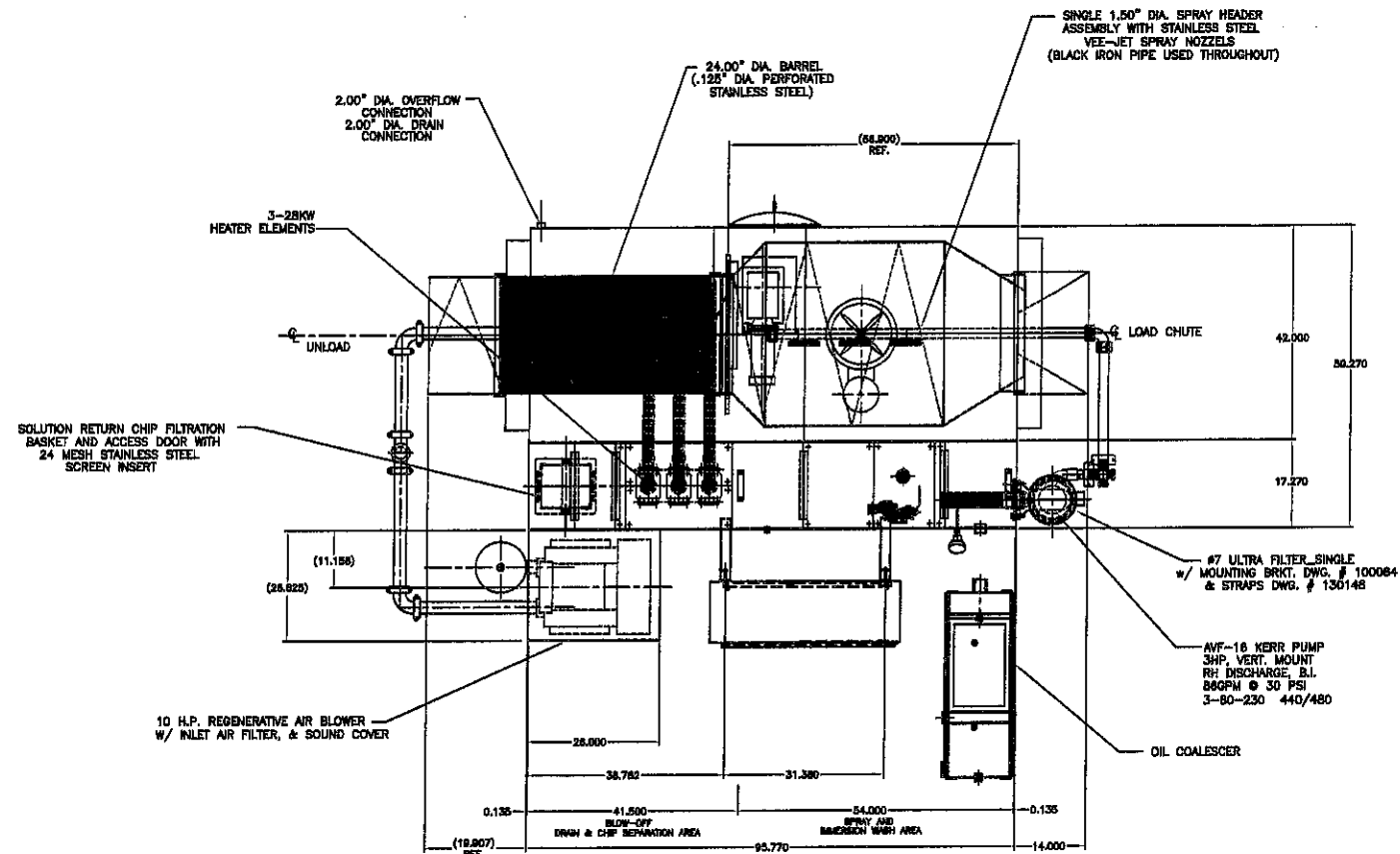
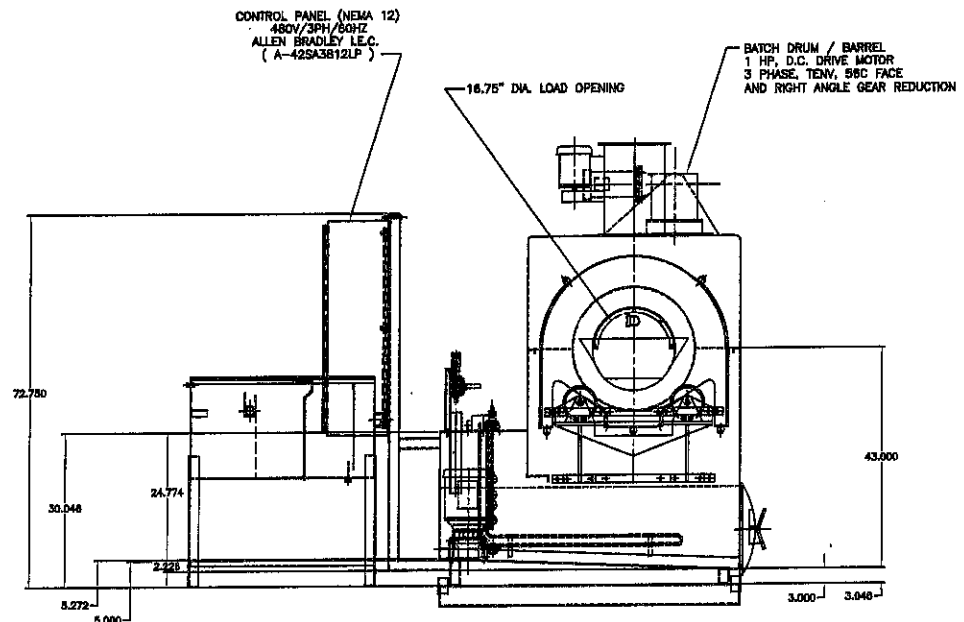
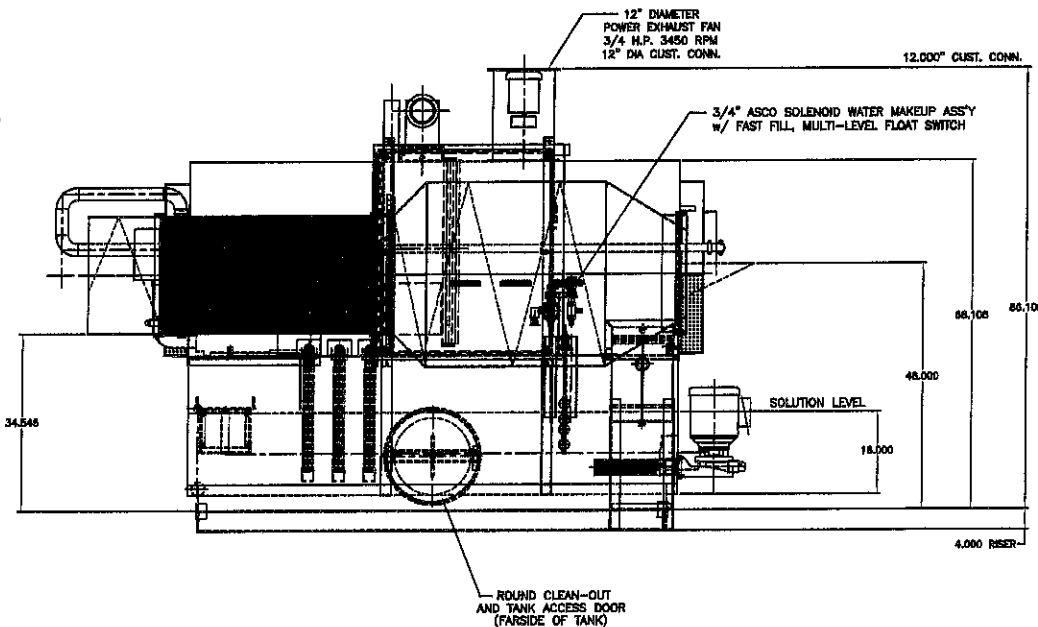
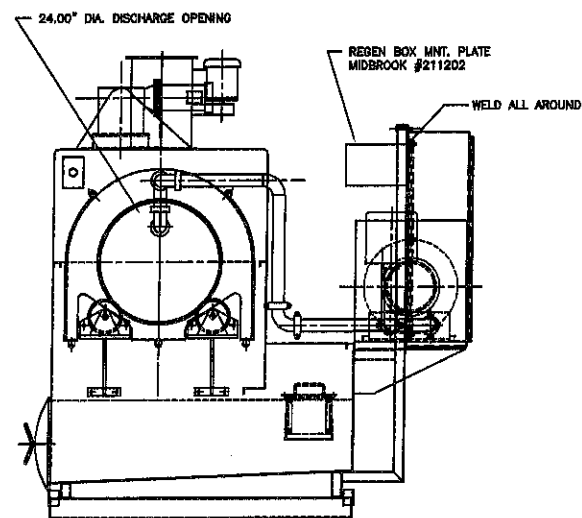




NOTES:

- PART(S) TO BE PROCESSED
PART NO: NA
PART NAME: SOLID JOINT PLIERS
LANE ASSIGNMENT:
- CLEANLINESS SPEC: SURFACE DEBRIS AND OILS
- DRYNESS SPEC: NONE
- PAINT SPEC: HURRICANE GRAY
PLUMBING: HURRICANE GRAY
STEAM/GAS: NA
GUARDS: YELLOW W/ BLACK FRAME
SIGNAGE: BT# HURRICANE STANDARD
- LINE SPEED/DRUM SPEED: 700 PARTS PER HOUR 1-4 RPM
- OPERATING TEMP/HEAT-UP TIME:
WASH TANK: 1454# F 60 MINUTES
RINSE TANK: NA
BLOW-OFF: NA
- DRYER TEMP: NA
- DECIBEL LEVEL: 85 dba
- INSULATION: NA
- REQUIRED TAGS: HURRICANE STANDARD
- TANK CONSTRUCTION: MILD STEEL
- TANK CAPACITIES:
WASH TANK: 366 GALS.
RINSE TANK: NA
- MACHINE PART ENVELOPE: SEE DRAWING
- MACHINE ACCESS DOORS: NA
- WASH TANK CHEMICAL & % OF CONCENTRATION: HURRICLEAN 8012
- RINSE TANK CHEMICAL & % OF CONCENTRATION: NA
- MACHINE IS EQUIPPED WITH A LOW SOLUTION LEVEL DETECTION: YES
-
-

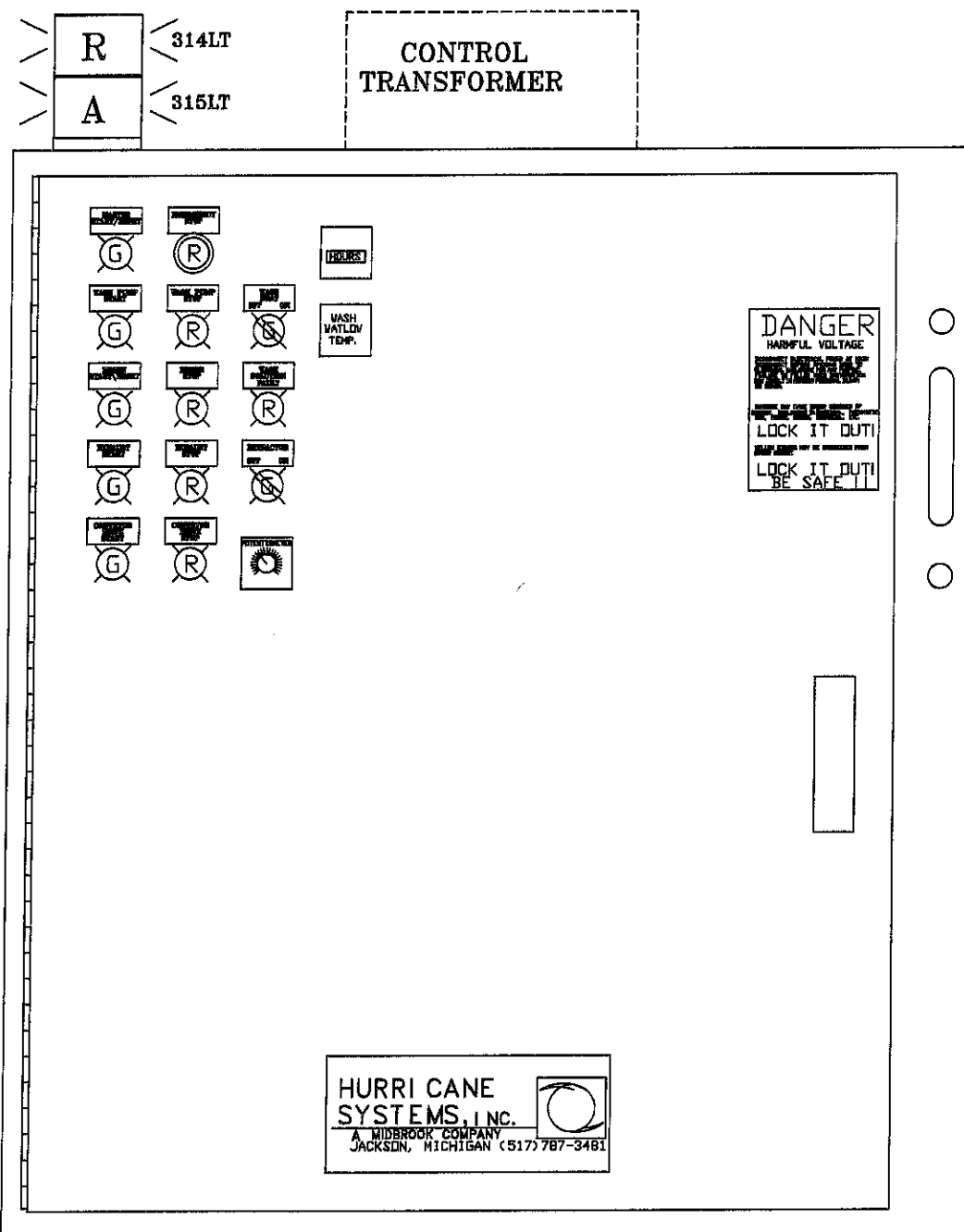


STANDARD HURRICANE TOLERANCES	
FABRICATION	MACHINING & LASER
MACHINE ASSEMBLY	.01 = .000
DIM = .01/0"	.00 = .000
LASER DIMS = .01/0"	.00 = .000
ANGLES ±1°-0'	SPECIAL TOLERANCES

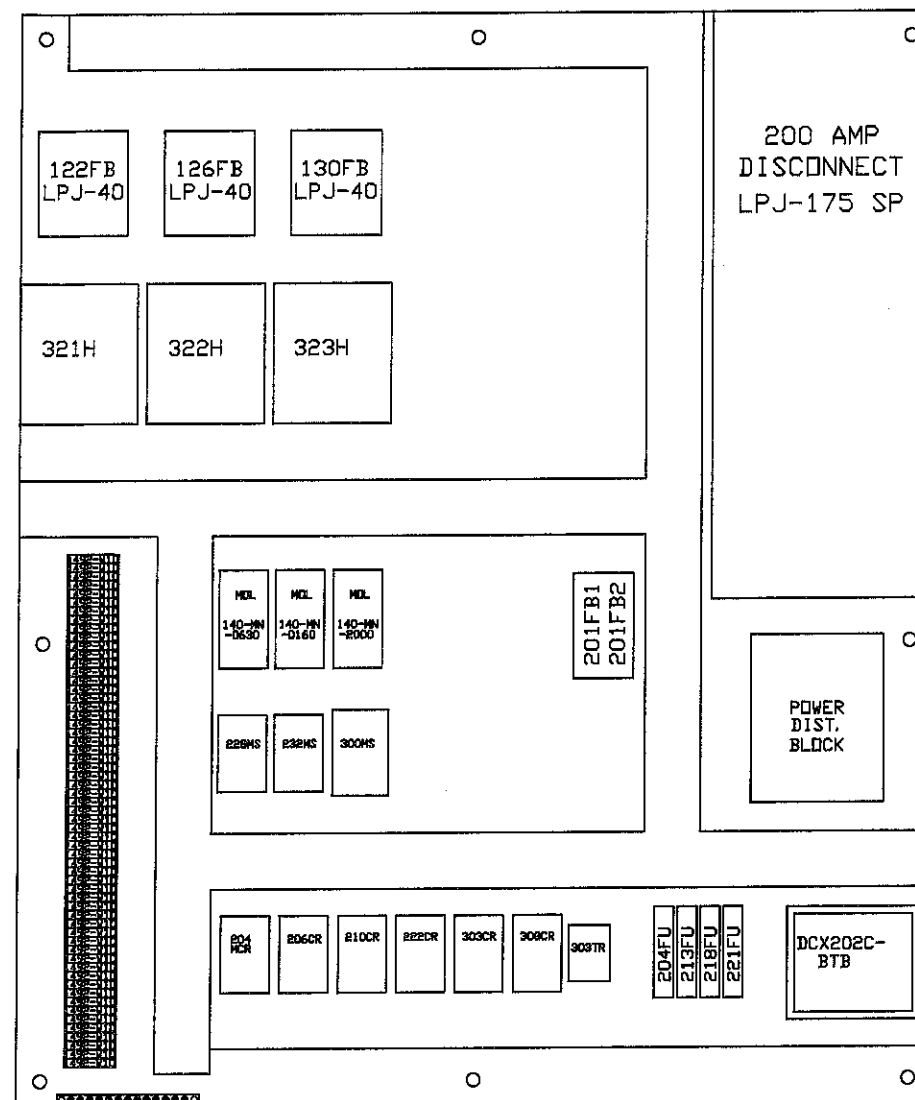
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RELEASED BY:		DATE:		JOB#:	
REV.	DESCRIPTION	BY	DATE		
DRAWN	KSC	DATE	05/28/88		
CHECKED	REV.				
APPROVED	SCALE		1" = 15"		
TITLE					
MODEL 250 ROTARY BATCH DRUM / BARREL					
WASH / BLOW-OFF (ELECTRIC HEAT)					
MATERIAL	SEE B.O.M.	SIZE	D	DWG. NO.	RM-25-0105
				SHT.	1

CAD FILE: Rm250105.dwg



ENCLOSURE HOFFMAN A42SA3812LP



PANEL: 39"H X 33"W
HOFFMAN A42P36

	PAINT
OUT SIDE ENCLOSURE	HURRICANE GRAY
INSIDE ENCLOSURE	WHITE
INSIDE DOORS	WHITE
OUTSIDE DOOR	HURRICANE GRAY
JUNCTION BOXES	HURRICANE GRAY
INSIDE DOORS	GRAY

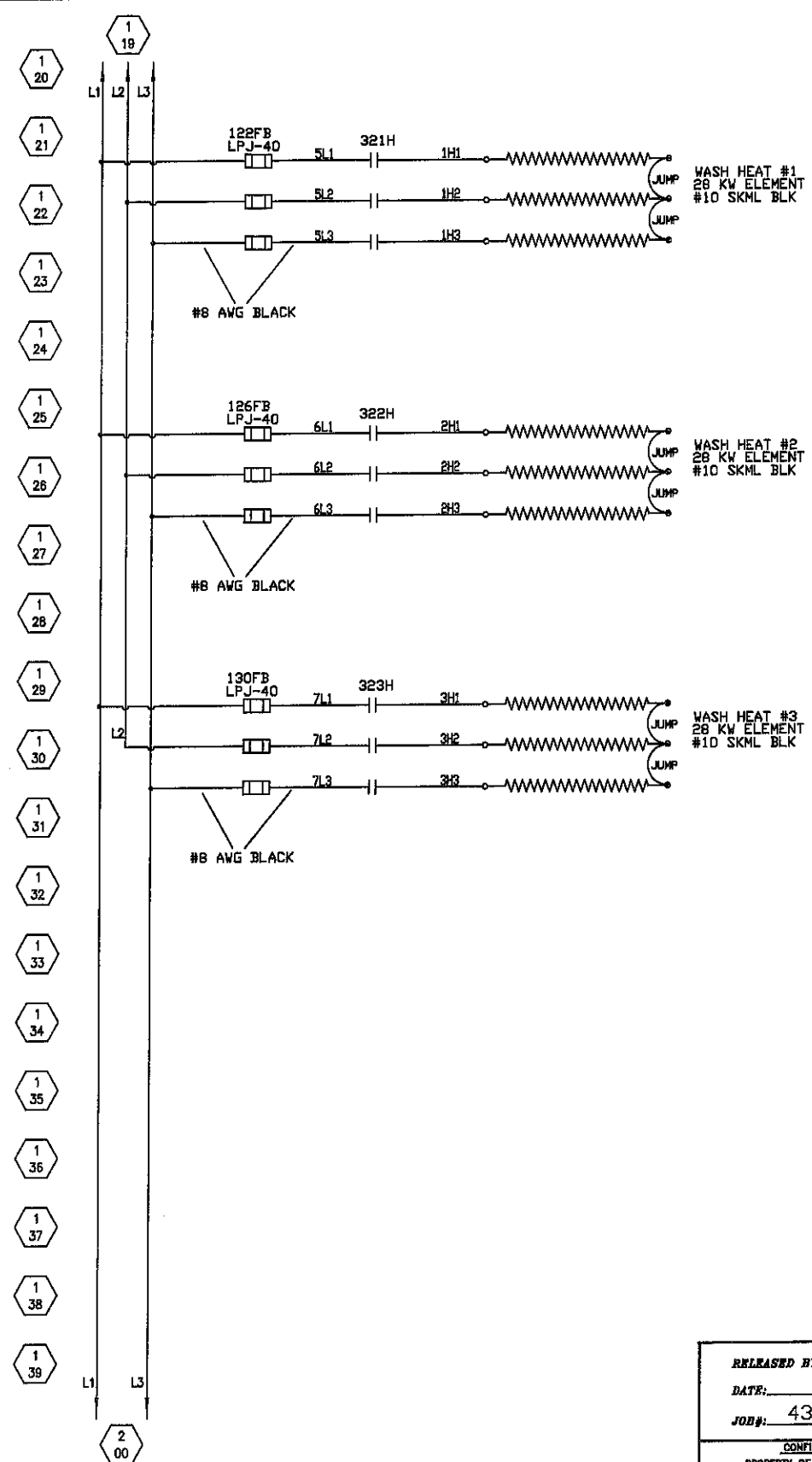
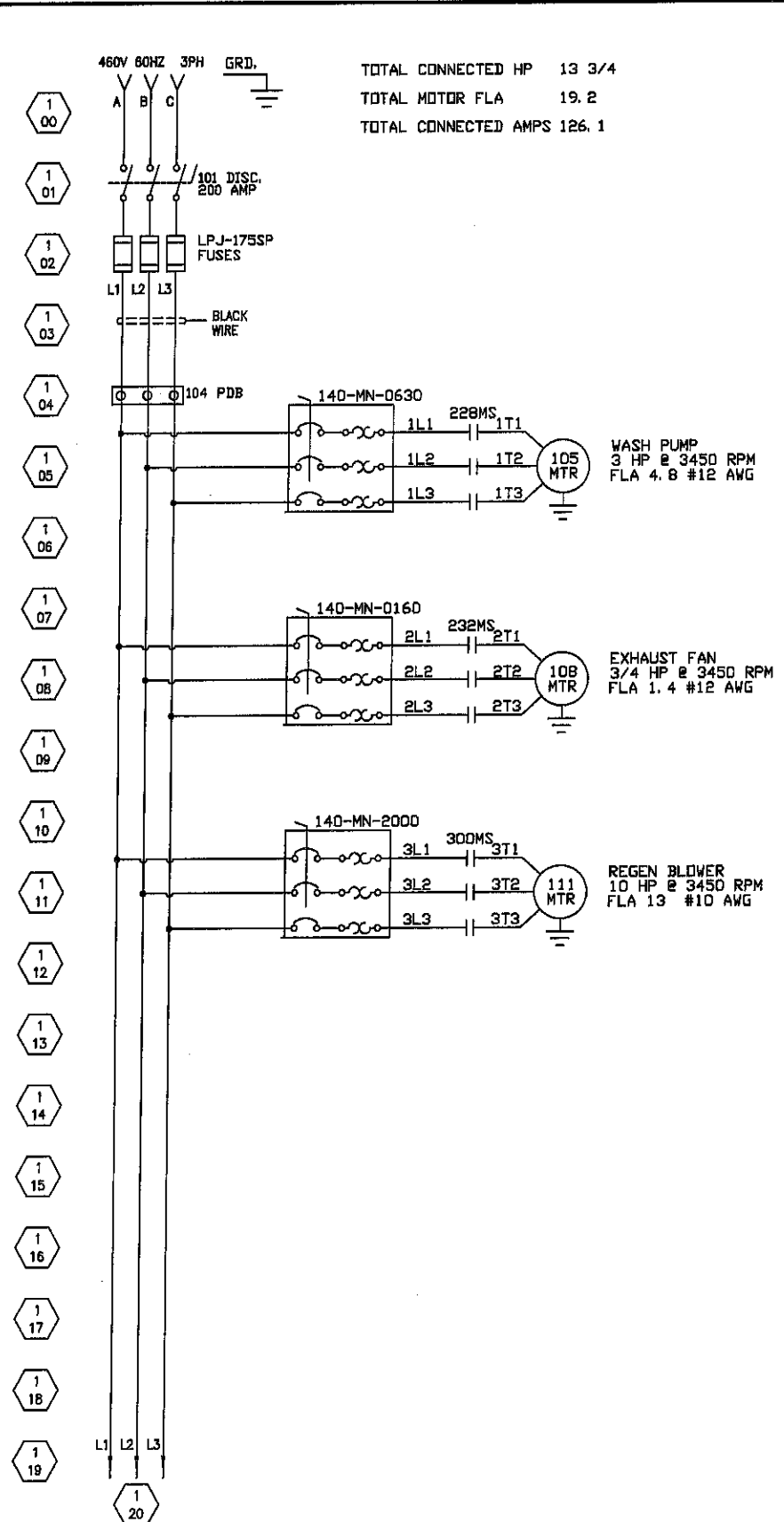
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DATE:			
JOB#: 43968			
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REV	DESCRIPTION	BY	DATE
DRAWN	JES	DATE	06/28/98
CHECKED	TJD	REV.	
APPROVED	SCALE	1=3	
TITLE		WESTERN FORGE	
250 WASH/BLOW-OFF (ELECTRIC HEAT)		ELECTRICAL SCHEMATIC	
MATERIAL	SERIAL #43968	SIZE	DWG. NO. 43968-04
		QTY	1

ITEM # QTY

BILL-OF-MATERIAL			
QTY.	DESCRIPTION	PART NO	MFG.
1	ELECTRICAL ENCLOSURE	A42SA3812LP	HOFFMAN
1	PANEL	A42P36	HOFFMAN
3	FUSE	LPJ-175 SP	BUSS
2	FUSE	LPJ-15 SP	BUSS
9	FUSE	LPJ-40 SP	BUSS
3	FUSE	KTK-R3	BUSS
1	FUSE	KTK-R1	BUSS
1	FUSE	KTK-R15	BUSS
4	FUSE BLOCK	CHCC1I	BUSS
2	FUSE BLOCK	JTN-60030	BUSS
9	FUSE BLOCK	JTN-60060	BUSS
1	200 AMP DISCONNECT	1494V-DH622	A-B
2	200 AMP LUG KIT	1494R-N3	A-B
1	LONG ROD	1494V-RA2	A-B
2	CONTACTOR	100-AD9-ND3	A-B
1	CONTACTOR	100-A18-ND3	A-B
1	MAN. MTR. STARTER	140-MN-0160	A-B
1	MAN. MTR. STARTER	140-MN-0630	A-B
1	MAN. MTR. STARTER	140-MN-2000	A-B
3	AUX. CONTACT	140-A10	A-B
3	ADDER DECK	195-FA11	A-B
5	RELAY	700F-310A1	A-B
1	RELAY	700F-220A1	A-B
1	SOLID STATE TIMER	700-HRM12TA17	A-B
1	TIMER BASE	700-HN125	A-B
1	LIGHTED P/B	800T-PB16A2	A-B
8	LIGHTED P/B	800T-PB16	A-B
5	GREEN LENS	800T-N41	A-B
4	RED LENS	800T-N40	A-B
1	PILOT LIGHT	800T-P16	A-B
1	RED LENS	800T-N26R	A-B
3	MUSHROOM HEAD P/P	800T-FX6D4	A-B
2	LIGHTED SELECTOR SWITCH	800T-16HG2KB6AX	A-B
1	POWER DIST. BLOCK	1492-PD3163	A-B
1	GROUND LUG	L-250	GENERIC
1	GROUND BAR	GB-14	GENERIC
3	CONTACTOR	360-ND-120A18	MDI
1	CONTROL TRANSFORMER	T2-53013S	ACME

BILL-OF-MATERIAL			
QTY.	DESCRIPTION	PART NO	MFG.
AR	TERMINALS	1492-W10	A-B
1	HOUR METER	8681T85	HECON
1	STACK LIGHT	CS-212	PAT-LITE
1	ROLLER LATCH KIT	9423-M4	SQUARE D
1	3RD ROLLER KIT	9423-M3	SQUARE D
1	THERMOSTAT	93AA-IDAD-00RR	WATLOW
1	DC MOTOR CONTROLLER	DCX-202C-BTB2	BOSTON
1	DC MOTOR CONTROLLER	DCX-HTSK	BOSTON
1	THERMOCOUPLE ASSEMBLY	0649	MIDBROOK
1	FLOAT SWITCH CORD	2376	MIDBROOK
1	MULTI LEVEL FLOAT SWITCH	2377	MIDBROOK
2	E-STOP BOX	0379	MIDBROOK

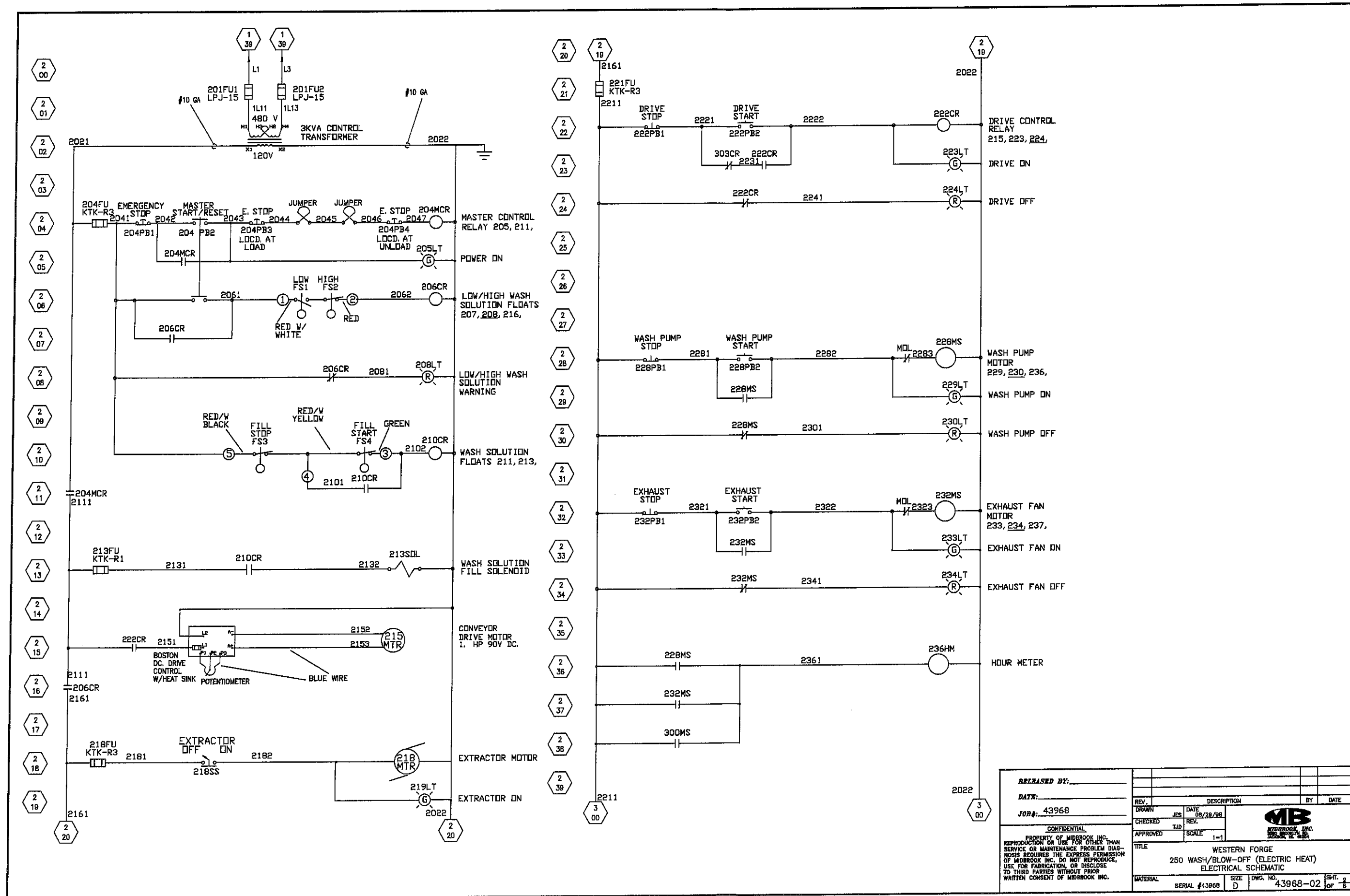
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DATE:					
JOB #: 43968					
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REV.	DESCRIPTION	BY	DATE		
DRAWN	JES	DATE	08/29/98		
CHECKED	TJD	REV.			
APPROVED	SCALE	1=1			
TITLE		WESTERN FORGE			
		250 WASH/BLOW-OFF (ELECTRIC HEAT)			
		ELECTRICAL SCHEMATIC			
MATERIAL	SERIAL #43968	SIZE	D	DWG. NO.	43968-05
				SHT.	5
				OF	8

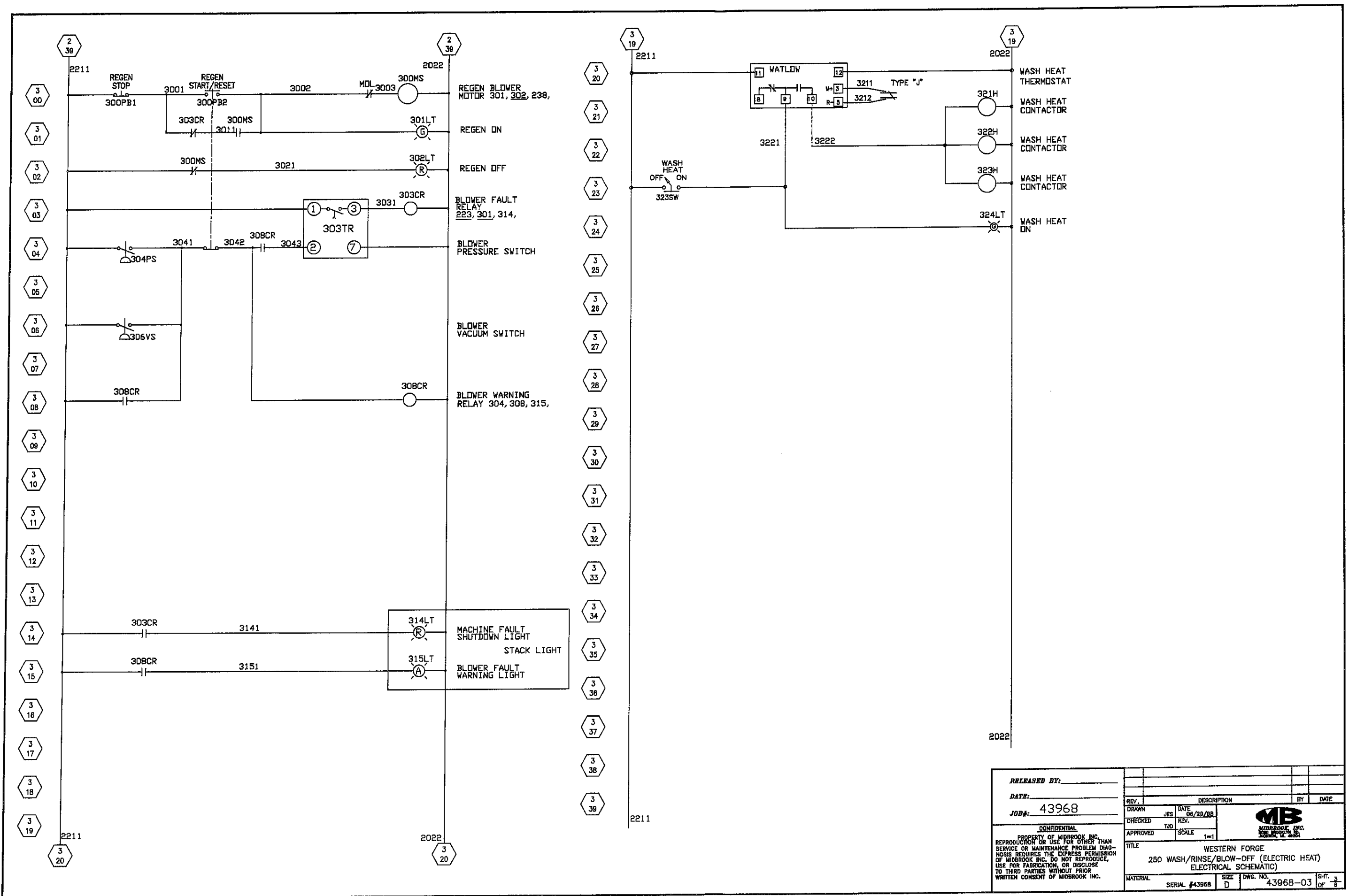


RELEASED BY:			
DATE:			
JOB#: 43968			
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REV.	DESCRIPTION	BY	DATE
DRAWN	JES	DATE	90/20/98
CHECKED	TJD	REV.	
APPROVED	SCALE	1=1	
TITLE			
WESTERN FORGE			
250 WASH/BLOW-OFF (ELECTRIC HEAT)			
ELECTRICAL SCHEMATIC			
MATERIAL	SERIAL #43968	SIZE	DWG. NO.
			43968-01
			SHT. OF 1

ITEM # QTY

CAD FILE: 43968-01.dwg



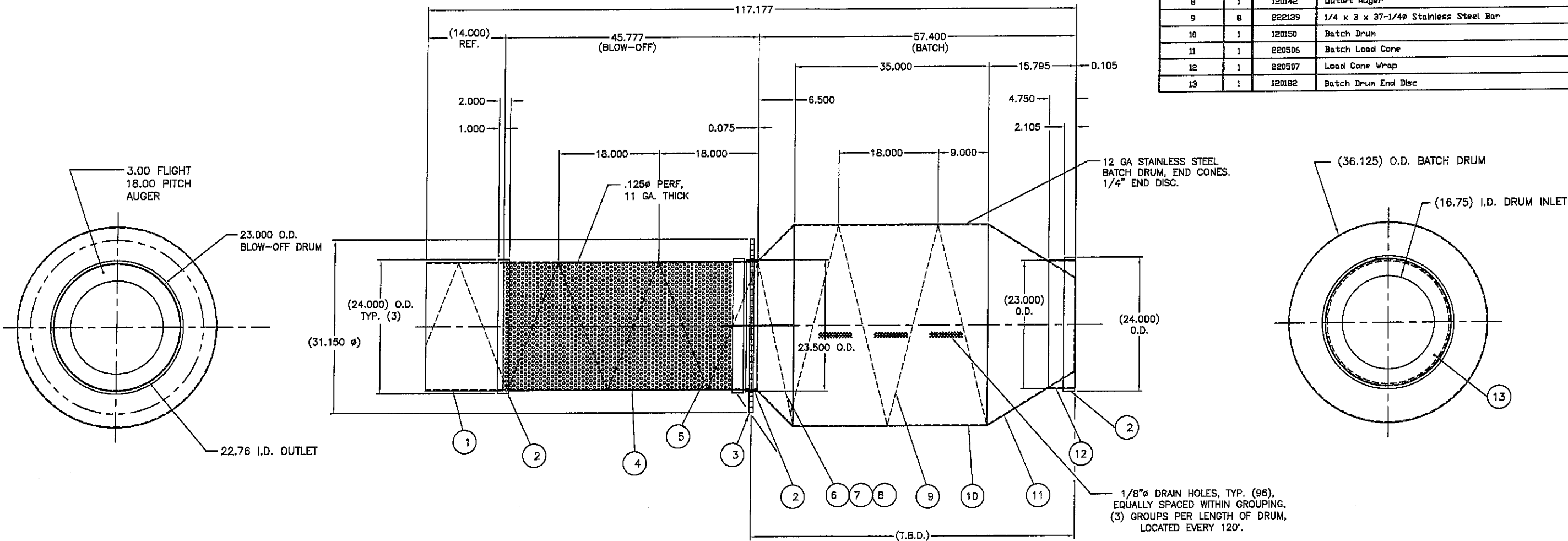


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JOB# 43968			
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DRAWN	JES	DATE	06/20/88
CHECKED	TJD	REV.	
APPROVED		SCALE	1=1
TITLE		WESTERN FORGE	
		250 WASH/RINSE/BLOW-OFF (ELECTRIC HEAT)	
		ELECTRICAL SCHEMATIC	
MATERIAL	SERIAL #43968	SIZE	D
DWG. NO.	43968-03	SHR.	3
		OF	8

- 1 AFTER CHECKING TO SEE THAT THE MACHINE IS CLEAR OF OBSTACLES AND PERSONNEL. TURN THE MAIN DISCONNECT ,LOCATED AT THE UPPER RIGHT HAND CORNER OF THE MAIN ELECTRICAL ENCLOSURE TO THE ON POSITION.
- 2 THEN PRESS THE GREEN MASTER START/RESET BUTTON. THIS WILL ENABLE THE MASTER CONTROL RELAY AND TURN OFF THE RED LOW SOLUTION LIGHT IF THE PROPER SOLUTION LEVEL HAS BEEN OBTAINED.
- 3 TURN THE SOLUTION HEAT SWITCH TO THE ON POSITION. THEN SET TEMPERATURE TO THE DESIRED SETTING.
- 4 WHEN DESIRED TEMPERATURE HAS BEEN REACHED PRESS THE WASH PUMP START BUTTON, THE GREEN LIGHT WILL COME ON TO INDICATE PUMP RUNNING.
- 5 PRESS THE REGEN START/RESET BUTTON THIS WILL LIGHT THE GREEN REGEN ON LIGHT IF AN AIR PRESSURE OR VACUUM FAULT OCCURS THE AMBER BLOWER LIGHT WILL GO ON FOR 3 MINUTES THEN THE RED FAULT SHUTDOWN LIGHT WILL LIGHT AND SHUT DOWN THE REGEN BLOWER AND THE DRIVE. TO RESTART, SERVICE THE FILTERS AND NOZZELS AND PRESS THE REGEN START/RESET BUTTON THEN PRESS THE DRIVE START BUTTON.
- 6 TO START THE EXHAUST FAN PRESS THE GREEN EXHAUST START BUTTON. THE GREEN EXHAUST ON LIGHT WILL COME ON.
- 7 TO START THE DRIVE PRESS THE GREEN DRIVE START BUTTON. THE GREEN DRIVE ON LIGHT WILL COME ON.
- 8 TO SHUT THE MACHINE DOWN ,CLEAR ALL PARTS OUT OF MACHINE. TURN THE SOLUTION HEAT OFF, THEN PRESS THE WASH PUMP STOP BUTTON, THEN PRESS THE REGEN STOP BUTTON, THEN PRESS THE DRIVE STOP BUTTON, THEN PRESS THE EXHAUST STOP BUTTON THEN PRESS THE EMERGENCY STOP BUTTON ON THE MAIN ENCLOSURE.

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DATE: _____					
JOB#: 43968					
CONFIDENTIAL					
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REV.	DESCRIPTION	BY	DATE		
DRAWN	JES	DATE	06/29/98		
CHECKED	TJD	REV.			
APPROVED	SCALE	1=1			
TITLE		WESTERN FORGE			
		250 WASH/BLOW-OFF (ELECTRIC HEAT)			
		ELECTRICAL SCHEMATIC			
MATERIAL	SERIAL #43968	SIZE	D	DWG. NO.	43968-06
				SHT.	6
				OF	6

ITEM No.	QTY	PART NO#	DESCRIPTION
1	1		10 GA. x 14.000' x 71.875" Stainless Steel
2	4	120152	Barrel Ring
3	1		Sprocket (80A96)
4	1		11Ga. x 45-7/8 x 71-7/8 Perforated S.S.
5	4	222138	1/4 x 3 x 24-1/2" Stainless Steel Bar
6	1	120139	Batch Exit Cone
7	1	120138	Liftout Auger
8	1	120142	Outlet Auger
9	8	222139	1/4 x 3 x 37-1/4" Stainless Steel Bar
10	1	120150	Batch Drum
11	1	220506	Batch Load Cone
12	1	220507	Load Cone Wrap
13	1	120182	Batch Drum End Disc



STANDARD HURRICANE TOLERANCES	
FABRICATION	MACHINING & LASER
MACHINE ASSEMBLY DAL= ±1/8"	.0 = ±.100 .00 = ±.020
LASER BENDS = ±1/16"	.000 = ±.005 ANGLES ±1°-0'
MACHINING REQUIRED	SPECIAL TOLERANCES

RELEASED BY: _____

DATE: _____

JOB#: _____

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REV.	DESCRIPTION	BY	DATE
DRAWN	LCA	DATE	09 Jul 98
CHECKED	REV.		
APPROVED	SCALE	1=18	
MIDBROOK, INC. 2080 BROOKLYN RD. JACKSON, MI. 49204 TITLE MODEL 250, 12 GA. BATCH EXTERNAL BEARING BATCH / BARREL DRUM ASS'Y			
MATERIAL	SEE B.O.M.	SIZE	B
DWG. NO.	Bxx-7462	SHT.	OF

ITEM # _____ QTY _____