

Specifications:

PRETREATMENT SYSTEM - 3 STAGE WASHER

Stage 1 - Steam 400gal Net Capacity 100sec 150F max
 1 - 5 hp Spray Pump (#316 S/S) - 150 gpm @ 60' hd
 80 AH Air Heat Burner w/.33 hp Blower
 8000cfh Natural Gas - 2 to 5 psi supply pressure
 Heat Exchanger Construction - 10 gal. HRS
 Automatic Back Flow Make-up from Stage 2
 Manual Fresh Water Fill

Stage 2 - Rinse 350gal Net Capacity 60sec Ambient
 1 - 5 hp Spray Pump (#316 S/S) - 90 gpm @ 60' hd
 Manual Fresh Water Make-up & Manual Fresh Water Fill

Stage 3 - Steam/Steam 350gal Net Capacity 60sec Ambient
 1 - 5 hp Spray Pump (#316 S/S) - 90 gpm @ 60' hd
 Automatic Fresh Water Fill/Make-up

General
 Tank Construction - 3/16" #304 S/S Plate
 Drain boards - 12ga #304 S/S
 Cathodes - 12ga #304 S/S
 Sump Covers - 12ga #304 S/S
 Exhaust Fan - 533 cfm @ 3" SP - 2 hp
 2 Vent Fans - 2125 cfm ea. - 1hp
 Pressure Gauges and Flow Control Valves on All Pumps
 Spray Risers - 10 Nozzles - Side/Side
 Insurance Standard - FM

DRY-OFF OVEN

Two Pass
 Design Maximum Operating Temperature - 350' F.
 Design Product Throughput - 3000 lbs/hr Steel
 Residence Time - 15 min. @ 3' FM Conveyor Line Speed
 High Velocity Air Seals - 2 @ 2 hp

General
 Heat System - 80 AH Air Heat Burner w/.33 HP Motor
 1 1/4" DWS Backdrafting Air Blower - 7,682 cfm - 7.5 hp
 800 cfm Natural Gas @ 2-5 PSI Supply Pressure
 Insulated 'b' Deck Floor
 6" Thick Oven Walls and Roof
 Exhaust Fan - 700 cfm - 1 hp
 Insurance Standard - FM

CONVEYOR SYSTEM

Rapid 3" Y Beam Conveyor - Floor Supported - 330 ft. Running Length
 Trolleys w/Full Complement Ball Bearings, No Seals, 1" Attachments
 & Trolleys on 24" Spacers
 Line Speeds - 3 FPM (2 To 4 FPM Range)
 Average Line Loading - 17 lbs/ft
 All Turns to be 24" Roller Bank Except for Internal Oven Turns
 Which Shall Be Graphopoly Bushed Traction Wheel Type
 Caterpillar Drive - Variable Speed A/C (Located in Oven Panel)
 Air Operated Trolley
 Oven Expansion Joints on Required
 Automatic Chain Lubricator

IMPORTANT:
 Per NFPA 86 (1999), Section 3-4.1, "A sufficient quantity of makeup air shall be admitted to oven rooms and buildings to provide the air volume required for oven safety ventilation and adequate combustion air."

GENERAL NOTES

1. All Specifications are subject to completion of System Engineering.
2. LIBRITY requirements are approximate. Actual requirements should not be greater than those stated and may be less.
3. Deflagration venting for powder coating equipment (if required) to be supplied and installed by customer.

REVIEW THIS DOCUMENT CAREFULLY. APPROVAL IS REQUIRED FOR MUTUAL PROTECTION OF PURCHASER AND SELLER.

SATISFACTORY AND APPROVED FOR FABRICATION

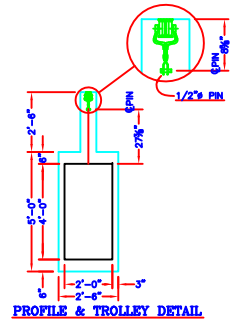
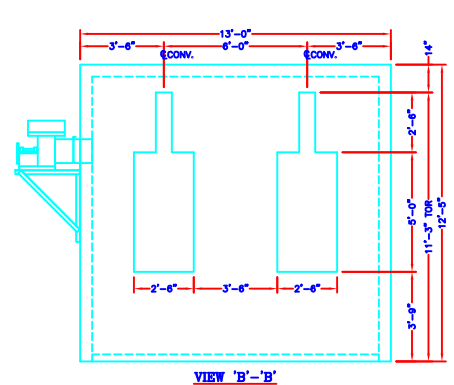
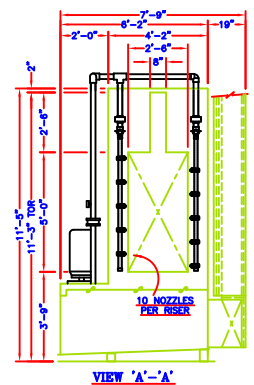
APPROVED FOR FABRICATION WITH CHANGES NOTED.

UNSATISFACTORY. REQUIRES REVISED PRINT WITH CHANGES AS INDICATED.

DESIGNED BY: _____

SIGNATURE DATE _____ TITLE _____

PRIOR APPROVAL

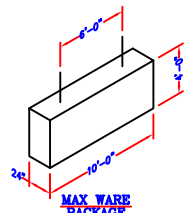


UTILITY LEGEND

G1 - Washer 80 amp - 240 V / 3 Ph. (70A Fuse - 100A Disc.)
 G2 - Wash 6.5 amp - 240 V / 3 Ph. (60A Fuse - 80A Disc.)
 W1 - City Water 40 amp - 120 V / 3 Ph. (20A Disc.)
 B1 - Booth Lights 20 amp - 120 V / 3 Ph.
 C1 - Booth Electric 40 amp - 240 V / 3 Ph.
 A1 - AMI Electric 71 amp - 240 V / 3 Ph.

G1 - Washer Gas Drop, 800 CFH Natural Gas, 2-5 PSI Req'd.
 G2 - Dry-Off Oven Gas Drop, 800 CFH Natural Gas, 2-5 PSI Req'd.
 W1 - City Water Connection - 1 1/2" IPS
 A1 - Take-up Compressed Air @ 30 PSI - No CFM

NOTE: G1 & G2 Have Regulators By G.A.T.



REQUIRED CUSTOMER INFORMATION

The following information is required before detail engineering can begin. Please include the following information on the return copy of this approval drawing:

Roof Height: 33'-0" (ft-in)
 Clear Height: 11'-0" @ base, 10'-0" (ft-in)
 10'-0" @ EXHAUST

Roof Slope: FLAT (inches per foot) (Indicate direction)

3 phase Voltage: 240
 Heat Source: Natural Gas or Electric
 Fuel Supply Pressure: 2-5 (psi)
 NOTE: 2psi(min req'd) - 7psi(max allowed)

Building Access Size & Location: _____

Revision	Notes
01-15-08	ENHANCE CHANGES
02-28-08	OVEN EXHAUST ROOF
03-05-08	WEAT SIZE & CONVEYOR CHANGE
04-10-08	HOAST CONV. NEW TROLLEY
05-26-08	WOVED BOOTH CHANGES

GENERAL AUTOMATIC TRANSFER CO. ST. LOUIS, MO.

FOR: _____

JOB: _____

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SCALE: 3/16"=1'-0"	DRAWN BY: D.GUIRL	DATE: 08-17-07
CHECKED BY: _____	DESIGNED BY: _____	PROJECT NO: 07155