

#### Specifications:

##### PRETREATMENT SYSTEM - 5 STAGE

Stage 1 - Alkaline Clean 848 gal Net Capacity 96sec @ 1600x.  
7.5hp Spray Pump 288 gpm @ 60' wc  
7ga 301 SS Tank  
160 CAH Eclipse Burner - 1,600,000 BTU  
Automatic Back flow Make-up from Stage 2  
Manual Fresh Water Fill

Stage 2 - Rinse 387 gal Net Capacity 36sec @ Ambient  
5hp Spray Pump 108 gpm @ 60' wc  
7ga 301 SS Tank  
Manual Fresh Water Make-up / Fill

Stage 3 - Iron Phosphate 628 gal Net Capacity 60sec @ 1600x.  
5hp Spray Pump 180 gpm @ 60' wc  
80 AH Eclipse Burner - 800,000 BTU  
7ga 304 SS Tank  
Automatic Back flow Make-up from Stage 4  
Manual Fresh Water Fill

Stage 4 - Rinse 387 gal Net Capacity 36sec @ Ambient  
5hp Spray Pump 108 gpm @ 60' wc  
7ga 301 SS Tank  
Manual Fresh Water Make-up / Fill

Stage 5 - Seal 387 gal Net Capacity 36sec @ Ambient  
5hp Spray Pump 108 gpm @ 60' wc  
7ga 301 SS Tank  
Automatic Fresh Water Make-up

##### General

Tank Construction - see Stage breakdown above  
Drain boards - 12ga 301 SS throughout  
Catwalks - 12ga 304 SS  
Sump Covers - Same as Tank Material Spec.  
Heat Exchangers - 304 SS on both Stage #1 & #3  
Conveyor Rail to be 12ga 304 SS  
2 Vent Fans - 2,500 cfm ea. - 1hp  
Exhaust Fan - 1,600 cfm ea. - 2hp  
Pressure Gauges and Flow Control Valves on All Pumps  
All Spray Risers - 12 nozzles - Side/Side/Over/Under  
Insurance Standard - FM

##### COMBINATION OVEN w/ WEATHER ENCLOSURE

###### Dry-Off Zone

Two Pass  
Design Maximum Operating Temperature - 1550  
Design Product Throughput - 7,500 lb/hr  
Residence Time - 7 min @ 5 fpm Conveyor Line Speed  
High Velocity Air Seals - 2 @ 2hp

###### Cure Zone

Four Pass  
Design Maximum Operating Temperature - 1550  
Design Product Load - 7,500 lb/hr  
Residence Time - 29 min @ 5 fpm Conveyor Line Speed  
Heat System - 280TAH Air Heat Burner w/33hp blower  
#2 DWDI Recirculating Air Blower - 26,240 cfm - 25hp  
Exhaust Fan 1750 cfm - 1hp  
High Velocity Air Seals - 2 @ 2 hp

###### Batch Zone

Single pass with LF of manual push rail & 2 trolleys  
To fit 3'-6" w x 6' h x 12' l part (Note P/C booth Portal only 3' w x 5' h)

##### General

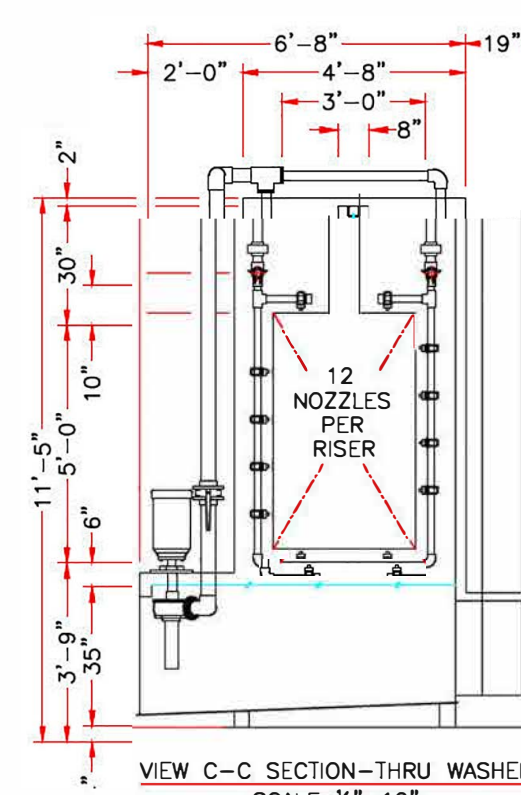
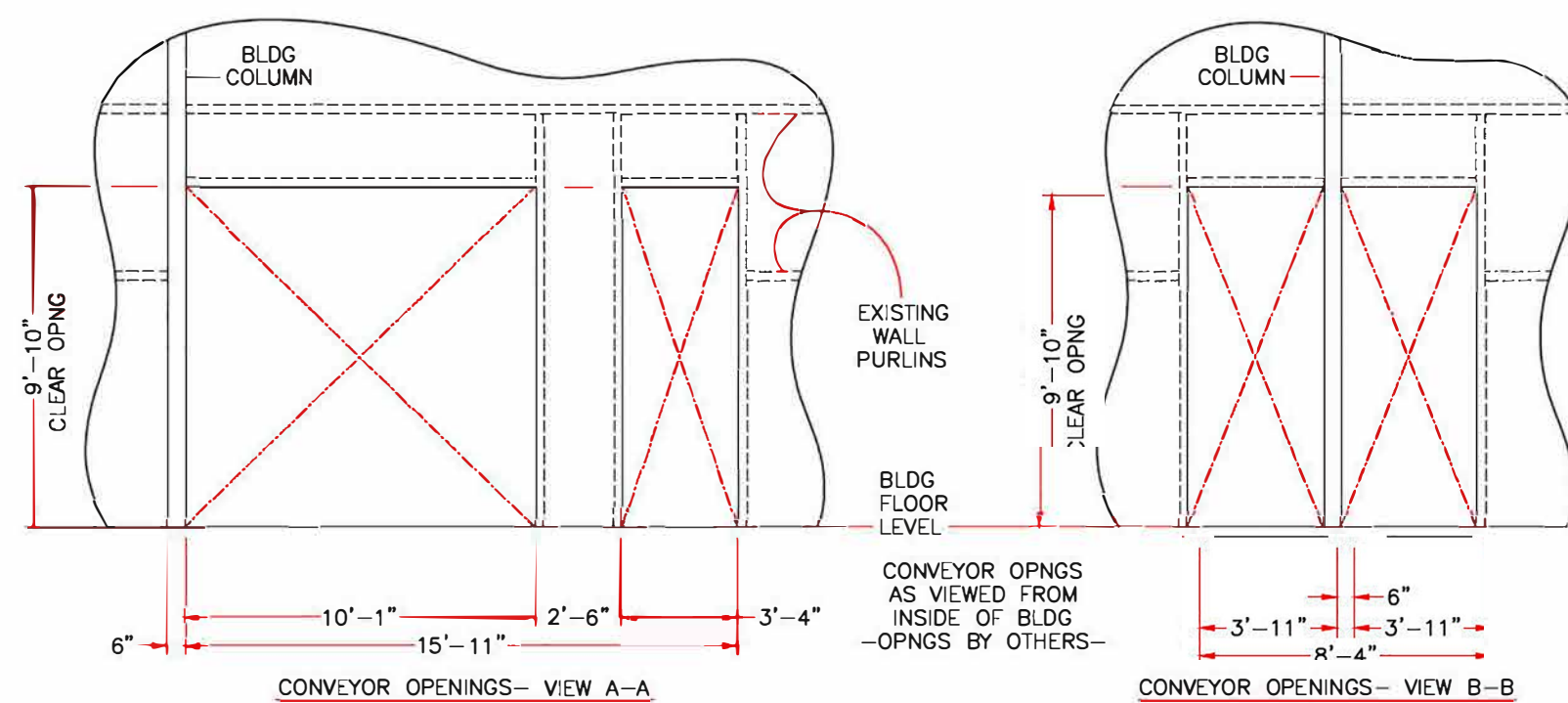
Insulated B-Deck Floor  
6" Thick Over Walls and Roof  
Enclosure Roof - 22ga Galvanized B-Deck / Walls 22ga Gray Prime B-deck

##### CONVEYOR SYSTEM

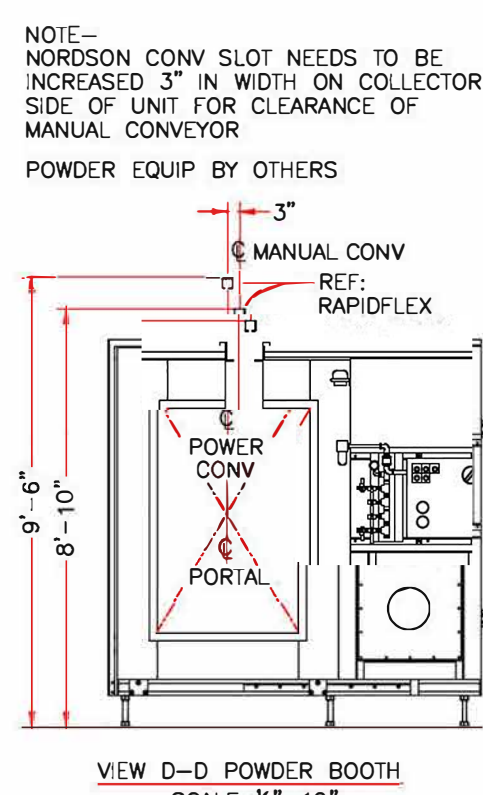
Rapidflex Enclosed Track Conveyor - 570 ft Running Length  
Floor Support Dwg. & B.D.M. by GAT - Fab. & Painted By I.C.F. - Installed by GAT  
Pendants on 8' centers  
Line Speed - 5 fpm Design Speed (3 to 9 fpm adjustable)  
Average Line Loading - 25#/ft  
Maximum Load Weight - 300# on 12' Centers  
650# Drive - Variable Speed A/C  
Air Operated Automatic Take-up  
Oven Expansion Joints as Required  
Automatic Chain Lubricator

##### POWDER COATING EQUIPMENT ENCLOSURE

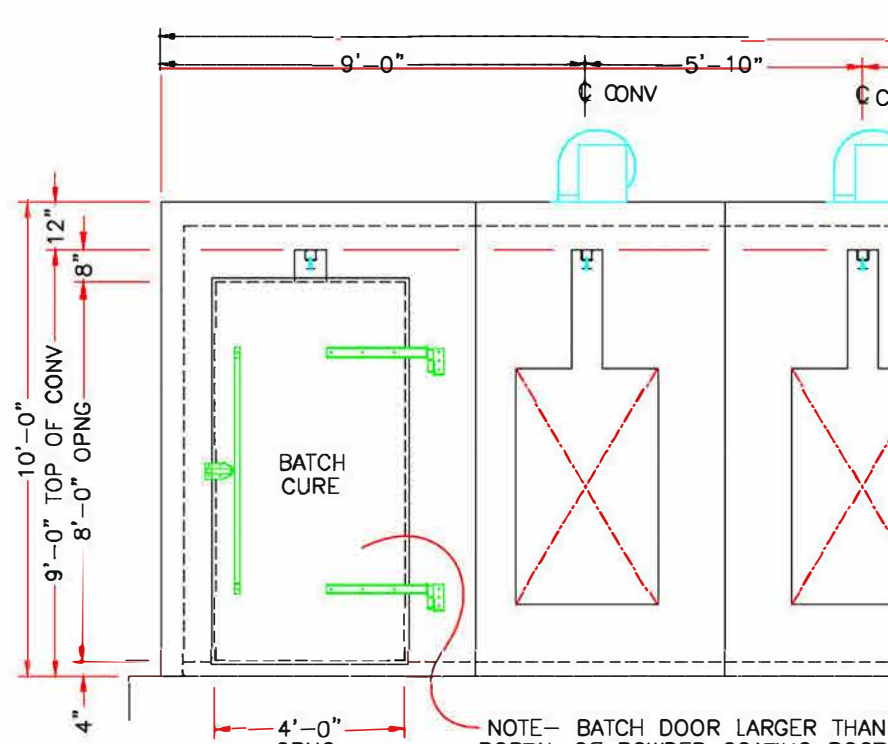
Walls - 3" Panels - .030 FRP Smooth Faced w/ 3" Structural Tube Framing  
Ceiling - 2" Panels - .030 FRP Smooth Faced (one side) w/ Bar Joist Supported  
Commercial Drop Ceiling Grid  
Fluorescent 4 Tube Flush Mount Light Fixtures - 9 ea.  
3'-0"x6'-8" Man Door - 1 ea.  
5'-0"x6'-8" Double Man Door - 1 ea.  
3'-0"x4'-0" Polycarbonate Viewing Window - 4 ea.  
Air Conditioning System - 15 Ton Capacity w/ Controls  
Condensing Unit Mounted on Grade outside



VIEW C-C SECTION-THRU WASHER  
SCALE-X/4"=12"



VIEW D-D POWDER BOOTH  
SCALE-X/4"=12"



VIEW E-E COMBINATION OVEN  
SCALE-X/4"=12"

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 REVISION WITH CHANGES AS INDICATED.

COMPANY

SIGNATURE DATE TITLE

Revision	
No.	Note
8	8-30-07 REDRAWN
9	9-13-07

**GAT**

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SCALE: 3/16"=12"

DATE: 8-30-07

CHK'D BY: [Signature]

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