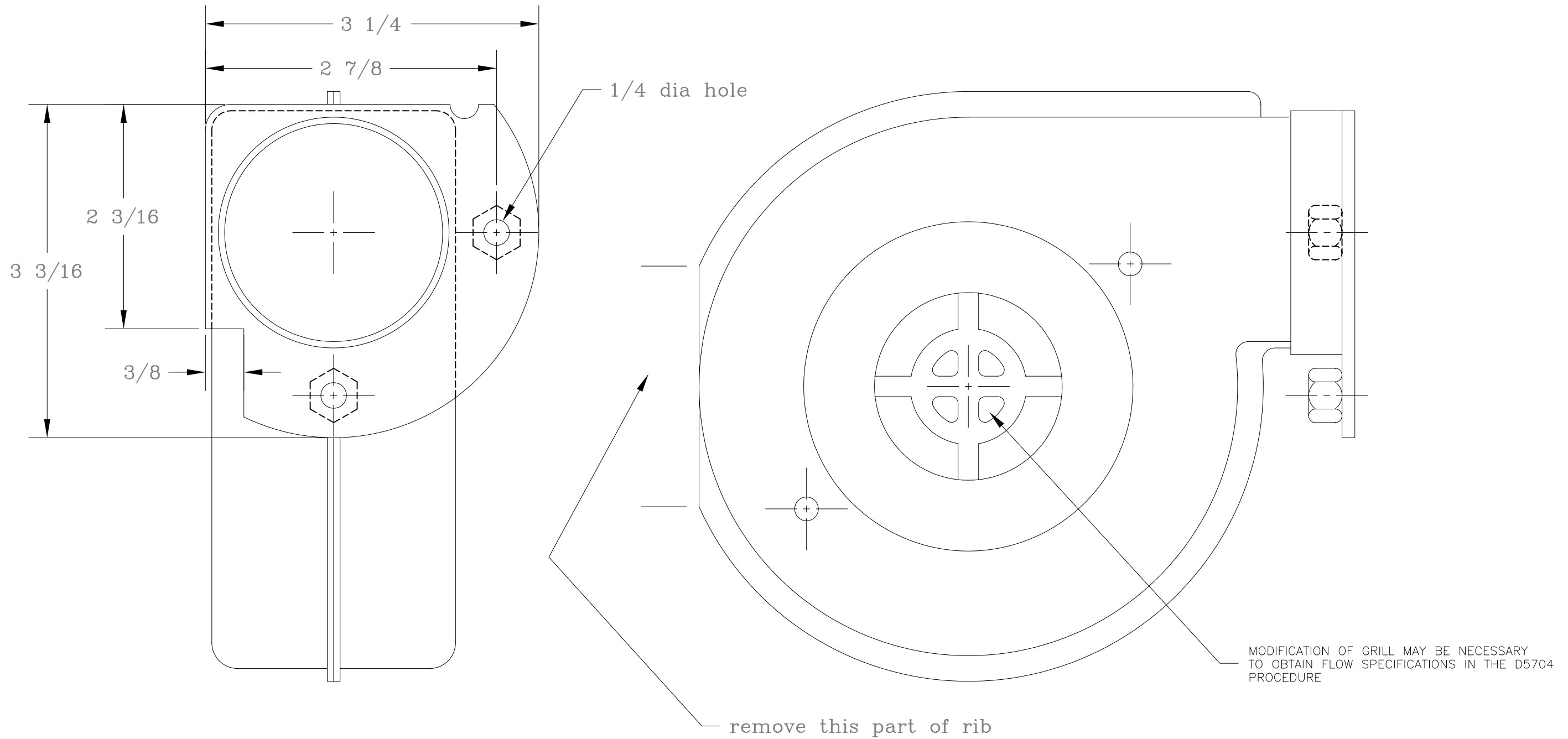


303 or 304 stainless nut  
5/8-18 LH & RH



KEY MODIFICATIONS

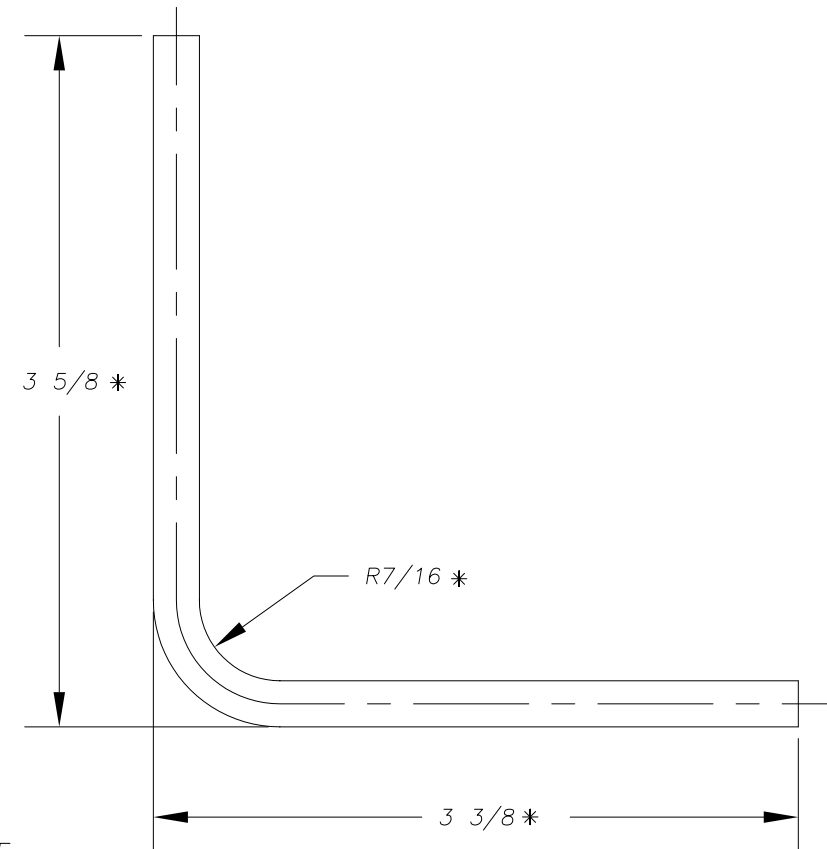
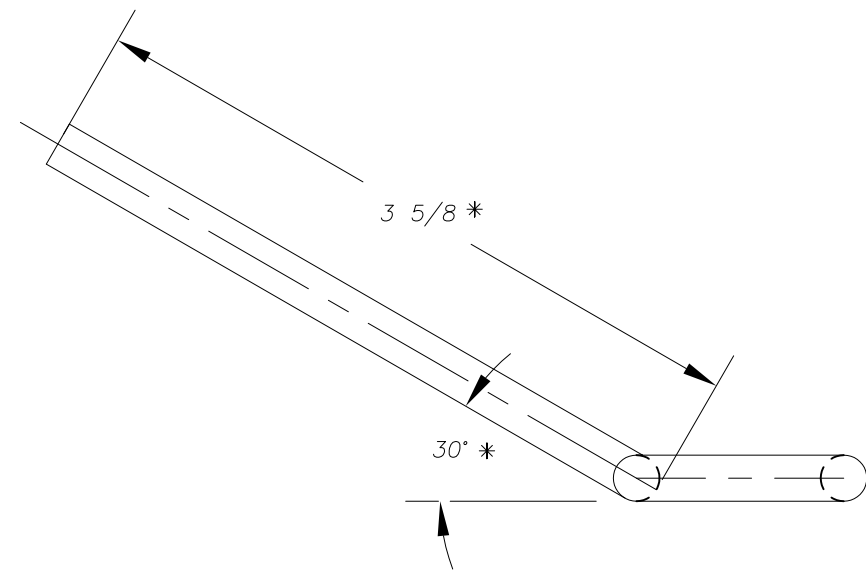
|                                 |  |                   |  |
|---------------------------------|--|-------------------|--|
| TOLERANCES<br>(EXCEPT AS NOTED) | <b>ASTM</b>                            |                   | DWG FILE<br>A:74                             |
| DECIMAL<br>± .001               | L-60-1                                 | SCALE<br>1=1      | DRAWN BY T. HABY<br>MATERIAL DRILL ROD OR SS |
| FRACTION<br>± 1/32              | TITLE<br>GEAR SHAFT AND NUT (EXTENDED) |                   |  |
| REVISION<br>2                   | ANGULAR<br>±                           | DATE<br>15JAN2004 | DRAWING NO<br>B-1996-629-Z                   |



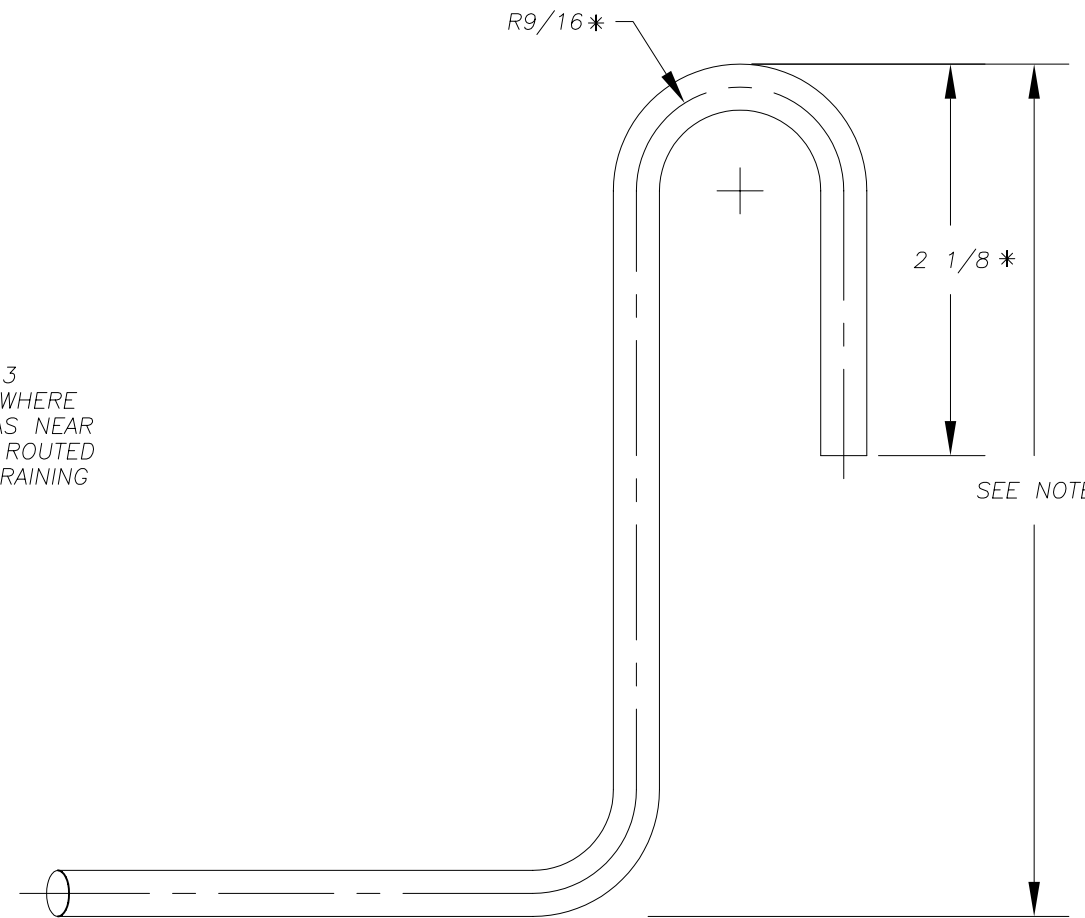
NOTE: MODIFY FLANGE AS SHOWN.  
 -ADD 1/4 DIA HOLE AND WELD 1/4-20 HEX NUTS AS SHOWN.  
 -BLOWER HOUSING IS FROM DAYTON MODEL 4C440 SHADED POLE BLOWER (MOTOR IS NOT USED).

TYPICAL BLOWER HOUSING (OTHERS MAY BE USED BUT MUST COMPLY WITH FLOW SPECIFICATIONS IN THE D5704 PROCEDURE.)

|                              |                                  |                   |                              |
|------------------------------|----------------------------------|-------------------|------------------------------|
| TOLERANCES (EXCEPT AS NOTED) | <b>ASTM</b>                      |                   | DWG FILE<br>A:86             |
| DECIMAL<br>±                 | L-60-1                           | SCALE<br>1=1      | DRAWN BY T. HABY<br>MATERIAL |
| FRACTION<br>± 1/16           | TITLE<br>MODIFIED BLOWER HOUSING |                   |                              |
| REVISION NO.<br>1            | ANGULAR<br>±                     | DATE<br>15JAN2004 | DRAWING NO<br>B-3752-1118-Z  |



NOTE: TUBE MUST RISE A MINIMUM OF 3 INCHES VERTICALLY ABOVE THE DRAIN (WHERE OIL ACTUALLY LEAVES THE GEARCASE) AS NEAR THE CASE AS POSSIBLE BEFORE BEING ROUTED TO THE AIR SUPPLY TO PREVENT OIL DRAINING FROM THE CASE.

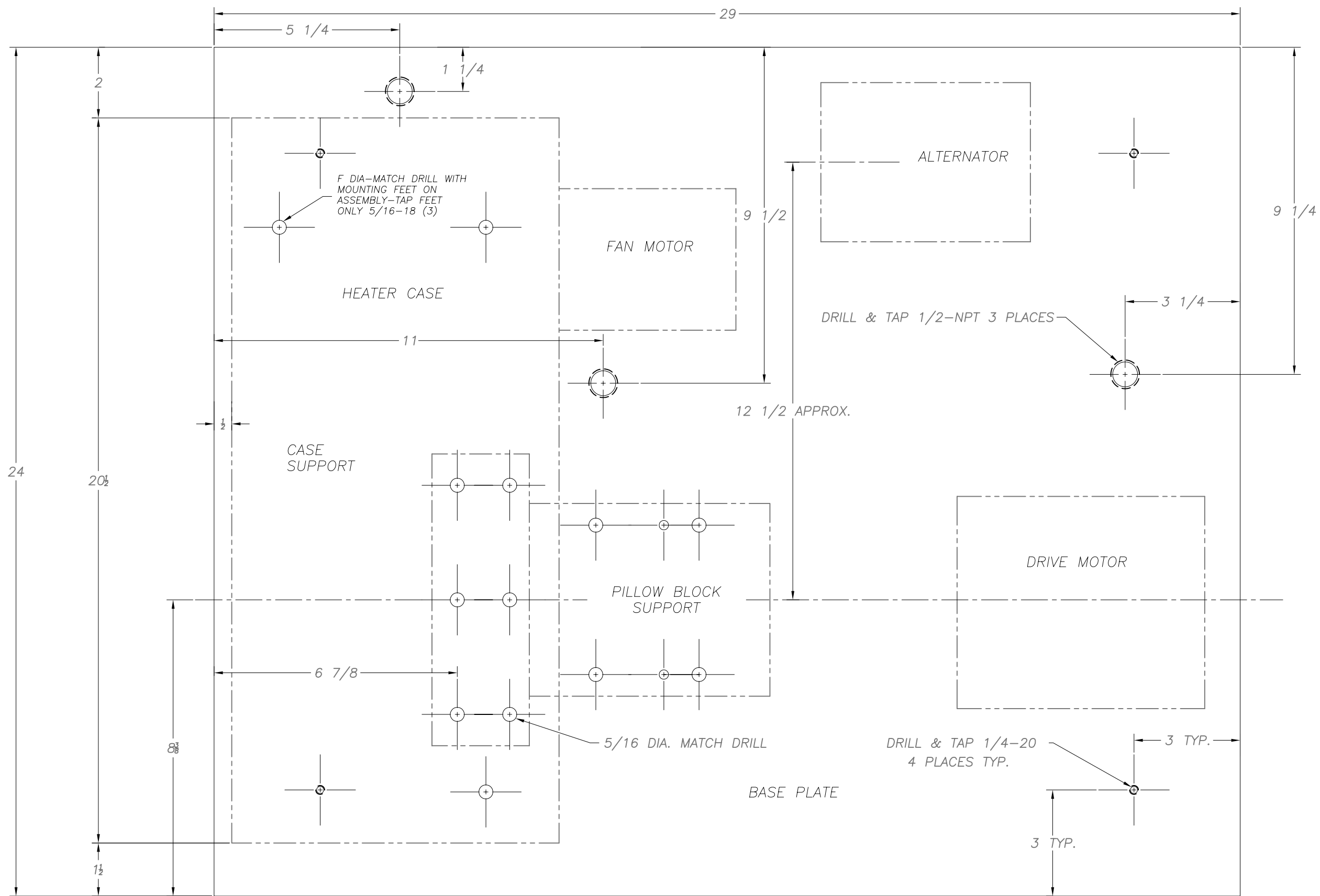


USE 1/4 O.D. STAINLESS TUBE

TYPICAL AIR TUBE

\* TYPICAL DIMENSIONS  
NOTE: STAINLESS 303 OR 304

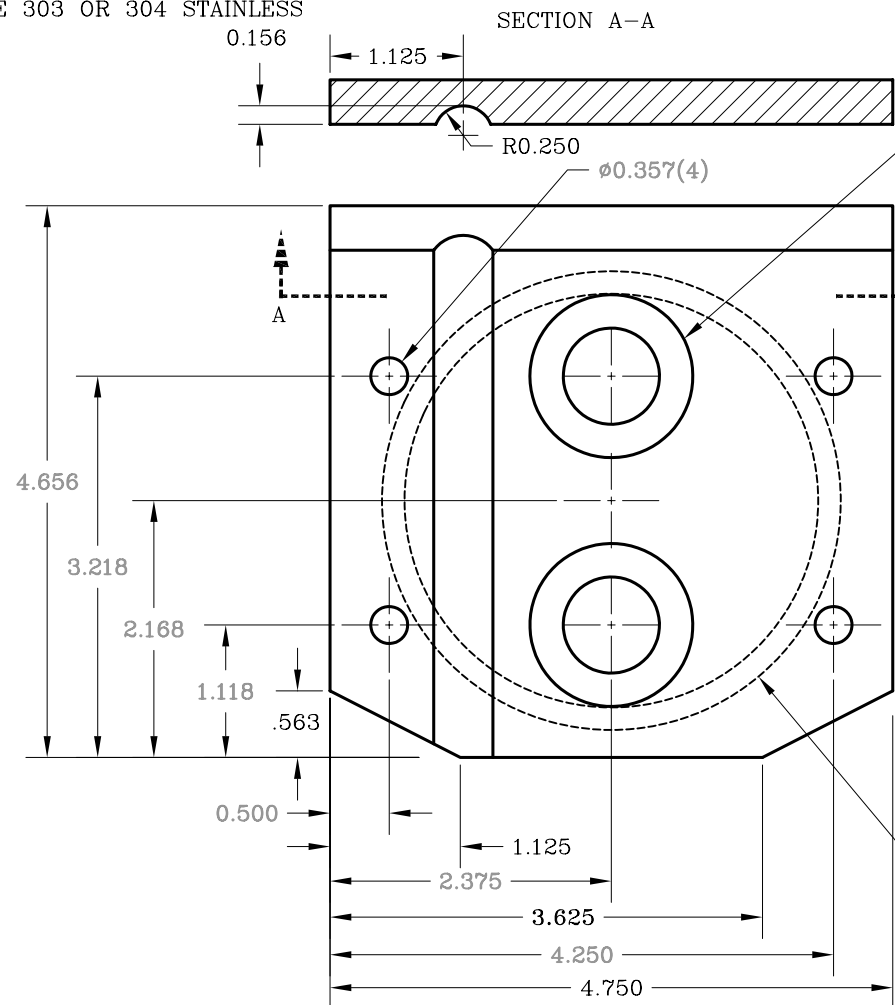
|                                 |                          |                   |                             |
|---------------------------------|--------------------------|-------------------|-----------------------------|
| TOLERANCES<br>(EXCEPT AS NOTED) | <b>ASTM</b>              |                   | DWG FILE<br>O:AIRSUPTB      |
| DECIMAL<br>±                    | L-60-1                   | SCALE<br>1=1      | DRAWN BY T. HABY            |
| FRACTION<br>± 1/16              | TITLE<br>AIR SUPPLY TUBE |                   |                             |
| REVISION NO.<br>2               | ANGULAR<br>2°            | DATE<br>15JAN2004 | DRAWING NO<br>B-4805-1374-Z |



TYPICAL BASE PLATE LAYOUT

|                                 |                     |                   |                              |
|---------------------------------|---------------------|-------------------|------------------------------|
| TOLERANCES<br>(EXCEPT AS NOTED) | ASTM                |                   | DWG FILE<br>104              |
| DECIMAL<br>±                    | L-60-1              | SCALE<br>NTS      | DRAWN BY T. HABY<br>MATERIAL |
| FRACTION<br>±                   | TITLE<br>BASE PLATE |                   |                              |
| REVISION NO.<br>1               | ANGULAR<br>±        | DATE<br>15JAN2004 | DRAWING NO.<br>C-6-6376-05-Z |

SEAL PLATE  
TYPE 303 OR 304 STAINLESS



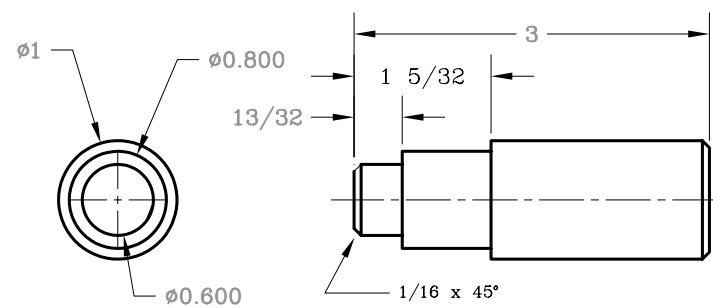
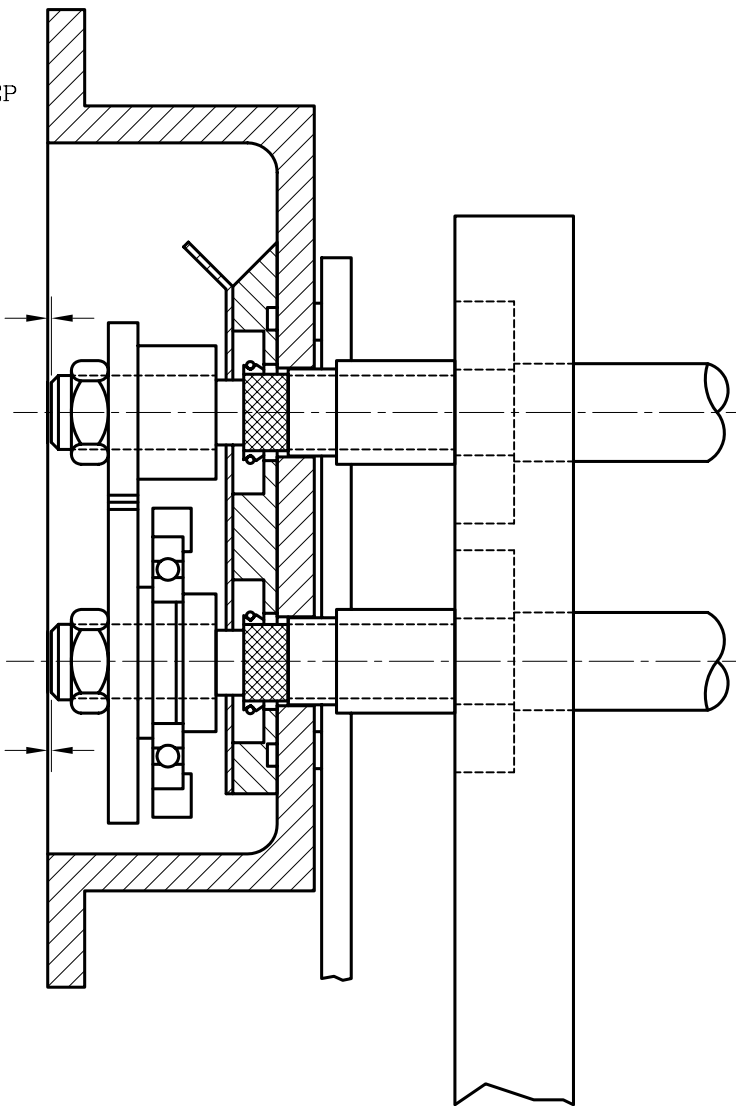
0.812 DIA MIN. THRU HOLE-2 REQ'D  
C'BORE 1.375  $^{+0.000}_{-.001}$  DIA x .262 DEEP  
(SEE NOTE 1)

32 RMS TYP.  
FLATNESS  $\pm 0.001$

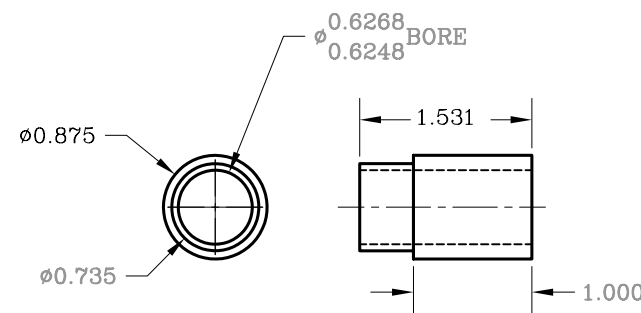
0.031 TYP.

0.031 TYP.

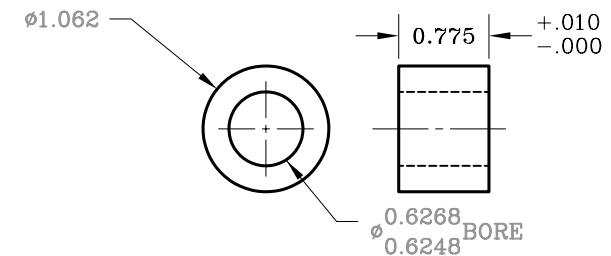
GROOVE OPPOSITE SIDE  
3.492 ID  
3.782 OD  
.078  $^{+0.010}_{-.000}$  DEEP



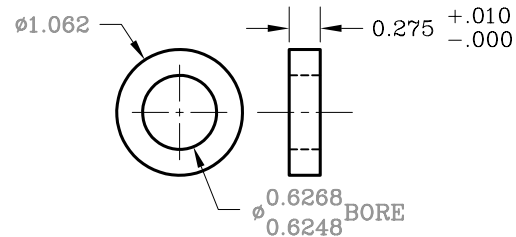
SEAL REMOVAL TOOL-CRS



RETAINER BUSHING-2 REQ'D  
TYPE 303 OR 304 STAINLESS



SPACER BUSHING-UPPER  
TYPE 303 OR 304 STAINLESS



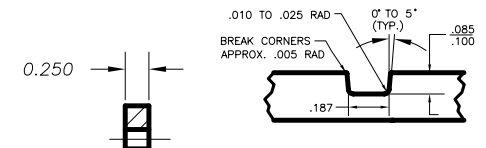
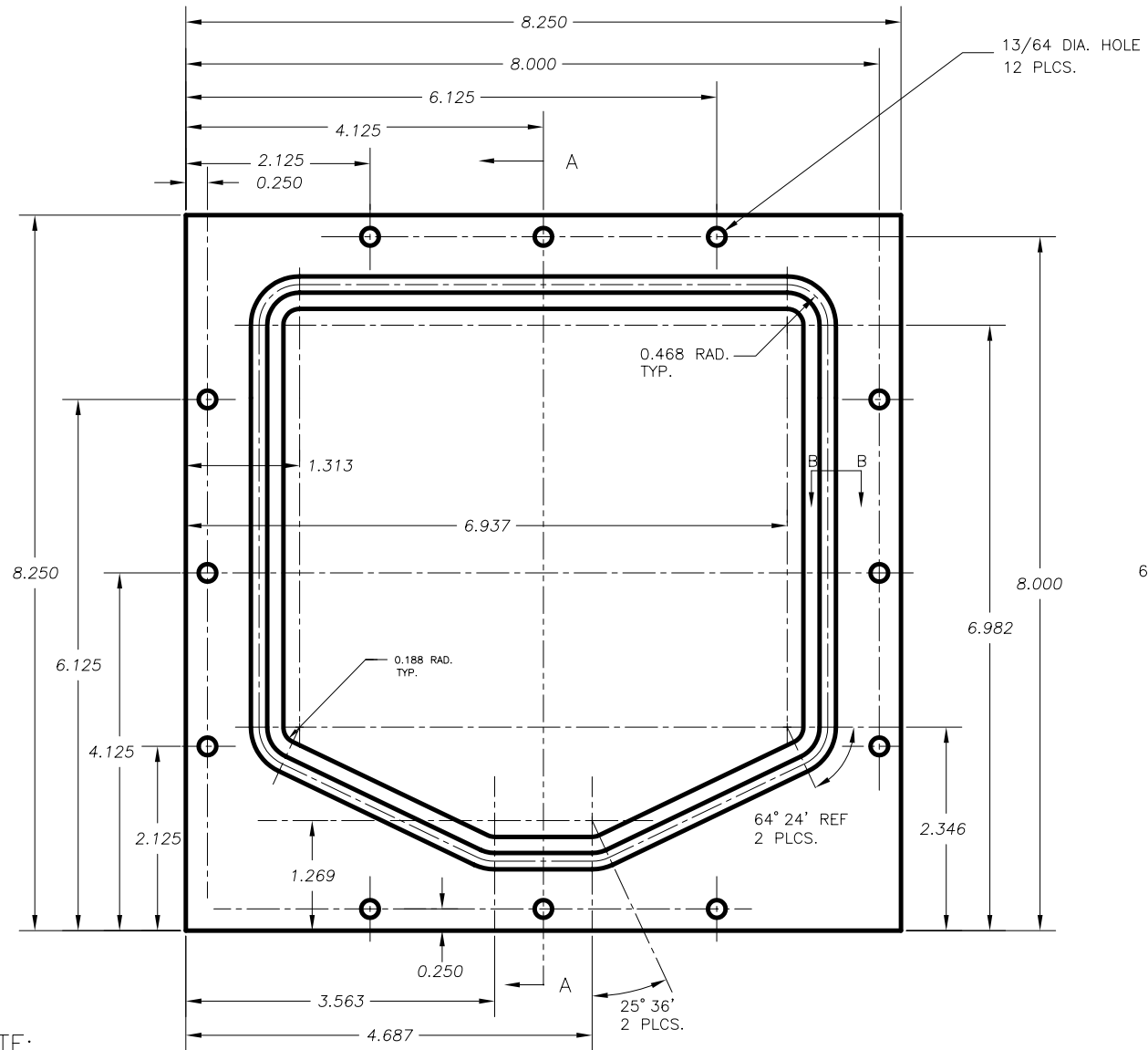
SPACER BUSHING-LOWER  
TYPE 303 OR 304 STAINLESS

NOTE 1:  
MATERIAL MAY BE REMOVED FROM SHOULDER  
TO FACILITATE LIP SEAL REMOVAL

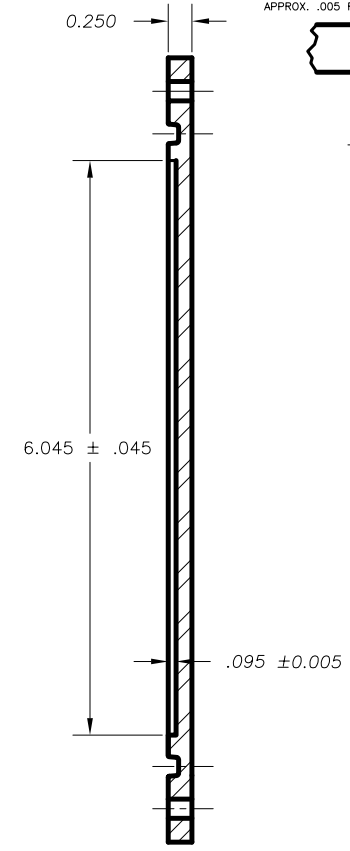
NOTE 2:  
"O" RING-NO.2-153  
OIL SEAL-CR-6383 2 REQ'D  
SPEEDI SLEEVE-CR-99062 2 REQ'D  
V-RING-CR-400164 2 REQ'D

NOTE 3:  
FOR PROPER STACK-UP ASSEMBLY, THE DISTANCE  
FROM THE SNAP RING GROOVE TO THE COUNTER  
BORE OF THE SEAL PLATE SHOULD BE .400  
 $\pm 0.03125$  INCHES. THE COUNTER BORE DEPTH  
OF .262 INCHES MAY BE ADJUSTED TO GIVE PROPER  
STACK-UP ASSEMBLY OF THE OIL SEAL (CR-6383)  
AND V-RING (CR-400164).

|                                 |                  |                              |                             |                              |
|---------------------------------|------------------|------------------------------|-----------------------------|------------------------------|
| TOLERANCES<br>(EXCEPT AS NOTED) |                  | <b>ASTM</b>                  |                             | DWG FILE<br>C:SLPLT          |
| DECIMAL<br>$\pm .005$           |                  | L-60-1                       | SCALE<br>1=1                | DRAWN BY T. HABY<br>MATERIAL |
| FRACTION<br>$\pm 1/32$          |                  | TITLE<br>MODIFIED SEAL PLATE |                             |                              |
| REVISION NO.<br>3               | ANGULAR<br>$\pm$ | DATE<br>29SEPT04             | DRAWING NO<br>C-3963-1277-Z |                              |



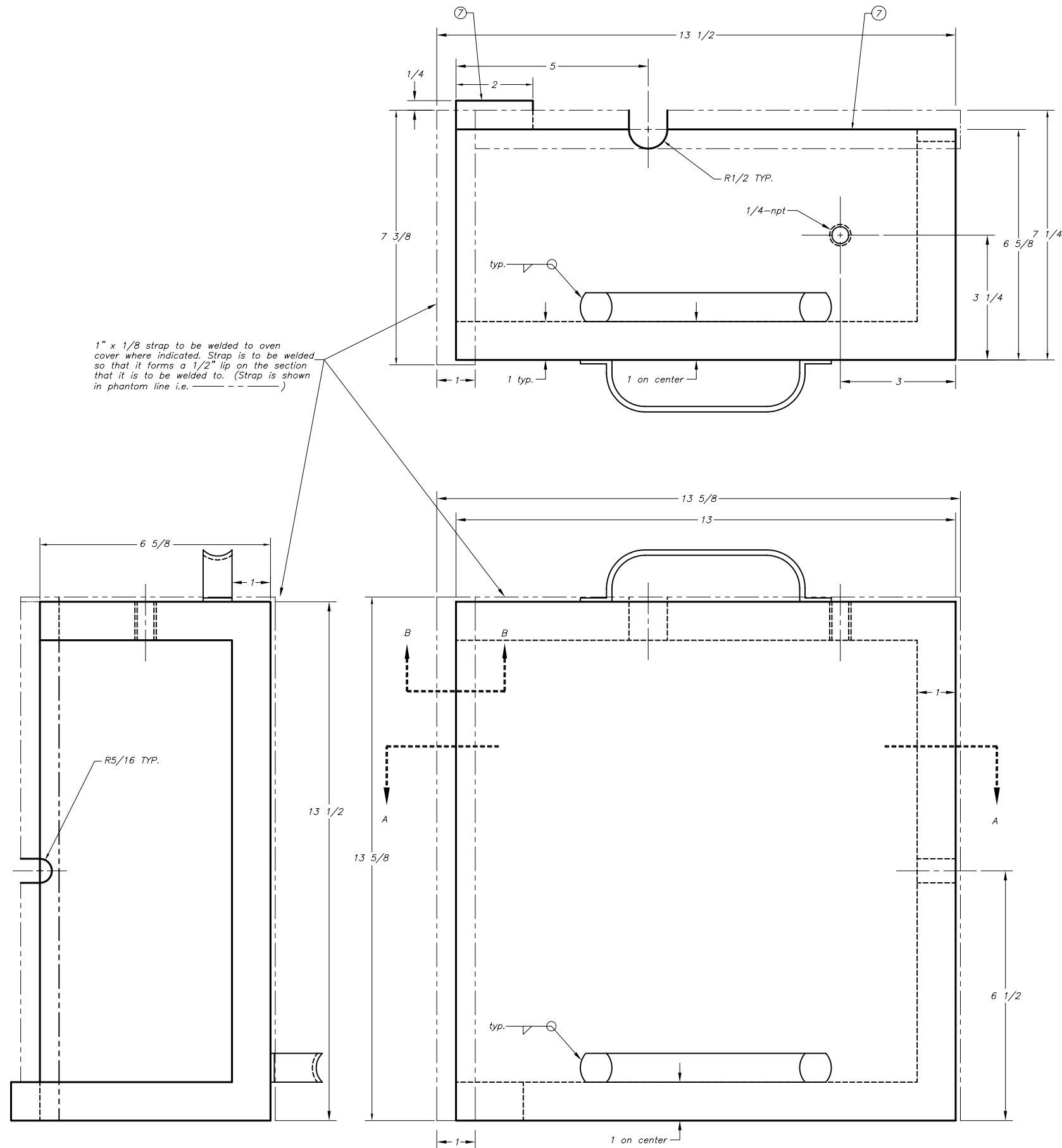
**SECT. B-B**  
SCALE 1/2" = 1"



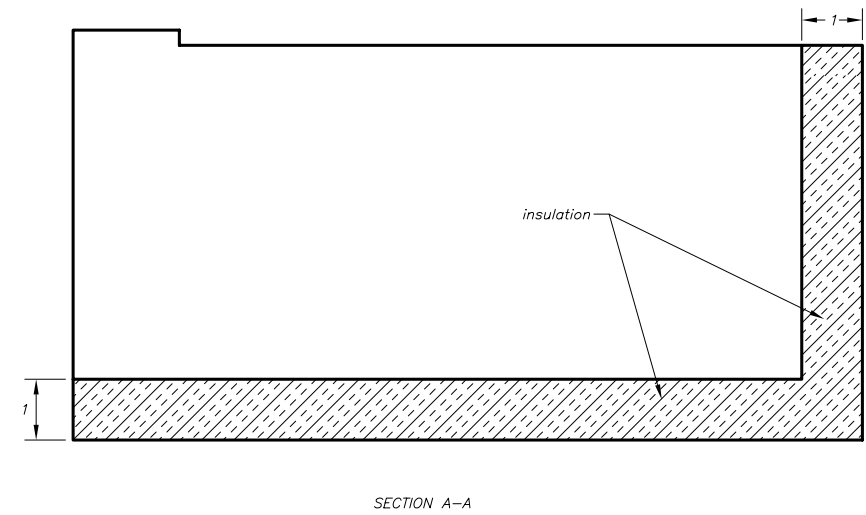
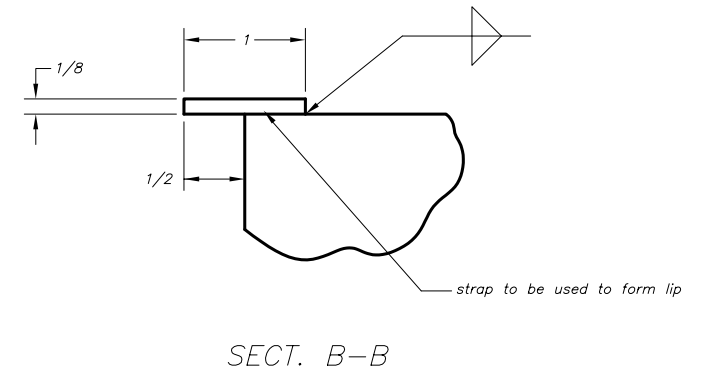
**SECTION A-A**

- NOTE:**
1. 2-264 FLUOROCARBON RUBBER O-RING.
  2. ALL DIMENSIONS ARE IN INCHES.
  3. SURFACE FINISH 32 RMS TYP.

|                                 |  |                   |                            |
|---------------------------------|--|-------------------|----------------------------|
| TOLERANCES<br>(EXCEPT AS NOTED) |  | <b>ASTM</b>       |                            |
| DECIMAL<br>± 0.005              | MATERIAL<br>303 OR 304 SS                          | SCALE<br>1 = 1    | DRAWN BY<br>T.HABY         |
| FRACTION<br>±                   | TITLE<br>COVER, T.O.S.T GEARCASE<br>O-RING, L-60-1 |                   |                            |
| REVISION NO.<br>1               | ANGULAR<br>± 0° 30"                                | DATE<br>13MAY2004 | DRAWING NO<br>C-7518-655-Z |



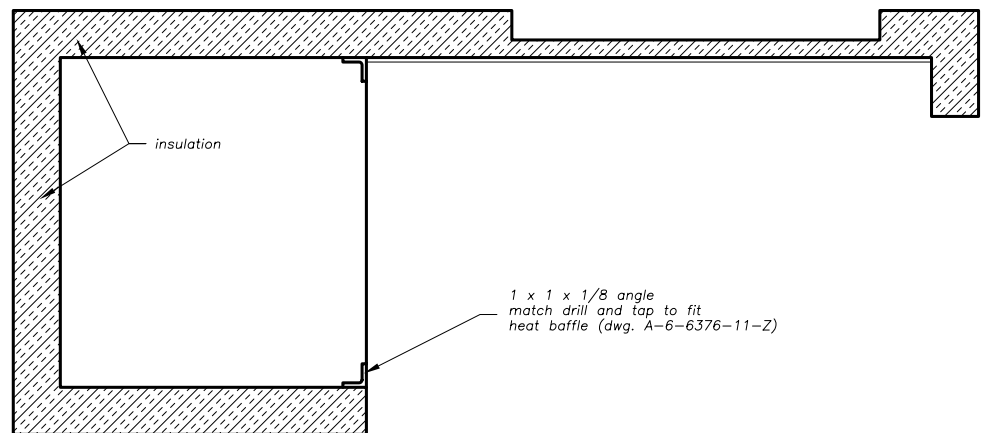
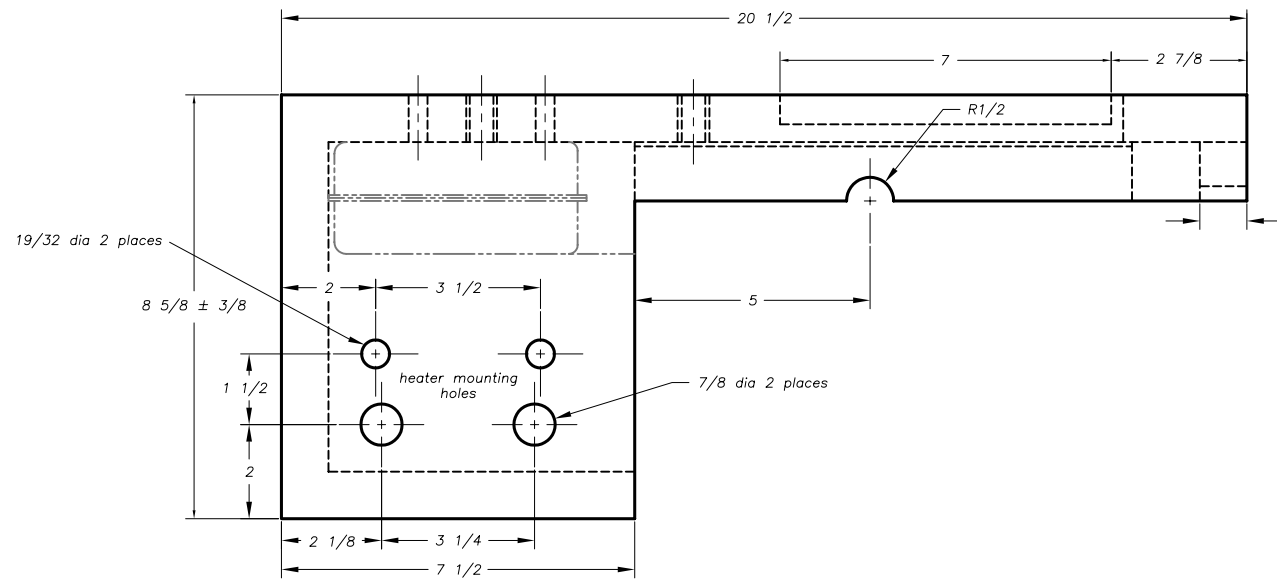
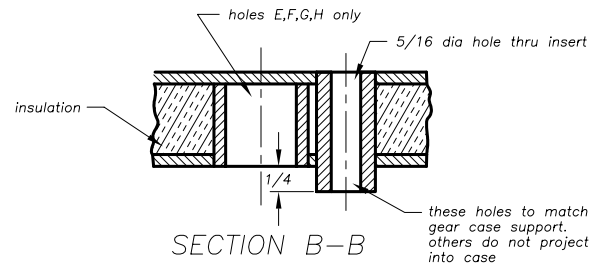
1" x 1/8" strap to be welded to oven cover where indicated. Strap is to be welded so that it forms a 1/2" lip on the section that it is to be welded to. (Strap is shown in phantom line i.e. - - - - -)



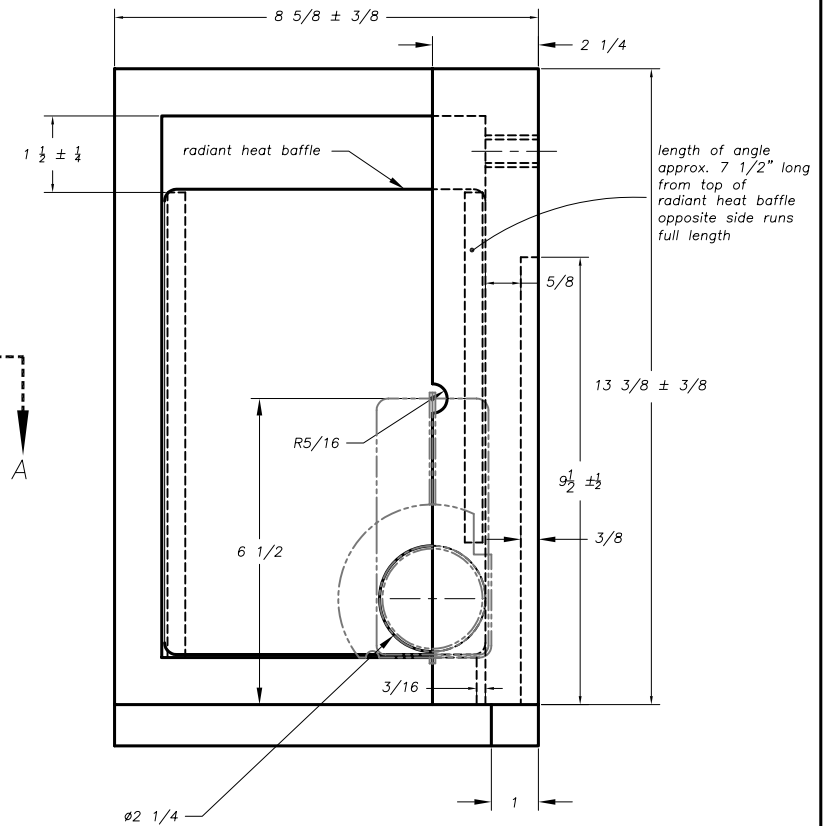
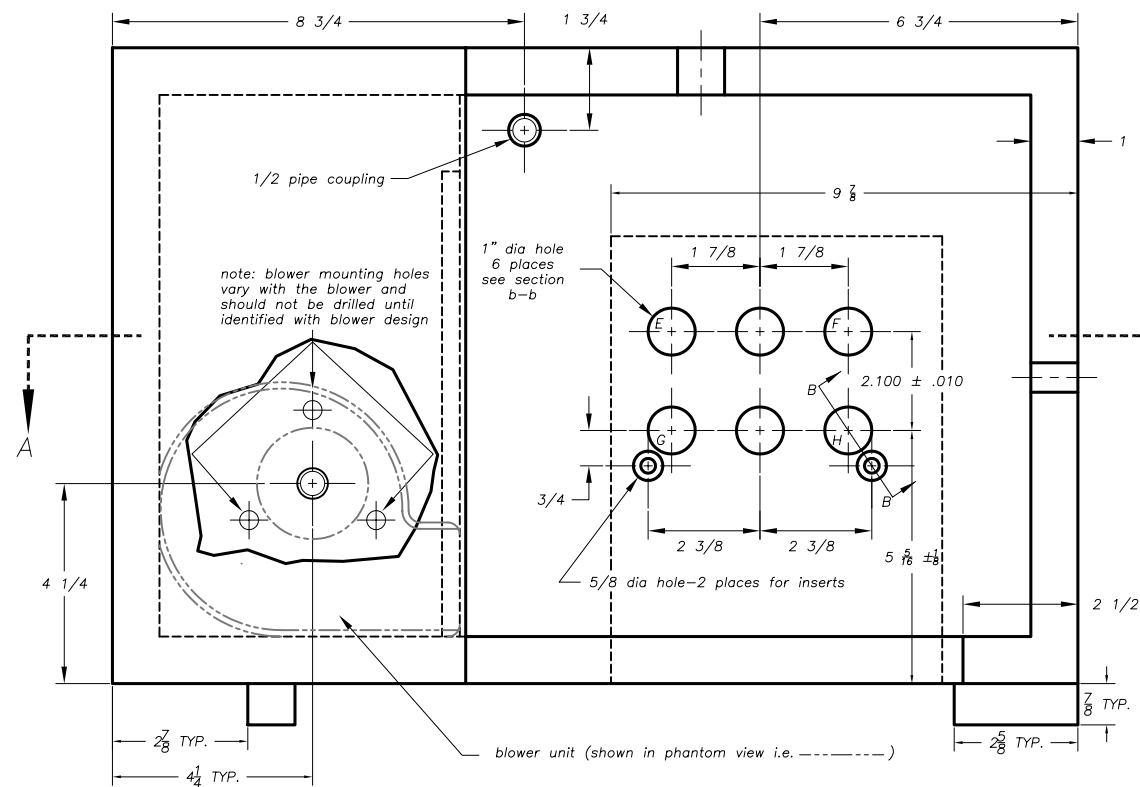
- NOTES
1. CASE CONSISTS OF A DOUBLE WALL CONTAINER WITH INSULATION BETWEEN THE WALLS.
  2. WALLS TO BE 16 GA. HOT ROLLED STEEL.
  3. ALL JOINTS TO BE WELDED LEAK PROOF.
  4. INSULATION TO BE INSTALLED DURING CONSTRUCTION.
  5. ALL HOLES THRU CASE TO BE LINED WITH METAL TUBE AND WELDED TO INNER AND OUTER WALLS.
  6. MUST MATCH OVEN WITHIN 1/8"
  7. FLANGED MOUNTING SURFACE OF THE OVEN COVER ASSEMBLY CAN BE MODIFIED FOR PROPER SEALING, PROVIDED THE INNER DIMENSIONS OF THE BOX ARE MAINTAINED ACCORDING TO THE PRINT.

|                                 |                            |                               |
|---------------------------------|----------------------------|-------------------------------|
| TOLERANCES<br>(EXCEPT AS NOTED) | <b>ASTM</b>                | DWG FILE<br>C:OVEN2           |
| DECIMAL<br>±                    | L-60                       | SCALE<br>NTS                  |
| FRACTION<br>± 1/8               | TITLE<br>HEATER CASE COVER | DRAWN BY<br>T.L. HABY         |
| REVISION NO.<br>1               | ANGULAR<br>±               | DATE<br>12-7-04               |
|                                 |                            | DRAWING NO.<br>D-6-6376-41a-Z |





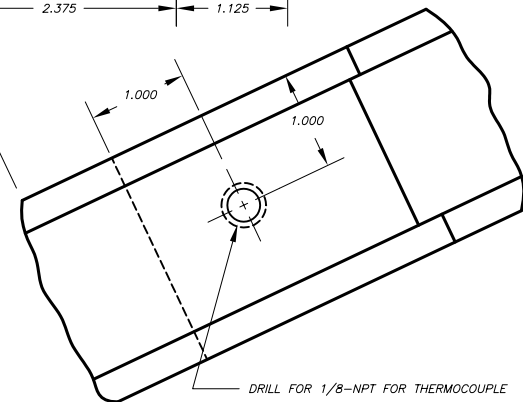
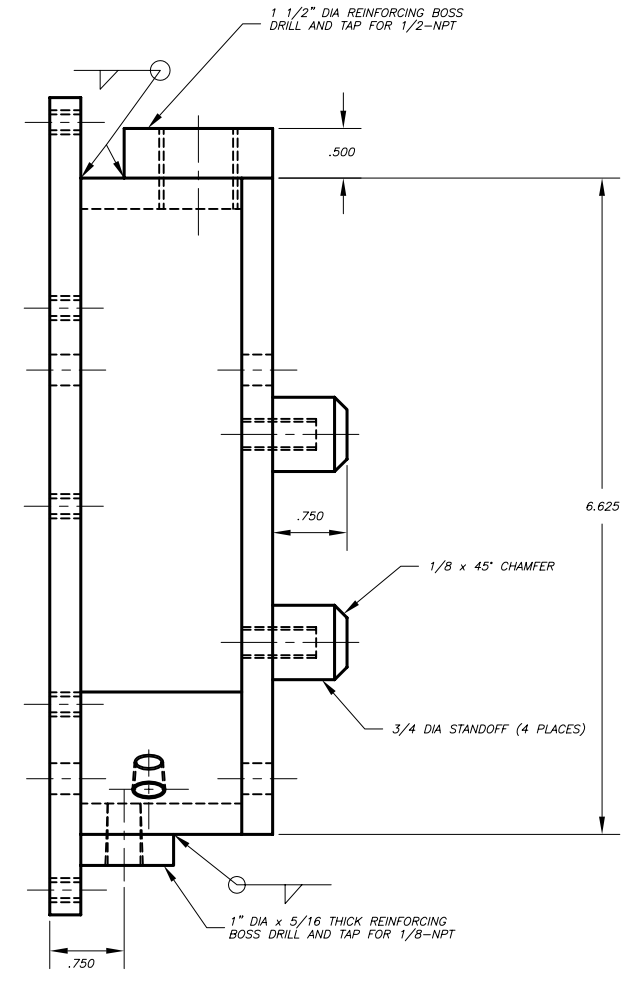
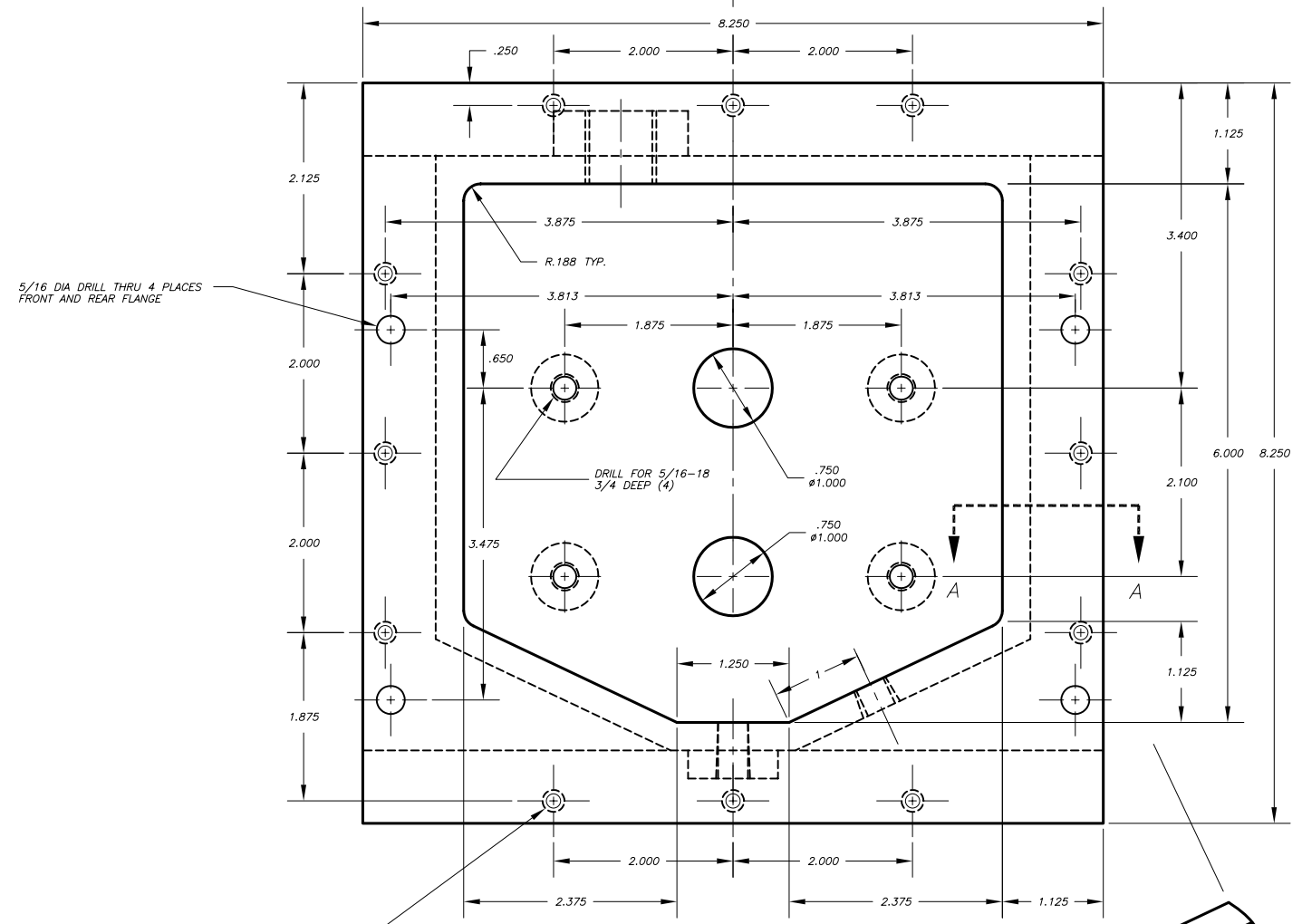
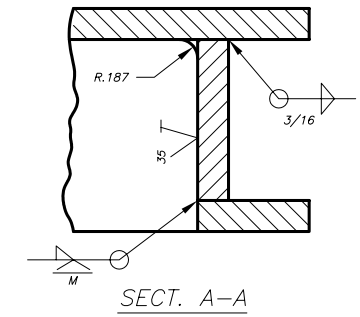
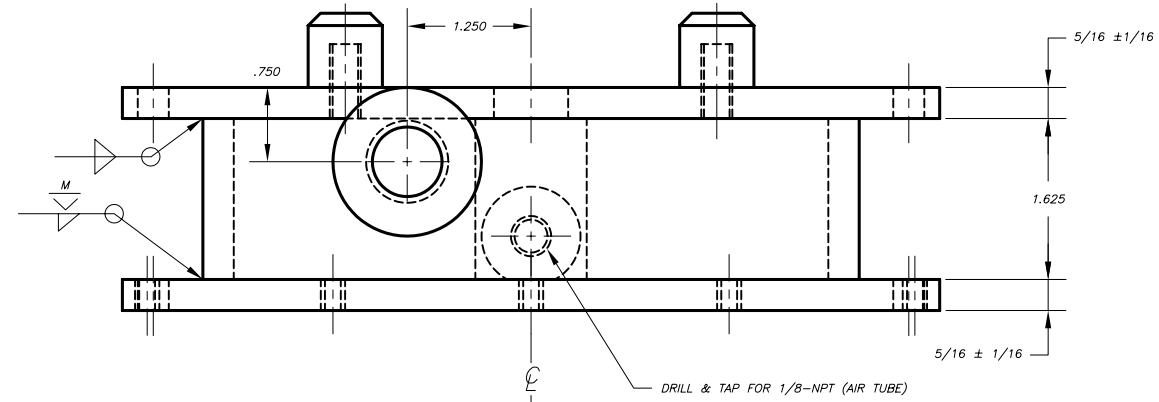
SECTION A-A



NOTES

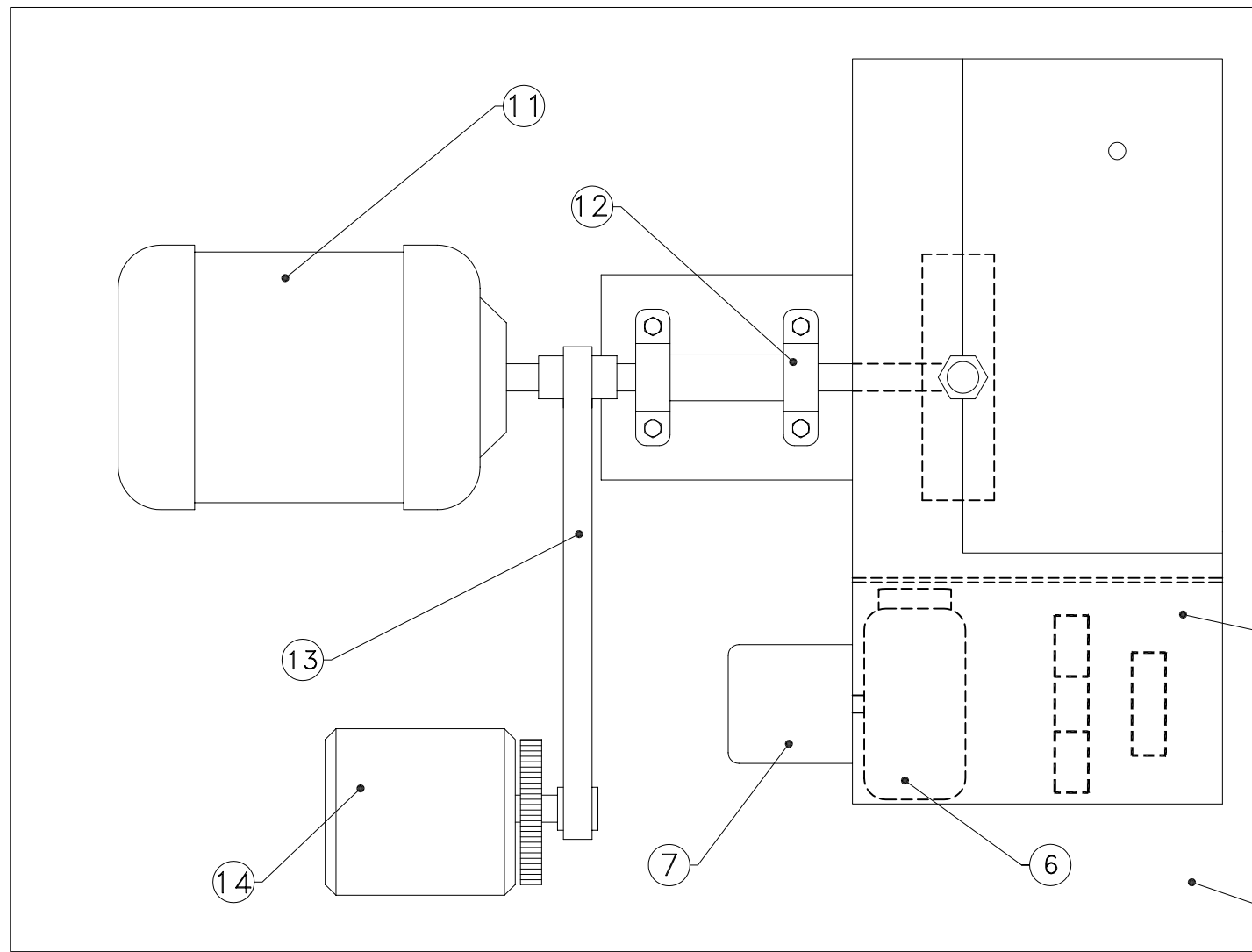
1. CASE CONSISTS OF A DOUBLE WALL CONTAINER WITH INSULATION BETWEEN THE WALLS
2. WALLS TO BE 16 GA HOT OR COLD ROLLED STEEL
3. ALL JOINTS TO BE WELDED LEAK PROOF
4. INSULATION TO BE INSTALLED DURING CONSTRUCTION
5. ALL HOLES THRU CASE TO BE LINED WITH METAL TUBE AND WELDED TO INNER AND OUTER WALLS
6. MUST MATCH COVER WITHIN 1/8"

|                              |              |                             |                                     |                                   |
|------------------------------|--------------|-----------------------------|-------------------------------------|-----------------------------------|
| TOLERANCES (EXCEPT AS NOTED) |              | <b>ASTM</b>                 |                                     | DWG FILE<br>C:OVEN                |
| DECIMAL<br>± .010            |              | L-60-1                      | SCALE<br>NTS                        | DRAWN BY T.L. HABY<br>APPROVED BY |
| FRACTION<br>± 1/8            |              | TITLE<br><b>HEATER CASE</b> |                                     |                                   |
| REVISION NO.<br>2            | ANGULAR<br>± | DATE<br>14JAN2004           | DRAWING NO.<br><b>D-6-6376-41-Z</b> |                                   |

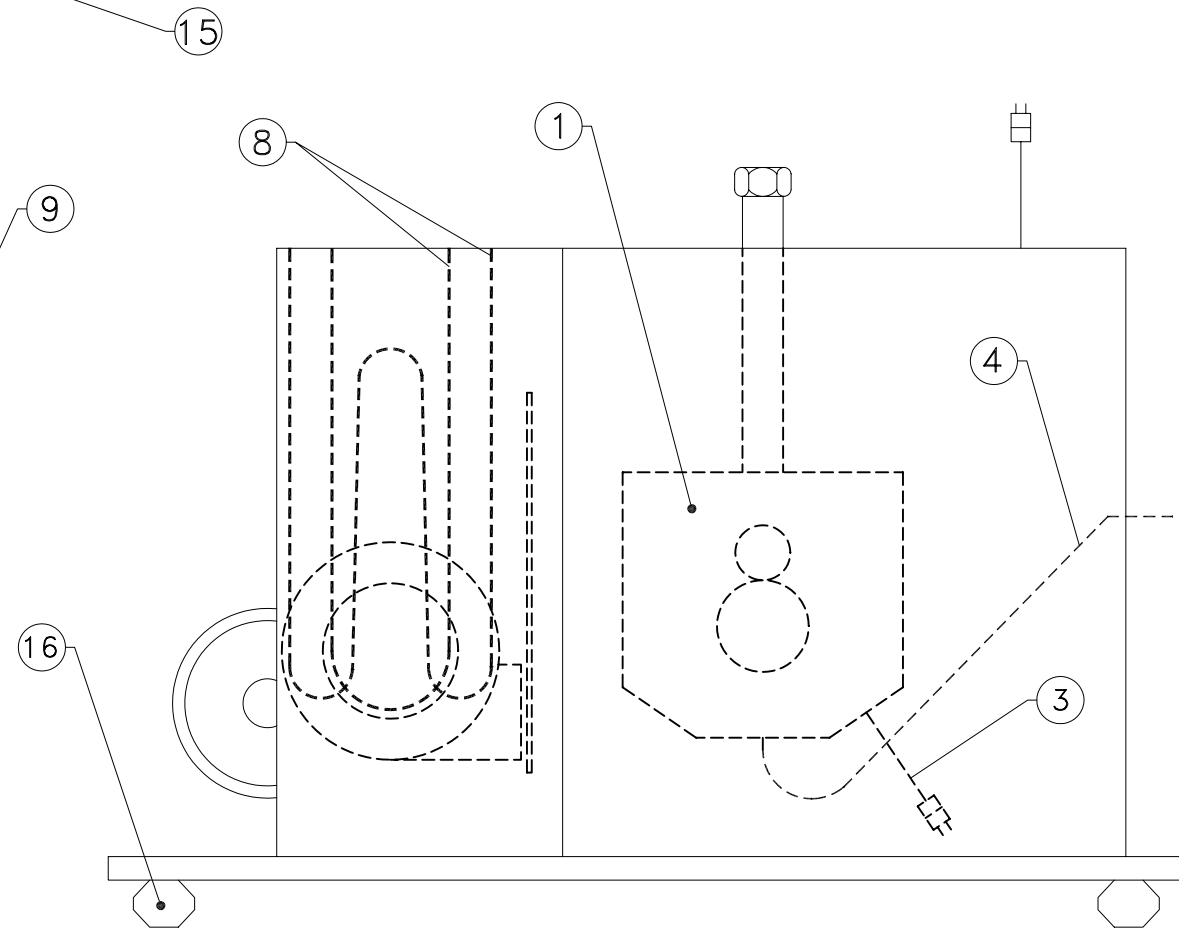
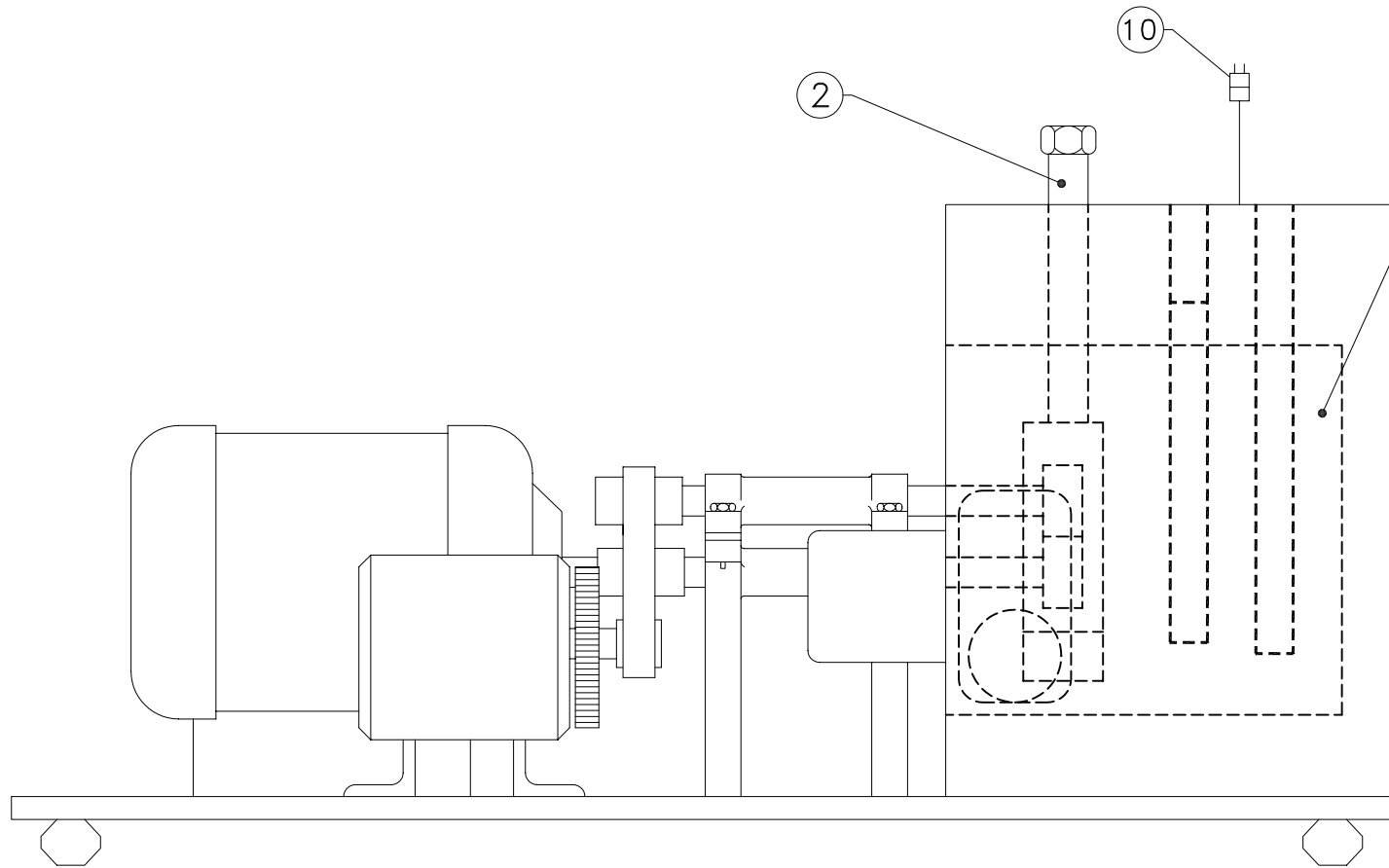


1. MATERIAL—303 STAINLESS STEEL 5/16 THICK; ALL JOINTS TO BE WELDED ON BOTH SIDES (INSIDE AND OUTSIDE CASE) OR MACHINE FROM BILLET.
2. STRESS RELIEVE AFTER WELDING
3. MACHINE FRONT FACE FLAT ±.001; MACHINE SIDES
4. MACHINE INSIDES OF BACK FLAT ±.001
5. MUST BE LEAK PROOF
6. INSIDE SURFACE OF CASE MUST BE FREE OF TOOL MARKS

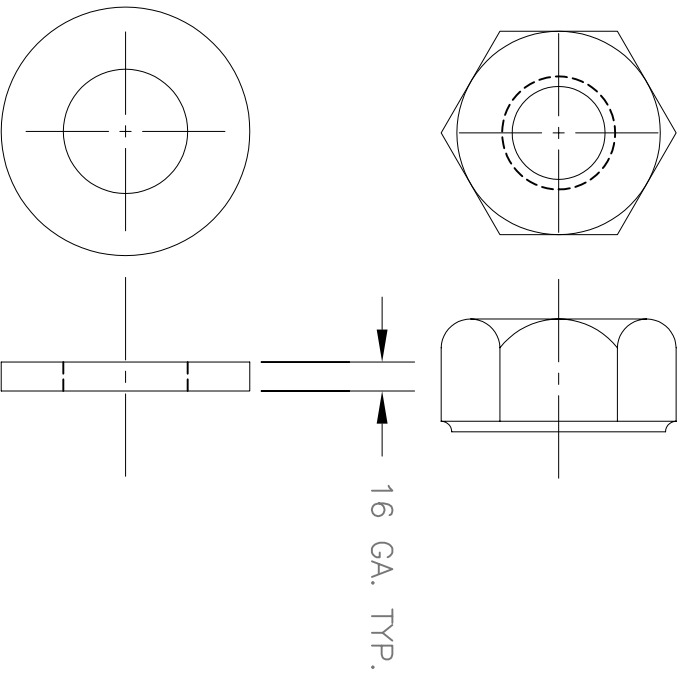
|                                 |                    |                   |                             |
|---------------------------------|--------------------|-------------------|-----------------------------|
| TOLERANCES<br>(EXCEPT AS NOTED) | <b>ASTM</b>        |                   | DWG FILE<br>C:GRCSE         |
| DECIMAL<br>± .005               | L-60-1             | SCALE<br>1=1      | DRAWN BY<br>T.L. HABY       |
| FRACTION<br>±                   | TITLE<br>GEAR CASE |                   |                             |
| REVISION NO.<br>2               | ANGULAR<br>±       | DATE<br>13MAY2004 | DRAWING NO<br>D-6-6376-42-Z |



- 1 GEAR CASE
- 2 GEAR CASE VENT TUBE
- 3 TEST LUBRICANT TEMP. SENSOR
- 4 AIR SUPPLY TUBE
- 5 INSULATED OVEN
- 6 BLOWER
- 7 BLOWER MOTOR
- 8 HEATING ELEMENTS
- 9 RADIANT HEAT BAFFLE
- 10 OVEN AIR TEMP. SENSOR
- 11 DRIVE MOTOR
- 12 PILLOW BLOCKS
- 13 VEE BELT
- 14 ALTERNATOR
- 15 BASE PLATE
- 16 VIBRATION MOUNTS



TYPICAL 5/16-18 STAINLESS NUT



TYPICAL STAINLESS WASHER 11/16 OD x 11/32 ID

4 EACH REQ'D

REVISION NO. 1

DWG FILE A:55  
DRAWN BY T.L. HABY ±

L-60-1

TITLE SEAL PLATE NUT AND WASHER

SCALE  
2=1

DATE  
15JAN2004

DRAWING NO  
A:6-6376-44-Z

**ASTM**