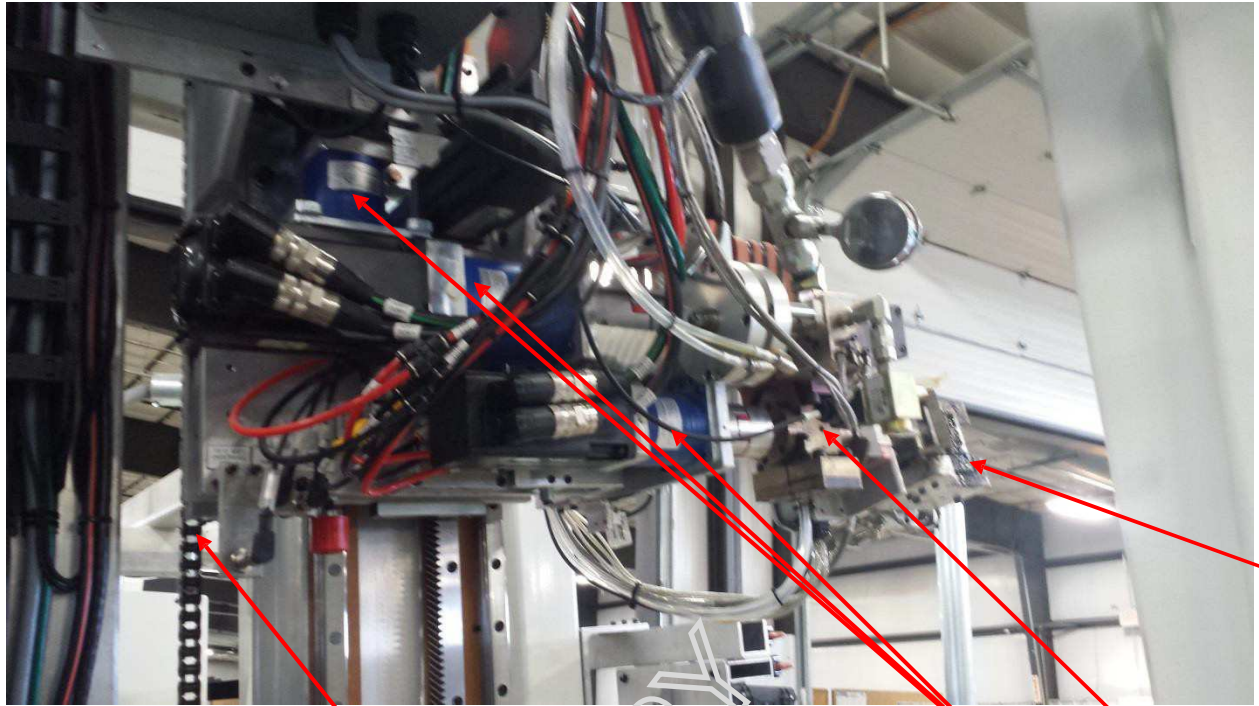


7500 TWO HEADED SEALER

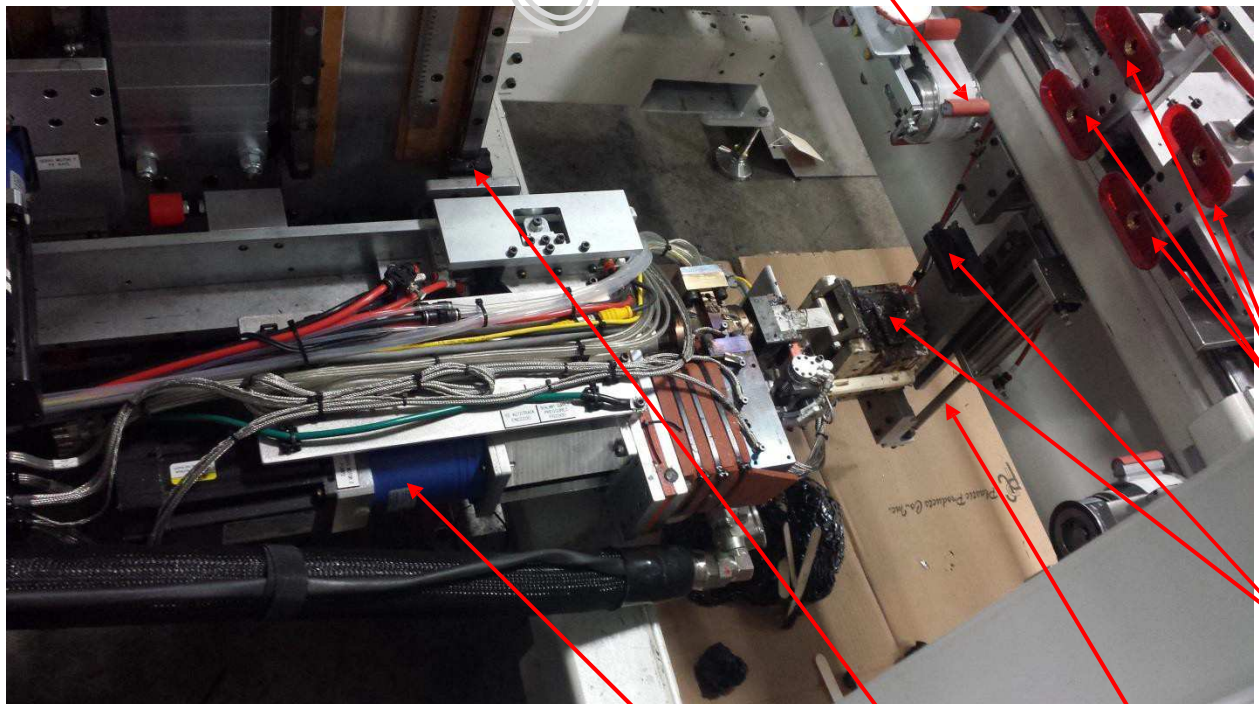
MAINTENANCE INSTRUCTIONS



Upper head



Lower head



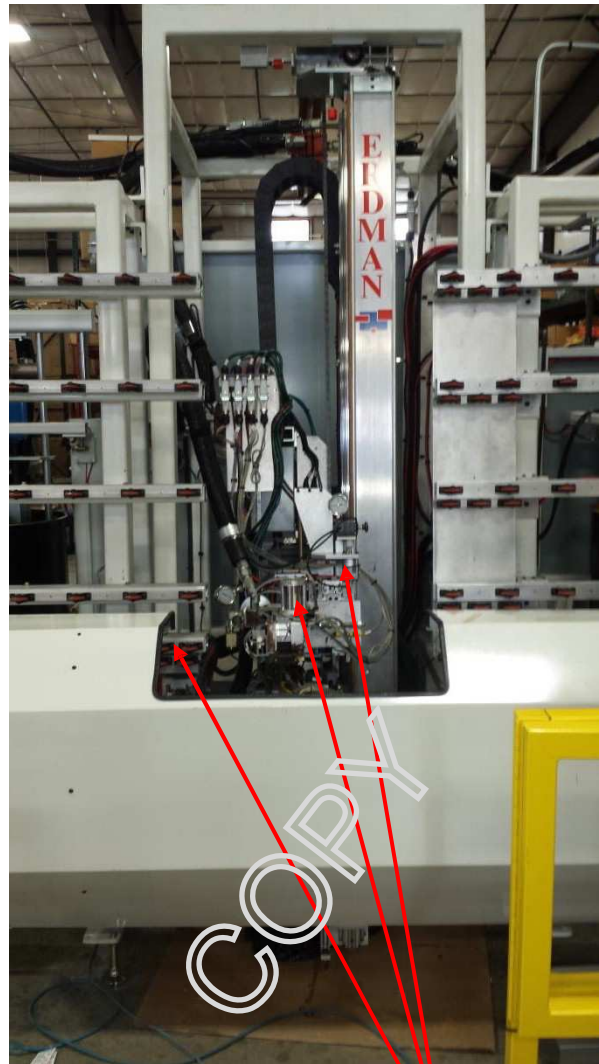


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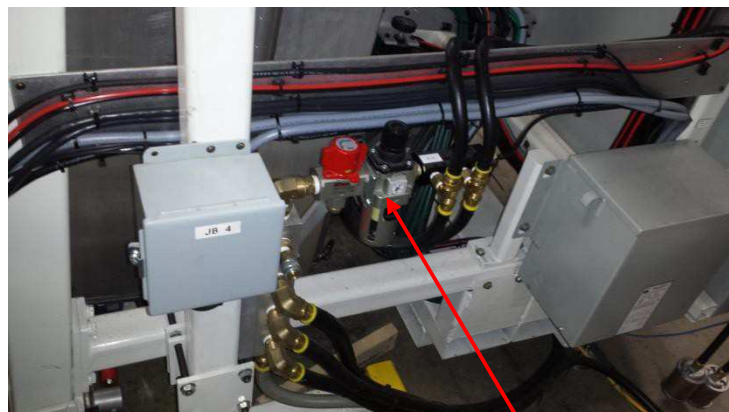
12

6

3



7



11



1. Precision Gear Box

- a. Location: Gantry drive, applicator head drive, pump drive (2), applicator head rotate (2), applicator head raise/lower, suction cup shuttle travel, infeed conveyor drive, out feed conveyor drive
- b. Lubricated for their service life by the manufacturer with a mineral oil-based lithium soap
- c. Inspect for leakage and damage



2. Roller Chain

- a. Location: Center counterweight
- b. Inspection: Check for dust build up. Check for tension, wear, abrasions. Replace per manufacturer's instructions and recommendations
- c. Type: Crown 363115-001 Chain Lube
- d. Frequency: Inspect and lubricate once per month



3. Transfer Roller

- a. Location: Vertical bed surface
- b. Inspect and replace as needed

Clean rollers with clean dry lint free rag (dampen rag with warm water if they need to be scrubbed)



4. Bearing

- a. Location: Transfer belt pulleys, infeed and out feed conveyor.
- b. Sealed and lubricated from the factory
- c. Inspect and replace as needed



5. THK bearings

- a. Location: Gantry travel, head travel (2), floating head setup (2), roller bed shift, vacuum shuttle travel, vacuum shuttle shift
- b. Pay special attention to Blocks and Rails

- c. Wipe any contaminants such as dust or silicone from rail surfaces daily at minimum, between shifts is preferred
- d. Type: NLGI 2 EP Lithium
- e. Frequency: Grease every 20,000 units or monthly



6. Spare nozzle heater box

- a. Location: Front center
- b. Clean interior as needed



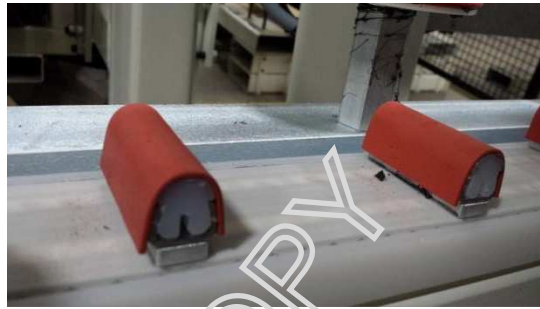
7. Air cylinder

- a. Location: Head shift, floating head setup, suction cup shuttle, applicator head, product stop
- b. Wipe any contaminants such as dust or silicone from rod surface



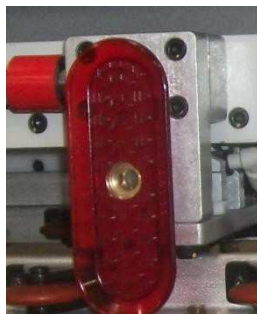
8. Dodge bearings

- a. Location: Gantry
- b. Type: NLGI 2 EP Lithium
- c. Frequency: Grease every 219,000 units or every 6 months



9. Conveyor Belt

- a. Location: Front shuttle
- b. Clean with lukewarm water. A mild soap may be used, dry with a soft cloth.
- c. Check for dust, silicone build up. Check for tension, wear, abrasions. Replace flight covers as needed



10. Suction cups

- a. Location: Front shuttle/stop
- b. Clean with lukewarm water. A mild soap may be used, dry with a soft cloth.
- c. Replace if damaged



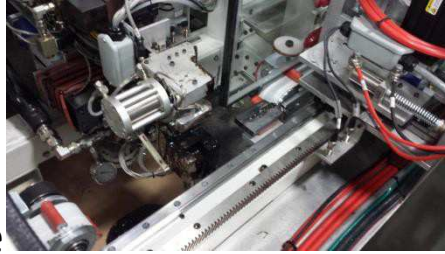
11. Pneumatic regulator

- a. Location: Back
- b. Check the amount of water in the collector
- c. Empty as needed



12. Vacuum pump

- a. Location: Front In-feed
- b. Check filter for clogging
- c. Clean and replace as needed



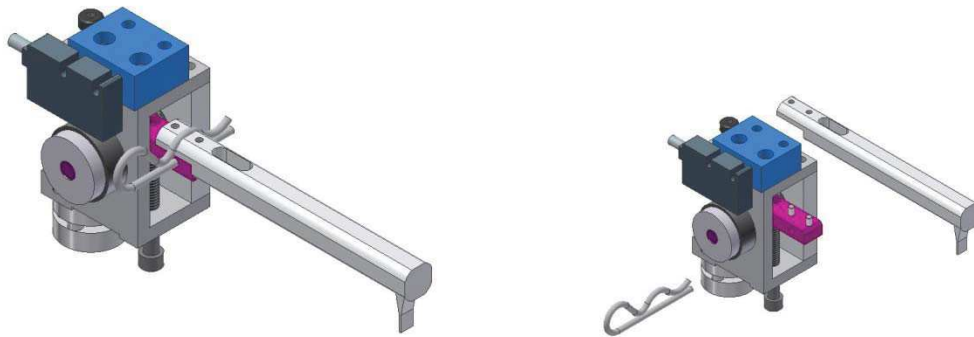
13. Corner wiper and nozzle

a. Location: Front center of machine.



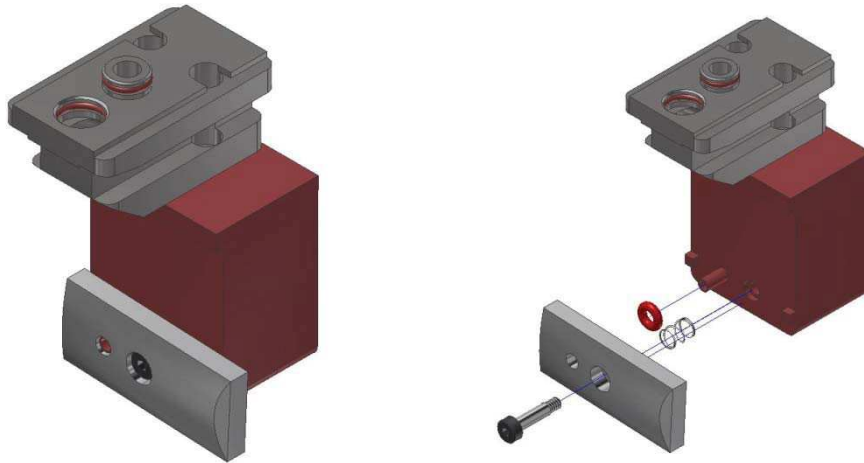
- b. While hot use tongue depressor to wipe excess sealant off nozzle and corner wiper. Be careful to not get burned. The nozzle and wiper will be hot.
- c. Should be done as need and or once per shift.

15. Upper and lower depth probe change out.



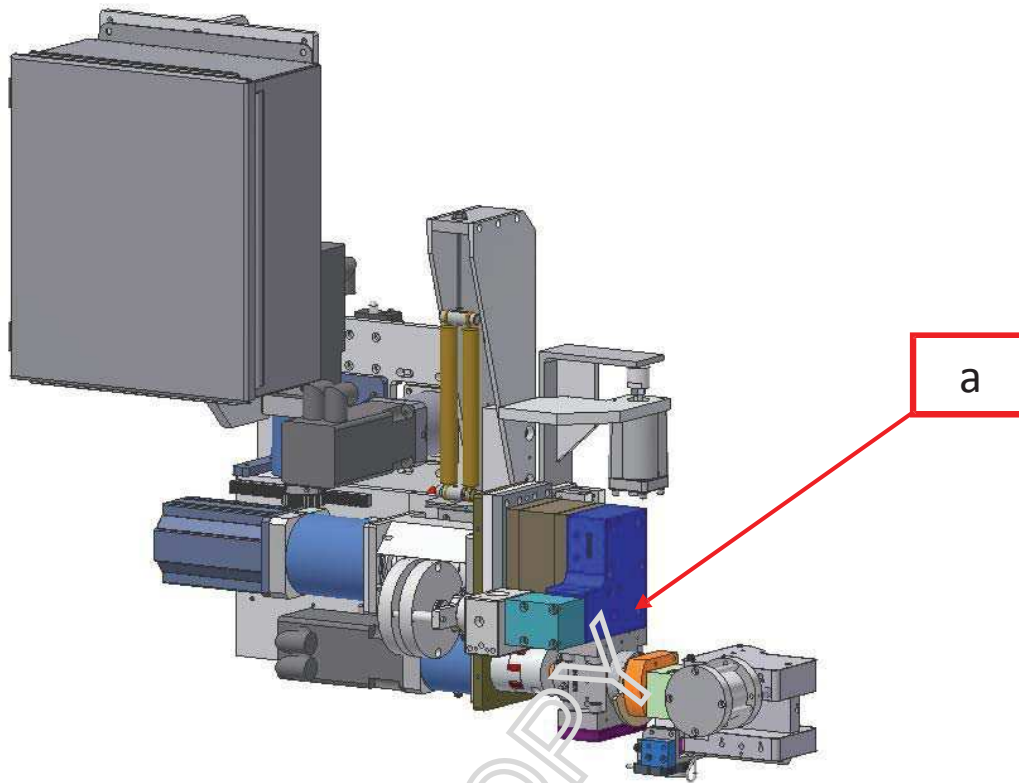
- a. Place machine into purge mode.
- b. Once in purge mode. Open the safety gate.
- c. Locate the desired probe to be changed out (upper or lower head)
- d. Remove the hitch pin clip.
- e. Lift depth probe off of dowel pins.
- f. Replace with new depth probe. (Be sure that new probe is located properly and seated in correct position over the dowel pins)
- g. Replace hitch pin clip.
- h. After exiting machine and closing safety gate. Take machine out of purge mode.
- i. Recalibrate machine for any variance in the new depth probe compare to the old.

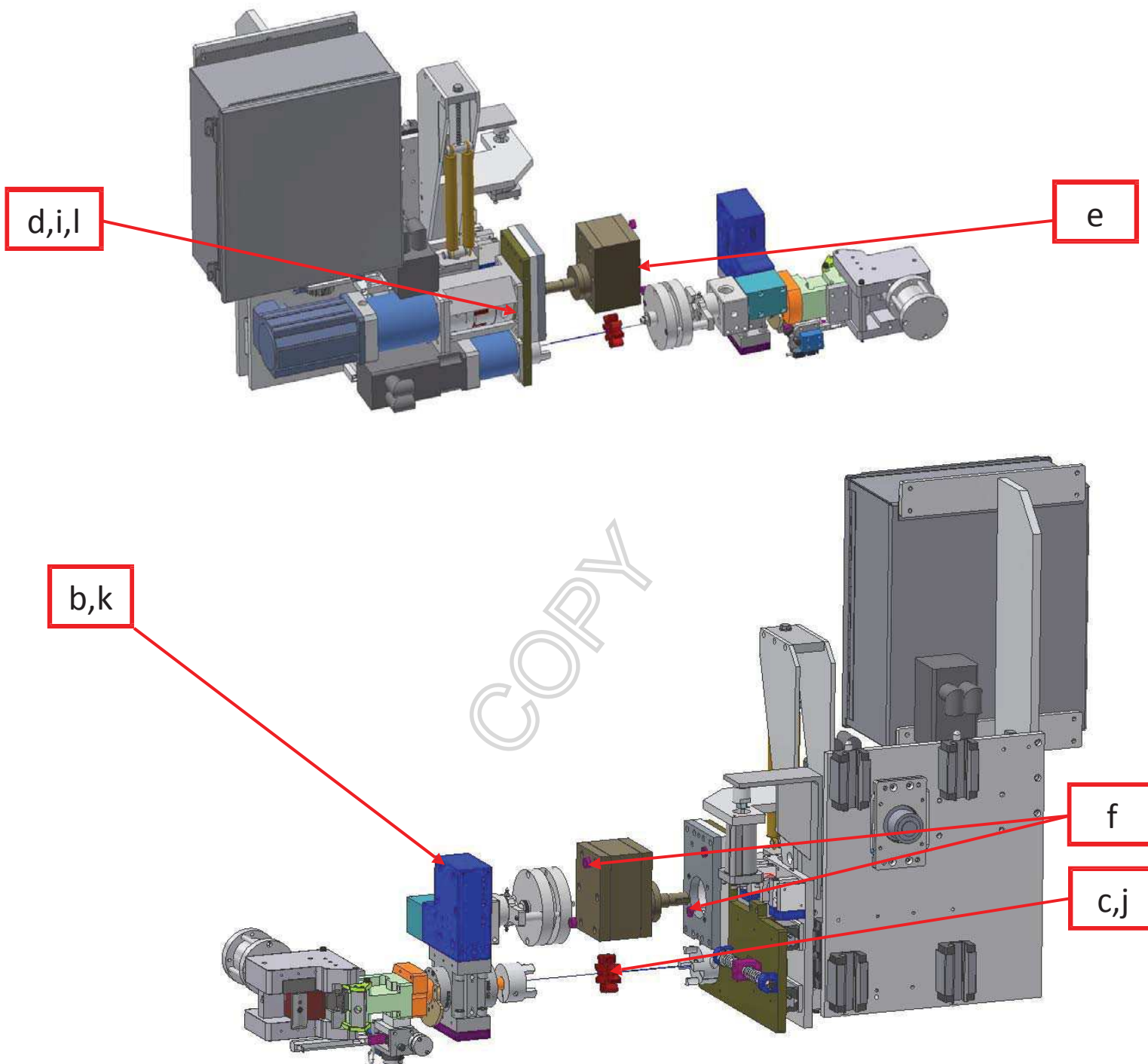
16. Nozzle pad change out



- a. With nozzle removed clean excess sealant from nozzle pad area.
- b. Remove shoulder bolt that retains the nozzle pad.
- c. Remove nozzle pad. (Be sure to retain the small spring behind the nozzle pad.)
- d. Remove and inspect nozzle pad O-ring.
- e. If O-ring appears to be ok reinstall or replace it.
- f. Place spring into spring pocket
- g. Install new nozzle pad.
- h. Reinstall and tighten shoulder bolt.
- i. Inspect all other O-rings before putting into service

17. Kawasaki change out





a. With machine powered down and cool. Locate pump and pump adapter plate and remove insulation from pump.

- b. Support and remove bolts from pump adapter plate.
- c. Separate the lovejoy coupler and pull adapter plate out of the way.
- d. Loosen the lovejoy coupler on the pump shaft.
- e. Remove Kawasaki pump.
- f. Remove bushings from Kawasaki pump.
- g. Clean all surfaces that mate to the new Kawasaki pump. (Must be free of any and all debris).
- h. Insert bushings into the new pump.
- i. Reinsert pump shaft into lovejoy coupler (Do not tighten).
- j. Bring adapter plate into alignment with the Kawasaki as well as realign the lovejoy coupler that turns the head.
- k. Replace the bolts into the adapter plate.
- l. Tighten the lovejoy coupler onto the pump shaft.
- m. Reinstall insulation around the pump.

18. Heater and RTD change out.

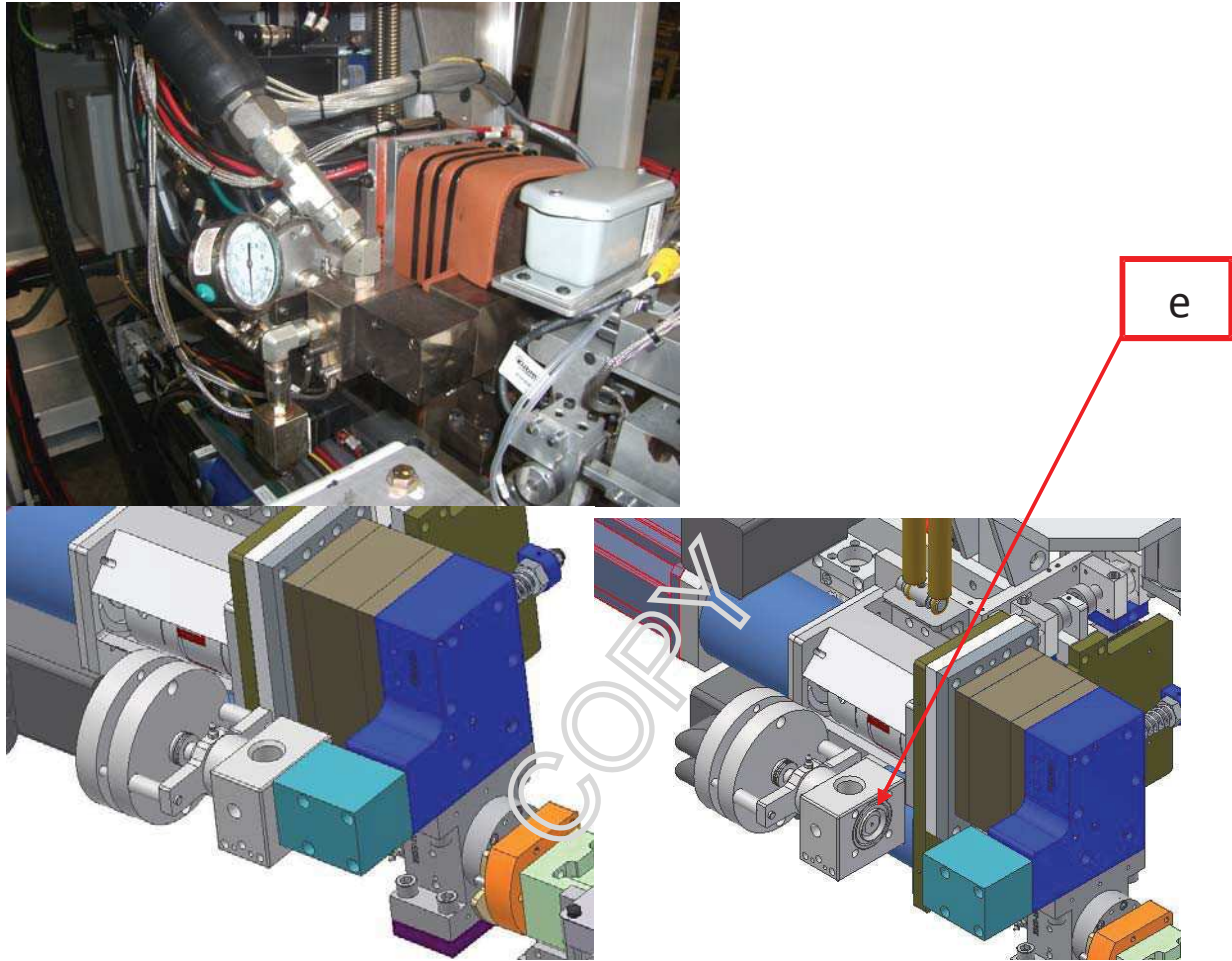


- a. With machine powered down. Determine which heater has failed by using an ohm meter to check resistance.(consult your wiring diagram for proper wattage and resistance)
- b. After locating faulty heater remove it by removing the retaining shoulder bolt.
- c. Gently pull the heater element out of the locating hole.
- d. Follow lead to plug.
- e. Unplug and disassemble the plug.

- f. Remove the faulty heater wires that are connected to the plug.
- g. Install new heater wires into plug and reassemble plug.
- h. Route the new heater lead in the same way the old heater lead was mounted.
- i. Use high temperature anti-seize (McMaster Carr part # 1367K51 or equivalent) on the heater probe.
- j. Place heater head into the locating hole.
- k. Reinstall the retaining shoulder bolt.

COPY

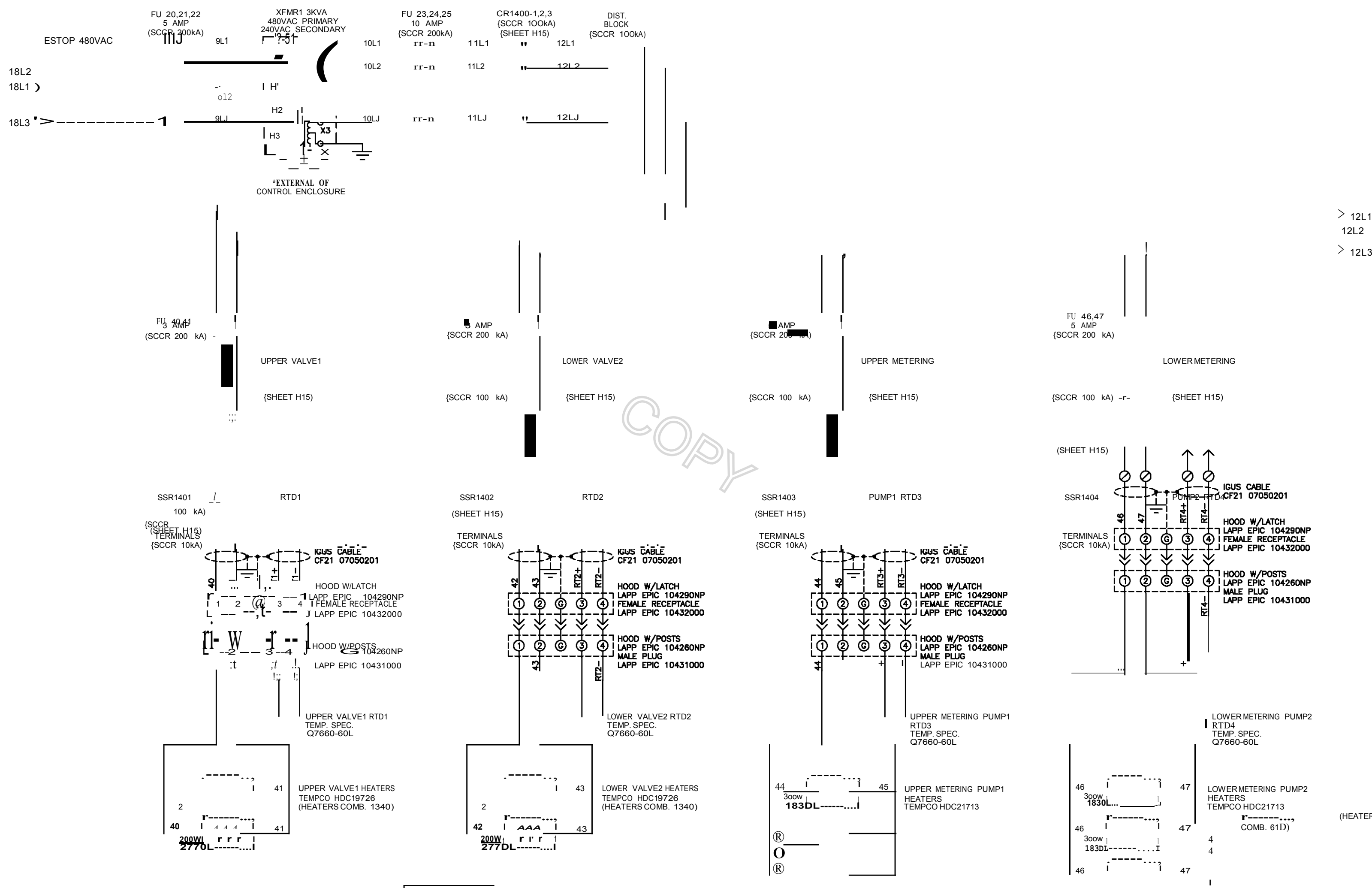
19. FMS valve replacement.

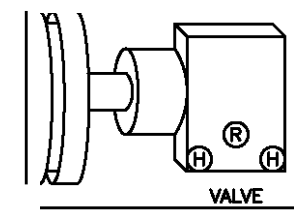


- a. With the machine cool and shut down locate the FMS valve that needs to be replaced.
- b. Remove the supply hose and pressure switch fittings and airlines.
- c. Remove heaters and RTD by removing the retaining shoulder bolts.
- d. Remove the 4 valve mounting bolts and remove valve. Take care to make sure the O-ring is removed as well.

- e. Unpack the new valve. Make sure that the Teflon O₂ ring is installed in new valve from manufacturer.
- f. Clean mating surfaces on the machine.
- g. Install new valve.
- h. Fill pressure switch fittings with Grease (Mobil 1 synthetic part# 121071)
- i. Use thread sealant (Loctite 565) on pressure switch fittings to install pressure switch.
- j. Reinstall the supply hose.
- k. Reinstall airlines.

COPY





(@) RTD TEMPERATURE SENSOR
@HEATER
O UNUSED HOLE

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Automation
Corp.
1603 S 14TH ST, Princeton, MN 55371

Description: IG GLAZER
HEATER CONNECTIONS

Drawn By: JPP Dwg: 131522 H5
Date: 3 / 2014 Sheet 5 of 17

COPY

SHEET H5
HEAT
24fNN.;

12L1)

12L2 /

12L3'

) 12L1

/ 12L2

' 12L3

3 AMP
(SCCR 200 leA) -

3 AMP
(SCCR 200 leA)

3 AMP
(SCCR 200 leA)

FU 54,55
3 AMP
(SCCR 200 leA)

(SHEET H13)

(SCCR 100 leA)

(SHEET H13)

(SCCR 100 leA)

(SHEET H13)

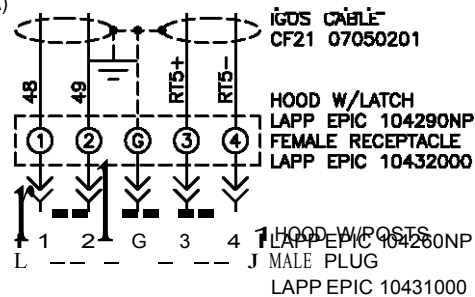
SSR1500

(SCCR 100 leA)

(SHEET H13)

SSR1405
(SCCR 100 kA)
TERMINALS
(SCCR 10kA)

UPPER NOZZLE1
RTDS



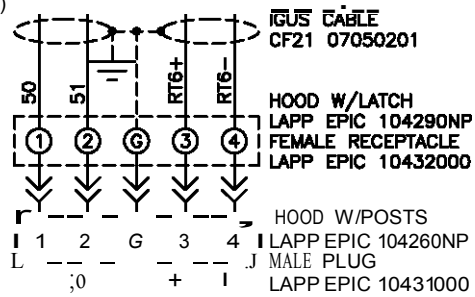
18/5 SIUCONE CABLE
SAB 1271805

2"x4" JUNCTION BOX
WITH WAGO SPRING
TERMINALS

RTDS

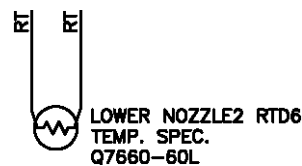
SSR1406
(SHEET H13)
TERMINALS
(SCCR 10kA)

LOWER NOZZLE2
RTD6



18/5 SIUCONE CABLE
SAB 1271805

2"x4" JUNCTION BOX
WITH WAGO SPRING
TERMINALS

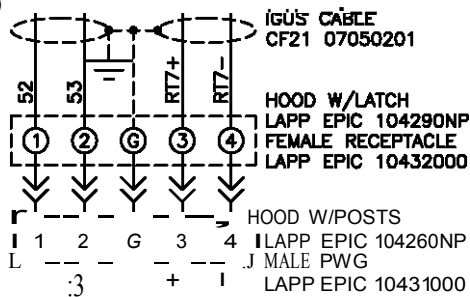


LOWER NOZZLE2 RTD6
TEMP. SPEC.
Q7660-60L

51 LOWER NOZZLE2
HEATERS
TEMPCO HDC19726
(HEATERS COMB, 920)

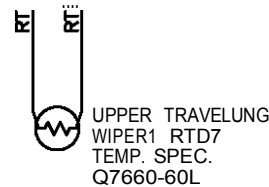
SSR1407
(SHEET H13)
TERMINALS
(SCCR 10kA)

UPPER TRAVELLING
WIPER1 RT07



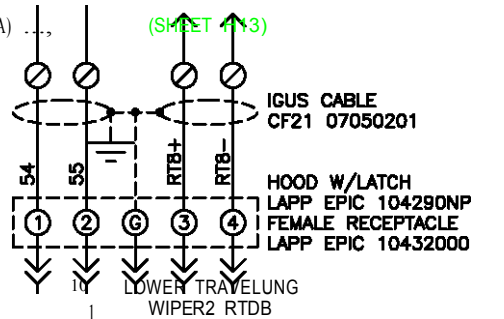
18/5 SIUCONE CABLE
SAB 1271805

2"x4" JUNCTION BOX
WITH WAGO SPRING
TERMINALS



UPPER TRAVELUNG
WIPER1 RTD7
TEMP. SPEC.
Q7660-60L

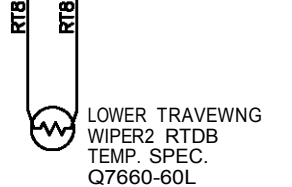
53 UPPER TRAVELUNG
WIPER1 HEATERS
TEMPCO HDC19726
(HEATERS COMB, 1340)



HOOD W/POSTS
LAPP EPIC 104260NP
MALE PLUG
LAPP EPIC 10431000

18/5 SIUCONE CABLE
SAB 1271805

2"x4" JUNCTION BOX
WITH WAGO SPRING
TERMINALS



LOWER TRAVELUNG
WIPER2 RTDB
TEMP. SPEC.
Q7660-60L

55 LOWER TRAVELUNG
WIPER2 HEATERS
TEMPCO HDC19726
(HEATERS COMB, 1340)

2 2770.____WJ V

____, ... ---
____, ...
,
2ððwj'VV
2770.....-----

@ RTD TEMPERATURE SENSOR
@HEATER

2 2770.____'i¥I

____, ... ---, ...

2 2770.____j V

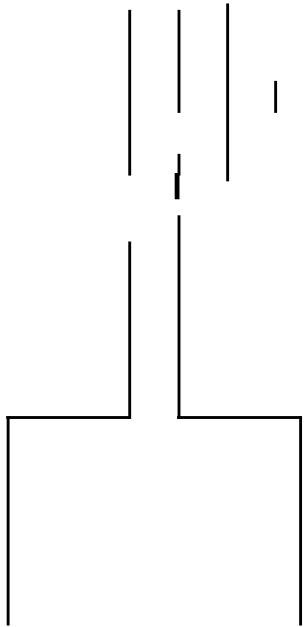
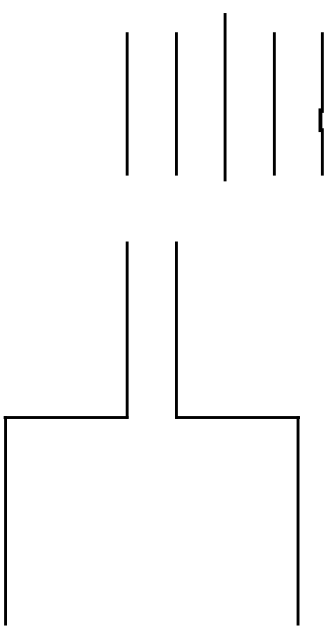
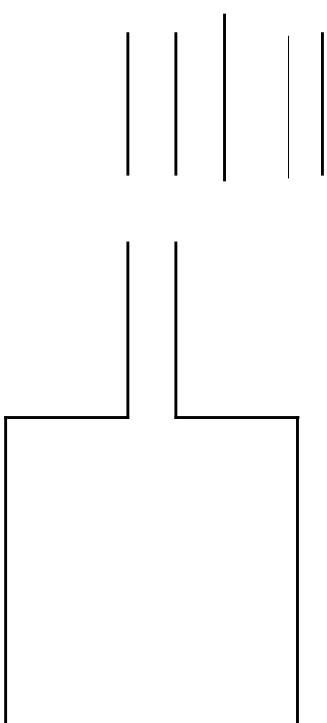
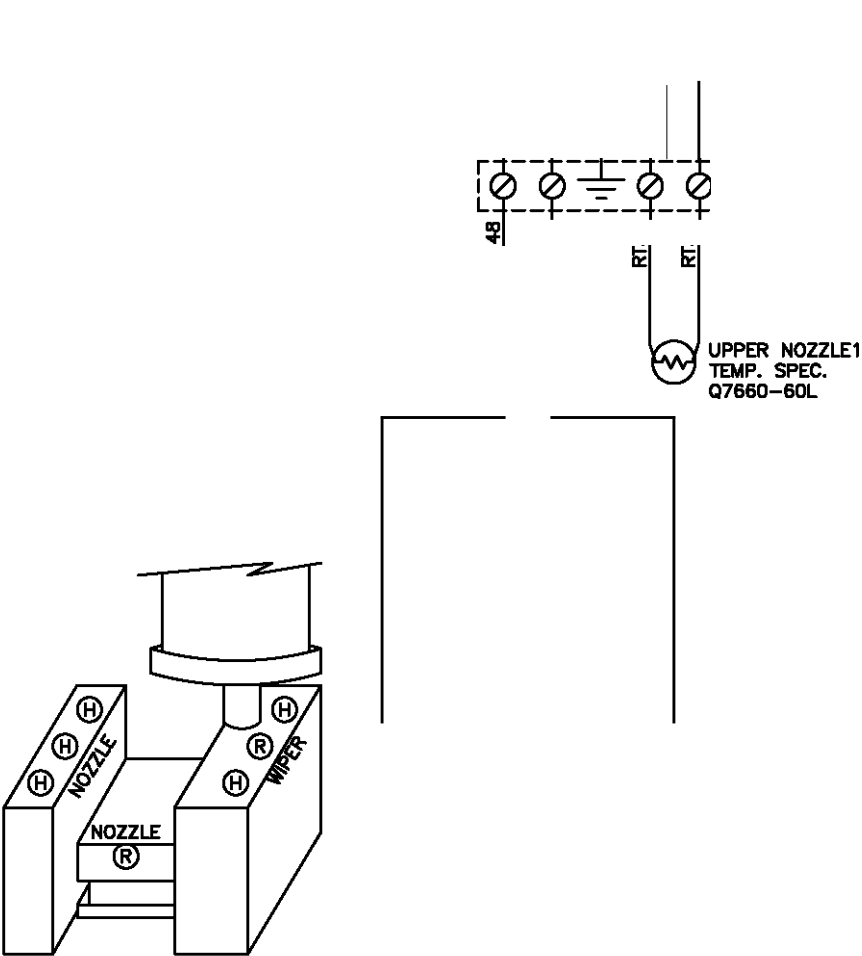
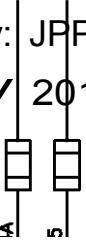
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Automation Corp.
1603 S 14TH ST, Princeton, MN 55371

Description: IG GLAZER
HEATER CONNECTIONS

Drawn By: JPP Dwg:131522 H6
Date: 3 / 2014 Sheet 6 of 17



SHEET H5
HEAT
240VAC

12L1 "
12L2,"
12L3

" 12L1
" 12L2
12L3

2 AMP
(SCCR 2DD kA)

SSR1501
{SCCR 10D kA}
{SHEET H15}

TERMINALS
(SCCR 10kA)

{SHEET H15}
FIXE
D WIPER RTD9

2 AMP
(SCCR 2DD kA)

SSR1502
{SHEET H15}

TERMINALS
(SCCR 10kA)

EXTRA NOZZLE

{SHEET H15}
STORAGE BOX
RT010

FU 6D,61
3 AMP
(SCCR 2DO kA)

SSR1503
{SHEET H15}

TERMINALS
(SCCR 10kA)

{SHEET H15}
MANIFOLD RT011

HOOD W/POSTS
LAPP EPIC 10429000
FEMALE RECEPTACLE
J LAPP EPIC 1D432000

HOOD W/POSTS
LAPP EPIC 10426DNP
LAPP EPIC 10431000

EXTRA NOZZLE STORAGE
BOX RT010
TEMP. SPEC.
Q766D-6DL

MANIFOLD RT011
TEMP. SPEC.
Q766D-60L

FIXED WIPER HEATER
TEMPCO HDC19726

EXTRA NOZZLE STORAGE
BOX HEATERS
TEMPCO HDC19726
{HEATERS COMB. 1340}

MANIFOLD HEATERS
TEMPCO HDC19726
(HEATERS COMB. 1340)

B
A
C
K

@

R

TO
TEMPERATU
RE SENSOR

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Description: IG GLAZER
T
L

Drawn By: JPP | Dwg:
131522 H7

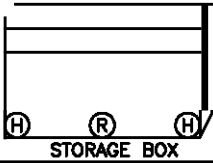
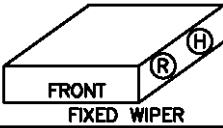
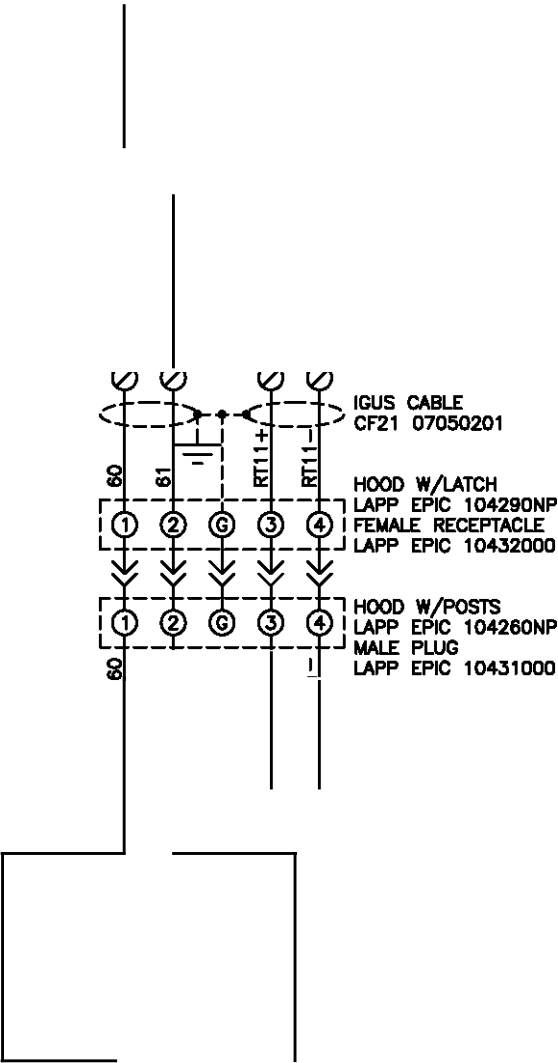
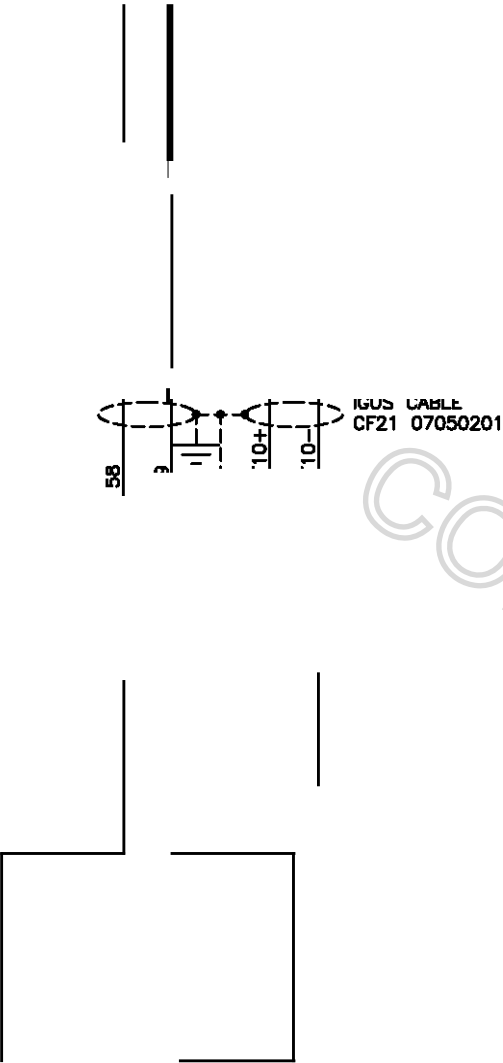
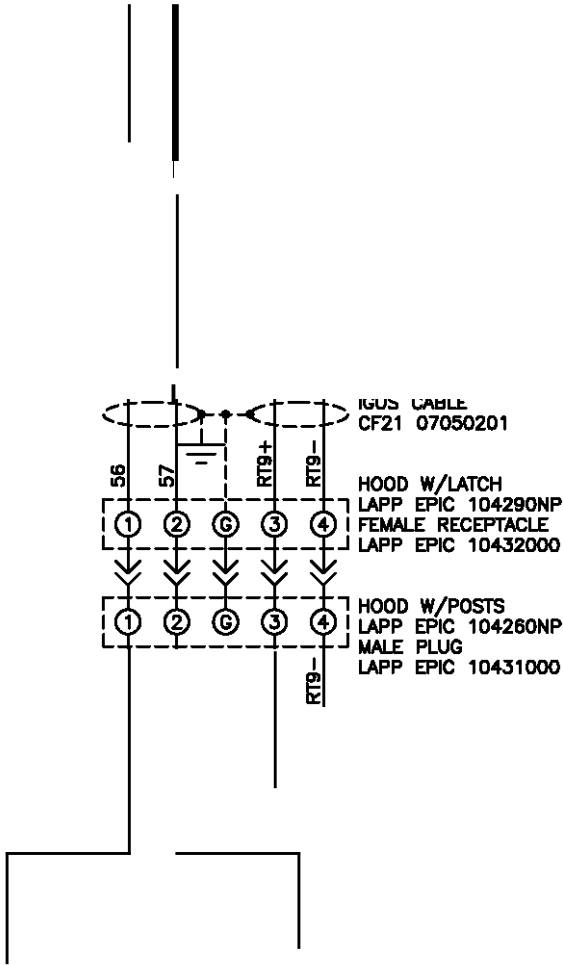
1603 S 14TH ST, Princeton, MN 55371

Date: 3 / 2014

| Sheet 7 of 17

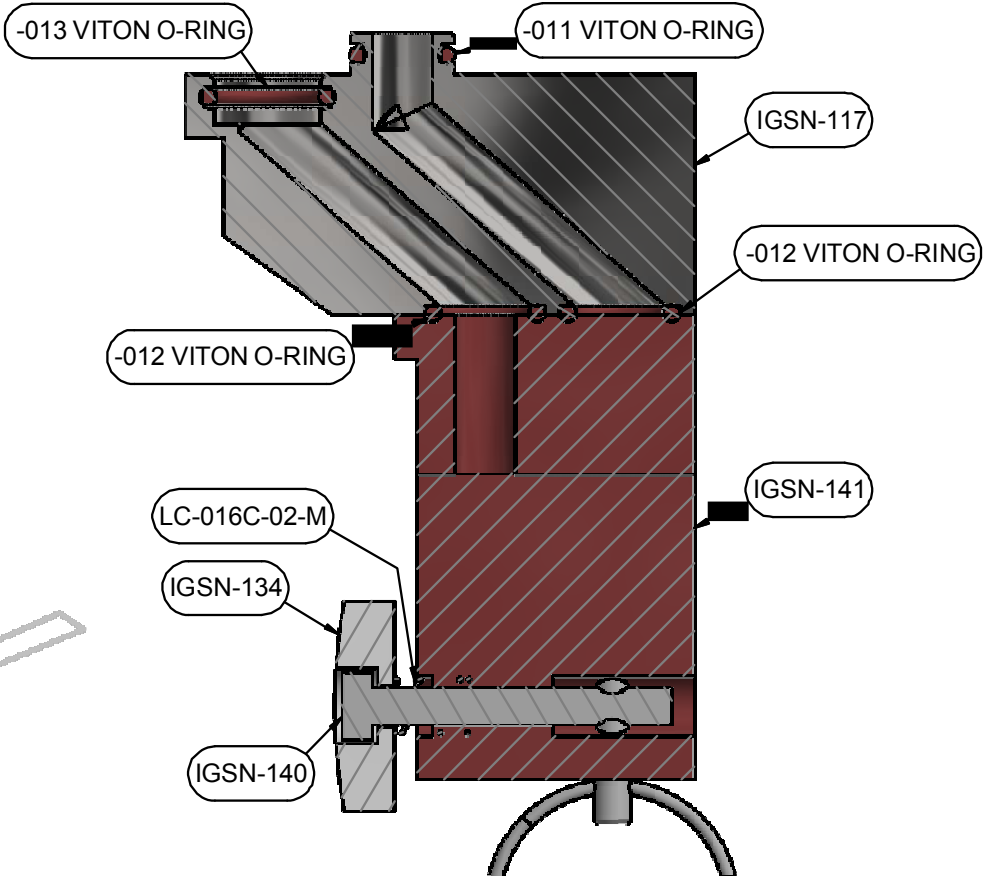
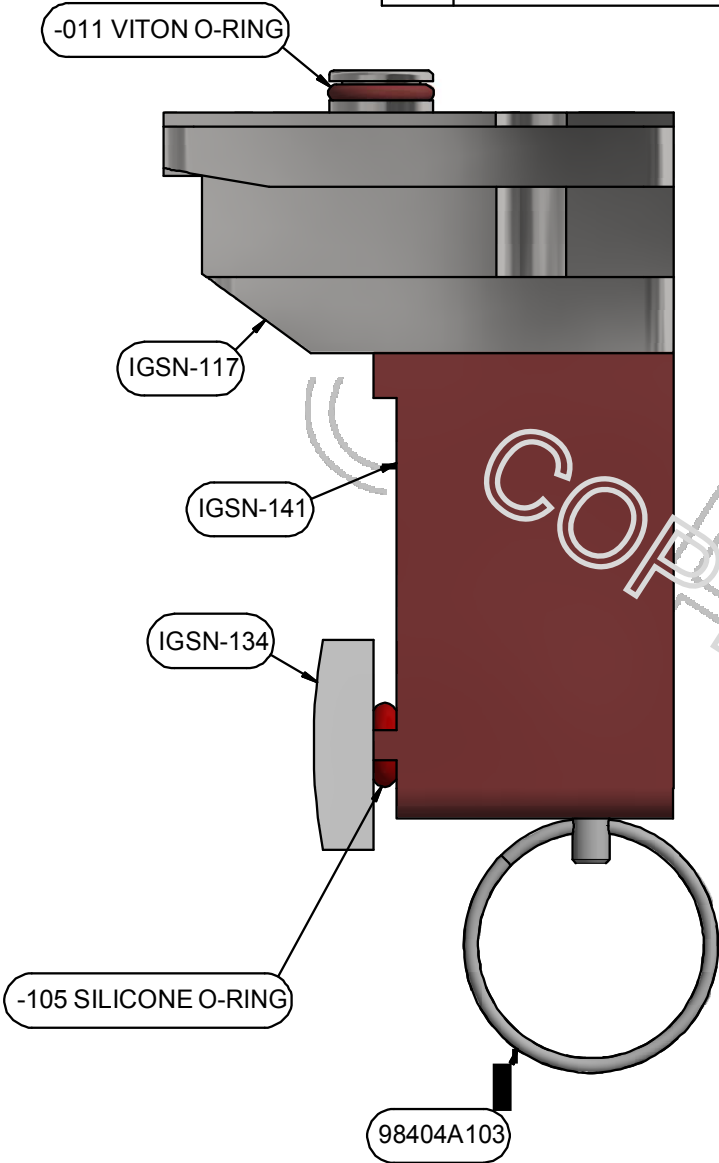
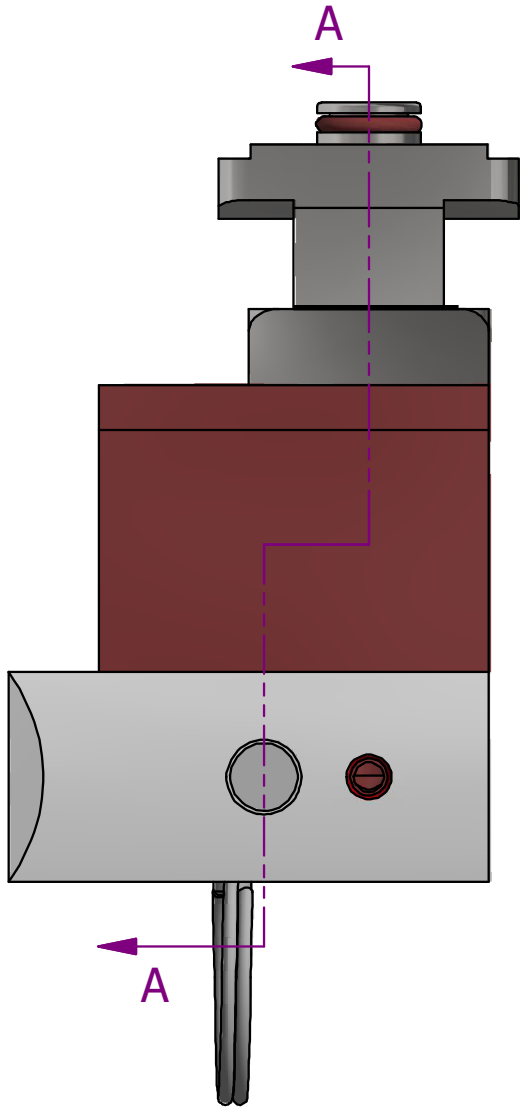
@HEATER

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HEATER CONNECTIONS	

PARTS LIST			
QTY	PART NUMBER	DESCRIPTION	VENDOR
1	IGSN-117	NOZZLE BODY ADAPTER - DUAL PORT	
1	IGSN-134	NOZZLE TIP INSERT , 7/32" GLASS SPACER (REGULAR WIDTH SHOE)	
1	IGSN-140	NOZZLE SHOE RETAINING PIN	
1	IGSN-141	NOZZLE TIP BASE, 7/32" GLASS SPACER	
1	LC-016C-02-M	LEE SPRING, .240 O.D., .016 WIRE DIA, .750 FREE LENGTH, ENDS ARE GROUND, MUSIC WIRE	LEE SPRING
1	-011 VITON O-RING	-011 VITON O-RING, 5/16" ID X 7/16" OD X 1/16" CS	LUTZ
2	-012 VITON O-RING	-012 VITON O-RING, 3/8" ID X 1/2" OD X 1/16" CS	LUTZ
1	-013 VITON O-RING	-013 VITON O-RING, 7/16" ID X 9/16" OD X 1/16" CS	LUTZ
1	-105 SILICONE O-RING	-105 SILICONE O-RING, 5/32" ID X 11/32" OD X 3/32" CS SS	LUTZ
1	98404A103	QUICK-RELEASE PIN, 5/32" DIA, 1" USEABLE LENGTH	MCMaster CARR



REPLACES

STOCKING STATUS

MIN

MAX

STANDARD PART

TOLERANCES:
UNLESS OTHERWISE
SPECIFIED

X = ± 0.1

.XX = ± 0.02

XXX = ± 0.005

.XXXX = ± 0.0005

ANGULAR ± 1°

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SHEET: 1 OF 1

MFG By:

DESIGNED BY: GWD

Y: GWD

DRAWN B: 6/6/2016

DRAWN DATE:

ERDMAN Automation Corp.
1603 So. 14th Street, Princeton, MN 55371

PART NAME: IG NOZZLE ASSEMBLY, 7/32" GLASS SPACER, SINGLE PUMP, QUICK RELEASE PIN, PLASTIC SHOE.

FINISH: AS SPECIFIED

MATERIAL: AS SPECIFIED

REV:

PART #:

IGSN-A19

RETRO #

MFG Date:

MFG

Quantity:

150736+A19+1+1

Sawing Time:

Machining Time:

Welding Time:

Paint Time:

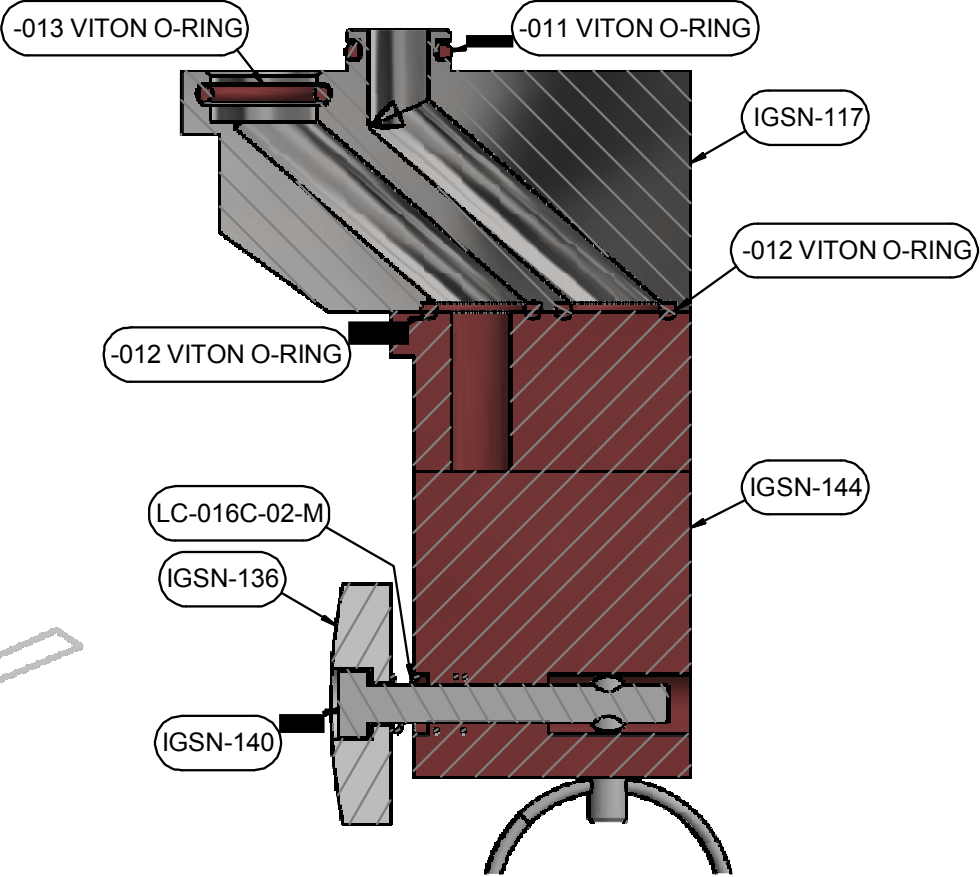
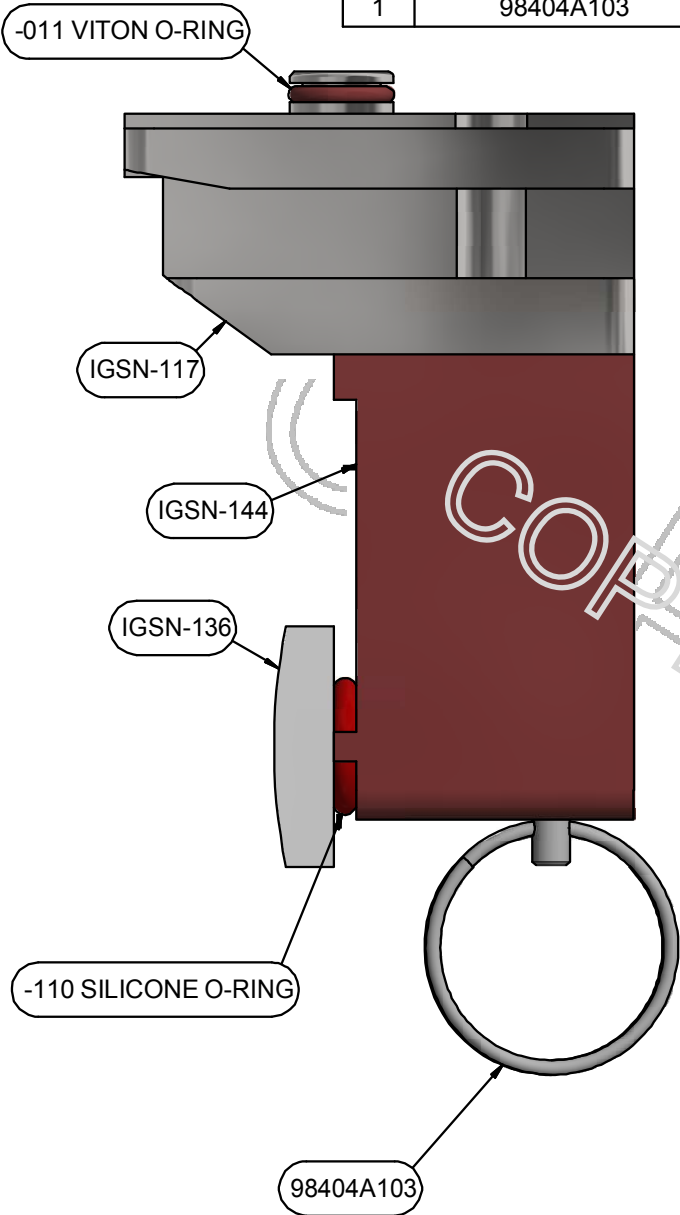
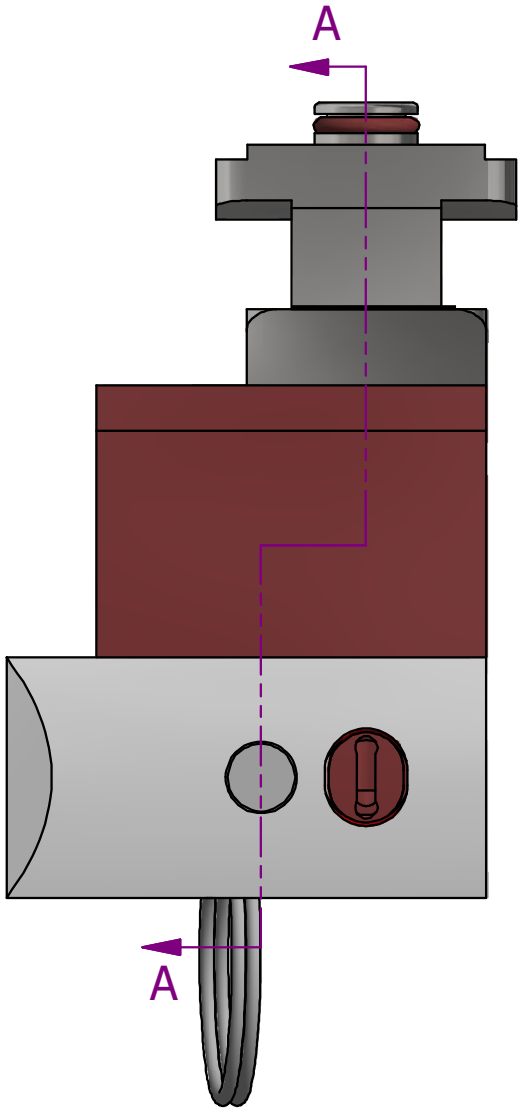
Finishing:

Misc. Time/Cost:

Erdman Job #:

150736

COPY



PARTS LIST			
QTY	PART NUMBER	DESCRIPTION	VENDOR
1	IGSN-117	NOZZLE BODY ADAPTER - DUAL PORT	
1	IGSN-136	NOZZLE TIP INSERT , 7/16" GLASS SPACER (WIDE SHOE)	
1	IGSN-140	NOZZLE SHOE RETAINING PIN	
1	IGSN-144	NOZZLE BLOCK WELDMENT, 7/16" GLASS SPACER	
1	LC-016C-02-M	LEE SPRING, .240 O.D., .016 WIRE DIA, .750 FREE LENGTH, ENDS ARE GROUND, MUSIC WIRE	LEE SPRING
1	-011 VITON O-RING	-011 VITON O-RING, 5/16" ID X 7/16" OD X 1/16" CS	LUTZ
2	-012 VITON O-RING	-012 VITON O-RING, 3/8" ID X 1/2" OD X 1/16" CS	LUTZ
1	-013 VITON O-RING	-013 VITON O-RING, 7/16" ID X 9/16" OD X 1/16" CS	LUTZ
1	-110 SILICONE O-RING	-110 SILICONE O-RING, 3/8" ID X 9/16" OD X 3/32" CS	LUTZ
1	98404A103	SS QUICK-RELEASE PIN, 5/32" DIA, 1" USEABLE LENGTH	MCMaster CARR

REPLACES

STOCKING STATUS

MIN

MAX

STANDARD PART

TOLERANCES:
UNLESS OTHERWISE
SPECIFIED

$X = \pm 0.1$

$.XX = \pm 0.02$

$.XXX = \pm 0.005$

$.XXXX = \pm 0.0005$

ANGULAR $\pm 1^\circ$

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DESIGNED BY: CLS

Y: GWD

DRAWN B

6/6/2016

DRAWN DATE:

ERDMAN
Automation
Corp.
1603 So. 14th Street, Princeton, MN 55371

PART NAME: IG NOZZLE ASSEMBLY, 7/16" GLASS SPACER, SINGLE PUMP, QUICK RELEASE PIN, PLASTIC SHOE.

FINISH: AS SPECIFIED

MATERIAL: AS SPECIFIED

REV:

PART #:

IGSN-A20
RETRO #

MFG By:

MFG Date:

MFG

Quantity:

DRAWING
SIZE
B

SHEET:
1 OF 1
MFG By:

USED IN:

MFG Date:

MFG

Quantity:

150736+A20+1+1

Sawing Time:

Machining Time:

Welding Time:

Paint Time:

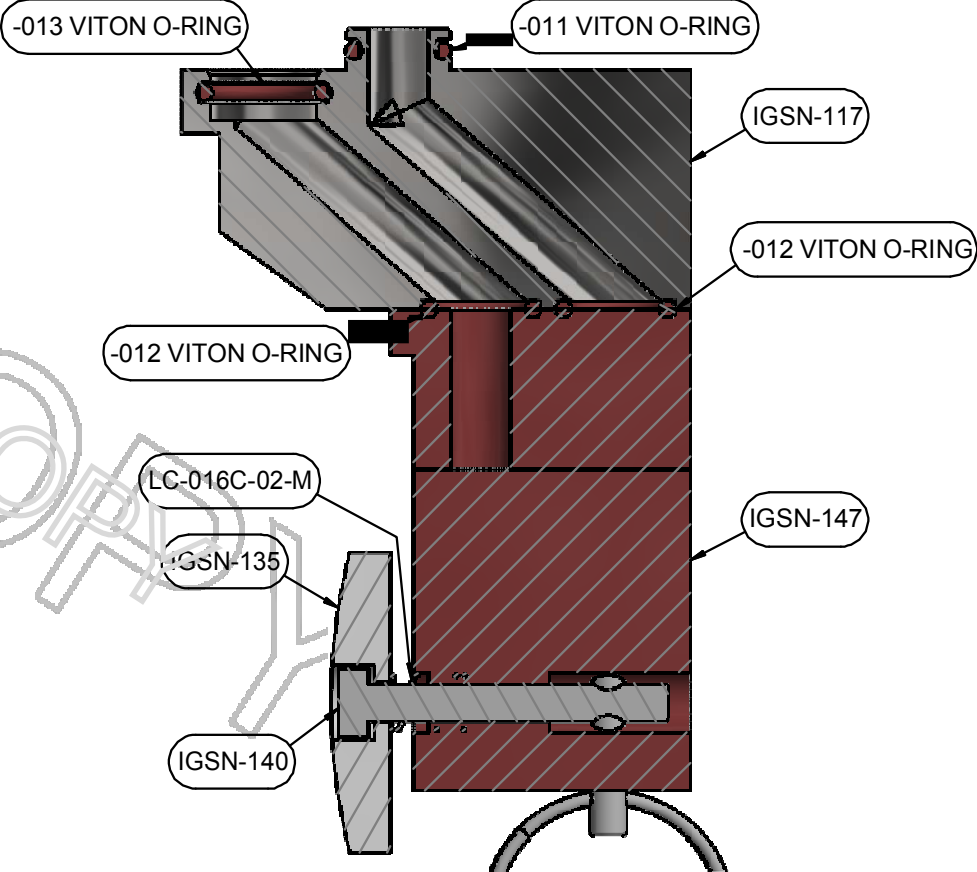
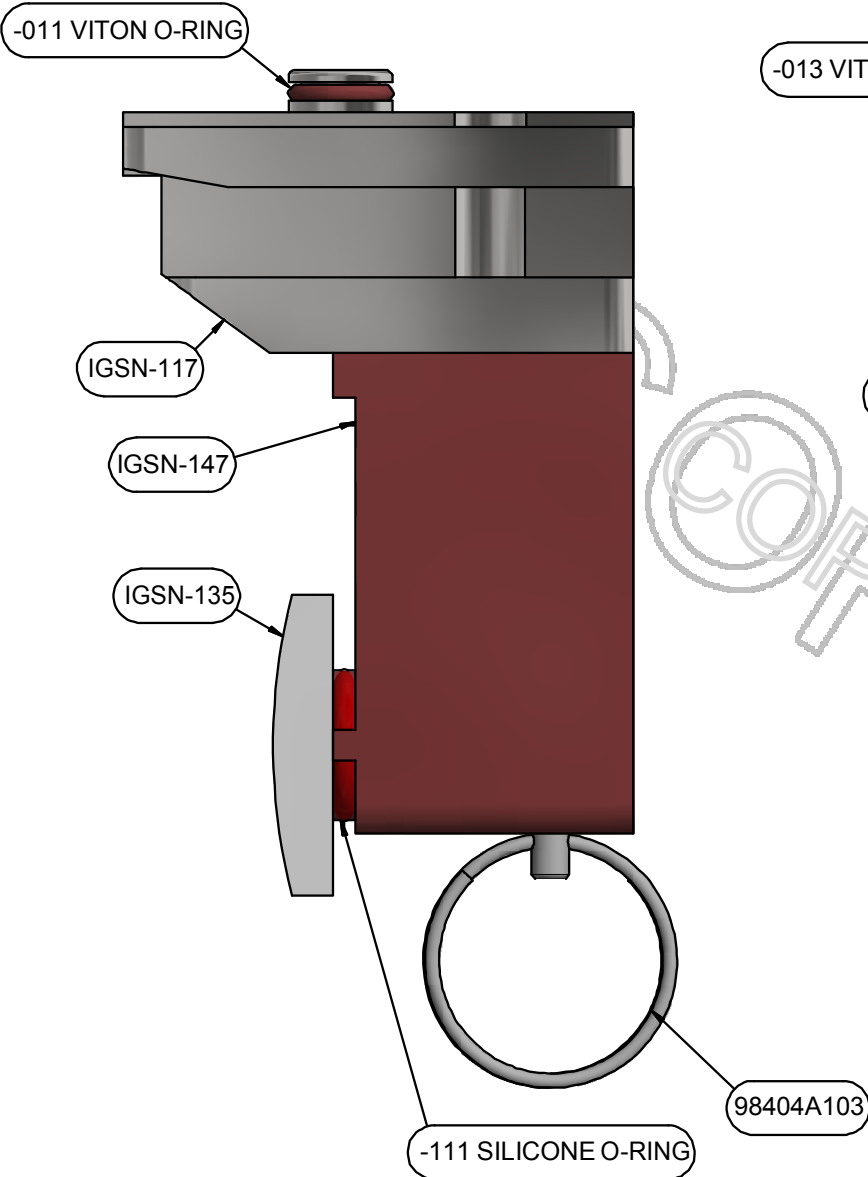
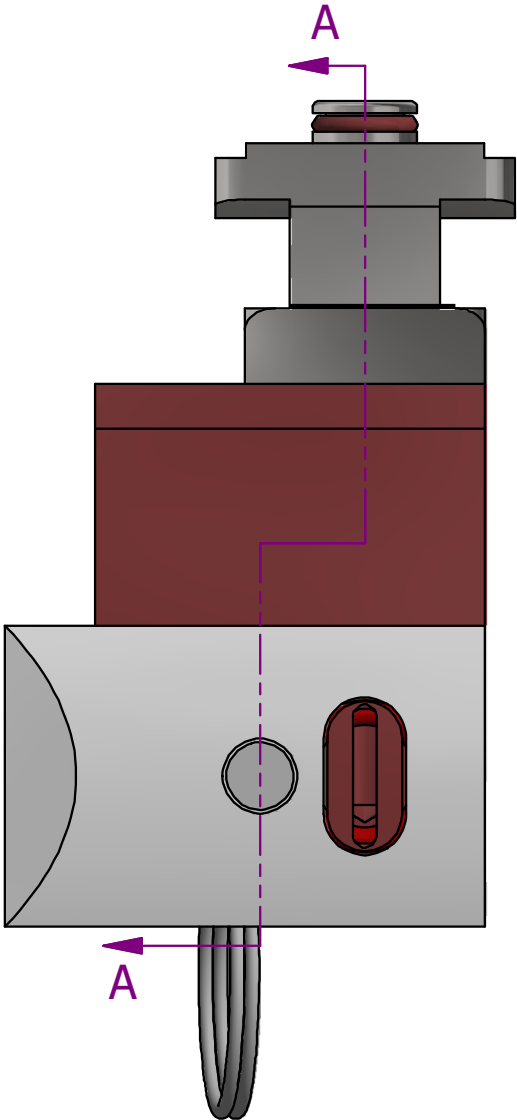
Finishing:

Misc. Time/Cost:

Erdman Job #:

150736

COPY



PARTS LIST			
QTY	PART NUMBER	DESCRIPTION	VENDOR
1	IGSN-117	NOZZLE BODY ADAPTER - DUAL PORT	
1	IGSN-135	NOZZLE TIP INSERT , 11/16" GLASS SPACER (REGULAR WIDTH SHOE)	
1	IGSN-140	NOZZLE SHOE RETAINING PIN	
1	IGSN-147	NOZZLE BLOCK WELDMENT, 11/16" GLASS SPACER	
1	LC-016C-02-M	LEE SPRING, .240 O.D., .016 WIRE DIA, .750 FREE LENGTH, ENDS ARE GROUND, MUSIC WIRE	LEE SPRING
1	-011 VITON O-RING	-011 VITON O-RING, 5/16" ID X 7/16" OD X 1/16" CS	LUTZ
2	-012 VITON O-RING	-012 VITON O-RING, 3/8" ID X 1/2" OD X 1/16" CS	LUTZ
1	-013 VITON O-RING	-013 VITON O-RING, 7/16" ID X 9/16" OD X 1/16" CS	LUTZ
1	-111 SILICONE O-RING	-111 SILICONE O-RING, 7/16" ID X 5/8" OD X 3/32" CS	LUTZ
1	98404A103	SS QUICK-RELEASE PIN, 5/32" DIA, 1" USEABLE LENGTH	MCMaster CARR

REPLACES

STOCKING STATUS

MIN

MAX

STANDARD PART

TOLERANCES:
UNLESS OTHERWISE
SPECIFIED

$.X = \pm 0.1$

$.XX = \pm 0.02$

$.XXX = \pm 0.005$

$.XXXX = \pm 0.0005$

ANGULAR $\pm 1^\circ$

REMOVE ALL BURRS & SHARP EDGES
SAND RADIUS ALL CORNERS (1/8"-1/4") UNLESS NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.

DO NOT SCALE THIS DRAWING

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DRAWING SIZE
B

DESIGNED BY: GWD
DRAWN BY: GWD
DRAWN DATE: 6/6/2016

ERDMAN Automation Corp.
1603 So. 14th Street, Princeton, MN 55371

PART NAME: IG NOZZLE ASSEMBLY, 11/16" GLASS SPACER, SINGLE PUMPQUICK RELEASE PIN, PLASTIC SHOE.

REV:

FINISH: AS SPECIFIED
MATERIAL: AS SPECIFIED

PART #:

SHEET: 1 OF 1
RETRO #

USED IN:

FAB Qty: 1

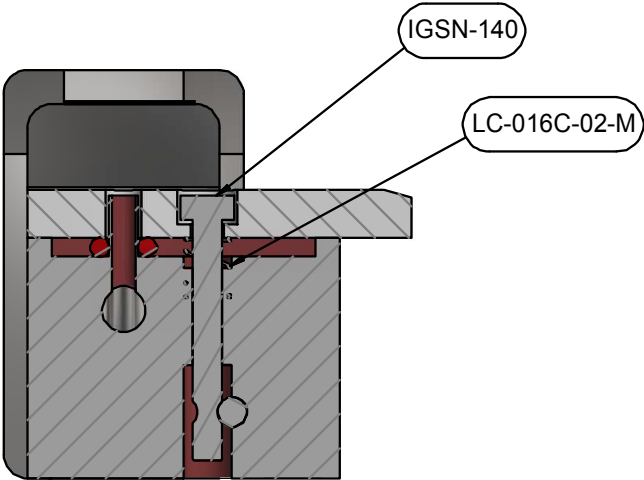
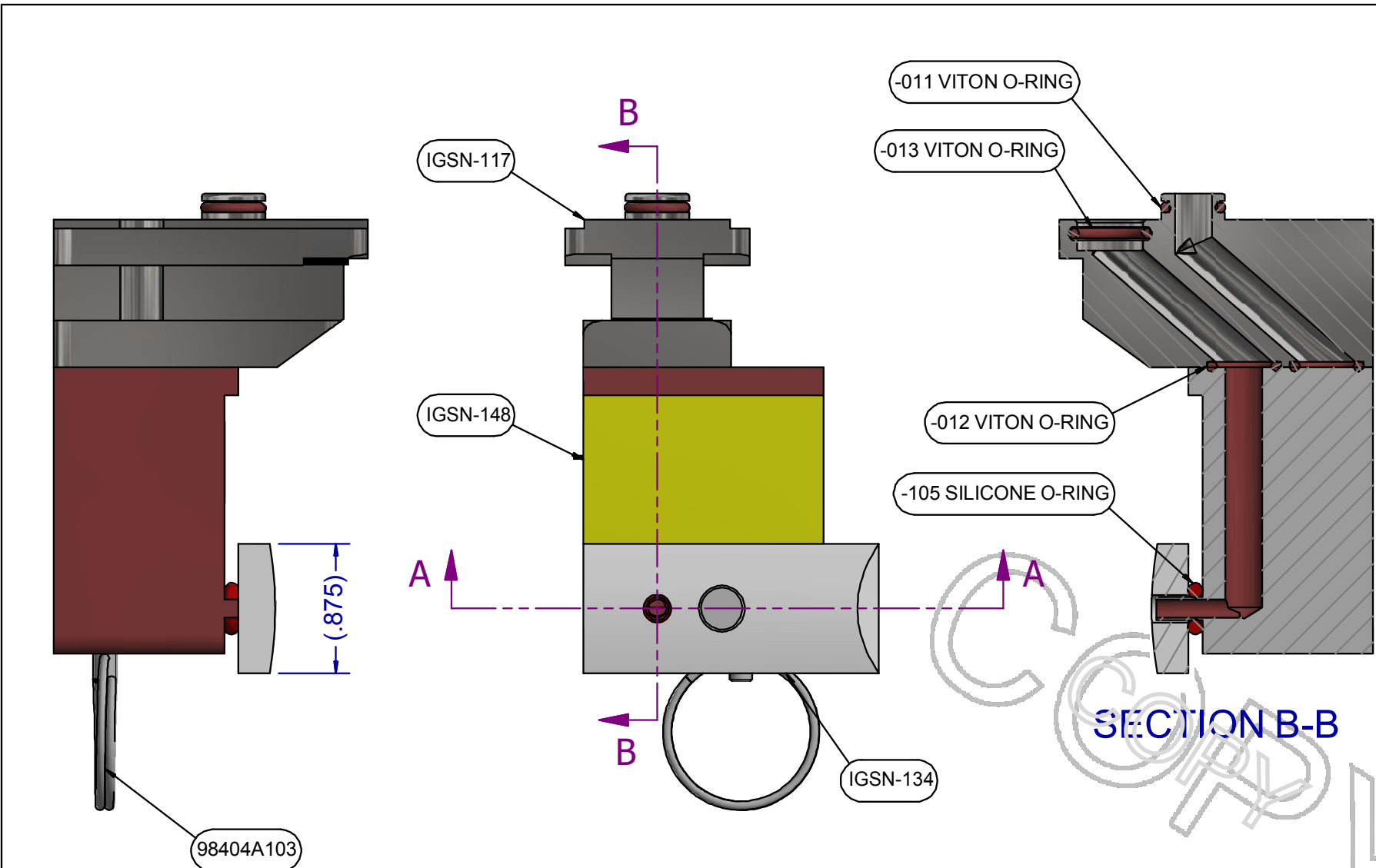
Erdman Job #: 150736

MFG By:

MFG Date:

MFG Quantity:

150736+A21+1+1



SECTION A-A

PARTS LIST			
QTY	PART NUMBER	DESCRIPTION	VENDOR
1	IGSN-117	NOZZLE BODY ADAPTER - DUAL PORT	
1	IGSN-134	NOZZLE TIP INSERT , 7/32" GLASS SPACER (REGULAR WIDTH SHOE)	
1	IGSN-140	NOZZLE SHOE RETAINING PIN	
1	IGSN-148	NOZZLE TIP BASE, 7/32" GLASS SPACER (FOR OPPOSITE-HAND HEAD)	
1	LC-016C-02-M	LEE SPRING, .240 O.D., .016 WIRE DIA, .750 FREE LENGTH, ENDS ARE GROUND, MUSIC WIRE	LEE SPRING
1	-011 VITON O-RING	-011 VITON O-RING, 5/16" ID X 7/16" OD X 1/16" CS	LUTZ
2	-012 VITON O-RING	-012 VITON O-RING, 3/8" ID X 1/2" OD X 1/16" CS	LUTZ
1	-013 VITON O-RING	-013 VITON O-RING, 7/16" ID X 9/16" OD X 1/16" CS	LUTZ
1	-105 SILICONE O-RING	-105 SILICONE O-RING, 5/32" ID X 11/32" OD X 3/32" CS	LUTZ
1	98404A103	SS QUICK-RELEASE PIN, 5/32" DIA, 1" USEABLE LENGTH	MCMASTER CARR

REPLACES

STOCKING STATUS

MIN

MAX

STANDARD PART

TOLERANCES:
UNLESS OTHERWISE
SPECIFIED

.X = ± 0.1
.XX = ± 0.02
ANGULAR ± 1°

XXX = ± 0.005
.XXXX = ± 0.0005

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DESIGNED BY: BLH
DRAWN BY: BLH
DRAWN DATE: 6/6/2016

ERDMAN
Automation Corp.
1603 So. 14th Street, Princeton, MN 55371

PART NAME: IG NOZZLE ASSEMBLY, 7/32" GLASS SPACER, SINGLE PUMP (FOR OPPOSITE-HAND HEAD) QUICK RELEASE PIN, PLASTIC SHOE.

FINISH: AS SPECIFIED
MATERIAL: AS SPECIFIED

REV:

PART #:

IGSN-A22

FAB Qty: 1

Erdman Job #: 150736

MFG By:

MFG Date:

MFG Quantity:

DRAWING
SIZE

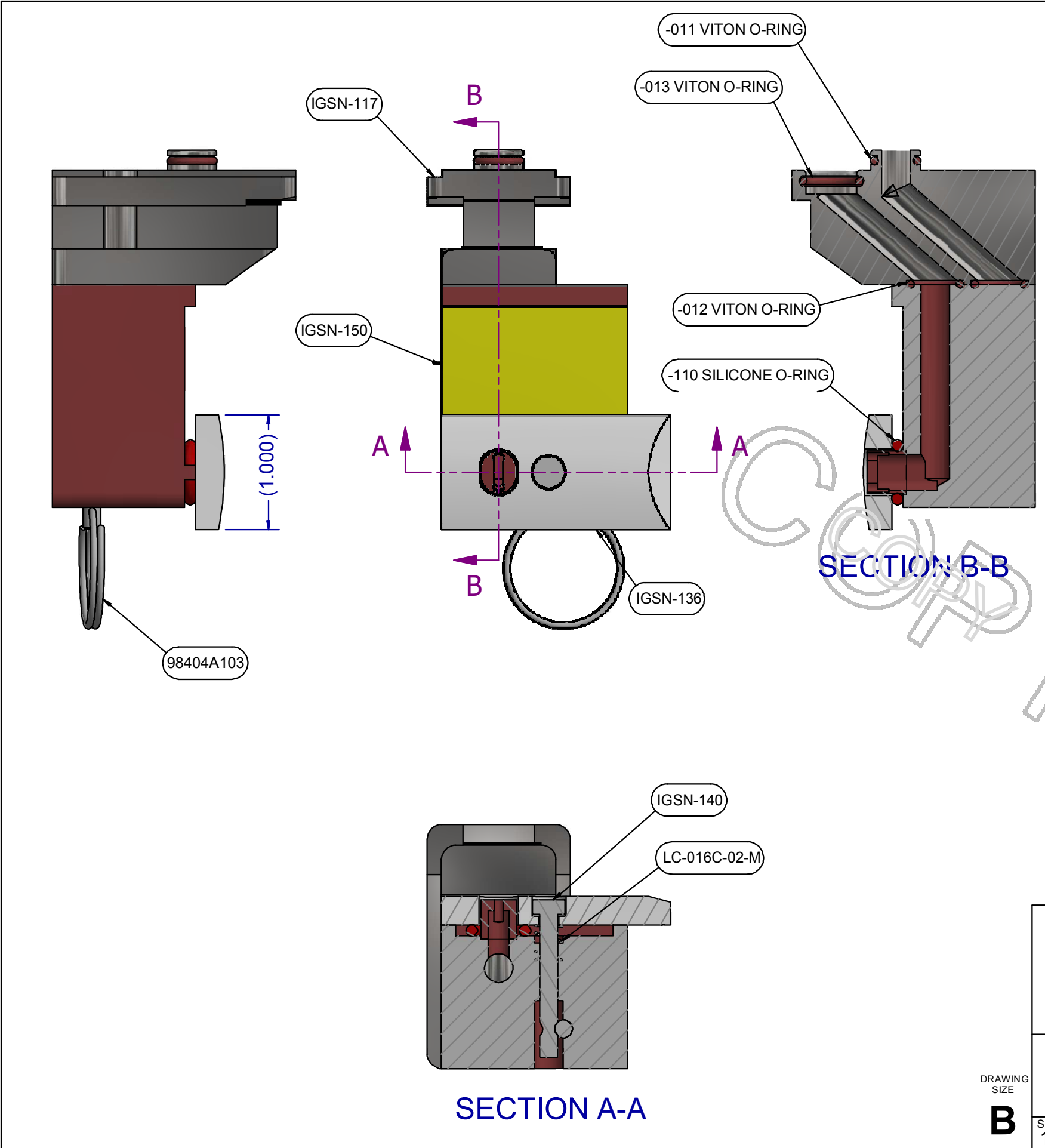
B

SHEET:
1 OF 1

RETRO #

USED IN:

150736+A22+1+1



PARTS LIST			
QTY	PART NUMBER	DESCRIPTION	VENDOR
1	IGSN-117	NOZZLE BODY ADAPTER - DUAL PORT	
1	IGSN-136	NOZZLE TIP INSERT , 7/16" GLASS SPACER (WIDE SHOE)	
1	IGSN-140	NOZZLE SHOE RETAINING PIN	
1	IGSN-150	NOZZLE BLOCK WELDMENT, 7/16" GLASS SPACER (FOR OPPOSITE-HAND HEAD)	
1	LC-016C-02-M	LEE SPRING, .240 O.D., .016 WIRE DIA, .750 FREE LENGTH, ENDS ARE GROUND, MUSIC WIRE	LEE SPRING
1	-011 VITON O-RING	-011 VITON O-RING, 5/16" ID X 7/16" OD X 1/16" CS	LUTZ
2	-012 VITON O-RING	-012 VITON O-RING, 3/8" ID X 1/2" OD X 1/16" CS	LUTZ
1	-013 VITON O-RING	-013 VITON O-RING, 7/16" ID X 9/16" OD X 1/16" CS	LUTZ
1	-110 SILICONE O-RING	-110 SILICONE O-RING, 3/8" ID X 9/16" OD X 3/32" CS	LUTZ
1	98404A103	SS QUICK-RELEASE PIN, 5/32" DIA, 1" USEABLE LENGTH	MCMASTER CARR

REPLACES

STOCKING STATUS

MIN

MAX

STANDARD PART

TOLERANCES:
UNLESS OTHERWISE
SPECIFIED

.X = ± 0.1

.XX = ± 0.02

ANGULAR ± 1°

XXX = ± 0.005

.XXXX = ± 0.0005

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DESIGNED BY: BLH

DRAWN BY: BLH

DRAWN DATE: 6/6/2016

ERDMAN
Automation Corp.
1603 So. 14th Street, Princeton, MN 55371

PART NAME: IG NOZZLE ASSEMBLY, 7/16" GLASS SPACER, SINGLE PUMP (FOR OPPOSITE-HAND HEAD)QUICK RELEASE PIN, PLASTIC SHOE.

REV:

FINISH: AS SPECIFIED

MATERIAL: AS SPECIFIED

PART #:

IGSN-A23

FAB Qty: 1

Erdman Job #: 150736

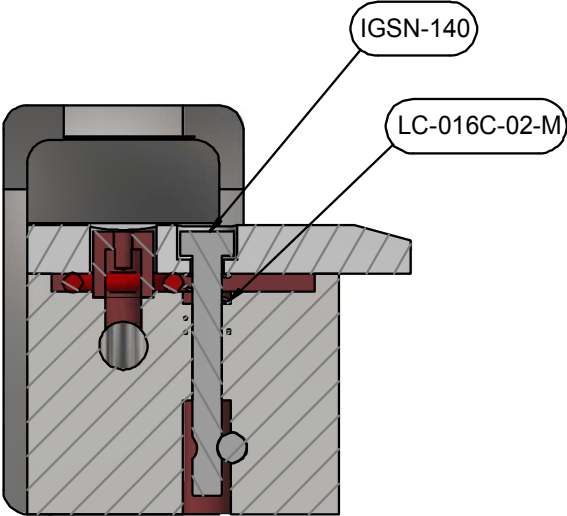
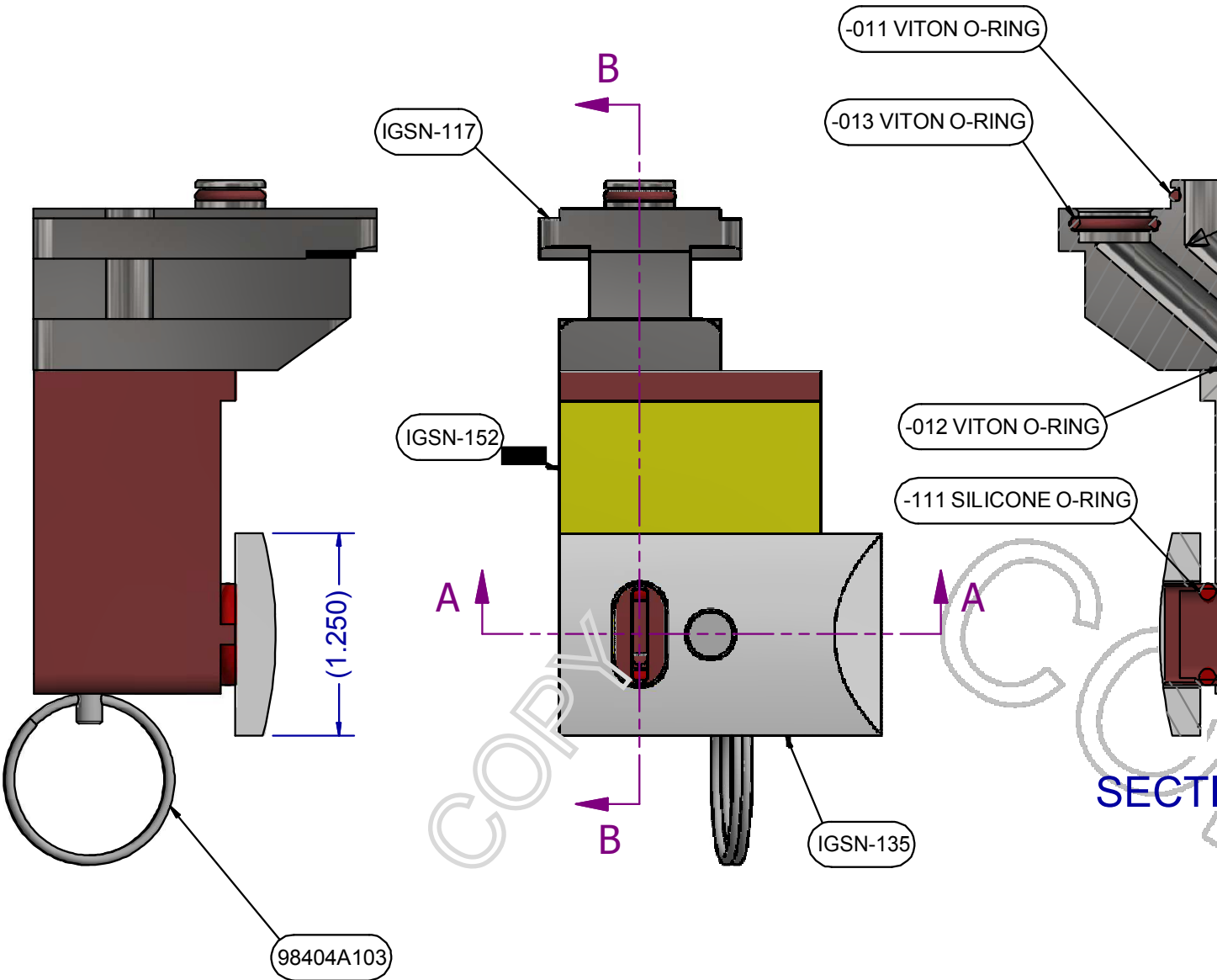
Sawing Time:

Machining Time:

Welding Time:

Paint Time:

Fi



SECTION A-A

MFG By:

MFG Date:

MFG Quantity: