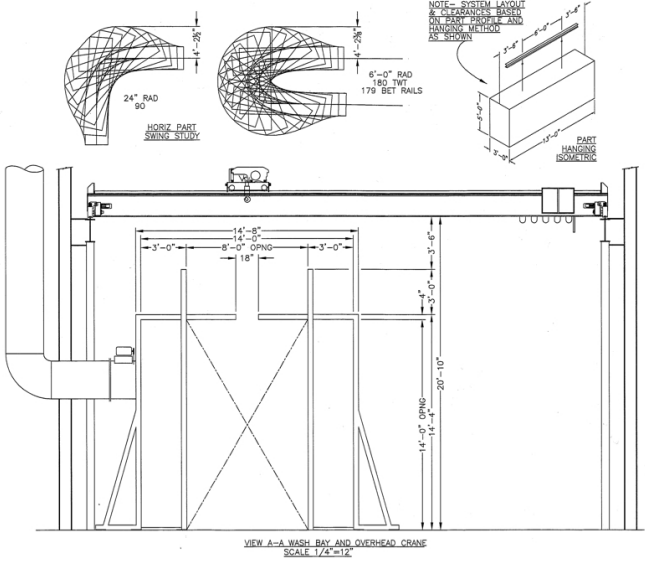
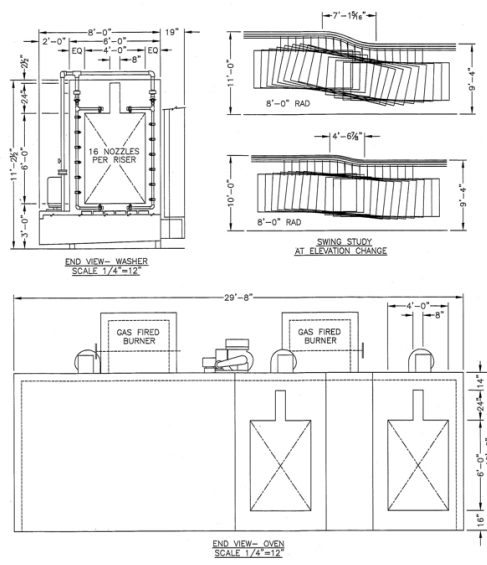
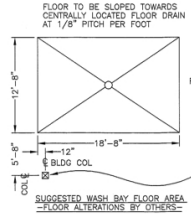


PLAN VIEW - SCALE 1/8"=12"

**UTILITY LEGEND**  
 NOTE: #S DO NOT INCLUDE P/C BOARDS  
**WASHER:**  
 A - NEW CONTROL PANEL - 460V/3PH/60HZ - 25 AMPS  
 B - EXISTING CONTROL PANEL - 460V/3PH/60HZ - 35 AMPS  
 C - STG 1-2 - 3 PSI PROPANE GAS - 480 CFH  
 D - STG 1-2 - 3 PSI PROPANE GAS - 480 CFH  
 E - 1 1/2" WATER CONNECTION AT CITY PRESSURE  
 F - 1 1/2" WATER CONNECTION AT CITY PRESSURE  
**OVEN:**  
 G - CONTROL PANEL - 460V/3PH/60HZ - 60 AMPS  
 H - 2 PSI PROPANE GAS - 960 CFH, 1 1/2" CONNECTION  
 I - 5 PSI PROPANE GAS - 960 CFH, 1 1/2" CONNECTION  
**CONV:**  
 J - 1/4" COMPRESSED AIR (50 PSI MIN) FOR TAKE-UP  
 K - 120V/1PH/60HZ - 2 AMPS FOR AUTOMATIC OILER  
**WASH BAY:**  
 M - MOTOR STARTER - 460V/3PH/60HZ - 10 AMPS



VIEW A-A WASH BAY AND OVERHEAD CRANE SCALE 1/4"=12"

**Specifications:**

**WASHER:**  
 Note - Below Washer Specifications cover replacement stages 1 & 2 only - Stages 3 thru 5 are existing  
**Stage 1 - Clean**  
 638gal Net Capacity - 60sec-160F max.  
 1-2hp Spray Pump 182 gpm @ 60" wc  
 1-120A4 Air Heat Burner w/33hp Blower  
 480cfm Propane Gas - 5 psi supply pressure  
 Heat Exchanger Construction - 304 SS  
 Automatic Back flow Make-up from Stage 2  
 Manual Fresh Water Fill  
**Stage 2 - Rinse**  
 438gal Net Capacity 45sec-Ambient  
 1-2hp Spray Pump 144 gpm @ 60" wc  
 Manual Fresh Water Fill  
**General:**  
 Tank Construction - 3/16" 304 SS Plate  
 Drain boards - 12ga 304 SS  
 Catwalks - 12ga 304 SS  
 Sump Covers - 12ga 304 SS  
 Entrapment Vent Fan - 4100 cfm - 2hp  
 Pressure Gauges and Flow Control Valves on All Pumps  
 All Spray Risers - 18 nozzles - Side/Over/Under  
 304 SS Conveyor Roll in washer  
 Insurance Standards - N/A  
 Power Requirement - 460V/3ph/60hz - 25 Amps  
 Note: Washer C/P contains controls for conveyor drive  
**COMBINATION OVEN**  
**Unit - 1 Pass**  
 Single Pass  
 Design Maximum Operating Temperature - 400F  
 Design Product Throughput - 15,000 lb/hr  
 Residence Time - 8 min @ 4 fpm Conveyor Line Speed  
 High Velocity Air Seals - 2 @ 2hp  
**Cure Zone**  
 Three Pass  
 Design Maximum Operating Temperature - 500F  
 Design Product Load - 15,000 lb/hr  
 Residence Time - 35 min @ 4 fpm Conveyor Line Speed  
 Heat System - 2 ea - 240TAH Air Heat Burner w/33 hp blower  
 2 ea #1 1/4" DWV Reducing Air Blower - 18,000cfm - 15hp  
 1920cfm Propane Gas (2 drops @ 960) - 5 psi Supply Pressure  
 Exhaust Fan - 18,000cfm - 15hp  
 High Velocity Air Seals - 2 @ 2 hp  
**General:**  
 B-Deck Divider Wall  
 Insulated B-Deck Floor  
 6" Thick Oven Walls and Roof  
 Power Requirement - 460V/3ph/60hz - 60 Amps  
**WASH BAY**  
 Construction of 4" struct. tubing with 1/2" thk polypropylene panels  
 Exhaust fan - 30" tubecoid - 13190 cfm @ 1" sp - 5 hp

**CONVEYOR SYSTEM**  
 X-458 I-Beam Conveyor - Floor Supported - 660 ft Running Length  
 Trolleys w/Full Complement Ball Bearings, H-Attachment & Carrier Pins,  
 No Sides or Nylon Rugs - 7 3/16" Drop - Trolleys on 24" centers  
 Line Speed - 3 to 9 fpm (adjustable)  
 Horiz turns outside of oven to be 24" Radius  
 Horiz turns inside of oven to be 36" Radius  
 Vertical turns to be 6" Radius  
 Caterpillar Drive - Variable Speed A/C  
 Air Operated Automatic Take-up  
 Oven Expansion Joints as Required  
 Automatic Chain Lubricator  
 Drive Controller in Washer Control Panel  
 Average Line Loading - 828/ft Based on 15,000 lbs/hr @ 4 fpm  
 Maximum allowable load per trolley - 400 lbs  
 Maximum part weight - Not to exceed 1000 lbs every 14 ft

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.

COMPANY \_\_\_\_\_  
 SIGNATURE \_\_\_\_\_ DATE \_\_\_\_\_ TITLE \_\_\_\_\_

Rev	Revision
1	8-21-02
2	9-4-02
3	9-10-02

**GAT**  
 GENERAL AUTOMATIC TRANSFER CO. ST. LOUIS, MO.

**JOB: POWDER COATING SYSTEM**

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SCALE: 1/8"=12" DRAWN BY: \_\_\_\_\_ CHECK BY: \_\_\_\_\_  
 DATE: \_\_\_\_\_