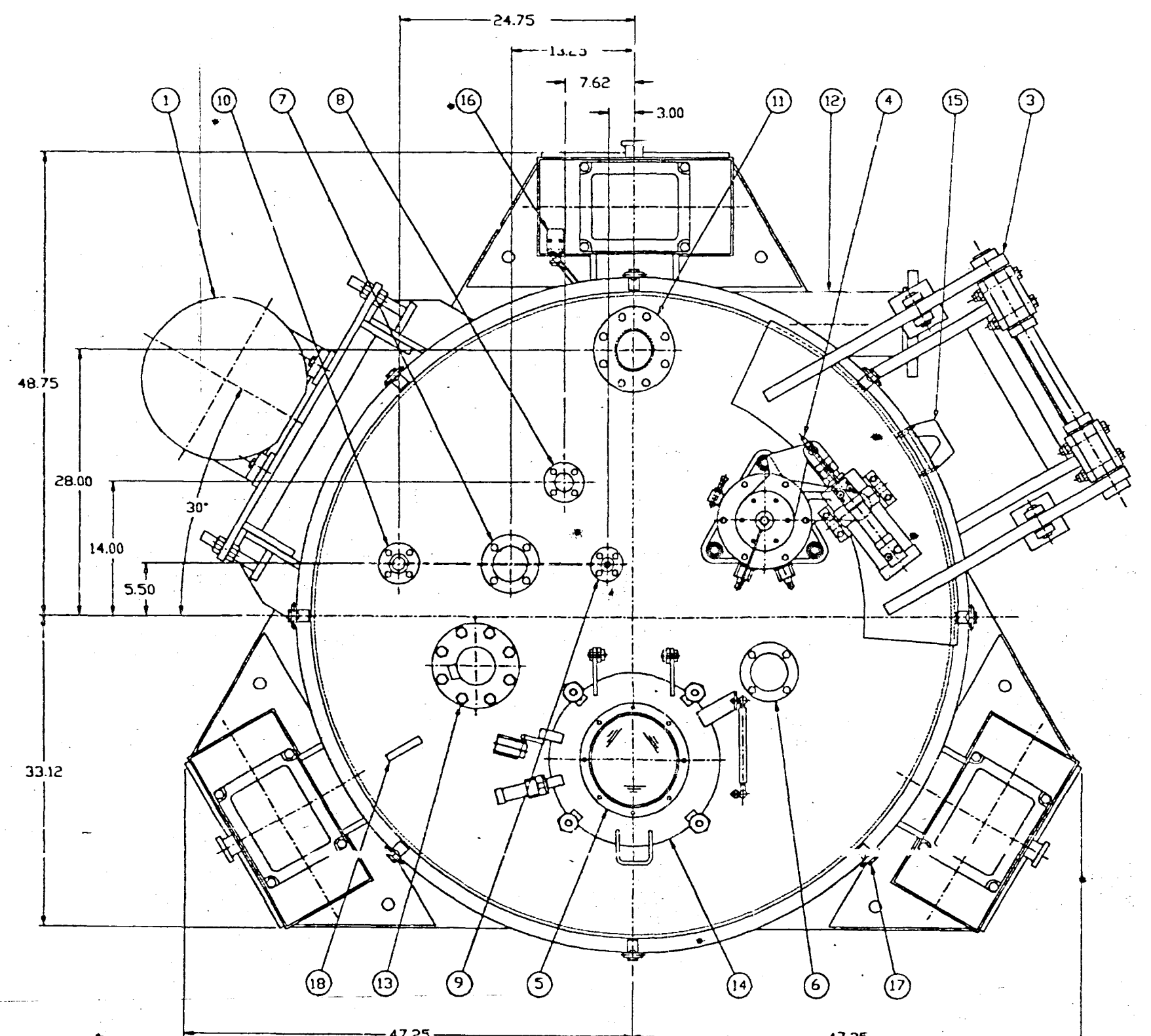
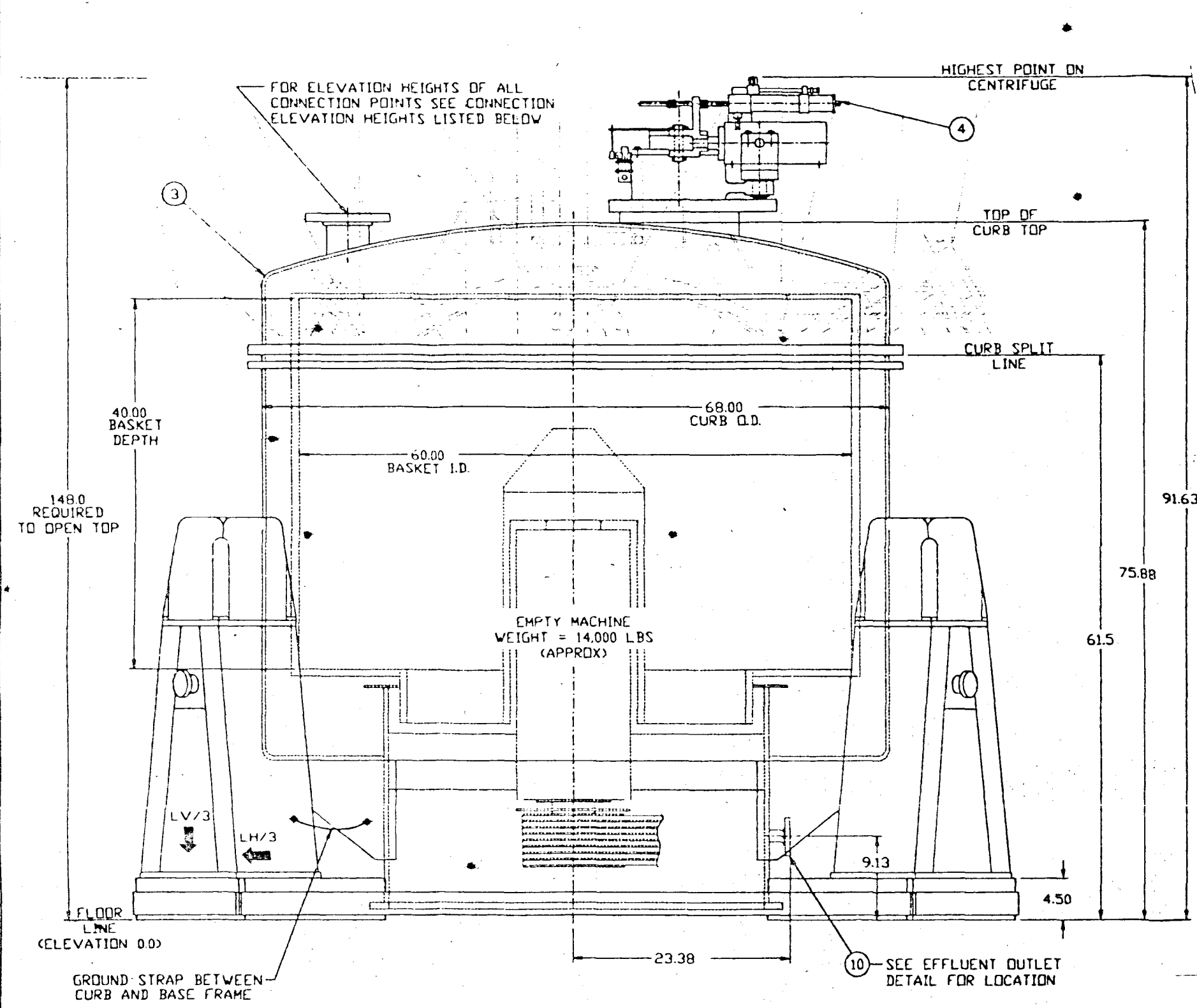




FRONT PLAN

CUSTOMER NOTES

1. ALL CONNECTIONS, PIPING, AIR LINES AND CONDUIT TO THE SUSPENDED CURB ASSEMBLY TO BE FLEXIBLE
2. CURB TOP ELEVATION SHOWN FOR CONNECTION HEIGHTS ONLY. SEE PLAN VIEW FOR CORRECT ORIENTATION. FOR COMPLETE LIST OF ELEVATION CONNECTION HEIGHTS SEE LIST ON SHEET #1 OF 2.
3. FOR EFFLUENT OUTLET, IT IS PREFERRED TO PUT FLEXIBLE CONNECTION IN VERTICAL PLANE.
4. AREA CLASSIFICATION: CLASS I DIV. II, GROUP D.
5. ALL GASKETS AND SEALS TO BE TEFLON.
6. PRESSURE TIGHT CONSTRUCTION CAPABLE OF WITHSTANDING AN INTERNAL PRESSURE OF 27" WATER WITH A MAXIMUM LEAK RATE OF 5 SCFH.
7. SPEED RANGE: 0 TO 1000 RPM
8. PLOW TIP: 316 SS.
9. ALL MACHINE WIRING TO BE IN NEMA 4 CONDUIT AND TERMINATED IN MACHINE MOUNTED NEMA 4 JUNCTION BOX.
10. MAX. DESIGN PROCESS WT. AT 850 G'S = 2640#
11. ALL GLASS WINDOWS SHALL HAVE SHATTER PROOF GLASS
12. ALL WETTED PARTS INCLUDING BEARING HOUSING SHALL BE CONSTRUCTED OF 316L SS. EXCEPT BASKET SHELL WHICH SHALL BE CONSTRUCTED OF ALLOY 2205
13. BASKET WILL BE DYNAMICALLY BALANCED
14. DRIVE (BELT) HOUSING IS ISOLATED (PRESSURE TIGHT CONSTRUCTION) FROM CENTRIFUGE PROCESS END AND NITROGEN PURGE IS NOT REQUIRED IN THE DRIVE AREA. BELTS SHALL BE STATICALLY CONDUCTING.
15. ALL CUSTOMER CONNECTION POINTS TO BE ASA 150# RAISED FACE FLANGES EXCEPT SOLIDS DISCHARGE CHUTE OUTLET

ACCESSORIES

1. 75 HP VARIABLE FREQUENCY DRIVE
2. 1/4" NPT BEARING HOUSING AIR PURGE CONNECTION
3. HYDRAULICALLY ACTUATED FULL OPENING CO²R WITH MECHANICAL AND ELECTRICAL INTERLOCKS
4. PNEUMATIC DISCHARGER WITH ELECTRICAL INTERLOCKS
5. 10" SIGHT GLASS
6. 4" LIGHT PORT
7. 2" FLANGED FEED PIPE CONNECTION
8. 1" FLANGED WASH PIPE CONNECTION WITH NOZZLES
9. 1/2" FLANGED OXYGEN ANALYZER CONNECTION
10. 1" FLANGED PURGE CONNECTION (2 REQ'D)
11. 4" FLANGED VENT CONNECTION
12. 8" FLANGED EFFLUENT OUTLET CONNECTION
13. CAPACITANCE LOAD CONTROL
14. 18" HINGED ACCESS OPENING WITH MECHANICAL AND ELECTRICAL INTERLOCKS
15. VIBRATION SWITCH
16. GYRATION SWITCH
17. COVER CLAMPS (MECHANICAL) - 8 REQ'D
18. LIFTING LUG

CONNECTION HEIGHTS

DISTANCE FROM ELEVATION 0.0

1. 75 HP VARIABLE FREQUENCY DRIVE	
2. 1/4" NPT BEARING HOUSING AIR PURGE CONNECTION	+10.25
3. HYDRAULICALLY ACTUATED FULL OPENING CO ² R WITH MECHANICAL AND ELECTRICAL INTERLOCKS	
4. PNEUMATIC DISCHARGER WITH ELECTRICAL INTERLOCKS	
5. 10" SIGHT GLASS	
6. 4" LIGHT PORT	
7. 2" FLANGED FEED PIPE CONNECTION	+80.13
8. 1" FLANGED WASH PIPE CONNECTION WITH NOZZLES	+80.00
9. 1/2" FLANGED OXYGEN ANALYZER CONNECTION	+80.00
10. 1" FLANGED PURGE CONNECTION (2 REQ'D)	+79.00 (CURB TOP)
11. 4" FLANGED VENT CONNECTION	+9.13 (DISCHARGE CHUTE)
12. 8" FLANGED EFFLUENT OUTLET CONNECTION	+77.75
13. CAPACITANCE LOAD CONTROL	+22.00
14. 18" HINGED ACCESS OPENING WITH MECHANICAL AND ELECTRICAL INTERLOCKS	
15. VIBRATION SWITCH	
16. GYRATION SWITCH	
17. COVER CLAMPS (MECHANICAL) - 8 REQ'D	
18. LIFTING LUG	

93487
M6201

DYNAMIC LOADING FORMULA
LV = VERTICAL COMPONENT
(EMPTY MACHINE WEIGHT + PROCESS WEIGHT) X 2
LH = HORIZONTAL COMPONENT
.75 X VERTICAL COMPONENT

CUSTOMER: FMC CORPORATION
1701 EAST PATAPSCO AVE.
BALTIMORE, MARYLAND 21226

FIRST JOB 5209844		THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
MATERIAL	SCALE .13=1.0	UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED DIMENSIONS: 0 = .000, .001 = .005, .002 = .005, .003 = .005, .004 = .005, .005 = .005	
DATE 3/29/95	DATE 3/29/95	TITLE INSTALLATION DRAWING 60" X 40" QUADRAMATIC	
REPRODUCIBLE COPY, REVISION TO	DATE	PART NO. 054058	
CR. GWS	DATE 11/10/95	DWG NO. SHEET 1 OF 2 110-0776-00-4	

1 11/8/95 ZONE REMOVED COOLING FAN ASSEMBLY SD

(16) 5/8" (.625) DIA HOLES
EQUALLY SPACED AT 22.5 DEG.
ON A 43.50 DIA B.C.

10 LOCATED 30° OFF
CENTERLINE AS
SHOWN

CURB

CURB

13.50 8.0
O.D. I.D.

22.00

0.50

2.62

FLOOR LINE

8" EFFLUENT OUTLET

41.00 I.D. SOLIDS DISCHARGE
OPENING

42.00 O.D. CHUTE

43.50 DIA B.C.

45.00 O.D. FLANGE

50.00 DIA FLOOR OPENING

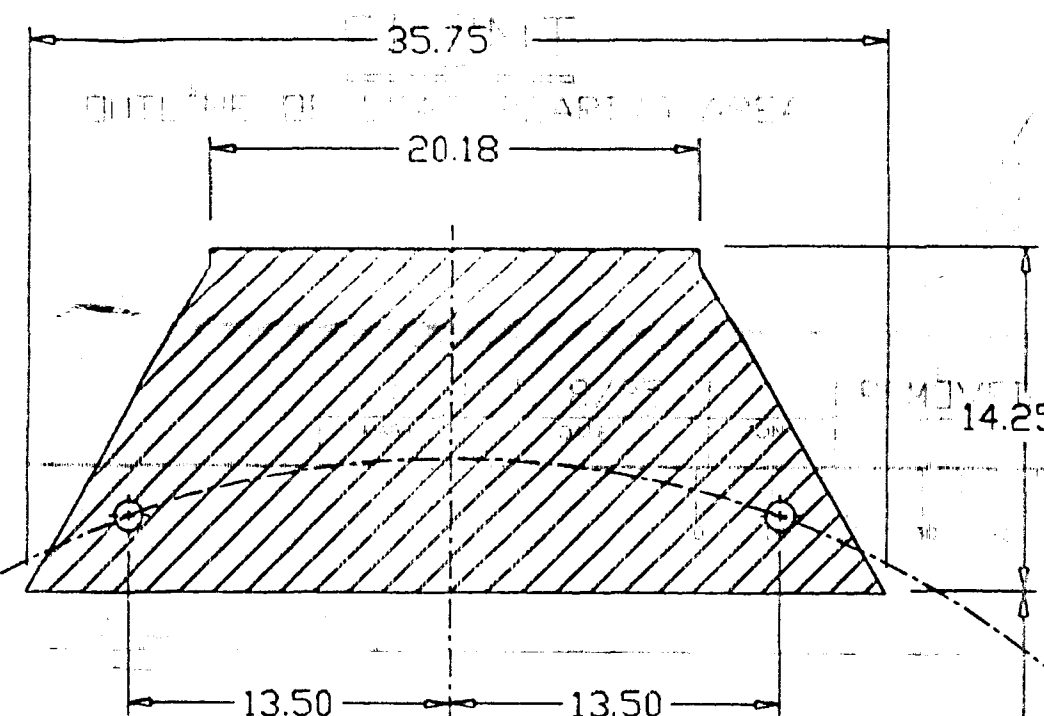
DRIVE ASSEMBLY ELEVATION

81.38

1.0 DIA HOLE

148.0

COVER OPEN DIMENSION DETAIL



PEDESTAL
& CURB

34.50

40.0 R. B.C.

120°

120°

CURB

PEDESTAL

PEDESTAL

FRONT

OUTLINE OF LOAD BEARING AREA

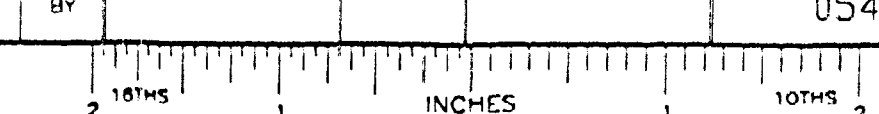
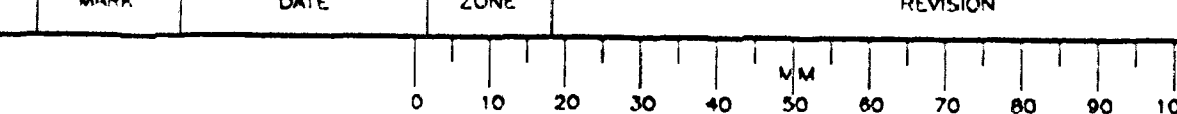
(6) 1-1/4" (1.25) DIA HOLES IN BASE
FRAME FOR ANCHOR BOLTS

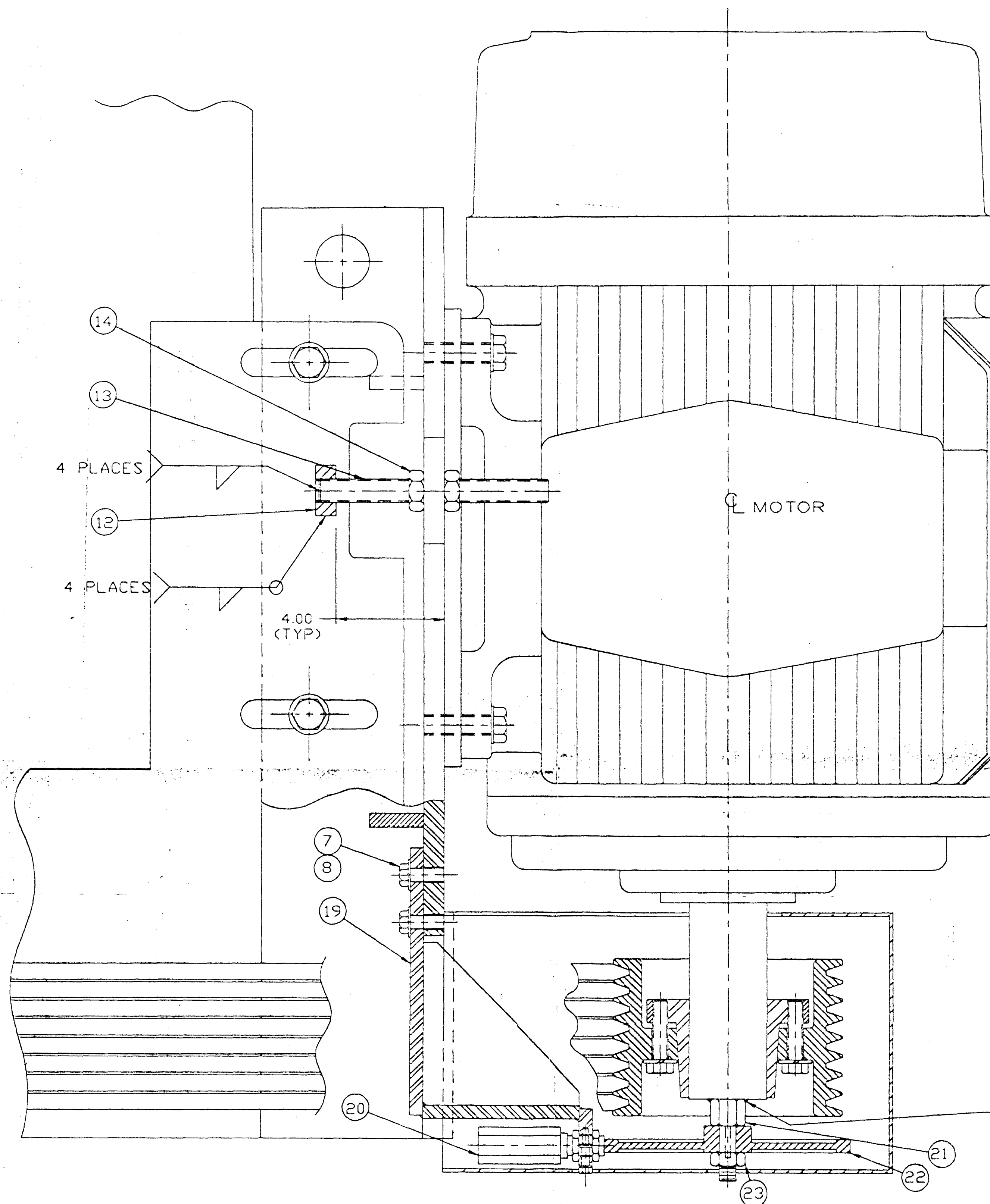
#93487

FIRST JOB 5209844		THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
MATERIAL	SCALE .13=1.0	UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED INCH DIMENSIONS .0000 ± .0020 MM DIMENSIONS .00 ± .05	
DATE 3/29/95	DR. SMD	TITLE INSTALLATION DRAWING 60" X 40" QUADRAMATIC	
REPRODUCIBLE COPY ISSUED TO	DATE	CK. GWS	PART No. 054058
FILMED		DWG No. SHEET 2 OF 2 110-0776-00-4	

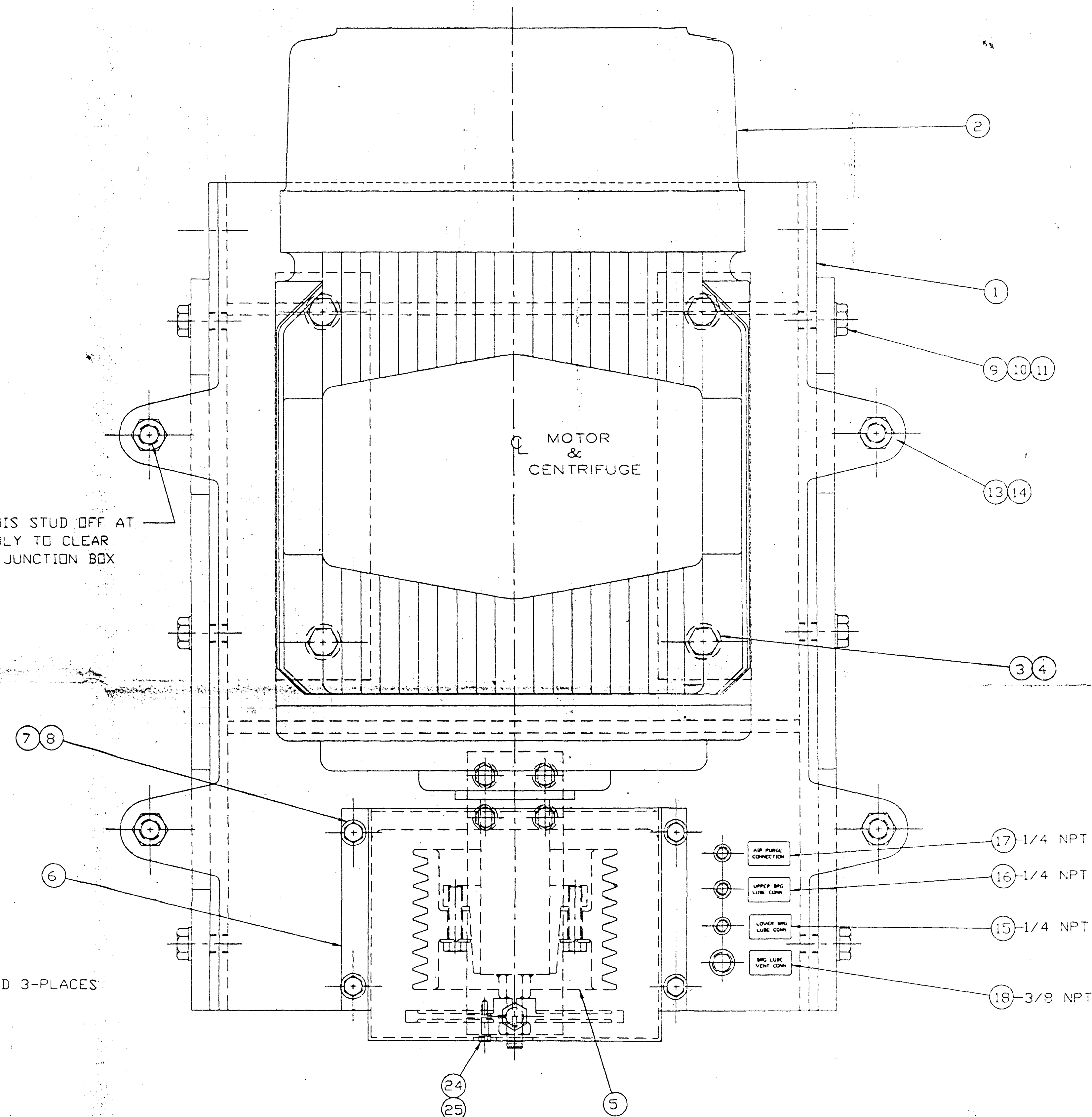
11/8/95 REMOVED COOLING FAN ASSEMBLY

SD





NOTE:
CUT THIS STUD OFF AT
ASSEMBLY TO CLEAR
MOTOR JUNCTION BOX



ITEM	QTY	DWG NO	DESCRIPTION
1	1	078-0944-00-4	DRIVE BASE - MACHINING
2	1		SIEMENS ELECTRIC MOTOR (75 HP TEFC)
3	4		SCREW, HEX HEAD CAP - 3/4-10 NC X 2-1/2 LG
4	4		LOCKWASHER - 3/4
5	1		DRIVE SHEAVES AND BELTS (SEE B/M)
6	1	078-0906-00-3	GUARD, BELT
7	8		SCREW, HEX HEAD CAP - 1/2-13 NC X 1-1/4 LG
8	8		LOCKWASHER - 1/2
9	6		SCREW, HEX HEAD CAP - 3/4-10 X 1-3/4 LG
10	6		FLATWASHER - 3/4
11	6		LOCKWASHER - 3/4
12	4	078-0125-00-2	BLOCK, ADJUSTING
13	4	078-0018-00-2	STUD, MOTOR BASE
14	8		NUT, HEX - 7/8-9 NC

ITEM	QTY	DWG NO	DESCRIPTION
15	1	094-0572-00-2	NAMEPLATE, LOWER BEARING LUBE CONNECTION
16	1	094-0573-00-2	NAMEPLATE, UPPER BEARING LUBE CONNECTION
17	1	094-0569-00-1	NAMEPLATE, AIR PURGE CONN
18	1	094-0577-00-2	NAMEPLATE, BRG LUBE VENT CONN
19	1	078-0908-00-2	MAGNETIC PICKUP MOUNTING BRACKET
20	1		MAGNETIC PICKUP
21	1	078-0756-00-2	EXTENSION, SHAFT
22	1		TACH GEAR, MAGNETIC PICKUP
23	1		LOCKNUT, - SELF LOCKING 5/8-18
24	1		SCREW, HEX HEAD CAP - 1/4-20 X 1-1/4 LG
25	1		LOCKWASHER, - 1/4

FIRST JOB 5209844

MATERIAL

SCALE 3:8

DR. P.K.

DATE 6-26-95

CK GWS

FILED 6/29/95

TITLE DRIVE, ASSEMBLY 405T FRAME - GREASE LUBE

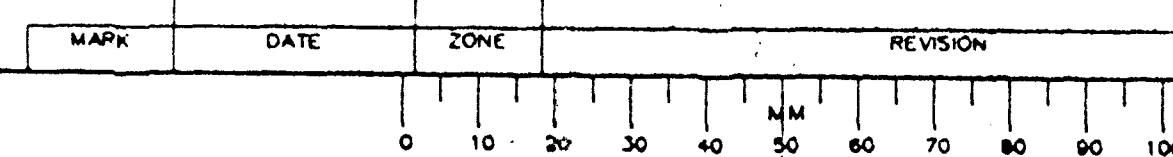
PART NO. 054624

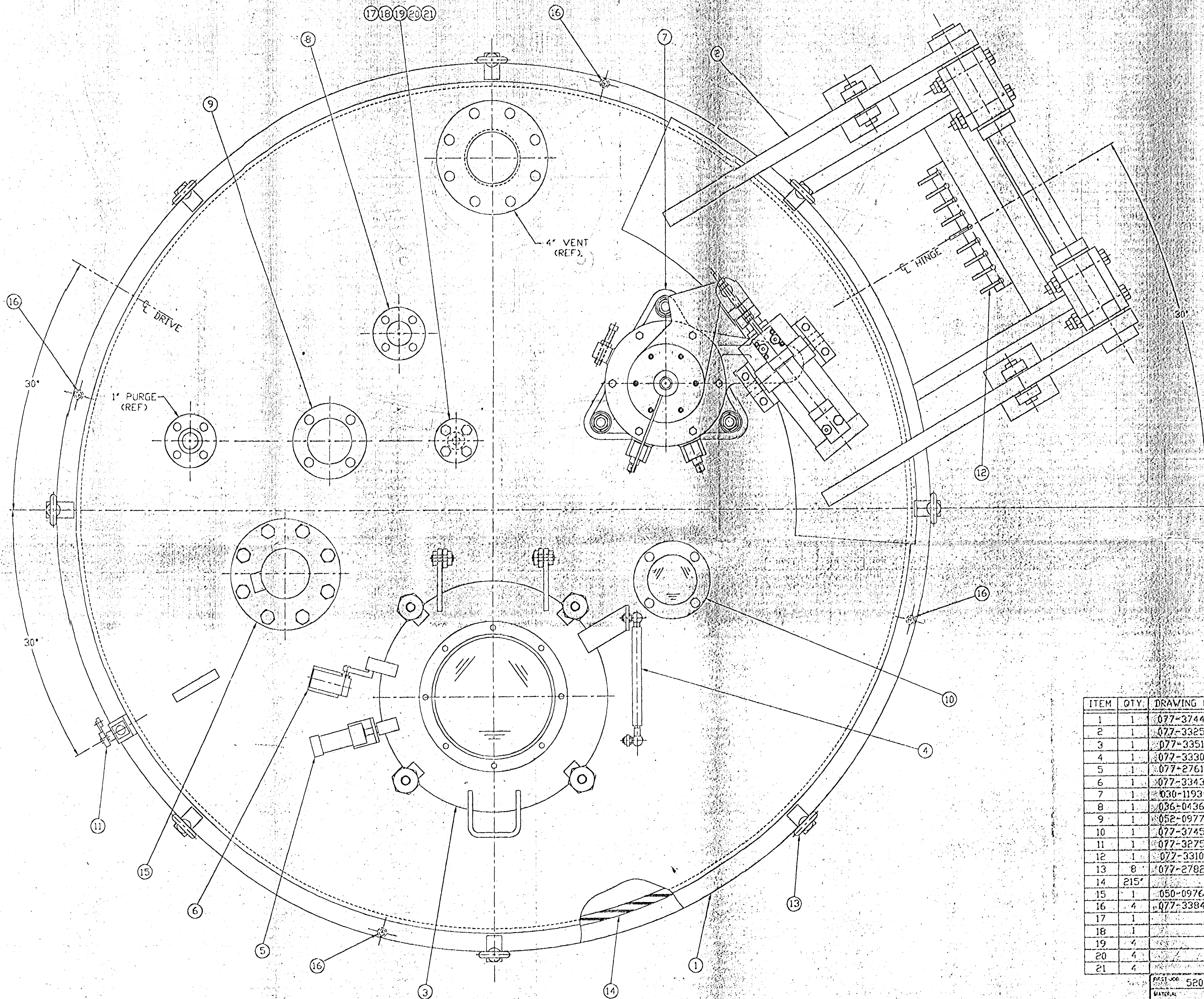
DWG NO. 078-0942-00-4

UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED
INCH DIMENSIONS 0 ± .010
MM DIMENSIONS 0 ± .25
0.00 ± .005

HAMILTON, OHIO U.S.A.

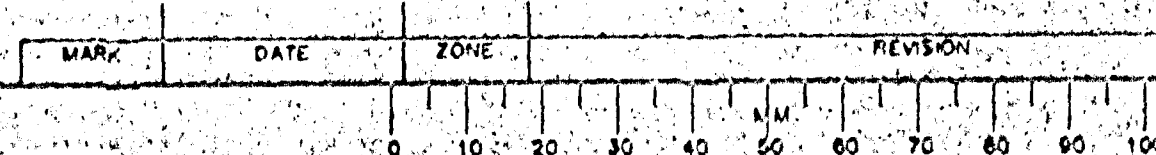
THE WESTERN STATES MACHINE COMPANY

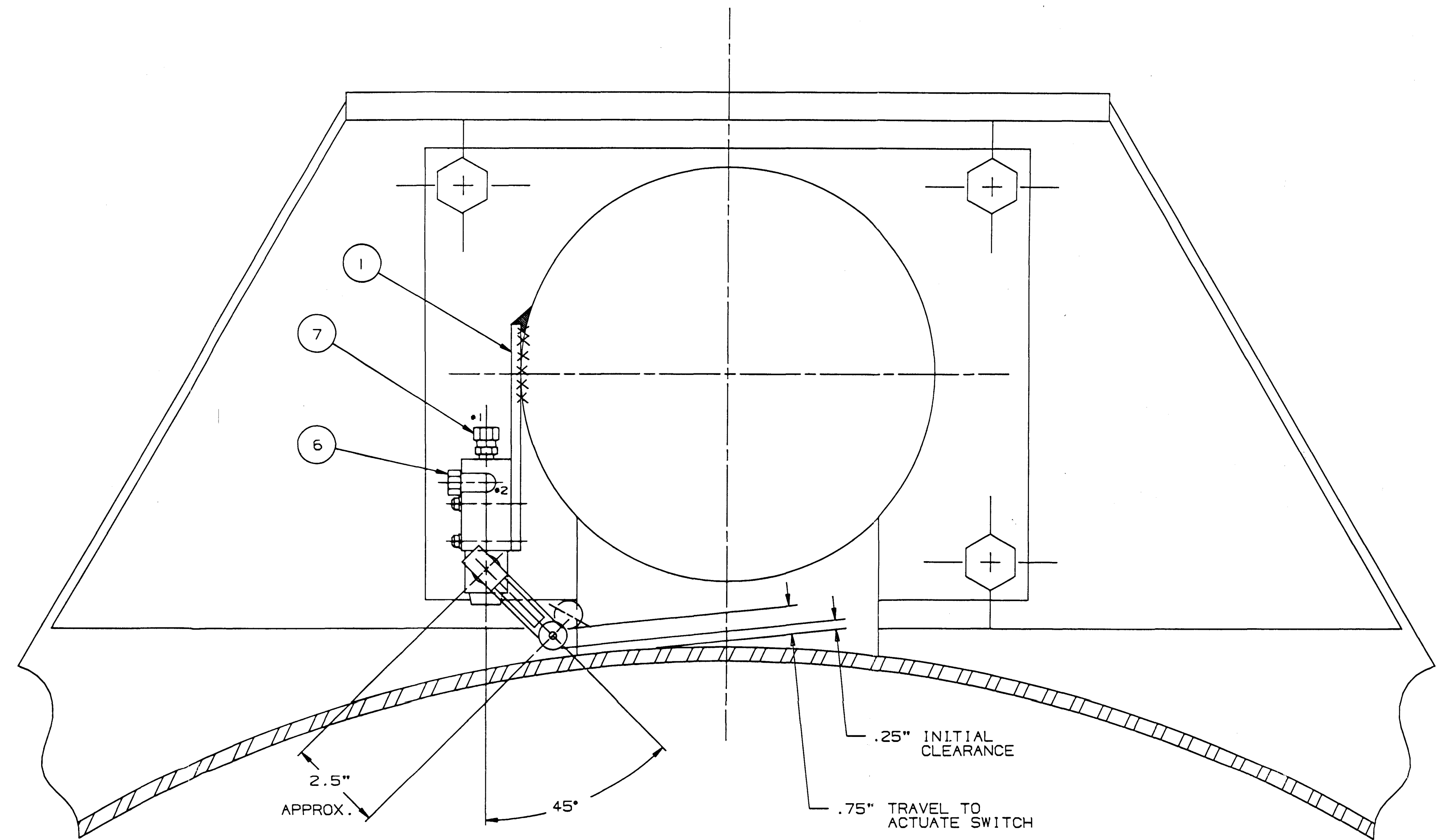
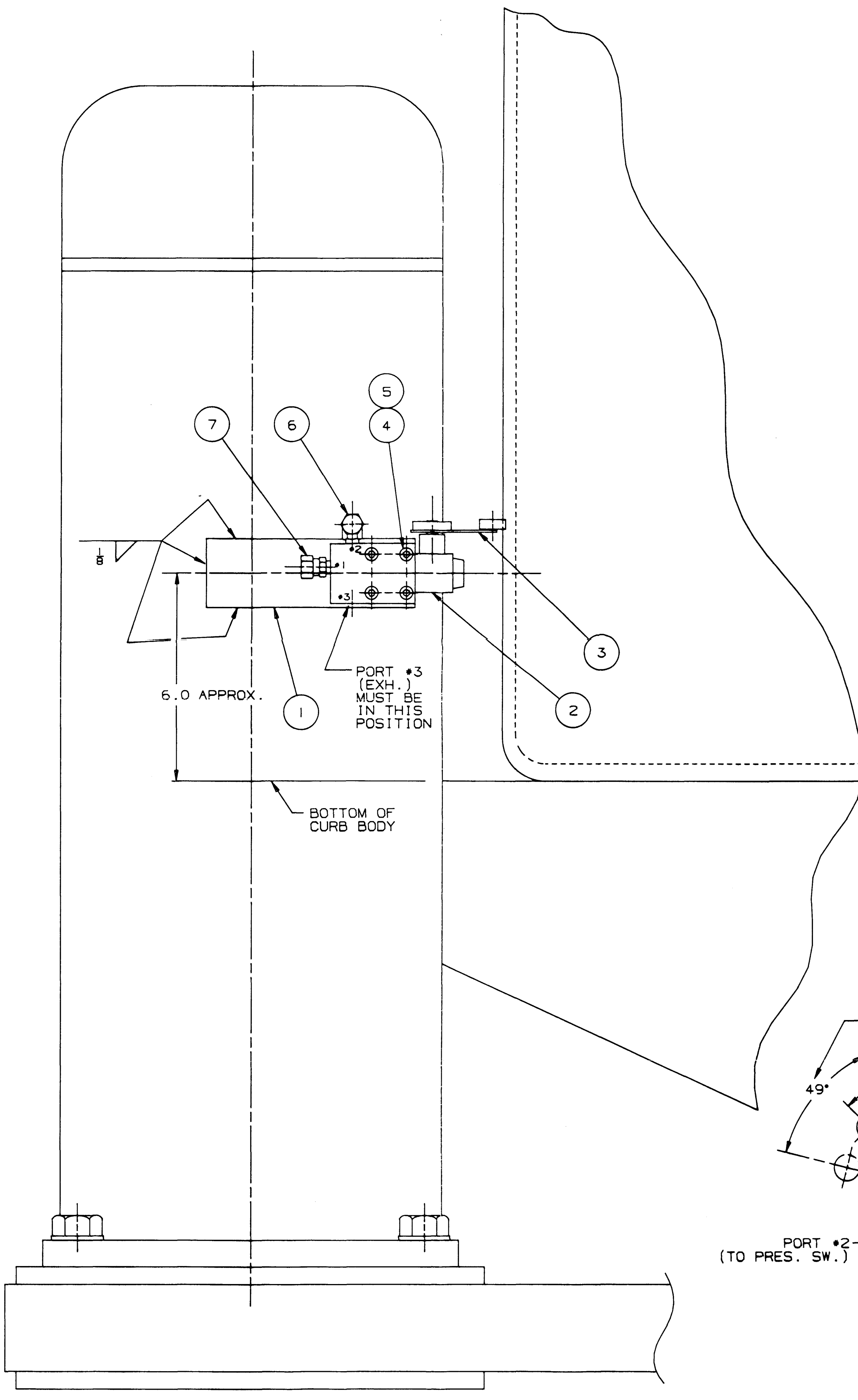




ITEM	QTY.	DRAWING NUMBER	DESCRIPTION
1	1	077-3744-00-4	CURB TOP FABRICATION
2	1	077-3325-00-4	HINGED TOP ASSEMBLY
3	1	077-3351-01-4	18" MANHOLE
4	1	077-3330-00-3	MANHOLE COUNTERBALANCE
5	1	077-2761-00-2	MANHOLE SAFETY LATCH
6	1	077-3343-00-2	MANHOLE LIMIT SWITCH
7	1	030-1193-00-4	PNEUMATIC DISCHARGER W/ELEC. INTERLOCKS
8	1	036-0436-00-3	1" FLANGED WASH PIPE
9	1	052-0977-00-3	2" FLANGED FEED PIPE
10	1	077-3745-00-2	4" LIGHT PORT ASSEMBLY
11	1	077-3275-00-3	COVER LIMIT VALVE ASSEMBLY
12	1	077-3310-00-4	CURB TOP AIR PIPING ASSEMBLY
13	8	077-2782-00-2	COVER CLAMPS (MECHANICAL)
14	215'		GASKET - VITON
15	1	050-0976-00-3	CAPACITANCE LOAD CONTROL - ON/OFF
16	4	077-3384-00-2	POSITIVE STOP PIN
17	1		1/2" 150# BLIND FLANGE
18	1		1/2" FULL FACE GASKET
19	4		1/2"-13 NC X 2" HEX HEAD CAP SCREW
20	4		1/2" LOCKWASHER
21	4		1/2"-13 NC HEX NUT

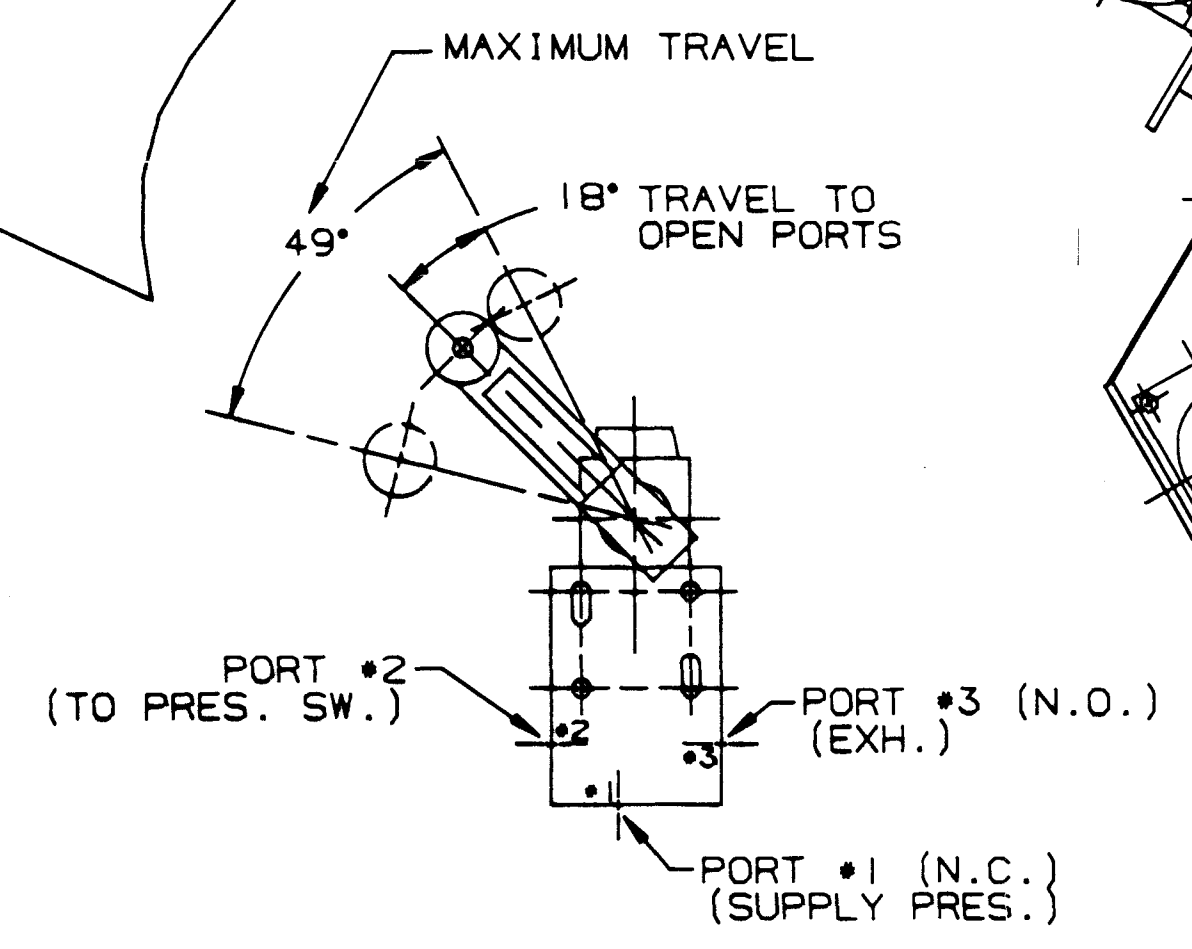
FIRST JOB 5209844		THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
MATERIAL 316L S.S.	SCALE 25=1.0	UNLESS OTHERWISE NOTED STANDARD TOLERANCE OF MACHINED DIMENSIONS IS .0015"	
DR MC39	DATE 6/21/95	TITLE CURB TOP ASSEMBLY 60" QUADRAMATIC	PART NO. 054490
DATE 6/21/95	DATE 6/21/95	DWG NO. 077-3746-00-4	
DATE 6/21/95	DATE 6/21/95		





- NOTES:
- 1. ASSEMBLE SWITCH TO MOUNTING PLATE (ITEM#1) AND LOCATE & WELD TO PEDESTAL AT ASSY.
 - 2. ADJUST LEVER (ITEM#3) TO OBTAIN SETTING AS SHOWN.

ITEM	QTY	DRAWING No.	DESCRIPTION
1	1	056-0129-00-2	SUB-MOUNTING PLATE
2	1		"ARO" AIR LIMIT SWITCH MODEL#402-3 WAY (N.C.)
3	1		"ARO" LEVER MODEL#450-ADJUSTABLE
4	4		#10-24 UNC X2" LG. SOC. HD. CAP SCR.
5	4		#10 LOCKWASHER
6	1		MALE ELBOW PARKER 4-2 CBZ SS 1/4" TUBE X 1/8" NPT
7	1		MALE CONNECTOR PARKER 4-2 FBZ SS 1/4" TUBE X 1/8" NPT

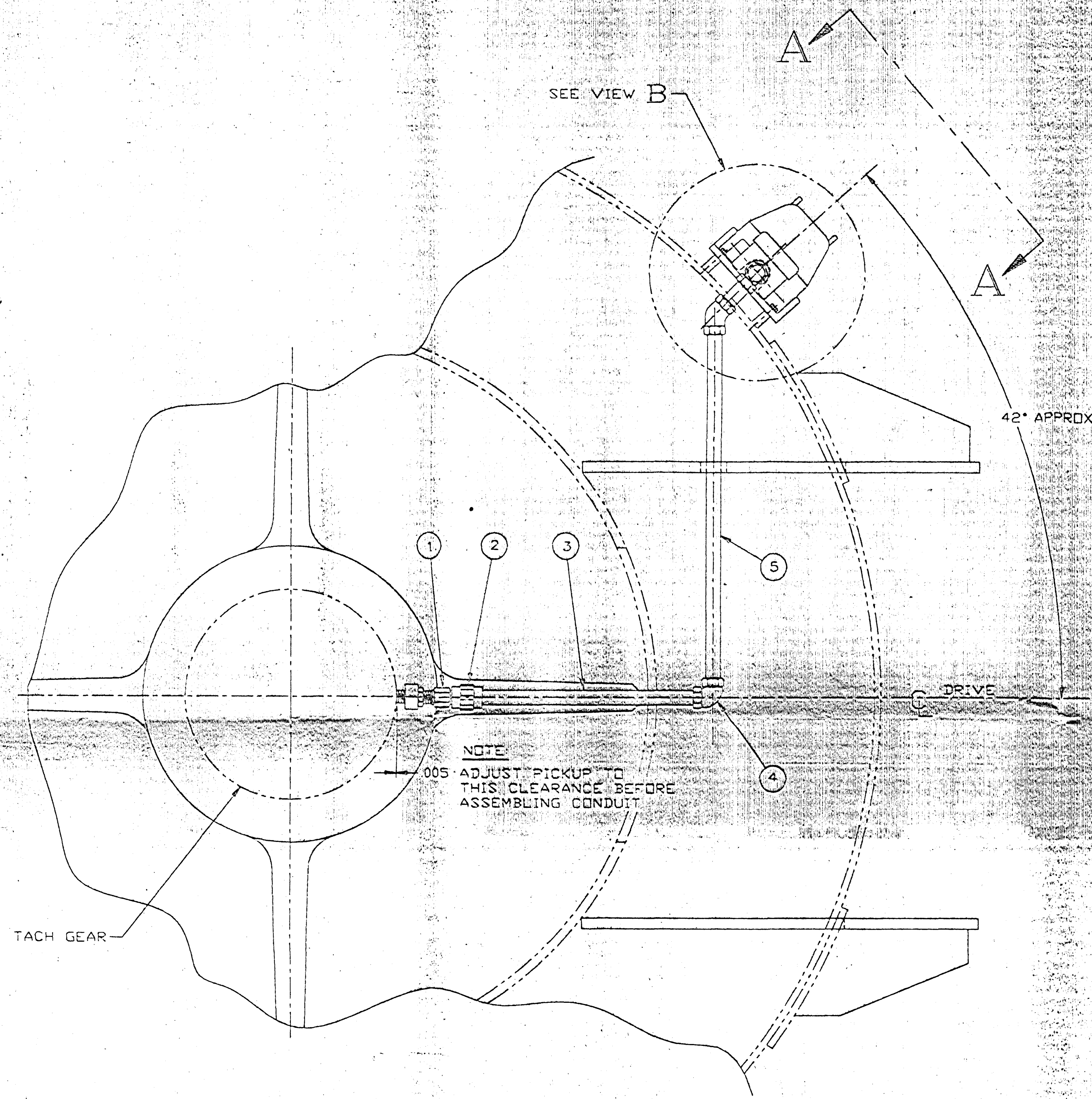


PLAN VIEW
SCALE: 1:16

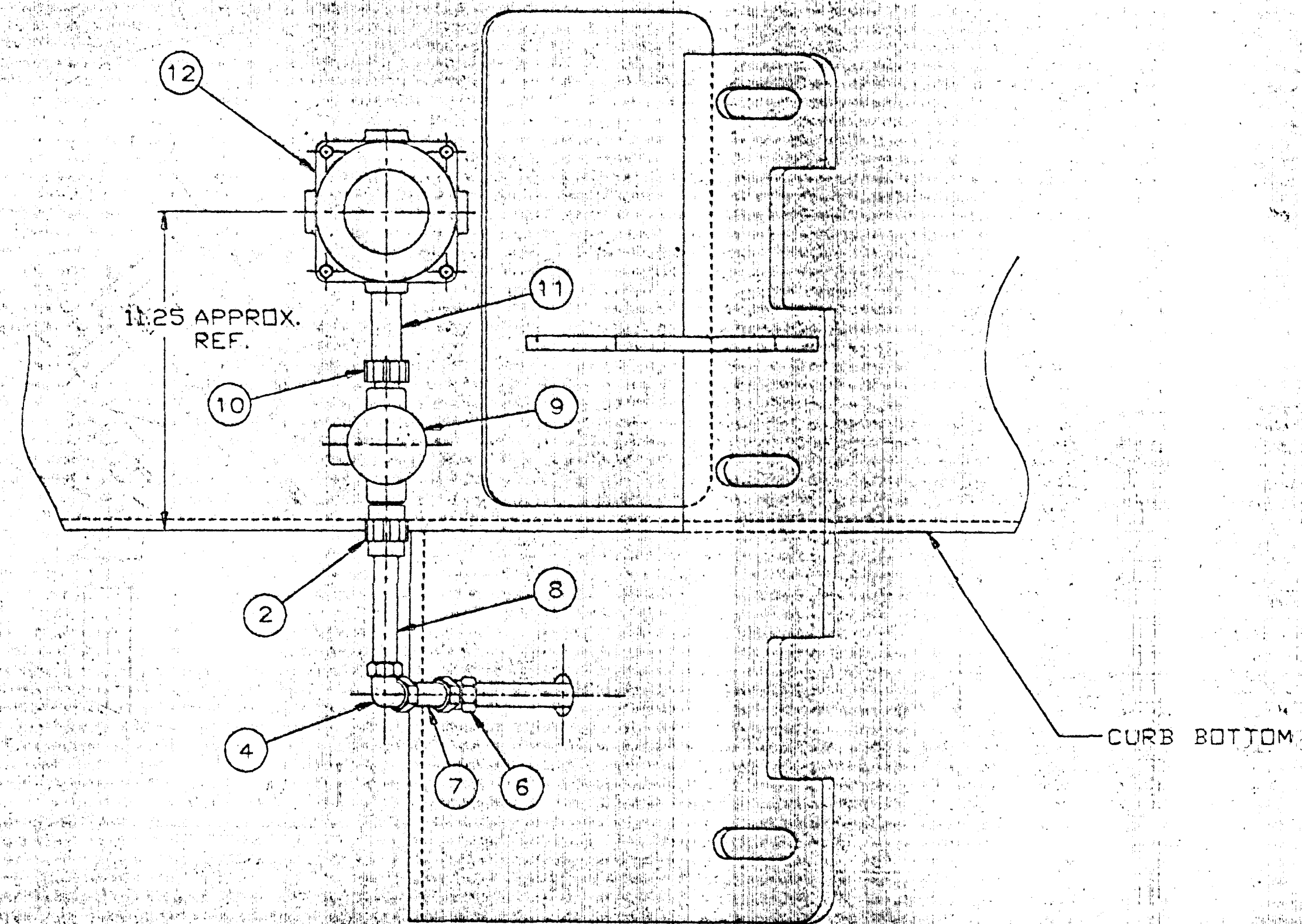
93487

FIRST JOB 50000		 THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
MATERIAL	SCALE 1" = 2"	UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED INCH DIMENSIONS .000 + .000 MM DIMENSIONS 0.00 + .00	
REPRODUCIBLE COPY ISSUED TO	DATE 6-8-93	TITLE GYRATION SWITCH ASSEMBLY	
DATE	DATE	PART No.	DWG No.
		050013	056-0133-00-4



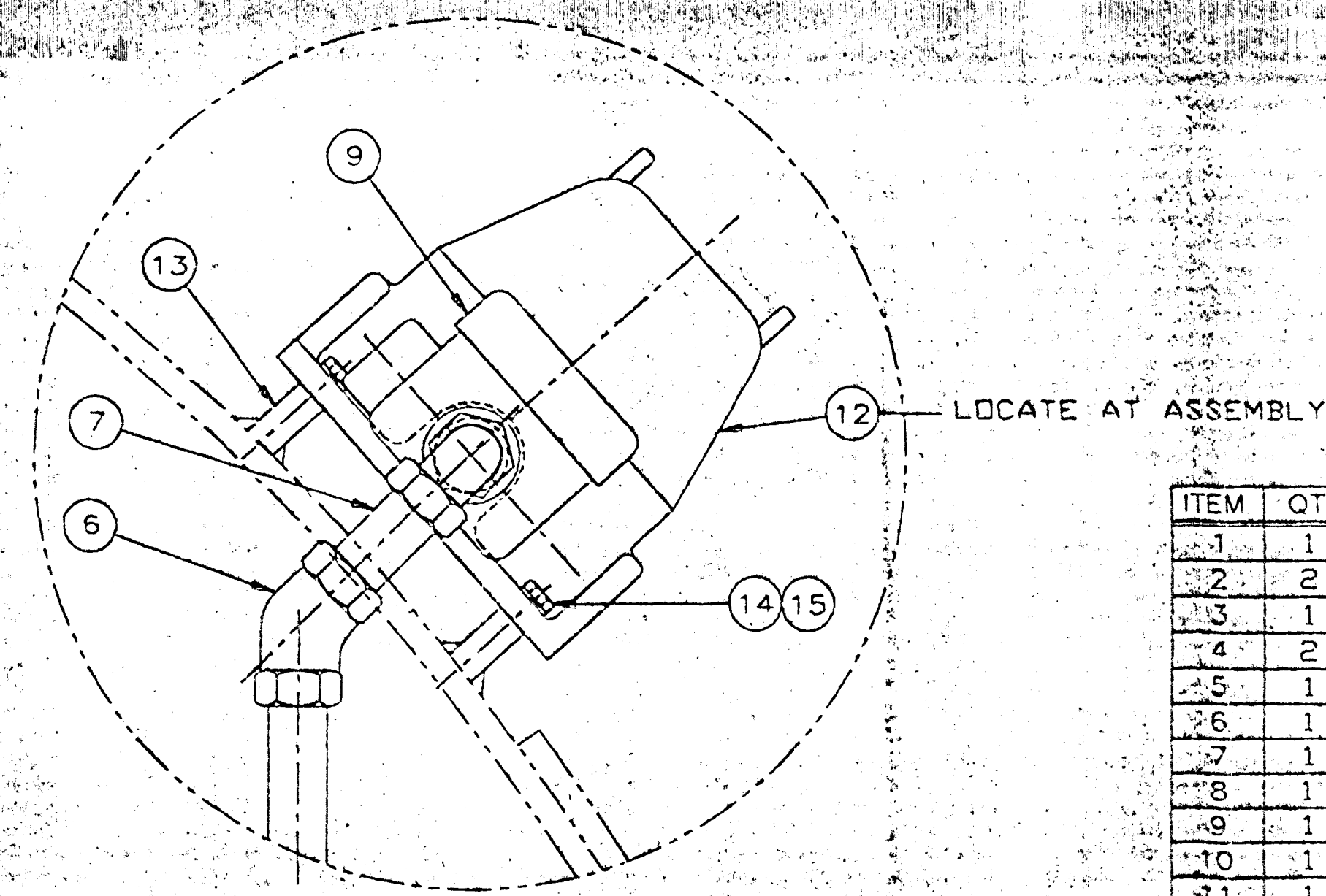


BOTTOM VIEW



VIEW A-A

ROTATED TO SHOW PROPER ORIENTATION



VIEW B

HALF SCALE

#93487

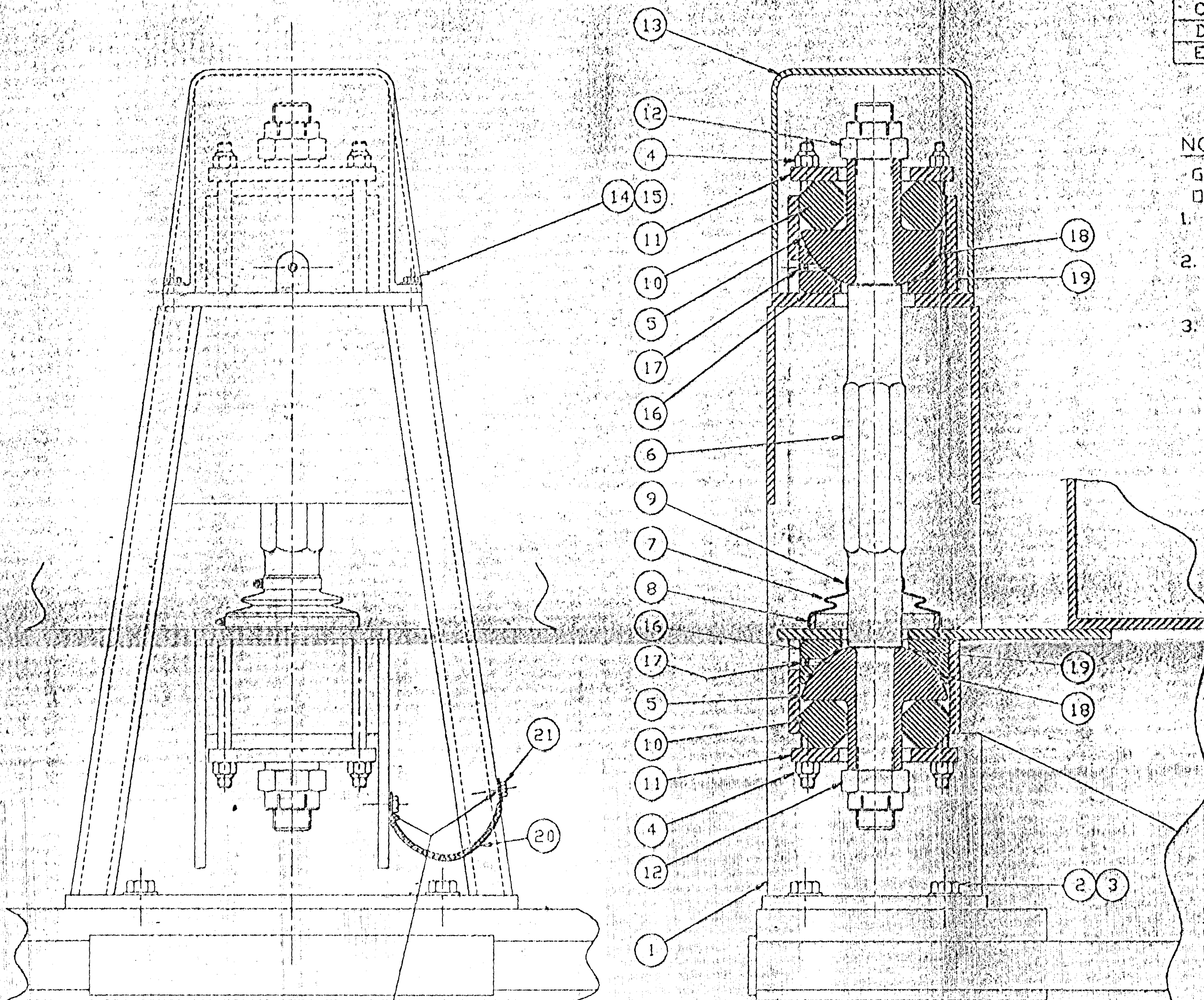
ITEM	QTY	DESCRIPTION
1	1	"AIRPAX" MAGNETIC PICKUP - #70085-1010-005
2	2	1/2" UNION - KILLARK #GUM-1 (MALE-FEMALE)
3	1	1/2" CONDUIT NIPPLE 15" LG. (GALVANIZED)
4	2	1/2" ELBOW 90° KILLARK #FF-90-1
5	1	1/2" CONDUIT NIPPLE 22" LG. (GALVANIZED)
6	1	1/2" ELBOW 45° KILLARK #FF-45-1
7	1	1/2" CONDUIT NIPPLE KILLARK#AN-1B (2" LG.)
8	1	1/2" CONDUIT NIPPLE KILLARK#AN-1G (5" LG.)
9	1	1/2" CONDUIT OUTLET FITTING KILLARK#GEMT-1
10	1	ADAPTER 1/2" MALE TO 3/4" FEMALE KILLARK#ADUP-12
11	1	3/4" CONDUIT NIPPLE KILLARK#AN-2E (3.5" LG.)
12	1	PMC/BETA VIBRATION SWITCH MODEL 450 S-R
13	4	1/2" X 1" T3 WELD BASE STUD W/1/4-20 TAP
14	4	HEX HD CAP SCREW 1/4-20 X 3/4" LG.
15	4	LOCKWASHER - 1/4"

5206744

THE WESTERN STATES MACHINE COMPANY
HAMILTON, OHIO U.S.A.

SCALE: QUARTER
UNLESS OTHERWISE NOTED, STANDARD TOLERANCES ON MACHINING:
DIMENSIONS: .0005 TO .0010
ANGLES: .0005 TO .0010
HOLE DIA: .0005 TO .0010
TAP DIA: .0005 TO .0010

DATE: 5-3-95
BY: GYG
TITLE: VIBRATION SWITCH & SPEED SENSING CONDUIT ASSEMBLY
DWG NO: 054081
REV: 065-0757-00-4



5/16 (312) DRILL & 3/8-16 TAP AT ASSEMBLY
(2) PLACES ON (1) PEDESTAL ONLY
NOTE: ONLY (1) GROUND STRAP REQ'D PER MACHINE.

ITEM #13 COVER					
LINE	PART No	PART No	DWG No	MC	POLISH
A	029859	006890	110-0196-00-3	131	NONE
B	035990	028145	110-0196-01-3	74	NONE
C	042779	021778	110-0360-00-3	41	NONE
D	042787	036733	110-0360-02-3	39	80 GRIT
E	054810	032140	110-0360-01-3	39	NONE

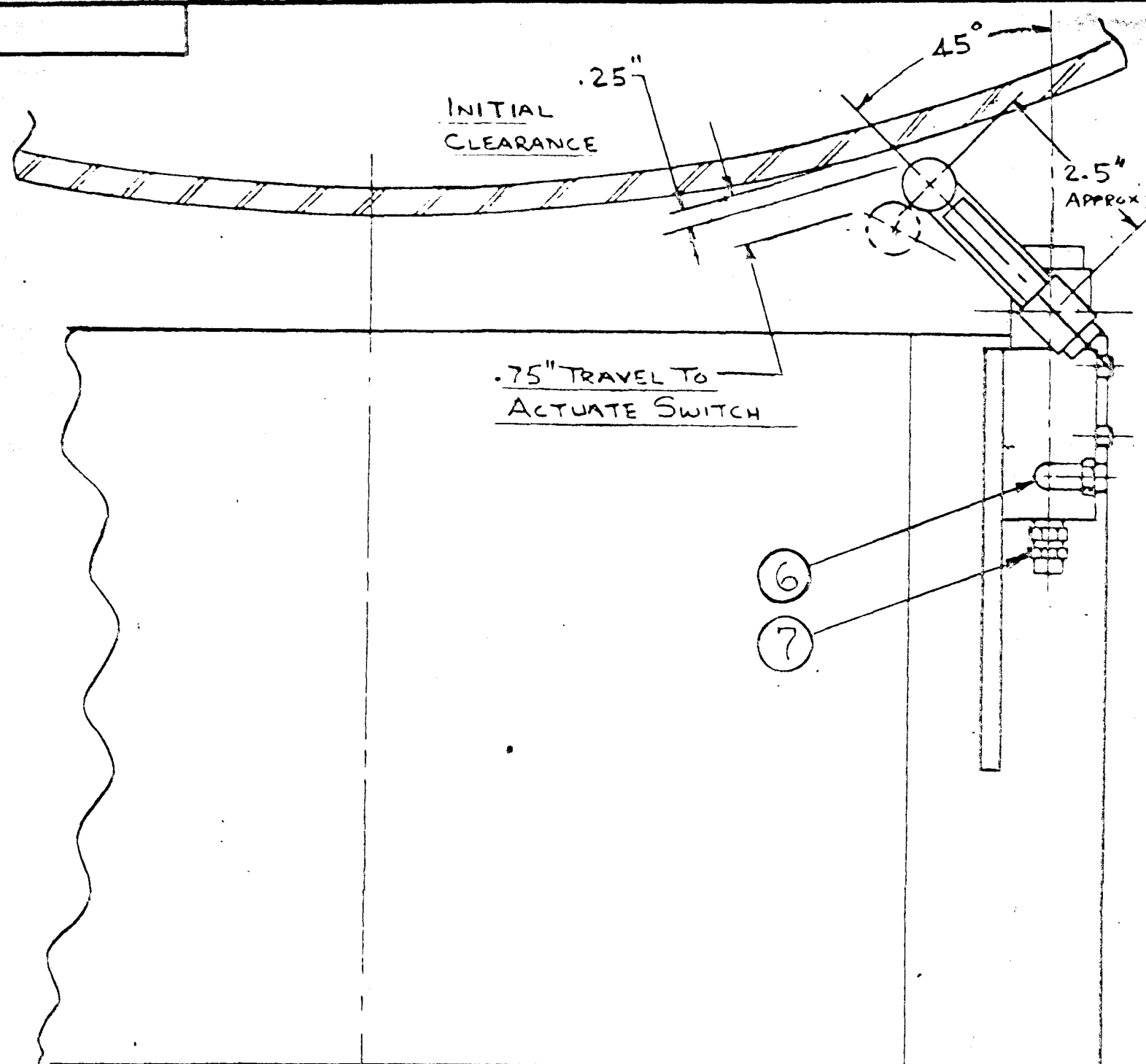
NOTE:

- GREASE BALL JOINT ASSEMBLY WITH 'MOLY-B2' GREASE, ONLY AS FOLLOWS:
1. PACK GREASE IN BALL & SOCKET WITH 'O' RING IN PLACE, BUT PIPE PLUGS REMOVED.
 2. DURING ASSEMBLY, APPLY 'NEVER-SEEZ' TO BOTH ENDS OF LINK, ITEM #6, AND INSIDE DIAMETER OF LINK BALL, ITEM #5, IN THE AREA OF CONTACT.
 3. AFTER ASSEMBLY, WHEN EXCESS GREASE IS FORCED OUT, INSTALL PIPE PLUGS.

21	2	(000319)	HEX HD CAP SCR 3/8-16NC X 3/4' LG
20	1	(028968)	BELDON GRND STRAP #71294 #4 GA 12' LG
19	2	(028861)	'O' RING #238 1/8 CS 3-1/2 ID 3-3/4 OD
18	2	(028766)	'O' RING #258 1/8 C.S. 6' ID 6-1/4' OD
17	2	(000532)	1/8"NPT PIPE PLUG C'SK HD
16	2	110-0197-01-2	SOCKET FOR LINK
15	4	(000073)	LOCKWASHER - 3/8
14	4	(000321)	HEX HD CAP SCR 3/8-16NC X 1' LG
13	1	SEE CHART	COVER
12	2	(029861)	1-3/4"-5 NC FLEXLOC LOCKNUT #31FN-2805
11	2	110-0020-00-1	BUFFER CLAMPING PLATE
10	2	PT-36-A	BUFFER
9	1	(029598)	HOSE CLAMP 2-5/8' I.D. C-208
8	1	(029599)	HOSE CLAMP 6-1/8' I.D. C-208
7	1	110-0144-00-2	BOOT
6	1	110-0198-01-2	LINK
5	2	110-0022-01-2	LINK BALL
4	8	(034628)	FLEX-LOC NUT 5/8"-UNC
3	4	(020401)	LOCKWASHER-3/4
2	4	(000741)	HEX HD CAP SCR 3/4-10NC X 1-3/4 LG
1	1	110-0222-00-4	PEDESTAL WELDMENT
ITEM	QTY	DWG No / PN	DESCRIPTION

10	7/31/95	REMOVED JAM NUTS, ADDED FLEXLOC	SD
9	7-5-95	REMOVED COTTER PIN & UPDATED ITEM NO'S	PK
8	5-23-95	REDRAWN ON CAD, REMOVED LIFT LUG	DF
7	8-16-89	ADDED CHART	PB
6	8-13-85	ADDED 'NEVER-SEEZ' TO NOTE	MW
5	10-9-84	ITEM 4 WAS FULL HT LOCKNUT #001569	SD
4	9-13-84	CORRECTED ITEM 16, DWG WAS 110-0197-01-1	REP
3	11-10-83	REDRAWN, CH'D GREASE NOTE-ADD ITEMS 21&22	REP
2	4-7-83	ADDED NOTE & LIFTING LUG	GS
1	2-28-83	DWG No FOR ITEM#1 REVISED	DH
MARK	DATE	ZONE	REVISION

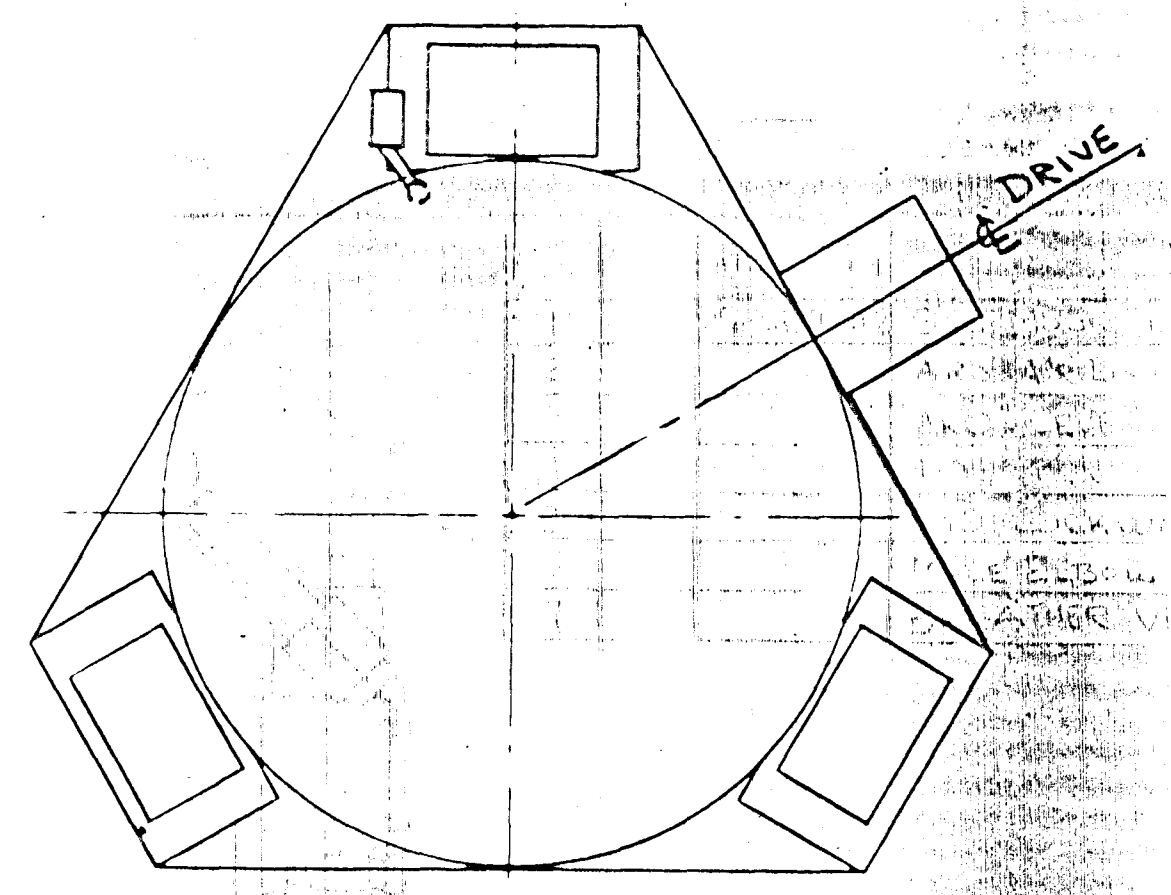
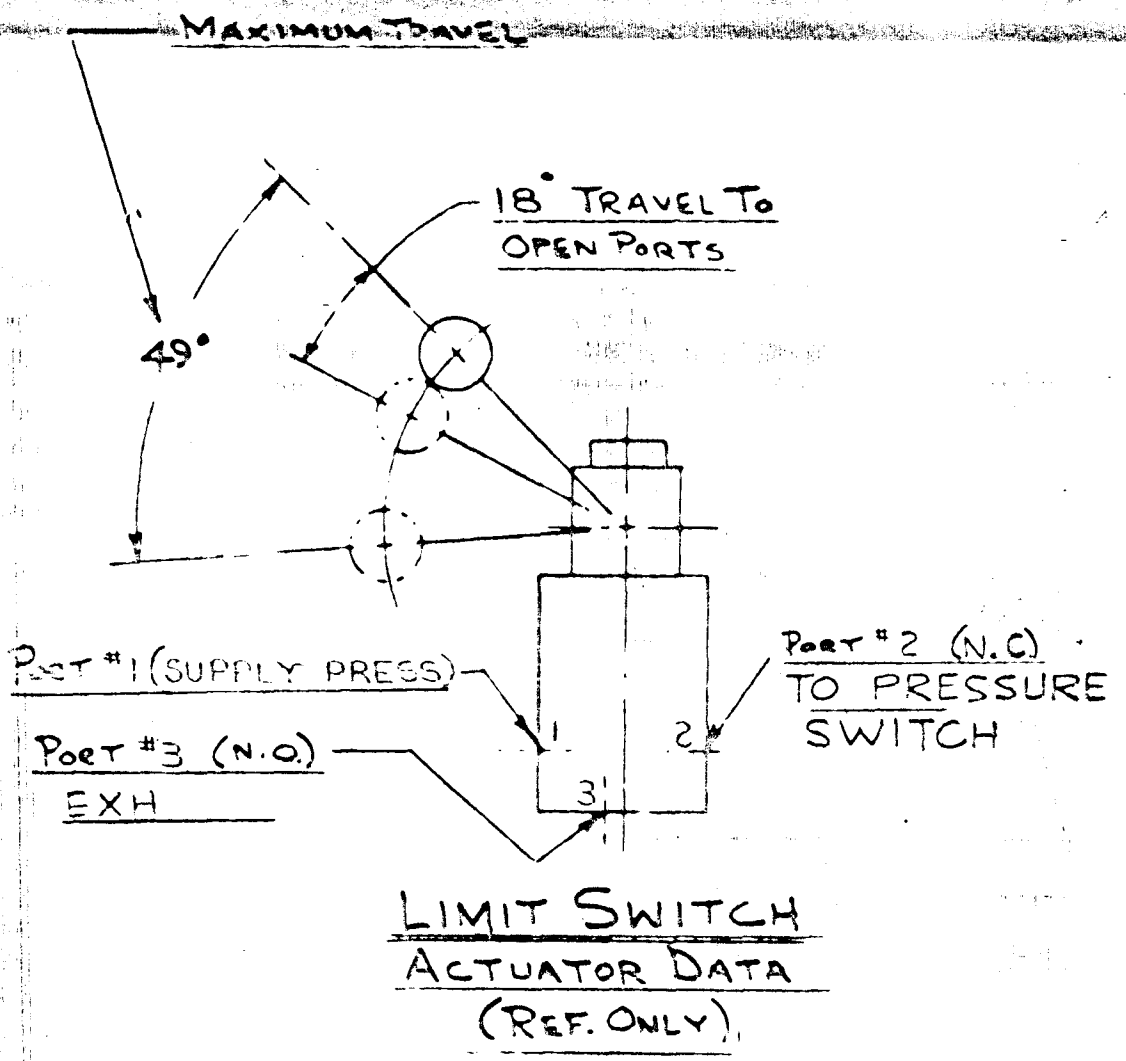
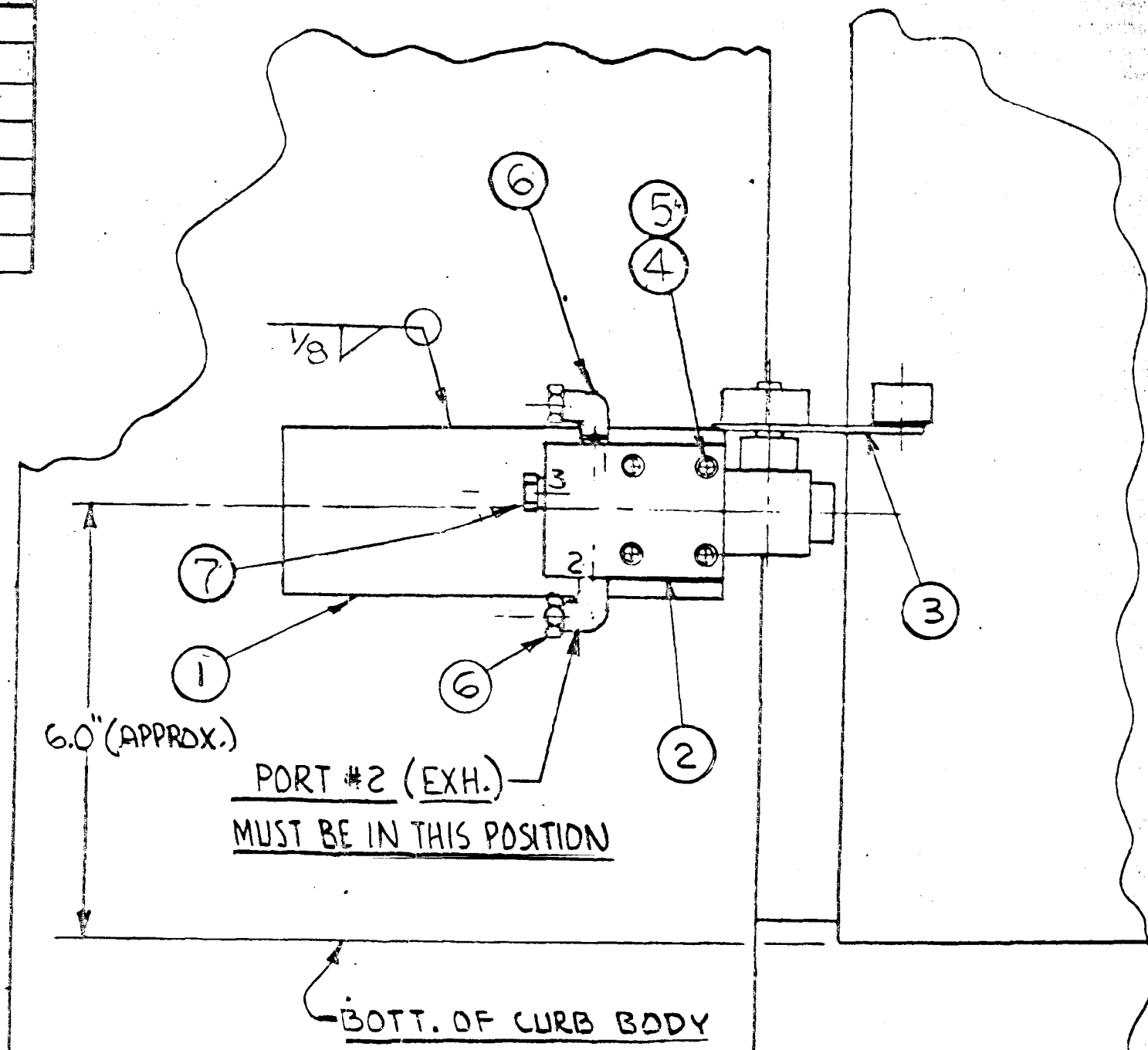
FIRST JOB 975750		MATERIAL		THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
SCALE 1/4"=1'	OR FW/REP	DATE 2-24-83	CHK. GWS	PART No.	DWG No.
UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED	INCH DIMENSIONS 0 ± .020 MM DIMENSIONS 0 ± .5		TITLE PEDESTAL ASSEMBLY		
REPRODUCIBLE COPY ISSUED TO	DATE	FILED 9 2 95	SEE CHART	110-0204-01-3	



ITEM	QTY.	DRAWING NO.	DESCRIPTION
1	1	056-0129-00-2	SUB-MOUNTING PLATE
2	1		ARO AIR LIMIT SWITCH MODEL #402-A
3	1		"ARO" LEVER MODEL #450-ADJUSTABLE
4	4		#10-24 UNC x 2" LG. SOC. HD. CAP SCREW
5	4		#10 LOCKWASHER
6			MALE ELBOW 1/4" TUBE x 1/8" NPT
7	1		BREATHING VENT 1/8" NPT #CEC-1 BV

NOTES:

- 1) ASSEMBLE SWITCH TO MOUNTING PLATE (ITEM #1) AND LOCATE & WELD TO PEDESTAL @ ASSY.
- 2) ADJUST LEVER (ITEM #3) TO OBTAIN SETTING AS SHOWN.



PLAN VIEW

FIRST JOB 42050		THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
MATERIAL		SCALE 1/2" = 1"	UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED INCH DIMENSIONS .0000 ± .0005 MM DIMENSIONS 0.00 ± 0.00 ± 0.00 ± 0.00
REPRODUCIBLE COPY ISSUED TO	DATE	DR. <i>Rephman</i> EX. <i>GWS</i> START 4/10/95 FIN	TITLE PNEUMATIC UNBALANCE SWITCH ASSEMBLY (R.H.)
2 6-595 1 4/10/95		PART NO.	DWG NO.

REVISED FITTINGS, ADDED BREATHING VENT. PORT LOCATIONS REVISED PER NEW SWITCH MODEL 1 SD

4	077-3339-002	BRACKET ACCESS PORT
3		HEX NUT - 5/16" - 18 NC - SS.
2	077-3342-002	BRACKET CURB TOP
1		GAS SPRING - SEE BIM WET
QTY	DRAWING NO.	DESCRIPTION

INSPECTION WINDOW & ACCESS PORT
ASSEMBLY - REF. DWG. D77-3327-00-4

ACCESS PORT

GAS SPRING

11.75" REF.

30° REF.

9.76" COMPRESSED

NOTE:

ASSEMBLE GAS SPRING
WITH ROD END AT THIS
PIVOT POINT.

4		077-3339-002	BRACKET, ACCESS PORT
3			HEX NUT - 5/16" - 18 NC. - SS.
2		077-3342-002	BRACKET, CURB TOP
1			GAS SPRING - SEE B/M LIST
ITEM	QTY.	DRAWING NO.	DESCRIPTION

MARK

DATE

ZONE

REVISION

BY

FIRST JOB 46050

MATERIAL



THE WESTERN STATES MACHINE COMPANY
HAMILTON, OHIO U.S.A.

SCALE 1/2"=1"

UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED
INCH DIMENSIONS 0 ± .020, .00 ± .010, .000 ± .005
MM DIMENSIONS 0 ± .500, .00 ± .200 ± .1

REPRODUCIBLE COPY ISSUED TO

DATE

DATE 6/18/92

CK. 9/1/93

FILMED 7-8-92

TITLE ACCESS PORT COUNTER BALANCE

ASSEMBLY

PART NO

DWG NO

048626

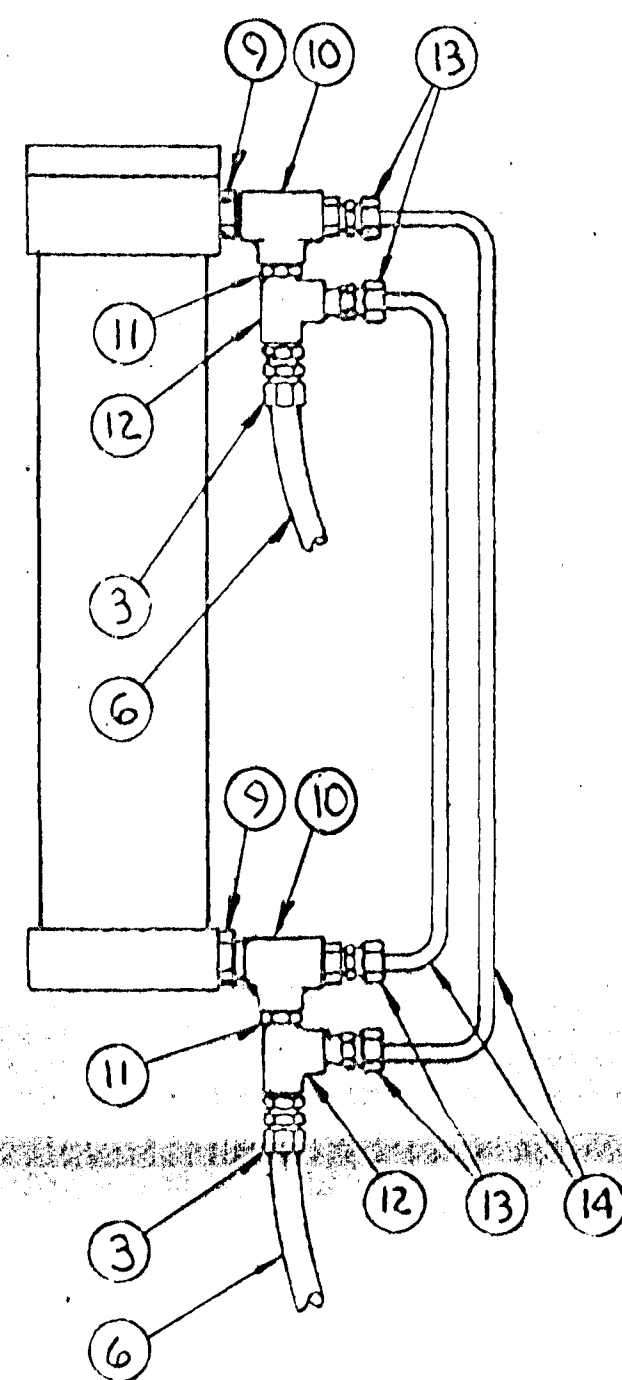
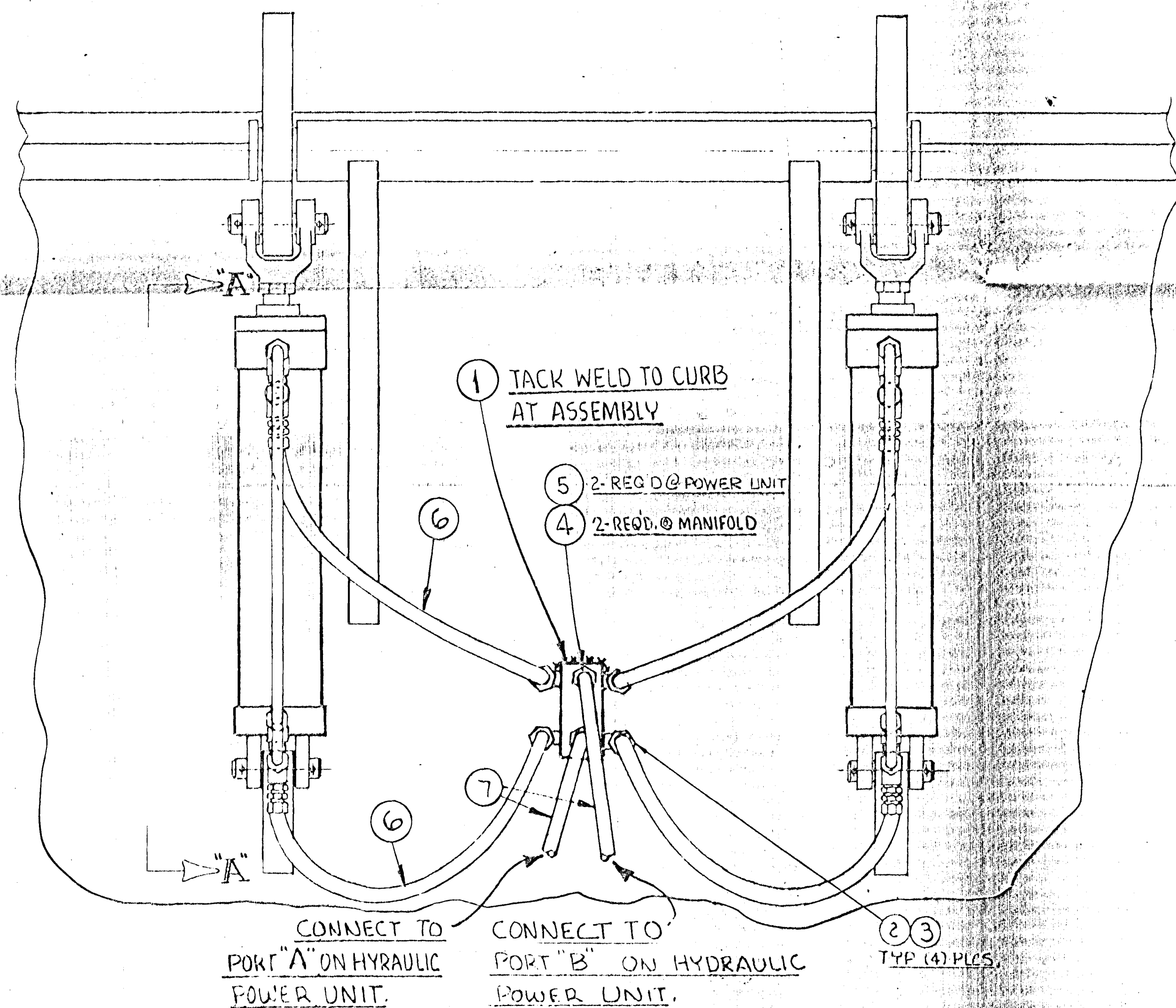
077-3330-00-3

10THS

INCHES

10THS

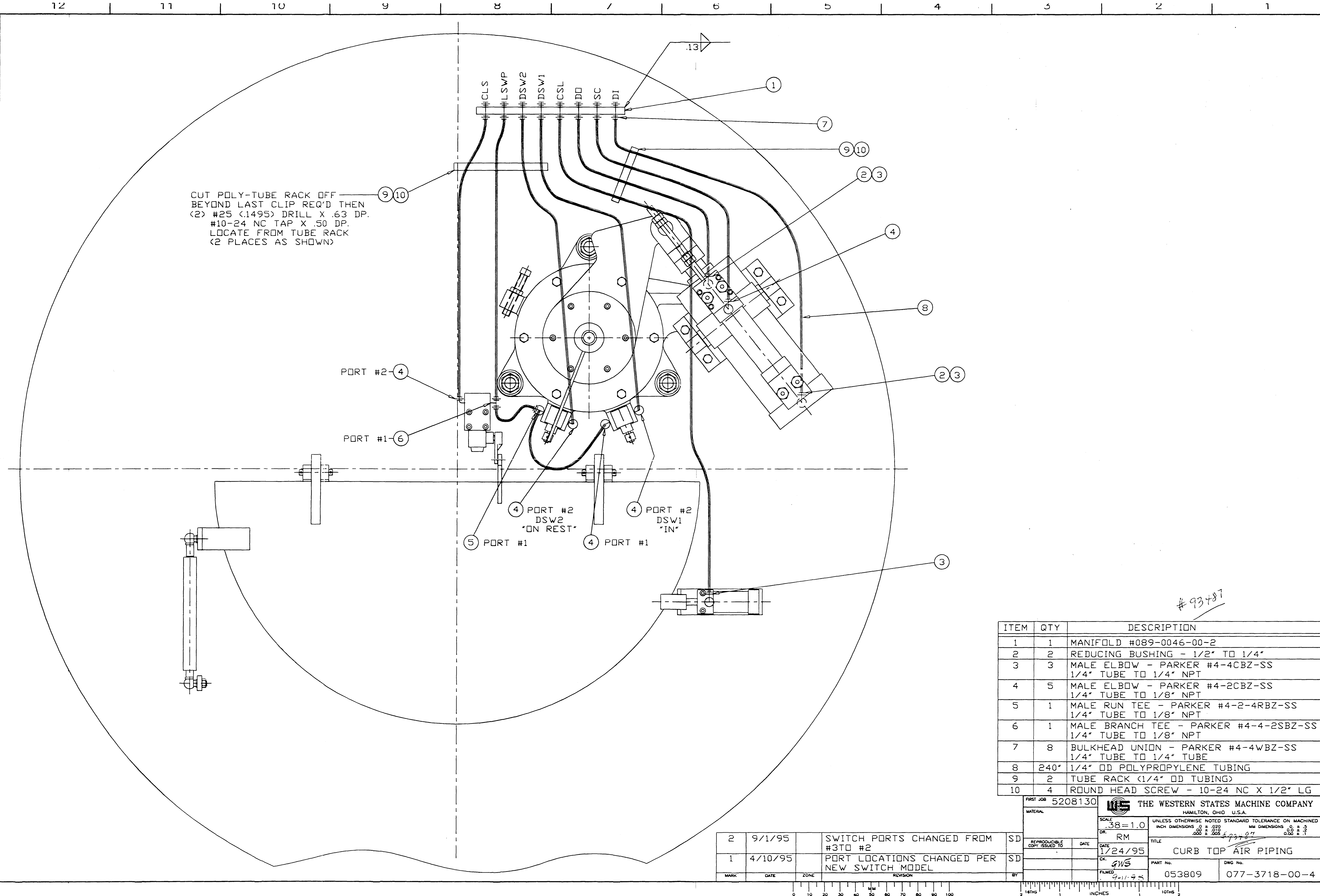
#93487



VIEW "A-A"
3 TYPICAL (2) PLACES

14	120"	1/4" O.D. x .035" WALL TUBE - S.S.
13	8	MALE CONN. - PARKER #4-4 FBZ-SS 1/4" NPT TO 1/4" TUBE
12	4	STREET TEE - PARKER #4-4-4 ST-SS 1/4" NPT
11	4	REDUCING BUSHING - PARKER #6-4RB-SS 3/8" NPT TO 1/4" NPT
10	4	PILOT CHECK VALVE - 3/8" BRAND HYDRAULICS #PC-37
9	4	FEMALE PIPE ADAPTER "PARKER" #10-3/8 F50 GS
8		
7	AS REQ	HYDRAULIC HOSE "LENZ" 3/8" 2BSR (3/4" O.D. x 3/8" I.D.)
6	192"	HYDRAULIC HOSE "LENZ" 1/4" 2BSR (9/16" O.D. x 1/4" I.D.)
5	2	UNION MALE FITTING "LENZ" #115 HUM-3 (3/4" O.D. HOSE, 3/8" NPT)
4	2	UNION MALE FITTING "LENZ" #115 HUM-2 (3/4" O.D. HOSE, 1/4" NPT)
3	8	UNION MALE FITTING "LENZ" #101 HUM-2 (9/16" O.D. HOSE, 1/4" NPT)
2	4	1/4" - 90° STREET ELBOW - S.S.
1	1	076-0104-01-2 FITTING MANIFOLD

ITEM	QTY	DWG. NO.	DESCRIPTION
FIRST JOB		44430	
MATERIAL		THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
SCALE 1/4" = 1"		UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED DIMENSIONS 0 ± .020, .00 ± .010, .000 ± .005 DIMENSIONS 0 ± .5, 0.0 ± .2, 0.00 ± .1	
REPRODUCIBLE COPY ISSUED TO		DATE	TITLE
DATE		6/17/92	OIL PIPING
DATE		6/17/92	FOR CURB TOP CYLINDERS
DATE		6/17/92	PART NO.
DATE		6/17/92	DWG. NO.
DATE		6/17/92	048593
DATE		6/17/92	076-0193-00-3



CUT POLY-TUBE RACK OFF
BEYOND LAST CLIP REQ'D THEN
(2) #25 (.1495) DRILL X .63 DP.
#10-24 NC TAP X .50 DP.
LOCATE FROM TUBE RACK
(2 PLACES AS SHOWN)

PORT #2-4

PORT #1-6

4 PORT #2
DSW2
"ON REST"

5 PORT #1

4 PORT #2
DSW1
"IN"

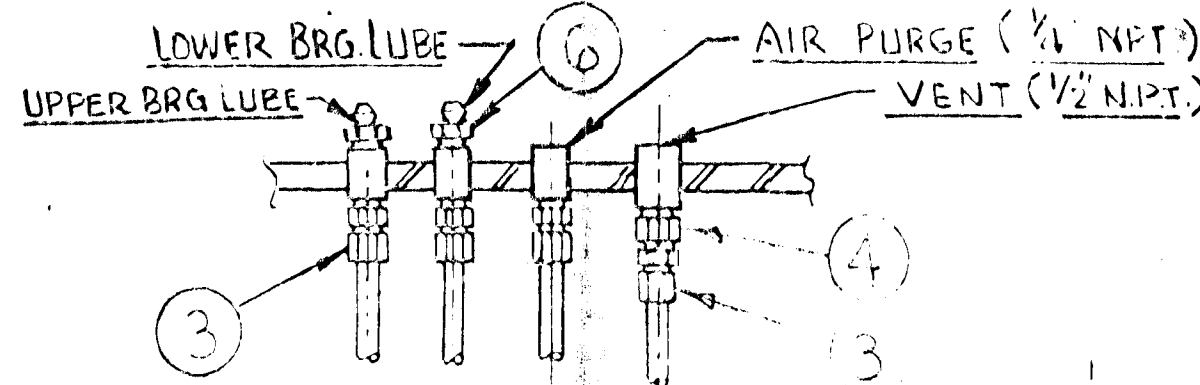
4 PORT #1

ITEM	QTY	DESCRIPTION
1	1	MANIFOLD #089-0046-00-2
2	2	REDUCING BUSHING - 1/2" TO 1/4"
3	3	MALE ELBOW - PARKER #4-4CBZ-SS 1/4" TUBE TO 1/4" NPT
4	5	MALE ELBOW - PARKER #4-2CBZ-SS 1/4" TUBE TO 1/8" NPT
5	1	MALE RUN TEE - PARKER #4-2-4RBZ-SS 1/4" TUBE TO 1/8" NPT
6	1	MALE BRANCH TEE - PARKER #4-4-2SBZ-SS 1/4" TUBE TO 1/8" NPT
7	8	BULKHEAD UNION - PARKER #4-4WBZ-SS 1/4" TUBE TO 1/4" TUBE
8	240'	1/4" OD POLYPROPYLENE TUBING
9	2	TUBE RACK (1/4" OD TUBING)
10	4	ROUND HEAD SCREW - 10-24 NC X 1/2" LG

FIRST JOB 5208130		THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
MATERIAL		SCALE .38=1.0	
REPRODUCIBLE COPY ISSUED TO		DATE 1/24/95	
DATE		CK. GWS	
FILMED 9-11-95		TITLE CURB TOP AIR PIPING	
BY		PART No. 053809	
		DWG No. 077-3718-00-4	

MARK	DATE	ZONE	REVISION	BY
2	9/1/95		SWITCH PORTS CHANGED FROM #3 TO #2	SD
1	4/10/95		PORT LOCATIONS CHANGED PER NEW SWITCH MODEL	SD

0 10 20 30 40 50 60 70 80 90 100
1/8THS 1 INCHES 1 10THS 2



SECT. "A-A"

CONNECT TO RESPECTIVE COUPLINGS

NOTE:
BUNDLE TUBING WITH TY-RAP STRAPS ⑦.
TUBING MUST CLEAR BELTS. PROVIDE ENOUGH
SLACK FOR ADJUSTMENT OF MOTOR BASE.

LUBE VENT (BOT. LIP)
LOWER LINE
AIR PURGE (BRG. H/G)
UPPER LINE
LOWER LUBE LINE
UPPER LUBE LINE

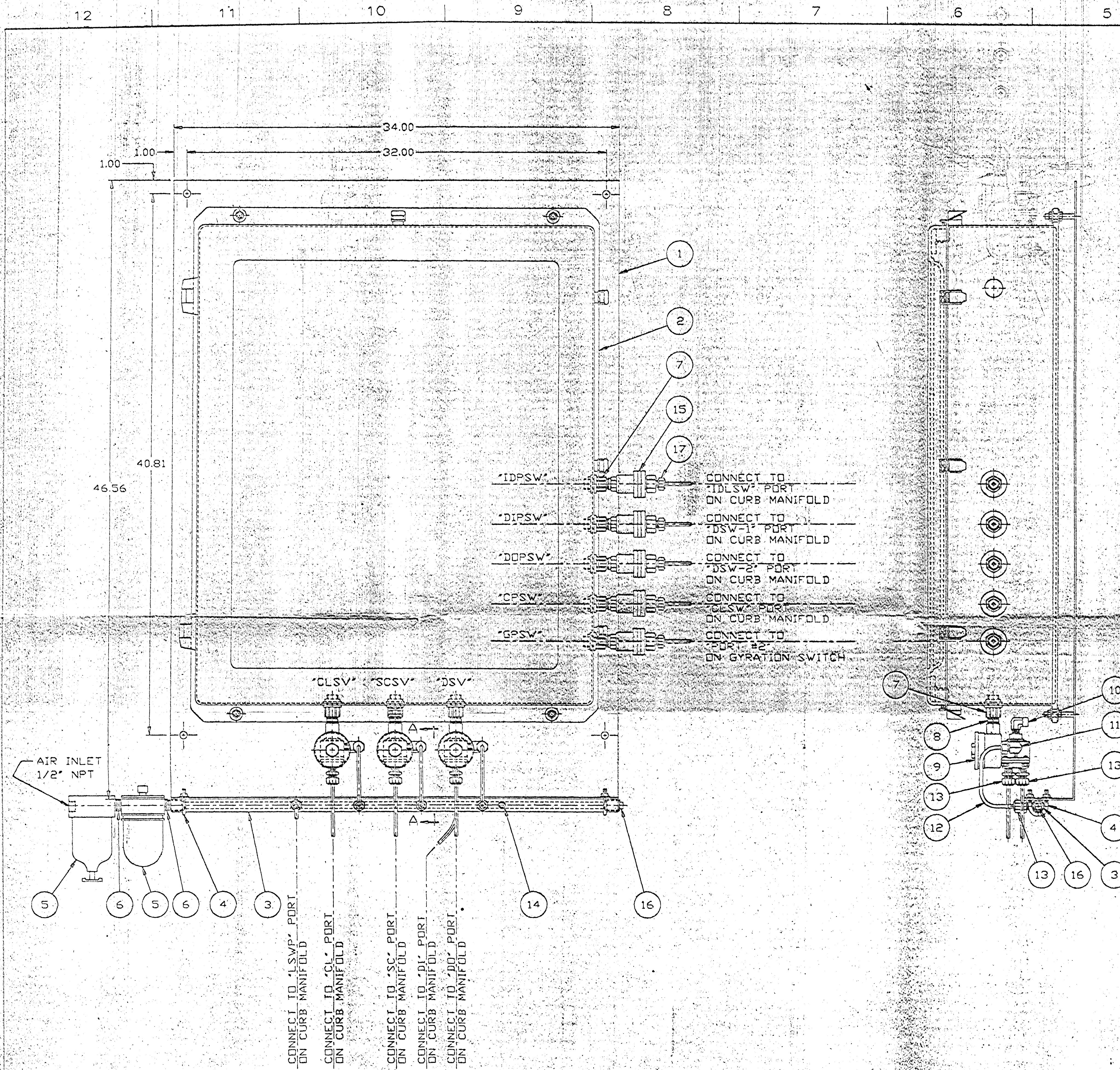
BOTTOM VIEW

#93487

ITEM	QTY	PART NUMBER	DESCRIPTION
1	2		MALE ELBOW IMP-EAST #269 P-06X02 (3/8" T x 1/2" NPT)
2	1		MALE CONNECTOR IMP-EAST #268 P-06X06 (3/8" T x 1/2" NPT)
3	4		MALE CONNECTOR IMP-EAST #268 P-06X06 (3/8" T x 1/2" NPT)
4	1		REDUCER IMP-EAST #110 B-06X04 (1/2" T x 1/4" NPT)
5	144"		7" TUBING IMP-EAST #661 P-IMP-ENE
6	2		GREASE FITTING-ALEMITE #1107 E
7	3		"TY-RAP" STRAP #TY-37
8	1		MALE CONNECTOR IMP-EAST #268 P-06X02 (3/8" T x 1/2" NPT)

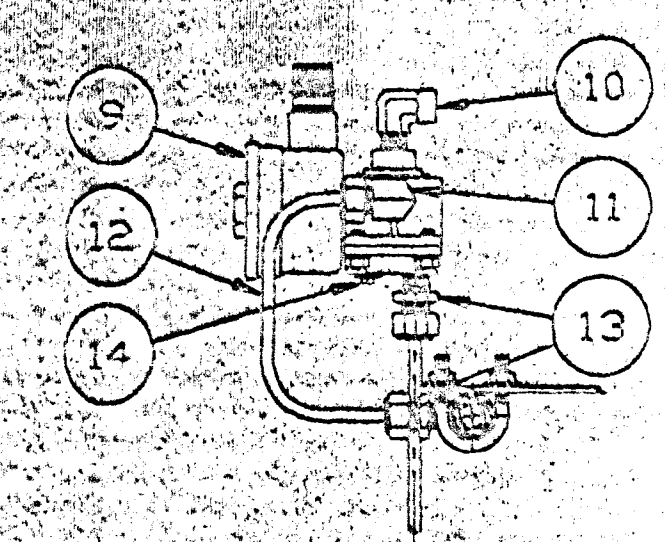
2	11-4-87		ITEM 1 QTY WAS 3, ADDED ITEM 2	SMD
1	5-12-87		CORRECTED DWG (LOWER & UPPER LUBE LINE TO BE THRU BOT)	AP
MARK	DATE	ZONE	REVISION	BY

FIRST JOB- 30430		THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
MATERIAL		SCALE 1/4" = 1"	UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED DIMENSIONS ARE 0 ± .020, .00 ± .010, .000 ± .005
REPRODUCIBLE COPY ISSUED TO	DATE	DR <i>Repl...</i>	TITLE
		CK	BEARING HOUSING LUBE ASSY.
		DATE	GREASE LUBE-WHISPERDYNE/V-F DRIVE
		FIN	PART NO
		FILED	DWG NO
			039141 094-0812-00-3



ITEM	QTY	DWG. NO.	DESCRIPTION
1	1	043-0791-00-3	MOUNTING PLATE
2	1	043-0790-00-4	JUNCTION BOX
3	1	043-0792-00-2	AIR SUPPLY MANIFOLD
4	2		"GRINNEL" #120 U-BOLT W/LOCKWASHER & NUTS
5	1		FILTER & LUBRICATOR "NORGREN" #PAC-400-M3L (1/2")
6	2		1/2" x 1-1/2" LG PIPE NIPPLE T.B.E.
7	8		HUB MEYERS CONDUIT (1/2")
8	3		1/2" x 1-1/2" LG CONDUIT NIPPLE
9	3		"ASCO" #8342-CL 4-WAY EX-PROOF SOLENOID VALVE
10	3		120 V. 60 HZ. 1/4" NPT
11	3		1/4" STREET ELBOW
12	60		MALE ELBOW - PARKER 4-4 GBZ, 1/4" NPT x 1/4" TUBE
13	8		1/4" TUBING, GRAY - GOULD IMP.-EASTMAN #44PGR
14	3		MALE CONNECTOR - PARKER 4-4 FBZ, 1/4" NPT x 1/4" TUBE
15	5		1/4" NPT SQ. HD. PIPE PLUG
16	1		"NEO DYN" X-PROOF PRESSURE SWITCH (10 PSI RISING)
17	5		1/2" NPT SQ. HD. PIPE PLUG
17	5		FEMALE CONNECTOR - PARKER 4-4 GBZ, 1/4" NPT x 1/4" TUBE

- "DIPSW" - DISCHARGER IN PRESSURE SWITCH
- "DOPSW" - DISCHARGER OUT PRESSURE SWITCH
- "CPSW" - COVER LIMIT SWITCH PRESSURE SWITCH
- "GPSW" - GYRATION SWITCH PRESSURE SWITCH
- "CLSV" - COVER LATCH SOLENOID VALVE
- "SCSV" - STOP CHECK SOLENOID VALVE
- "DSV" - DISCHARGER SOLENOID VALVE
- "IDPSW" - INSPECTION DOOR PRESSURE SWITCH

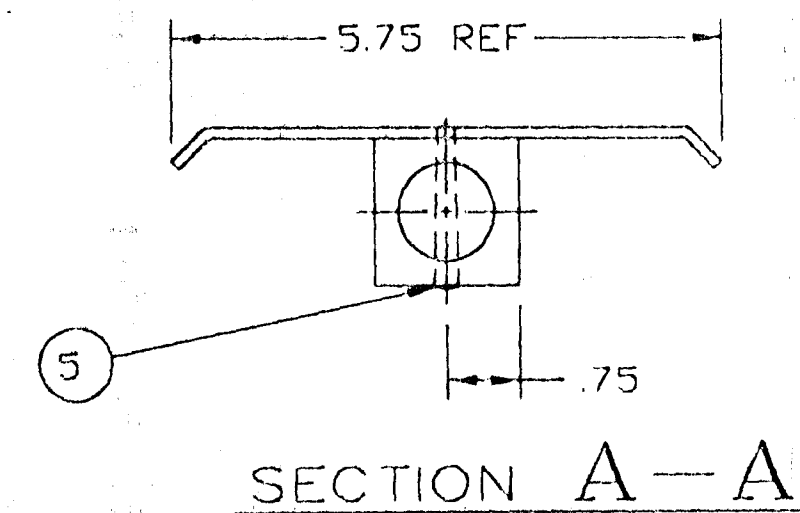
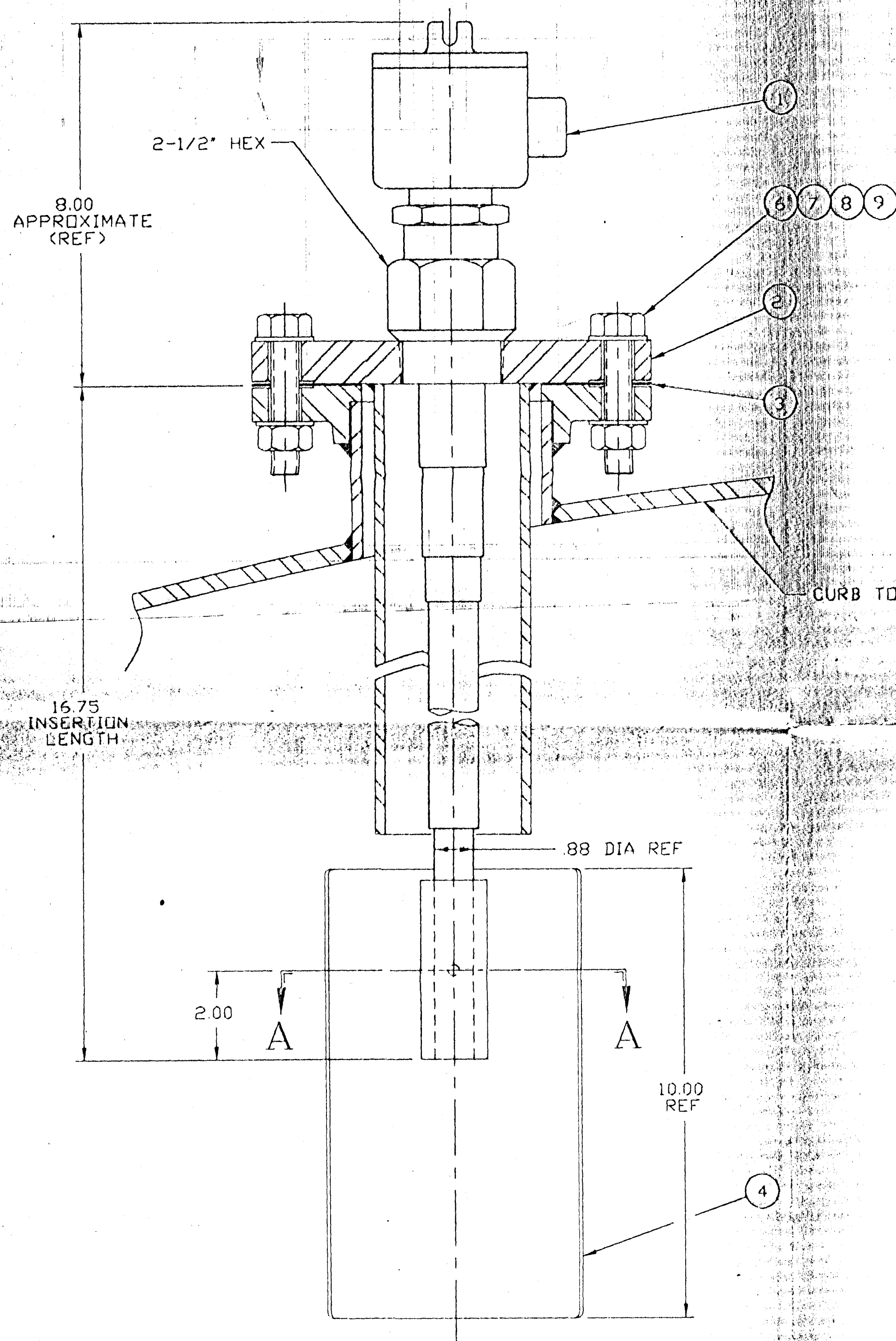


#93487

5209844		THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
SCALE 1:4	DATE 7-10-95	UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED DIMENSIONS: FRACTIONS DECIMALS ANGLES 1/16 0.0625 90 0.0005 1/2 0.001	
DATE 7-10-95	DATE 7-10-95	TITLE SOLENOID VALVE & PRESSURE SWITCH ASSEMBLY	
DATE 7-10-95	DATE 7-10-95	PART NO. 054706	DWG. NO. 043-0789-00-4

0 10 20 30 40 50 60 70 80 90 100

INCHES



ASSEMBLY NOTES:

1. LOCATE PROBE EXTENSION ON PROBE AS SHOWN
2. DRILL AND REAM FOR #4 TAPER PIN, SEE SECTION 'A-A'. PIN WITH PROBE BOTTOM FLUSH WITH BOTTOM OF SLEEVE.

ITEM	QTY	DWG NO	DESCRIPTION
1	1		DREXELBROOK PROBE
2	1	052-0855-00-2	BASE, MOUNTING
3	1		GASKET - GORETEX 'GR' SHEET
4	1	052-0658-00-2	PROBE EXTENSION ASSEMBLY
5	1		TAPER PIN #4 X 1-3/4" LG.
6	8		SCREW, HEX HD CAP 5/8"-11 NC X 3" LG.
7	8		NUT, HEX 5/8"-11 NC
8	8		LOCKWASHER - 5/8"
9	8		PLAINWASHER - 5/8"

FIRST JOB 5209844		THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
MATERIAL 316L S.S.		SCALE HALF	UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED
MC 39		DR. DF	INCH DIMENSIONS: 0 ± .020, .00 ± .010, .000 ± .005 MM DIMENSIONS: 0 ± .5, .00 ± .2, .000 ± .1
REPRODUCIBLE COPY ISSUED TO	DATE	DATE 6-7-95	TITLE CAPACITANCE LOAD CONTROL ASSEMBLY (ON/OFF)
		CK.	PART No.
		FILMED	DWG No. 54472 052-0976-00-3

MARK	DATE	ZONE	REVISION	BY

MM INCH

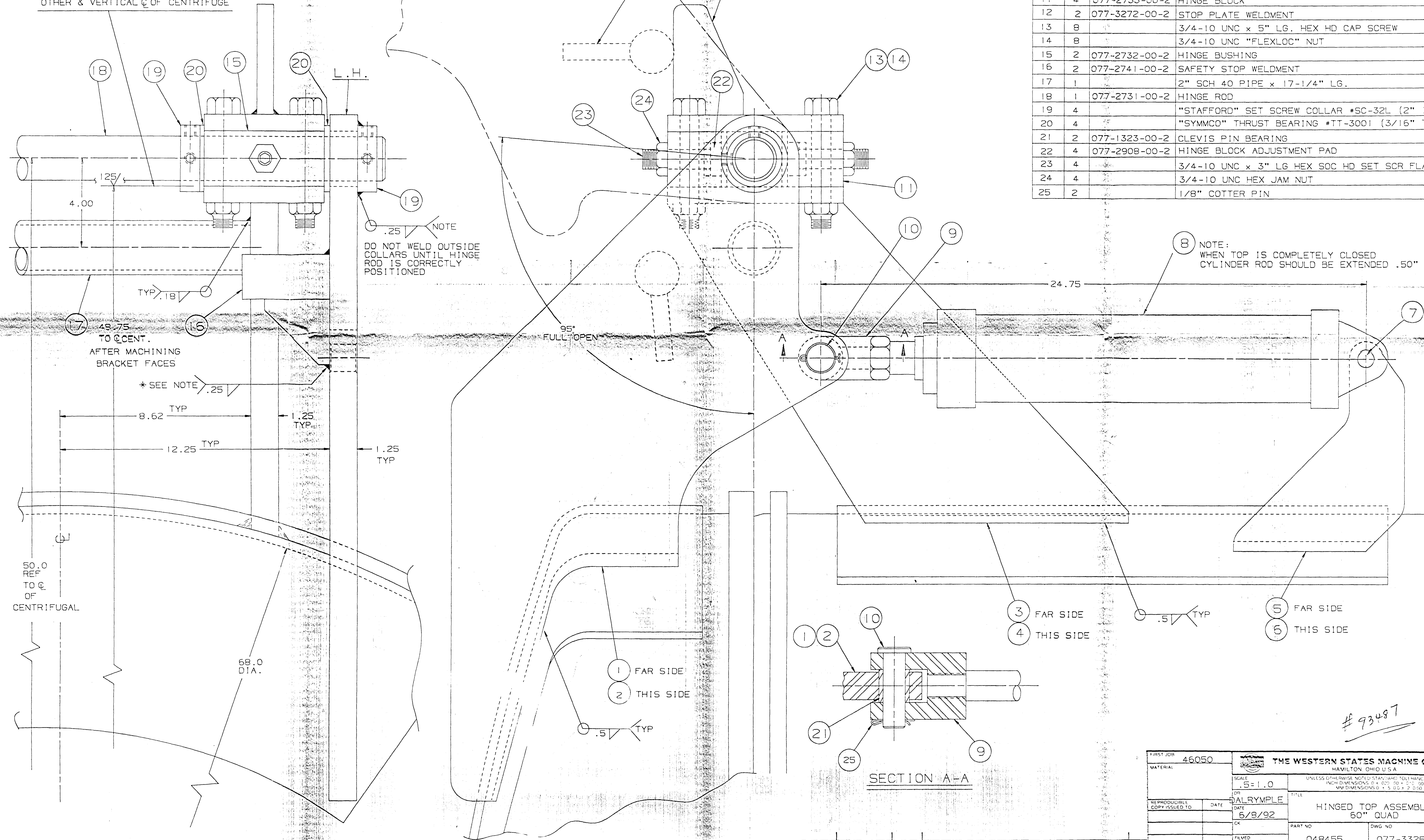
ITEM	QTY	DRAWING NO.	DESCRIPTION
1	1	077-3323-00-3	LEVER ARM, CURB TOP (R.H.)
2	1	077-3324-00-3	LEVER ARM, CURB TOP (L.H.)
3	1	077-3321-00-3	CURB HINGE SUPPORT (R.H.)
4	1	077-3322-00-3	CURB HINGE SUPPORT (L.H.)
5	1	077-3318-00-2	CYLINDER ANCHOR (R.H.)
6	1	077-3319-00-2	CYLINDER ANCHOR (L.H.)
7	2		PIVOT PIN (3/4" DIA.)
8	2		HYDRAULIC CYLINDER - 4" BORE - 14" STROKE
9	2		ROD CLEVIS
10	2		CLEVIS PIN (1" DIA.)
11	4	077-2733-00-2	HINGE BLOCK
12	2	077-3272-00-2	STOP PLATE WELDMENT
13	8		3/4-10 UNC x 5" LG. HEX HD CAP SCREW
14	8		3/4-10 UNC "FLEXLOC" NUT
15	2	077-2732-00-2	HINGE BUSHING
16	2	077-2741-00-2	SAFETY STOP WELDMENT
17	1		2" SCH 40 PIPE x 17-1/4" LG.
18	1	077-2731-00-2	HINGE ROD
19	4		"STAFFORD" SET SCREW COLLAR #SC-32L (2" I.D.)
20	4		"SYMMCO" THRUST BEARING #TT-3001 (3/16" THK.)
21	2	077-1323-00-2	CLEVIS PIN BEARING
22	4	077-2908-00-2	HINGE BLOCK ADJUSTMENT PAD
23	4		3/4-10 UNC x 3" LG HEX SOC HD SET SCR FLAT POINT
24	4		3/4-10 UNC HEX JAM NUT
25	2		1/8" COTTER PIN

NOTE:
MACHINE FACES OF HINGE SUPPORT
BRACKET TO BE PARALLEL TO EACH
OTHER & VERTICAL C OF CENTRIFUGE

* NOTE:
WELD SAFETY STOP, AS SHOWN WITH TOP
95° OPEN AND HINGE COMPLETELY ASSEMBLED

NOTE
DO NOT WELD OUTSIDE
COLLARS UNTIL HINGE
ROD IS CORRECTLY
POSITIONED

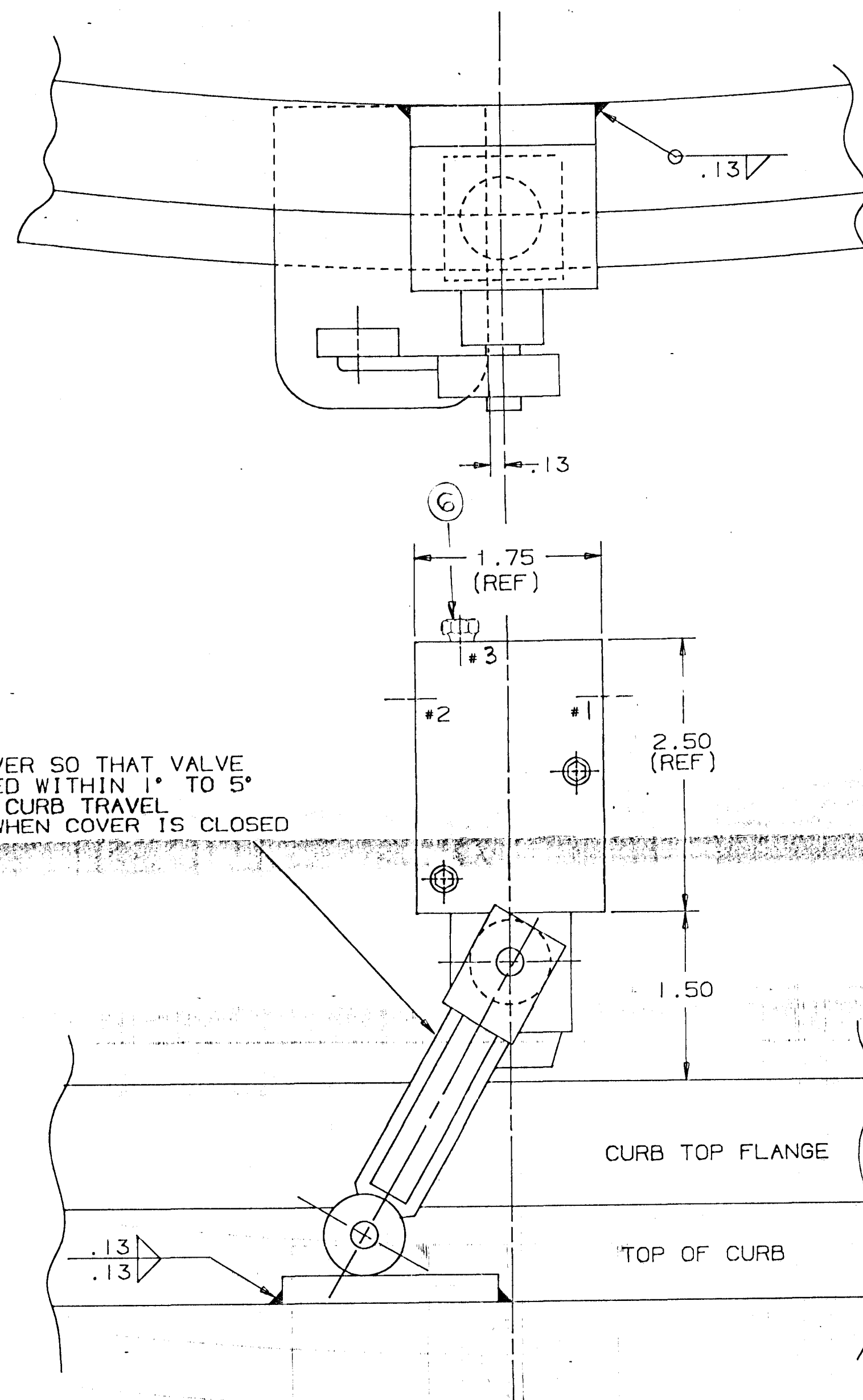
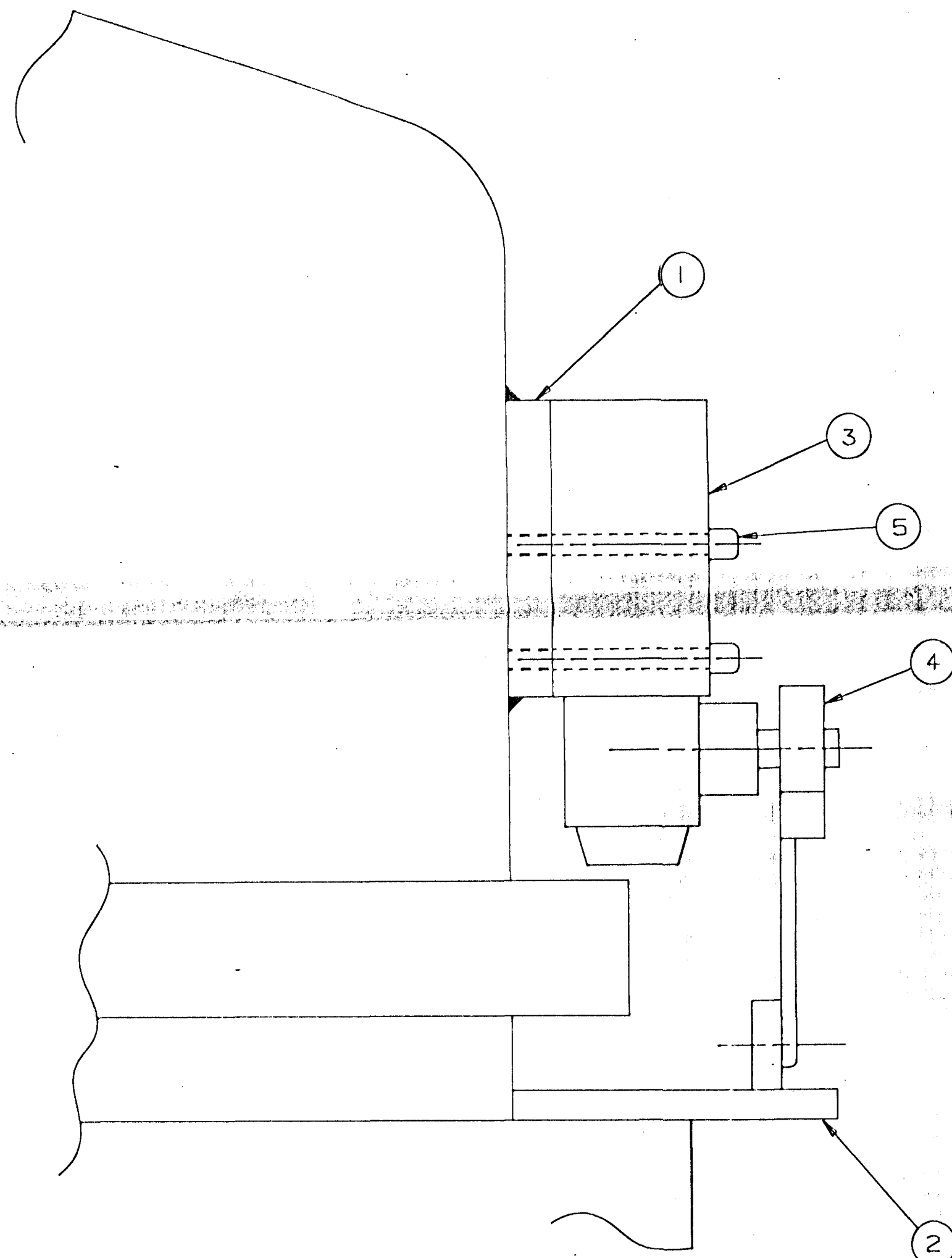
NOTE:
WHEN TOP IS COMPLETELY CLOSED
CYLINDER ROD SHOULD BE EXTENDED .50"



93487

FIRST JOB 46050		THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
MATERIAL	SCALE 1.5 = 1.0	UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED INCH DIMENSIONS 0 + .0010 - .0010 MM DIMENSIONS 0 + .0025 - .0025	
REPRODUCIBLE COPY ISSUED TO	DATE 6/9/92	TITLE HINGED TOP ASSEMBLY 60" QUAD	
FILED 2-1-92	DATE 6/9/92	PART NO 048455	DWG NO 077-3325-00-4

MM INCH



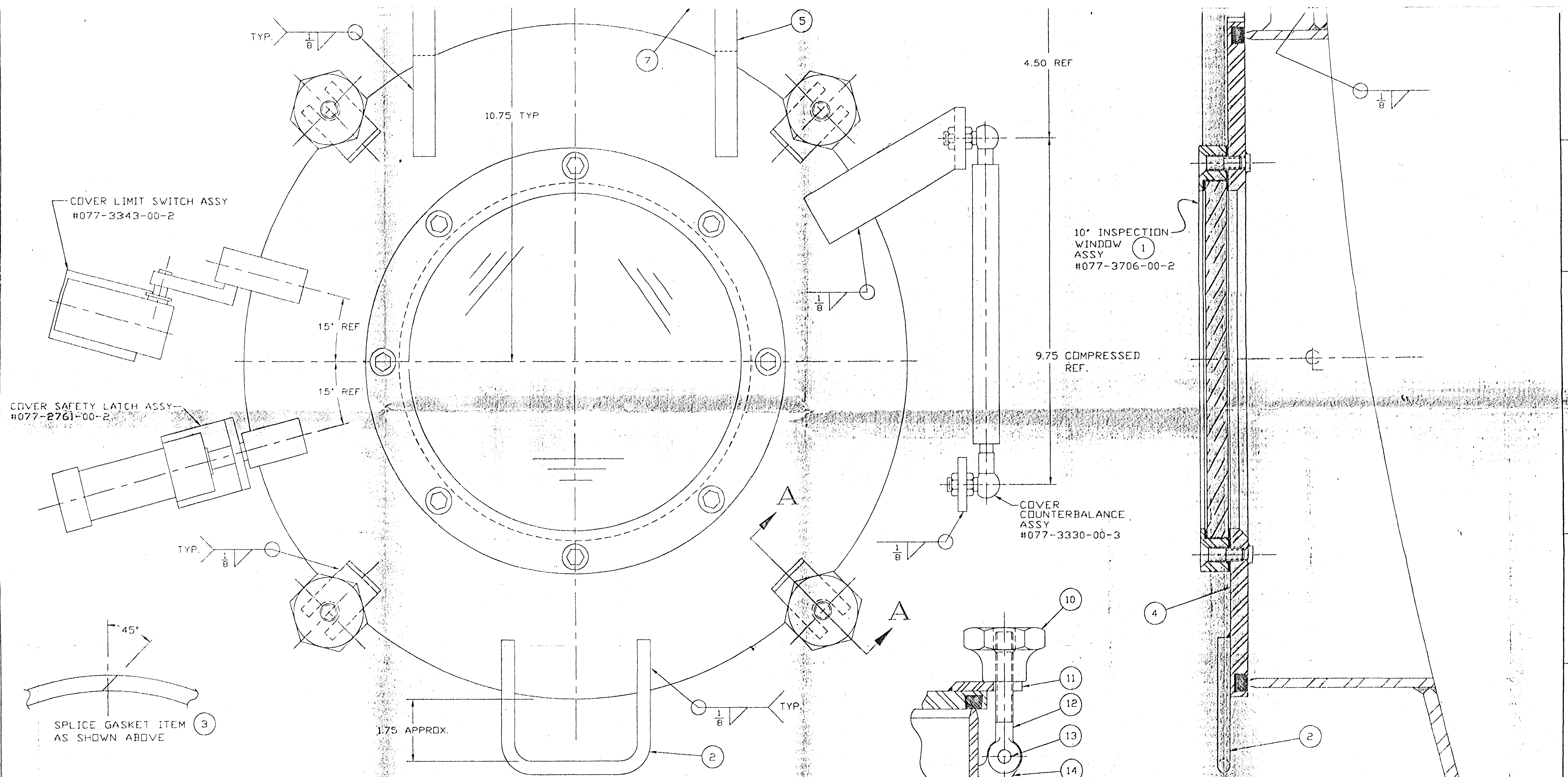
ADJUST LEVER SO THAT VALVE
IS ACTUATED WITHIN 1° TO 5°
OF TOP OF CURB TRAVEL
& RESETS WHEN COVER IS CLOSED

6	1		BREATHER VENT - 1/8" NPT #CEC-1BV
5	2		SCREW, HEX SOC CAP #10-24, 1-3/4 LG.
4	1		"ARO" LEVER ARM #450
3	1		"ARO" LIMIT VALVE #402
2	1	077-3274-00-2	TRIP, LIMIT VALVE
1	1	077-2468-00-2	PLATE, MOUNTING
ITEM	QTY	DRAWING NO.	DESCRIPTION

2	6-6-95	RELOCATED BREATHER VENT	DF
1	2-25-93	ADDED BREATHER VENT	SD
DATE	REVISION	BY	

FIRST JOB 44430		THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
MATERIAL		SCALE 1" = 1"	UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED INCH DIMENSIONS 0 + .020 00 ± .010 000 ± .005 MM DIMENSIONS 0 ± .5 00 ± 2 000 ± 1
REPRODUCIBLE COPY ISSUED TO		DR M.S.	TITLE COVER LIMIT VALVE ASSEMBLY
DATE		DATE 11-27-91	PART NO 047275
CK		CK	DWG NO 077-3275-00-3
FILMED 6/23/95			

#93487

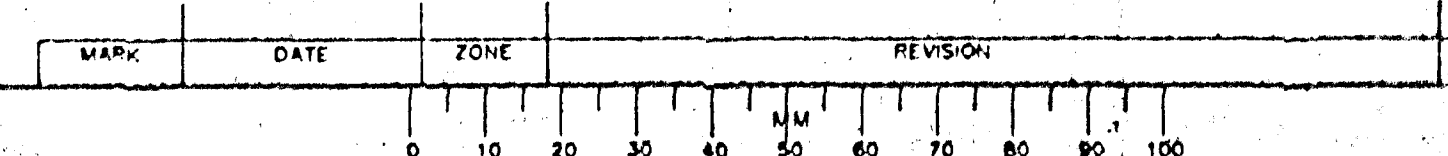


NOTE:
DO ALL WELDING TO BEZEL MOUNTING PLATE
BEFORE INSTALLING GASKETS AND WINDOW.

9	4	077-3335-00-2	LOCKING COLLAR *STAFFORD*#M8-SS
8	2	077-3334-00-2	STOP PIN
7	2	077-3334-00-2	HINGE SUPPORT
6	2	077-3333-00-2	HINGE PIN
5	2	077-3689-00-2	HINGE
4	1	077-3331-01-3	BEZEL MOUNTING PLATE
3	60	3/8" X 1/2" GASKET-VITON	
2	1	077-3336-00-2	HANDLE
1	1	077-3706-00-2	10" INSPECTION WINDOW ASSEMBLY
ITEM	QTY	DRAWING No.	DESCRIPTION

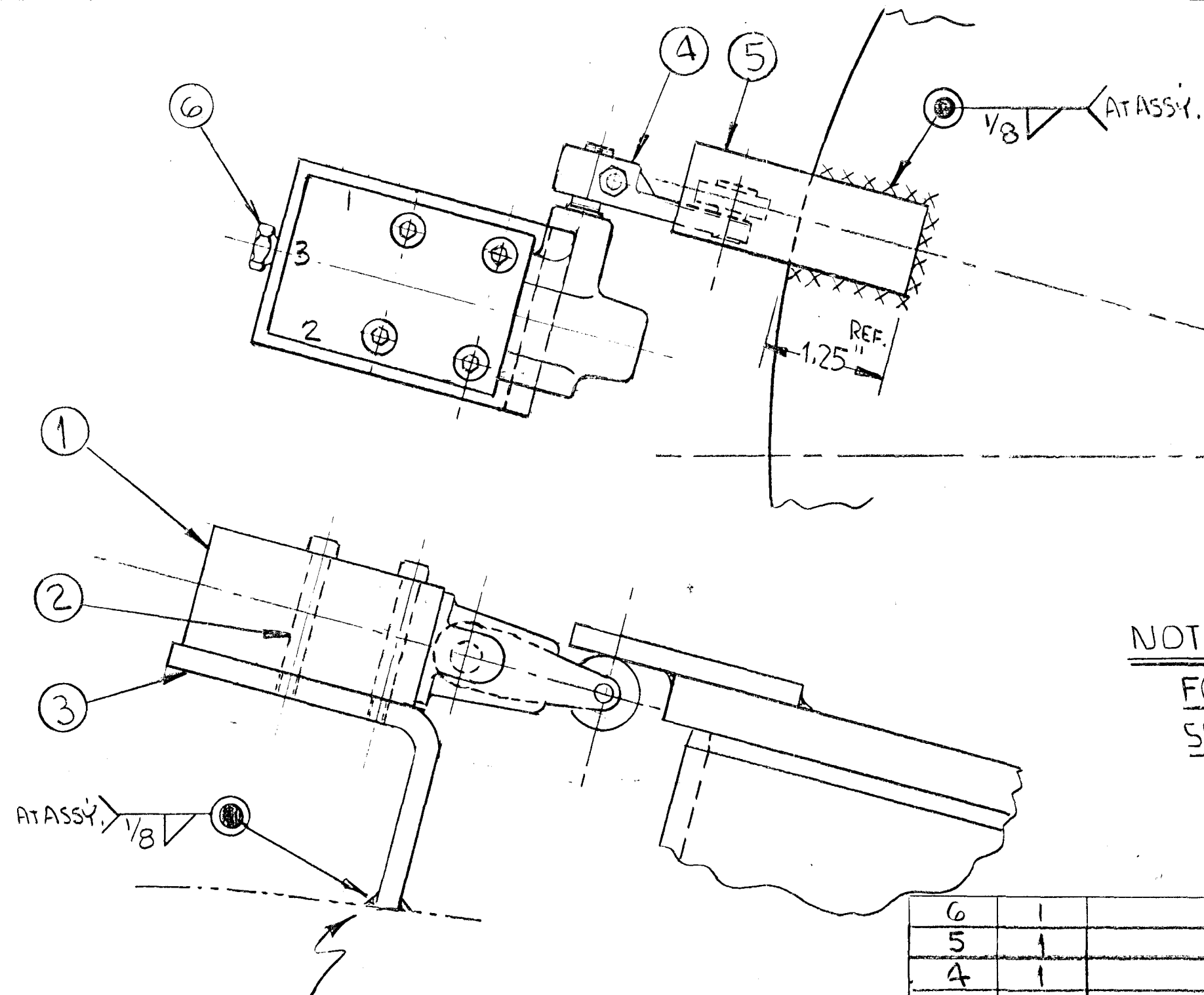
14	4	077-0165-00-1	BASE
13	4	077-0167-00-1	PIN
12	4	077-0164-00-1	ROD END
11	4	077-0168-00-1	CLAMP YOKE
10	4	077-0166-00-1	CLAMP KNOB
ITEM	QTY	DRAWING No.	DESCRIPTION

SECTION A-A



FIRST NO. 5209844		THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
SCALE 3/4"=1.0"		UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED INCH DIMENSIONS .000 ± .003 MM DIMENSIONS .00 ± .01	
DATE 7-10-95	DF	TITLE INSPECTION WINDOW AND ACCESS PORT ASSEMBLY	
FILED	87	PART NO. 054705	DWG NO. 077-3753-00-4

INCH

NOTE:

FOR CORRECT ORIENTATION
SEE INSPECTION PORT ASSEMBLY

#93487

NOTE:

TRIM TO FIT CONTOUR
OF CURB TOP AT ASSY.

6	1		BREATHER VENT - 1/8" NPT #CEC-1BV
5	1		1/4" THK. x 1" WIDE x 2 1/2" LG. (316L S.S.)
4	1		LEVER ACTUATOR "ARO" MODEL #447
3	1	077-3344-00-2	MOUNTING BRACKET
2	4		#10-32 x 1 5/8" LG. SOL. HD. CAP SCR. - S.S.
1	1		LIMIT SWITCH "ARO" MODEL #402 (1/8" NPT PORTS)

ITEM	QTY.	DRAWING NO.	DESCRIPTION
------	------	-------------	-------------

FIRST JOB 46050

MATERIAL



THE WESTERN STATES MACHINE COMPANY

HAMILTON, OHIO U.S.A.

SCALE 3/4" = 1"

UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED
INCH DIMENSIONS: 0 = .020
.00 = .010
.000 = .005
MM DIMENSIONS: 0 = .5
0.0 = .2
0.00 = .1

MC-100

DR.

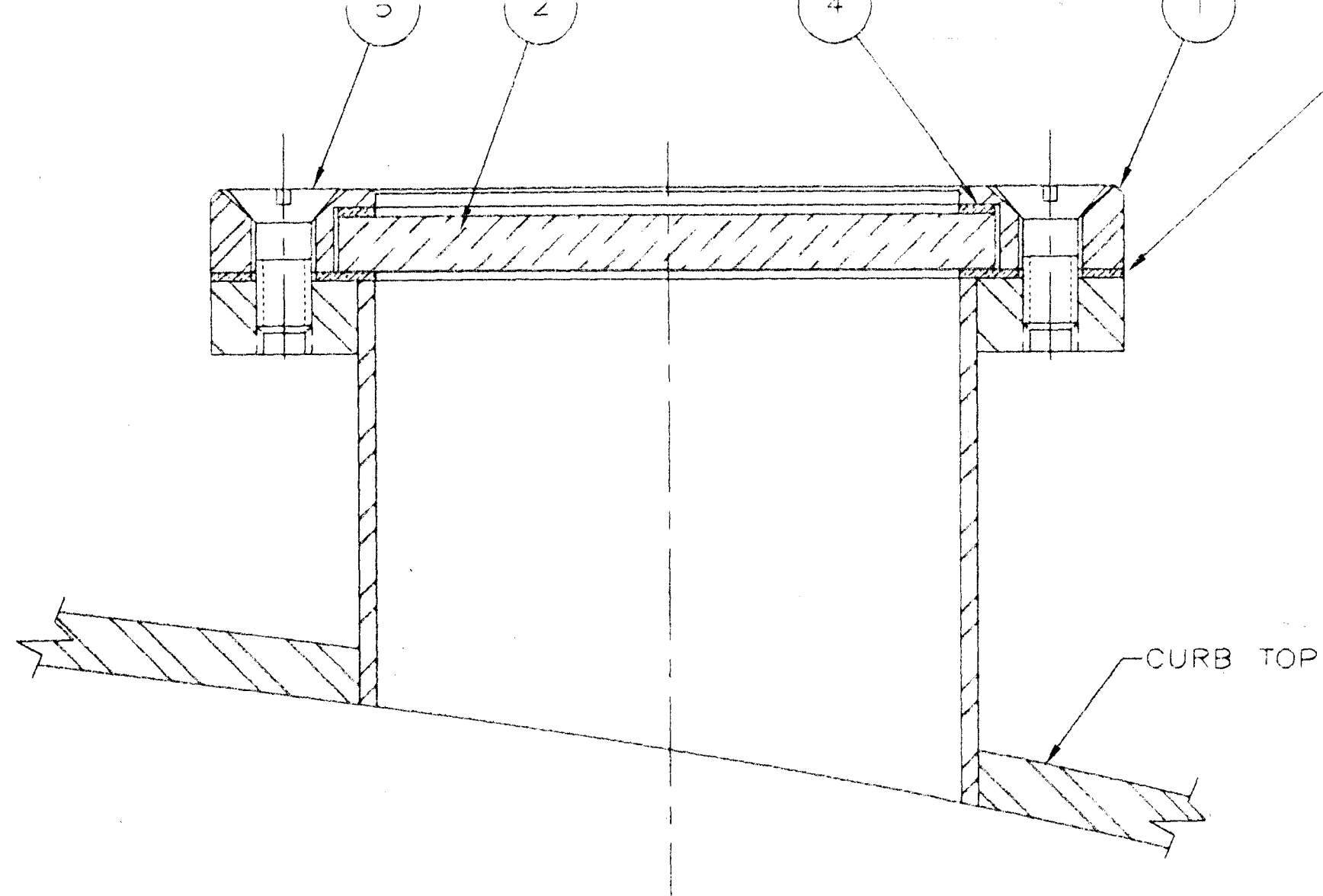
DATE

6/22/97

REPRODUCIBLE
COPY ISSUED TO

DATE

COVER LIMIT SWITCH ASSY.

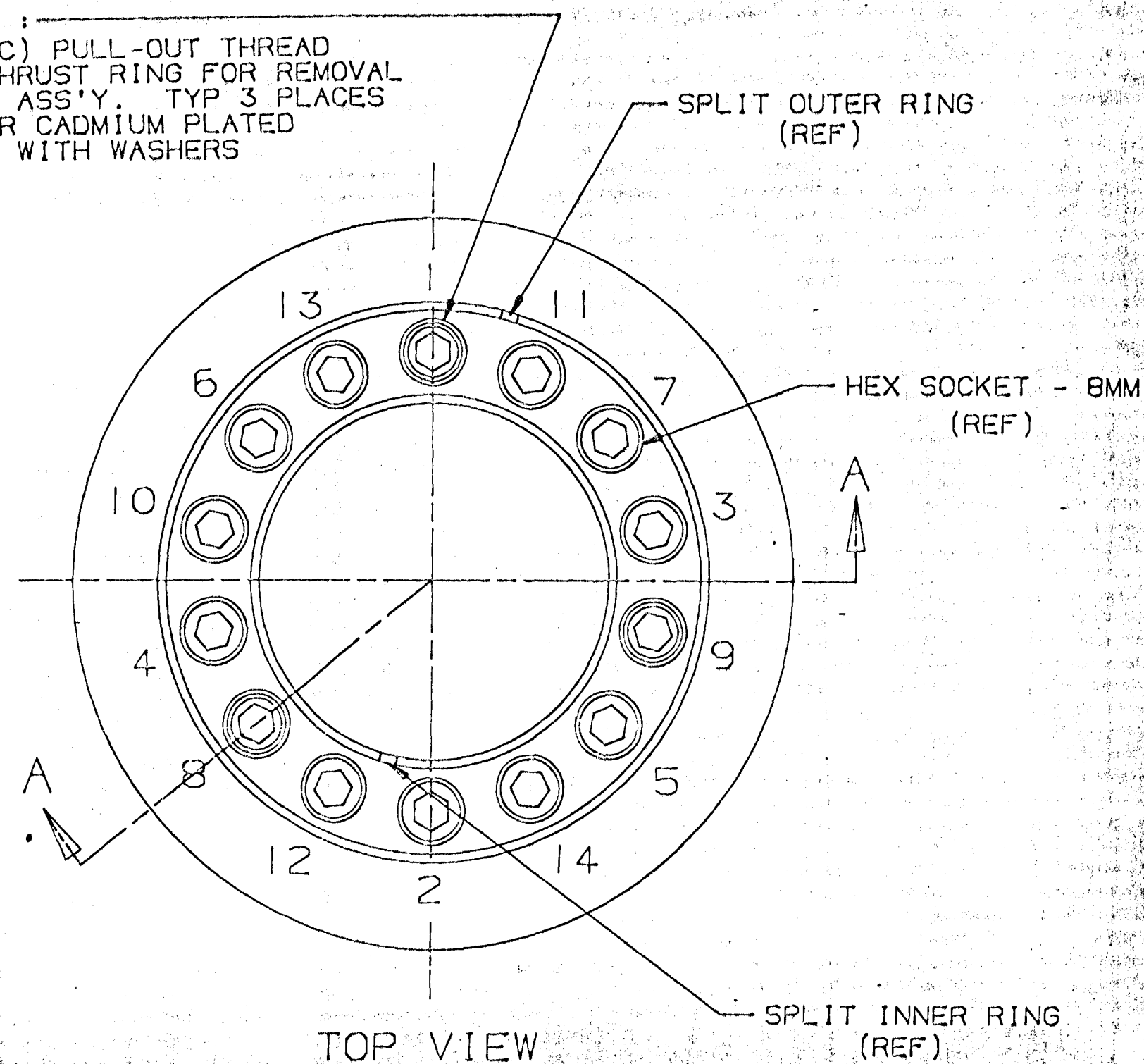


5	4		SCREW, FLAT HD SLOTTED 3/8-16 X 3/4" LG.
4	1	077-3636-00-2	GASKET (TOP)
3	1	077-3637-00-2	GASKET (BOTTOM)
2	1	077-3638-00-2	GLASS
1	1	077-3639-00-2	BEZEL
ITEM	QTY	DRAWING No.	DESCRIPTION
FIRST JOB 5209844		 THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
MATERIAL		SCALE FULL	UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED
		DR. DF	INCH DIMENSIONS 0 ± .020 .00 ± .010 .000 ± .005
REPRODUCIBLE COPY ISSUED TO		DATE 6-2-95	TITLE 4" LIGHT PORT ASSEMBLY
		CK. GSE	PART No 054471
		FILMED 6/22/95	DWG No. 077-3745-00-2

MARK	DATE	ZONE	REVISION	BY

MM INCH

NOTE (REF) :
M12 (METRIC) PULL-OUT THREAD
IN FRONT THRUST RING FOR REMOVAL
OF LOCKING ASS'Y. TYP 3 PLACES
ONLY, UNDER CADMIUM PLATED
CAP SCREWS WITH WASHERS

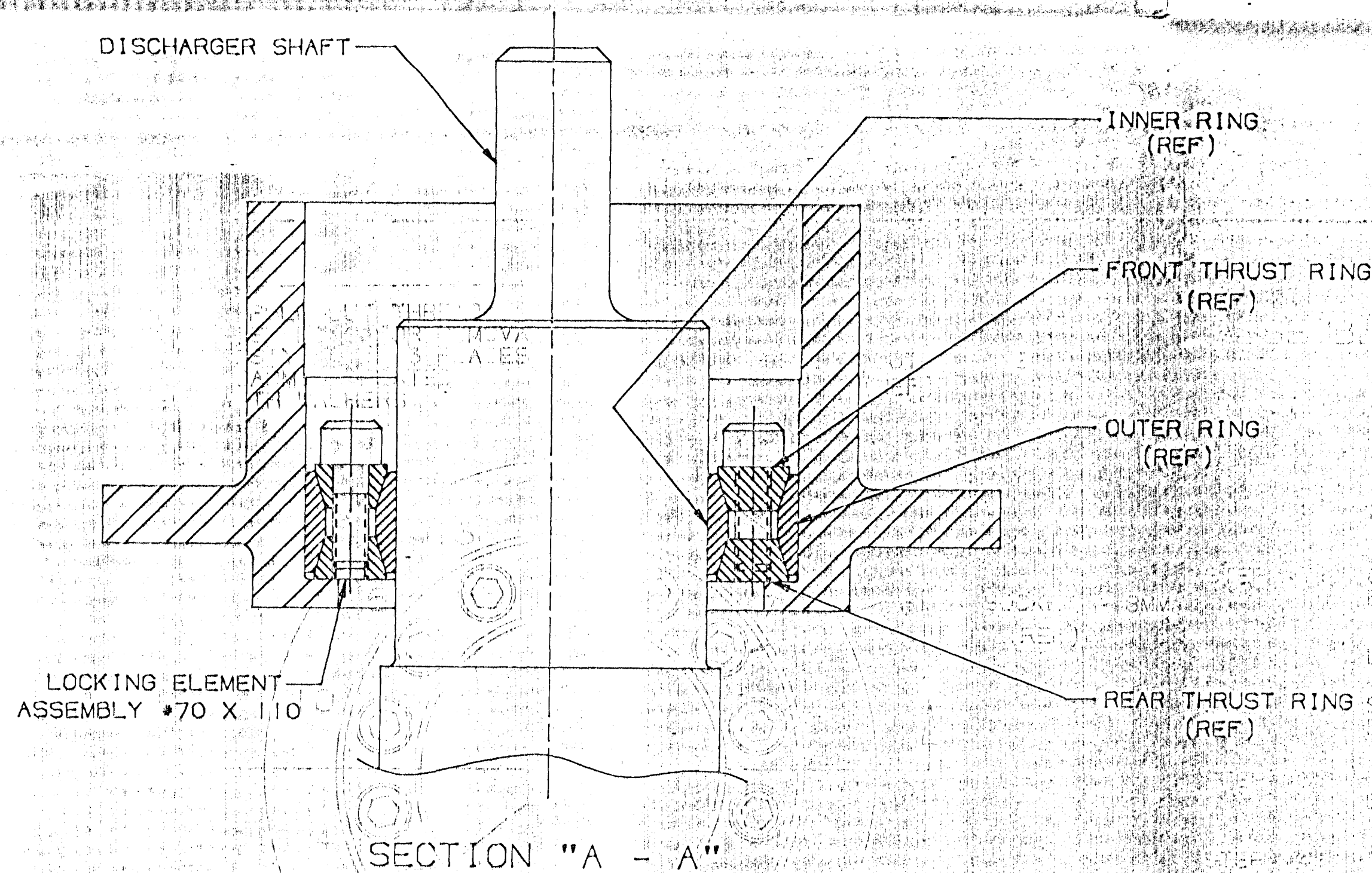


ASSEMBLY PROCEDURE FOR INSTALLING LOCKING ELEMENT

NOTE: DO NOT USE "NEVER-SEEZ" LUBRICATING COMPOUND OR ANY OTHER SIMILAR TYPE LUBRICANT CONTAINING MOLYBDENUM DISULPHIDE ON ANY THING IN THE ENTIRE PROCEDURE LISTED BELOW.

ALL PROCEDURE OPERATIONS ARE "EXTREMELY" IMPORTANT AND SHOULD BE ASSEMBLED IN THE ORDER STATED BELOW.

- STEP #1: CAREFULLY CLEAN DISCHARGER SHAFT, BLADE ASSEMBLY SUPPORT BORE AND LOCKING ELEMENT. LIGHTLY OIL PRIOR TO ASSEMBLY.
- LOCKING ELEMENT IS TO BE FITTED "USING OIL" ONLY.
- STEP #2: SLIP LOCKING ASSEMBLY ONTO SHAFT, SEAT FIRMLY IN BOTTOM OF BLADE ASSEMBLY SUPPORT BORE.
- STEP #3: TIGHTEN LOCKING SCREWS EVENLY AND IN SEVERAL STAGES FOLLOWING DIAMETRICALLY OPPOSITE SEQUENCE AS NUMBERED IN THE "TOP VIEW".
- STEP #4: TIGHTEN EACH SCREW, BY HAND, UNTIL A SLIGHT POSITIVE CONTACT IS ESTABLISHED.
- STEP #5: USING A TORQUE WRENCH, TIGHTEN SCREWS TO APPROXIMATELY HALF THE SPECIFIED TIGHTENING TORQUE (25.5 FT.LBS.) IN SEQUENCE.
- STEP #6: TIGHTEN ALL SCREWS, IN SEQUENCE AS NUMBERED TO FULL 51 FT.LBS. USING TORQUE WRENCH.
- STEP #7: RECHECK TIGHTENING TORQUE ON EACH SCREW (51 FT.LBS.) FOLLOWING SAME SEQUENCE. ASSEMBLY IS COMPLETE WHEN NO SCREW CAN BE TURNED BY THE TIGHTENING TORQUE OF 51 FT. LBS..



ASSEMBLY PROCEDURE FOR INSTALLING LOCKING ELEMENT

NOTE: DO NOT USE "NEVER-SEEZ" LUBRICATING COMPOUND OR ANY OTHER SIMILAR TYPE LUBRICANT CONTAINING MOLYBDENUM DISULPHIDE ON ANY THING IN THE ENTIRE PROCEDURE LISTED BELOW.

ALL PROCEDURE OPERATIONS ARE "EXTREMELY" IMPORTANT AND SHOULD BE ASSEMBLED IN THE ORDER STATED BELOW.

CAREFULLY CLEAN DISCHARGER SHAFT, BLADE ASSEMBLY SUPPORT BORE AND LOCKING ELEMENT. LIGHTLY OIL PRIOR TO ASSEMBLY.

LOCKING ELEMENT IS TO BE FITTED "USING OIL" ONLY.

SLIP LOCKING ASSEMBLY ONTO SHAFT, SEAT FIRMLY IN BOTTOM OF BLADE ASSEMBLY SUPPORT BORE.

TIGHTEN LOCKING SCREWS EVENLY AND IN SEVERAL STAGES FOLLOWING DIAMETRICALLY OPPOSITE SEQUENCE AS NUMBERED IN THE "TOP VIEW".

TIGHTEN EACH SCREW, BY HAND, UNTIL A SLIGHT POSITIVE CONTACT IS ESTABLISHED.

USING A TORQUE WRENCH, TIGHTEN SCREWS TO APPROXIMATELY HALF THE SPECIFIED TIGHTENING TORQUE (25.5 FT.LBS.) IN SEQUENCE.

TIGHTEN ALL SCREWS, IN SEQUENCE AS NUMBERED TO FULL 51 FT.LBS. USING TORQUE WRENCH.

RECHECK TIGHTENING TORQUE ON EACH SCREW (51 FT.LBS.) FOLLOWING SAME SEQUENCE. ASSEMBLY IS COMPLETE WHEN NO SCREW CAN BE TURNED BY THE TIGHTENING TORQUE OF 51 FT. LBS..

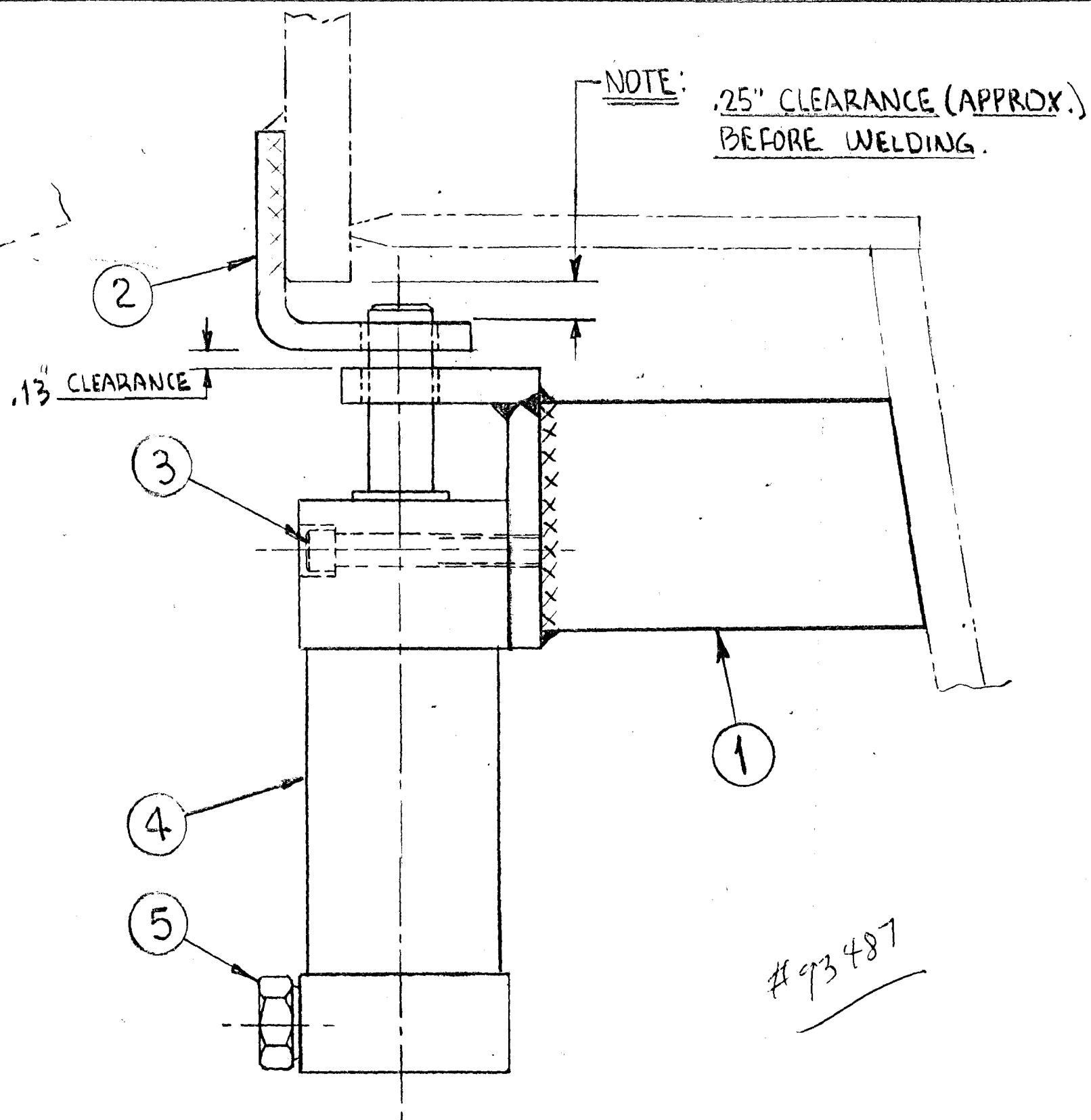
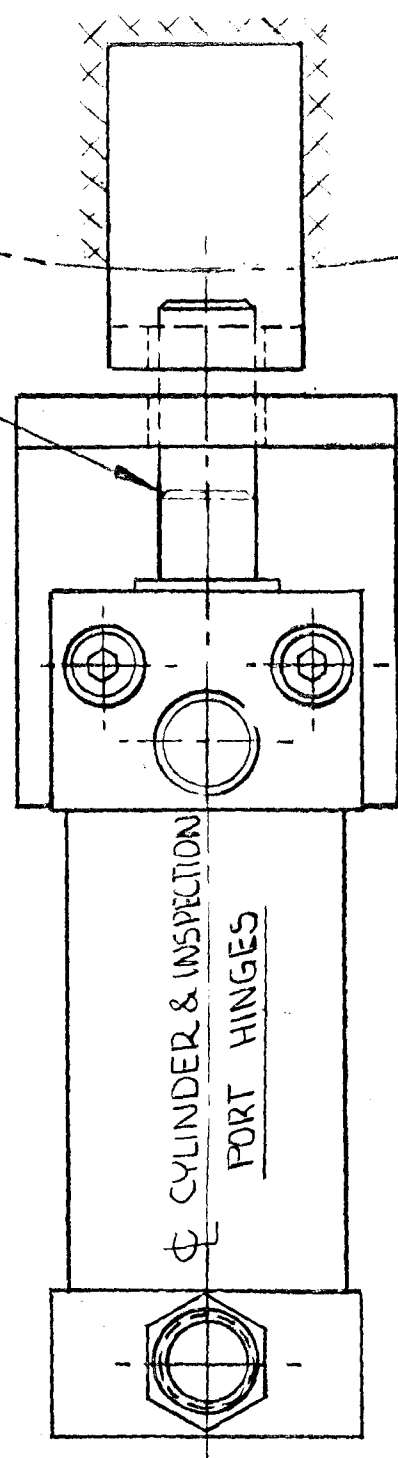
FIRST JOB		DATE		THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
MATERIAL		SCALE		UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED INCH DIMENSIONS 0.000 ± 0.000 ± 0.005 MM DIMENSIONS 0.000 ± 0.000 ± 0.005	
REPRODUCIBLE COPY ISSUED TO		DATE		TITLE	
DATE		DATE		ASSEMBLY OF LOCKING ELEMENT TO SHAFT	
FILMED		DATE		PART NO.	
12-5-89		DATE		043234	
INCHES		DATE		QWG NO.	
10THS		DATE		030-0348-01-3	

MARK	DATE	ZONE	REVISION	BY

2 TORQUE WRENCH 10THS INCHES 10THS

INCH

CYLINDER ROD IN "OPEN"
RETRACTED POSITION
MUST OPERATE FREELY AFTER
WELDING BRKT TO CURB TOP.



1	028199		BREATHER VENT - 1/4" NPT - SEE B/M LIST
1	039926		AIR CYLINDER - SEE B/M LIST
2	026649		1/4"-20NC x 1 5/8" LG. SOC. HD. CAP SCREW - STN. STL.
1		077-2763-00-2	LATCH PLATE
1		077-2762-00-2	CYLINDER MOUNTING BRACKET
QTY.	PART NO.	DRAWING NO.	DESCRIPTION

FIRST JOB 33190

MATERIAL



THE WESTERN STATES MACHINE COMPANY

HAMILTON, OHIO U.S.A.

SCALE FULL

UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED
INCH DIMENSIONS $0 \pm .020$, $.00 \pm .010$, $.000 \pm .005$
MM DIMENSIONS $0 \pm .5$, 0.0 ± 2.0 , 0.00 ± 1

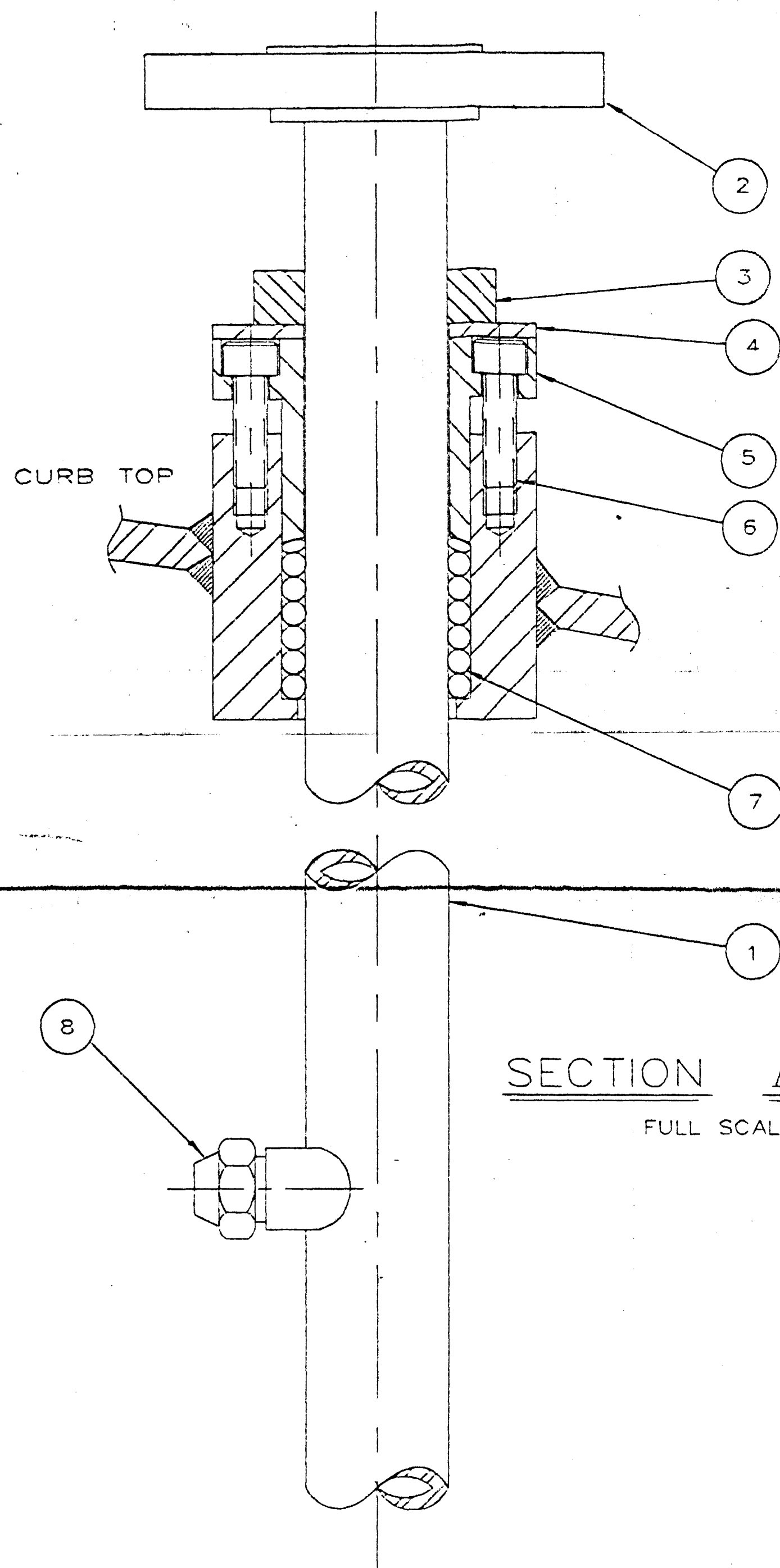
DR. Repfaffman

TITLE

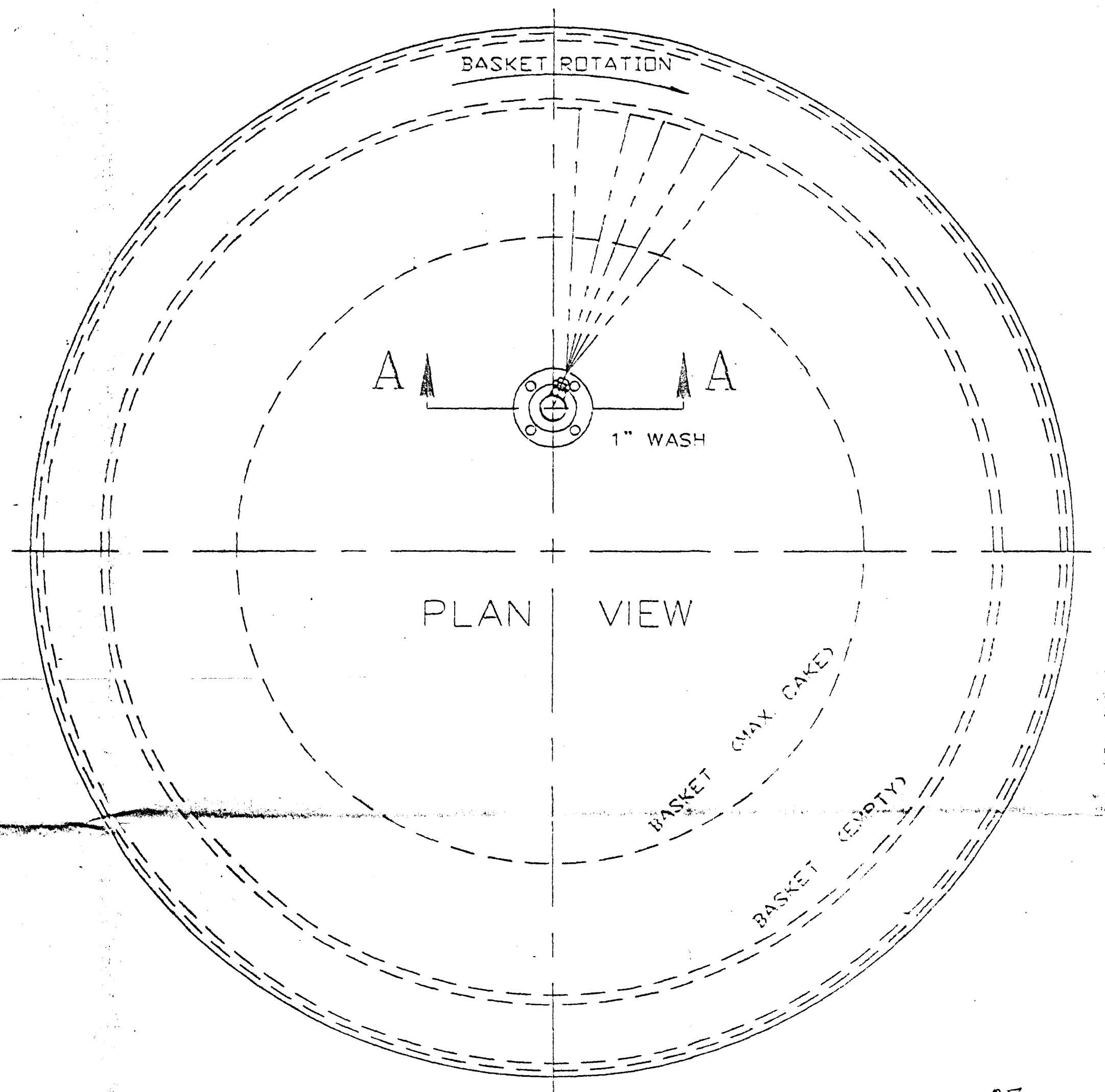
COVER SHEET

REPRODUCIBLE
COPY ISSUED TO

DATE



SECTION A-A
FULL SCALE

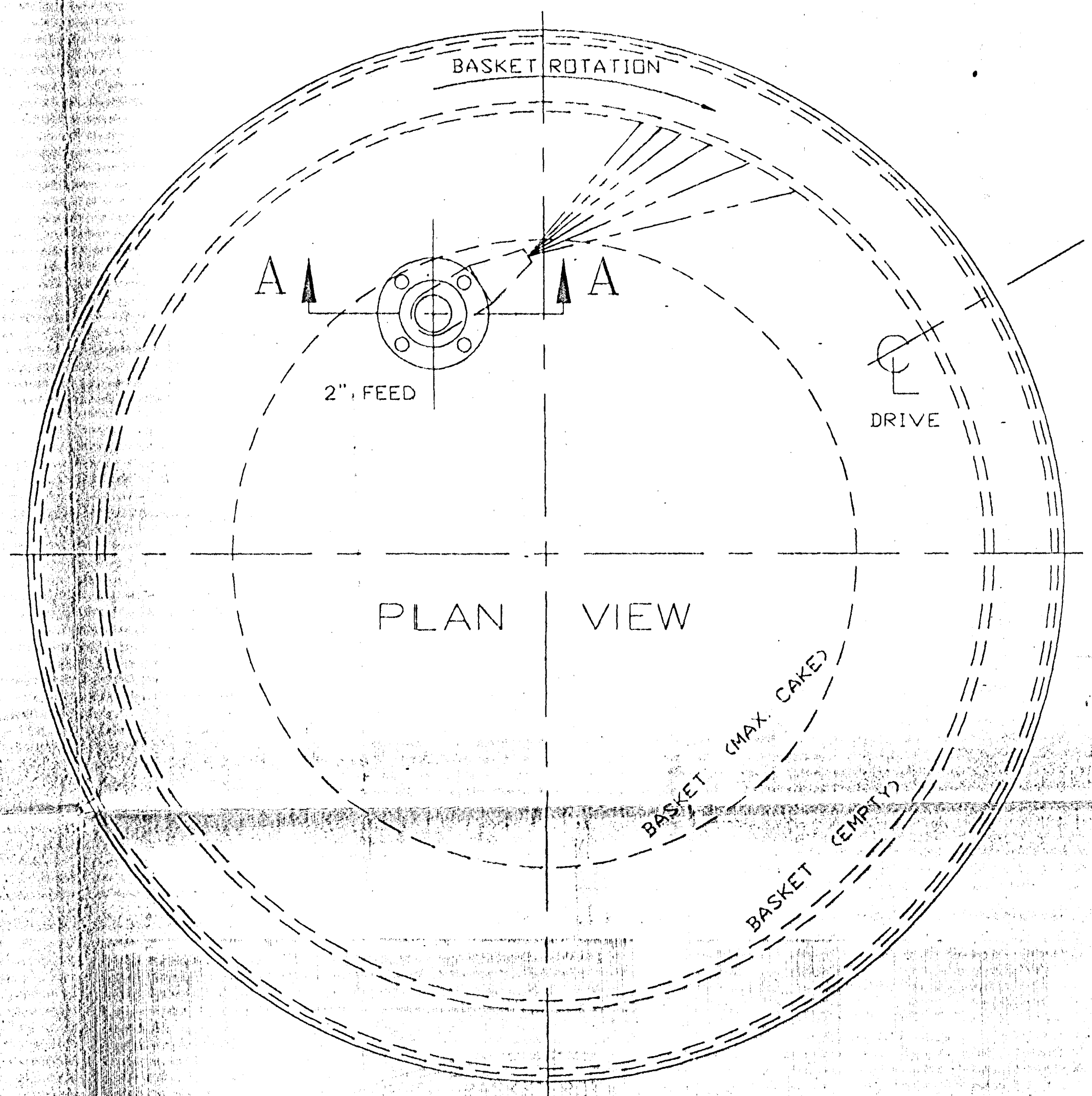
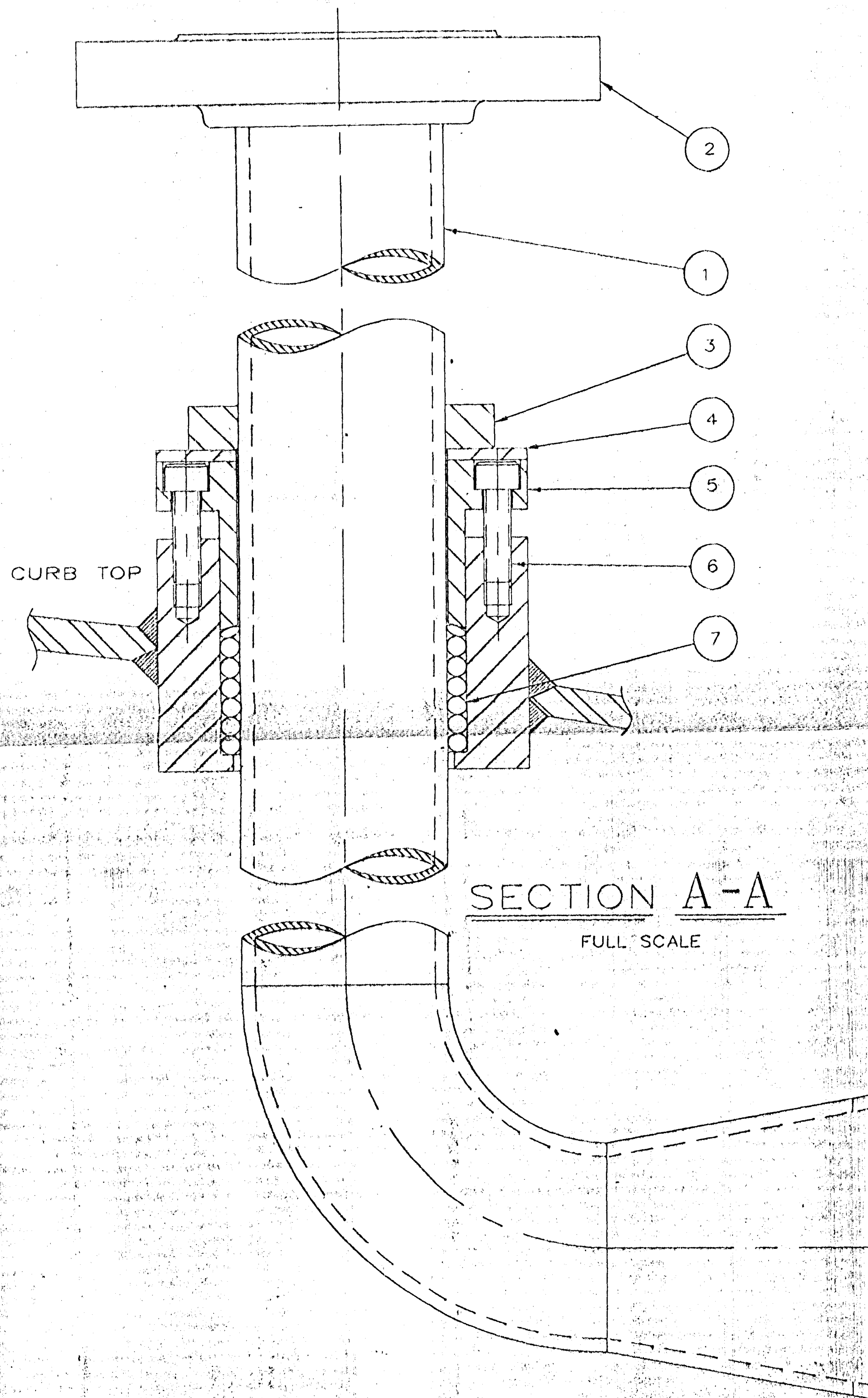


93487

ITEM	QTY	DRAWING No.	DESCRIPTION
1	1	036-0368-00-2	WASH PIPE WELDMENT
2	1		1"-150# THREADED FLANGE
3	1		CLAMP-TYPE COLLAR "STAFFORD" #21 SS
4	1	052-0422-00-2	COVER PLATE
5	1	052-0423-00-2	PACKING GLAND
6	2		SOC HD CAP SCR 5/16-18 NC X 1' LG S.S.
7	48"		"GORETEX" VALVE STEM PACKING 7/32"
8	3		SPRAY NOZZLE-1/4 NPT-(SEE B/M)

FIRST JOB 5209844		 THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
MATERIAL 316 L S.S. MC39		SCALE 1:1	UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED DIMENSIONS .000 + .010 .000 + .005
REPRODUCIBLE COPY ISSUED TO		DATE 6-29-95	TITLE 1" WASH PIPE ASSEMBLY 60" X 40"
DATE		CK GWS	DWG No. 036-0436-00-3
FILMED 7/7/95		PART No. 054637	

MARK	DATE	ZONE	REVISION	BY



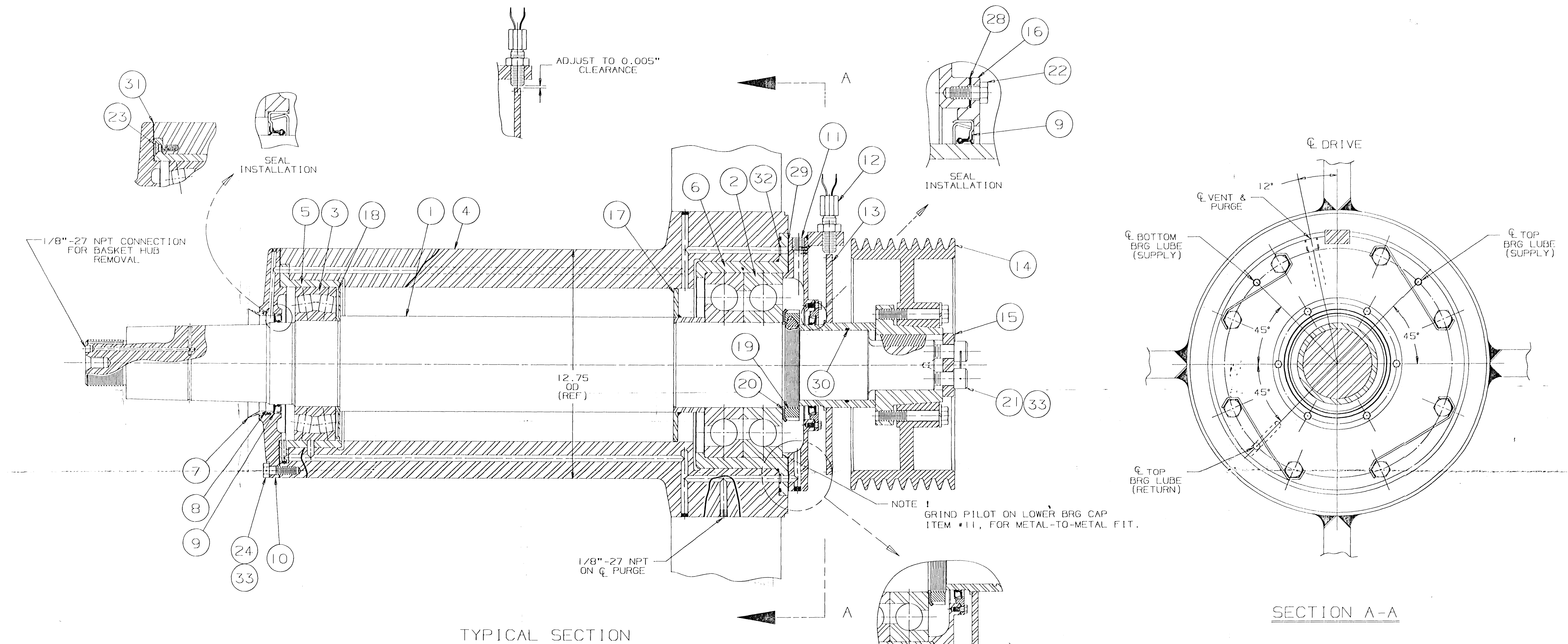
ITEM	QTY	DRAWING No.	DESCRIPTION
1	1	052-0799-00-2	FEED PIPE WELDMENT
2	1		2"-150# THREADED FLANGE
3	1		CLAMP-TYPE COLLAR "STAFFORD" #38 SS
4	1	052-0919-00-2	COVER PLATE
5	1	052-0920-00-2	PACKING GLAND
6	2		SOC HD CAP SCR 5/16-18 NC X 1" LG S.S.
7	80'		"GORETEX" VALVE STEM PACKING 7/32"

#93487

FIRST JOB 5209844		 THE WESTERN STATES MACHINE COMPANY HAMILTON, OHIO U.S.A.	
MATERIAL 316 L S.S.		SCALE 1:1	UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED INCH DIMENSIONS .00 ± .020 .000 ± .010 .000 ± .005
MC39		DR. P.K.	MM DIMENSIONS 0.0 ± .3 0.0 ± .2 0.00 ± .1
REPRODUCIBLE COPY ISSUED TO	DATE 6-29-95	DATE 6-29-95	TITLE 2" FEED PIPE ASSEMBLY 60" X 40"
		CK. GWS	PART No.
		FILMED 7/7/95	DWG No. 054638 052-0977-00-3

MARK	DATE	ZONE	REVISION	BY
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MM INCH



20	1		LOCKWASHER, BRG SKF #W-24	33	AS REQ		LOCKWIRE #18GA (0.040) STN-STL
19	1		LOCKNUT, BRG SKF #AN-24	32	3		"O"-RING #01-110 0.098"CSA x 0.38"ID x 0.56"OD
18	1	094-0795-00-2	RETAINER, GREASE, UPPER BRG	31	1	094-0995-00-2	GASKET, UPPER BRG CAP
17	1	094-0990-00-2	RETAINER, GREASE, LOWER BRG	30	1		"J"-RING #01-241 0.13"CSA x 3.88"ID x 4.13"OD
16	1	094-0068-00-2	RETAINER, SEAL	29	1	094-0994-00-2	GASKET, LOWER BRG CAP
15	1	094-0076-01-2	PLATE, SHEAVE RETAINER	28	1	094-0314-00-2	GASKET, RETAINER SEAL
14	1		SHEAVE, BASKET 14.0" DIA.	27	1		"J"-RING #01-271 0.13"CSA x 11.5"ID x 11.75"OD
13	1	094-1024-00-2	TACH GEAR -MACHINING-	26	1		"J"-RING #01-280 0.13"CSA x 14.0"ID x 14.25"OD
12	1		PICK-UP "AIRPAX" #1-0005	25	8		SCR, HEX HD CAP 5/8"-11 UNC x 2.5 LG WITH DRILLED HD
11	1	094-1022-00-3	CAP, BEARING LOWER	24	8		SCR, HEX HD CAP 3/8"-16 UNC x 1.25LG WITH DRILLED HD
10	1	094-0989-00-2	CAP, BEARING UPPER	23	8		SCR, FLT SOC HD 3/8"-16 UNC x 1.0 LG
9	2		SEAL, OIL C/R #44968	22	6		SCR, HEX HD CAP 1/4"-20 UNC x 5/8 LG WITH NYLON INSERT
8	2		PIN, SPRING "SPS" #3-1-S-125-0500	21	2		SCR, SOC HD CAP 3/4"-16 UNF x 3.0 LG WITH DRILLED HD
7	1	094-0071-00-2	SHIELD, SPINDLE				
6	1	094-0986-00-3	CARTRIDGE, BEARING LOWER				
5	1	094-0987-00-2	CARTRIDGE, BEARING UPPER				
4	REF	094-1026-00-4	HOUSING, BEARING				
3	1		BEARING, UPPER SKF #22224 CY-CC-W33				
2	2		BEARING, LOWER SKF #7324 BAGM				
1	1	094-1027-00-4	SPINDLE				
ITEM REQ	DWG NUMBER		DESCRIPTION	ITEM REQ	DWG NUMBER		DESCRIPTION

93487

"GREASE LUBRICATION"

FIRST JOB 43975		THE WESTERN STATES MACHINE COMPANY HAMILTON OHIO U.S.A.	
MATERIAL	SCALE 3/8" = 1"	UNLESS OTHERWISE NOTED STANDARD TOLERANCE ON MACHINED INCH DIMENSIONS $\pm .005$ TO $\pm .010$ 100 & OVER $\pm .005$ MM DIMENSIONS $\pm .005$ TO $\pm .010$ 250 & OVER $\pm .005$	
DATE 7-16-91	DR M.S.	TITLE HOUSING, BEARING -ASSY- (60" QUAD)	
REPRODUCIBLE COPY ISSUED TO	DATE 7-16-91	PART NO 046367	DWG NO 094-1021-00-4
CK GNS	DATE 8-22-91		
FILMED			