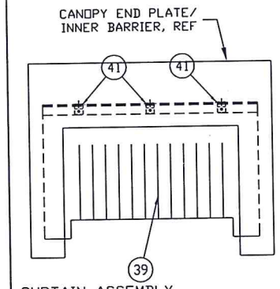
ITEM	STOELTING PN	QTY	DESCRIPTION
65	324812	1	DECAL "AquaForce" 2.5X11.5
66	324809	2	DECAL 4-1/2 X 23 STOELTING
67	324768	5	DECAL, HOT SURFACE
68	324769	4	DECAL, HOT LIQUIDS
69	324770	2	DECAL, ELECTRICAL SHOCK
70	324771	2	DECAL, WEAR EAR PROTECTION
71	324772	2	DECAL, WEAR SAFETY GLOVES
72	324773	4	DECAL, CORROSIVE MATERIAL
73	324600	2	DECAL CAUTION FINGER CRUSHER
74	324774	REF	DECAL, YELLOW ARROW TAPE
75	324775	REF	DECAL, BLUE ARROW TAPE
76	324777	REF	DECAL, GAS - YELLOW PIPE MARKER
77	324780	REF	DECAL, COMP. AIR - BLUE PIPE MARKER
78	324781	REF	DECAL, WATER - GREEN PIPE MARKER
79	324782	REF	DECAL, HOT WATER -YELLOW PIPE MARKER
80	324783	REF	DECAL, AIR - BLUE PIPE MARKER
81	6198035	1	SOUND ENCLOSURE ASSY AMB 84"WD
82	1182171	9	FRAME LEG - SOUND ENCLOSURE
83	644628	9	SCREW CAP 3/8-16 X 2-3/4 HXHD SSTL
84	6199209	1	SOUND ENCLOSURE ASSY AMB 60"WD
85	2200250-3	.	ACCESS PANEL - CLEAR LEXAN
86	1981107-1525	.	ANGLE 1X1X1/8 X 15.25"LG SSTL
87	1981107-2400	.	ANGLE 1X1X1/8 X 24.00"LG SSTL
88	482004	.	KNOB BLACK W/1/4-20 INSERT BRASS

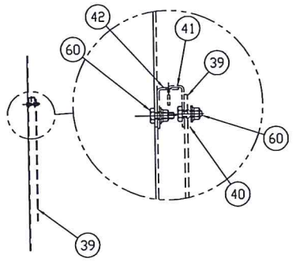
ITEM	STOELTING PN	QTY	DESCRIPTION
44	6173968-2	2	ELECTRIC HEAT OPTION - STD. HEAT
45	439065	.	HEATER IMMERSION 13KW
46	439048	10	HEATER IMMERSION 10.5KW
47	1159075	2	BLANK HEATER PLATE
48	438944	.	HEATER RADIANT 40KW 18"H 11"W
49	2150070	.	HEATER COVER
50	6182408	.	MODULAR DUCT HEATER ASSY 24"AQF
51	439112	.	HEATER MODULAR DUCT 6KW 480V
52	2182398	.	BLANK HEATER PLATE - MOD. DUCT
53	6173967	2	CLEAN OUT PLATE
54	2134778-1	2	GASKET EPDM
55	1171328	.	4" FLANGE PORT CAP
56	2182514-1	4	STEAM DEFLECTOR - 24"AQF
57	716042	REF	STUD WELD 1/4-20 X 1/2 CD SSTL
58	584061	1	PLUG PIPE 1"NPT SSTL
59	584045	2	PLUG PIPE 3/4"NPT SSTL
60	644116	60	SCREW CAP 1/4-20 X 3/4 HXHD SSTL
61	647886	6	SCREW MACH 1/4-20 X 1/2 TRS HD SSTL
62	644555	48	SCREW CAP 3/8-16 X 1-1/4 HXHD SSTL
63	644523	32	SCREW CAP 3/8-16 X 3/4 HXHD SSTL
64	644131	36	SCREW CAP 1/4-20 X 1 HX HD SSTL

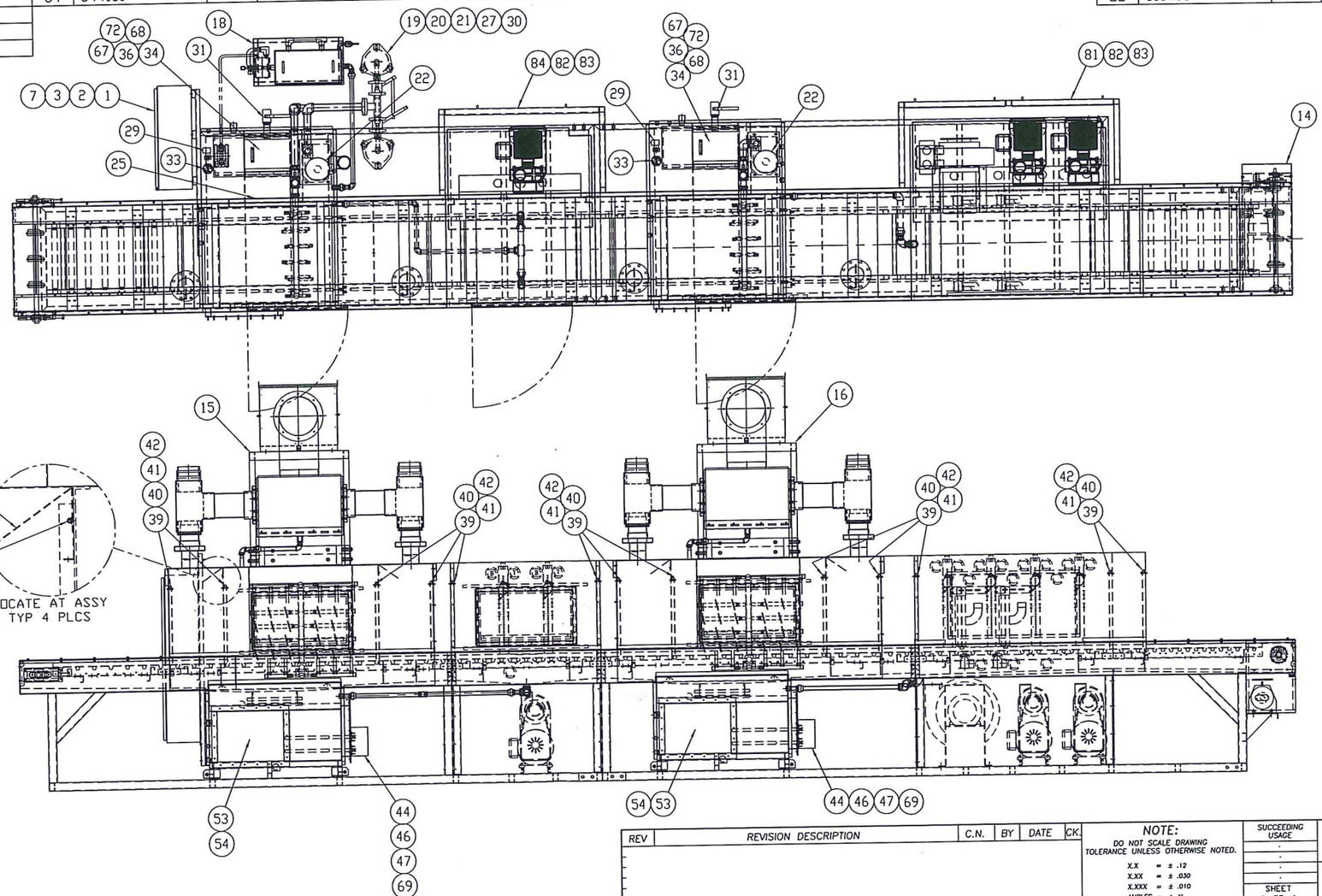
ITEM	STOELTING PN	QTY	DESCRIPTION
23	4158391	REF	CANOPY DOOR WELDM'T - 38 X 20
24	4158602	.	CANOPY DOOR WELDM'T - 20 X 20
25	6174844	1	CHEMICAL PUMP OPTION
26	6174065	.	OIL SKIMMER OPTION
27	402088	2	GAUGE PRESSURE 1/4NPT 0-200PSI
28	763162	.	VALVE SOLENOID 3/4" NPT S'STL
29	763113	2	VALVE SOLENOID 3/4" NPT
30	402087	4	GAUGE PRESSURE 1/4 NPT 0-60PSI
31	762173	2	VALVE BALL 2" NPT BRONZE
32	762156	.	VALVE BALL 2" NPT S'STL
33	296168	2	CONTROL LIQUID LEVEL
34	6174845	2	CHIP BASKET
35	6174551	.	CHIP BASKET
36	2174061	2	COVER WASH TANK
37	2174062	.	COVER RINSE TANK
38	1174697	.	COVER PLATE - NO SKIMMER
39	2181401	13	CURTAIN UPPER RUBBER SPECIAL
40	1173998	13	CURTAIN FLAT - UPPER
41	1158667	39	CURTAIN CLIP
42	1186371-1	13	CURTAIN MOUNTING ANGLE AQF 24"
43	2198144	.	CANOPY SPLICE PLATE

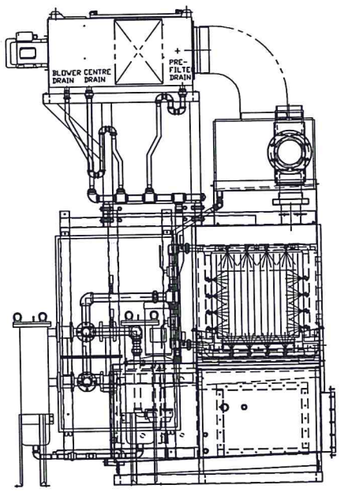
ITEM	STOELTING PN	QTY	DESCRIPTION
1	6161995-9700	1	ELECTRICAL CONDUIT ASSY
2	6161995-9800	1	ELECTRICAL PANEL ASSY
3	6161995-9900	0	ELECTRICAL SCHEMATIC
4	6161995-9990	0	FLOOR PLAN
5	SEE SHEET 2	REF	FINAL ASSY - CONV/DRIVE ASSY
6	SEE SHEET 3	REF	FINAL ASSY - CANOPY DOOR ASSEMBLY
7	SEE SHEET 4	REF	FINAL ASSY - ELEC. ENCLOSURE ASSY
8	.	.	.
9	6161995-0200	1	FRAME TANK CONVEYOR BASE ASSY
10	6161995-0300	1	INTERNAL CONVEYOR RAIL ASSEMBLY
11	6161995-0400	1	CANOPY/PIPING ASSY - WASH/RINSE
12	6161995-0500	1	AMBIENT BLOWOFF CANOPY ASSY
13	6161995-0600	1	AMBIENT BLOWOFF AIR KNIFE/BLOWER ASSY
14	6161995-1100	1	DRIVE ASSEMBLY
15	6161995-1300	1	MIST COLLECTOR ASSEMBLY - WASH
16	6161995-1301	1	MIST COLLECTOR ASSEMBLY - RINSE
17	6161995-1700	1	CLADDING ASSEMBLY M#1995
18	6161995-2200	1	OIL COALESCOR OPTION - AIR PUMP
19	6161995-2400	1	FILTRATION PIPING ASSY - WASH/RINSE
20	368463	1	FILTER DUPLEX MODEL 8-30 FTI SSTL
21	368168-100	2	FILTER BAG - 100 MICRON - W/SSTL RING
22	6184064	2	PUMP ASSY PIPING - 7.5 HP PAINTED

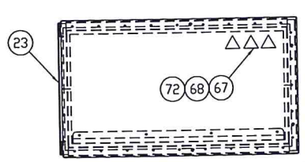


CURTAIN ASSEMBLY
TYPICAL 13 PLACES









DOOR DECAL LAYOUT - WETTED STAGES

REV	REVISION DESCRIPTION	C.N.	BY	DATE	CK.

NOTE:
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X.XX = ± .030
X.XXX = ± .010
ANGLES = ± 1°

SUCCEEDING USAGE

SHEET 1 OF 4

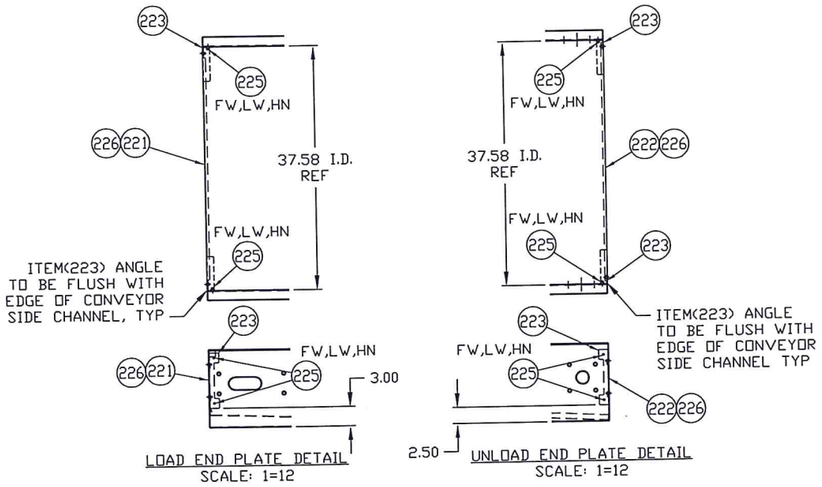
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STOELTING
KIEL, WISCONSIN 53042

TITLE: FINAL ASSEMBLY M#1995
AQF-224 WASH-AMB-RINSE-AMBIENT BLOWOFF

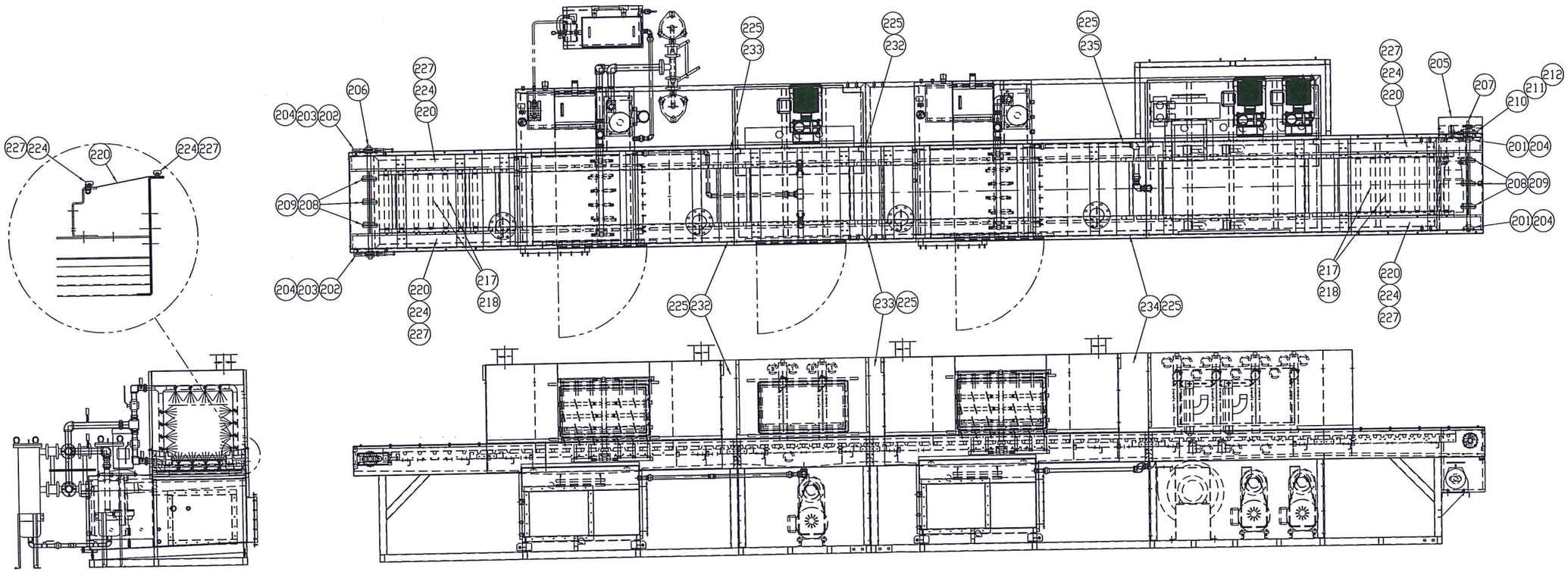
MATERIAL OR SOURCE

PRODUCT AQUAFORCE
AUTOCAD NO. 6161995$1
PRODUCT CODE 38
PART NO. 6161995
DATE 11-6-13
DWG BY JS
DWG NO. 6161995
REV 1
SCALE 1=24
CHK BY .



ITEM	STOELTING PN	QTY	DESCRIPTION
220	2189950-9	4	GUARD COVER - LOAD/UNLOAD 54"LG
221	2189971-1	1	CONVEYOR END PLATE - LOAD
222	2189971-2	1	CONVEYOR END PLATE - UNLOAD
223	1189972	4	CONVEYOR END PLATE ANGLE
224	716044	REF	STUD WELD 1/4-20 X 3/8 CD SSTL
225	716042	REF	STUD WELD 1/4-20 X 1/2 CD SSTL
226	647886	REF	SCREW MACH 1/4-20 X 1/2 TRS HD SSTL
⚠ 227	538030	36	NUT, CAP 1/4-20 S'STL
228	714038	60IN	STRIP EDGE PROTECTOR
229	647695	REF	SCREW MACH #10-24 X 3/4 FLHD SSTL
230	647886	REF	SCREW MACH 1/4-20 X 1/2 TRS HD SSTL
231	644306	REF	SCREW CAP 5/16-18 X 3/4 HXHD SSTL
232	2184333-5	2	CANOPY SPLASH COVER 6" GAP
233	2184333-6	2	CANOPY SPLASH COVER 6" GAP
234	2184333-7	1	CANOPY SPLASH COVER 12" GAP
235	2184333-8	1	CANOPY SPLASH COVER 12" GAP

ITEM	STOELTING PN	QTY	DESCRIPTION
201	1198368-1	2	BEARING FLANGE 1-1/2"SHAFT DIA PAINTED
202	1198368-3	2	FRAME SIDE MOUNTING PAINTED
203	1198368-4	2	TIGHTENER TAKE-UP 1-1/2" BORE PAINTED
204	645026	16	SCREW CAP 1/2-13 X 1-1/2 HXHD SSTL
205	6161995-1100	REF	DRIVE ASSEMBLY
206	2199025	1	IDLER SHAFT 1-1/2" DIA
207	2199026	1	DRIVE SHAFT 1-1/2" DIA
208	696517	6	SPROCKET BELT18T 1-1/2" BORE SSTL
209	1981454-0300	6	KEYSTOCK, 3/8X3/8X3.00 S'STL.
210	742026	1	TORQUE LIMITER MODEL 500
211	742026-1	1	SPROCKET CHAIN 5/8P 40T FOR TL
212	1981454-0125	1	KEYSTOCK, 3/8X3/8 X 1.25"LG S'STL.
213	716042	REF	STUD WELD 1/4-20 X 1/2 CD SSTL
214	1159906-3	REF	PROX SWITCH MOUNTING BRACKET
215	697216	REF	SPROCKET, CHAIN 5/8"PITCH 20T
216	153125	80FT	BELTING FALCON 24"WD RED NYLON GLASS
217	2158560-0024	73	24" CONVEYOR ROLLER ASSY
218	1158559	146	ROLLER BUSHING ASSY - PLASTIC
219	2179526	4	BELT GUARD - CE



REV	REVISION DESCRIPTION	C.N.	BY	DATE	CK.
1	IT 227 #538030 (36) WAS 482004 (36)	CUST	MC	3-18-14	

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X.XX = ± .030
X.XXX = ± .010
ANGLES = ± 1°

SUCCEEDING USAGE

SHEET 2 OF 4

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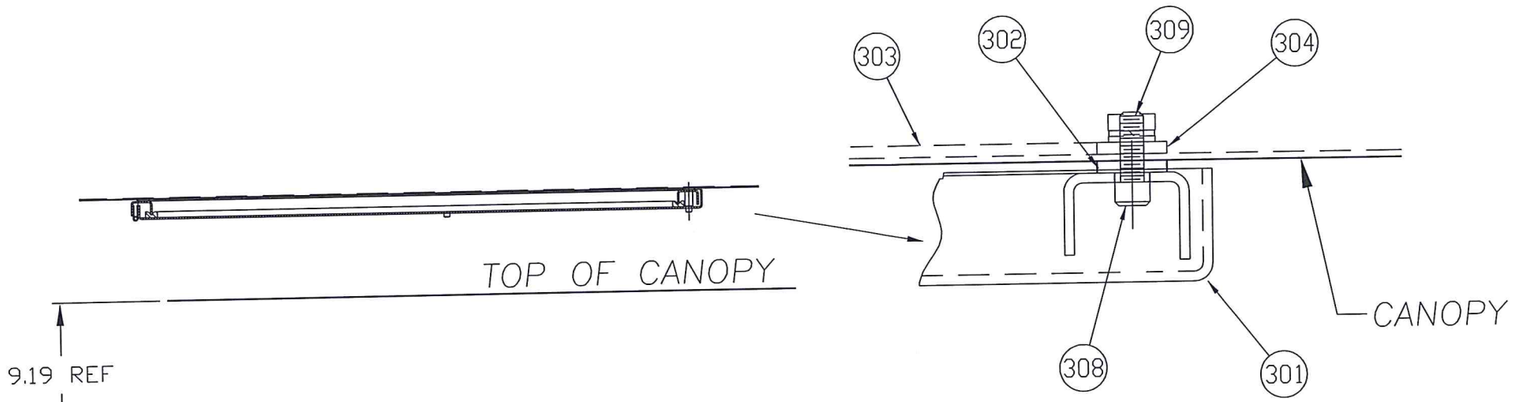
STOELTING
KIEL, WISCONSIN 53042

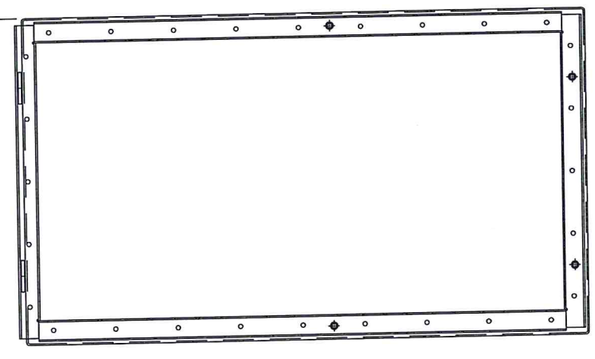
TITLE: FINAL ASSEMBLY M#1995
AQF-224 WASH-AMB-RINSE-AMBIENT BLOWOFF

MATERIAL OR SOURCE: LOAD/UNLOAD ASSEMBLY

PRODUCT AQUAFORCE
AUTOCAD NO. 6161995$2
PRODUCT CODE 38
PART NO. 6161995
DATE 11-6-13 DWG BY JS
SCALE 1=24 CHK BY .
DWG NO. 6161995
REV 1

ITEM	STOELTING PN	QTY	DESCRIPTION
301	4158391	3	CANOPY DOOR WELDMENT
302	2152767	3	GASKET, DOOR
303	2152488	6	FLAT, DOOR S'STL
304	2152489	6	FLAT, DOOR S'STL
305	4158602	·	CANOPY DOOR WELDMENT
306	2154027	·	GASKET, DOOR
307	2154026	·	FLAT, DOOR S'STL.
308	644134	84	SCREW CAP 1/4-20 X 1 SOC BTN
309	M002468	0	SILICONE





CANOPY DOOR DETAIL ASSEMBLY

38 X 20 DOOR
TYP 3 PLACES

REV	REVISION DESCRIPTION	C.N.	BY	DATE	CK.

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X.XX = ± .030
X.XXX = ± .010
ANGLES = ± 1°

SUCCEEDING USAGE
·
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·
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SHEET 3 OF 4

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TITLE FINAL ASSEMBLY #1995
CANOPY DOOR ASSEMBLY

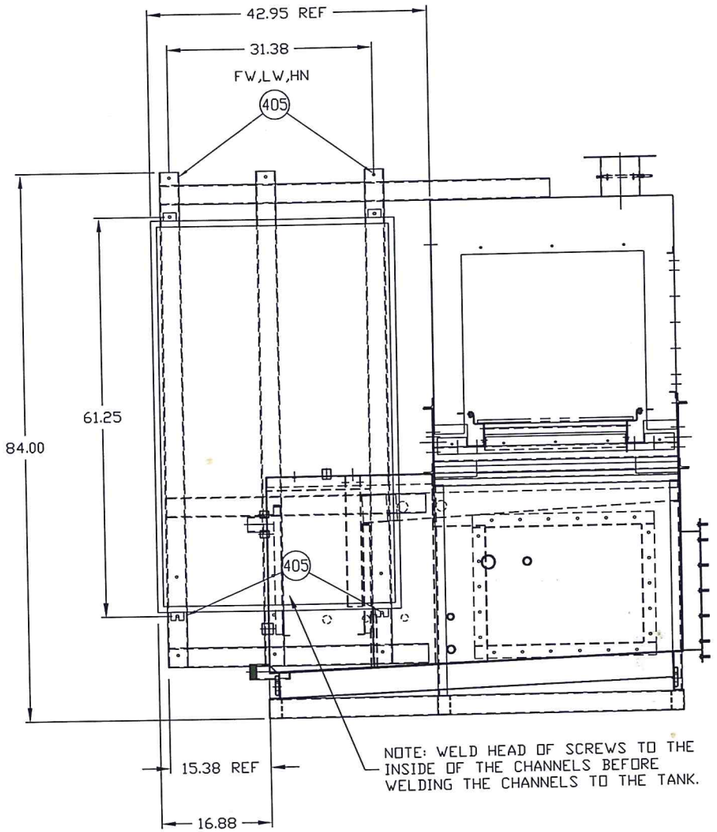
MATERIAL OR SOURCE
·
·

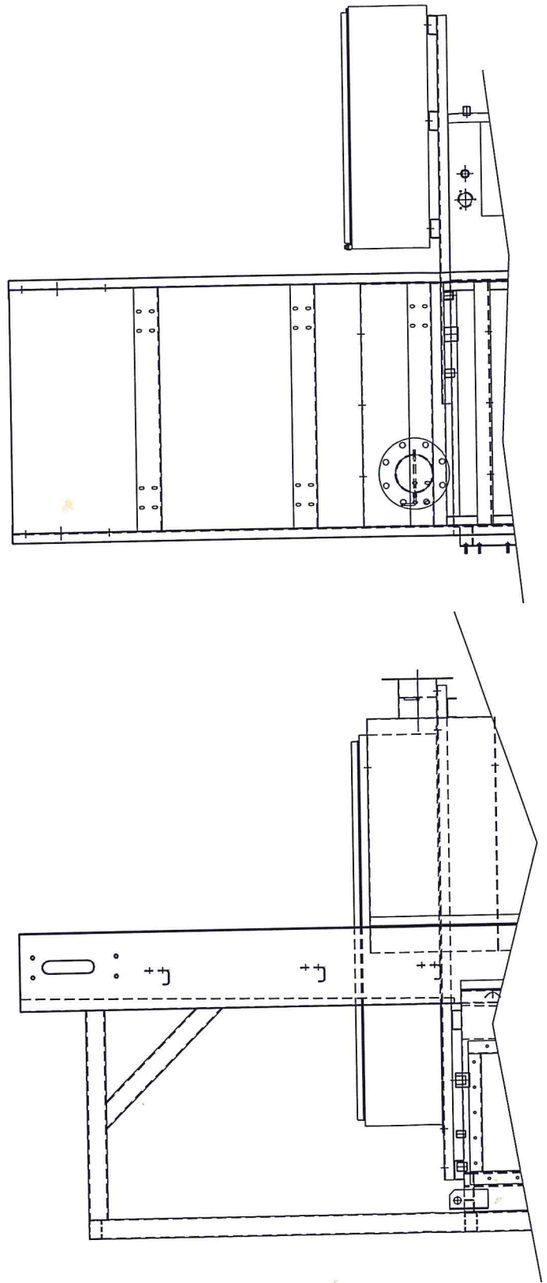
PRODUCT AQUAFORCE
AUTOCAD NO. 6161995$3
PRODUCT CODE 38
PART NO. 6161995
DATE 11-6-13
DWG BY JS
SCALE 1=5
CHK BY ·
DWG NO. 6161995
REV 1

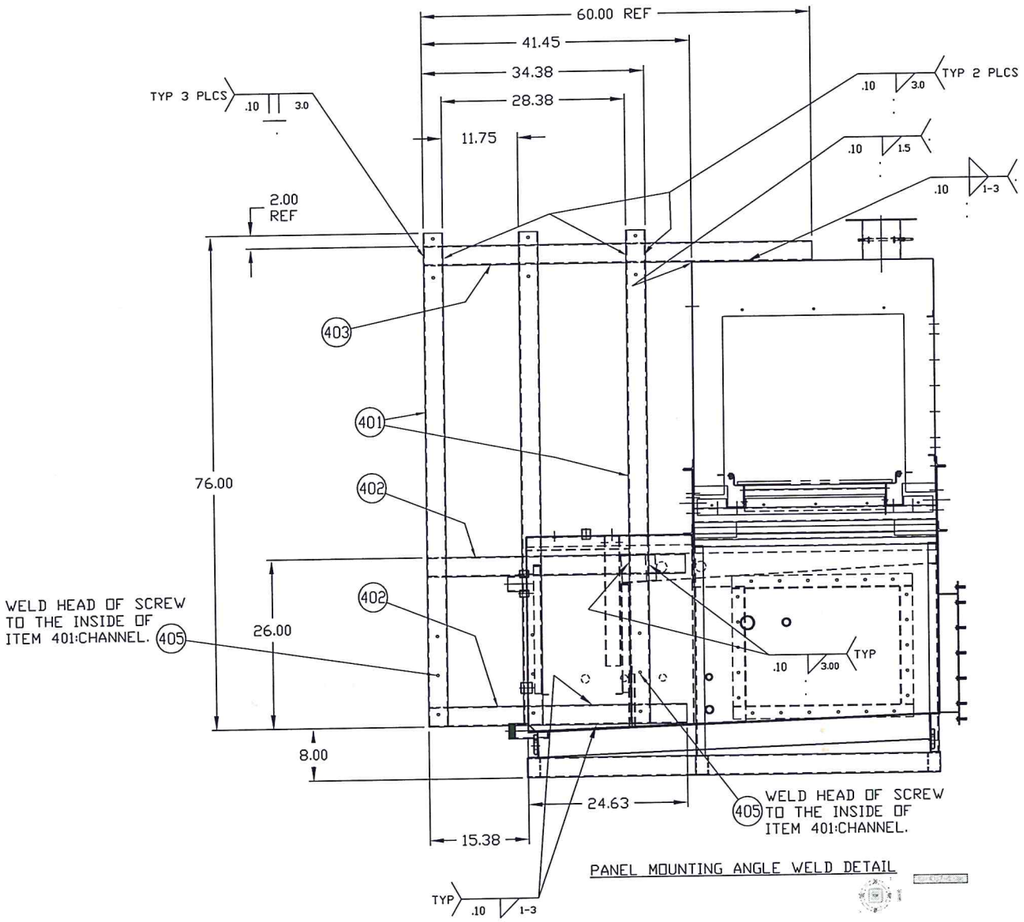
ITEM	STOELTING PN	QTY	DESCRIPTION
401	6185964-37	3	PANEL MOUNTING CHANNEL - 76" LG
402	6185964-5	2	PANEL MOUNTING CHANNEL - 40.00"LG
403	6185964-2	1	PANEL MOUNTING CHANNEL - 60.00"LG
404	SEE PANEL ASSY	REF	ENCLOSURE 60X38X12
405	644523	4	SCREW CAP 3/8-16 X 3/4 HXHD S'STL

NOTES

1. USE TOOL T-6670 TO SET PANEL MOUNT SPACING.







PANEL MOUNTING ANGLE WELD DETAIL

REV	REVISION DESCRIPTION	C.N.	BY	DATE	CK

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X.XXX = ± .010
ANGLES = ± 1°

SUCCEEDING USAGE

SHEET 4 OF 4

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KIEL WISCONSIN 53042

TITLE FINAL ASSEMBLY M#1995
ELECTRICAL PANEL MOUNTING

MATERIAL OR SOURCE

PRODUCT AQUAFORCE
AUTOCAD NO. 6161995S4
PRODUCT CODE 38
PART NO. 6161995
DATE 11-6-13
DWG BY JS
DWG NO. 6161995
REV 1
SCALE 1=12
CHK BY

ELECTRICAL

460V/60HZ/3PH

ELECTRICAL SCHEMATIC #6161995-9900

UTILITIES

INCOMING WATER

NOMINAL: 40PSI

MAXIMUM: 125PSI

NOTE: SOFT WATER RECOMMENDED

CONSTRUCTION

COMMON FRAMES: 11 GA. PAINTED STEEL TUBING
FRAMES: 10 GA. STAINLESS STEEL
TANKS: 12GA STAINLESS STEEL
CANOPIES: 14GA STAINLESS STEEL
CHIP BASKET: STAINLESS STEEL
PIPING: STAINLESS STEEL
SPRAY TUBES: STAINLESS STEEL
SPRAY NOZZLES: STAINLESS STEEL
FILTER CANISTER: STAINLESS STEEL
FILTER BAG: 100 MICRON
AMBIENT CONSTRUCTION: STAINLESS STEEL
BLOWER: PAINTED CARBON STEEL

CANOPY VENTING

NUTECH TFP-ELIMINATOR MODEL ME2500XCR
2500 CFM RATING
5 HP 230/460 3PH 60 HZ
DAMPER CONTROLLED VENT PORTS ON CANOPY

CONVEYOR ASSEMBLY

GEAR MOTOR: 3/4HP, 90 VDC
24" WIDE NYLON GLASS BELTING
STAINLESS STEEL ROLLERS ON 6" CENTERS
1-1/2" NOMINAL SHAFT SIZE
REMOTE START/STOP BUTTOMS AT UNLOAD END.
EMERGENCY STOP BUTTONS AT EACH END.

PUMP/SPRAY SPECIFICATION

WASH STAGE - 7.5 HP VERTICAL PUMP
RINSE STAGE: 7.5 HP VERTICAL PUMP
PAINTED STAINLESS STEEL FITTED PUMPS
STAINLESS STEEL PIPING AND NOZZLES
1/4"NPT FIXED NOZZLES

WASH STAGE FILTRATION

FILTER TECH MODEL D-830 DUPLEX FILTER
WITH MANUAL SWITCH-OVER VALVE
STAINLESS STEEL CONSTRUCTION
100 MICRON RATED FILTER BAG
WITH FILTER CLOGGED INDICATOR SWITCH

OIL COALESCOR OPTION - WASH STAGE

HYDE MODEL CF-1/2-A-SS
CROSS FLOW SEPARATOR
W/ PNEUMATIC AIR PUMP
STAINLESS STEEL CONSTRUCTION
2 GPM OIL PICK-UP RATING

CHEMICAL INJECTION - WASH

FLUID METERING MODEL QD-2CSC
18.9 GPH @ 2 PSIG MAXIMUM DISPLACEMENT
CERAMIC LINER W/STAINLESS BODY
3/8" DIA HOSE
FILL TO FULL MAKE-UP: 26 GAL.

TANK/CANOPY INSULATION OPTION

VERTICAL SIDES ONLY
1" THICK THERMALLY EFFICIENT INSULATION
W/18 GA. STAINLESS STEEL CLADDING

AMBIENT BLOWOFF #1 CONSTRUCTION

2 UPPER AIR KNIVES - 20HP BLOWER

AMBIENT BLOWOFF #2 CONSTRUCTION

4 UPPER AIR KNIVES - 2 - 20HP BLOWERS
2 FRONT/2 REAR SIDE KNIVES/
2 BOTTOM AIR KNIVES - 10HP BLOWER

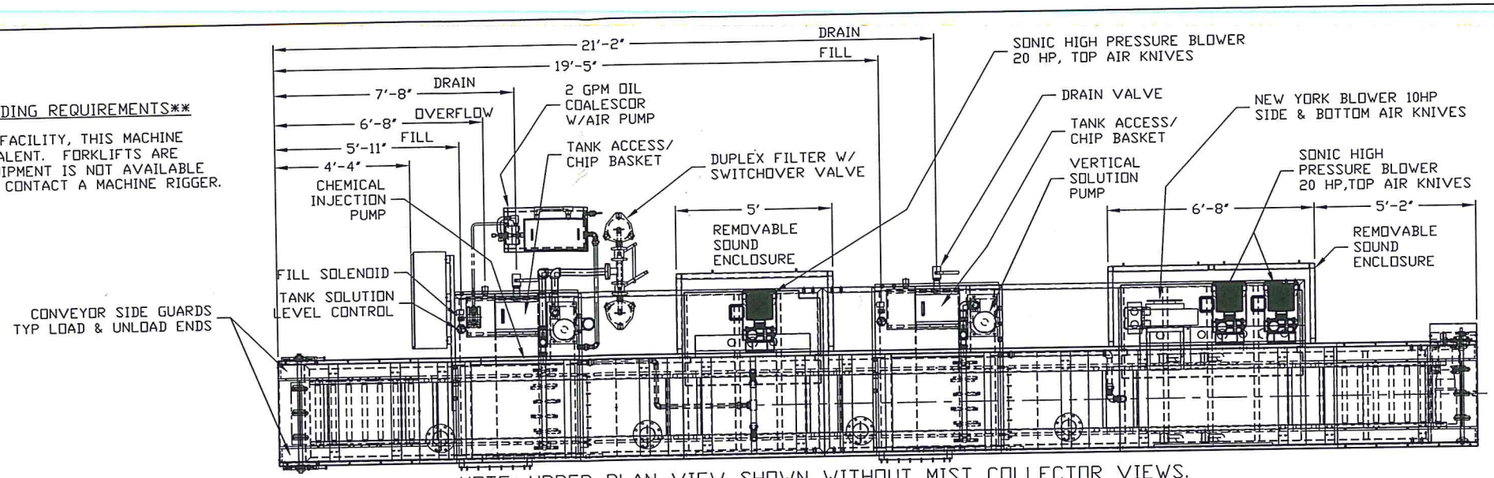
LIFTING INSTRUCTIONS

* - LIFTING POINTS

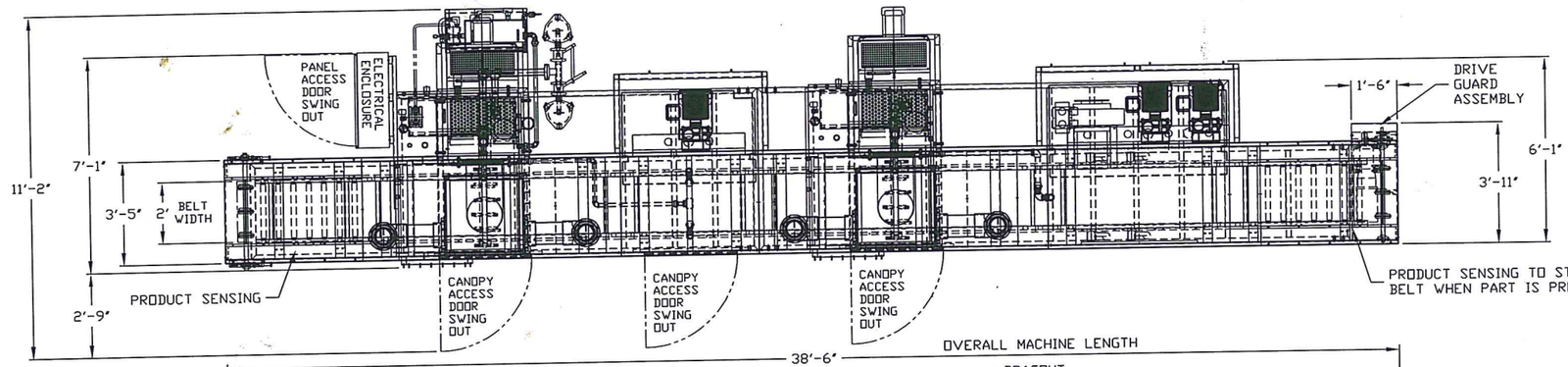
LIFT MACHINE USING CHAIN AT INDICATED LIFTING POINTS WITH SPREADER BAR TO PREVENT DAMAGE TO MACHINE.

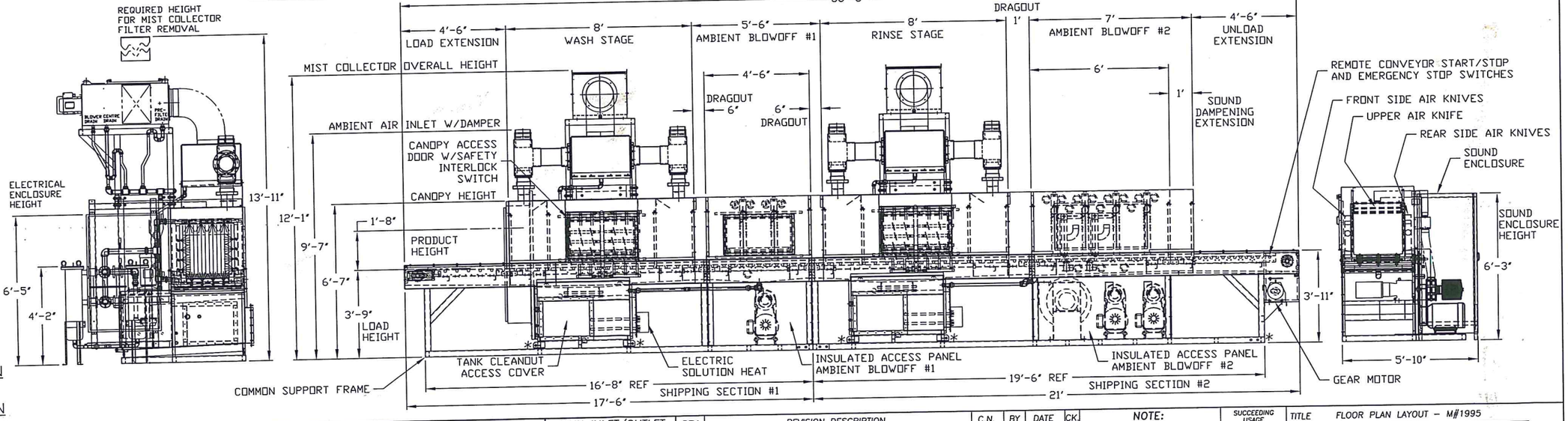
****MACHINE HANDLING/UNLOADING REQUIREMENTS****

FOR HANDLING AT CUSTOMERS FACILITY, THIS MACHINE REQUIRES A CRANE OR EQUIVALENT. FORKLIFTS ARE NOT RECOMMENDED. IF SUCH EQUIPMENT IS NOT AVAILABLE IN YOUR PLANT, YOU MAY NEED TO CONTACT A MACHINE RIGGER.



NOTE: UPPER PLAN VIEW SHOWN WITHOUT MIST COLLECTOR VIEWS.





	TANK CAP	PUMP/BLOWER			HEAT			TANK INLET/OUTLET		
	GALLONS	GPM/CFM	THD/SP	HP	TEMP	TYPE	KW-BTU/HR	FILL	O'FLOW	DRAIN
WASH	300GAL	120GPM	70'HD	7.5HP	140°	ELEC.	52.5 KW	3/4"NPT	2"NPT	2"NPT
BLOWER1	-----	500CFM	30"SP	20HP	AMB	-----	-----	-----	-----	-----
RINSE	300GAL	120GPM	70'HD	7.5HP	130°	ELEC.	52.5 KW	3/4"NPT	2"NPT	2"NPT
BLOWER2	-----	1200CFM	25"SP	10HP	AMB	-----	-----	-----	-----	-----
BLOWER3	-----	500CFM	30"SP	20HP	AMB	-----	-----	-----	-----	-----
BLOWER4	-----	500CFM	30"SP	20HP	AMB	-----	-----	-----	-----	-----
-----	-----	-----	-----	-----	-----	-----	-----	-----	-----	-----

REV	REVISION DESCRIPTION	C.N.	BY	DATE	CK.

DESIGN REVIEW & APPROVAL DRAWING
DIMENSIONS AND OBJECT LOCATIONS MAY VARY SLIGHTLY AS CONSTRUCTION WARRANTS
PLEASE INDICATE CRITICAL AREAS

COMPANY NAME _____

APPROVED BY _____

TITLE _____ DATE _____

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X.XX = ± .030
X.XXX = ± .010
ANGLES = ± 1°

SUCCEEDING USAGE

SHEET 1 OF 1

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STOELTING
KIEL, WISCONSIN 53042

TITLE FLOOR PLAN LAYOUT - M#1995
AOF-224 WASH-AMB-RINSE-AMBIENT BLOWOFF

MATERIAL OR SOURCE
PACE INDUSTRIES
GRAFTON, WI

PRODUCT AQUAFORCE
AUTOCAD NO. 6161995-9990

PRODUCT CODE 38
PART NO. 6161995-9990

DATE 11-8-13 DWG BY JS
SCALE 1=30 CHK BY .
DWG NO. 6161995-9990 REV 0

EACH HEATED STAGE

ITEM	STOELTING PN	QTY	DESCRIPTION
47	772112	150	WIRE 12AWG BLK
48	772136	0	WIRE 10AWG BLACK
49	772170	60	WIRE 8AWG BLACK
50	772206	100	WIRE 6AWG BLACK TGGT
51	772232	0	WIRE 4AWG BLACK
52	772200	120	WIRE, 6AWG BLACK
54	221374	0	BUSHING, 1/8 x 1/2
55	20030-14	2	RTD 100 OHM 36" LEADS
56	369261	2	FITTING 1/8" TUBE X ¼" MNPT
57	221221	1	BUSHING, 3/4 x 1/2
58	672642	0	PROBE, THERMOCOUPLE UNGRND 15" DRYER
59	556589	1	PANEL, SUB 8X8
60	346330	REF	ENCLOSURE, 8x8x4 J. BOX MILD STEEL
61	346554	REF	ENCLOSURE, P.B. 1 POSITION
62	346567	REF	ENCLOSURE, P.B. 3 POSITION
63	718712	1	SWITCH, PRESSURE DIFFERENTIAL
64	2175449	.	BRACKET, E-STOP STATION, CANOPY
65	2175449-1	2	BRACKET, E-STOP STATION, EXTENSIONS
66	2175449-2	0	BRACKET, 3POS. STATION, CANOPY
67	2175449-3	1	BRACKET, 3POS. STATION, EXTENSIONS
68	718375	3	SWITCH, PB RED MUSH. HEAD PUSH/PULL
69	528239	3	N.P. EMERGENCY STOP 800T
1 70	1185197-2	4	MOUNTING ANGLE - ALL DOORS
71	1110825-2195	1	N.P. CONVEYOR STOP
72	1110825-1239	1	N.P. CONVEYOR START
73	718345	1	SWITCH, PB RED EXTENDED 1NC
74	719117	1	SWITCH, PB GREEN ILLUMINATED LED 120V
1 75	346716	1	ENCPDER, 200PPR 5-30VDC
1 76	2180997	4	PHOTO-EYE BRACKET
77	346707	.	ENCODER, 600PPR 5VDC
78	672661	1	SWITCH, PROXIMITY 3 WIRE DC
79	1159906	.	BRACKET, SWITCH MOUNTING
80	324664	5	DECAL, LIGHTNING BOLT WARNING
1 81	672775	2	PHOTO-EYE, EMITTER BANNER QC 10-30VDC
1 82	672776	2	PHOTO-EYE, RECEIVER BANNER QC 10-30DC
1 83	229128	4	CABLE, QC 4-PIN EURO STYLE
1 84	718975	4	SWITCH, FLATPACK WITH KEY 2NC
1 85	1185197-3	4	NON-FLUSH DOOR MOUNTING ANGLE
1 86	1185197-1	4	FLUSH DOOR MOUNTING SPACER
87	772046	500	WIRE, 16 AWG BLUE
88	772088	100	WIRE, 16 AWG BLUE/WHITE

ITEM	STOELTING PN	QTY	DESCRIPTION
1	6161995-9900	REF	ELECTRICAL SCHEMATIC
2			
3	288004	240	CONDUIT 1/2" EMT
4	288006	60	CONDUIT 3/4" EMT
5	288010	120	CONDUIT 1" EMT
6	288013	120	CONDUIT 1-1/2" EMT
7	.	.	.
8	.	.	.
9	288030	120	CONDUIT 1/2" SEALTIGHT
10	288034	.	CONDUIT 3/4" SEALTIGHT
11	288008	.	CONDUIT 1" SEALTIGHT
12	.	.	.
13	.	.	.
14	292018	20	CONDUIT CONNECTOR 1/2" STRAIGHT
15	292025	4	CONDUIT CONNECTOR 3/4" STRAIGHT
16	292038	6	CONDUIT CONNECTOR 1" STRAIGHT
17	292062	10	CONDUIT CONNECTOR 1-1/2" STRAIGHT
18	.	.	.
19	.	.	.
20	292088	4	CONDUIT CONNECTOR 1/2" LB
21	292089	2	CONDUIT CONNECTOR 1/2" PULL EL
22	292034	0	CONDUIT CONNECTOR 3/4" PULL EL
23	292043	0	CONDUIT CONNECTOR 1" PULL EL
24	292780	1	CONDUIT CONNECTOR 1-1/2" LL W/COVER
25	292781	1	CONDUIT CONNECTOR 1-1/2" LR W/COVER
26	.	.	.
27	292014	6	CONDUIT CONNECTOR 1/2" STR SEALTIGHT
28	292021	2	CONDUIT CONNECTOR 1/2" 90 SEALTIGHT
29	292031	0	CONDUIT CONNECTOR 3/4 STR SEALTIGHT
30	292037	.	CONDUIT CONNECTOR 1" STR SEALTIGHT
31	292044	.	CONDUIT CONNECTOR 1" 90 SEALTIGHT
32	.	.	.
33	.	.	.
34	429004	8	CLAMP 1/2"
35	429009	0	CLAMP 3/4"
36	429011	5	CLAMP 1"
37	429021	4	CLAMP 1-1/2"
38	346238	REF	ENCLOSURE, 10 X 12 J-BOX
39	556508	1	SUB PANEL FOR 10 X 12
40	.	.	.
41	535324	2	CHASE NIPPLE 1-1/2"
42	772014	100	WIRE THERMOCOUPLE
43	772043	100	WIRE 16AWG WHITE
44	772042	1000	WIRE 16AWG RED
45	772071	500	WIRE 14AWG BLK
46	772058	100	WIRE 14AWG GREEN/YELLOW

SIMILAR TO 6161974-9700

REV	REVISION DESCRIPTION	C.N.	BY	DATE	CK.
1	ADDED AMBIENT BLOWER, MIST COLLECTOR AND HEAT	231148	GB	10/30/13	

NOTE:
DO NOT SCALE DRAWING
TOLERANCE UNLESS OTHERWISE NOTED.
X.X = ± .12
X.XX = ± .030
X.XXX = ± .010
ANGLES = ± 1°

SUCCEEDING USAGE
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KIEL, WISCONSIN 53042

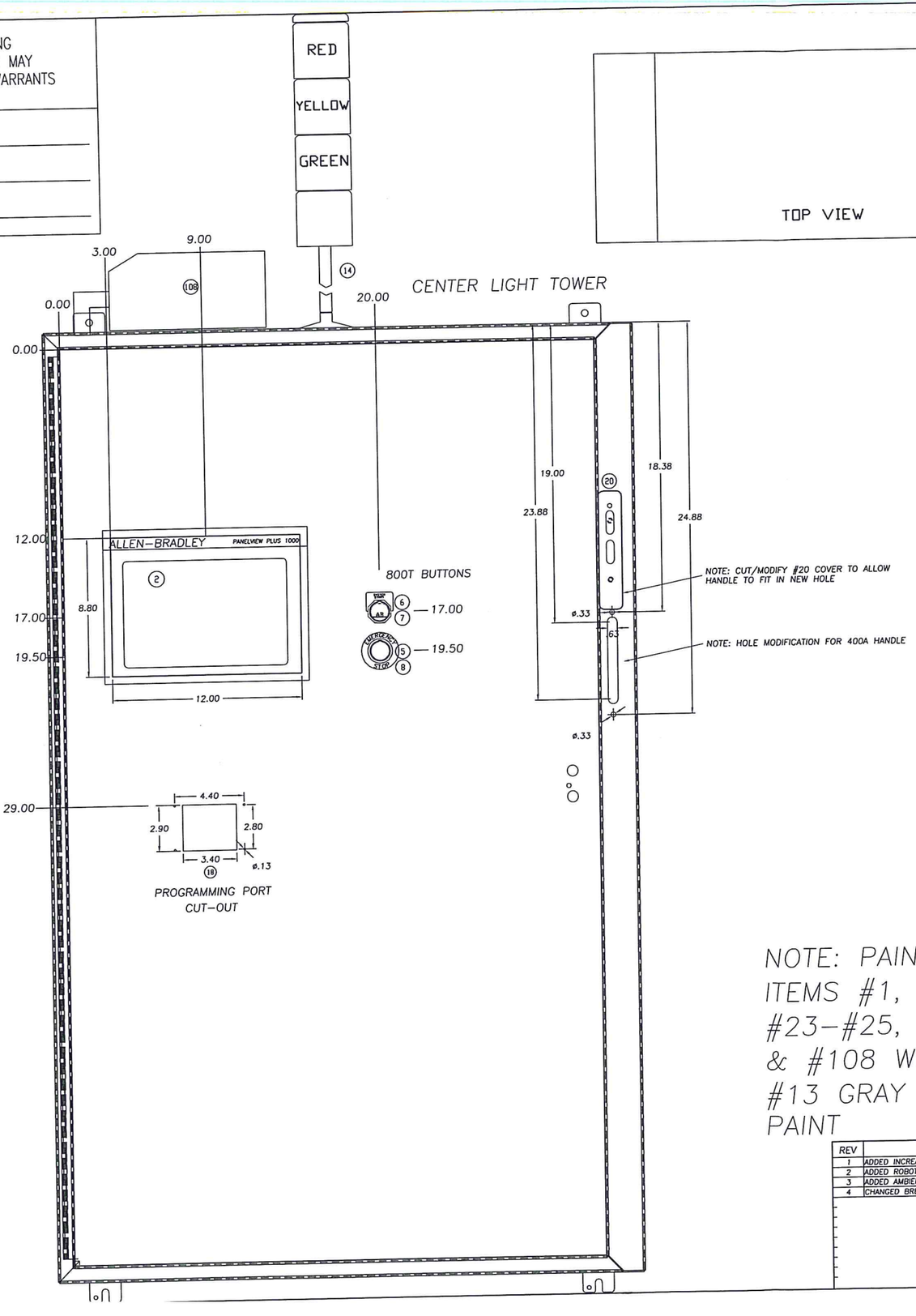
TITLE CONDUIT LAYOUT
.
MATERIAL OR SOURCE M1974 PACE
PRODUCT AQF-224
AUTOCAD NO. 6161995-9700
PRODUCT CODE WQ
PART NO. .
DATE 4/25/13 DWC BY GB
SCALE N/A CHK BY .
DWG NO. 6161995-9700
REV 1

DESIGN REVIEW & APPROVAL DRAWING
DIMENSIONS AND OBJECT LOCATIONS MAY VARY SLIGHTLY AS CONSTRUCTION WARRANTS
PLEASE INDICATE CRITICAL AREAS

COMPANY NAME _____

APPROVED BY _____

TITLE _____ DATE _____



ITEM	STOELTING PN	QTY	DESCRIPTION
1	346794	1	ENCLOSURE 60x38x12 FLANGED 400A
2	332551	1	PANELVIEW+ 1000 E-NET 24VDC
3	528237	1	NAMEPLATE, SERIAL "CE"
4			
5	528239	1	N.P. "EMERGENCY STOP" 30.5 RND
6	1110825-2367	1	N.P. "SYSTEM START"
7	719117	1	SWITCH, P.B. GREEN ILL. OPERATOR 24V
8	718375	1	SWITCH, MUSH. HEAD RED OPER. PUSH/PULL
9			
10	428018	1	DOOR HARDWARE
11	324808	1	DECAL, "STOELTING"
12	324598	1	DECAL, "DANGER - HIGH VOLTAGE…"
13	554076	.25	PAINT, METALIC GRAY
14	493116	1	LIGHT TOWER RYG & ALARM 24V PATLITE
15			
16			
17			
18	346789	1	ENCLOSURE, ETHERNET PROGRAMMING
19			
20	346795	1	ENCLOSURE, BLANK COVER
21			
22	163520	.	BLOCK, CONTACT 800T NC MINI
23	346330	3	ENCLOSURE, 8x8x4 J. BOX MILD STEEL
24	346554	2	ENCLOSURE, P.B. 1 POSITION
25	346567	1	ENCLOSURE, P.B. 3 POSITION
26	428019	1	DOOR HARDWARE, EXTRA ROLLER
27			
28			
29	163560	.	BLOCK, CONTACT 800T 2NC SHALLOW
30	346238	1	ENCLOSURE, 10 X 12 J-BOX

SERIAL NUMBER NAMEPLATE DATA

STOELTING

MODEL AQF-224 SERIAL NO. 07131995

460 VOLTS 60 HZ. 3 PH. TOTAL CURRENT 250 FLA

350 AMP BREAKER DIAGRAM 6161995-9900

23 AMP LARGEST MOTOR 2014 YEAR OF MFG.

ENVIRONMENTAL RATING
– TYPE 1
SCCR–10KA RMS
SYMMETRICAL
VOLTAGE RATING 460Y/277V

NOTE: PAINT ITEMS #1, #23–#25, #30 & #108 WITH #13 GRAY PAINT

SIMILAR TO M1974

REV	REVISION DESCRIPTION	C.N.	BY	DATE	CK.
1	ADDED INCREASED HEAT, LARGER PUMPS AND E-NET PORT	231148	GB	5/21/13	
2	ADDED ROBOT SIGNALS	231148	GB	5/28/13	
3	ADDED AMBIENT BLOWER, MIST COLLECTOR AND HEAT	231148	GB	10/30/13	
4	CHANGED BREAKER TO FLANGED FUSED DISCONNECT	231148	GB	12/9/13	

NOTE:
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TITLE ENCLOSURE LAYOUT
DOOR LAYOUT

MATERIAL OR SOURCE M1995 PACE

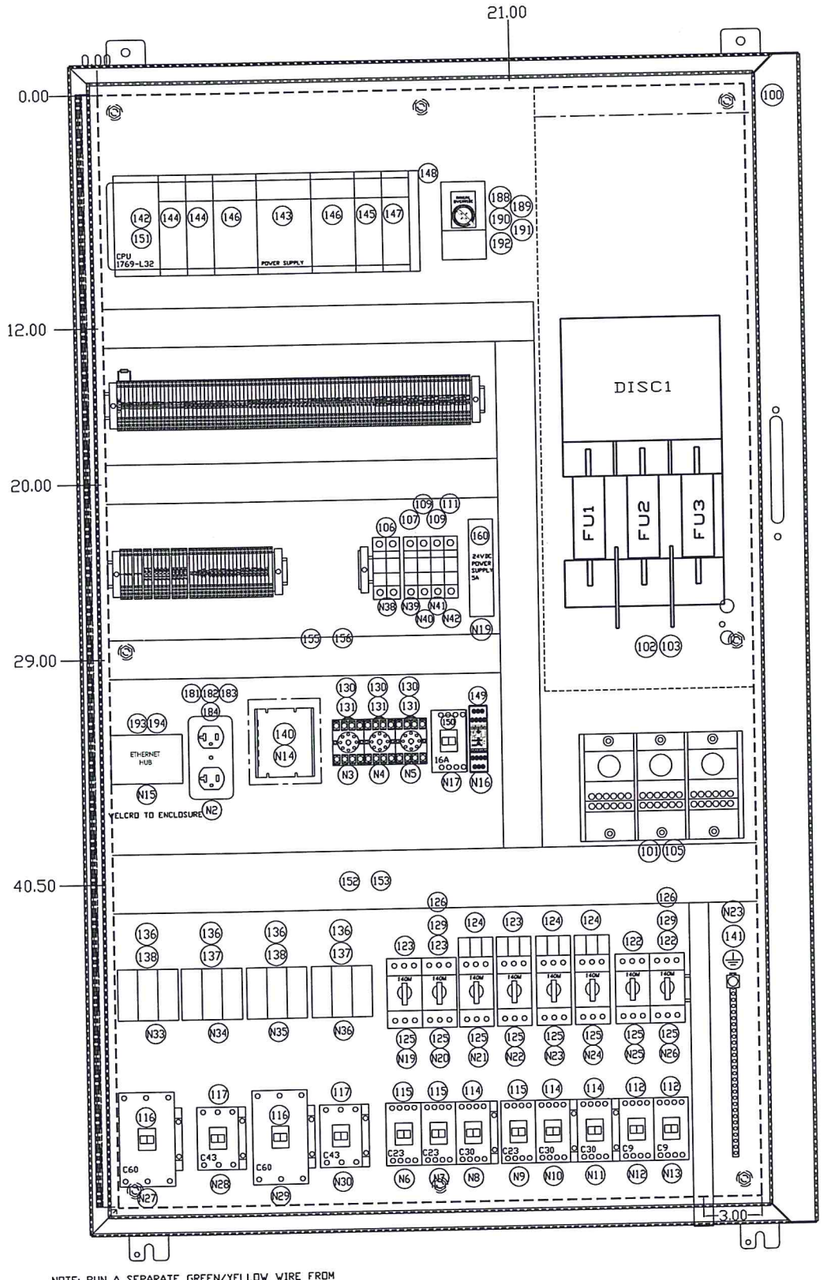
PRODUCT AQF-224 AUTOCAD NO. 6161995-9800$1

PRODUCT CODE WO PART NO. .

DATE 4/25/13 DWG BY GB

SCALE 1=4 CHK BY .

DWG NO. 6161995-9800 REV 4



NOTE: RUN A SEPARATE GREEN/YELLOW WIRE FROM GROUNDING STRIP AND SECURE TO DOOR.

ITEM	STOELTING PN	QTY	DESCRIPTION
160	593056	1	24VDC 5AMP POWER SUPPLY
161	.	.	.
162	302004	0	CORD, SIZE 22 2 CONDUCTOR SHIELDED
163	772330	0	WIRE, 20 AWG RED
164	772042	150	WIRE, 16 AWG RED
165	772043	50	WIRE, 16 AWG WHITE
166	772013	0	WIRE, 18 AWG BLUE
167	772058	50	WIRE, 14AWG GREEN/YELLOW
168	772071	50	WIRE, 14AWG BLACK
169	772112	0	WIRE, 12AWG BLACK
170	772144	0	WIRE, 10AWG GREEN/YELLOW
171	772136	0	WIRE, 10AWG BLACK
172	772200	0	WIRE, 6AWG BLACK
173	772232	.	WIRE, 4AWG BLACK
174	772264	.	WIRE, 2/0AWG BLACK
175	772280	.	WIRE, 4/0AWG BLACK
176	772291	3	WIRE, 350MCM BLACK
177	772046	100	WIRE, 16 AWG BLUE
178	772088	100	WIRE, 16 AWG BLUE/WHITE
179			
180	678875	1	SHEET, PLEXIGLASS
181	198028	1	OUTLET BOX
182	584182	1	RECEPTACLE, DUPLEX 120V
183	314181	1	RECEPTACLE, COVER
184	223058	1	BUSHING, HEYCO
185	.	.	.
186	.	.	.
187	6161995-9900	0	SCHEMATIC, ELECTRICAL
188	164248	1	LATCH, METAL FOR 800F
189	1175156	1	BRACKET, SELECTOR SWITCH MTG.
190	1110825-2351	1	NP. MANUAL OVERRIDE
191	718504	1	SWITCH, SPRING RETURN 800F
192	164235	1	BLOCK, CONTACT N.O. 800F
193	229117	3	CABLE ETHERNET CAT5 10'
193	521341	1	MODULE HUB ETHERNET 5 PORT
194	292333	.	CONNECTOR RJ-45 TO RJ-45

ITEM	STOELTING PN	QTY	DESCRIPTION
100	556512	1	PANEL, SUB 57 X 33
101	163674	1	COVER FOR DIST. BLOCK 163689
102	718945	1	SWITCH, DISCONNECT FLANGED 400A
103	394228	3	FUSE, LPJ-350
104			
105	163689	1	BLOCK, DISTRIBUTION 380A 12 POLE
106	202215	1	BREAKER, CIRCUIT 10A 2 POLE 1489
107	202214	1	BREAKER, CIRCUIT 10A 1 POLE 1489
108	743636	1	TRANSFORMER, 1.5 KVA 480-120V ENCLOSED
109	202211	2	BREAKER, CIRCUIT 2A 1 POLE 1489
110			
111	202240	1	BREAKER, CIRCUIT 15A 1 POLE 1489
112	295206	2	CONTACTOR, 9A IEC
113	295207	.	CONTACTOR, 12A IEC
114	295210	3	CONTACTOR, 30A IEC
115	295209	3	CONTACTOR, 23A IEC
116	295213	2	CONTACTOR, 60A IEC
117	295212	2	CONTACTOR, 43A (83A) IEC
118	704351	.	MAN. MTR. STARTER 1.0-1.6 AMP 140M
119	704352	.	MAN. MTR. STARTER 1.6-2.5 AMP 140M
120	704353	.	MAN. MTR. STARTER 2.5-4 AMP 140M
121	704354	.	MAN. MTR. STARTER 4-6.3 AMP 140M
122	704355	2	MAN. MTR. STARTER 6.3-10 AMP 140M
123	704356	3	MAN. MTR. STARTER 10-16 AMP 140M
124	704358	3	MAN. MTR. STARTER 18-25 AMP 140M
125	163579	8	INTERNAL AUX. CONTACT FOR MMSP 140M
126	704360	2	COMMONING LINK FOR 2 MMSP 140M
127	704361	.	COMMONING LINK FOR 4 MMSP 140M
128	704362	.	COMMONING LINK FOR 5 MMSP 140M
129	704363	2	COMMONING TERMINAL FOR MMSP 140M
130	618035	3	RELAY, 24VDC 8PIN OCTAL
131	688066	3	SOCKET, RELAY 8 PIN OCTAL
132			
133			
134	2157842	.	BRACKET, POTENTIOMETER
135			
136	163685	12	FUSE HOLDER, 1-60 AMP CUBE FUSE "J"
137	394480	6	FUSE, CUBE 40 AMP TCF "J"
138	394483	6	FUSE, CUBE 60 AMP TCF "J"
139			
140	296287	1	CONTROL, DC DRIVE EXTRON
141	731960	1	TERMINAL BLOCK, GROUND BAR KIT
142	521404	1	MODULE CPU COMPACT LOGIX L32
143	593082	1	POWER SUPPLY COMPACT LOGIX 24VDC
144	521405	2	MODULE INPUT 16PT 24VDC COMPACT
145	521427	1	MODULE RTD 6PT COMPACT
146	521406	2	MODULE OUTPUT 16PT RELAY COMPACT
147	521426	1	MODULE ANALOG OUT VOLT 4PT COMPACT
148	521408	1	MODULE END CAP RIGHT END
149	618245	1	RELAY SAFETY 24VDC AB MSR AUTO RESET
150	295227	1	CONTACTOR, MASTER SAFETY 23A 24VDC
151	521404-01	1	MODULE, MEMORY 128MB CARD FOR L32E
152	346242	3	ENCLOSURE, WIREWAY LAYIN, 3 X 4
153	314450	3	COVER, 3" WIREWAY
154	524073	150	MOUNT, DIN RAIL
155	346589	11	ENCLOSURE WIREWAY LAYIN, 2 x 4
156	314172	11	COVER, 2" WIREWAY
157	628028	24	RIVET, NYLON MOUNTING
158	346533	2	ENCLOSURE, WIREWAY LAYIN 1 X 4
159	314170	2	COVER, 1" WIREWAY

N.P. #	QTY	DESCRIPTION
N1	1	1FU-2FU-3FU LPJ-350SP 350A MAIN
N2	1	120VAC 2AMP 60HZ COMPUTER USE ONLY
N3	1	1CR CONVEYOR DRIVE RELAY
N4	1	2CR LOAD END READY TO LOAD
N5	1	3CR UNLOAD END READY TO UNLOAD
N6	1	1MS 1st STAGE PUMP MOTOR STARTER
N7	1	2MS 2nd STAGE PUMP MOTOR STARTER
N8	1	3MS AMBIENT BLOWER#1 MOTOR STARTER
N9	1	4MS AMBIENT BLOWER#2 MOTOR STARTER
N10	1	5MS AMBIENT BLOWER#3 MOTOR STARTER
N11	1	5MS AMBIENT BLOWER#4 MOTOR STARTER
N12	1	7MS MIST COLLECTOR #1 MOTOR STARTER
N13	1	7MS MIST COLLECTOR #2 MOTOR STARTER

N.P. #	QTY	DESCRIPTION
N14	1	DC DRIVE
N15	1	ETHERNET HUB
N16	1	MCR MASTER CONTROL RELAY
N17	1	MSC MASTER SAFETY CONTACTOR
N18	1	24VPS 24VDC POWER SUPPLY
N19	1	1MMSP 1st STAGE PUMP MAN. MTR. STARTER
N20	1	2MMSP 2nd STAGE PUMP MAN. MTR. STARTER
N21	1	3MMSP AMBIENT BLOWER#1 MAN. MTR. STARTER
N22	1	4MMSP AMBIENT BLOWER#2 MAN. MTR. STARTER
N23	1	5MMSP AMBIENT BLOWER#3 MAN. MTR. STARTER
N24	1	6MMSP AMBIENT BLOWER#4 MAN. MTR. STARTER
N25	1	7MMSP MIST COLLECTOR#1 MAN. MTR. STARTER
N26	1	8MMSP MIST COLLECTOR#2 MAN. MTR. STARTER

N.P. #	QTY	DESCRIPTION
N27	1	1HC 1ST STAGE HEAT CONTACTOR
N28	1	2HC 1ST STAGE HEAT CONTACTOR
N29	1	3HC 2ND STAGE HEAT CONTACTOR
N30	1	4HC 2ND STAGE HEAT CONTACTOR
N31		
N32		
N33	1	4FU 5FU 6FU TCF60 "J" 1HC
N34	1	7FU 8FU 9FU TCF40 "J" 2HC
N35	1	10FU 11FU 12FU TCF60 "J" 3HC
N36	1	13FU 14FU 15FU TCF40 "J" 4HC
N37		
N38	1	2CB 10AMP CIRCUIT BREAKER TRANS. PRIMARY
N39	1	3CB 10AMP CIRCUIT BREAKER TRANS. SECONDARY

N.P. #	QTY	DESCRIPTION
N40	1	4CB 2AMP CIRCUIT BREAKER OUTLET
N41	1	5CB 2AMP CIRCUIT BREAKER 24VDC PRIMARY
N42	1	6CB 15AMP CIRCUIT BREAKER DC DRIVE

REV	REVISION DESCRIPTION	C.N.	BY	DATE	CK.
1	ADDED INCREASED HEAT, LARGER PUMPS AND E-NET PORT	231148	GB	5/21/13	
2	ADDED ROBOT SIGNALS	231148	GB	5/28/13	
3	ADDED AMBIENT BLOWER, MIST COLLECTOR AND HEAT	231148	GB	10/30/13	
4	CHANGED BREAKER TO FLANGED FUSED DISCONNECT	231148	GB	12/9/13	

NOTE:
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TOLERANCE UNLESS OTHERWISE NOTED.
X.X = ± .12
X.XX = ± .030
X.XXX = ± .010
ANGLES = ± 1°

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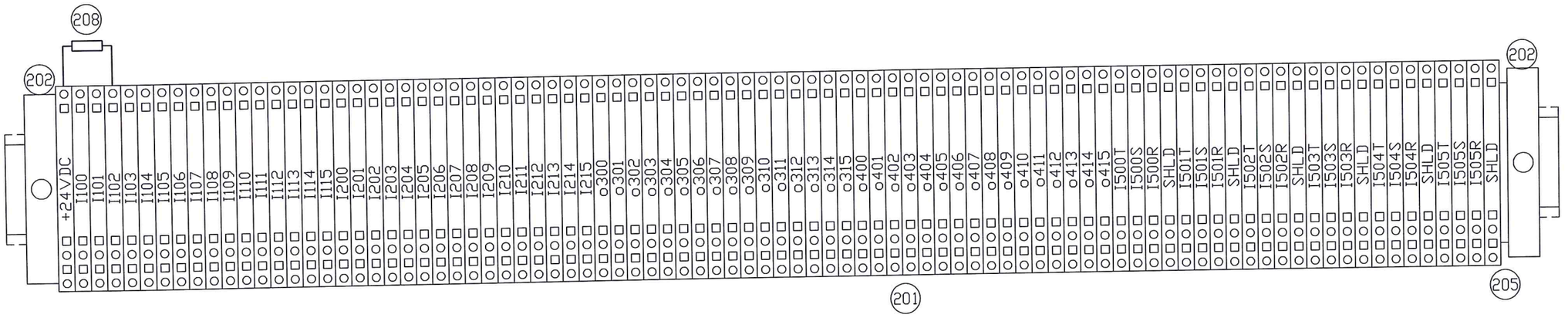
STOELTING
KIEL, WISCONSIN 53042

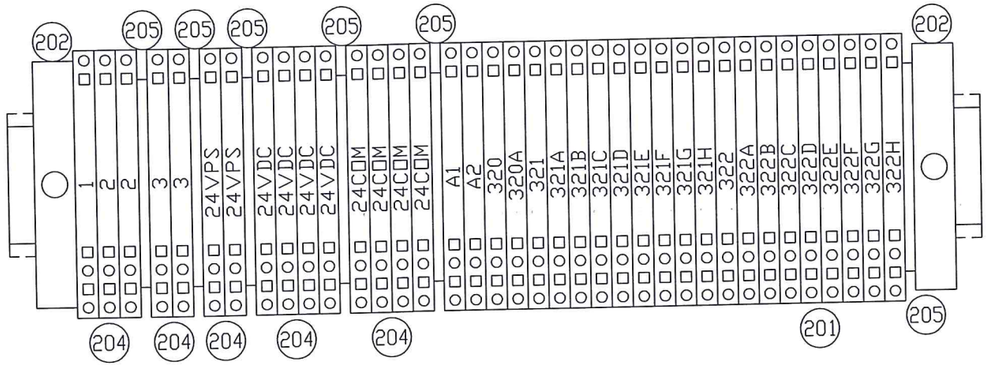
TITLE: ELECTRICAL ENCLOSURE
PANEL LAYOUT

MATERIAL OR SOURCE: M1995 PACE

PRODUCT AQF-224
AUTOCAD NO. 6161995-9800$2
PRODUCT CODE WQ
PART NO. .
DATE 4/25/13 | DWG BY GB
SCALE 1=4 | CHK BY .
DWG NO. 6161995-9800
REV 4

ITEM	STOELTING PN	QTY	DESCRIPTION
201	732034	125	TERMINAL, 26 AMP @ 600V, 24-12 AWG
202	346612	4	END PIECE, TERMINAL STRIP END STOP
203	312020	.	TERMINAL, THERMOCOUPLE "J"
204	731943	1	TERMINAL, JUMPER FOR WAGO TERMINALS
205	346613	7	END BARRIER, TERMINAL STRIP END
206	731953	0	TERMINAL, FUSED DISCONNECT
207	394161	0	FUSE, MDA-10
⚠1 208	621024	1	RESISTOR, 1800 OHM





REV	REVISION DESCRIPTION	C.N.	BY	DATE	CK
1	ADDED INCREASED HEAT, LARGER PUMPS AND E-NET PORT	231148	GB	5/21/13	
2	ADDED ROBOT SIGNALS	231148	GB	5/28/13	
3	ADDED AMBIENT BLOWER, MIST COLLECTOR AND HEAT	231148	GB	10/30/13	
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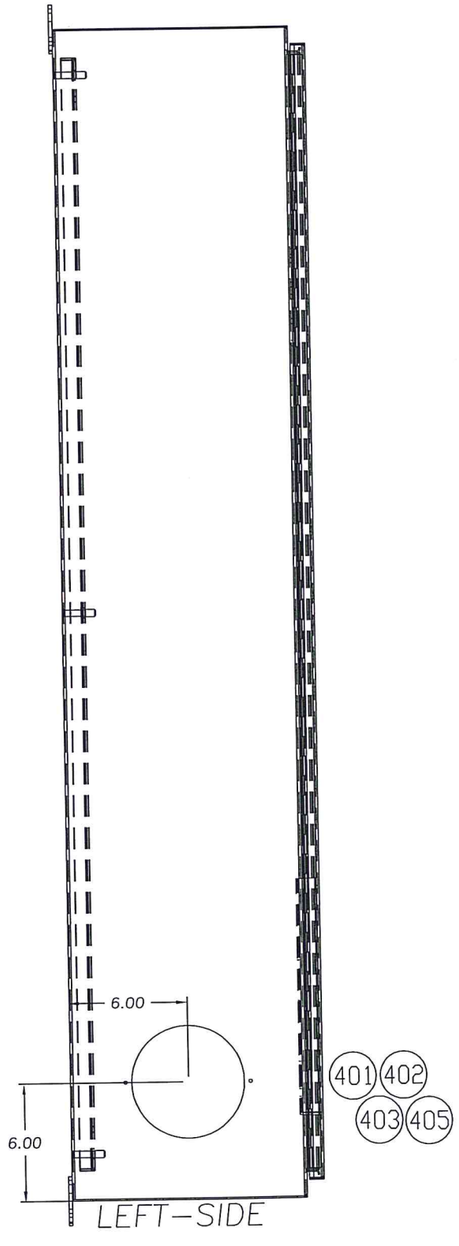
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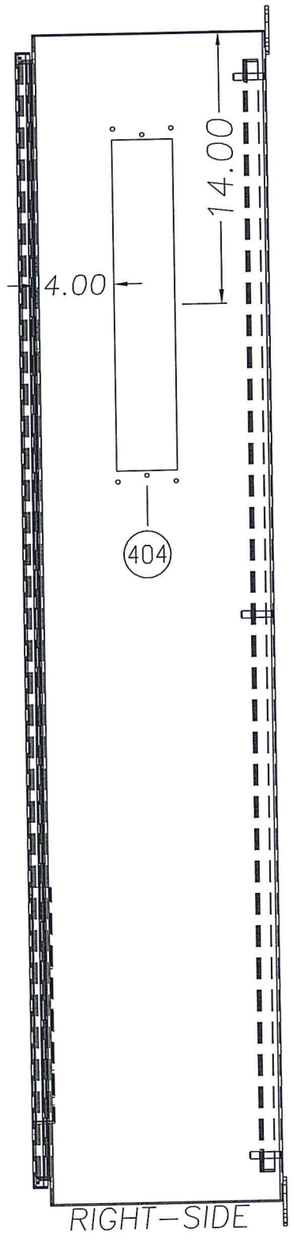
STOELTING
KIEL, WISCONSIN 53042

TITLE: TERMINAL STRIP LAYOUT
.
MATERIAL OR SOURCE: M1995 PACE
PRODUCT AOF-224
AUTOCAD NO. 6161995-9800S3
PRODUCT CODE WO
PART NO. .
DATE 4/25/13
DWG BY GB
SCALE N/A
CHK BY .
DWG NO. 6161995-9800
REV 4

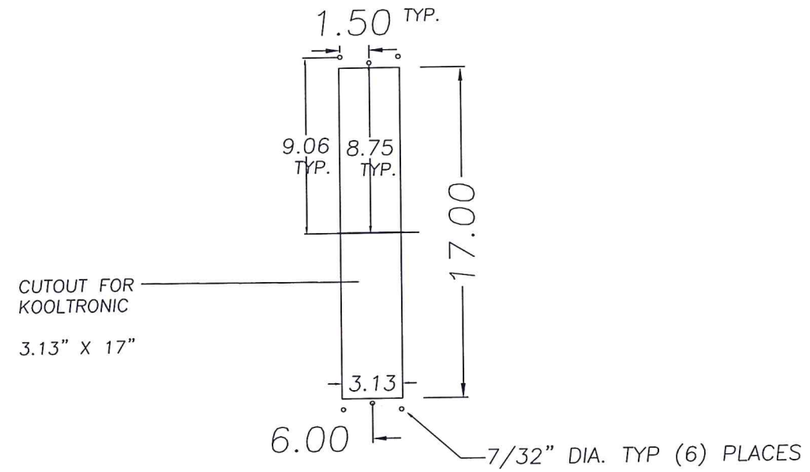
ITEM	STOELTING PN	QTY	DESCRIPTION
401	357087	1	FAN, 6" DIAMETER 236 CFM
402	368367	1	FAN, FILTER KIT FOR 6" FAN
403	357088	1	FAN, CORDSET 24" PLAIN ENDS
404	346390	1	FILTER GRILL, 3 X 17
405	20362-2	1	WIRE FAN GUARD



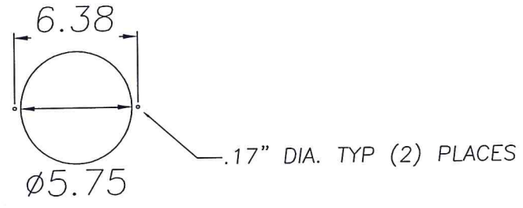
LEFT-SIDE



RIGHT-SIDE



EXHAUST AIR FILTER CUT-OUT



COOLING FAN CUT-OUT

NOTE: CUT-OUT LOCATION NOT CRITICAL.
MAY NEED TO BE RELOCATED
TO AVOID CONDUIT.

REV	REVISION DESCRIPTION	C.N.	BY	DATE	CK
1	ADDED INCREASED HEAT, LARGER PUMPS AND E-NET PORT	231148	GB	5/21/13	
2	ADDED ROBOT SIGNALS	231148	GB	5/28/13	
3	ADDED AMBIENT BLOWER, MIST COLLECTOR AND HEAT	231148	GB	10/30/13	
4	CHANGED BREAKER TO FLANGED FUSED DISCONNECT	231148	GB	12/9/13	

NOTE:
DO NOT SCALE DRAWING
TOLERANCE UNLESS OTHERWISE NOTED.
X.X = ± .12
X.XX = ± .030
X.XXX = ± .010
ANGLES = ± 1°

SUCCEEDING USAGE

SHEET 4 OF 4

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STOELTING
KIEL, WISCONSIN 53042

TITLE ENCLOSURE LAYOUT
DOOR LAYOUT

MATERIAL OR SOURCE M1995 PACE

PRODUCT AOF-224
AUTOCAD NO. 6161995-9800$4
PRODUCT CODE WQ
PART NO. .
DATE 4/25/13
DWG BY GB
DWG NO. 6161995-9800
REV 4
SCALE 1=4
CHK BY .

TORQUE TERMINALS
TO MFG. SPEC.

WIRE MUST BE COPPER
75C OR BETTER

ENCLOSURE
TYPE 1

460 VAC
3 PHASE 60HZ

250 F.L.A.

1DISC
400 AMP

LPJ-350

1FU 2FU 3FU

L1 L2 L3

DIST. BLOCK

6 AWG BLK

1MMSP
10-16 AMPS

1MS 14AWG BLACK

1T1 1T2 1T3

1MTR — 1st STAGE PUMP
7.5 H.P.
10 AMPS

ALLEN-BRADLEY
COMBINATION MOTOR PROTECTOR
BULLETIN 140M

2MMSP
10-16 AMPS

2MS 14AWG BLACK

2T1 2T2 2T3

2MTR — 2nd STAGE PUMP
7.5 H.P.
10 AMPS

ALLEN-BRADLEY
COMBINATION MOTOR PROTECTOR
BULLETIN 140M

8 AWG BLK

3MMSP
18-25 AMPS

3MS 8AWG BLACK

3T1 3T2 3T3

3MTR — AMBIENT #1 SONIC BLOWER
20 H.P.
23 AMPS

ALLEN-BRADLEY
COMBINATION MOTOR PROTECTOR
BULLETIN 140M

8 AWG BLK

4MMSP
10-16 AMPS

4MS 12AWG BLACK

4T1 4T2 4T3

4MTR — AMBIENT #2 BLOWER
10 H.P.
12.9 AMPS

ALLEN-BRADLEY
COMBINATION MOTOR PROTECTOR
BULLETIN 140M

L1 L2 L3

8 AWG BLK

5MMSP
18-25 AMPS

5MS 8AWG BLACK

5T1 5T2 5T3

5MTR — AMBIENT #3 SONIC BLOWER
20 H.P.
23 AMPS

ALLEN-BRADLEY
COMBINATION MOTOR PROTECTOR
BULLETIN 140M

8 AWG BLK

6MMSP
18-25 AMPS

6MS 8AWG BLACK

6T1 6T2 6T3

6MTR — AMBIENT #4 SONIC BLOWER
20 H.P.
23 AMPS

ALLEN-BRADLEY
COMBINATION MOTOR PROTECTOR
BULLETIN 140M

8 AWG BLK

7MMSP
6.3-10 AMPS

7MS 14AWG BLACK

7T1 7T2 7T3

7MTR — MIST COLLECTOR #1
5 H.P.
6.5 AMPS

ALLEN-BRADLEY
COMBINATION MOTOR PROTECTOR
BULLETIN 140M

8MMSP
6.3-10 AMPS

8MS 14AWG BLACK

8T1 8T2 8T3

8MTR — MIST COLLECTOR #2
5 H.P.
6.5 AMPS

ALLEN-BRADLEY
COMBINATION MOTOR PROTECTOR
BULLETIN 140M

NOTE: ALL WIRE TO MOTORS AND HEATERS TO BE TYPE "THHN" WIRE.

NOTE: RUN GROUND WIRE TO ALL MOTORS FROM ELECTRICAL ENCLOSURE

REV	REVISION DESCRIPTION	C.N.	BY	DATE	CK.
1	ADDED INCREASED HEAT, LARGER PUMPS AND E-NET PORT	231148	GB	5/21/13	
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3	ADDED AMBIENT BLOWER, MIST COLLECTOR AND HEAT	231148	GB	10/30/13	
4	CHANGED BREAKER TO FLANGED FUSED DISCONNECT	231148	GB	12/9/13	

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X.XXX = ± .010
ANGLES = ± 1°

SUCCEEDING USAGE

SHEET 1 OF 6

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STOELTING
KIEL, WISCONSIN 53042

TITLE ELECTRICAL SCHEMATIC

MATERIAL OR SOURCE M1995 PACE

PRODUCT AQF-224

AUTOCAD NO. 6161995-9900$1

PRODUCT CODE WO

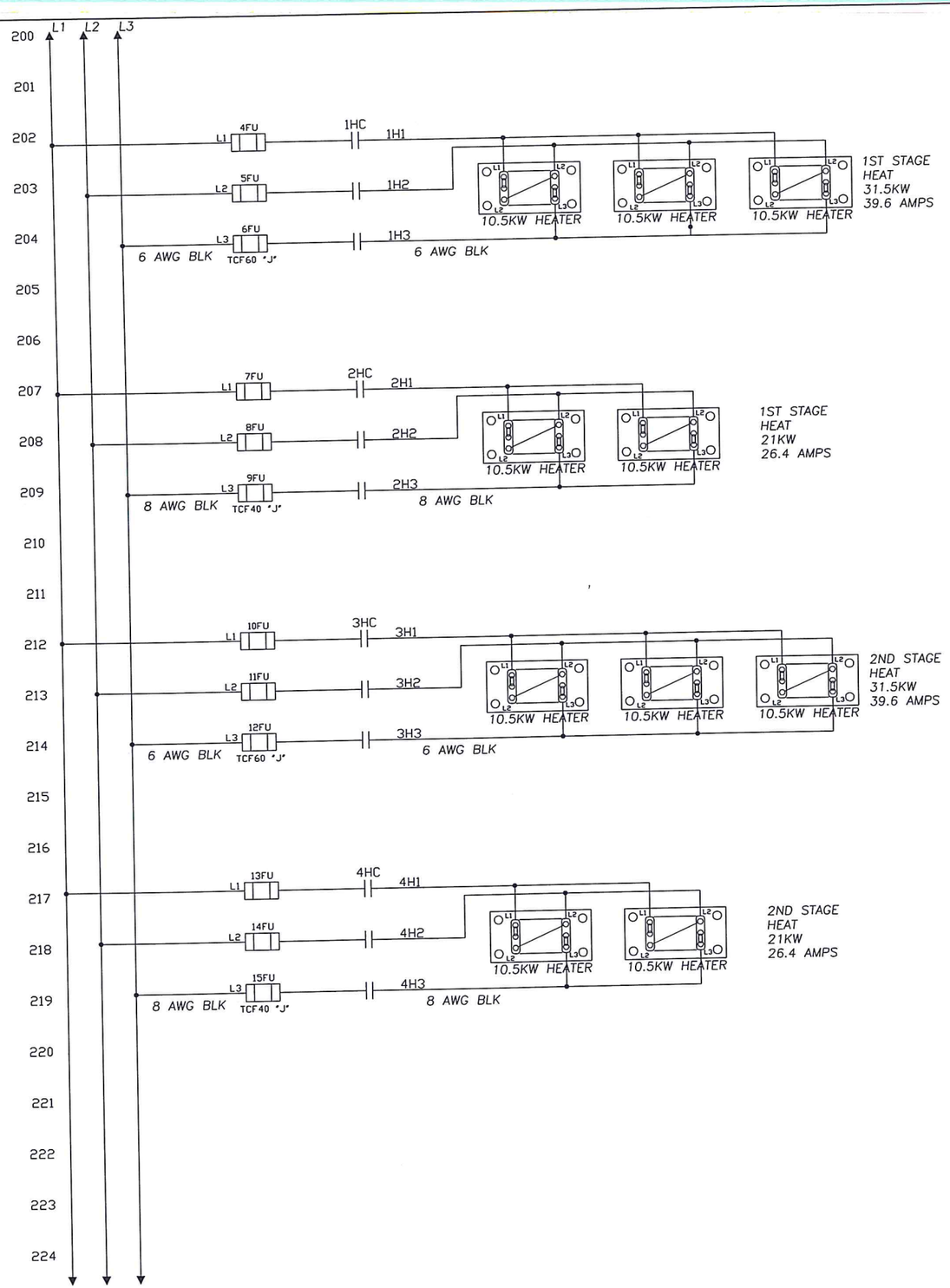
PART NO.

DATE 4/25/13 | DWG BY GB | CHK BY

SCALE N/A

DWG NO. 6161995-9900

REV 4



WIRE COLORS:
460V – BLACK
120V – RED
GROUND – GREEN/YELLOW
24VDC – BLUE
24VDC GROUNDED – BLUE/WHITE

REV	REVISION DESCRIPTION	C.N.	BY	DATE	CK.
1	ADDED INCREASED HEAT, LARGER PUMPS AND E-NET PORT	231148	GB	5/21/13	
2	ADDED ROBOT SIGNALS	231148	GB	5/28/13	
3	ADDED AMBIENT BLOWER, MIST COLLECTOR AND HEAT	231148	GB	10/30/13	
4	CHANGED BREAKER TO FLANGED FUSED DISCONNECT	231148	GB	12/9/13	

NOTE:
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X.XXX = ± .010
ANGLES = ± 1°

SUCCEEDING USAGE

SHEET 2 OF 6

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KIEL, WISCONSIN 53042

TITLE ELECTRICAL SCHEMATIC

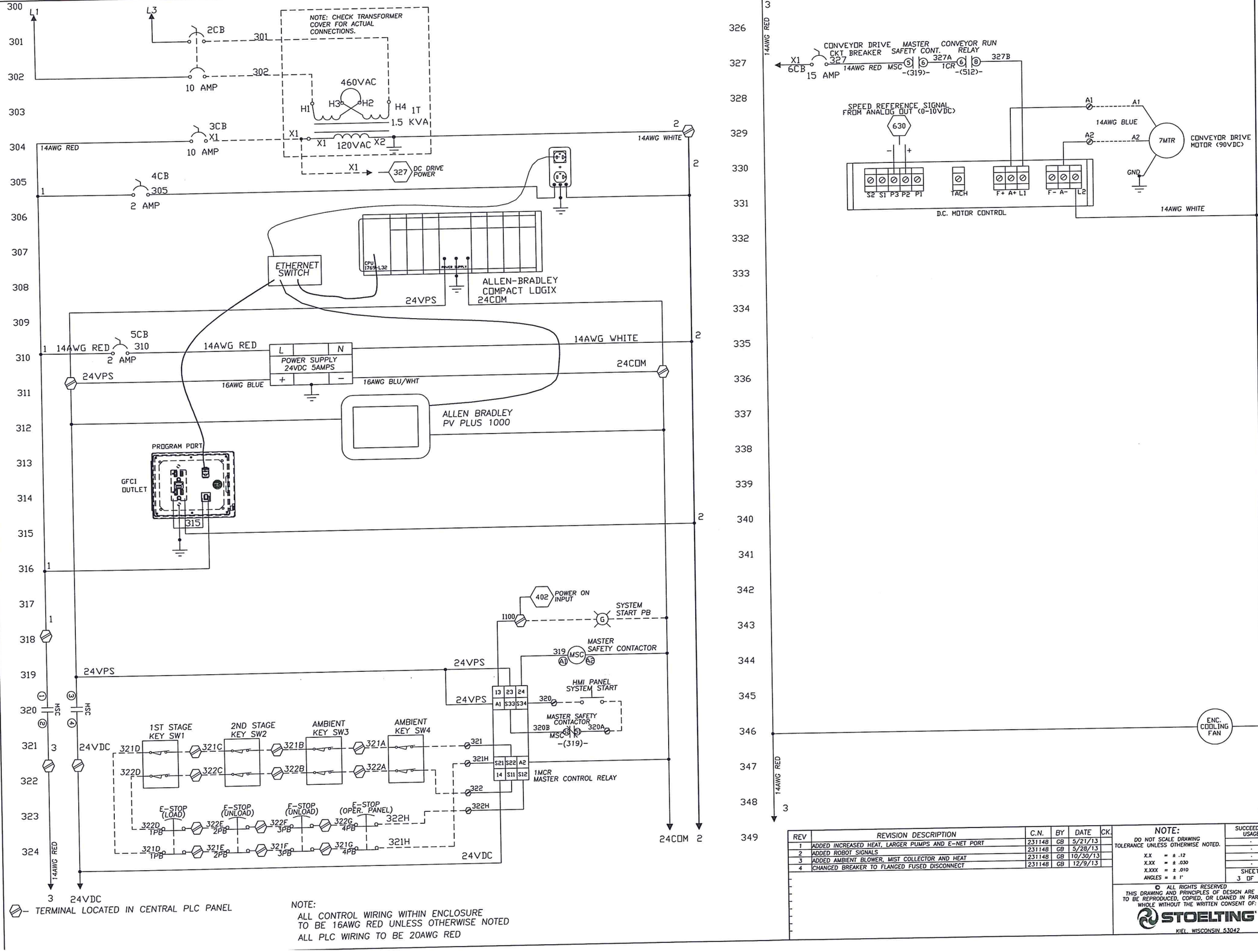
MATERIAL OR SOURCE M1995 PACE

PRODUCT AQF-224 AUTOCAD NO. 6161995-9900$2

PRODUCT CODE WO PART NO.

DATE 4/25/13 DWG BY GB DWG NO. 6161995-9900 REV 4

SCALE N/A CHK BY



NOTE:
ALL CONTROL WIRING WITHIN ENCLOSURE TO BE 16AWG RED UNLESS OTHERWISE NOTED
ALL PLC WIRING TO BE 20AWG RED

REV	REVISION DESCRIPTION	C.N.	BY	DATE	CK.
1	ADDED INCREASED HEAT, LARGER PUMPS AND E-NET PORT	231148	GB	5/21/13	
2	ADDED ROBOT SIGNALS	231148	GB	5/28/13	
3	ADDED AMBIENT BLOWER, MIST COLLECTOR AND HEAT	231148	GB	10/30/13	
4	CHANGED BREAKER TO FLANGED FUSED DISCONNECT	231148	GB	12/9/13	

NOTE:
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TOLERANCE UNLESS OTHERWISE NOTED.
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X.XXX = ± .010
ANGLES = ± 1°

SUCCEEDING USAGE

SHEET 3 OF 6

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TITLE: ELECTRICAL SCHEMATIC

MATERIAL OR SOURCE: M1995 PACE

PRODUCT AQF-224

AUTOCAD NO. 6161995-9900$3

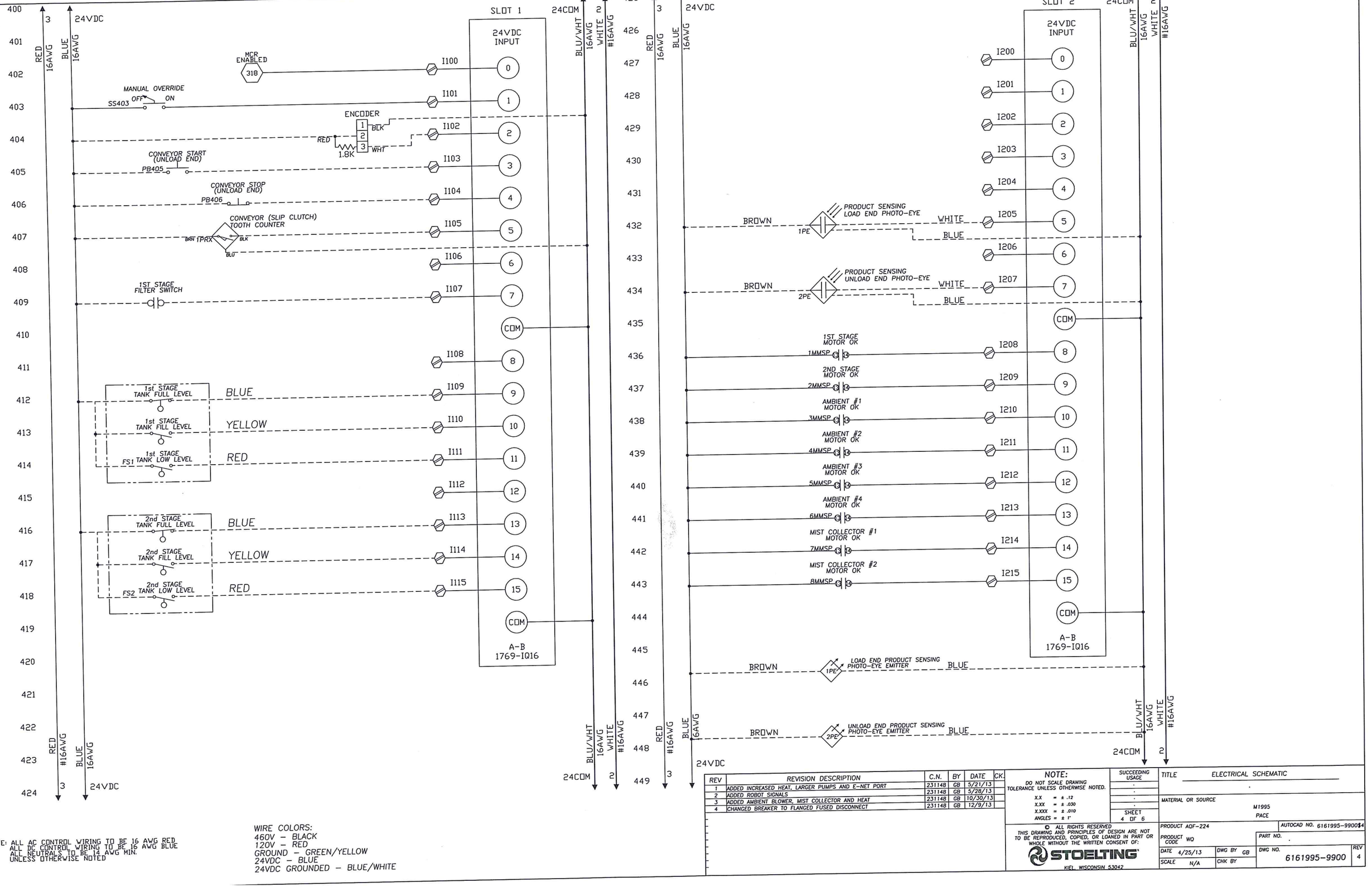
PRODUCT CODE WO

PART NO. .

DATE 4/25/13 | DWG BY GB | SCALE N/A | CHK BY .

DWG NO. 6161995-9900

REV 3



NOTE: ALL AC CONTROL WIRING TO BE 16 AWG RED.
ALL DC CONTROL WIRING TO BE 16 AWG BLUE
ALL NEUTRALS TO BE 14 AWG MIN.
UNLESS OTHERWISE NOTED

WIRE COLORS:
460V – BLACK
120V – RED
GROUND – GREEN/YELLOW
24VDC – BLUE
24VDC GROUNDED – BLUE/WHITE

REV	REVISION DESCRIPTION	C.N.	BY	DATE	CK
1	ADDED INCREASED HEAT, LARGER PUMPS AND E-NET PORT	231148	GB	5/21/13	
2	ADDED ROBOT SIGNALS	231148	GB	5/28/13	
3	ADDED AMBIENT BLOWER, MIST COLLECTOR AND HEAT	231148	GB	10/30/13	
4	CHANGED BREAKER TO FLANGED FUSED DISCONNECT	231148	GB	12/9/13	

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X.XXX = ± .010
ANGLES = ± 1°

SUCCEEDING USAGE

SHEET 4 OF 6

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TITLE: ELECTRICAL SCHEMATIC

MATERIAL OR SOURCE: M1995 PACE

PRODUCT AQF-224

AUTOCAD NO. 6161995-9900S4

PRODUCT WQ CODE

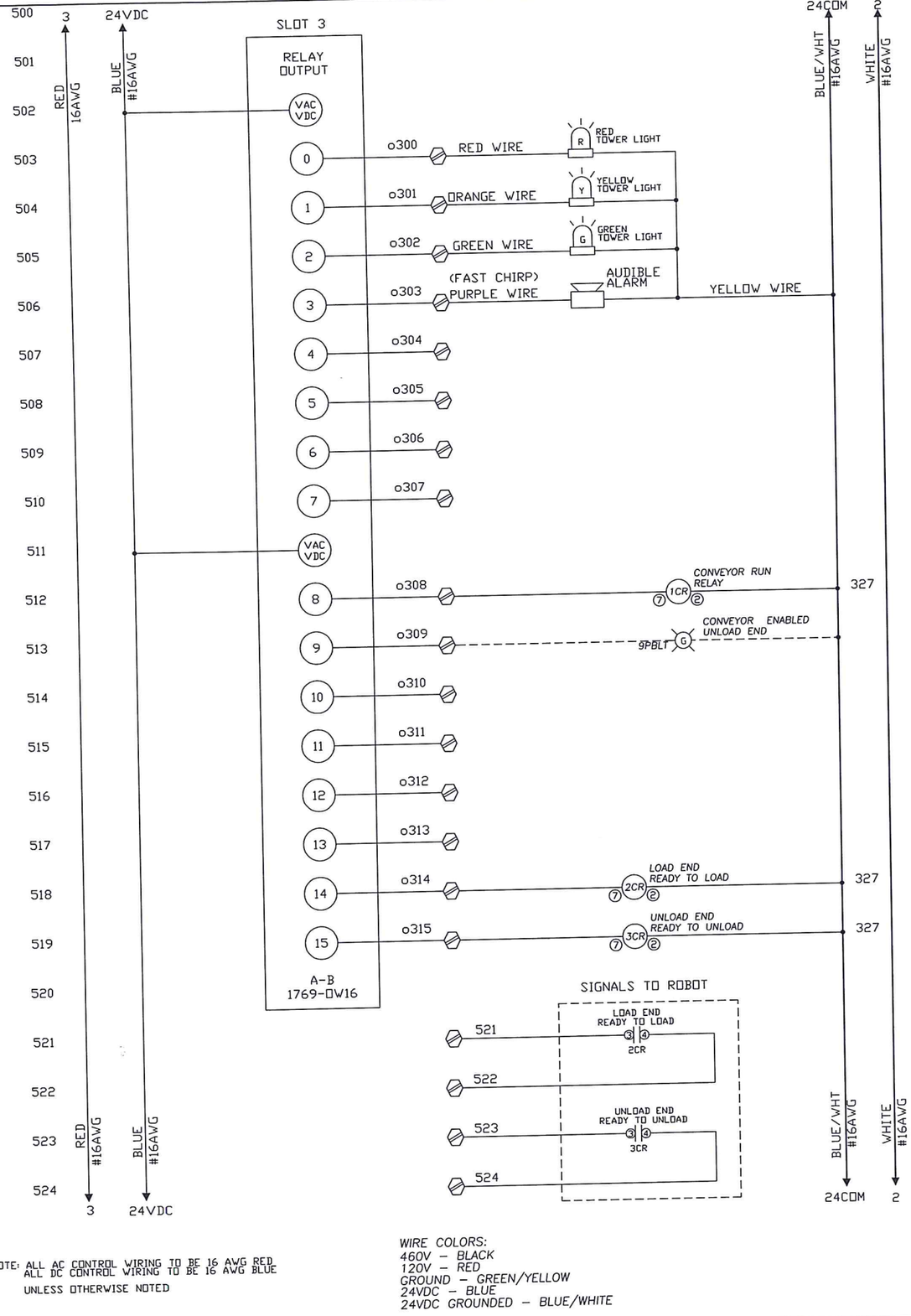
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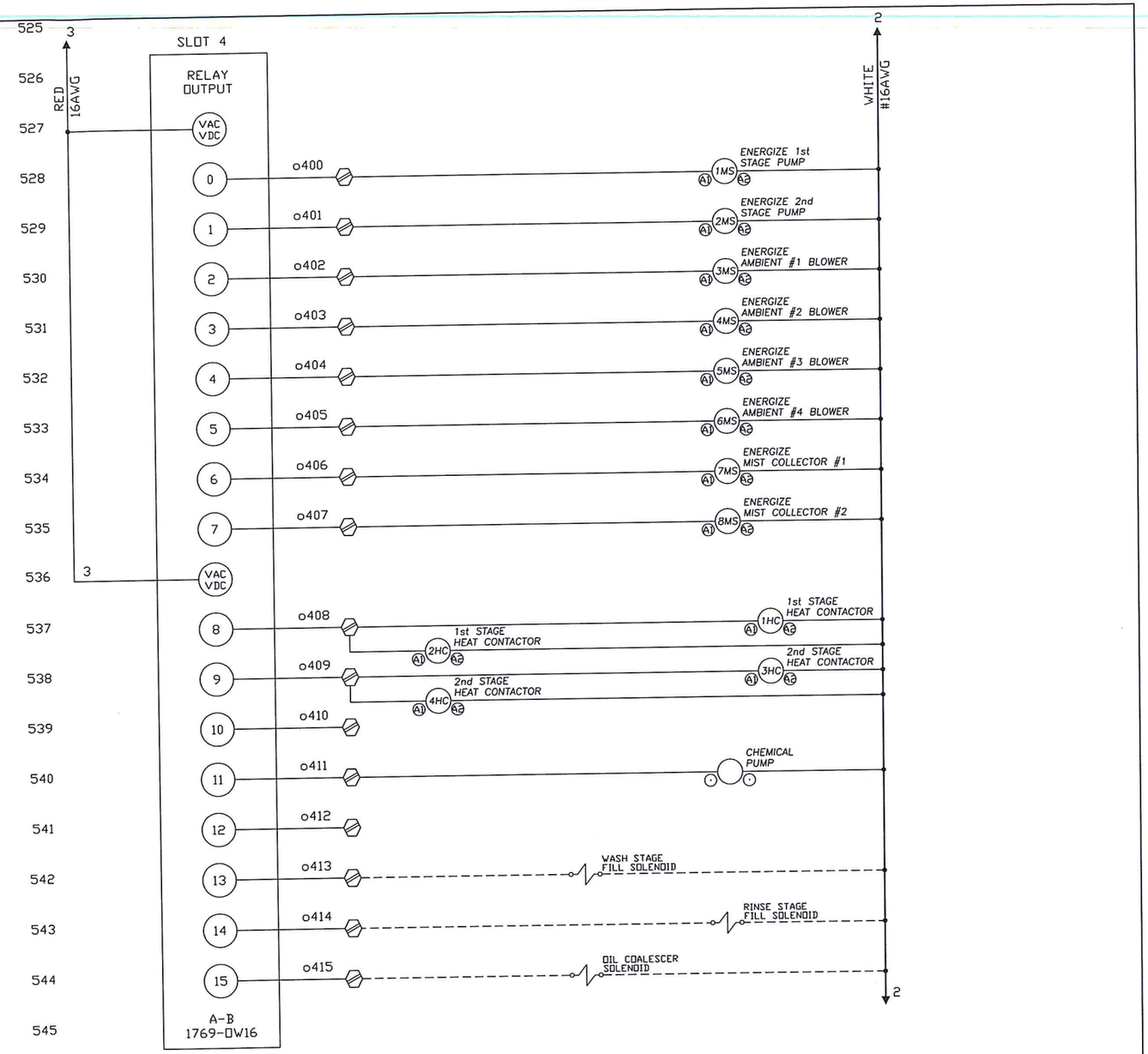
DATE 4/25/13 | DWG BY GB

SCALE N/A | CHK BY

DWG NO. 6161995-9900

REV 4





NOTE: ALL AC CONTROL WIRING TO BE 16 AWG RED
ALL DC CONTROL WIRING TO BE 16 AWG BLUE
UNLESS OTHERWISE NOTED

WIRE COLORS:
460V – BLACK
120V – RED
GROUND – GREEN/YELLOW
24VDC – BLUE
24VDC GROUNDED – BLUE/WHITE

REV	REVISION DESCRIPTION	C.N.	BY	DATE	CK.
1	ADDED INCREASED HEAT, LARGER PUMPS AND E-NET PORT	231148	GB	5/21/13	
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3	ADDED AMBIENT BLOWER, MIST COLLECTOR AND HEAT	231148	GB	10/30/13	
4	CHANGED BREAKER TO FLANGED FUSED DISCONNECT	231148	GB	12/9/13	

NOTE:
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X.XXX = ± .010
ANGLES = ± 1°

SUCCEEDING USAGE

SHEET 5 OF 6

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TITLE ELECTRICAL SCHEMATIC

MATERIAL OR SOURCE M1995 PACE

PRODUCT AQF-224

AUTOCAD NO. 6161995-9900$5

PRODUCT CODE WQ

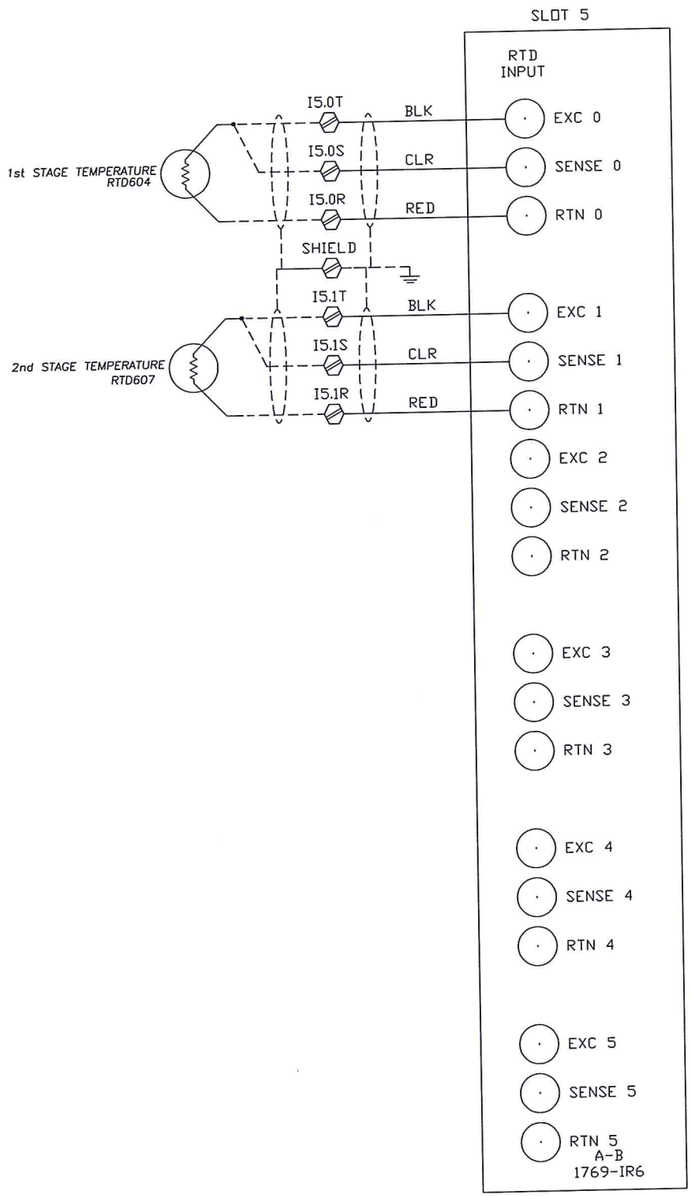
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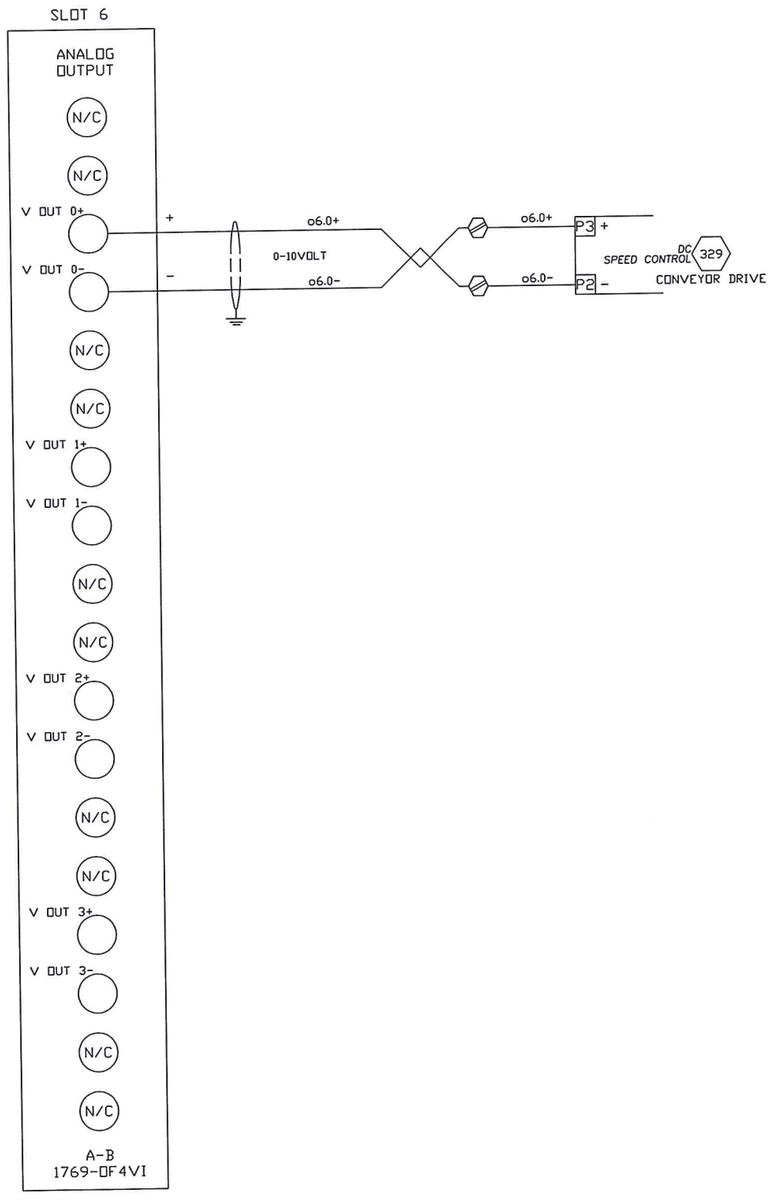
DATE 4/25/13 | DWG BY GB

SCALE N/A | CHK BY

DWG NO. 6161995-9900

REV 4





NOTE: ALL AC CONTROL WIRING TO BE 16 AWG RED
ALL DC CONTROL WIRING TO BE 16 AWG BLUE
UNLESS OTHERWISE NOTED

NO WIRING SMALLER THAN 16AWG TO BE USED

WIRE COLORS:
460V – BLACK
120V – RED
GROUND – GREEN/YELLOW
24VDC – BLUE
24VDC GROUNDED – BLUE/WHITE

REV	REVISION DESCRIPTION	C.N.	BY	DATE	CK.
1	ADDED INCREASED HEAT, LARGER PUMPS AND E-NET PORT	231148	GB	5/21/13	
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SUCCEEDING USAGE

SHEET 6 OF 6

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TITLE ELECTRICAL SCHEMATIC

MATERIAL OR SOURCE M1995 PACE

PRODUCT AQF-224

AUTOCAD NO. 6161995-9900$6

PRODUCT CODE WO

PART NO.

DATE 4/25/13 | DWG BY GB | CHK BY

SCALE N/A

DWG NO. 6161995-9900

REV 4