



STEAM 'N' HOLD™
STEAMER
PARTS MANUAL

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DOCUMENT HISTORY

Current revision:
Date:

Prior revision: -
Date: None

Change

Steam "N" Hold Current Production

PART NUMBER	DESCRIPTION	MODEL	PAGE
Buzzers			
AT0E-2807-1	Buzzer, Timer/Low Water	S3 & S6	22-23
Door Quick Release Door -Current Production			
AT1A-2912-1	QR Door Replacement - Right Hinged (floating inner)	S6	15
AT1A-2912-3	QR Door Replacement - Left Hand (floating inner)	S6	15
AT1A-2426-5	Floating Inner Door - Right hand	S6	17-18
AT1A-2426-6	Floating Inner door - Left Hand	S6	17-18
AT1A-2427-1	Valve Bracket Assy- (w/cups & rod)	S3 & S6	19
AT1A-2644-2	Quick Release Door handle	S3 & S6	16
AT1G-1830-1	Seal, QRD Suction Cup	S3 & S6	19
AT1H-2046-1	QRD, Spring Compression	S3 & S6	17-18
AT1M-3045-1	QRD Valve Cover	S3 & S6	17-18
AT1M-3046-1	QRD Latch Backer Plate -RH	S3 & S6	16
AT1M-3046-2	QRD Latch Backer Plate -LH	S3 & S6	16
AT1H-2058-2	Door Hinge (Pair)	S3 & S6	16
AT0F-2691-41011	Nut, 10-24 Waxed Nyloc	S3 & S6	16
AT0F-2061-41160	Screw, 10-24x13/4" Flat Hd Machine	S3 & S6	16
AT0F-2061-41140	Screw, 10-24x3/4" Flat Hd Machine	S3 & S6	16
Door Gasket			
AT1G-2633-1	Gasket, Door S6 - Six Pan	S3 & S6	17-18
AT1G-2633-2	Gasket, Door S3 - 3 Pan	S3 & S6	17-18
Fittings/Screws			
AT0F-2691-41011	Nyloc Nut, Serrated hex #10-24	S3 & S6	Not Shown
AT0F-2875-51050	Screw 1/4-20UNC x 5/8 Hex Head Machine Screw	S3 & S6	28
AT0F-1922-5000	Washer, 1/4" Helical Coil (Drain Pan Bracket)	S3 & S6	28
AT0P-2987-2	Nylon Tee - Barbed 1/2x1/2x1/2	S3 & S6	21
AT0F-1046-31030	Truss Screws#8 x 3/8 SS	S3	11-12
AT0F-2777-31030	Screw, Self Tapping Truss Head 3/8"	S6	6,9
AT1P-2239	Ball Valve (drain)	S3 & S6	6,9,11-12
Fuses			
AT0E-3162-1	Fuse, Slo-Blo 1/2 Amp	S3 & S6	22-23
AT0E-2731-1	Fuse, Slo-Blo 3 Amp	S3 & S6	22-23
Gauges			
AT1A-3303-1	2" Thermometer Assembly	S3 & S6	13-14
AT0H-2614-1	2 " Vacuum Gauge Assembly	S3 & S6	13-14
AT0H-3544-1	2" Lens Cover for Thermometer and Vacuum Gauge	S3 & S6	Not Shown
Heaters			
AT1A-3530-1	Cast Heater Kit; 208v 6kw, 230/7.3, 240/8, 380/6.7, 400/7.4, 415/8, 440/9, 480/10.7	S3 & S6	34
AT1A-3530-2	Cast Heater Kit; 240k/6kw	S3 & S6	34
AT1A-3530-3	Cast Heater Kit; 208v/8kw, 240/10.7, 380/9, 400/10, 415/10.7, 480/14	S3 & S6	34
AT1A-3530-4	Cast Heater Kit; 208v/12.0kw, 240/16, 380/13, 400/14.8, 415/16, 440/18	S3 & S6	34
AT1A-3530-6	Cast Heater Kit; 208v 10.0kw	S3 & S6	34
AT1A-3530-7	Cast Heater Kit; 208v 17.0kw	S3 & S6	34
Hoses			
AT0P-2714-1	Hose Clamp 1/4	S3 & S6	21
AT0P-2714-2	Hose Clamp 1/2	S3 & S6	21
AT1P-2558-1	Hose 1/2 - 14"	S3 & S6	21
AT1P-2555-1	1/4" Silicone Hose - per ft'	S3 & S6	6,9
AT1P-2555-2	1/2" Silicone Hose - per ft'	S3 & S6	21
Lamps			

Steam "N" Hold Current Production

PART NUMBER	DESCRIPTION	MODEL	PAGE
AT0E-1800-5	Pilot Lamp Unit, 208/240V (Red)	S6	13-14
AT0E-1800-4	Pilot Lamp Unit, 208/240V (Green)	S6	13-14
AT0E-1800-6	Pilot Lamp Unit, 208/240V (Amber)	S6	13-14
AT0E-1800-9	Pilot Lamp Unit, 208/240V (Clear)	S6	13-14
Legs			
AT0H-3040-1	Rubber Foot Tip (Cooker)	S3 & S6	31
AT1A-3030-1	Leg Assembly Kit, Steamer	S3 & S6	32
Misc. Electronic			
AT0E-2717-1	MOV Transient Suppressor, 275V	S3 & S6	
Misc. Hardware			
AT1M-2590-1	Bracket, Interior Tray Left	S6	6,10
AT1M-2590-1	Bracket, Interior Tray Right	S6	6,10
AT1A-2548-1	Assembly, Pan Rack	S3	11-12
AT1M-2872-1	Drain Pan Bracket	S3 & S6	28
Overlay Graphics			
AT1L-2804-3	Overlay, 180M Timer and External Thermostat	S6	13-14
AT1L-2804-1	Overlay, 90M Timer and External Thermostat	S6	13-14
AT1L-2804-2	Overlay, 90M Timer and Internal Thermostat	S6	13-14
AT1L-2804-4	Overlay, 20 Minute Timer	S6	13-14
AT1L-2804-5	Overlay, 180 Minute Timer	S6	13-14
AT1L-2575-1	Overlay, 90 Minute Timer and External Thermostat	S3	13-14
AT1L-2575-2	Overlay, 90 Minute Timer and Internal Thermostat	S3	13-14
AT1L-2529-1	Overlay, Instructions	S3 & S6	15
Overtemp			
AT1E-2653-3	Overtemp - Cast Heater Only	S3 & S6	6,9, 11-12
PCB			
AT1E-2593-1	Light Control Board	S3	12-Nov
Power Cords			
AT0A-2788-10	17KW Power Cord Assy	S6	
Relays			
AT0E-2059-3	Solid State Relay, (D & A2450)	S3 & S6	27
AT0E-2996-1	Heat Pad - SSR	S3 & S6	27
AT0E-1587-1	Contact, 3 Pole 208/240	S3 & S6	6,9,11-12
AT0E-2825-1	Control Relay, 208V 3PDT	S3 & S6	21-22
AT0E-2825-2	Control Relay, 240V 3PDT	S3 & S6	21-23
AT0E-2825-3	Control Relay, 208/240V 3PDT (Replaces -1 or -2)	S3 & S6	21-24
Sheet Metal			
AT1M-2979-1	Exterior Shell, Steamer - 6 Pan - Internal Muffler	S6	24-26
AT1M-2979-2	Exterior Shell, Steamer - 6 Pan 14 KW and above - Internal Muffler	S6	24-26
AT1M-2981-1	Side Panel - 6 Pan, Right	S6	6,9
AT1M-2781-2	Bottom Shell, 6 Pan Steamer	S6	6,9
AT1M-2981-2	Side Panel - 6 Pan, Left	S6	6,9
Stands			
AT0H-2479-7	Stand Caster, Non-Break	Stand	Not Shown
AT0H-2479-8	Stand Caster, Break	Stand	Not Shown
Switches			
AT0E-2874-2	Toggle Switch - Fast Cook/Thermostat	S6	13-14
AT1E-2647-1	Pressure Switch - Single Pressure Switch	S3 & S6	13-14
AT1E-2647-2	Pressure Switch - Dual Pressure Switch -14 KW and above	S3 & S6	13-14
AT0E-3336-1	Operator, AB Rotary Switch	S3	13-14
AT0E-3337-1	On Pushbutton, Steamer	S6	13-14
AT0E-3337-2	Off Pushbutton, Steamer	S3 & S6	13-14
AT0E-3338-1	On Contact, Steamer	S3 & S6	13-14
AT0E-3338-2	Off Contact, Steamer	S3 & S6	13-14
AT0E-3339-1	Pushbutton Lock Ring	S3 & S6	13-14

Steam"N"Hold Current Production

PART NUMBER	DESCRIPTION	MODEL	PAGE
Timers			
AT0E-2297-1	Timer, 90 Minute	S3 & S6	13-14
AT0E-2297-2	Timer, 180 Minute	S3 & S6	13-14
AT0E-2297-3	Timer, 20 Minute	S3 & S6	13-14
AT0H-1455-2	Thermostat/Timer Repl. Knob-soft grip	S3 & S6	13-14
Thermocouples			
AT0E-3386-1	Thermocouple	S3 & S6	6,9,11-12
Thermostats			
AT0E-2559-2	AC Thermostat, Calibrated (100-200 F)	S3 & S6	13-14
Transformer			
AT0E-2662-1	Transformer - for 440/480V	S3 & S6	24-25
Vacuum Pumps			
AT1E-2991-1	Vacuum Pump, Gast (new style)	S3 & S6	20
RK935	Gast Vacuum Pump Rebuild Kit	S3 & S6	Not Shown
Water Sensor			
AT1E-2652	Probe Water Sensor	S3 & S6	6,9,11-12
AT1E-2654-1	PCB, Water Board Sensor	S3 & S6	20-21

AT1A-3470 MODULAR BOM FOR 6 PAN STEAMERS

To build up a complete 6 pan steamer assembly BOM, begin with the desired steamer model number, created from the Steamer Model String Number Configuration (ATT-2611), and follow steps 1 through 4.

Example: S62083D0803020

STEP 1. MODULE, VOLTAGE WATTAGE PHASE

Using model string digits 1 through 10, locate the generic model number in the chart and find the corresponding Module, Voltage Wattage Phase.

Example:
Generic Model No. = S62083D080XXXX
Voltage Wattage Phase Module No. = AT1A-3472-28

DIGITS 1-10 GENERIC MODEL No.	MODULE, VOLTAGE WATTAGE PHASE	RATED VOLTAGE / WATTAGE / AMPERAGE [ⓑ]
S62081D060XXXX	AT1A-3472-25	208V 6.0KW 16.7A
S62083D080XXXX	AT1A-3472-28	208V 8.0KW 22.2A
S62083D100XXXX	AT1A-3472-29	208V 10.0KW 27.8A
S62083D120XXXX	AT1A-3472-30	208V 12.0KW 33.3A
S62083D170XXXX	AT1A-3472-31	208V 17.0KW 47.2A
S62301D073XXXX	AT1A-3472-32	230V 7.3KW 31.9A
S62401D060XXXX	AT1A-3472-33	240V 6.0KW 25.0A
S62403D080XXXX	AT1A-3472-36	240V 8.0KW 19.3A
S62403D107XXXX	AT1A-3472-37	240V 10.7KW 25.7A
S62403D160XXXX	AT1A-3472-39	240V 16.0KW 38.5A
S63805D067XXXX	AT1A-3472-40	380V 6.7KW 10.2A
S63805D090XXXX	AT1A-3472-41	380V 9.0KW 13.5A
S63805D130XXXX	AT1A-3472-43	380V 13.0KW 20.3A
S64005D074XXXX	AT1A-3472-40	400V 7.4KW 10.7A
S64005D100XXXX	AT1A-3472-41	400V 10.0KW 14.2A
S64005D148XXXX	AT1A-3472-43	400V 14.8KW 21.3A
S64155D080XXXX	AT1A-3472-40	415V 8.0KW 11.1A
S64155D107XXXX	AT1A-3472-41	415V 10.7KW 14.8A
S64155D160XXXX	AT1A-3472-43	415V 16.0KW 22.1A
S64403D090XXXX	AT1A-3472-47	440V 9.0KW 11.8A
S64403D180XXXX	AT1A-3472-51	440V 18.0KW 23.5A
S64803D140XXXX	AT1A-3472-52	480V 14.0KW 17.1A

[ⓑ]

STEP 4. MODULE, SPECIAL OPTION

Add the Module, Special Option derived from model string digit 14 for modification of a standard model steamer.

Example:
(S62083D0803020)
0 = AT1T-3079-0

DIGIT 14	MODULE, SPECIAL OPTION DESCRIPTION	MODULE, SPECIAL OPTION CONFIGURATION
0	DRAIN PAN RAILS	AT1T-3079-0
2	MARITIME SPECS	AT1T-3079-2
4	TAMPER-PROOF SPECS [ⓑ]	AT1T-3079-4
5	4" LEGS WITH BULLET FEET	AT1T-3079-5

ECN	REV	DESCRIPTION	DATE	APPR
389	B	CHG.D (STEP #1) S62403D107XXXX WAS 3472-38; 240V 10.7KW 25.7A WAS 240V 10.7KW 25.7A; TAMPER-PROOF SPECS WERE ADDED TO ALL GENERIC MODEL NO. WATTAGE WAS RATED VOLTAGE / WATTAGE TO ALL GENERIC MODEL NO.	01-15-08	GLS/ALB
392	A	RELEASED TO PRODUCTION	8/31/07	GLS/ALB

REVISIONS

STEP 2. MODULE, CONTROL PANEL

Add the Module, Control Panel derived from model string digits 11 & 12. See AT1T-2611 for internal thermostat settings represented by digit 12.

Example:
(S62083D0803020)
30 = AT1A-3078-7

DIGITS 11 & 12	CONTROL PANEL MODULE
30	AT1A-3078-7
31	AT1A-3078-10
32	AT1A-3078-10
33	AT1A-3078-10
34	AT1A-3078-10
35	AT1A-3078-10
36	AT1A-3078-10
40	AT1A-3078-8
41	AT1A-3078-11
42	AT1A-3078-11
43	AT1A-3078-11
44	AT1A-3078-11
45	AT1A-3078-11
46	AT1A-3078-11
50	AT1A-3078-9
51	AT1A-3078-12
52	AT1A-3078-12
53	AT1A-3078-12
54	AT1A-3078-12
55	AT1A-3078-12
56	AT1A-3078-12

EXAMPLE RESULT:

S62083D0803020 is made from modules AT1A-3472-28 + AT1A-3078-7 + AT1A-3377-5 + AT1T-3079-0

NOTES:

- SHEETS 2 THROUGH SHEET 5 SHOW COMPONENT AND MODULE ASSEMBLY ORIENTATIONS.

STEP 3. MODULE, COMMON COMPONENTS

Add the Module, Common Components derived from the model string digits 13 & 14.

Examples:
(S62083D0803020)
20 = AT1A-3377-5

DIGITS 13 & 14	COMMON COMPONENTS MODULE	MODULE DESCRIPTION
20	AT1A-3377-5	RH CHAMBER
22	AT1A-3377-5	RH CHAMBER
24	AT1A-3377-7	RH CHAMBER
25	AT1A-3377-5	RH CHAMBER
30	AT1A-3377-6	LH CHAMBER
32	AT1A-3377-6	LH CHAMBER
34	AT1A-3377-8	LH CHAMBER
35	AT1A-3377-6	LH CHAMBER

Unless otherwise specified, Dimensions: Inches Bends: 90° Tolerances: Angular: ±1° 2-Place Decimal 3-Place Decimal T/LR: ±.005 Material: GD&T Per ANSI Y14.5M Comments: Do Not Scale Drawing		<table border="1"> <tr><td>Drawn</td><td>ALB</td><td>Date</td><td>08-07-2007</td></tr> <tr><td>Checked</td><td>GLS</td><td>08-07-2007</td><td></td></tr> <tr><td>Project Eng</td><td>GLS</td><td>08-07-2007</td><td></td></tr> <tr><td>Material</td><td></td><td></td><td></td></tr> </table>	Drawn	ALB	Date	08-07-2007	Checked	GLS	08-07-2007		Project Eng	GLS	08-07-2007		Material				<table border="1"> <tr><td>Name</td><td>ALB</td><td>Date</td><td>08-07-2007</td></tr> <tr><td>Checked</td><td>GLS</td><td>08-07-2007</td><td></td></tr> <tr><td>Project Eng</td><td>GLS</td><td>08-07-2007</td><td></td></tr> <tr><td>Material</td><td></td><td></td><td></td></tr> </table>	Name	ALB	Date	08-07-2007	Checked	GLS	08-07-2007		Project Eng	GLS	08-07-2007		Material				<table border="1"> <tr><td>Size</td><td>N/A</td></tr> <tr><td>Finish</td><td>N/A</td></tr> </table>	Size	N/A	Finish	N/A	<table border="1"> <tr><td>Rev.</td><td>B</td></tr> <tr><td>Drawing No.:</td><td>AT1A-3470</td></tr> <tr><td colspan="2" style="text-align: center;">6 PAN FINAL</td></tr> </table>	Rev.	B	Drawing No.:	AT1A-3470	6 PAN FINAL		<table border="1"> <tr><td>Scale:</td><td>1:8</td></tr> <tr><td>ECN:</td><td>352</td></tr> </table>	Scale:	1:8	ECN:	352	<table border="1"> <tr><td colspan="2">AccuTemp Products, Inc 8415 N. Clinton Park Fort Wayne, IN 46825</td></tr> <tr><td colspan="2" style="text-align: center;">AccuTemp</td></tr> </table>	AccuTemp Products, Inc 8415 N. Clinton Park Fort Wayne, IN 46825		AccuTemp	
Drawn	ALB	Date	08-07-2007																																																						
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Project Eng	GLS	08-07-2007																																																							
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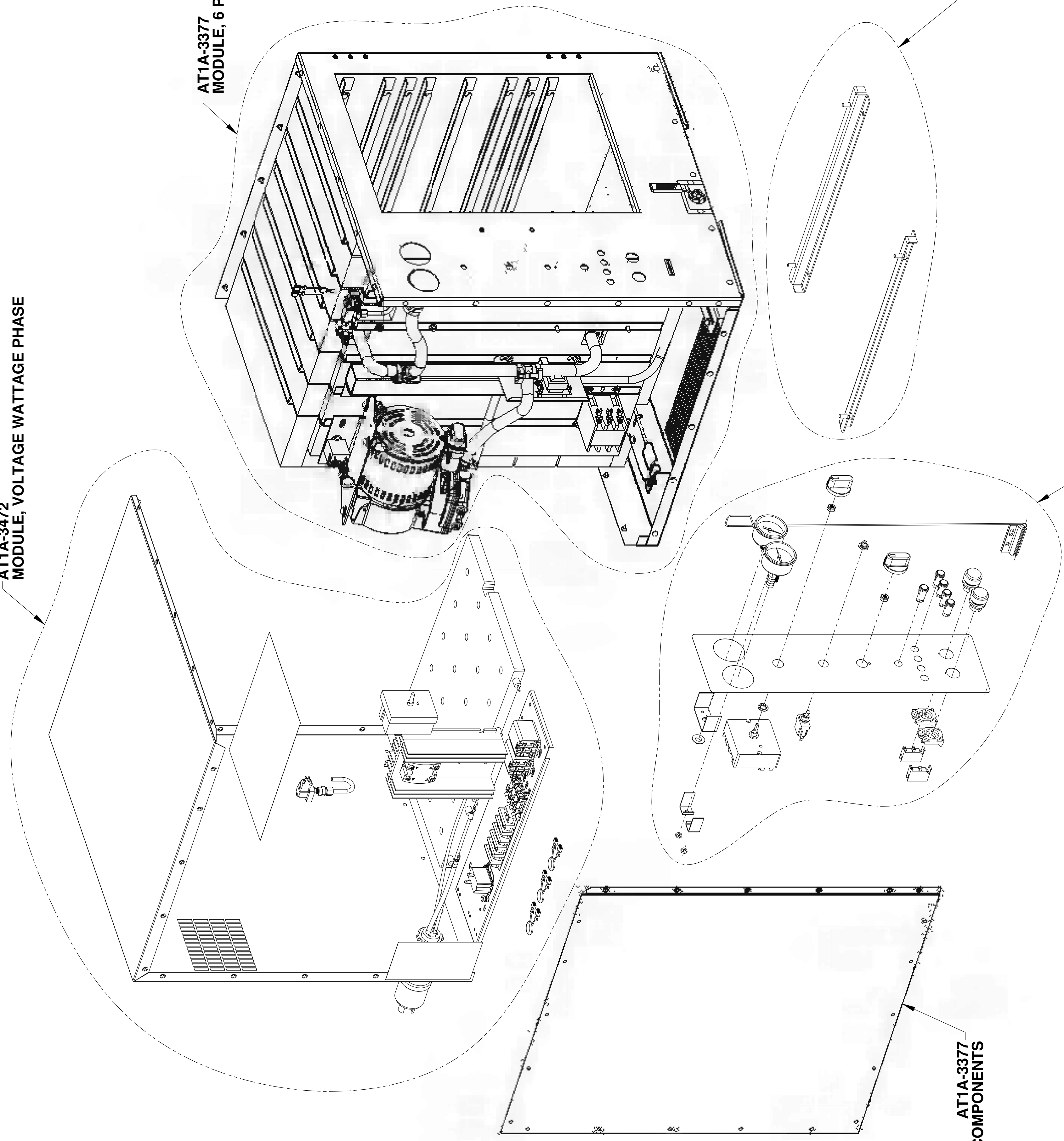
AT1A-3472
MODULE, VOLTAGE WATTAGE PHASE

AT1A-3377
MODULE, 6 PAN COMMON COMPONENTS

AT1A-3377
MODULE, 6 PAN COMMON COMPONENTS

AT1A-3078
MODULE, STEAMER CONTROL PANEL

AT1T-3079
MODULE, SPECIAL OPTION



Unless otherwise specified,
Dimensions are in inches
Rounds 90°
Tolerances:
Angular ±1°
2 Place Decimal ±.02
3 Place Decimal ±.005
1 LR ±.005
√125 Micro Inches
GD&T Per ANSI Y14.5M
Comments:
Do Not Scale Drawing

Name	Date
ALB	08-07-2007
gls	08-07-2007
gls	08-07-2007
gls	08-07-2007
gls	08-07-2007
gls	08-07-2007

AccuTemp Products, Inc
8415 N. Clinton Park
Fort Wayne, IN 46825

AccuTemp

BOM
6 PAN FINAL

Drawing No.: **AT1A-3470**

Rev: **B**

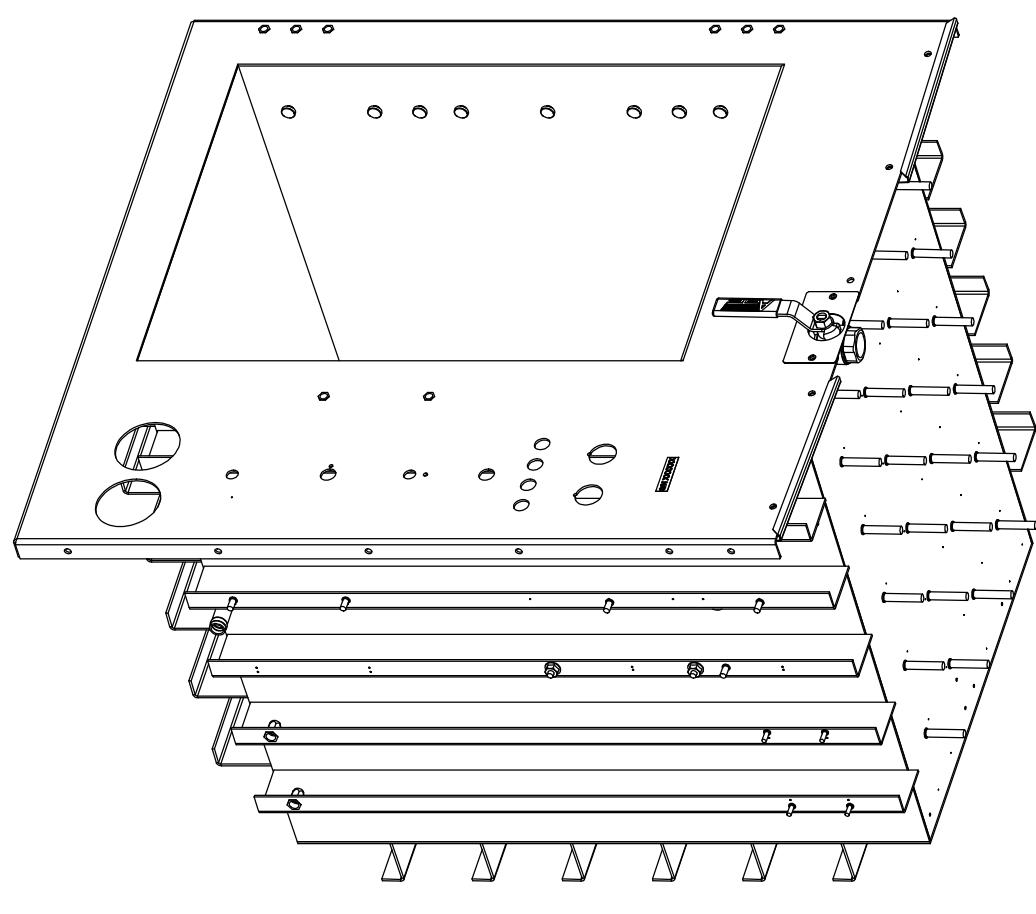
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Finish: **N/A**

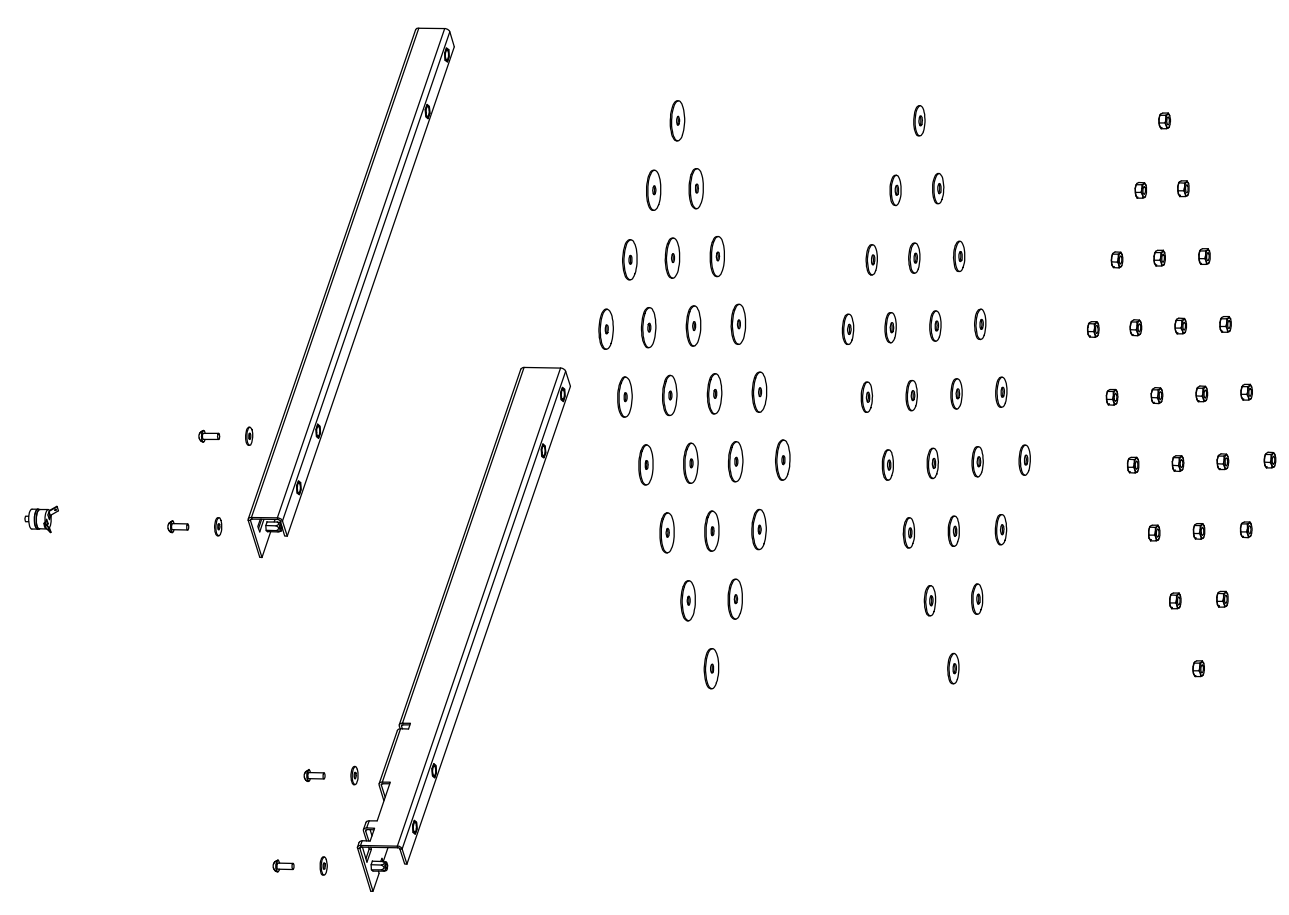
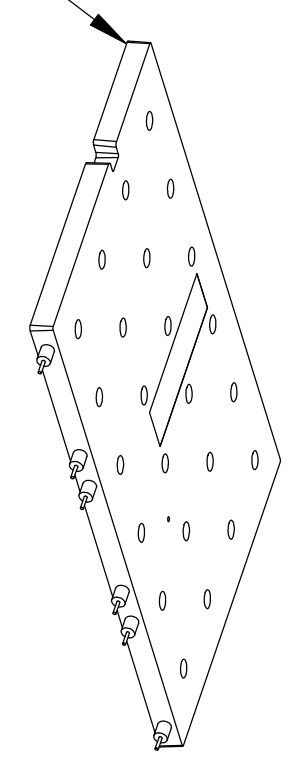
Scale: 1:4 ECN: 352

Sheet 2 of 5

1



AT1A-3472 MODULE
(REMAINING ITEMS BELONG
TO AT1A-3377)

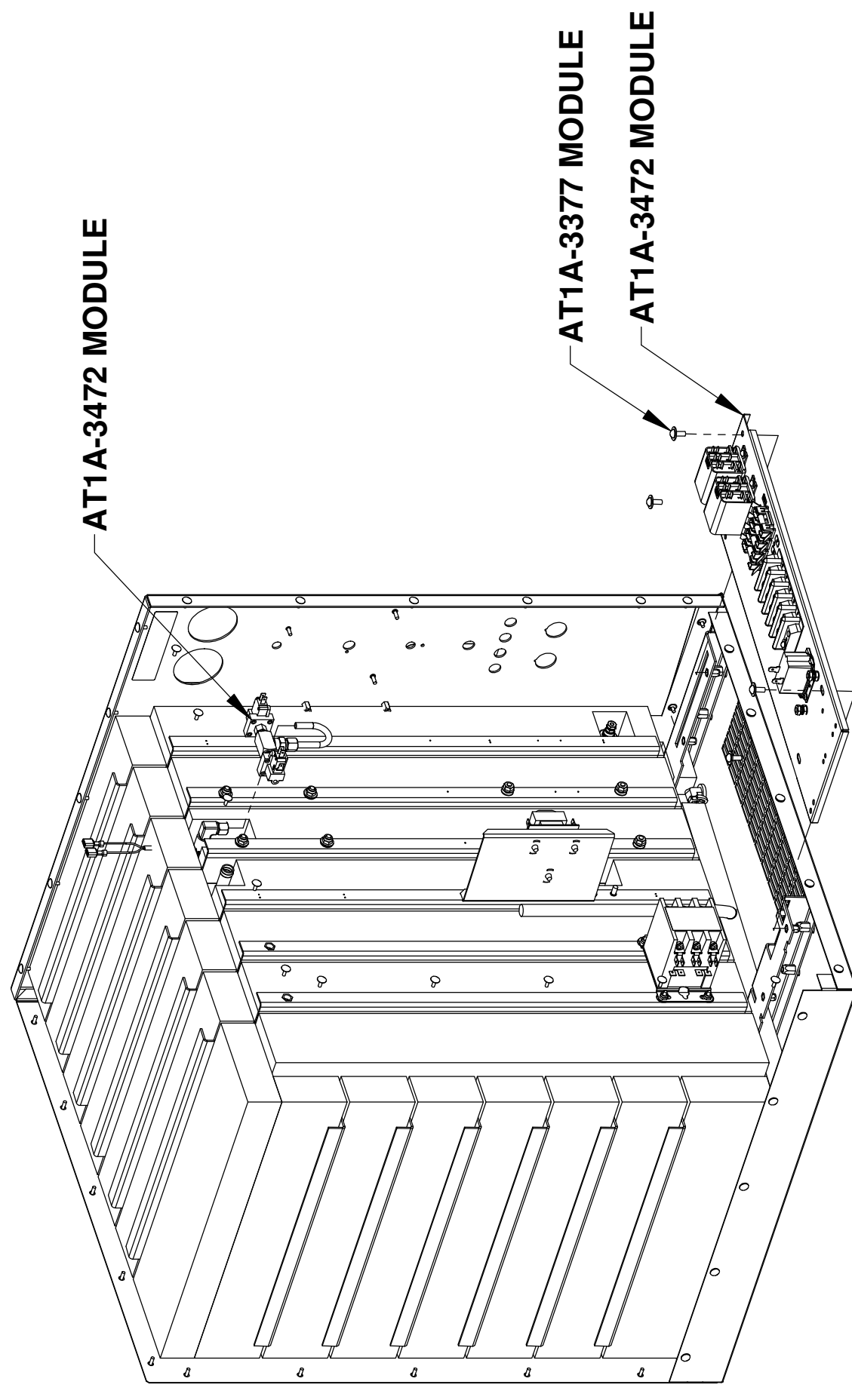


ALL MODELS

Unless otherwise specified, Dimensions in Inches		Name	Date	AccuTemp Products, Inc 8415 N. Clinton Park Fort Wayne, IN 46825
Drawn	ALB	08-07-2007		
Checked	GLS	08-07-2007		
Project Eng	GLS	08-07-2007		
Material:	N/A			
Angular	±1°			
2 Place Decimal	±.02			
3 Place Decimal	±.005			
Tolerance	±.005			
Tolerance	±.005			
GD&T Per ANSI Y14.5M	√125 Micro Inches			
Comments:	Do Not Scale Drawing			
Size:	D			
Drawing No.:	AT1A-3470			
Rev:	B			
Scale:	1:6 ECN: 352			

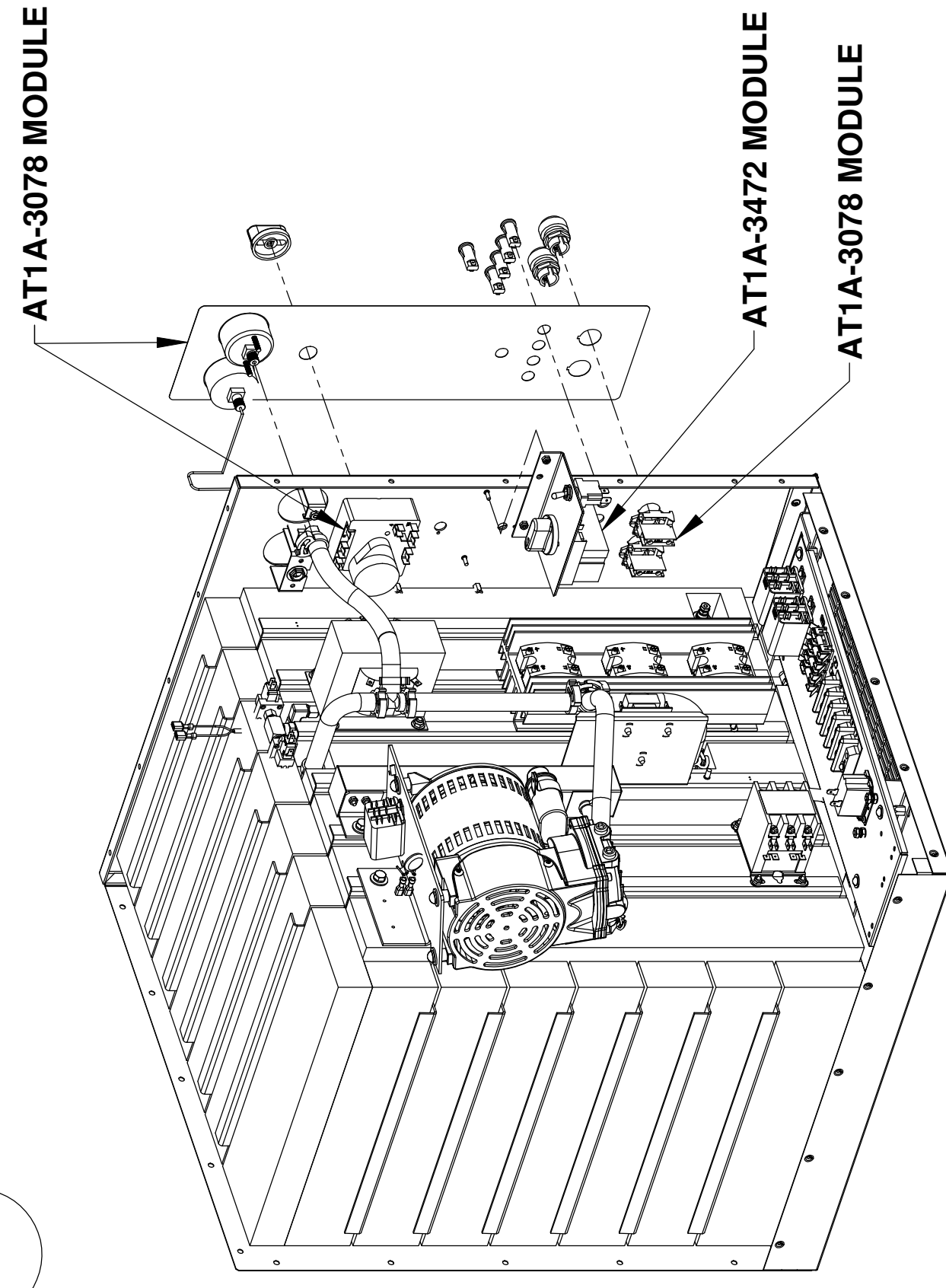
6 PAN FINAL

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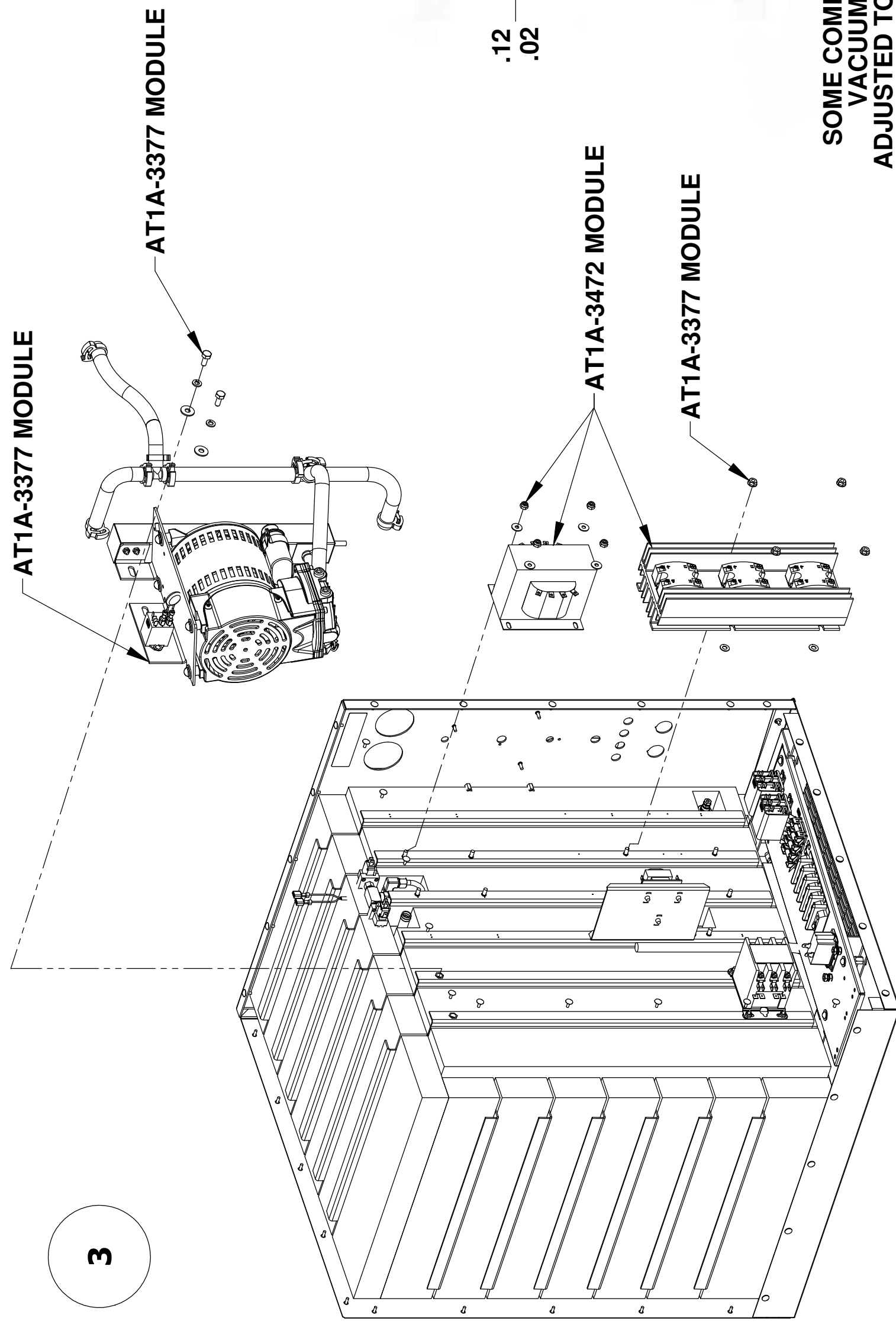
SOME COMPONENTS ARE REMOVED FOR CLARITY
(SEE INDIVIDUAL MODULAR DRAWINGS FOR APPLICABLE PART NUMBERS)

4



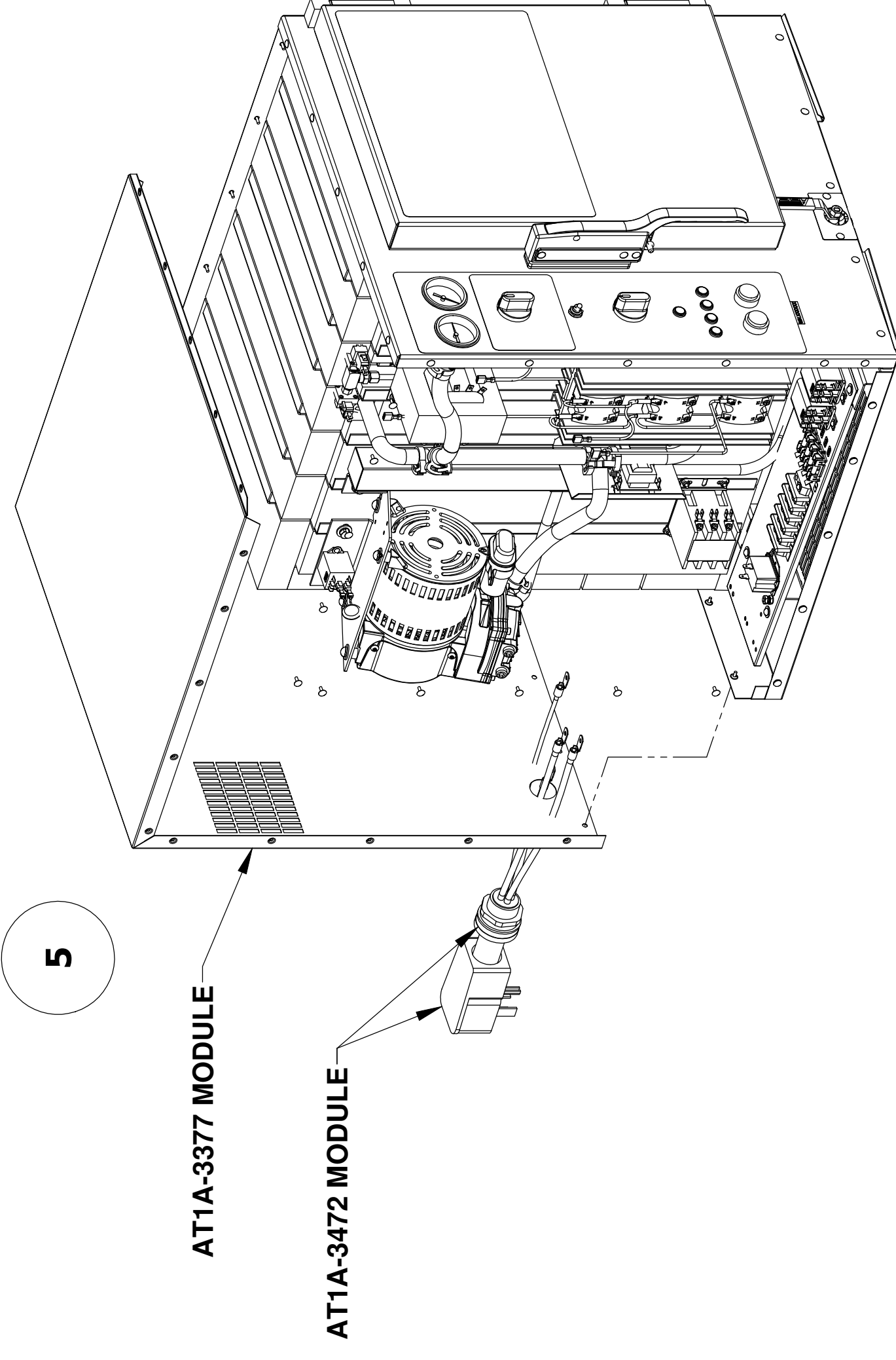
SOME COMPONENTS ARE REMOVED FOR CLARITY
(SEE INDIVIDUAL MODULAR DRAWINGS FOR APPLICABLE PART NUMBERS)

3



SOME COMPONENTS ARE REMOVED FOR CLARITY
VACUUM PUMP SHOULD BE INSTALLED AND
ADJUSTED TO THE DIMENSION SHOWN BETWEEN THE
INSIDE OF THE EXTERIOR SHELL AND THE VACUUM
PUMP HEAD

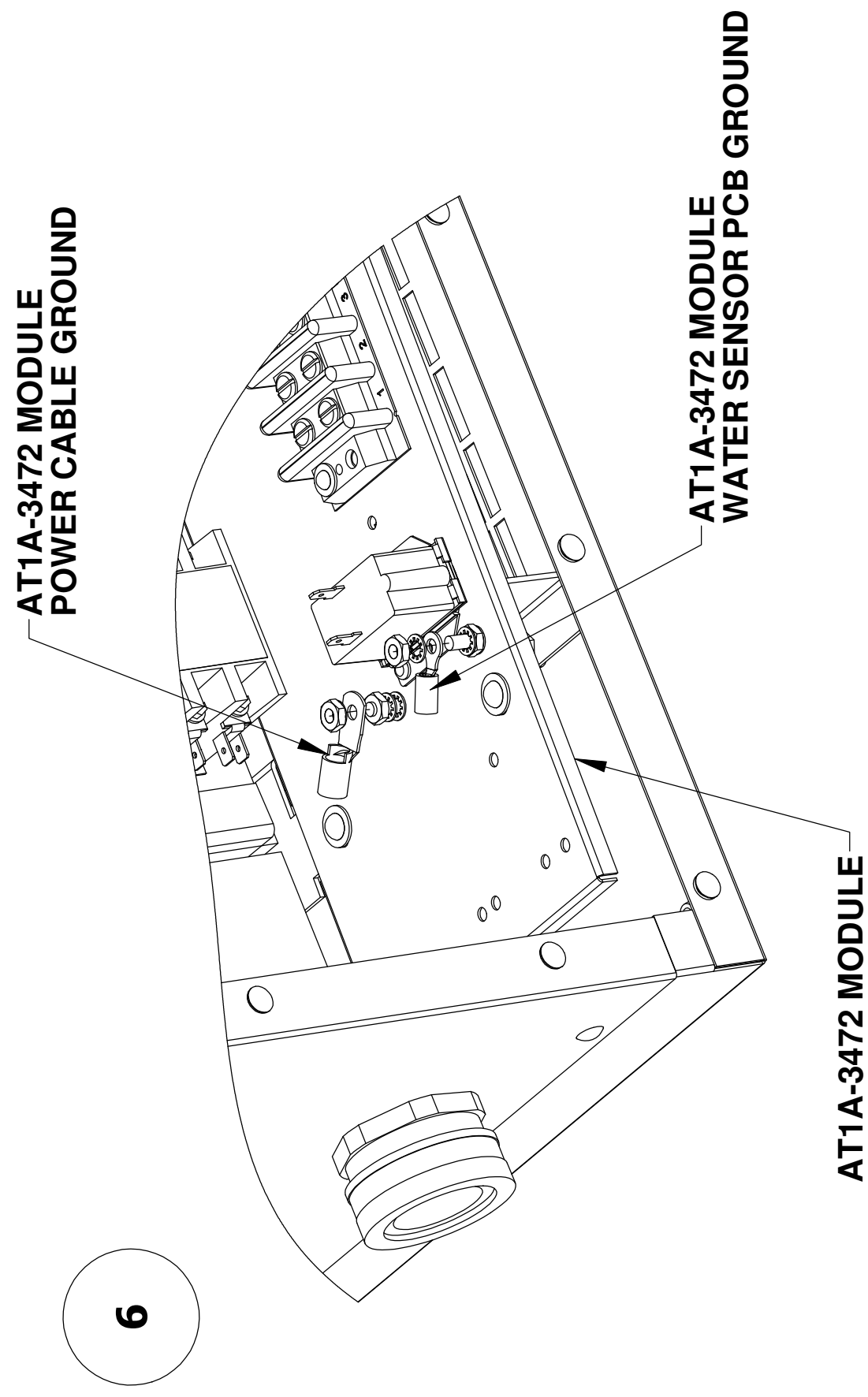
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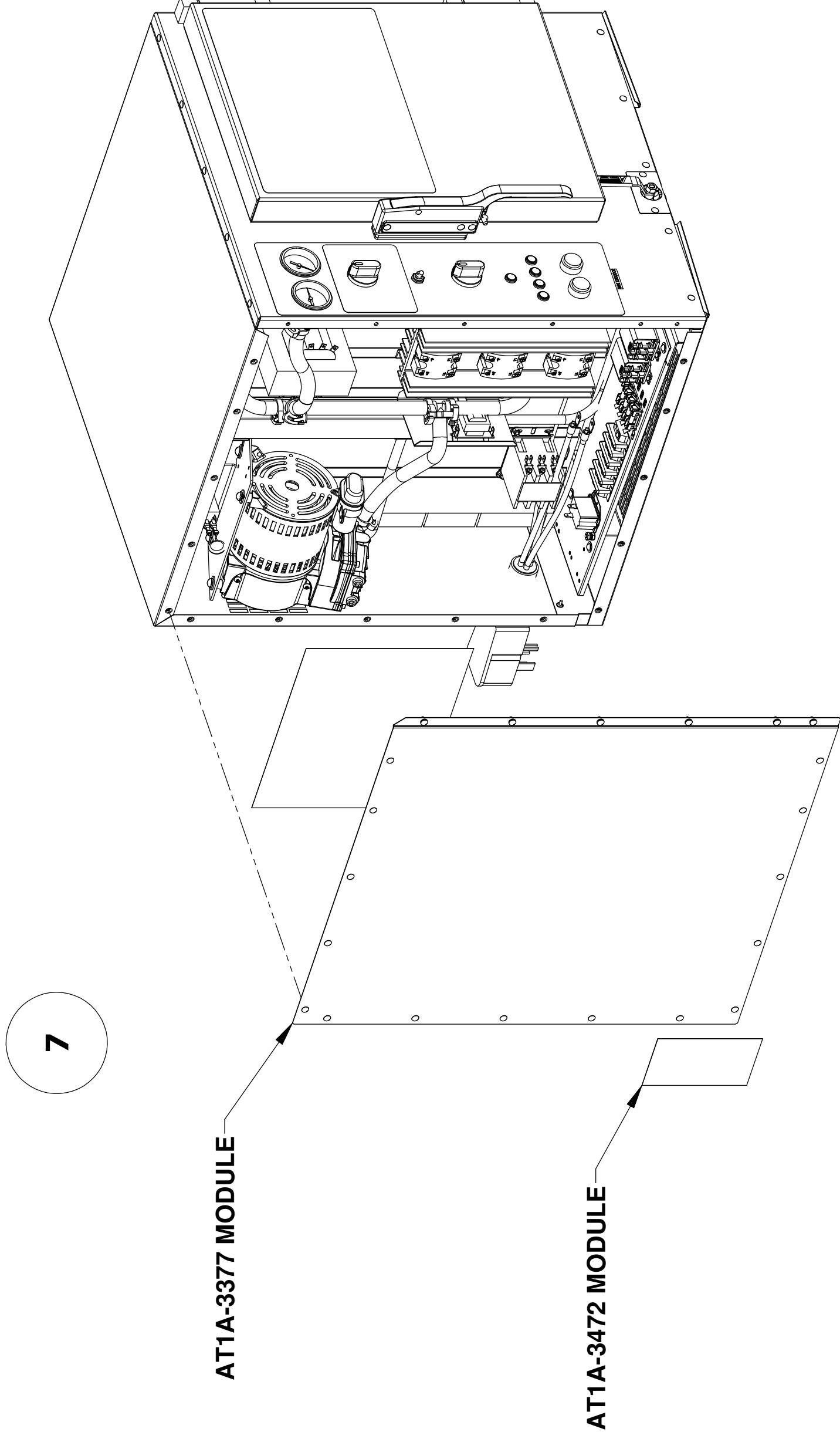
SOME COMPONENTS ARE REMOVED FOR CLARITY
(SEE INDIVIDUAL MODULAR DRAWINGS FOR APPLICABLE PART NUMBERS)

Unless otherwise specified, Dimensions in Inches		Name	Date
Bore	.005	ALB	08-07-2007
Radial	.005	CLS	08-07-2007
Tolerances:		Checked	CLS
Angular	±.1°	Project Eng	CLS
2 Place Decimal	±.02		
3 Place Decimal	±.005	Material:	
Tolerance	±.005		
Tolerance	±.005		
GD&T Per ANSI Y14.5M			
Comments:			

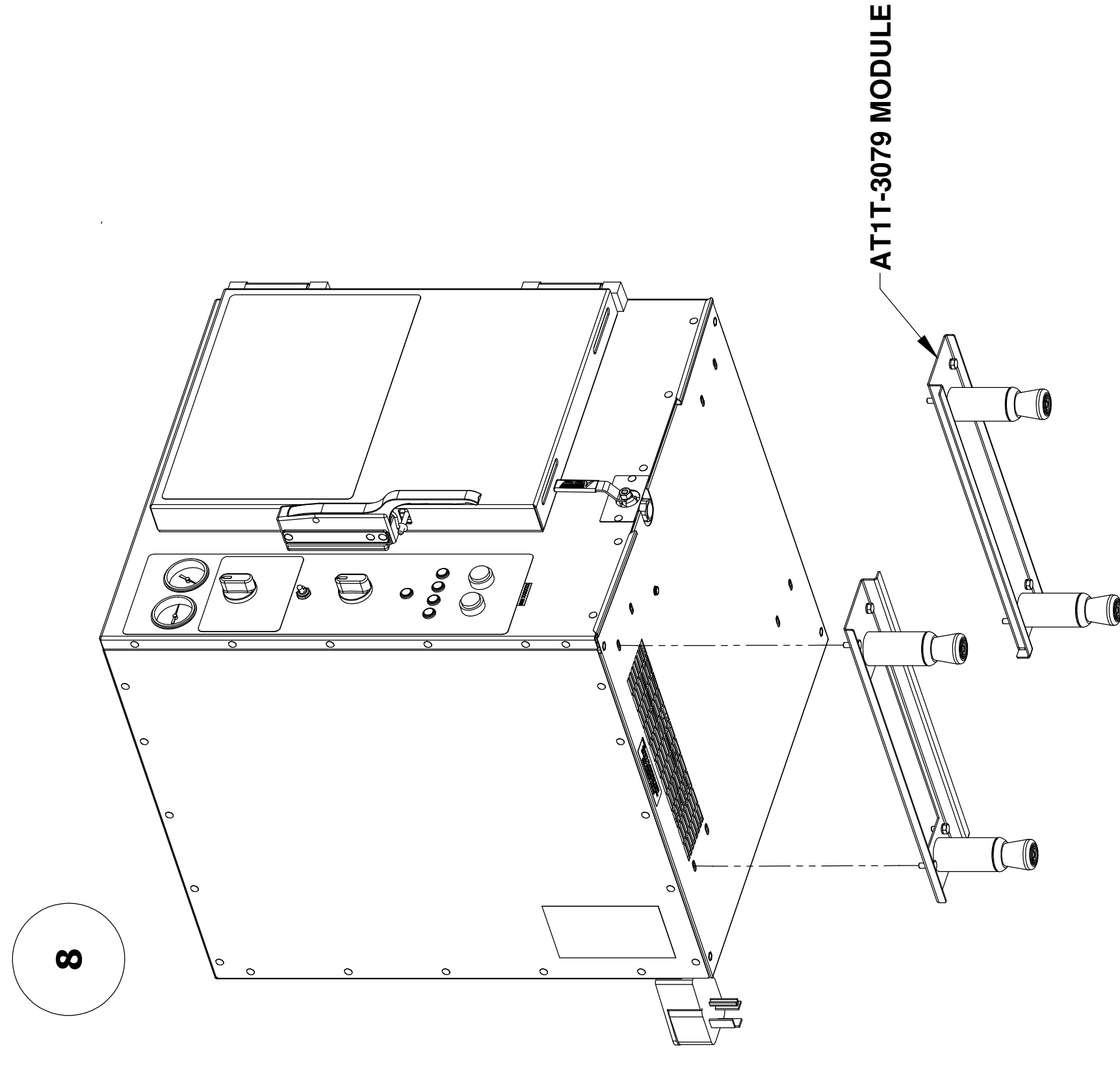
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Title:		BOM	
Size:		6 PAN FINAL	
Drawing No.:		AT1A-3470	
Finish:		D	
Do Not Scale Drawing		Rev:	
Scale: 1:6 ECN: 352		B	
		Sheet 4 of 5	



SOME COMPONENTS ARE REMOVED FOR CLARITY
(SEE INDIVIDUAL MODULAR DRAWINGS FOR APPLICABLE PART NUMBERS)



SOME COMPONENTS ARE REMOVED FOR CLARITY
(SEE INDIVIDUAL MODULAR DRAWINGS FOR APPLICABLE PART NUMBERS)

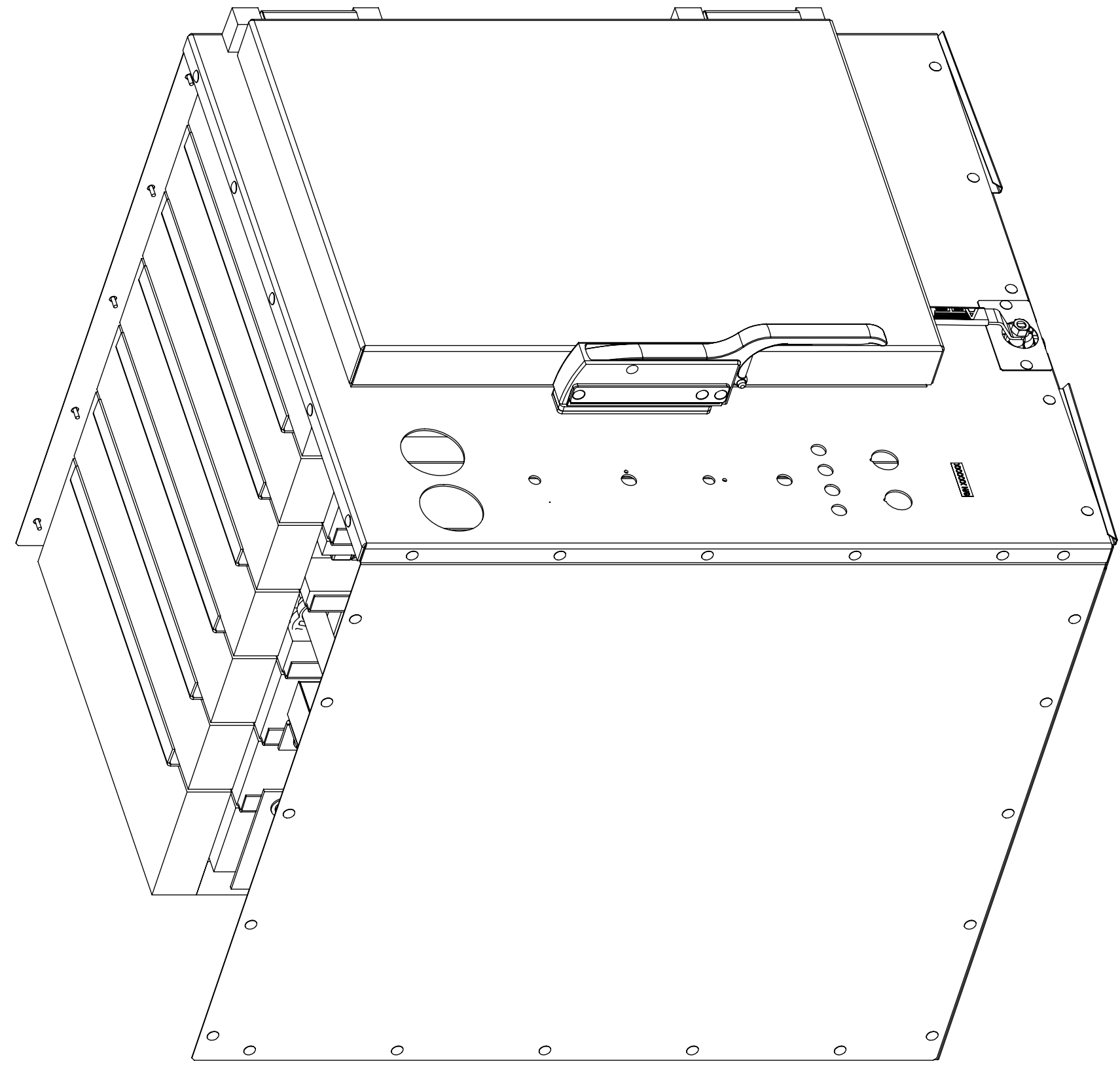


SOME COMPONENTS ARE REMOVED FOR CLARITY
(SEE INDIVIDUAL MODULAR DRAWINGS FOR APPLICABLE PART NUMBERS)

Unless otherwise specified, Dimensions: Inches		Name	Date	AccuTemp Products, Inc. 8415 N. Clinton Park Fort Wayne, IN 46825	
Drawn	ALB	08-07-2007	08-07-2007		
Checked	GLS	08-07-2007	08-07-2007		
Tolerances:		Project Eng	GLS	08-07-2007	BOM 6 PAN FINAL
Angular	±.1°	Material:	N/A	Size: D Drawing No.: AT1A-3470 Rev: B	
2 Place Decimal	±.02	Finish:	N/A	Scale: 1:6 ECN: 352 Sheet 5 of 5	
3 Place Decimal	±.005	Do Not Scale Drawing			
1/16	±.005				
1/32	±.005				
1/64	±.005				
1/125 Micro Inches	Y14.5M				
GD&T Per ANSI Y14.5M					
Comments:					


NOTES:

- SEE AT1A-3352 BOM, 6 PAN FINAL FOR WATLOW FIREBAR HEATER DESIGN OR AT1A-3470 BOM, 6 PAN FINAL FOR CAST IN HEATER DESIGN, COMPONENT AND MODULE ASSEMBLY ORIENTATIONS.
- SEE AT1A-3359 MODULE, VOLTAGE WATTAGE PHASE FOR COMPONENT DETAILS.
- TORQUE ITEM 56 (AT0F-2895-51002) NUTS TO 45±5 IN-LBS.
- TORQUE ITEM 57 (AT0F-3401-1) SPECIAL LOCKING NUT TO 25±2 IN-LBS, STARTING IN THE CENTER AND WORKING FIRST TO THE SIDES (SIDES OF STEAMER CHAMBER) AND THEN TO THE ENDS (FRONT AND BACK OF STEAMER CHAMBER) OF THE HEATER. TIGHTEN TWICE IN THIS MANNER.
- HEATING ELEMENTS ARE NUMBERED ONE TO THREE, FROM THE BACK TO THE FRONT OF THE STEAMER.
- APPLY THIN FILM OF ITEM 68 (AT0H-3412-1) WAKEFIELD 120 THERMAL JOINT COMPOUND TO THE BOTTOM OF ITEM 25 (AT1E-2653-3) OVERTEMP SWITCH.
- APPLY ITEM 67 (AT0H-3065-2) LOCTITE 246 ONLY TO THE THREADS OF ITEM 25 (AT1E-2653-3) OVERTEMP SWITCH.
- PLACE ITEM 48 (AT1A-3387-1) STEAMER LOOSE PIECES INTO EMPTY, DRY CHAMBER FOR SHIPPING.
- TORQUE ITEM 39 (AT1E-2652-1) WATER SENSOR PROBE NUTS TO 11-14 IN-LBS. DO NOT EXCEED 14 IN-LBS AS THIS WILL STRIP THE THREADS.
- APPLY ITEM 69 (AT0H-3102-1) THREAD SEALANT ON CUSTOM PIPE NIPPLE (AT1P-2476-1) ON CHAMBER WELD ASSEMBLY (AT1A-2968) BEFORE SECURELY MOUNTING BALL VALVE (AT1P-2239-1).
- APPLY ITEM 71 (AT1L-2624-1) LABEL TO ITEM 2 (AT1A-3409) BOTTOM SHELL APPROXIMATELY .25" FROM THE CONTROL PANEL SIDE AND 9.00" BACK FROM THE FRONT. ORIENT THE LABEL SO THAT THE TEXT CAN BE READ FROM THE LEFT SIDE OF THE STEAMER IN ITS NORMAL UPRIGHT POSITION.
- SEE AT1A-3472 MODULE, VOLTAGE WATTAGE PHASE FOR COMPONENT DETAILS.



308	F	CHDQ. (NOTE 4) 250 WAS 1402	05-19-08	EWALKS
307	E	CHDQ. (NOTE 4) 250 WAS 1402	11-04-07	063418
306	D	CHDQ. (NOTE 4) 250 WAS 1402	06-26-07	063418
304	C	CHDQ. (NOTE 4) 250 WAS 1402	09-16-07	063407
300	B	CHDQ. (NOTE 4) 250 WAS 1402	06-14-07	063418
300	A	CHDQ. (NOTE 4) 250 WAS 1402	06-04-07	063418

QTY	AT1A-3377-8	AT1A-3377-7	AT1A-3377-6	AT1A-3377-5	AT1A-3377-4	AT1A-3377-3	AT1A-3377-2	AT1A-3377-1	ITEM	DESCRIPTION
1	1	1	1	1	1	1	1	1	24	OVERTEMP SWITCH
1	1	1	1	1	1	1	1	1	23	OVERTEMP BRACKET
1	1	1	1	1	1	1	1	1	22	3 POLE CONTACTOR
1	1	1	1	1	1	1	1	1	21	PAN RACK SOLID RIGHT HAND
1	1	1	1	1	1	1	1	1	20	PAN RACK SOLID LEFT HAND
1	1	1	1	1	1	1	1	1	19	RAIL, PAN SUPPORT RIGHT HAND
1	1	1	1	1	1	1	1	1	18	RAIL, PAN SUPPORT LEFT HAND
1	1	1	1	1	1	1	1	1	17	COVER, STEAMER DRAIN
1	1	1	1	1	1	1	1	1	16	CENTER HEATER MOUNT
1	1	1	1	1	1	1	1	1	15	DROP EDGE
1	1	1	1	1	1	1	1	1	14	DRIP EDGE
1	1	1	1	1	1	1	1	1	13	HOSE ASSEMBLY
1	1	1	1	1	1	1	1	1	12	HEATER MOUNTING BRACKET ASSY
1	1	1	1	1	1	1	1	1	11	HEATER MOUNTING BRACKET ASSY
1	1	1	1	1	1	1	1	1	10	ASSY, FRONT BOTTOM Z BRACKET
1	1	1	1	1	1	1	1	1	9	ASSY, REAR BOTTOM Z BRACKET
1	1	1	1	1	1	1	1	1	8	HOSE ASSEMBLY
1	1	1	1	1	1	1	1	1	7	SHRIKE
1	1	1	1	1	1	1	1	1	6	STRIKE
1	1	1	1	1	1	1	1	1	5	DOOR ASSEMBLY 6 PAN LEFT HAND PRISON
1	1	1	1	1	1	1	1	1	5	DOOR ASSEMBLY 6 PAN RIGHT HAND PRISON
1	1	1	1	1	1	1	1	1	5	DOOR ASSEMBLY 6 PAN LEFT HAND
1	1	1	1	1	1	1	1	1	4	DOOR ASSEMBLY 6 PAN RIGHT HAND
1	1	1	1	1	1	1	1	1	3	PANEL, LEFT SIDE
1	1	1	1	1	1	1	1	1	2	BOTTOM SHELL (6 PAN)
1	1	1	1	1	1	1	1	1	1	CHAMBER WELD ASSEMBLY 6 PAN STEAMER - LH CAST TAMPER-PROOF
1	1	1	1	1	1	1	1	1	1	CHAMBER WELD ASSEMBLY 6 PAN STEAMER - RH CAST TAMPER-PROOF
1	1	1	1	1	1	1	1	1	1	CHAMBER WELD ASSEMBLY 6 PAN STEAMER - LH CAST
1	1	1	1	1	1	1	1	1	1	CHAMBER WELD ASSEMBLY 6 PAN STEAMER - RH CAST
1	1	1	1	1	1	1	1	1	1	CHAMBER WELD ASSEMBLY 6 PAN STEAMER - LH FIREBAR TAMPER-PROOF UNIT
1	1	1	1	1	1	1	1	1	1	CHAMBER WELD ASSEMBLY 6 PAN STEAMER - RH FIREBAR
1	1	1	1	1	1	1	1	1	1	HAMBER WELD ASSY 6 PAN STEAMER - LH FIREBAR



 VCCILLIUM

Name: Date:

 Drawn: Dimensional:

 Checked: Dwg #:

 Project Eng: Date:

 Project Manager:

2 - Engineer

3 - Project Director - (005) National

4 - Project Manager

5 - Design Engineer

6 - Project Engineer

7 - Project Engineer

8 - Project Engineer

9 - Project Engineer

10 - Project Engineer

11 - Project Engineer

12 - Project Engineer

13 - Project Engineer

14 - Project Engineer

15 - Project Engineer

16 - Project Engineer

17 - Project Engineer

18 - Project Engineer

19 - Project Engineer

20 - Project Engineer

21 - Project Engineer

22 - Project Engineer

23 - Project Engineer

24 - Project Engineer

25 - Project Engineer

26 - Project Engineer

27 - Project Engineer

28 - Project Engineer

29 - Project Engineer

30 - Project Engineer

31 - Project Engineer

32 - Project Engineer

33 - Project Engineer

34 - Project Engineer

35 - Project Engineer

36 - Project Engineer

37 - Project Engineer

38 - Project Engineer

39 - Project Engineer

40 - Project Engineer

41 - Project Engineer

42 - Project Engineer

43 - Project Engineer

44 - Project Engineer

45 - Project Engineer

46 - Project Engineer

47 - Project Engineer

48 - Project Engineer

49 - Project Engineer

50 - Project Engineer

51 - Project Engineer

52 - Project Engineer

53 - Project Engineer

54 - Project Engineer

55 - Project Engineer

56 - Project Engineer

57 - Project Engineer

58 - Project Engineer

59 - Project Engineer

60 - Project Engineer

61 - Project Engineer

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63 - Project Engineer

64 - Project Engineer

65 - Project Engineer

66 - Project Engineer

67 - Project Engineer

68 - Project Engineer

69 - Project Engineer

70 - Project Engineer

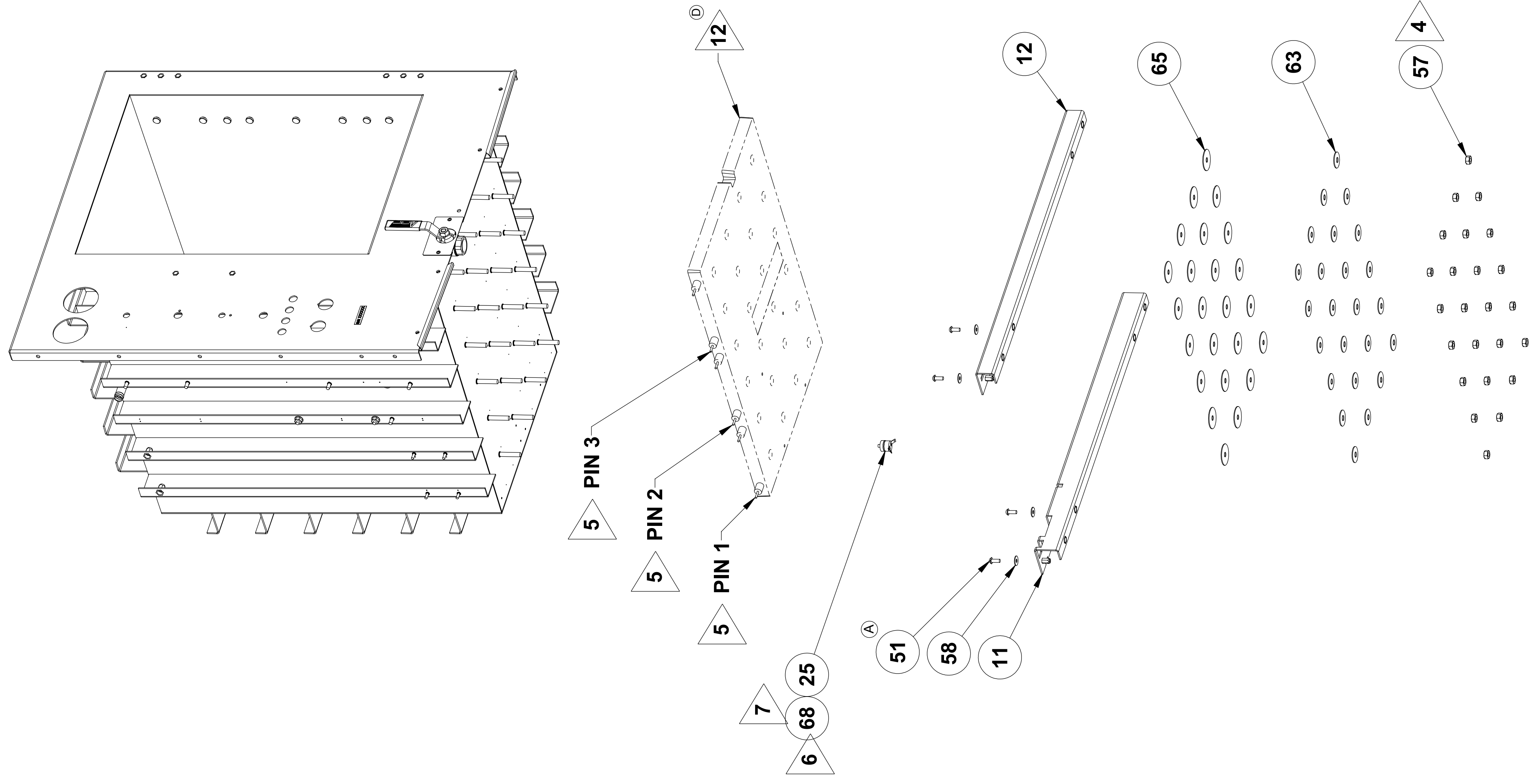
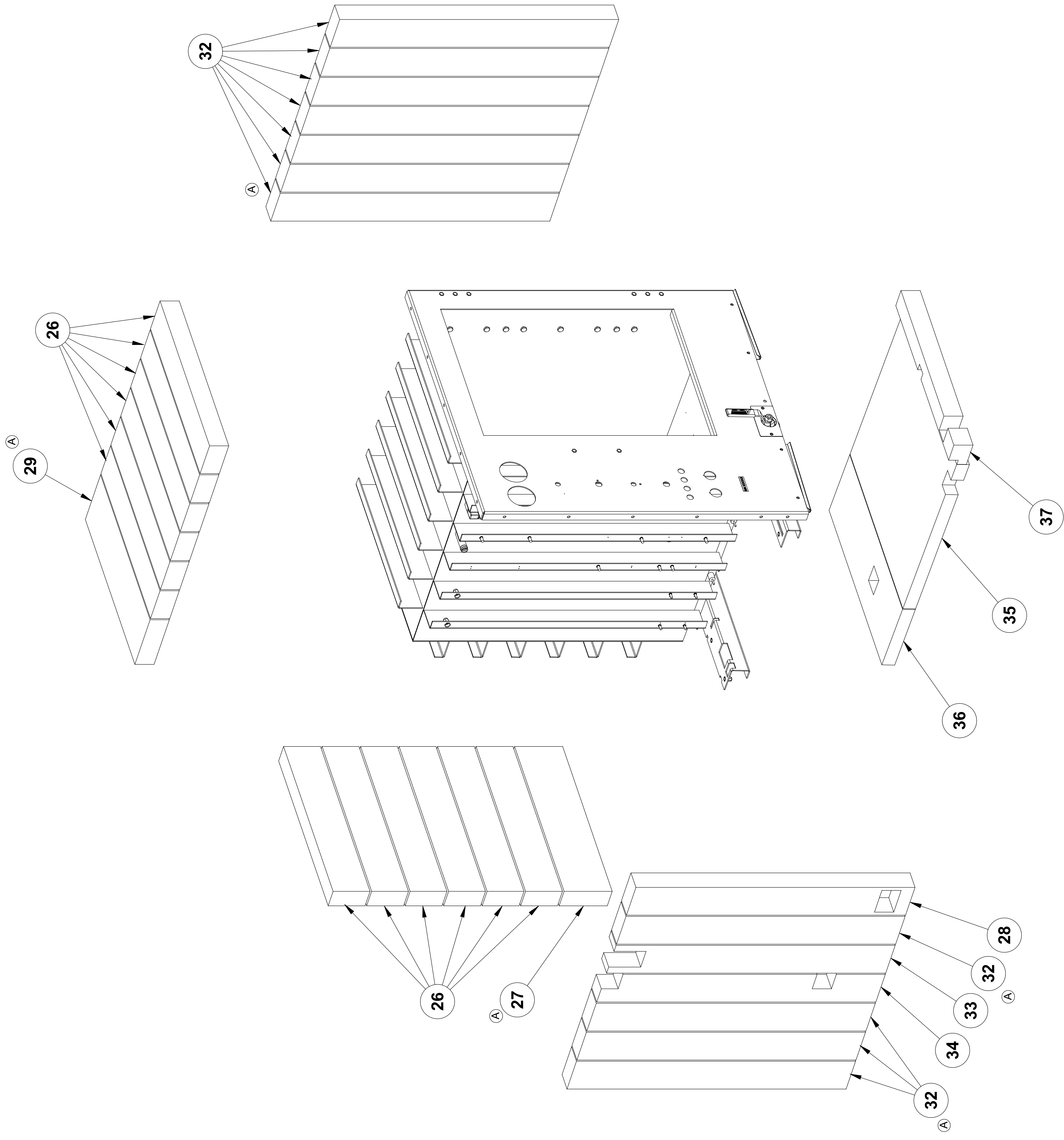
71 - Project Engineer

72 - Project Engineer

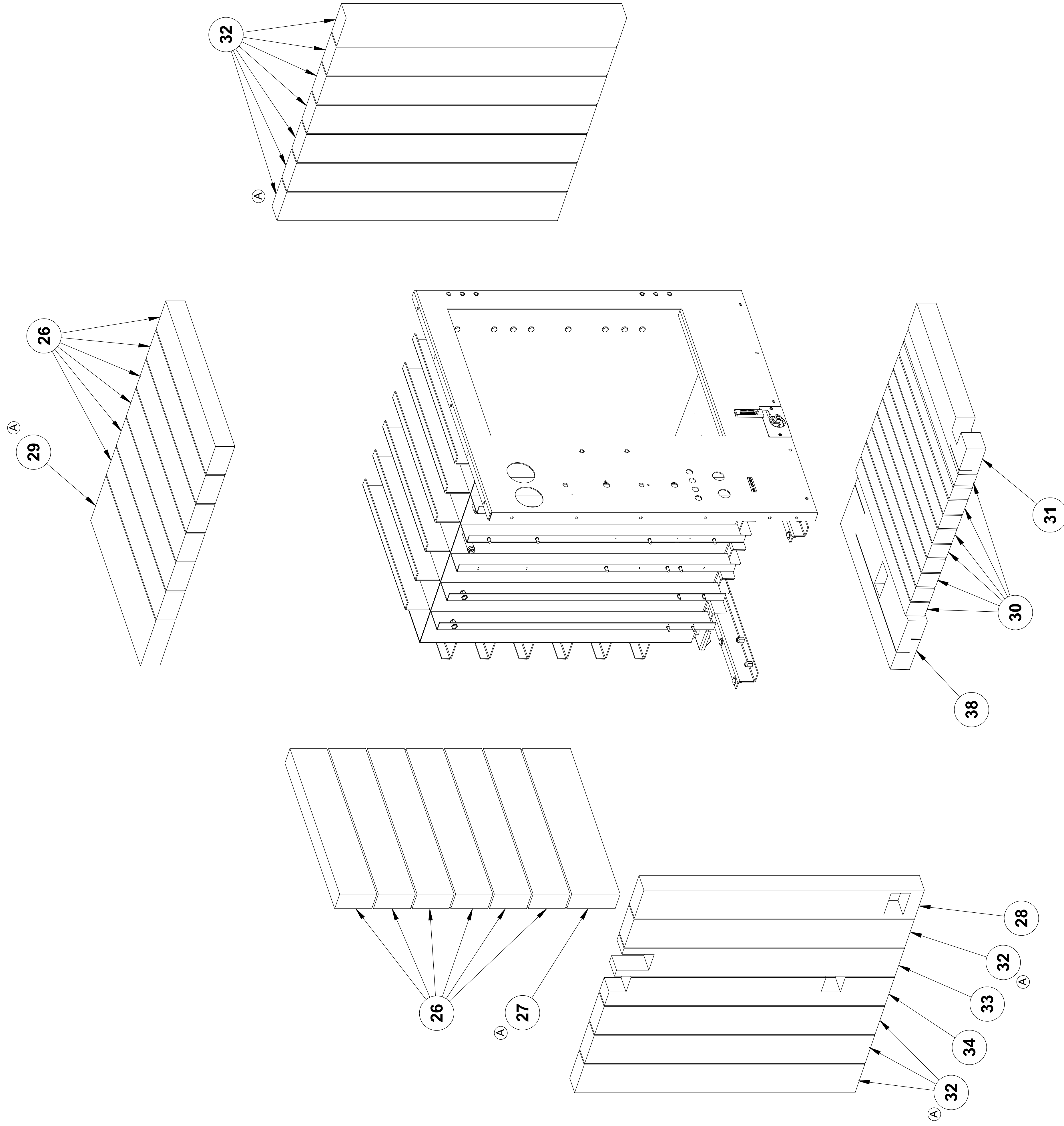
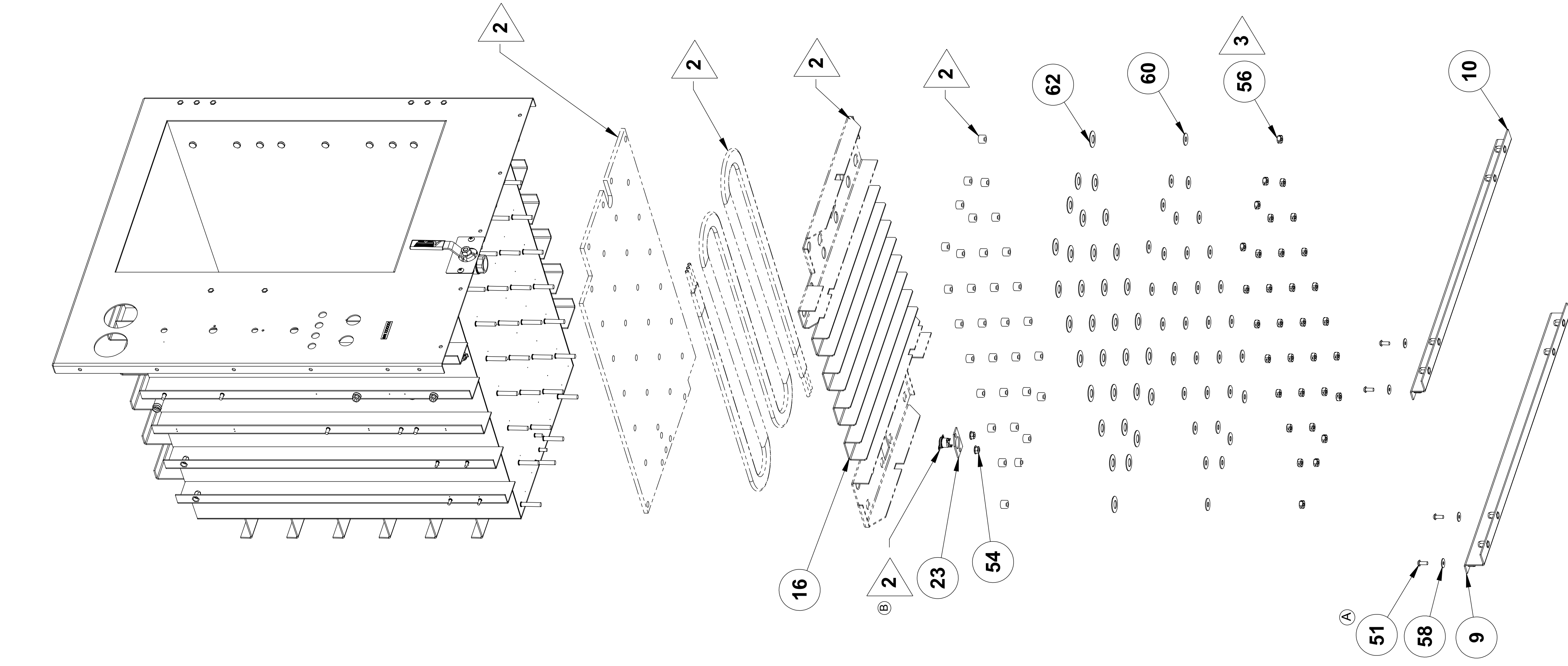
73 - Project Engineer

74 - Project Engineer

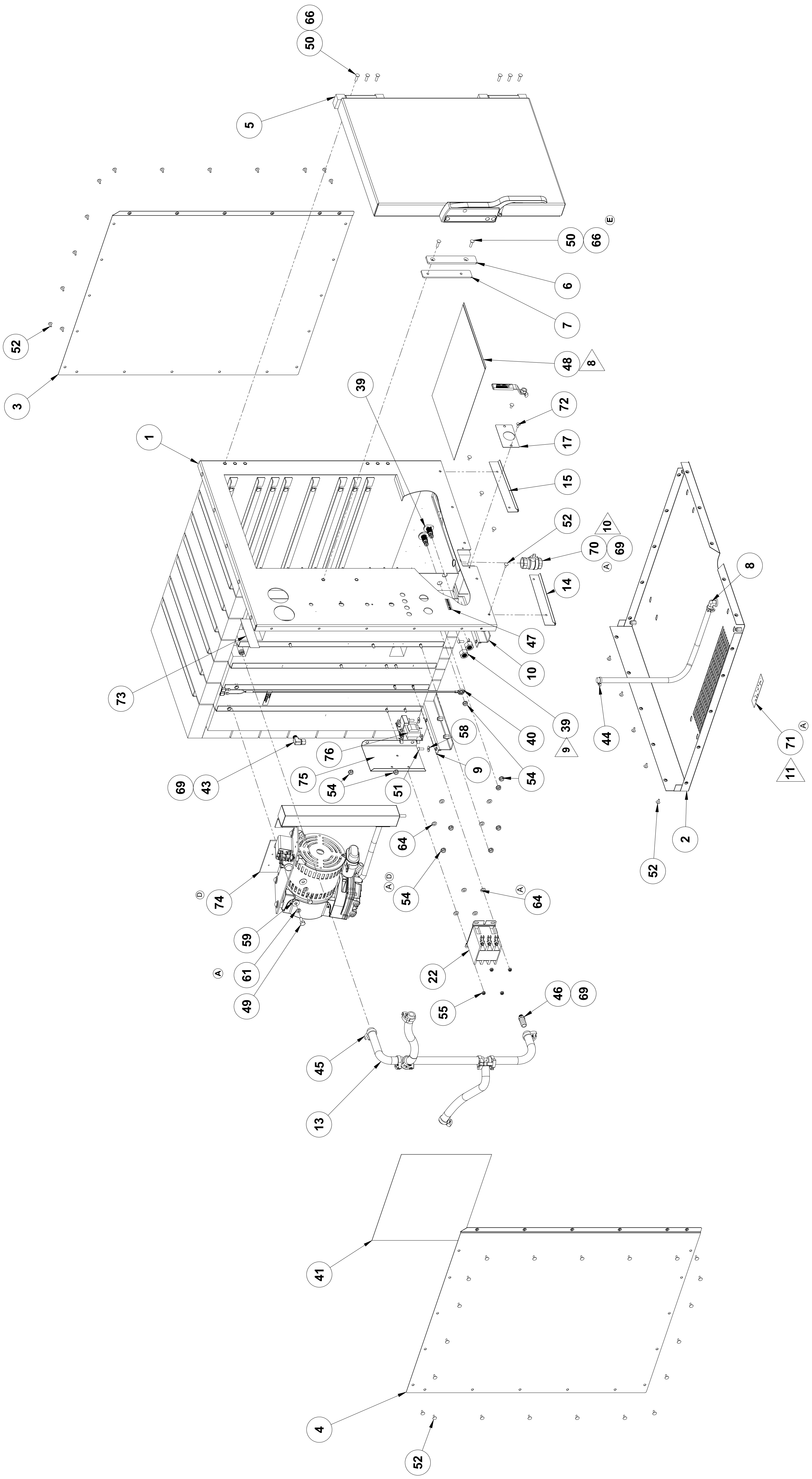
75 - Project Engineer



AT1A-3377-5 THRU AT1A-3377-8
 OTHERWISE SAME AS AT1A-3377-1 THRU AT1A-3377-4
 SOME COMPONENTS ARE REMOVED FOR CLARITY

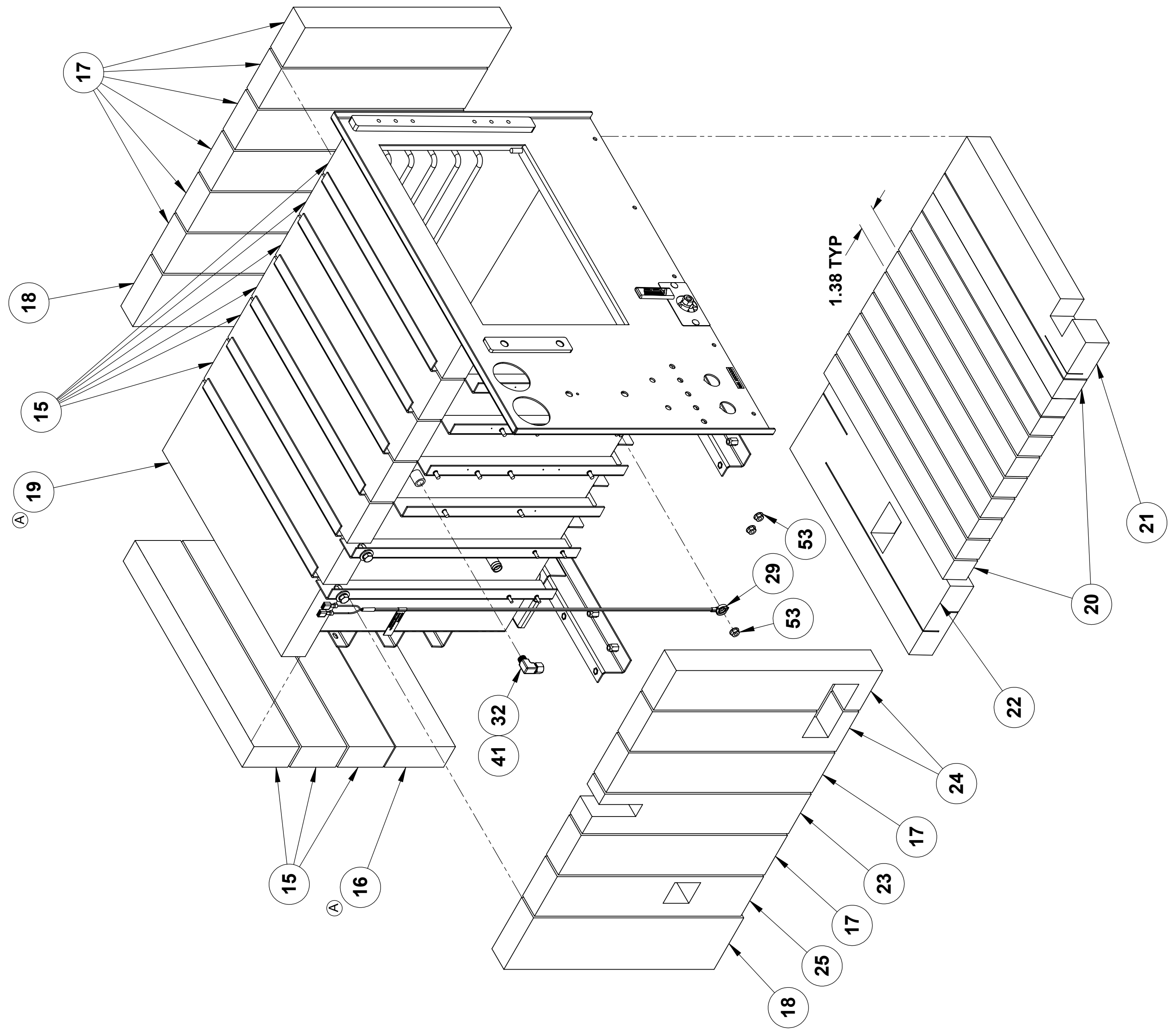


AT1A-3377-1 THRU AT1A-3377-4
SOME COMPONENTS ARE REMOVED FOR CLARITY

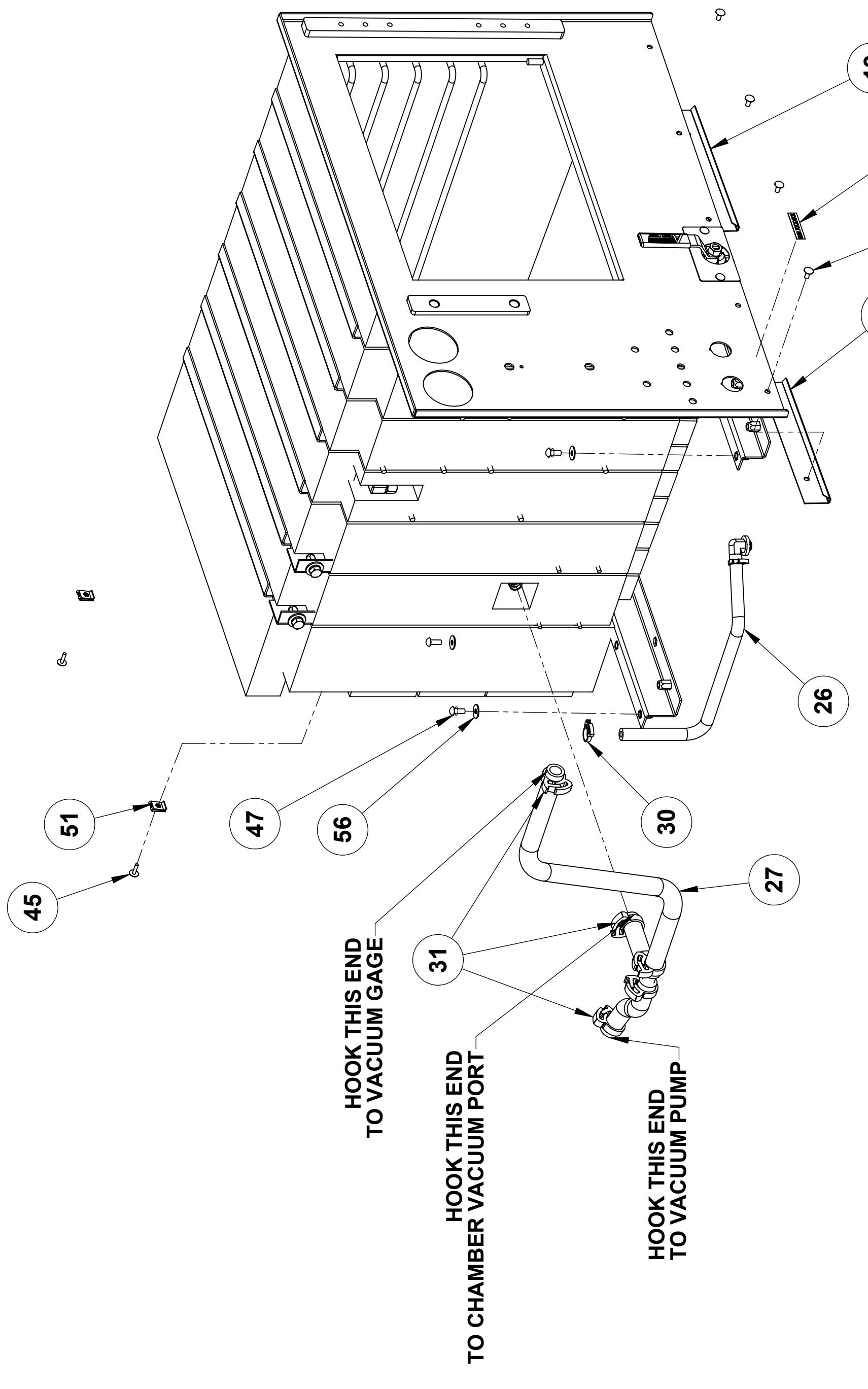


AT1A-3377-1 THRU AT1A-3377-8

SOME COMPONENTS ARE REMOVED FOR CLARITY



AT1A-2650-1 AND AT1A-2650-2
SOME COMPONENTS ARE REMOVED FOR CLARITY



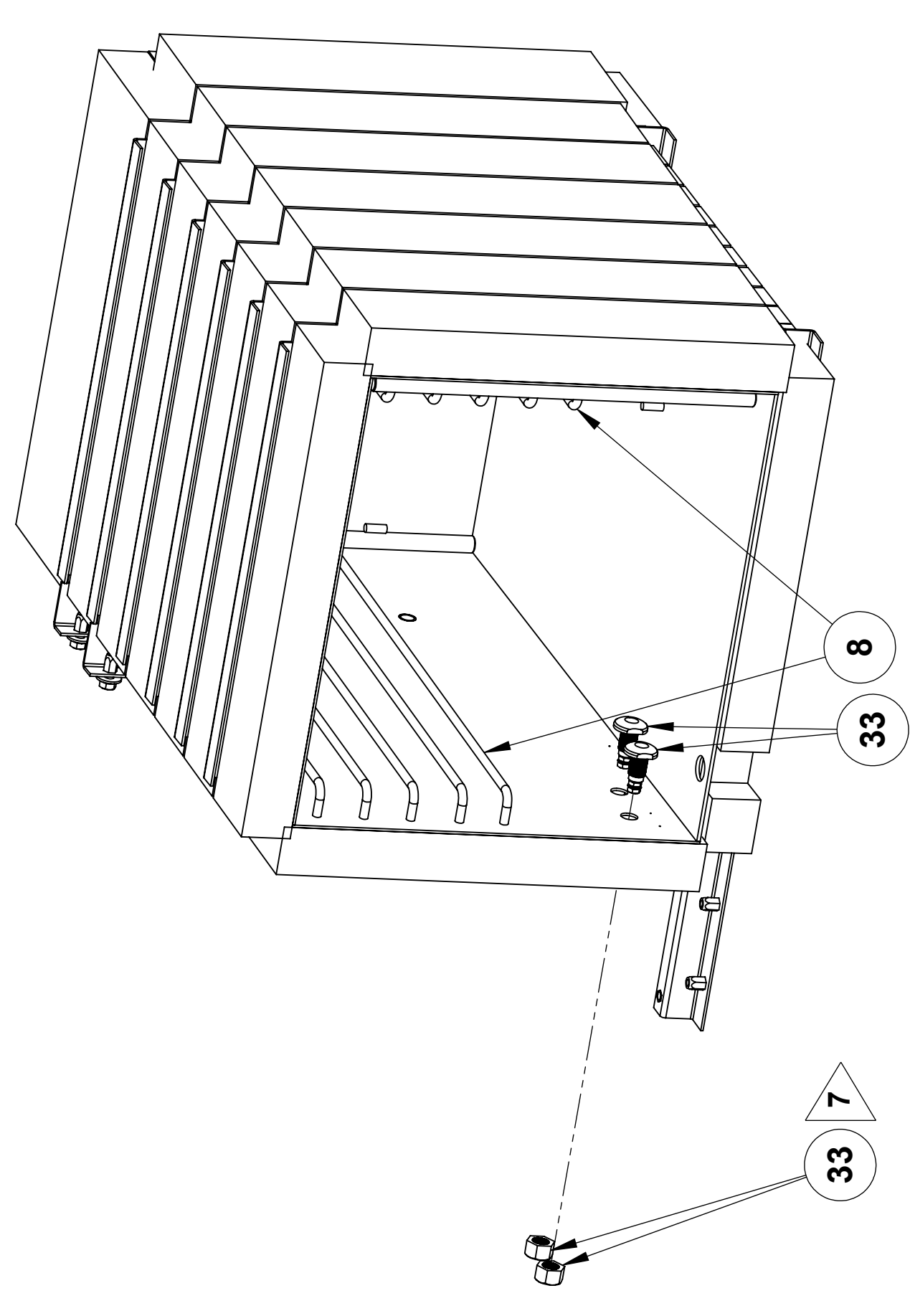
HOOK THIS END TO VACUUM GAGE

HOOK THIS END TO CHAMBER VACUUM PORT

HOOK THIS END TO VACUUM PUMP

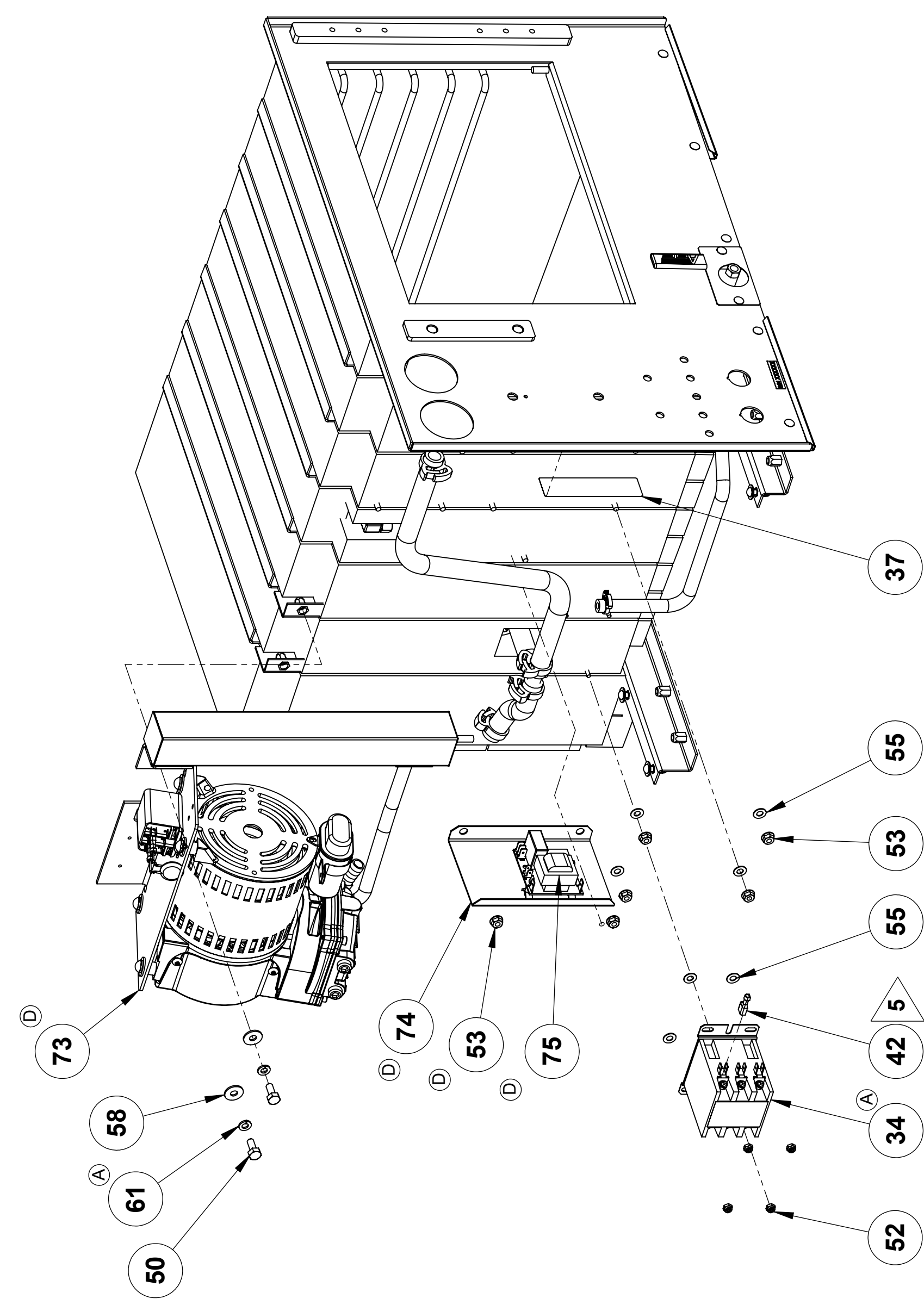
SOME COMPONENTS ARE REMOVED FOR CLARITY

AT1A-2650-3 AND AT1A-2650-4
OTHERWISE SAME AS AT1A-2650-1
SOME COMPONENTS ARE REMOVED FOR CLARITY

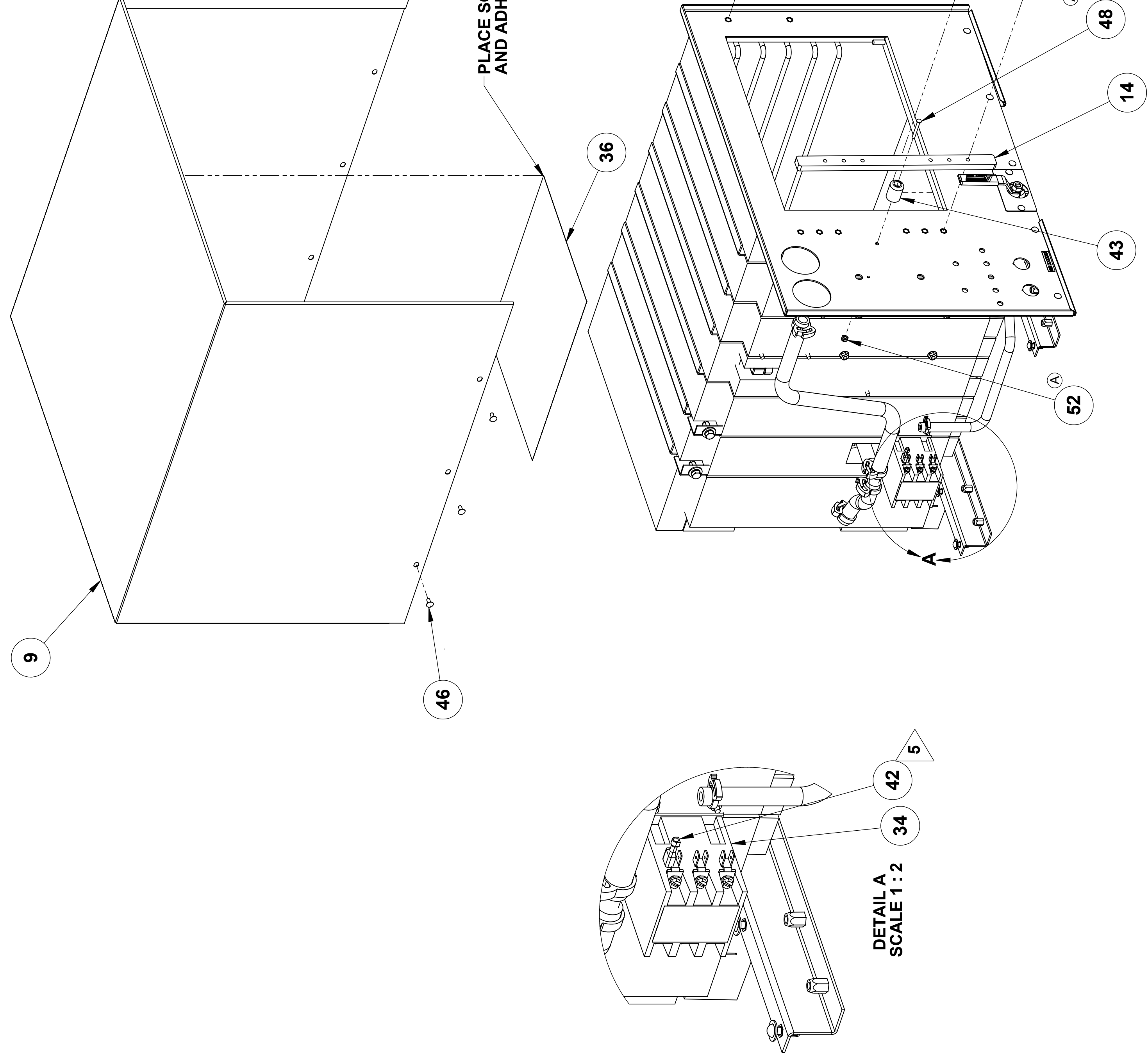


SOME COMPONENTS ARE REMOVED FOR CLARITY

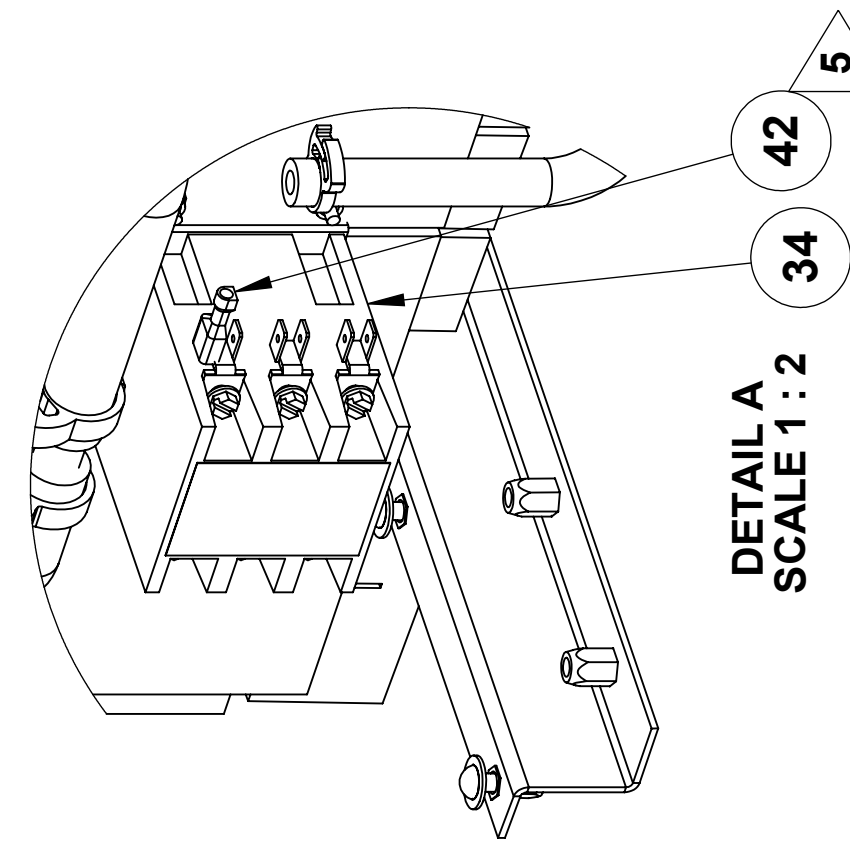
PLACE SCHEMATIC (AT1A-3358 MODULE) INSIDE ITEM 36 AND ADHERE TO UNDERSIDE OF TOP COVER.



SOME COMPONENTS ARE REMOVED FOR CLARITY



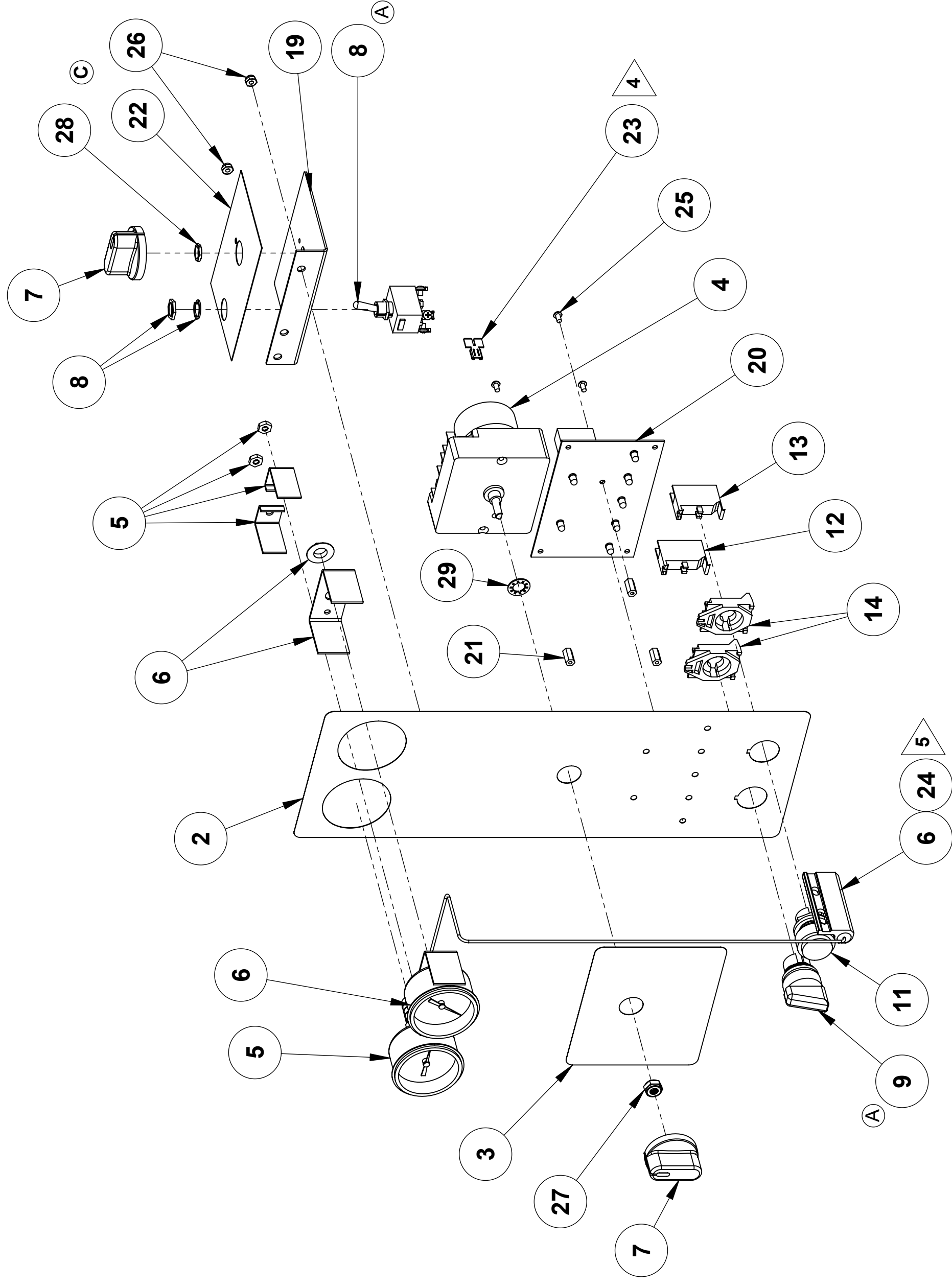
SOME COMPONENTS ARE REMOVED FOR CLARITY



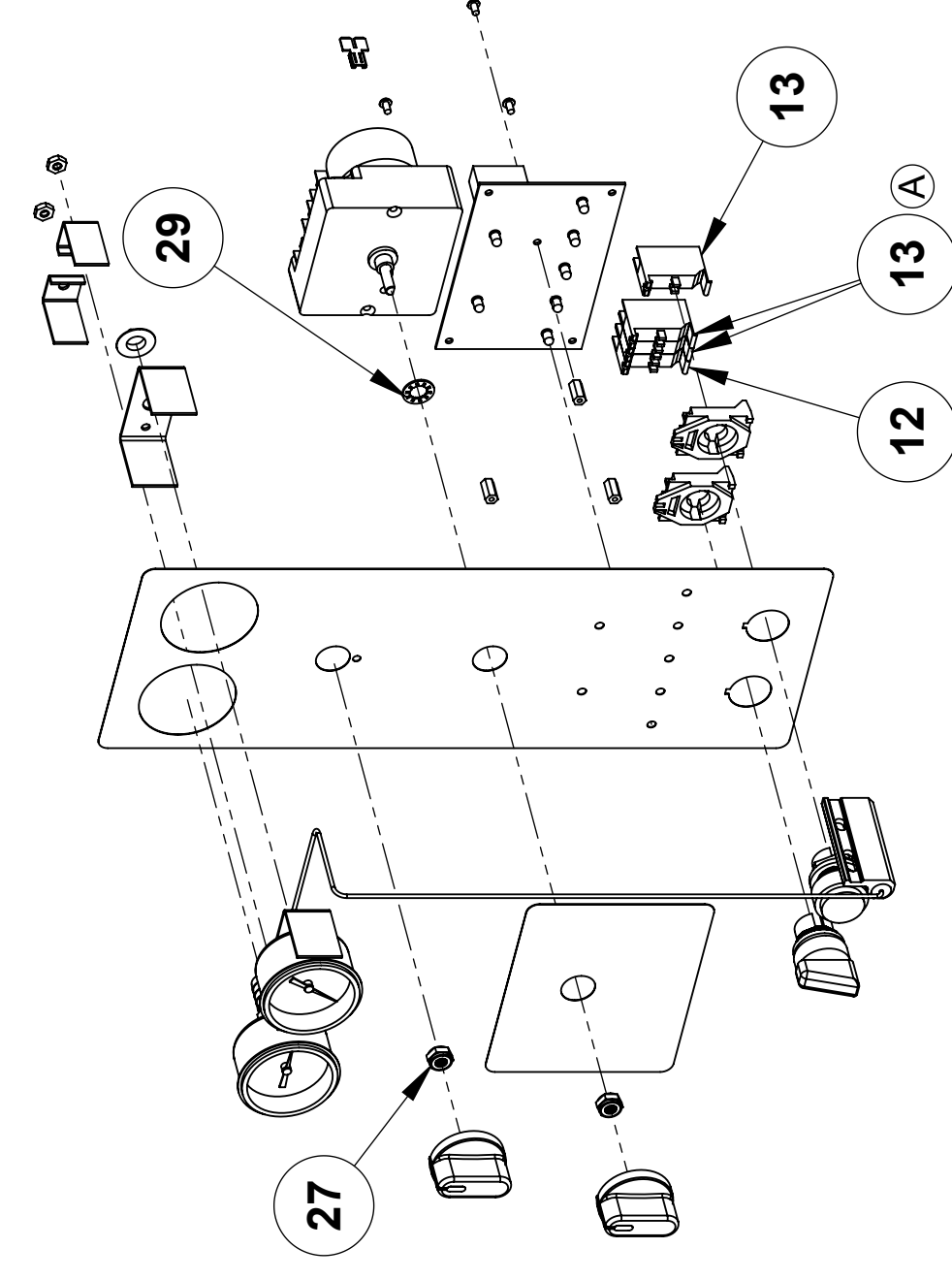
DETAIL A
SCALE 1:2

PLACE THIS ITEM INTO EMPTY, DRY CHAMBER FOR SHIPPING

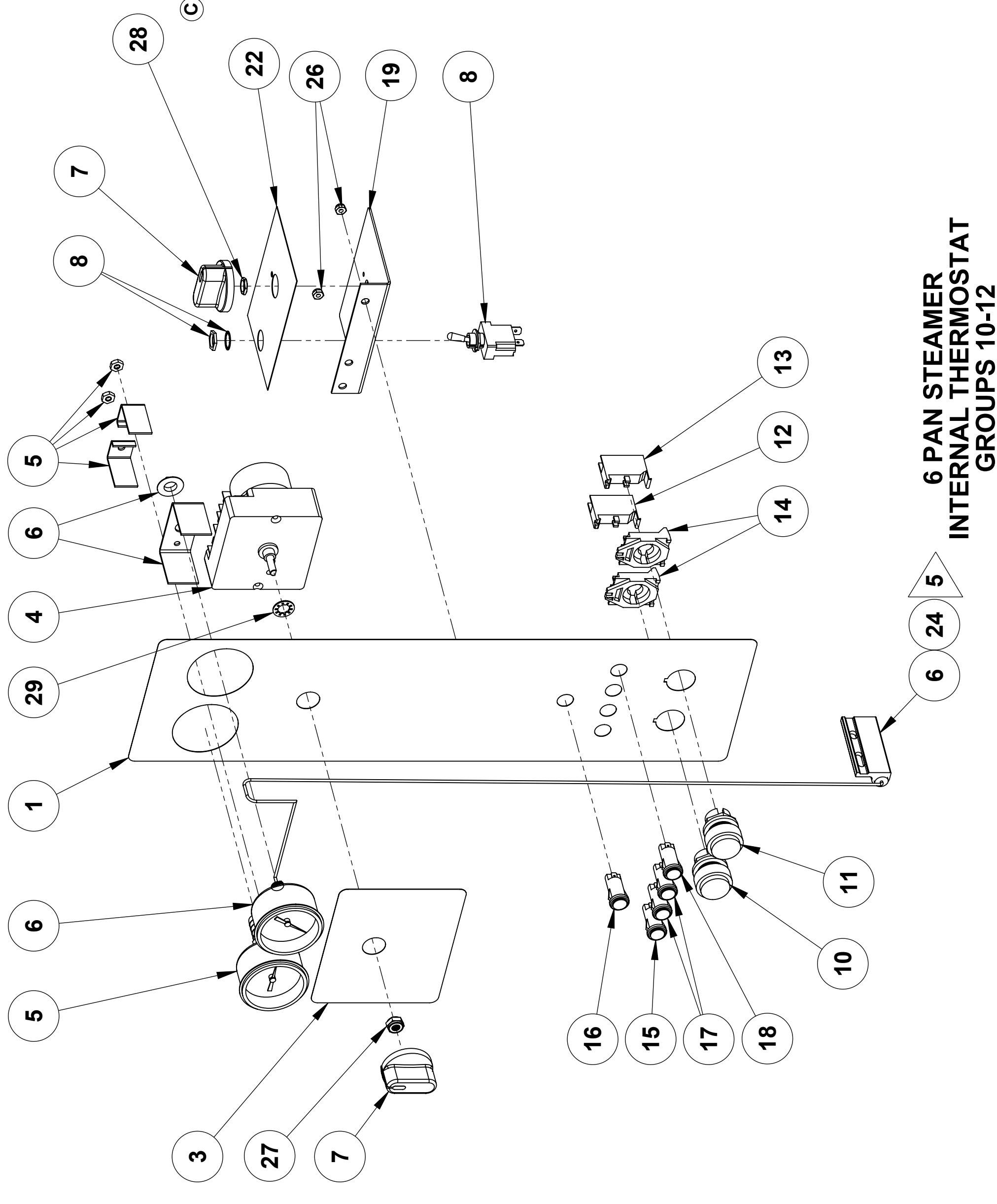
 Accutemp Products, Inc. Fort Wayne, IN 46826		Name: D300 Drawn: LAW Checked: LAW Project ETO: LAW Date: 10/13/2008 Title: MODULE 3 PAN COMMON COMPONENTS
Dimensions: Inches Tolerances: 1 - Regular Precision: .005 2 - Fine Precision: .0025 3 - Free Precision: .0105 4 - As Shown: .0105 5 - 1/25 Micro Inches 6 - .005 Micro Inches Comments: Do Not Scale Drawing	Material: N/A Finish: N/A Scale: 1:1 ECK: 308 Sheet: 2 of 2	Part No.: AT1A-2650 Rev: F



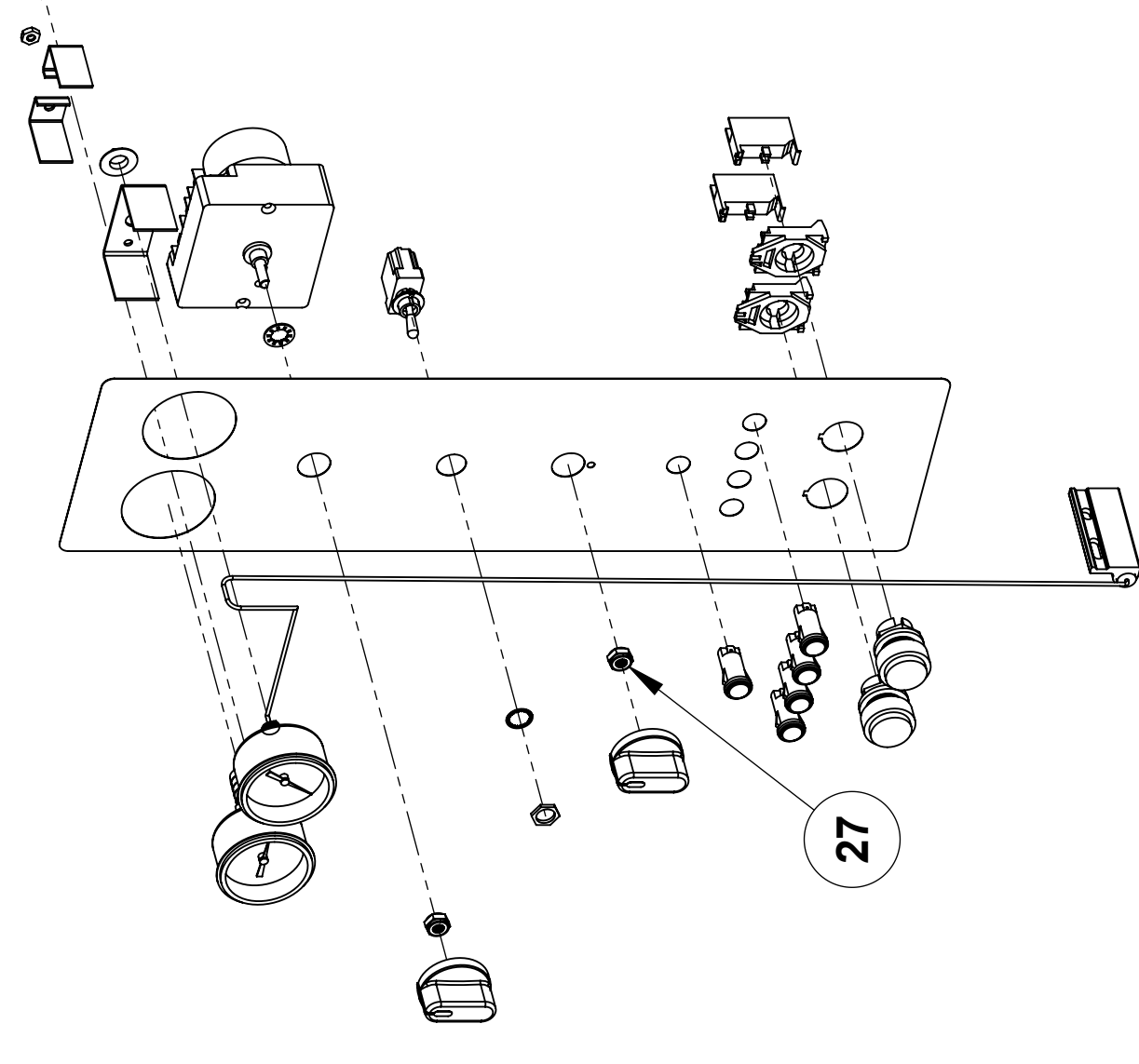
**3 PAN STEAMER
INTERNAL THERMOSTAT
GROUPS 4-6**



**3 PAN STEAMER
EXTERNAL THERMOSTAT
GROUPS 1-3
OTHERWISE SAME AS GROUPS 4-6**

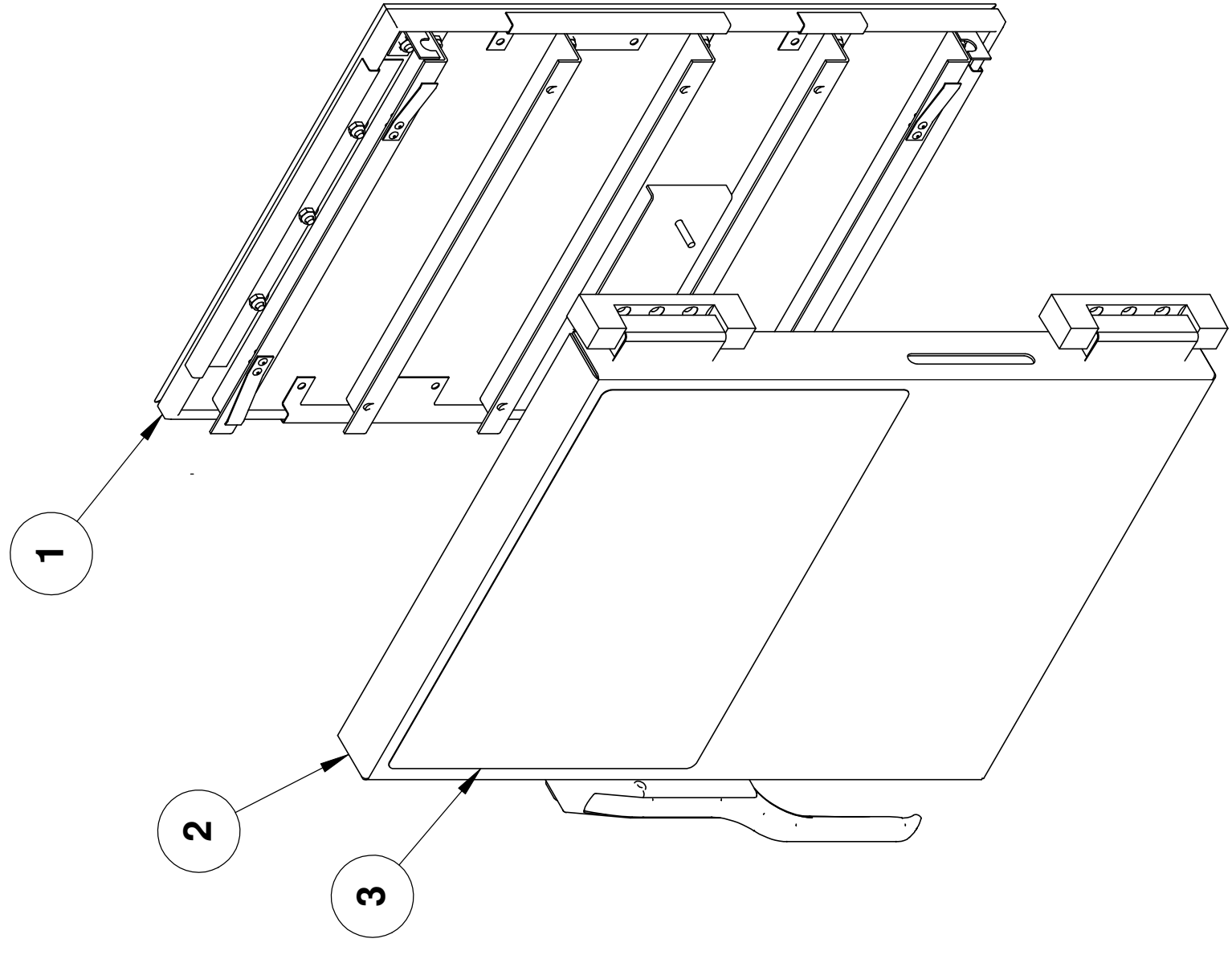


**6 PAN STEAMER
INTERNAL THERMOSTAT
GROUPS 10-12**

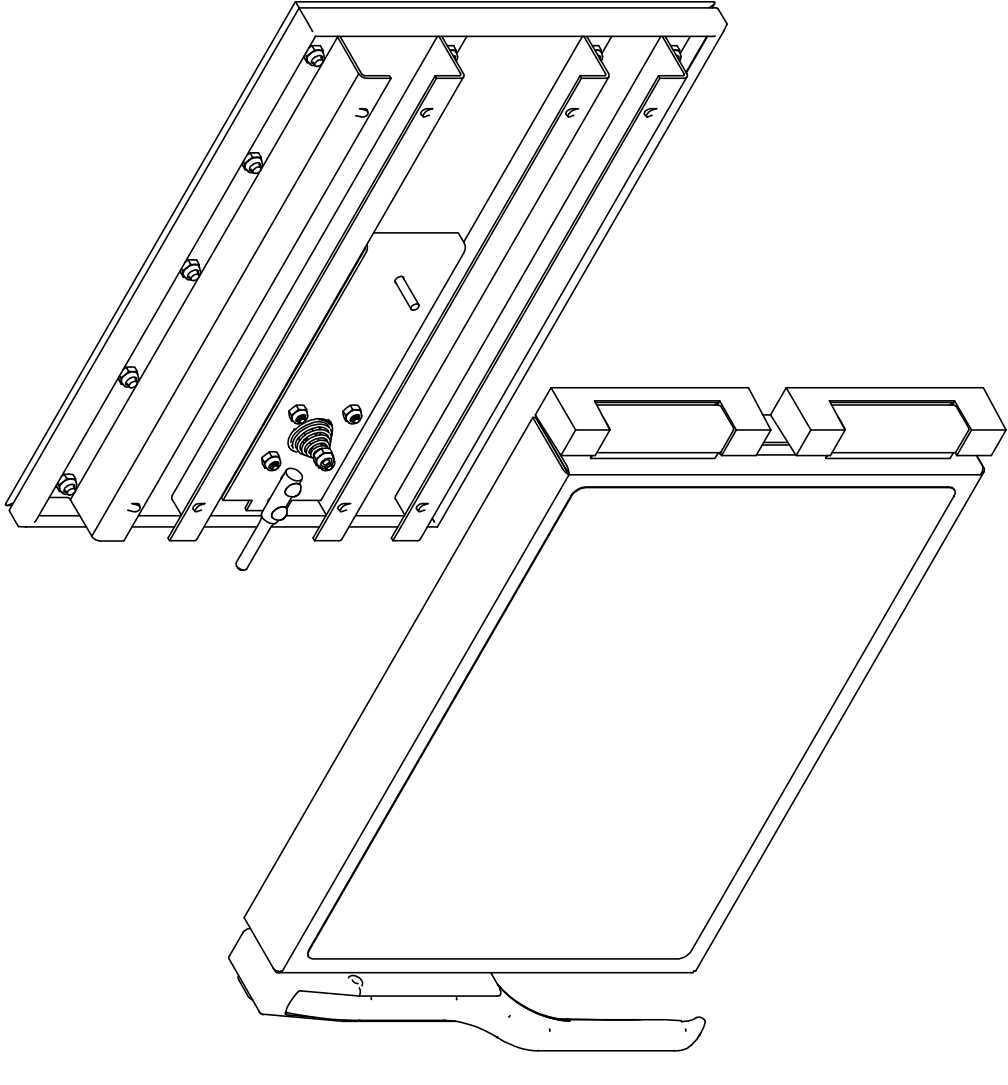


**6 PAN STEAMER
EXTERNAL THERMOSTAT
GROUPS 7-9
OTHERWISE SAME AS GROUPS 10-12**

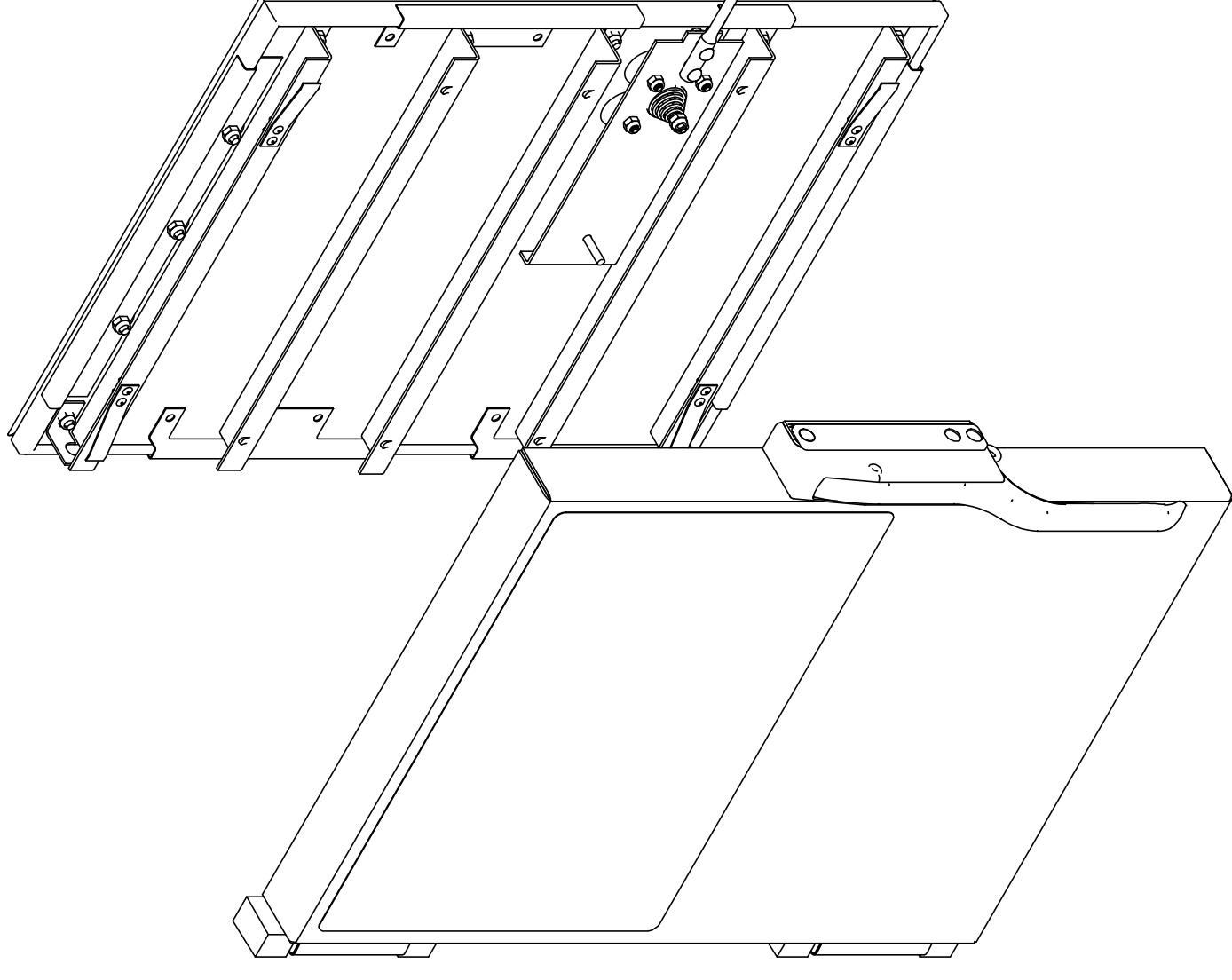
Unless otherwise specified, Units: Inches Bends: 90° Tolerances: Angular: ±1° 2 Place Decimal: ±.05 3 Place Decimal: ±.005 GD&T Per ANSI Y14.5M Comments: Do Not Scale Drawing		Name	Date	AccuTemp Products, Inc 8415 N. Clinton Park Fort Wayne, IN 46825	
Drawn	ALB	10/12/2006	Checked	LRW	10/12/2006
Project Eng.	LRW	10/12/2006	Material:	N/A	
Title:			MODULE CONTROL PANEL		
Drawing No.:			AT1A-3078		
Finish:			N/A		
Scale:			1:4 ECN: 328		
Sheet:			2 of 2		



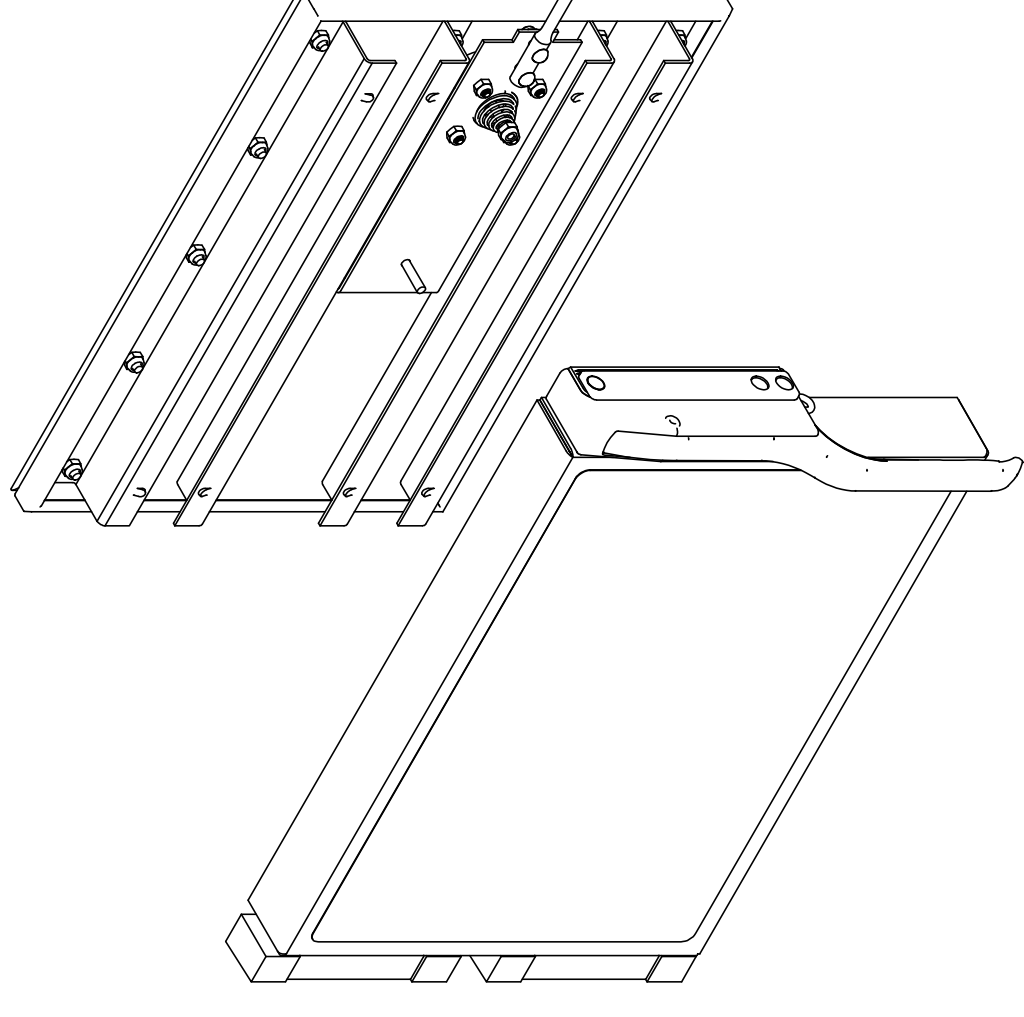
A
AT1A-2912-1 & AT1A-2912-5
DOOR ASSEMBLY 6 PAN RIGHT HAND



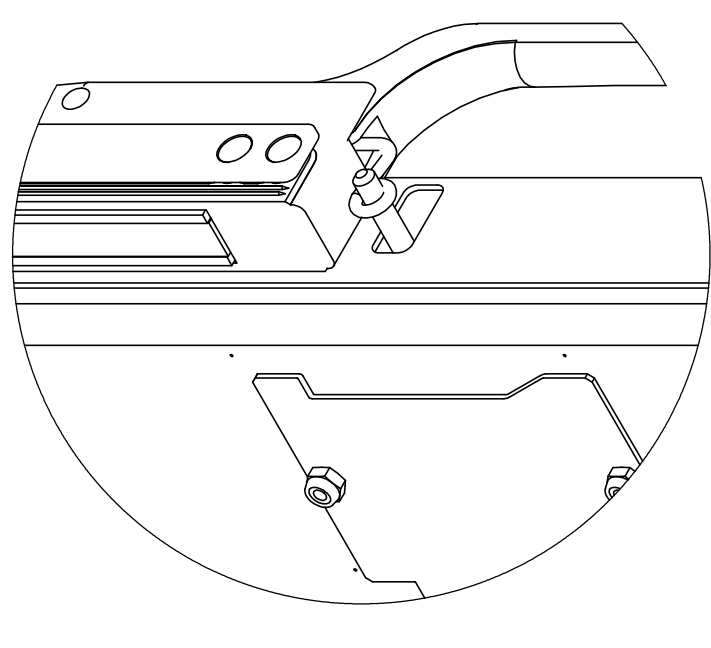
AT1A-2912-2
DOOR ASSEMBLY 3 PAN RIGHT HAND



A
AT1A-2912-3 & AT1A-2912-6
DOOR ASSEMBLY 6 PAN LEFT HAND



AT1A-2912-4
DOOR ASSEMBLY 3 PAN LEFT HAND



TYP INNER DOOR (ITEM #1) &
OUTER DOOR (ITEM #2) ASSEMBLY

QTY	AT1A-2912-6	AT1A-2912-5	AT1A-2912-4	AT1A-2912-3	AT1A-2912-2	AT1A-2912-1	PART NUMBER	ITEM	DESCRIPTION
1	1	1	1	1	1	1	AT1L-2594-1	3	OVERLAY, INSTRUCTIONS, STEAMER
1	-	-	-	-	-	-	AT1A-2428-6	2	OUTER DOOR ASSEMBLY 6 PAN LEFT HAND
-	1	-	-	-	-	-	AT1A-2428-5	2	OUTER DOOR ASSEMBLY 6 PAN RIGHT HAND
-	-	1	-	-	-	-	AT1A-2428-4	2	OUTER DOOR ASSEMBLY 3 PAN LEFT HAND
-	-	-	1	-	-	-	AT1A-2428-3	2	OUTER DOOR ASSEMBLY 6 PAN LEFT HAND
-	-	-	-	1	-	-	AT1A-2428-2	2	OUTER DOOR ASSEMBLY 3 PAN RIGHT HAND
-	-	-	-	-	1	-	AT1A-2428-1	2	OUTER DOOR ASSEMBLY 6 PAN RIGHT HAND
-	-	1	-	-	-	-	AT1A-2426-4	1	INNER DOOR ASSEMBLY 3 PAN LEFT HAND
1	-	-	1	-	-	-	AT1A-2426-6	1	INNER DOOR ASSEMBLY 6 PAN LEFT HAND
-	-	-	-	1	-	-	AT1A-2426-2	1	INNER DOOR ASSEMBLY 3 PAN RIGHT HAND
-	1	-	-	-	-	-	AT1A-2426-5	1	INNER DOOR ASSEMBLY 6 PAN RIGHT HAND

B

B

AccuTemp Products, Inc.
 8415 N. Clinton Park
 Fort Wayne, IN 46825

AccuTemp

Name: ALB
 Date: 07/14/04
 Drawn: RP
 Checked: RP
 Project Eng: RP
 Title: 022305

Unless otherwise specified:
 Dimensions: Inches
 Bends: 90°
 Tolerances:
 Angular: ±1°
 2 Place Decimal: ±.02
 3 Place Decimal: ±.005
 1 PL ±.005
 1.125 Micro Inches
 GD&T Per ANSI Y14.5M
 Comments:
 Do Not Scale Drawing

Rev. **B**
 Drawing No.: **AT1A-2912**
 Size: **D**
 Scale: 1/2" = 1'-0"

ECN: _____
 Sheet 1 of 1

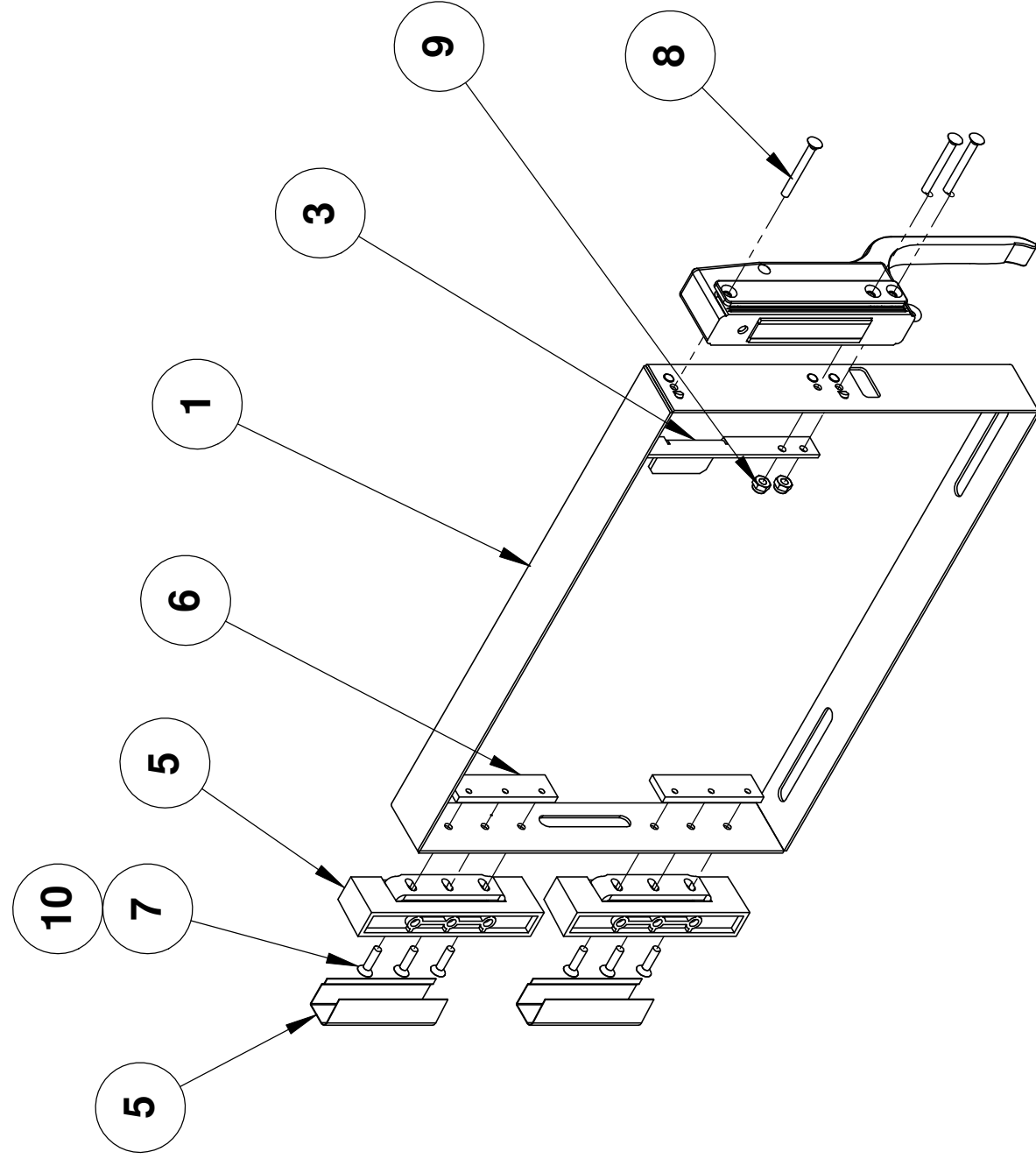
REV	DESCRIPTION	DATE	APP
402	B	04-14-08	LRW/ALB
384	A	08/15/07	GLS/DD
			RF/ALB
			GL/RS

NOTE:

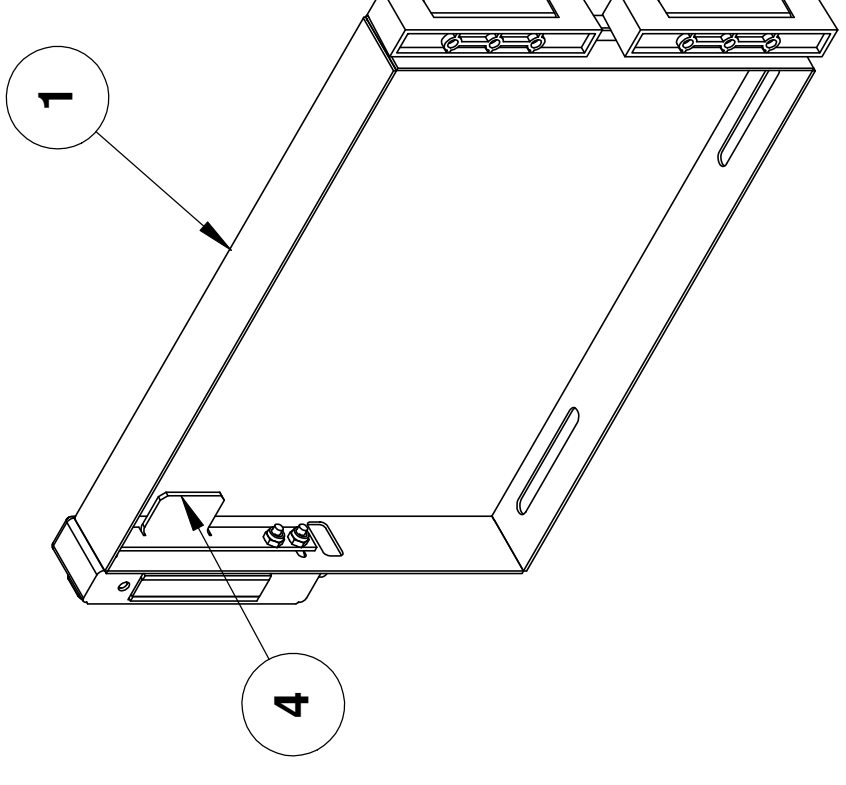
1. APPLY ITEM #10 ON ITEM #7 BEFORE ANY ASSEMBLY.
2. REMOVE ITEM #5 COVER FOR AT1A-2428-5 & -6

3 AT1A-2428-7 IS AN INTERIM REPLACEMENT FOR AT1A-2428-1.

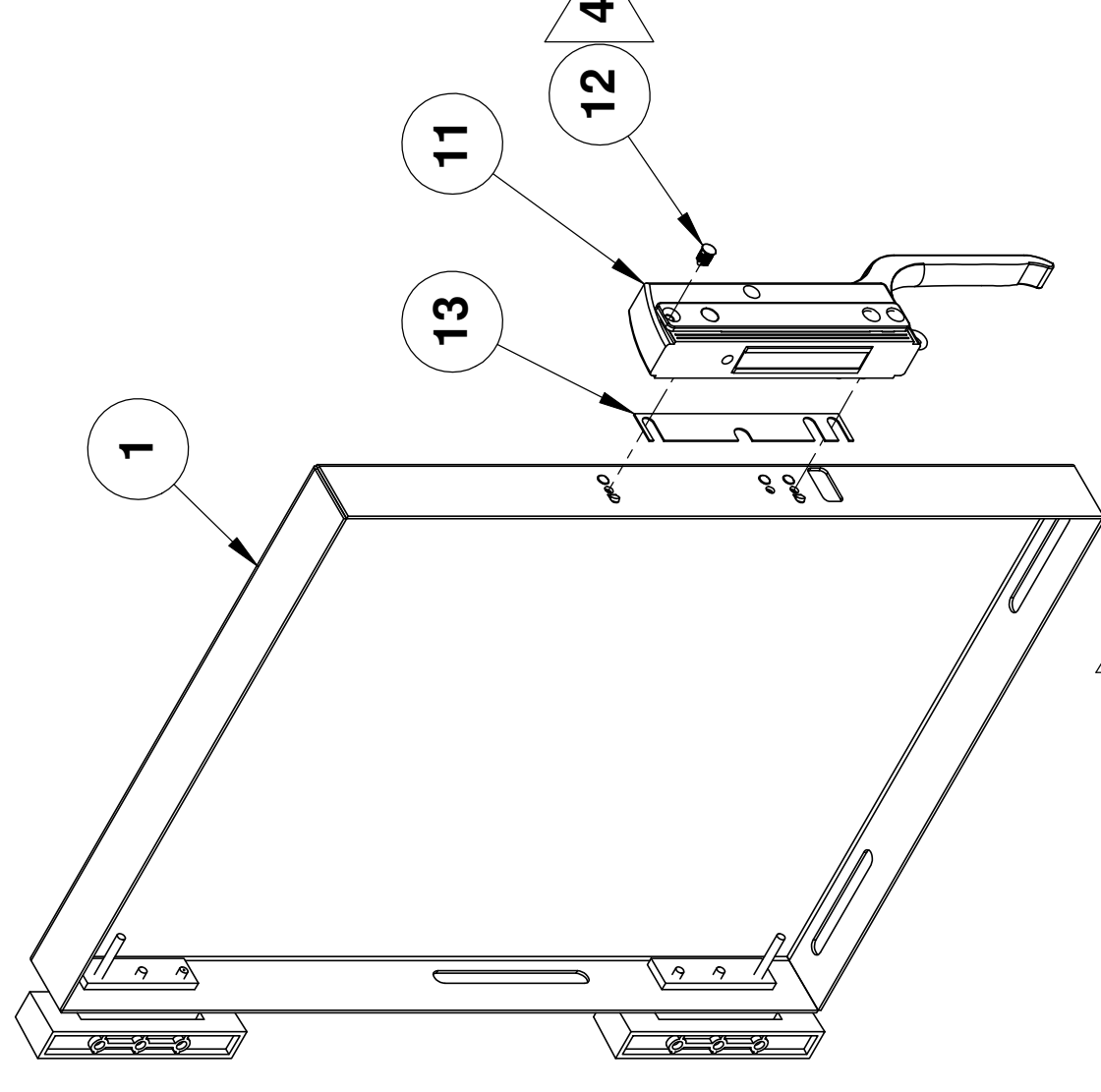
4 PUSH ITEM 12 FIRMLY INTO ITEM 11 UNTIL SUB-FLUSH IN COUNTERSUNK HOLE.



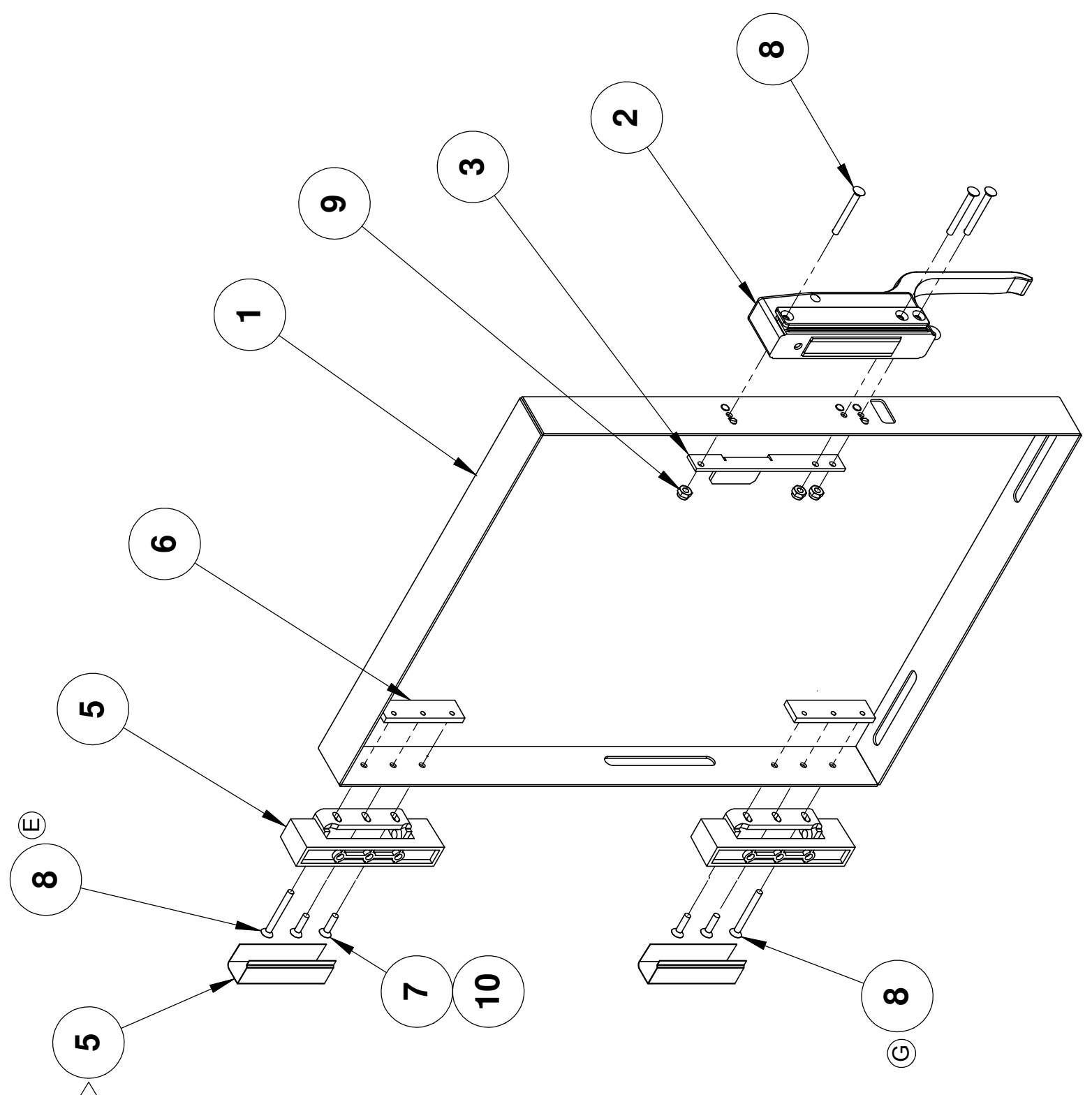
**AT1A-2428-2
OUTER DOOR ASSEMBLY 3 PAN RIGHT HAND**



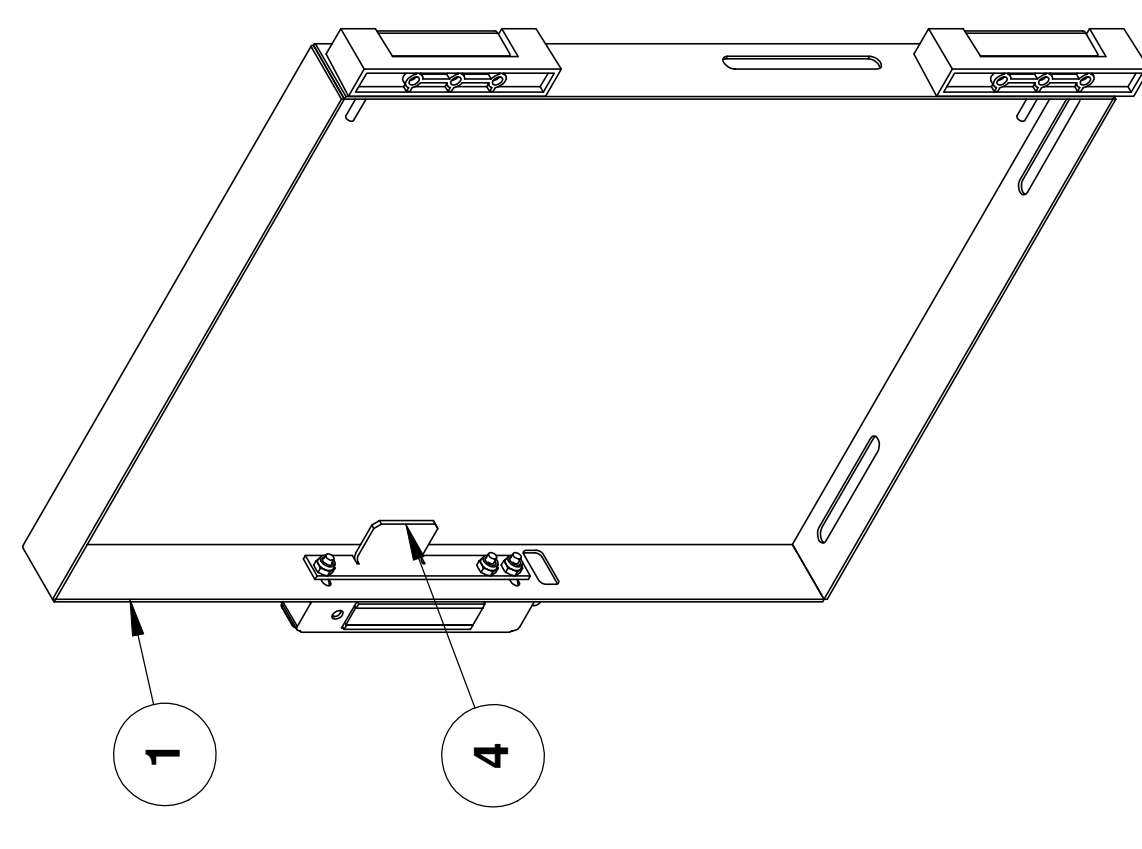
**AT1A-2428-4
OUTER DOOR ASSEMBLY 3 PAN LEFT HAND
(SAME AS -2 EXCEPT AS SHOWN)**



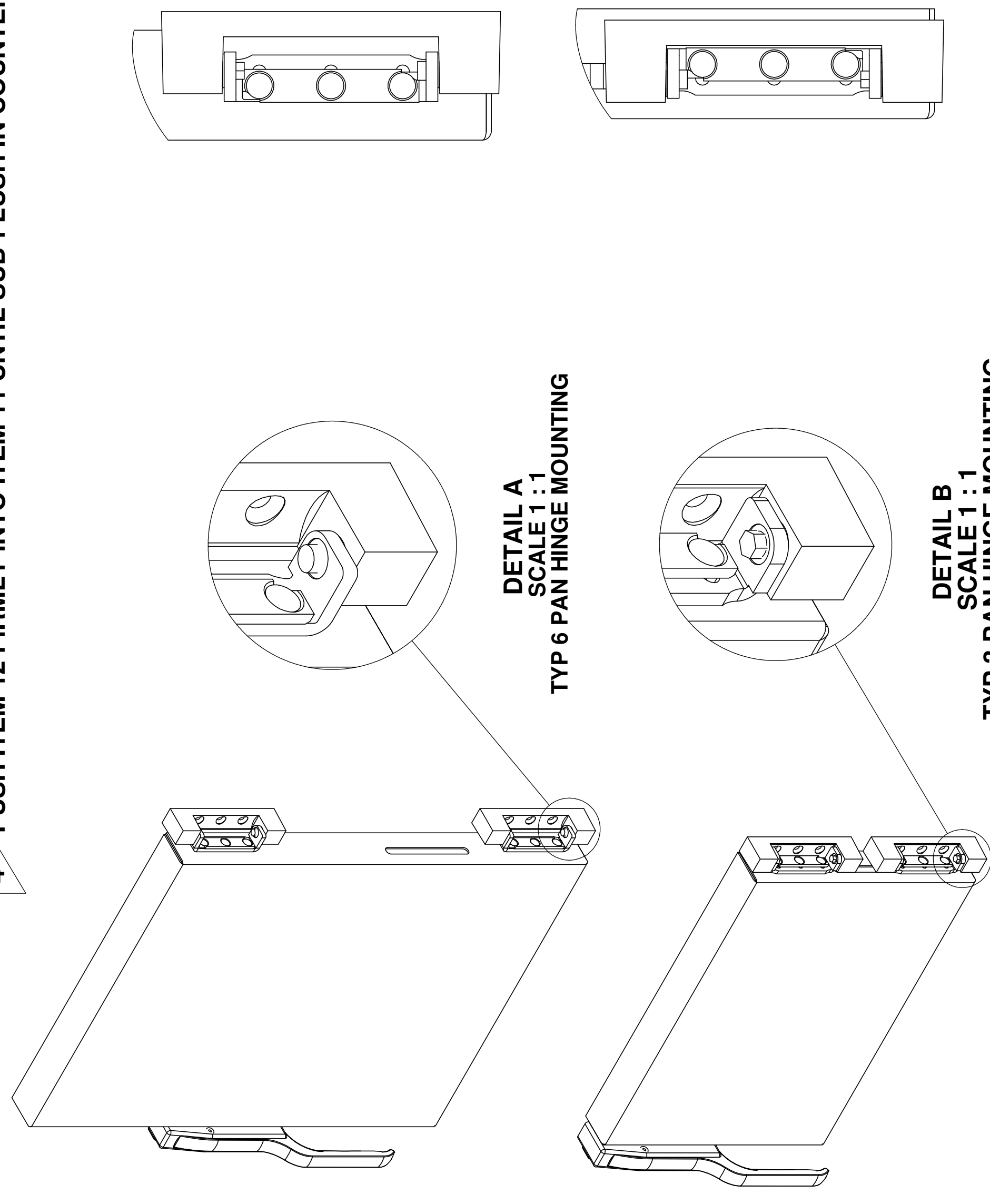
**AT1A-2428-7
OUTER DOOR ASSEMBLY 6 PAN RIGHT HAND
(SAME AS -1, EXCEPT AS SHOWN)**



**AT1A-2428-1 & AT1A-2428-5
OUTER DOOR ASSEMBLY 6 PAN RIGHT HAND**



**AT1A-2428-3 & AT1A-2428-6
OUTER DOOR ASSEMBLY 6 PAN LEFT HAND
(SAME AS -1, EXCEPT AS SHOWN)**



**DETAIL A
SCALE 1 : 1
TYP 6 PAN HINGE MOUNTING**

**DETAIL B
SCALE 1 : 1
TYP 3 PAN HINGE MOUNTING**

QTY	AT1A-2428-7	QTY	AT1A-2428-6	QTY	AT1A-2428-5	QTY	AT1A-2428-4	QTY	AT1A-2428-3	QTY	AT1A-2428-2	QTY	AT1A-2428-1	DESCRIPTION
1	1	1	1	1	1	1	1	1	1	1	1	1	1	SPACER, LATCH
1	1	1	1	1	1	1	1	1	1	1	1	1	1	BARBED PUSH FASTENER
1	1	1	1	1	1	1	1	1	1	1	1	1	1	LATCH HANDLE ASSEMBLY, INTERIM
3	3	3	3	3	3	3	3	3	3	3	3	3	3	THREAD LOCKER LIQUID 243
5	5	5	5	5	5	5	5	5	5	5	5	5	5	NUT, #10-24 X 1 3/4" FLAT HD MACH
5	5	5	5	5	5	5	5	5	5	5	5	5	5	SCREW, #10-24 X 2" DRL SPAN FLT HD MACH
4	4	4	4	4	4	4	4	4	4	4	4	4	4	SCREW, #10-24 X 3/4" FLAT HD MACH
2	2	2	2	2	2	2	2	2	2	2	2	2	2	HINGE MOUNTING PLATE
2	2	2	2	2	2	2	2	2	2	2	2	2	2	HINGE, STEAMER DOOR
1	1	1	1	1	1	1	1	1	1	1	1	1	1	LATCH MOUNTING PLATE LEFT HAND
1	1	1	1	1	1	1	1	1	1	1	1	1	1	LATCH MOUNTING PLATE RIGHT HAND
1	1	1	1	1	1	1	1	1	1	1	1	1	1	LATCH HANDLE ASSEMBLY
1	1	1	1	1	1	1	1	1	1	1	1	1	1	OUTER DOOR PANEL 3 PAN LEFT HAND
1	1	1	1	1	1	1	1	1	1	1	1	1	1	OUTER DOOR PANEL 6 PAN LEFT HAND
1	1	1	1	1	1	1	1	1	1	1	1	1	1	OUTER DOOR PANEL 3 PAN RIGHT HAND
1	1	1	1	1	1	1	1	1	1	1	1	1	1	OUTER DOOR PANEL 6 PAN RIGHT HAND

Description

Name	Date	Drawn	Checked	Project/Eng	RP	Material	Finish	Comments
ALB	2/2/2005	RP	RP	RP	RP	N/A	N/A	Do Not Scale Drawing

Part Number	Item No.	Description
AT1A-2428-1	1	OUTER DOOR ASSEMBLY QUICK RELEASE

QTY	AT1A-2428-7	QTY	AT1A-2428-6	QTY	AT1A-2428-5	QTY	AT1A-2428-4	QTY	AT1A-2428-3	QTY	AT1A-2428-2	QTY	AT1A-2428-1
1	1	1	1	1	1	1	1	1	1	1	1	1	1

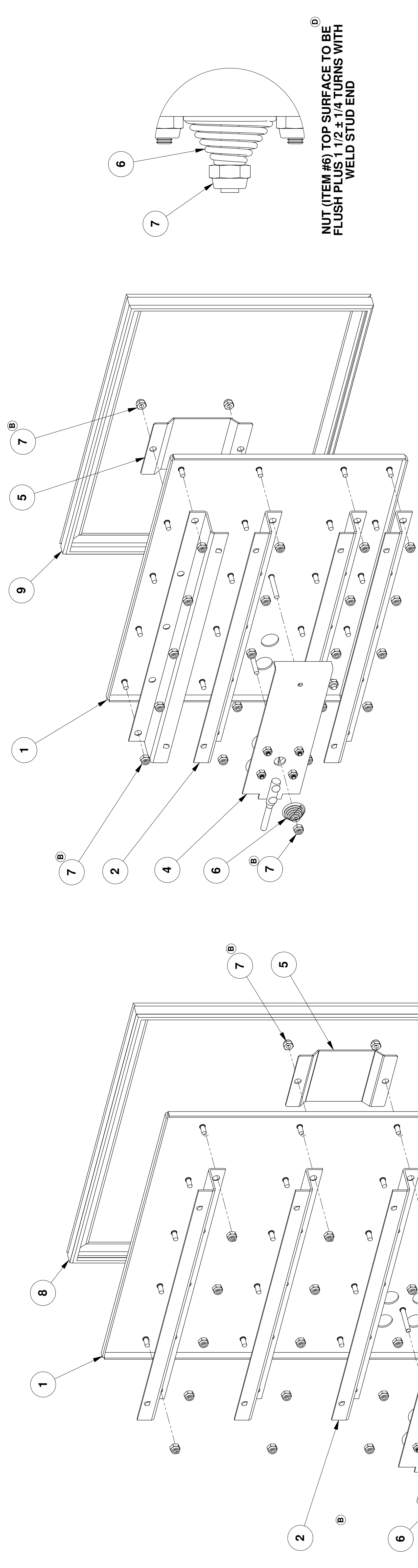
QTY	AT1A-2428-7	QTY	AT1A-2428-6	QTY	AT1A-2428-5	QTY	AT1A-2428-4	QTY	AT1A-2428-3	QTY	AT1A-2428-2	QTY	AT1A-2428-1
1	1	1	1	1	1	1	1	1	1	1	1	1	1

QTY	AT1A-2428-7	QTY	AT1A-2428-6	QTY	AT1A-2428-5	QTY	AT1A-2428-4	QTY	AT1A-2428-3	QTY	AT1A-2428-2	QTY	AT1A-2428-1
1	1	1	1	1	1	1	1	1	1	1	1	1	1

QTY	AT1A-2428-7	QTY	AT1A-2428-6	QTY	AT1A-2428-5	QTY	AT1A-2428-4	QTY	AT1A-2428-3	QTY	AT1A-2428-2	QTY	AT1A-2428-1
1	1	1	1	1	1	1	1	1	1	1	1	1	1

QTY	AT1A-2428-7	QTY	AT1A-2428-6	QTY	AT1A-2428-5	QTY	AT1A-2428-4	QTY	AT1A-2428-3	QTY	AT1A-2428-2	QTY	AT1A-2428-1
1	1	1	1	1	1	1	1	1	1	1	1	1	1

ECN	REV	DESCRIPTION	DATE	APPR
420	I	ADD'D: AT1A-2428-7, (BOM) ITEMS 11, 12 & 13; NOTES 3 & 4	06-18-08	DPS/ALB
402	H	CHG'D: (BOM) ITEM #8; GROUPS -1, -3, -5 & -6; QTY) 3 WAS 7	04-16-08	LRW/ALB
364	G	CHG'D: (AT1A-2428-1) ITEM #7, QTY 4 WAS 5; ITEM #8, QTY 5 WAS 4; ITEM #9, QTY 7 WAS 8; (AT1A-2428-3) ITEM #7, QTY 4 WAS 5; ITEM #8, QTY 7 WAS 8; (AT1A-2428-5 AND -6) GROUPS AT1A-2428-5 AND -6	09-09-07	LRW/DDI
340	F	CHG'D: AT0F-2061-41011 WAS AT0F-2061-41001	05-15-07	GLS/ALB
274	E	CHG'D: (AT1A-2428-1 & AT1A-2428-3) ITEM 10 AT0F-2061-41000 QTY 5 WAS 6; ITEM 11 AT0F-2061-41100 QTY 4 WAS 3	04-14-06	LEC/ATP
262	D	CHG'D: (AT1A-2428-1) ITEM NUMBERS, ITEM 2 AT1A-2644-1	02-28-06	LEC/ATP
213	C	ADD'D: ITEM #13 AND NOTE #1	04-02-05	RP/ALB
209	B	CHG'D: ITEM #12 WAS AT0F-2061-41002	02-10-05	RP/ALB
199	A	EDR-330 RELEASED TO PRODUCTION	07-16-04	JAH
		REV'D: OUTER DOOR ASSEMBLY		APPR



NUT (ITEM #6) TOP SURFACE TO BE FLUSH PLUS 1/2 ± 1/4 TURNS WITH WELD STUD END

**AT1A-2426-2
INNER DOOR ASSEMBLY 3 PAN RIGHT HAND**

**AT1A-2426-1
INNER DOOR ASSEMBLY 6 PAN RIGHT HAND**

**AT1A-2426-3
INNER DOOR ASSEMBLY 6 PAN LEFT HAND
(SAME AS -1 EXCEPT AS SHOWN)**

**AT1A-2426-4
INNER DOOR ASSEMBLY 3 PAN LEFT HAND
(SAME AS -2 EXCEPT AS SHOWN)**

QTY	AT1A-2426-6	QTY	AT1A-2426-5	QTY	AT1A-2426-4	QTY	AT1A-2426-3	QTY	AT1A-2426-2	QTY	AT1A-2426-1	PART NUMBER	ITEM NO.	Description
1	1	1	1	1	1	1	1	1	1	1	1	AT1G-2633-1	18	INNER DOOR GASKET (6 PAN)
4	4	4	4	4	4	4	4	4	4	4	4	AT1M-3525-1	17	SPRING, INNER DOOR
8	8	8	8	8	8	8	8	8	8	8	8	ATOF-3368-2	16	BLIND RIVET
2	2	2	2	2	2	2	2	2	2	2	2	AT1M-3524-1	15	RETAINER, SIDE DOOR GASKET
2	2	2	2	2	2	2	2	2	2	2	2	AT1M-3508-1	14	RETAINER, DOOR GASKET
2	2	2	2	2	2	2	2	2	2	2	2	AT1M-3507-1	13	RETAINER, SIDE SMALL DOOR GASKET
1	1	1	1	1	1	1	1	1	1	1	1	AT1M-3466-2	12	BRACKET, DOOR
1	1	1	1	1	1	1	1	1	1	1	1	AT1M-3466-1	11	BRACKET, DOOR
-	-	-	-	-	-	-	-	-	-	-	-	AT1G-2633-2	10	INNER DOOR GASKET (3 PAN)
-	-	-	-	-	-	-	-	-	-	-	-	AT1G-2633-1	9	INNER DOOR GASKET (6 PAN)
28	28	28	28	28	28	28	28	28	28	28	28	ATOF-2691-41011	8	NUT, #10-24 WAXED NYLOC
1	1	1	1	1	1	1	1	1	1	1	1	AT1H-2046-1	7	COMPRESSION SPRING
1	1	1	1	1	1	1	1	1	1	1	1	AT1M-3045-1	6	VALVE COVER
2	2	2	2	2	2	2	2	2	2	2	2	AT1A-2427-1	5	VALVE BRACKET ASSY.
3	3	3	3	3	3	3	3	3	3	3	3	AT1M-2424-3	4	Z BRACKET, INNER DOOR
1	1	1	1	1	1	1	1	1	1	1	1	AT1A-2424-2	3	Z BRACKET, INNER DOOR
-	-	-	-	-	-	-	-	-	-	-	-	AT1A-2687-6	2	INNER DOOR WELDMENT 6 PAN LEFT HAND
-	-	-	-	-	-	-	-	-	-	-	-	AT1A-2687-5	1	INNER DOOR WELDMENT 6 PAN RIGHT HAND
-	-	-	-	-	-	-	-	-	-	-	-	AT1A-2687-4	1	INNER DOOR WELDMENT 3 PAN LEFT HAND
-	-	-	-	-	-	-	-	-	-	-	-	AT1A-2687-3	1	INNER DOOR WELDMENT 3 PAN LEFT HAND
-	-	-	-	-	-	-	-	-	-	-	-	AT1A-2687-2	1	INNER DOOR WELDMENT 6 PAN LEFT HAND
-	-	-	-	-	-	-	-	-	-	-	-	AT1A-2687-1	1	INNER DOOR WELDMENT 6 PAN RIGHT HAND

ECN	REV	DESCRIPTION	DATE	APPR	REV	DESCRIPTION	DATE	APPR
407	E	CHGD: (BOM AT1A-2426-5 & 6) ITEM 2426-5 & 6 ITEM #15 WAS ATOF-1025-53000 QTY 4	05-02-08	LRW/ALB				
402	D	CHGD: NUT (ITEM #6) TOP SURFACE TO BE FLUSH PLUS 1/2 ± 1/4 TURNS (ITEM #6) TO BE FLUSH WITH WELD STUD. ADDED: SHIT 2 & AT1A-2426-5 & 6 (BOM) ITEMS 12 THRU 17.	04-16-08	LRW/ALB				
384	C	CHGD: ITEM #10 & #11, AT1M-3466-1 & 2	08/09/07	LRW/DDI				
286	B	CHGD: (ALL GRPS) ITEM 7 ATOF-2891-41011 WAS A10P-2581-141001	7-15-06	LEC/ATP				
209	A	CHGD: ITEM #7 WAS ATOF-2691-11002	03/02/05	RP				
ECN	REV	EDR-030 RELEASED TO PRODUCTION	02-10-05	RP/ALB				
		DESCRIPTION	DATE	APPR				
		REVISIONS						

Name	Date	Drawn	Checked	Project Eng	Material	Finish
ALB	02-09-05	RP	RP	RP	N/A	N/A
RP	02-09-05	RP	RP	RP	N/A	N/A

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Fort Wayne, IN 46825

INNER DOOR ASSEMBLY
QUICK RELEASE

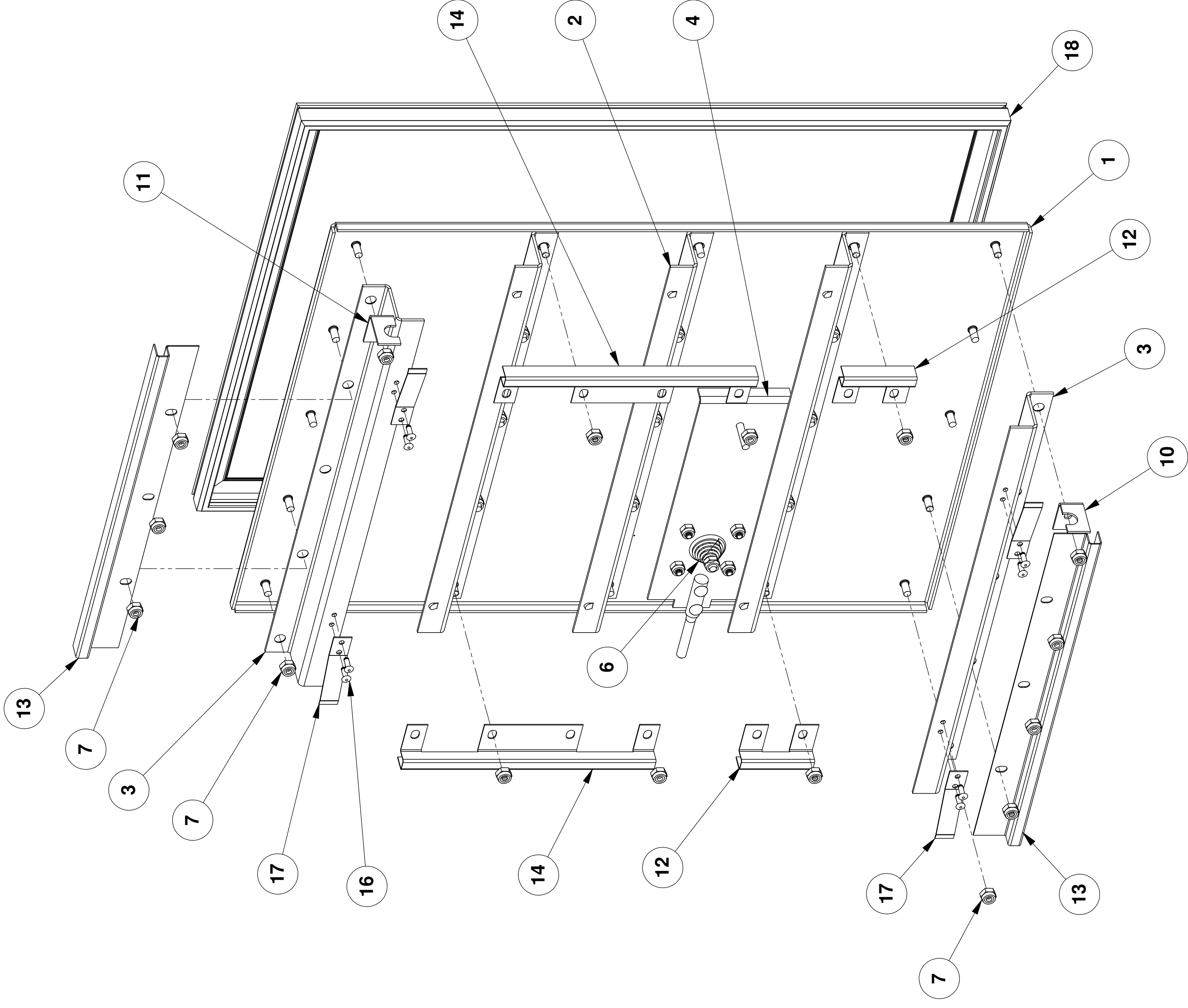
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D AT1A-2426

Rev. E

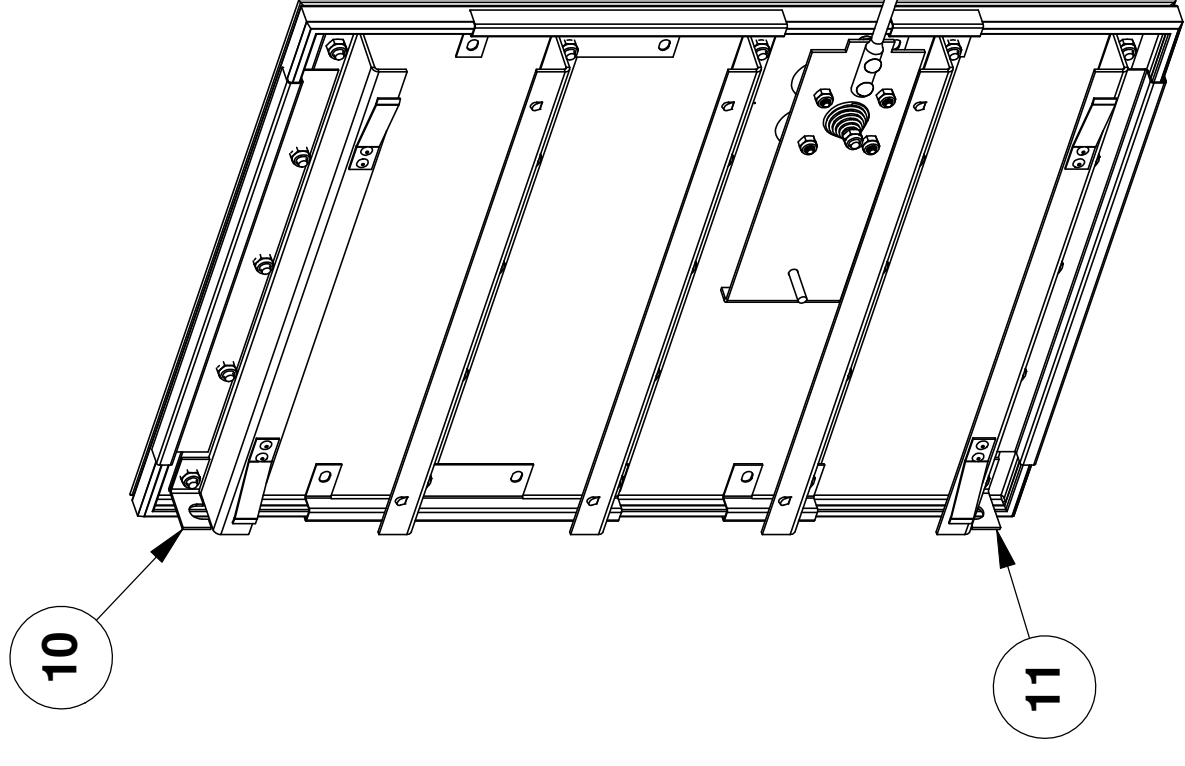
Scale: 1:1 ECN: 030

Sheet 1 of 2

NOTE:
 1. PUSH ITEMS 12, 13 AND 14 UP AGAINST THE DOOR
 GASKET BEFORE TIGHTENING HOLD-DOWN NUTS.



AT1A-2426-5
INNER DOOR ASSEMBLY 6 PAN RIGHT HAND
OTHERWISE SAME AS AT1A-2426-1



AT1A-2426-6
INNER DOOR ASSEMBLY 6 PAN LEFT HAND
OTHERWISE SAME AS AT1A-2426-5

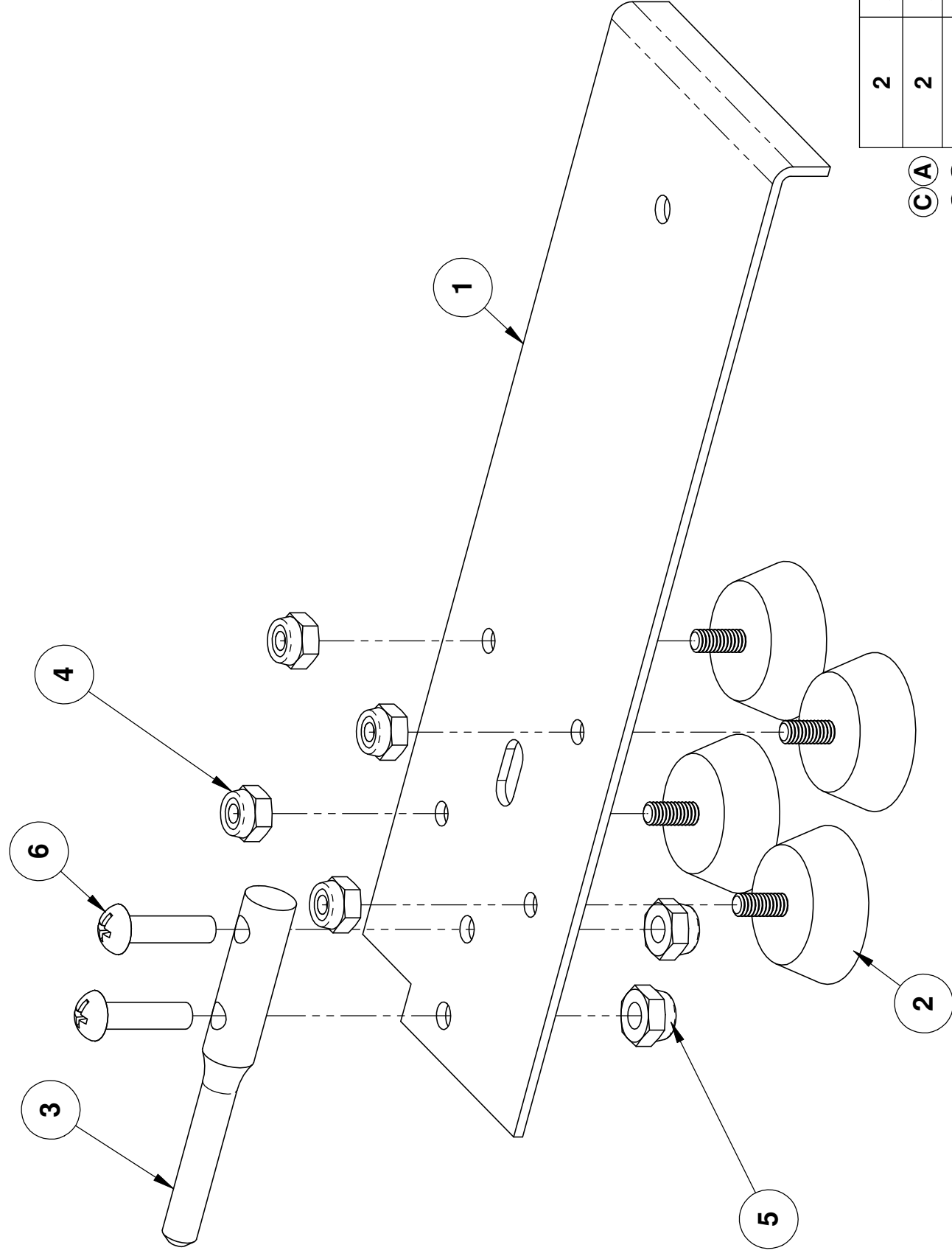
Unless otherwise specified, dimensions in inches		Name	Date
Bends: 90°		ALB	02/29/05
Tolerances:		Checked	RP
Angular: ±1°		Project Eng	02/29/05
2 Place Decimal: ±.02		Material:	
3 Place Decimal: ±.005			
1/16" Per ANS Y14.5M			
GD&T Per ANS Y14.5M		Finish:	
Comments:			
Do Not Scale Drawing			
Title: INNER DOOR ASSEMBLY QUICK RELEASE		Size: D	Rev: E
Drawing No.: AT1A-2426		ECN: 030	Sheet 2 of 2



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NOTE:

- ASSEMBLE ITEM #2 AND ITEM #4 TILL ITEM #4 TOUCHES AND SET FIRMLY WITH ITEM #1. ONCE THIS POSITION IS ACHIEVED, DO NOT OVER TORQUE ITEM #4




AT1A-2427-1

QTY.	PART NO.	ITEM	DESCRIPTION
2	AT0F-2755-41060	6	SCREW, #10-24UNC X 3/4 PHILIPS ROUND HEAD MACHINE
2	AT0F-2691-41011	5	NUT, #10-24 WAXED NYLOC
4	AT0F-2691-31011	4	NUT, #8-32 WAXED NYLOC
1	AT1M-2734-1	3	DOOR PIN, QUICK RELEASE
4	AT1G-1830-1	2	SEAL, QUICK RELEASE DOOR
1	AT1M-2430-1	1	VALVE BRACKET, QUICK REL. DOOR

(C) (A)

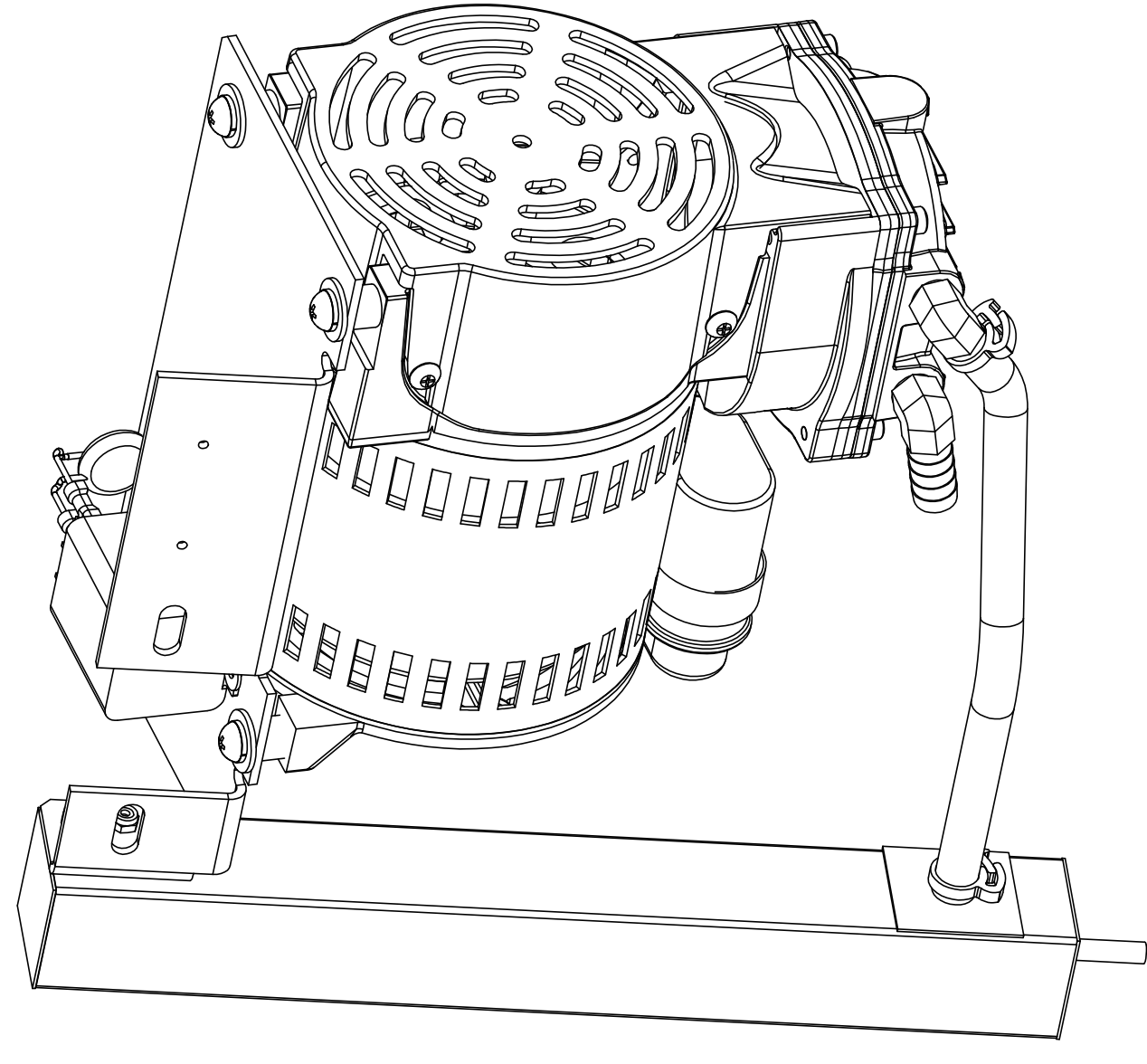
(C) (A)

		AccuTemp Products, Inc. 8415 N. Clinton Park Fort Wayne, IN 46825	
Drawn	JAH	Date	10/09/03
Checked	RP	Date	02/16/04
Proj. Engr.	RP	Date	02/16/04
Material:	N/A		
Finish:	N/A		
Scale:	B	Drawing No.:	AT1A-2427
Rev.:	C		
Sheet	1 of 1		

Unless otherwise specified,
 Dimensions: Inches
 Bends: 90°
 Tolerances:
 Angular ±1°
 2 Place Decimal ±.02
 3 Place Decimal ±.005
 T.I.R ±.005
 √125 Micro Inches
 GD&T Per ANSI Y14.5M
 Comments:
 Do Not Scale Drawing

ECN	REV	DESCRIPTION	DATE	APPR	GLS/ALB
352	C	CHG'D: AT0F-2691-31011 WAS AT0F-2691-31001; AT0F-2691-41011 WAS AT0F-2691-41001	08-07-07		GLS/ALB
213	B	ADDED: NOTE #1	04-02-05		RP / ALB
209	A	CHG'D: ITEM # 4 WAS AT0F-2691-31002, ITEM # 5 WAS AT0F-2691-41002	03/02/05		RP
	-	EDR-030 RELEASED TO PRODUCTION	02-10-05		RP ALB
	REV	DESCRIPTION	DATE	APPR	

REVISIONS



- NOTES:
- 1 STRIP GREEN GROUND WIRE AND ADD SPECIFIED RING TERMINAL.
 - 2 STRIP BLUE & WHITE WIRE LEADS AND ADD SPECIFIED TERMINALS AND MOV ASSY.
 - 3 FOR 6 PAN STEAMER WIRING DETAILS SEE SCHEMATIC AT11-2988. FOR 3 PAN STEAMER WIRING DETAILS SEE SCHEMATIC AT11-2622.
 - 4 ATTACH LABEL SHOWING "CR3" MARKING TO TOP OF RELAY (AT0E-2825).
 - 5 APPLY THREAD SEALANT TO 90° ELBOWS BEFORE MOUNTING TO VACUUM PUMP.

AR	AR	AT0H-3102-1	19	PIPE THREAD SEALANT
4	4	AT0F-2691-21002	18	NUT, #6-32 NYLOC
4	4	AT0F-1922-50002	17	WASHER, 1/4" HELICAL SPRING LOCK
4	4	AT0F-1052-51002	16	WASHER 1/4 TYPE B PLAIN
2	2	AT0F-1052-21002	15	WASHER #6 TYPE B PLAIN
4	4	AT0F-2755-51082	14	SCREW, 1/4-20UNC X 1 PHILIPS ROUND HEAD MACHINE
2	2	AT0F-2755-21042	13	SCREW, #6-32UNC X 1/2 PHILIPS ROUND HEAD MACHINE
2	2	AT0P-2714-1	12	1/4" HOSE CLAMP
1	1	AT0E-2680-11	11	18-22 AWG INSULATED RING TERMINAL 1/4 STUD
2	2	AT0E-2699-4	10	QD TERMINAL FEMALE INSULATED 14-16 AWG .187 x .020 TAB
1	1	AT0P-2867-2	9	90° ELBOW 1/4 NPT X 1/2 BARB
1	1	AT0P-2867-1	8	90° ELBOW 1/4 NPT X 1/4 BARB
1	1	AT0E-2825-3	7	GENERAL PURPOSE RELAY 208/240V
-	-	AT0E-2825-2	7	GENERAL PURPOSE RELAY 240VAC
4	4	AT1M-2664-1	6	SPACER, HEATER
1	1	AT1E-2991-1	5	VACUUM PUMP, GAST
1	1	AT0A-2736-1	4	MOV- TERMINALS ASSEMBLY
1	1	AT1P-2558-15	3	HOSE, Ø 1/4 SILICONE
1	1	AT1A-2984-1	2	SQUARE TUBE MUFLER ASSEMBLY
1	1	AT1M-2993-1	1	VACUUM PUMP BRKT, GAST
QTY	AT1A-3099-1	PART NUMBER	ITEM	DESCRIPTION

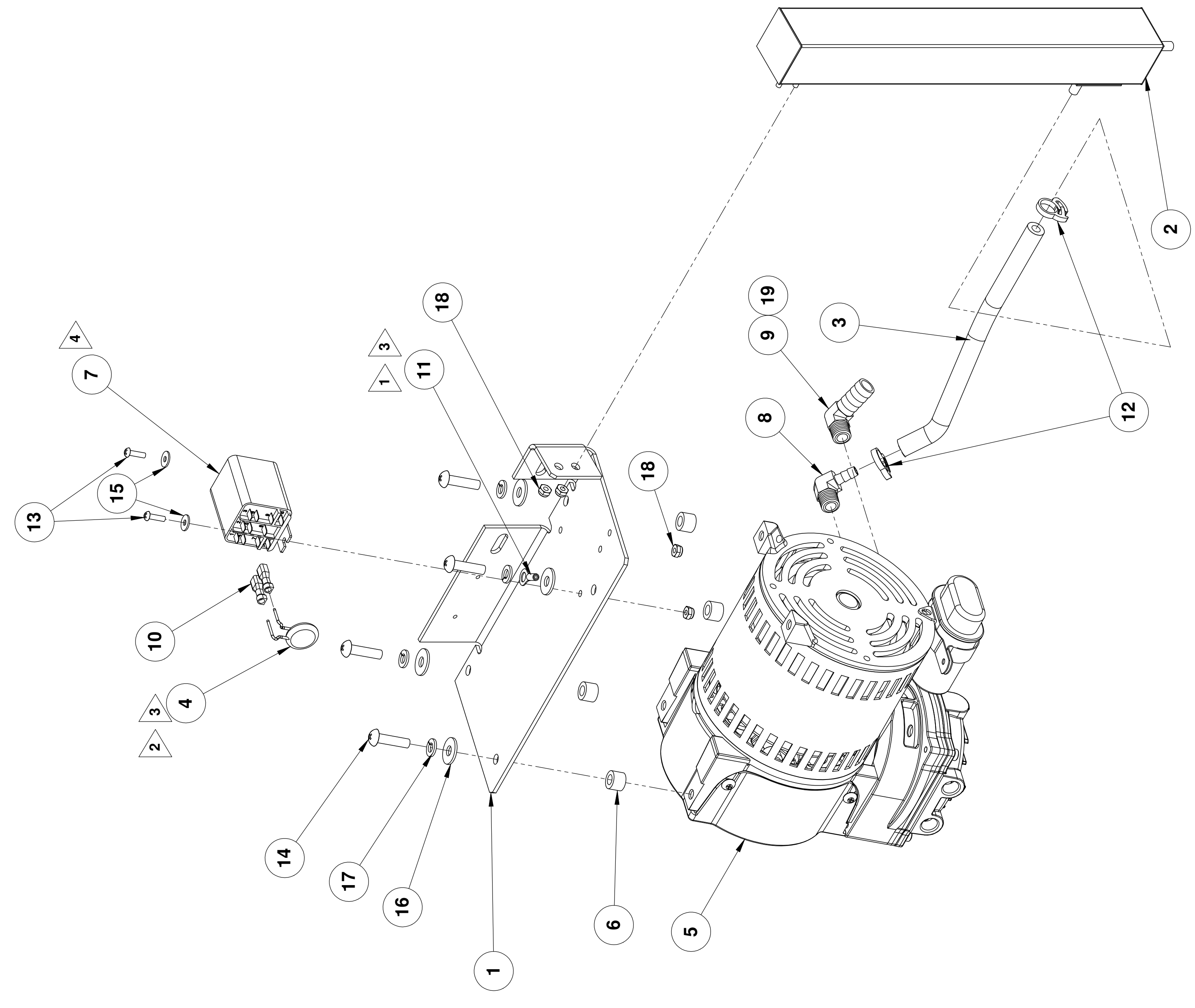
Ass/Terna Products, Inc.
 8415 N. Chippewa Rd.
 Fort Wayne, IN 46825

Acculamp

Assy, GAST VACUUM PUMP MUFLER

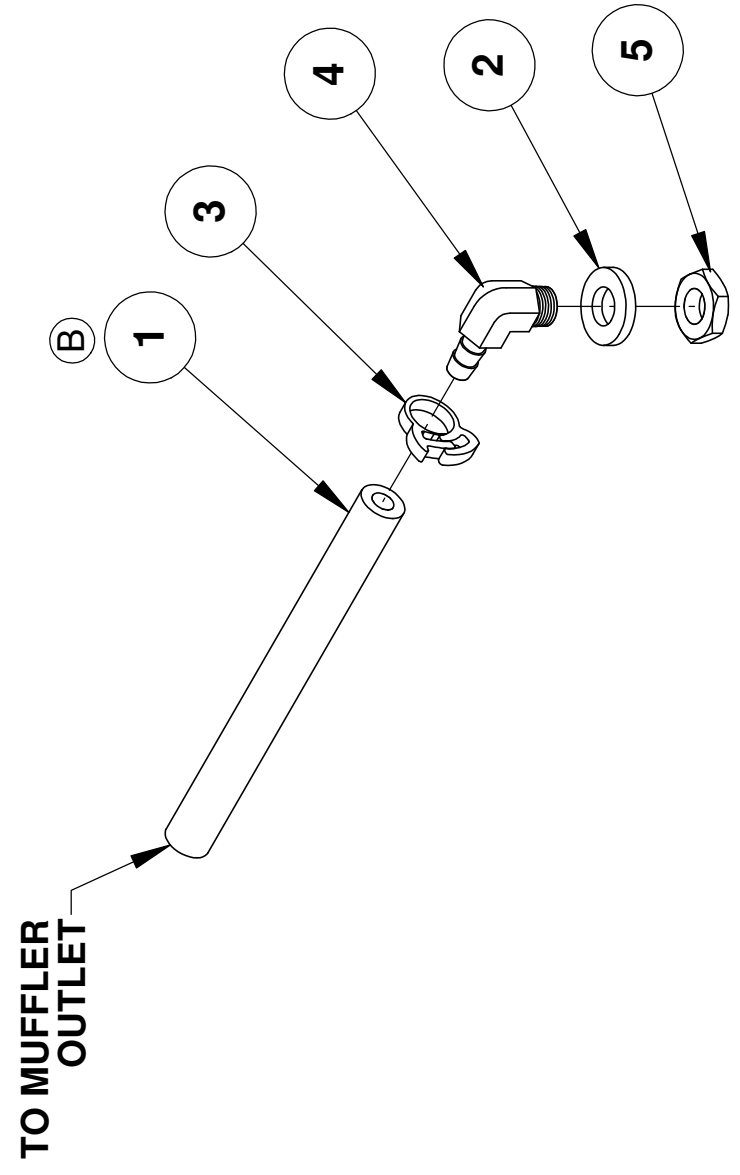
AT1A-3099

Scale: 1:2 EDR: 124 Sheet 1 of 1



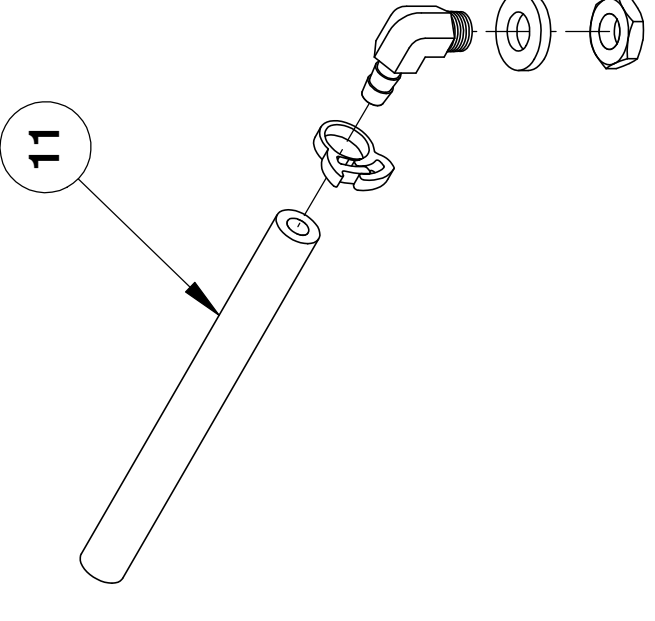
AT1A-3099-1 & AT1A-3099-2

ECN	REV	DESCRIPTION	DATE	APPR
382	C	CHG'D: (BOM ITEM 7) AT0E-2825 WAS-11 AT1A-3099-1	08-07-07	GLS/ALB
249	B	RMVD: SHT 2, AT1A-3099-3, AT1A-3099-4, NOTE 6, NOTE 7, ITEM 20, AT1E-2700-1, ITEM 21 PAN STEAMER WIRING DETAILS SEE SCHEMATIC AT11-2988	10/25/06	LRW/ATP
286	A	ADDED: SHT 2, AT1A-3099-3, AT1A-3099-4, AT1E-2700-1, AT0E-2731-1, (SHT 1) NOTE 6 & 7	7-3-06	LRW/ATP
REVISIONS				
ECN	REV	DESCRIPTION <td>DATE</td> <td>APPR</td>	DATE	APPR

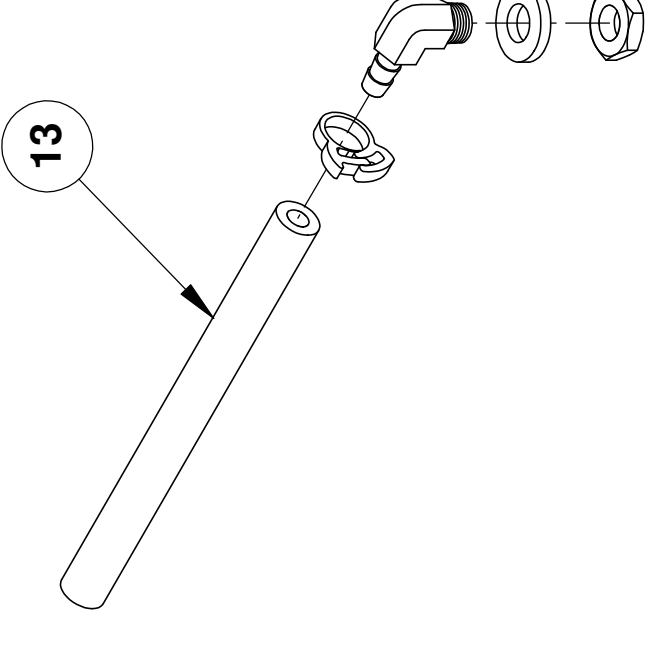


AT1A-3066-1

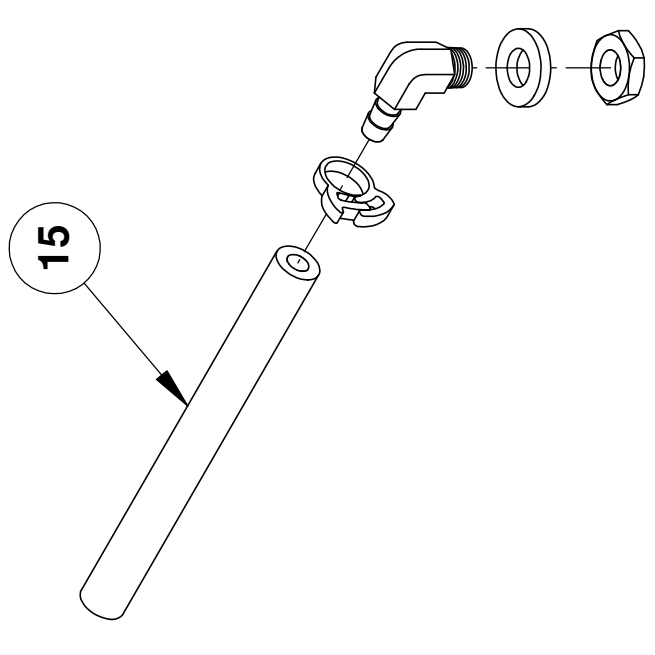
AT1A-3066-5
OTHERWISE SAME AS AT1A-3066-1



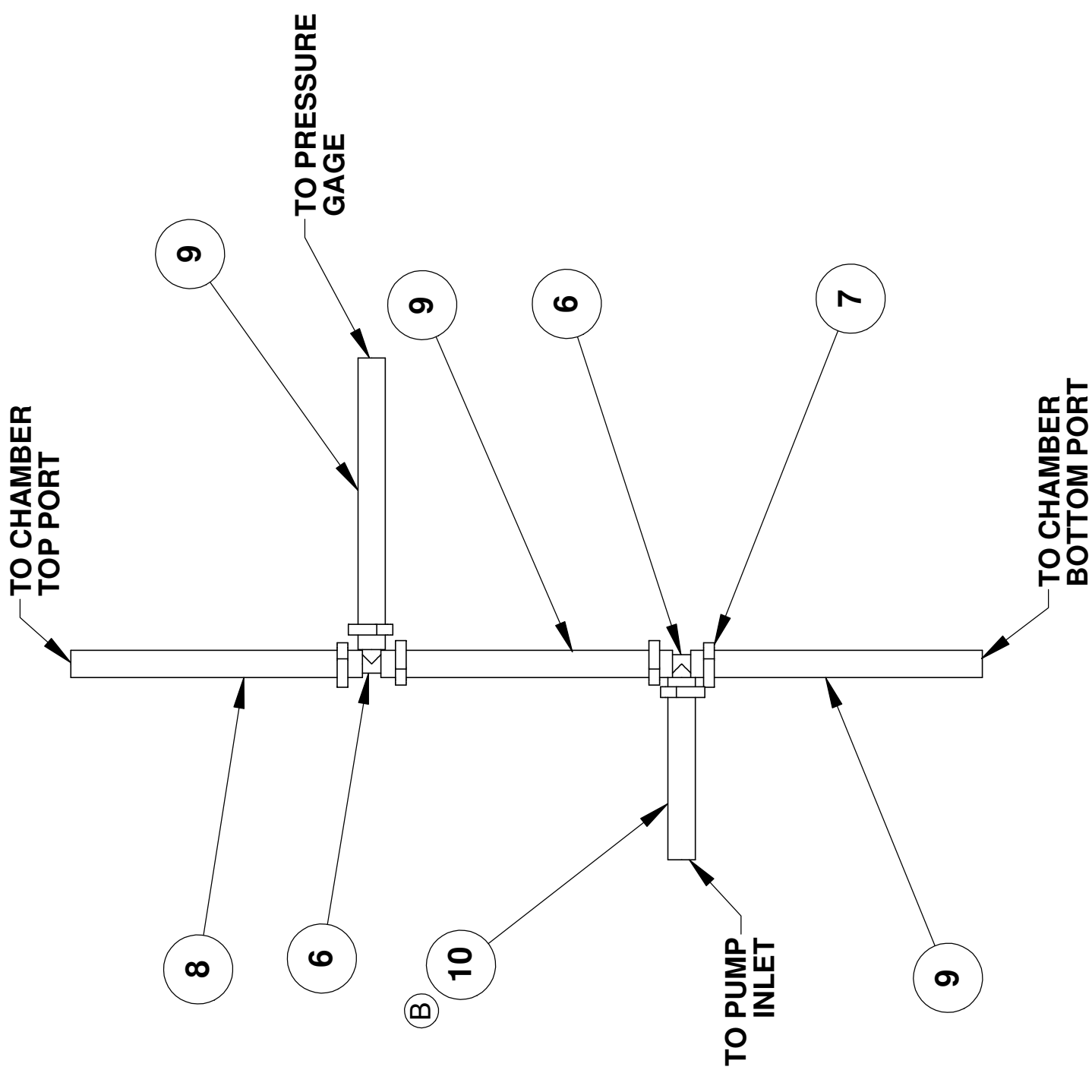
AT1A-3066-3
OTHERWISE SAME AS AT1A-3066-1



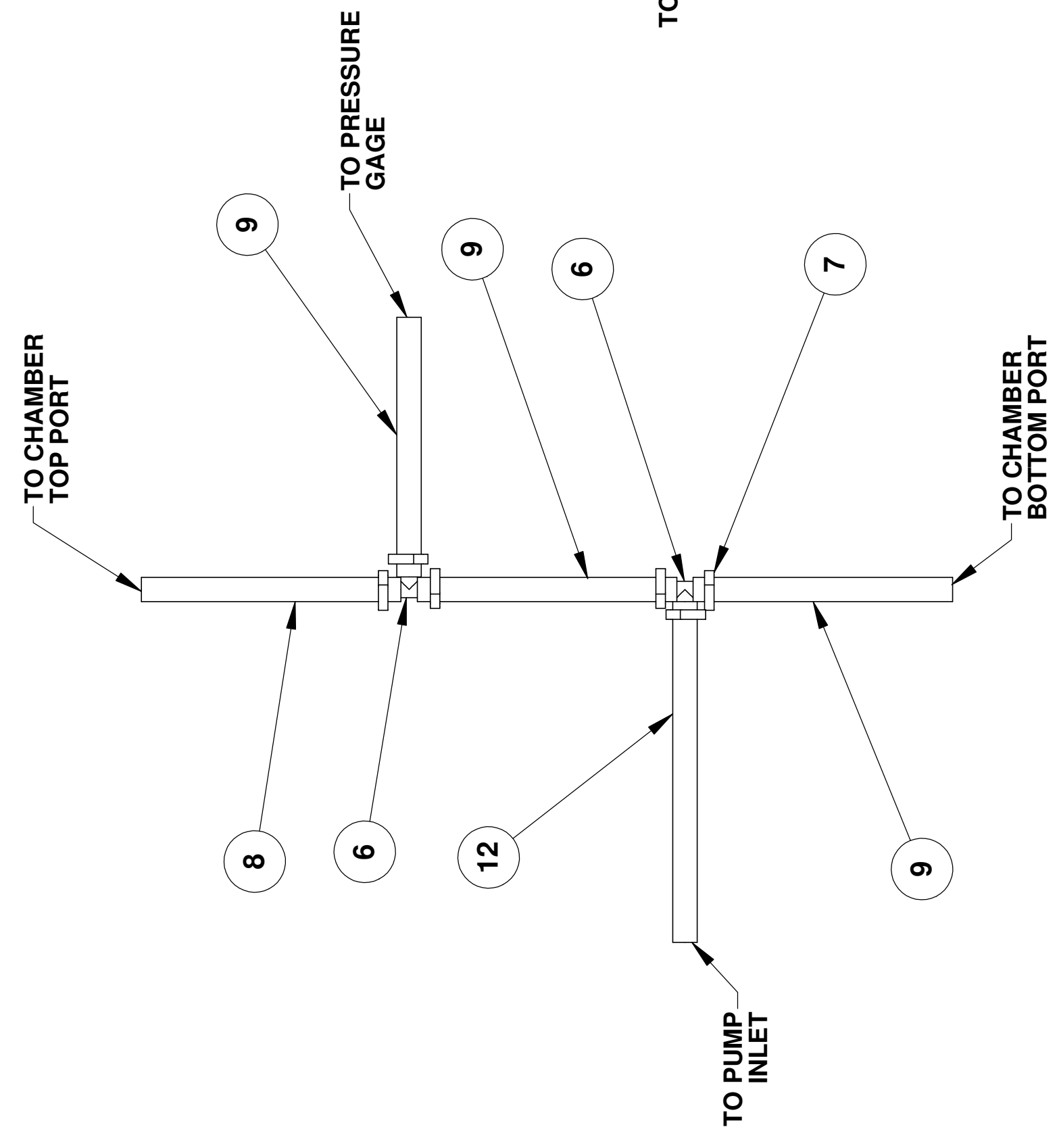
AT1A-3066-4
OTHERWISE SAME AS AT1A-3066-1



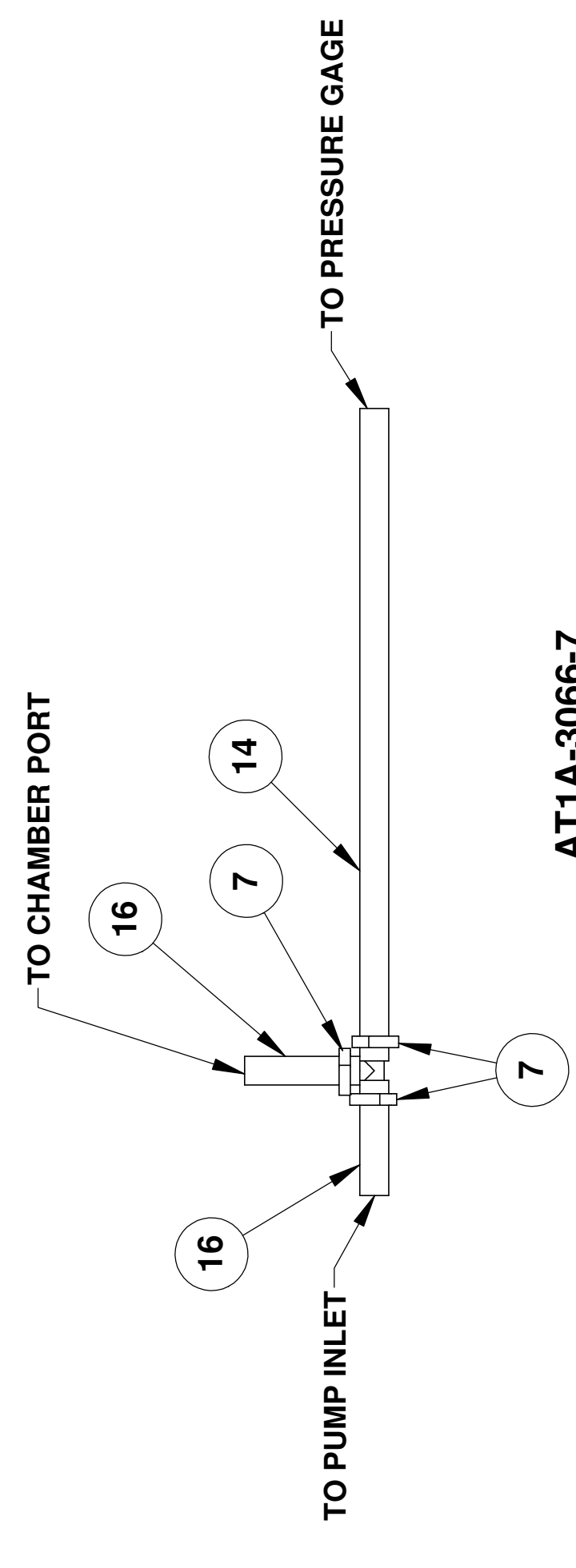
AT1A-3066-5
OTHERWISE SAME AS AT1A-3066-1



AT1A-3066-2



AT1A-3066-6



AT1A-3066-7

ITEM	PART NUMBER	DESCRIPTION
16	AT1P-2558-18	HOSE, Ø½ SILICONE
15	AT1P-2558-16	HOSE, Ø¼ SILICONE
14	AT1P-2558-7	HOSE, Ø½ SILICONE
13	AT1P-2558-21	HOSE, Ø¼ SILICONE
12	AT1P-2558-17	HOSE, Ø½ SILICONE
11	AT1P-2558-14	HOSE, Ø¼ SILICONE
10	AT1P-2558-11	HOSE, Ø½ SILICONE
9	AT1P-2558-10	HOSE, Ø½ SILICONE
8	AT1P-2558-9	HOSE, Ø½ SILICONE
7	ATOP-2714-2	1/2" HOSE CLAMP
6	ATOP-2987-2	BARBED TEE FITTING, 1/2 X 1/2 X 1/2
5	ATOP-2868-1	PIPE NUT, NPSL
4	ATOP-2867-3	90° ELBOW 1/8 NPT X 1/4 BARB
3	ATOP-2714-1	1/4" HOSE CLAMP
2	ATOF-2869-1	FLAT WASHER
1	AT1P-2558-13	HOSE, Ø¼ SILICONE

ECN	REV	DESCRIPTION	DATE	APPR
249	E	CHG'D: (FROM ITEMS 1, 8 - 16) CHANGED PART DESCRIPTIONS REMOVING CUT LENGTHS	12-22-06	LW/ATP
286	D	ADDED: AT1A-3066-5, AT1A-3066-7, ITEM 14 AT1P-2558-7, ITEM 15 AT1P-2558-16, ITEM 16 AT1P-2558-18	7-3-06	LW/ATP
287	C	VIEW (NEW) AT1A-3066-2 TOP VIEW (NEW) BALLOONS 3, 4, 2, 6 CHG'D: 3066-4, AT1P-2558-17, AT1P-2558-21	3-29-06	LW/ATP
230	B	CHG'D: ITEM #1 AT1P-2558-13 WAS AT1P-2558-12 ITEM #10 AT1P-2558-11 WAS AT1P-2558-13; ADDED: AT0A-3066-3	06-17-05	RP / ALB
220	A	CHG'D: AT1P-2558-12 WAS AT1P-2555-1, ADDED AT1P-3066-2	05-25-05	RP / ALB
	-	EDR-021 RELEASED TO PRODUCTION	04-05-05	RP / ALB
		REVISIONS		

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Fort Wayne, IN 46825

AccuTemp

HOSE ASSEMBLY

Drawing No.: **AT1A-3066**

Rev: **E**

Size: **D**

Scale: 1:4 EDR: 021

Sheet 1 of 1

Name	Date
Drawn ALB	4/4/2005
Checked RP	4/4/2005
Project Eng RP	4/4/2005
Material:	N/A
Finish:	N/A

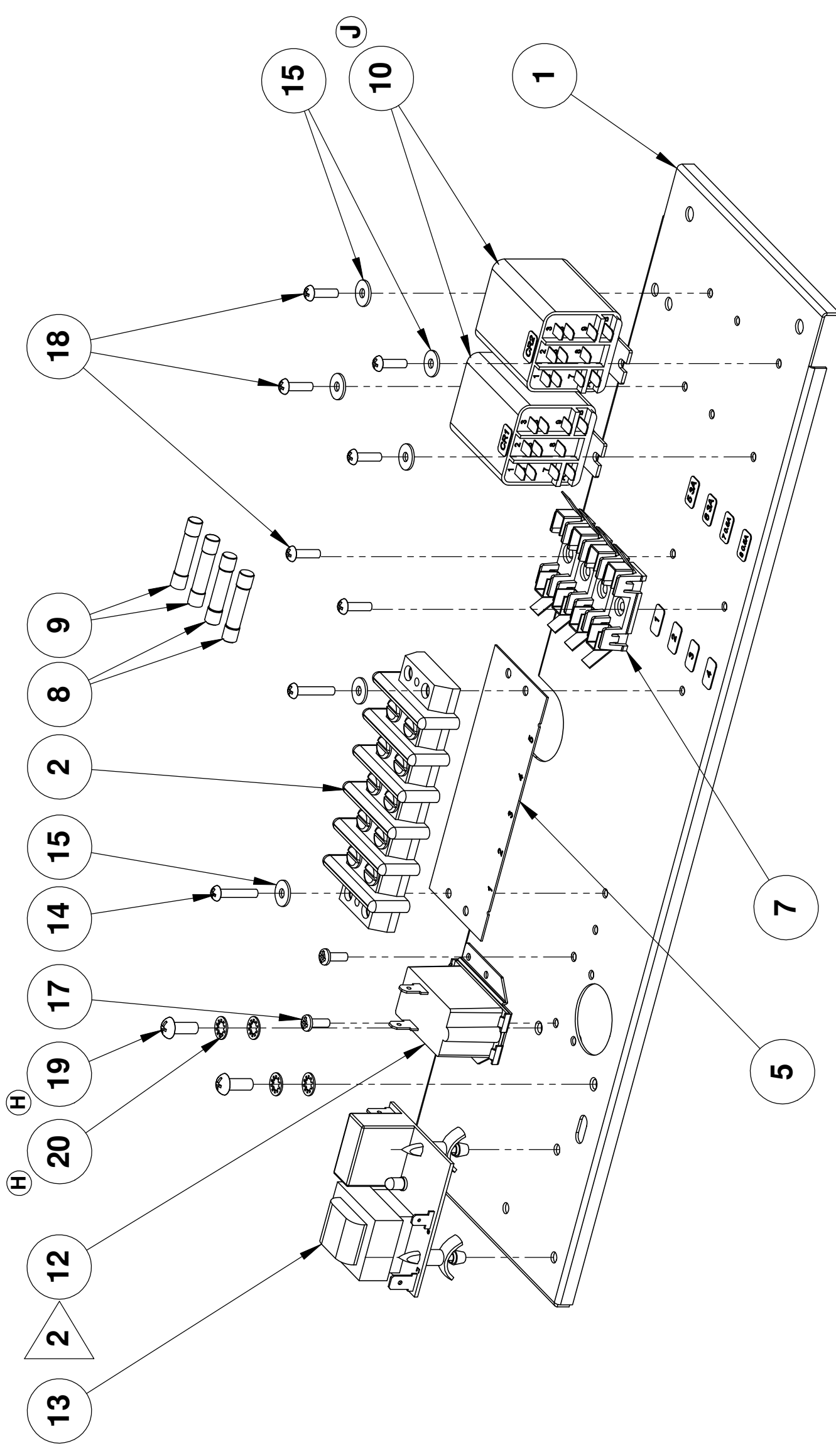
Unless otherwise specified,
Dimensions are in inches
Bends 90°
Tolerances:
Angular: ±1°
2 Place Decimal: ±.02
3 Place Decimal: ±.005
T.L.R.: ±.005
Material: 1/125 Micro Inches
GD&T Per ANSI Y14.5M
Comments:
Do Not Scale Drawing

QTY	AT1A-3066-7	AT1A-3066-6	AT1A-3066-5	AT1A-3066-4	AT1A-3066-3	AT1A-3066-2	AT1A-3066-1
2	-	-	-	-	-	-	-
(E)(D)							
1	-	1	1	1	1	1	1
(E)(D)							
1	-	-	-	-	-	-	-
(E)(D)							
1	-	-	-	1	-	-	-
(E)(C)							
1	-	-	-	-	-	-	-
(E)(C)							
1	-	-	-	-	-	-	-
(E)(B)							
1	-	-	-	-	-	-	-
(E)(B)							
3	-	3	-	-	-	-	-
(E)							
1	-	-	-	-	-	-	-
(E)							
6	-	-	-	-	-	-	-
(E)							
2	-	-	-	-	-	-	-
(E)(B)(A)							
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(E)(B)(A)							
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(E)(B)(A)							

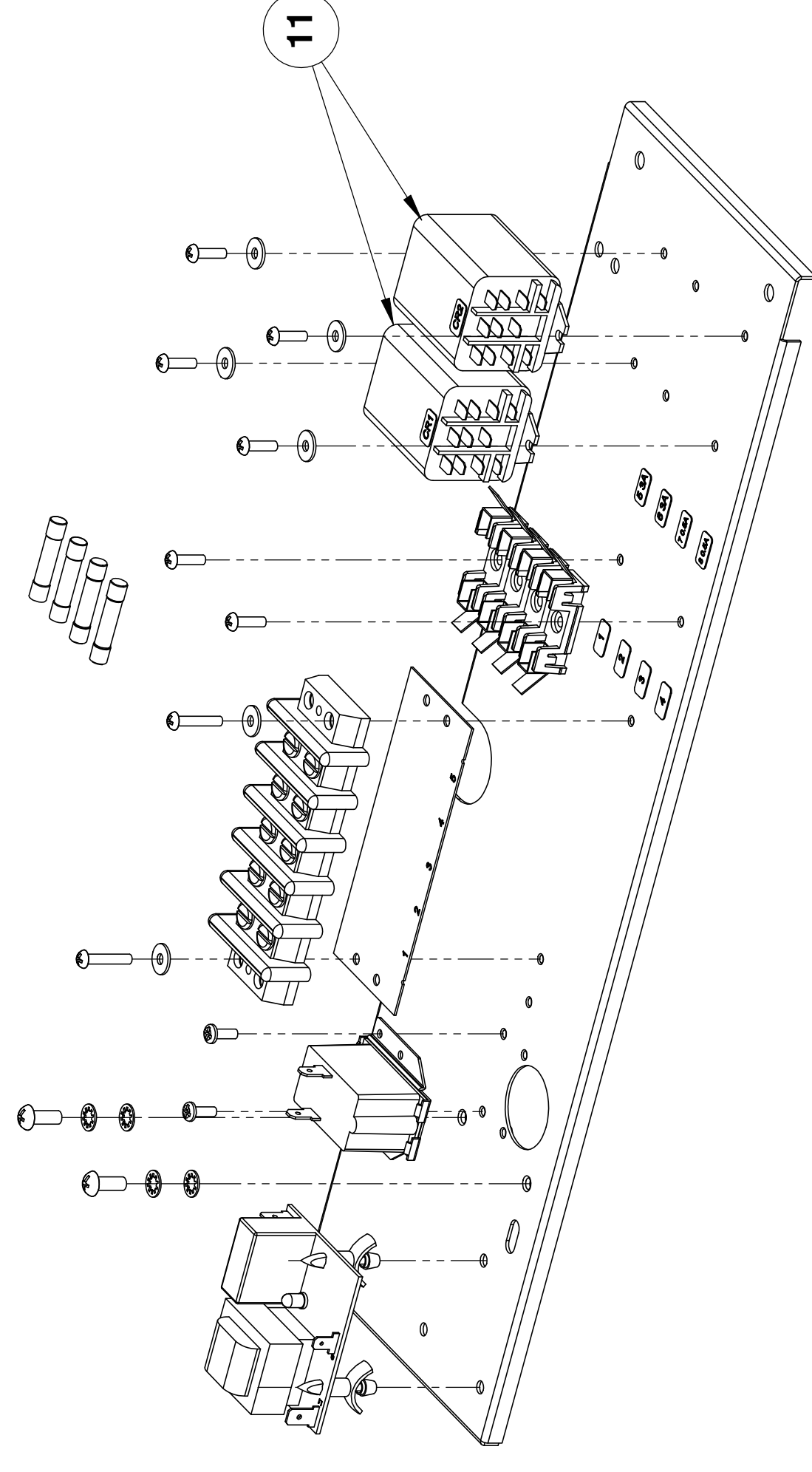
(A) NOTE:

1 ATTACH, APPROXIMATELY AS SHOWN, LABELS SHOWING "5.3A", "6.3A", "7.0.5A", "8.0.5A", "1", "2", "3", "4", "CR1" & "CR2" MARKINGS.

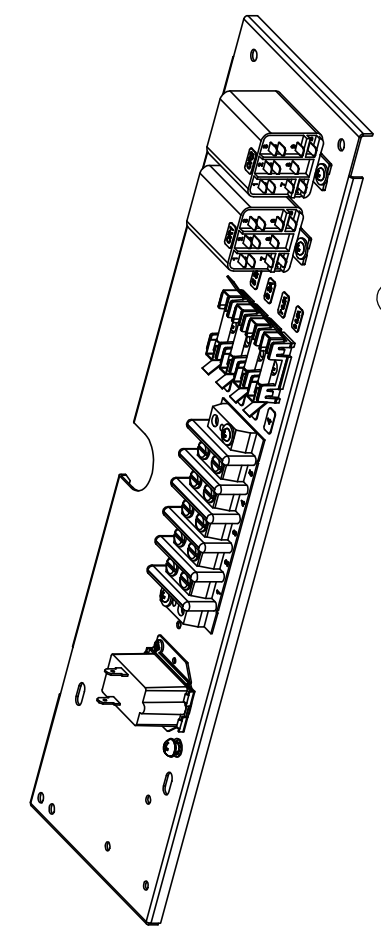
2 USE 2 OF THE 4 AVAILABLE MOUNTING HOLES, ONE ON EITHER SIDE OF THE BUZZER.



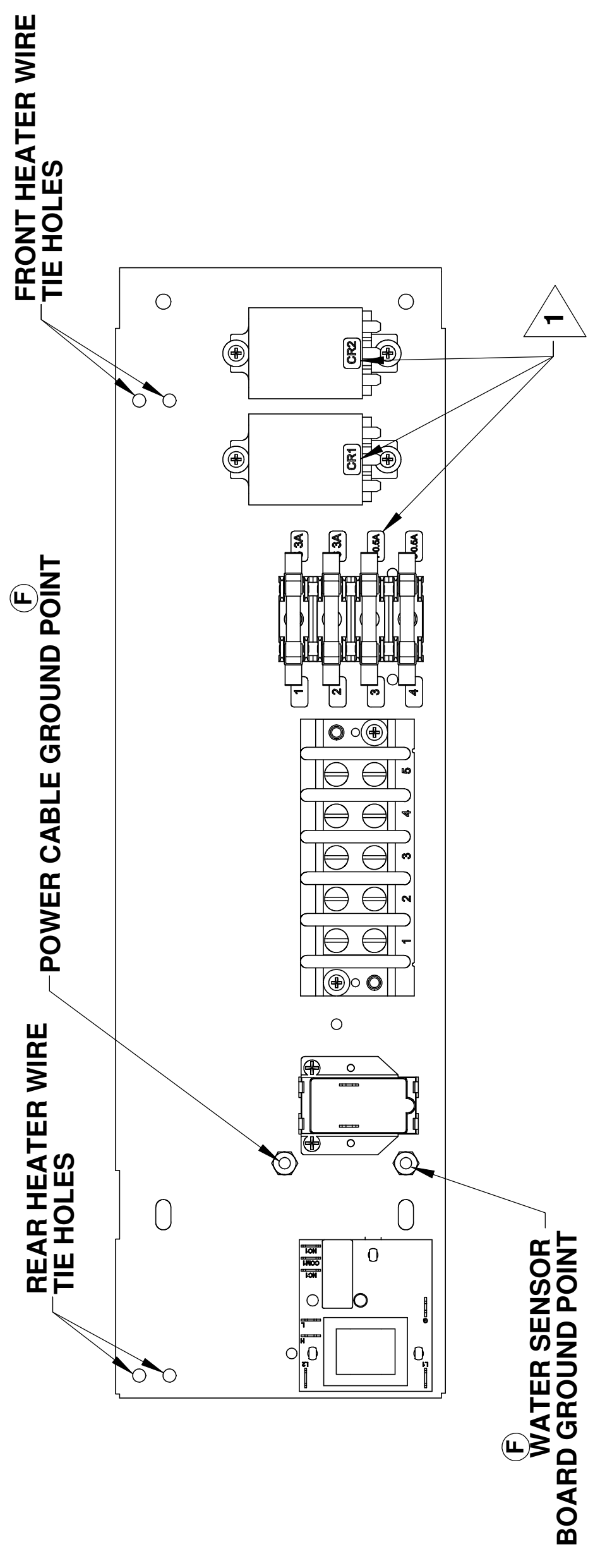
AT1A-2992-6



**AT1A-2992-7
OTHERWISE SAME AS AT1A-2992-6**



**AT1A-2992-8
OTHERWISE SAME AS AT1A-2992-6**



21					WASHER, #10 INTERNAL TOOTH LOCK
20	4	AT0F-2666-40000			
19	2	AT0F-2755-41042			SCREW, #10-24UNC X 1/2 PHILIPS ROUND HEAD MACHINE
18	6	AT0F-2755-21042			SCREW, #6-32UNC x 1/2 PHILIPS ROUND HEAD MACHINE
17	2	AT0F-3222-21035			SCREW, #6-32UNC x 3/8 PHILLIPS PAN HEAD TYPE F
16	-				
15	6	AT0F-1052-21002			WASHER #6 TYPE B PLAIN
14	2	AT0F-2755-21062			SCREW, #6-32UNC x 3/4 PHILIPS ROUND HEAD MACHINE
13	1	AT1E-2654-1			PCB, 208/240VAC WATER SENSOR
12	1	AT0E-2807-1			BUZZER
11	-	AT0E-2825-2			GENERAL PURPOSE RELAY 240VAC
10	2	AT0E-2825-3			GENERAL PURPOSE RELAY 208/240V
9	2	AT0E-2731-1			FUSE 3 AMP 250V
8	2	AT0E-3162-1			FUSE 1/2 AMP 250V FAST ACTING
7	1	AT0E-2708-2			3AG OMNI-BLOK FUSE BLOCK 4 POS
6	-				
5	1	AT0E-3062-2			MARKER STRIP BARRIER BLOCK 5 POS
4	-				
3	-				
2	1	AT0E-1134-5			5 POSITION TERMINAL BLOCK
1	1	AT1M-2990-2			COMPONENT PLATE

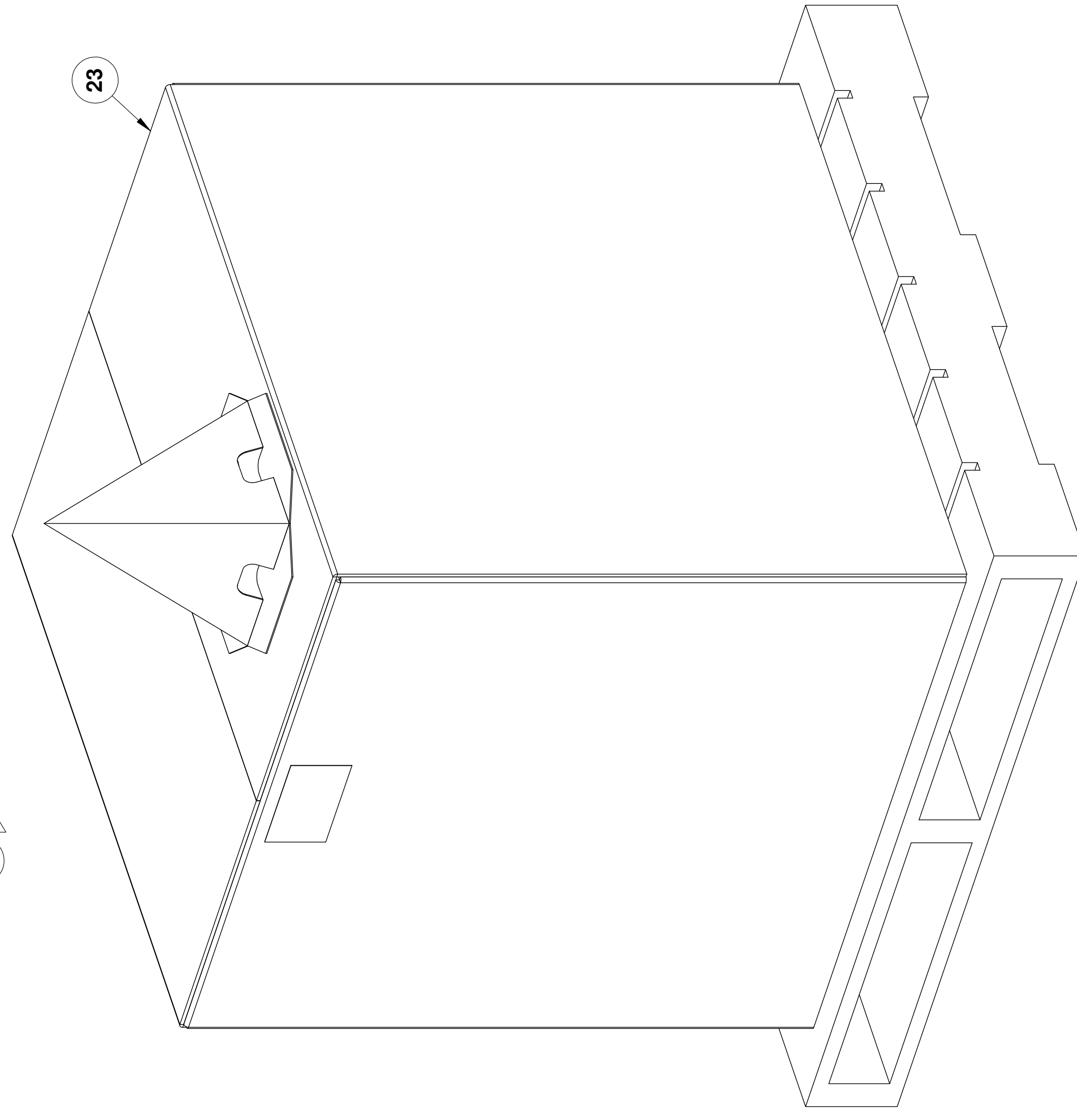
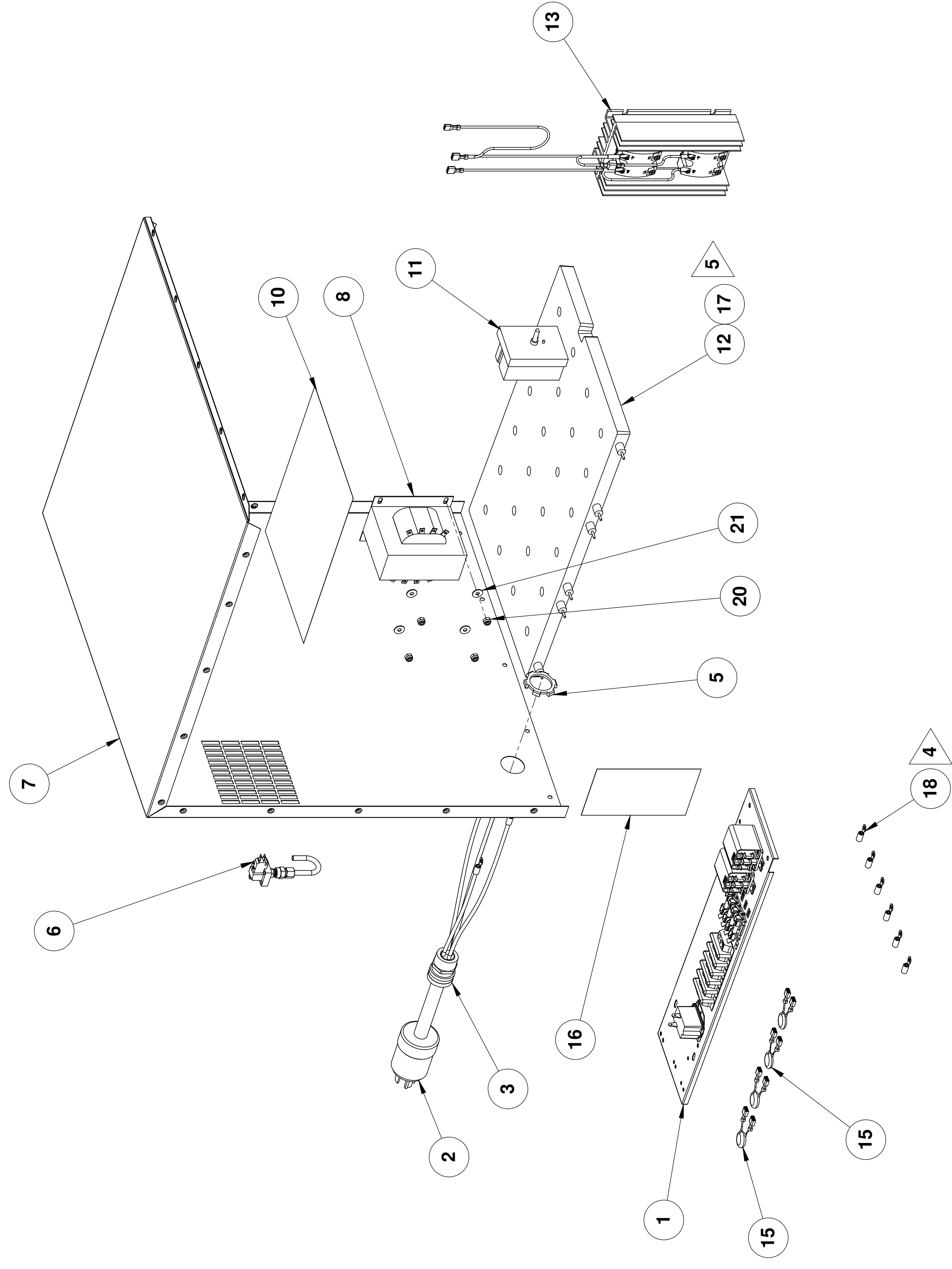
QTY	AT1A-2992-8	QTY	AT1A-2992-7	QTY	AT1A-2992-6	PART NUMBER	ITEM	DESCRIPTION
1		1		1				

Unless otherwise specified, Dimensions: Inches
 Bore: .005
 Tolerances:
 Angular: ±.1°
 2 Place Decimal: ±.02
 3 Place Decimal: ±.005
 TLR: ±.005
 Material:
 GD&T Per ANSI Y14.5M
 Comments:
 Do Not Scale Drawing

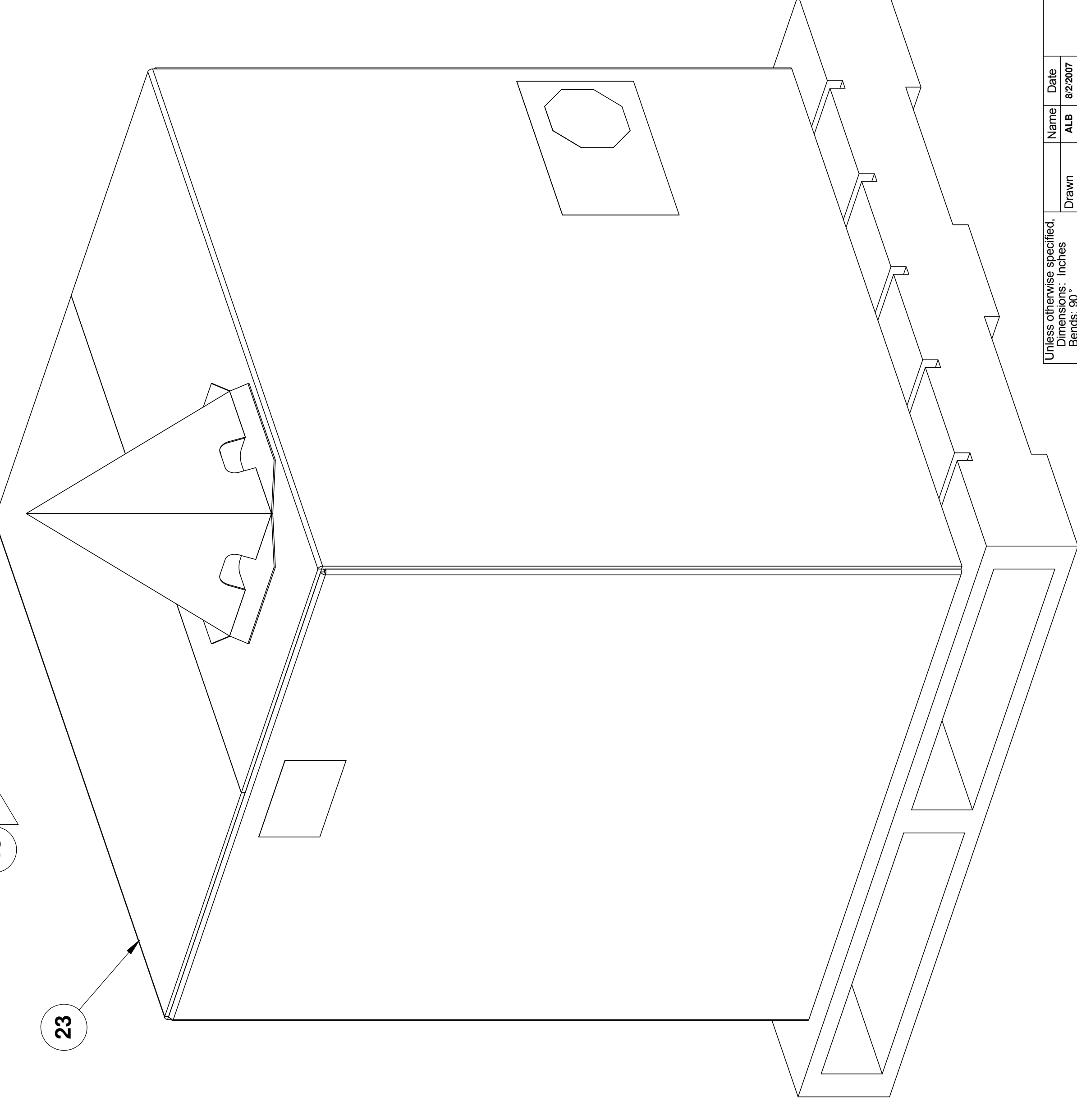
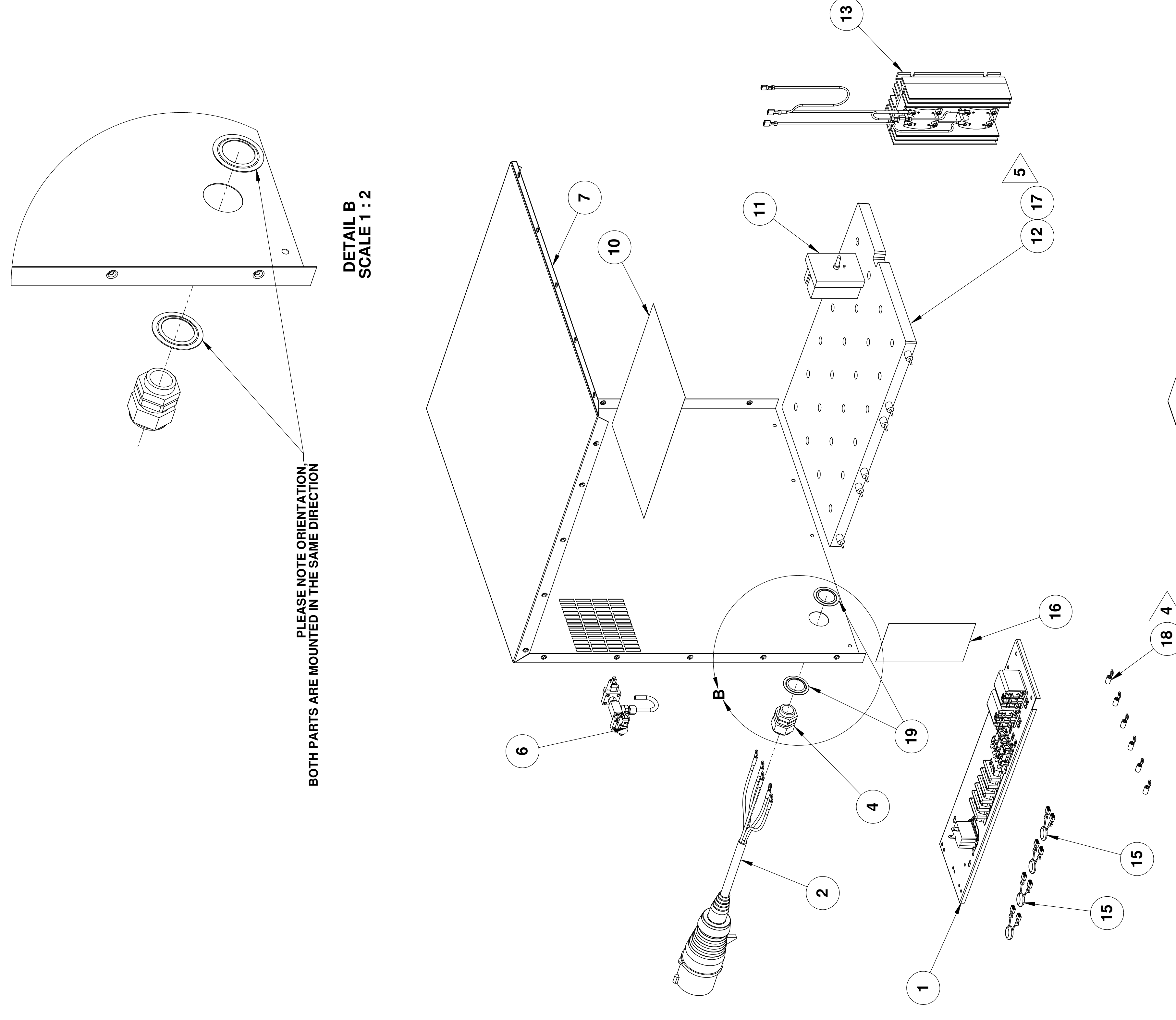
AccuTemp Products, Inc
 8415 N. Clinton Park
 Fort Wayne, IN 46825

COMPONENT BRACKET ASSEMBLY STEAMER

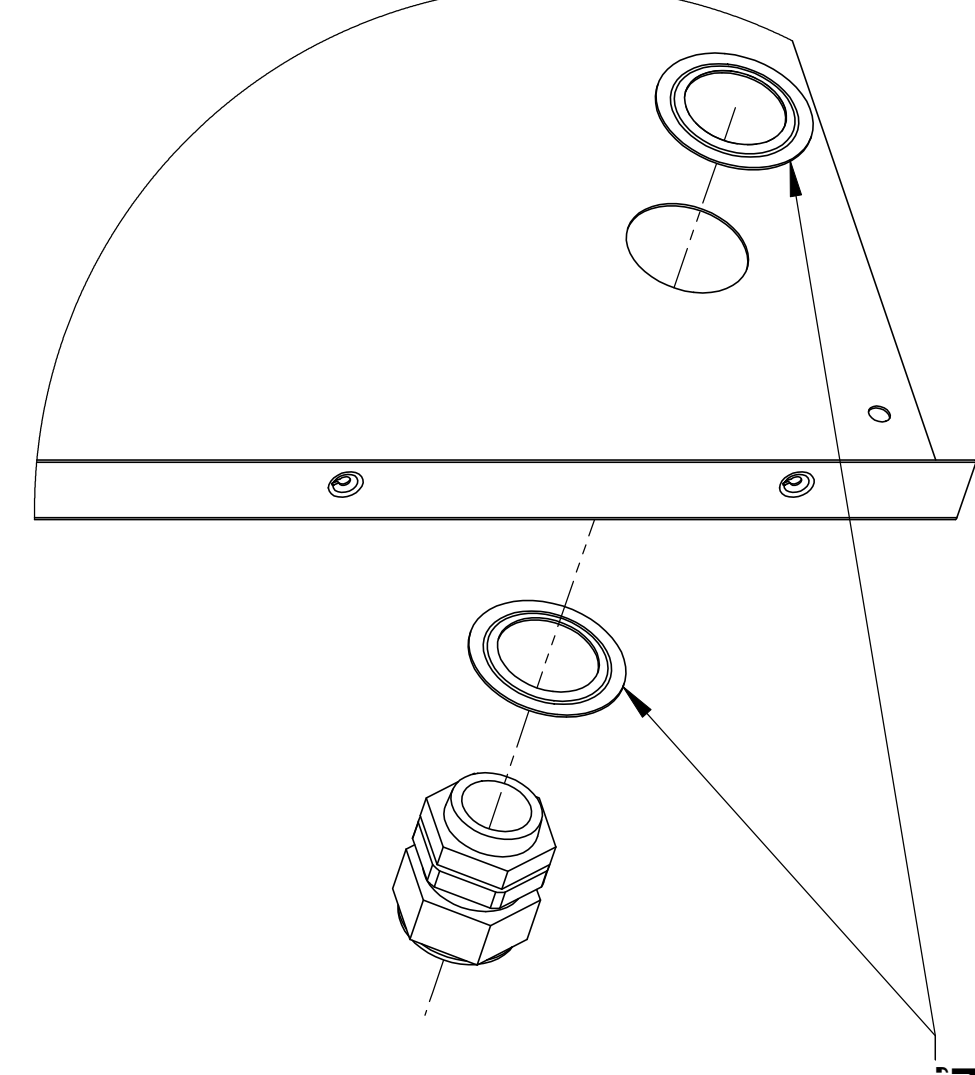
Rev: **J**
 Drawing No.: **AT1A-2992**
 Scale: 1:2 ECN: Sheet 2 of 2



6 PAN STEAMER CONFIGURATION
GROUPS 25, 38-31, 33, 36, 38, 39, 47, 51, 52



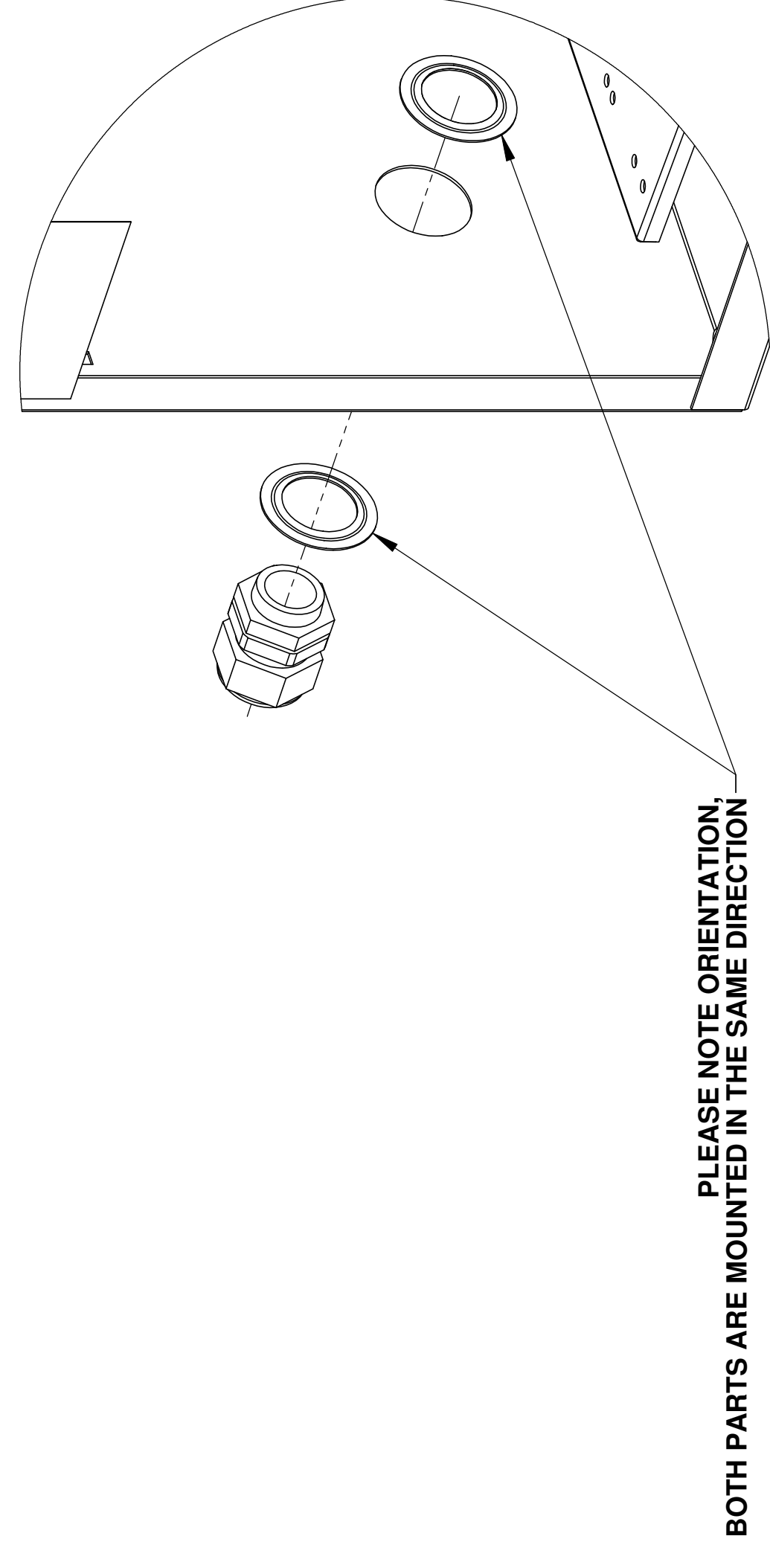
6 PAN STEAMER CONFIGURATION
GROUPS 32, 40, 41, 43



DETAIL B
SCALE 1:2

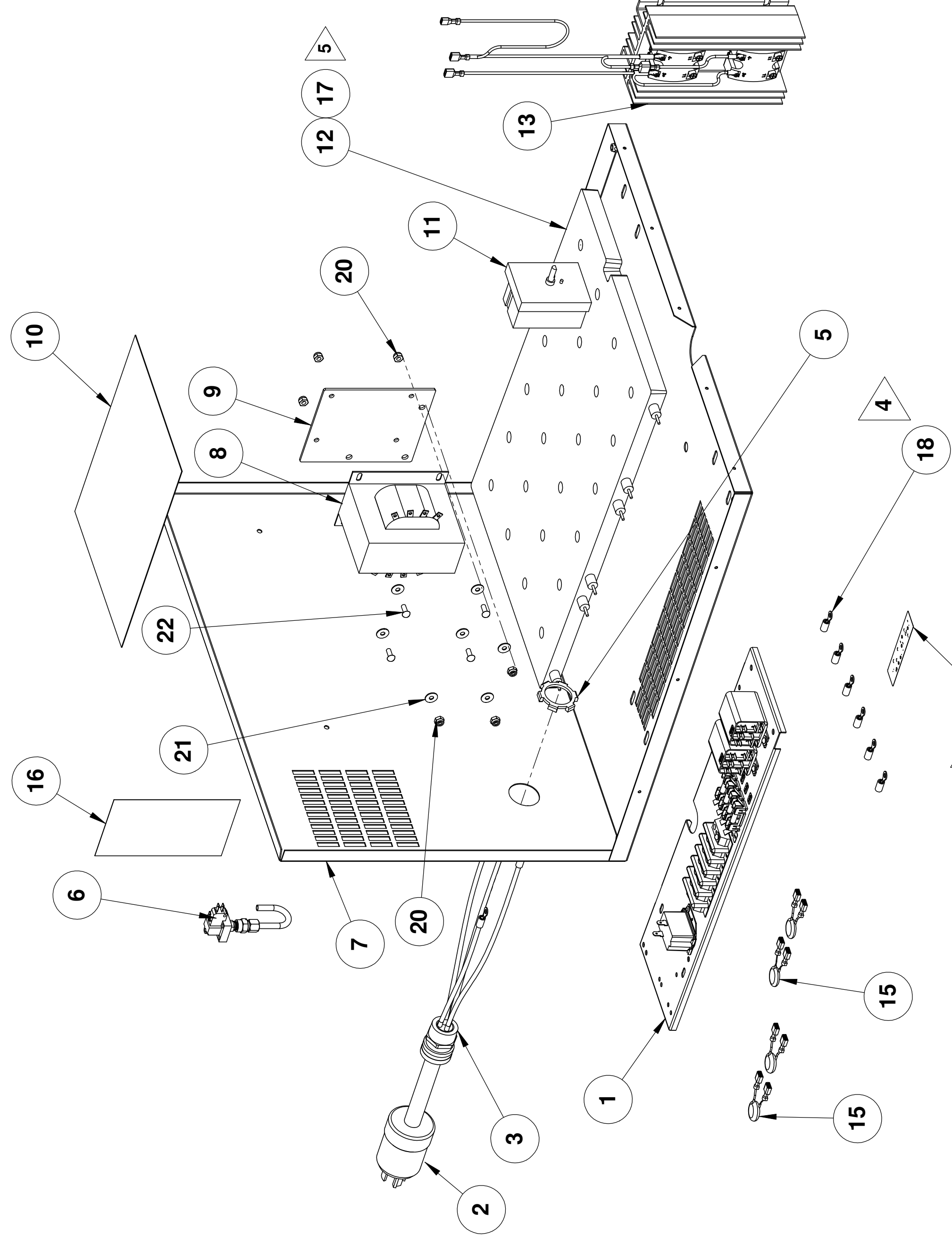
PLEASE NOTE ORIENTATION.
BOTH PARTS ARE MOUNTED IN THE SAME DIRECTION

Official: Revision: 00000000	Name: [Redacted]	Date: 02/20/2007	Title: MODULE, VOLTAGE WATTAGE PHASE
Dimension: inches	Drawn: [Redacted]	Checked: [Redacted]	Drawn: [Redacted]
Projection: First Angle	Project Eng: [Redacted]	Project Mgr: [Redacted]	Project Title: [Redacted]
Author: [Redacted]	Material: [Redacted]	Quantity: [Redacted]	Quantity: [Redacted]
3 Piece Diagram: 1:005 Material: [Redacted]	Material: [Redacted]	Material: [Redacted]	Material: [Redacted]
Qty: 1/25 Micro Inches: [Redacted]	Material: [Redacted]	Material: [Redacted]	Material: [Redacted]
Comments: [Redacted]	Material: [Redacted]	Material: [Redacted]	Material: [Redacted]
Do Not Scale Drawing	Material: [Redacted]	Material: [Redacted]	Material: [Redacted]

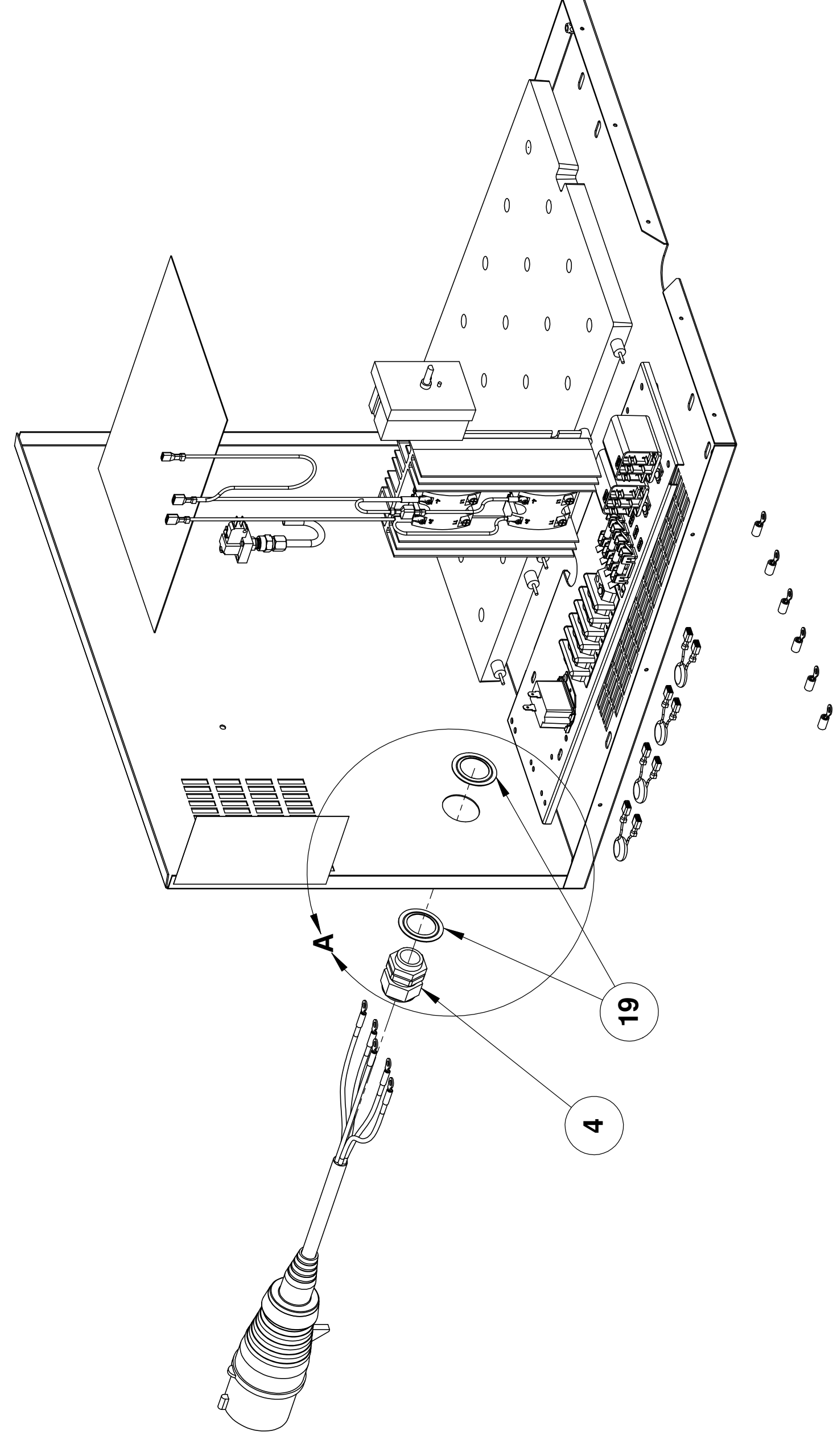


BOTH PARTS ARE MOUNTED IN THE SAME DIRECTION

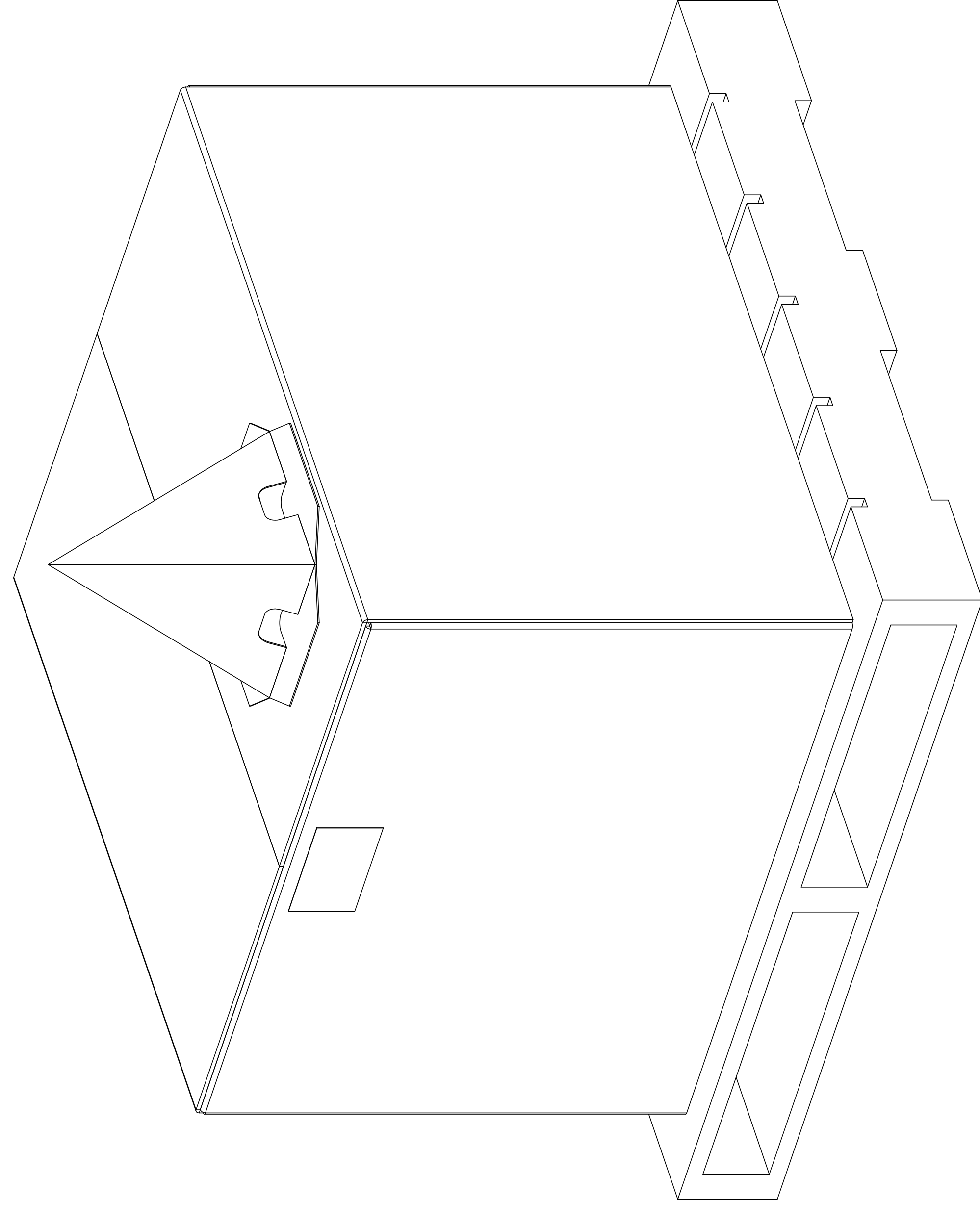
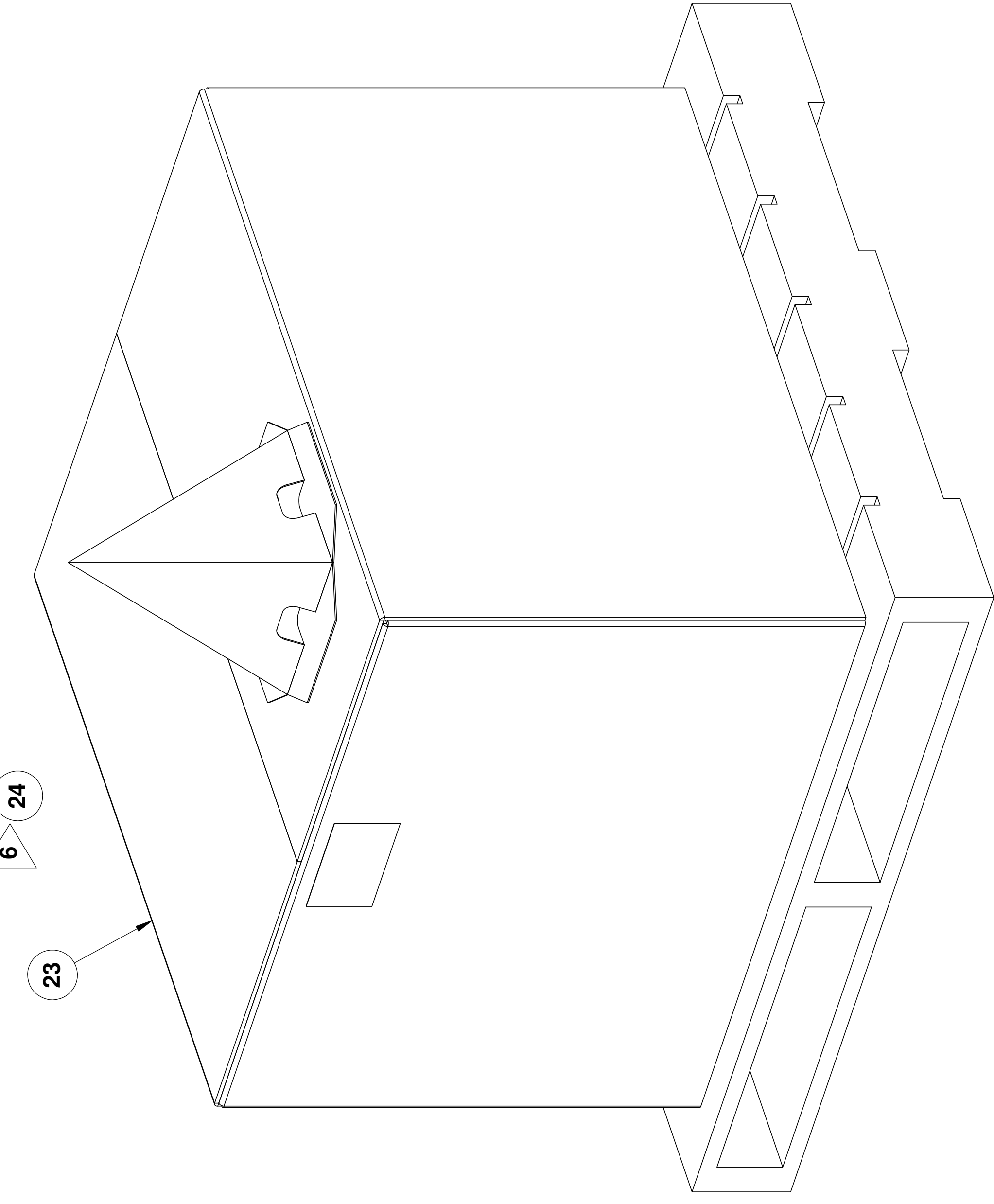
DETAIL A
SCALE 1 : 2



3 PAN STEAMER CONFIGURATION
GROUPS 1, 4-6, 8, 11, 13, 22

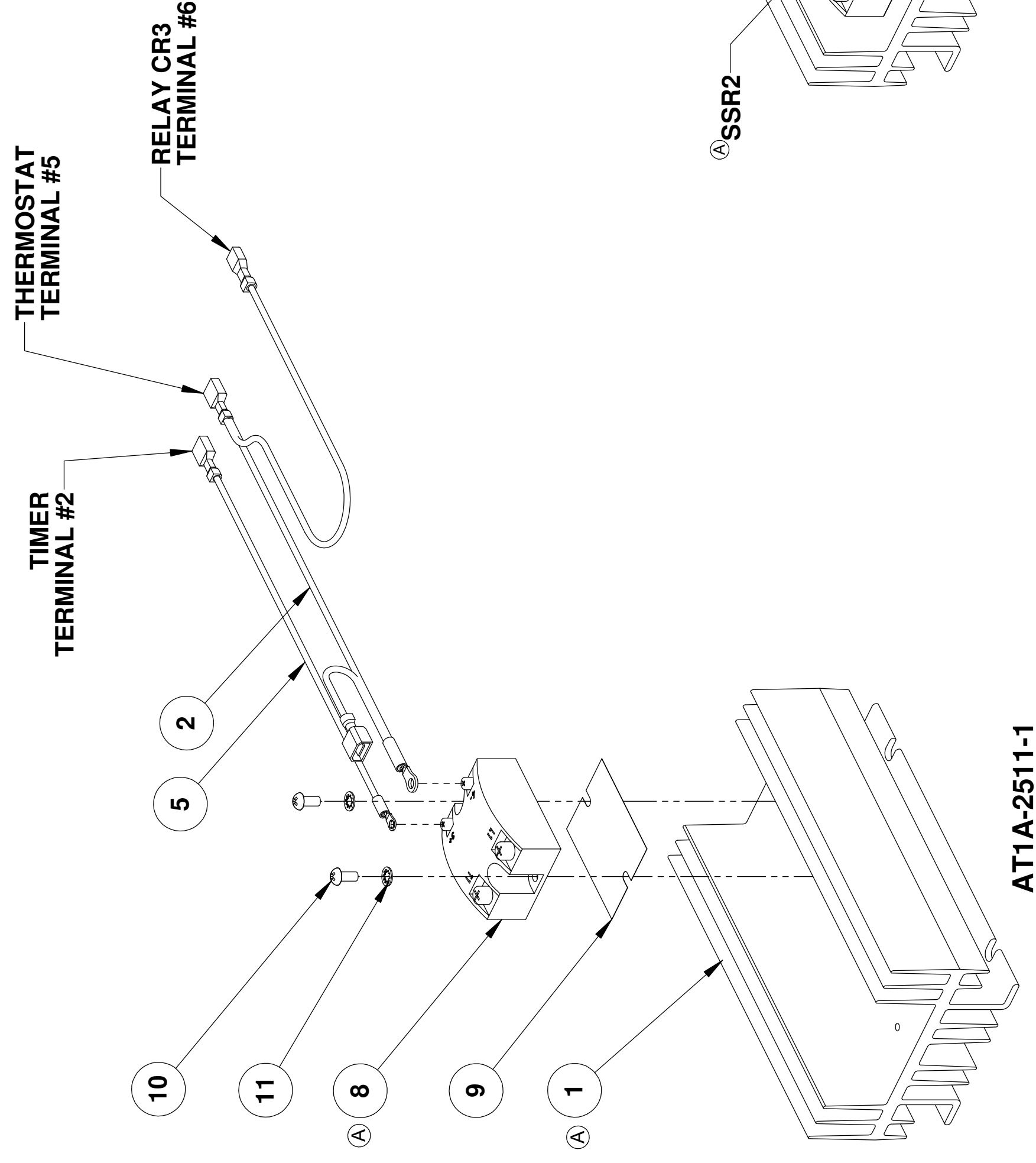


3 PAN STEAMER CONFIGURATION
GROUPS 7, 14, 15
OTHERWISE SAME AS GROUPS 1, 4-6, 8, 9, 11, 13, 22

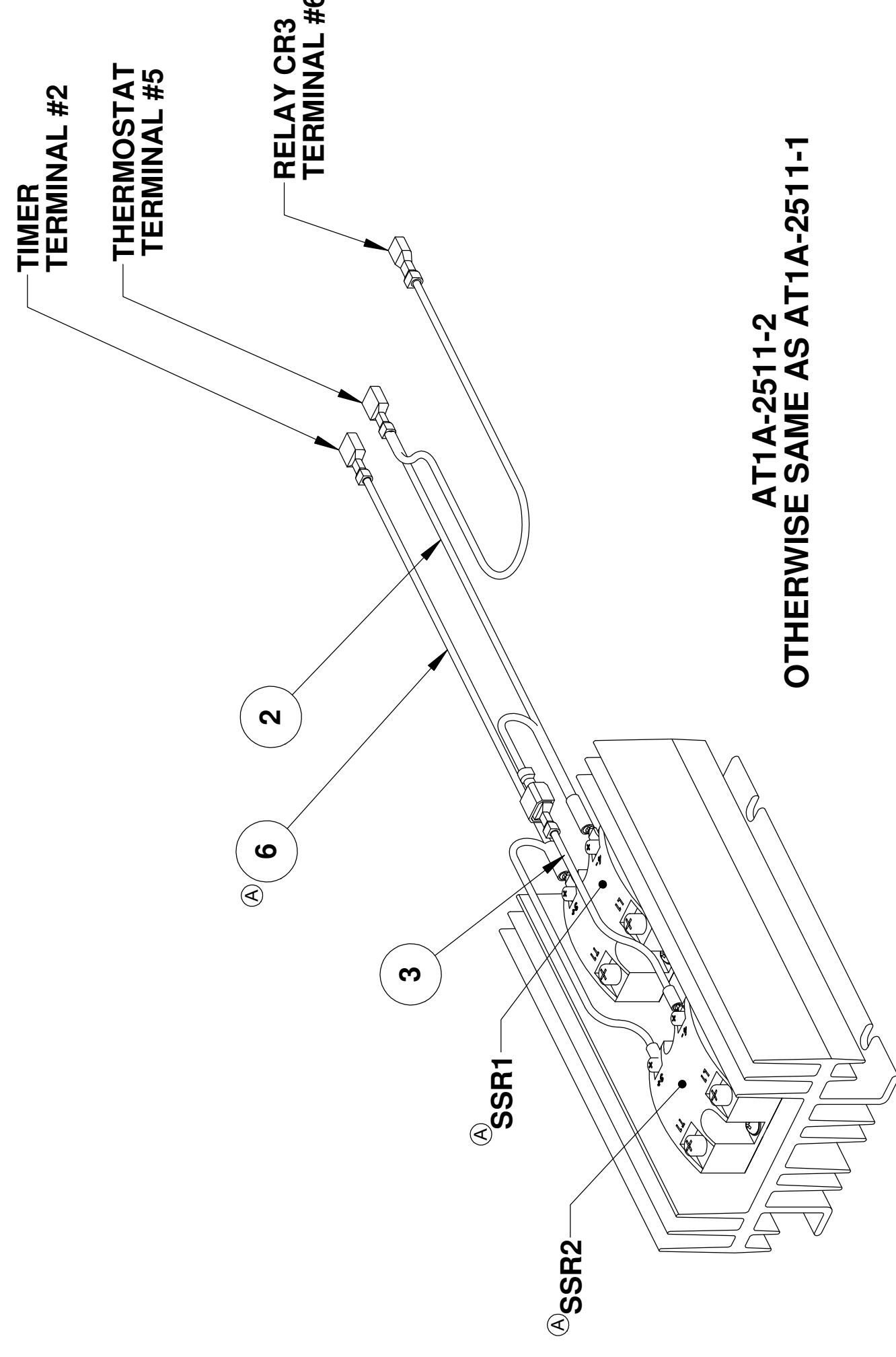


Official Dimensions Specified: Dimensions: Inches Tolerances:	Name: Drawn: Checked: Project Eng: Material:	Dim: Rev: Date: Date: Date:	Academy Products, Inc. Fort Wayne, IN 46825
Angular Dimension: 0.02 2 Place Decimal : 0.05 3 Place Decimal : 0.005 4 Place Decimal : 0.0005 Comments: Do Not Scale Drawing	Title: Material: Finish:	File: Date: Date:	MODULE, VOLTAGE WATTAGE PHASE
	Size: Scale:	Rev: Date:	E AT1A-3472 C
	Drawn: Checked: Project Eng: Material: Finish:	File: Date: Date:	Scale: 1/4" = 1'-0"

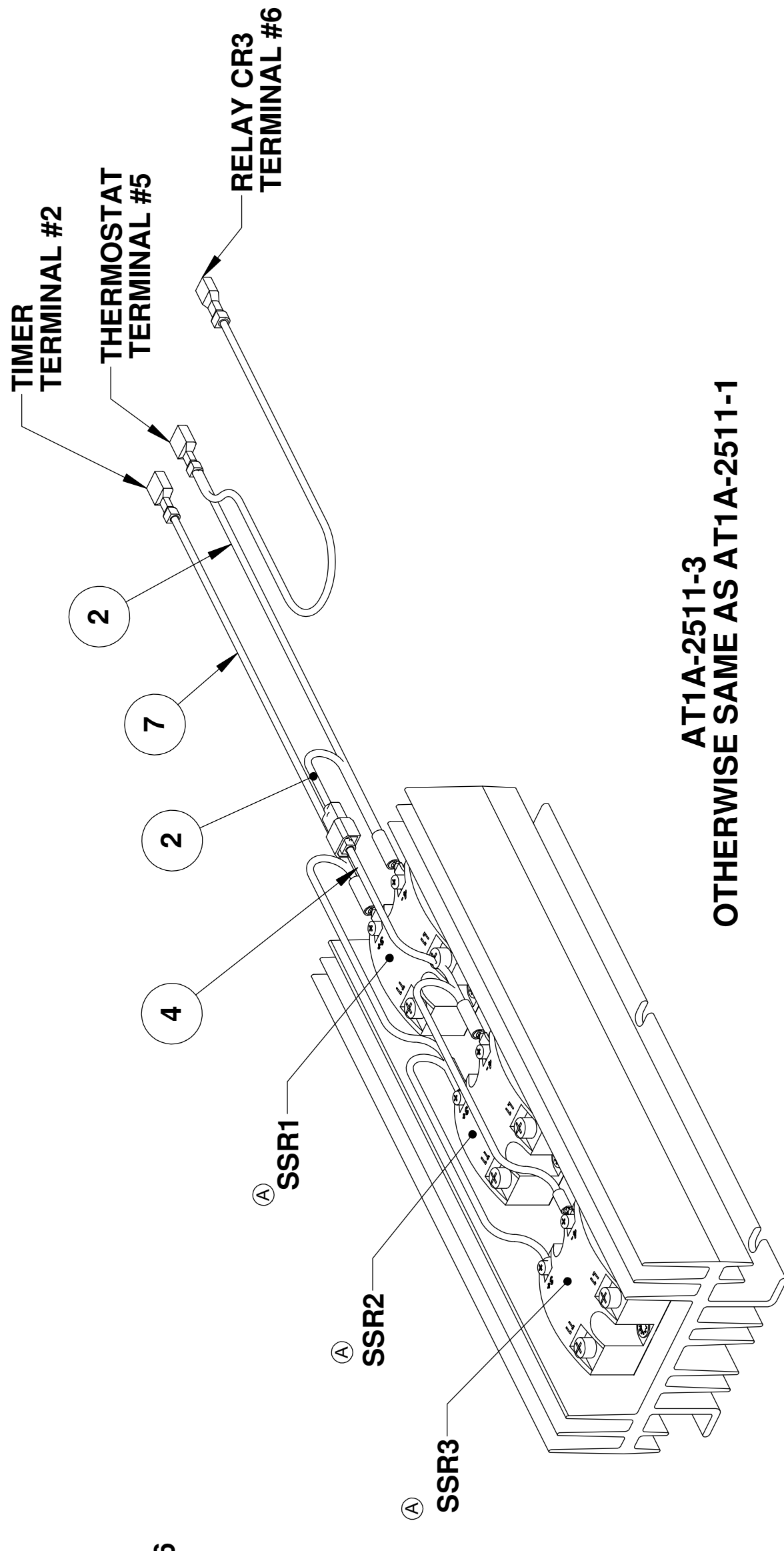
NOTES:
 1. ITEM 9, PAD, SSR HEAT SINK CAN BE SUBSTITUTED WITH HEAT SINK COMPOUND



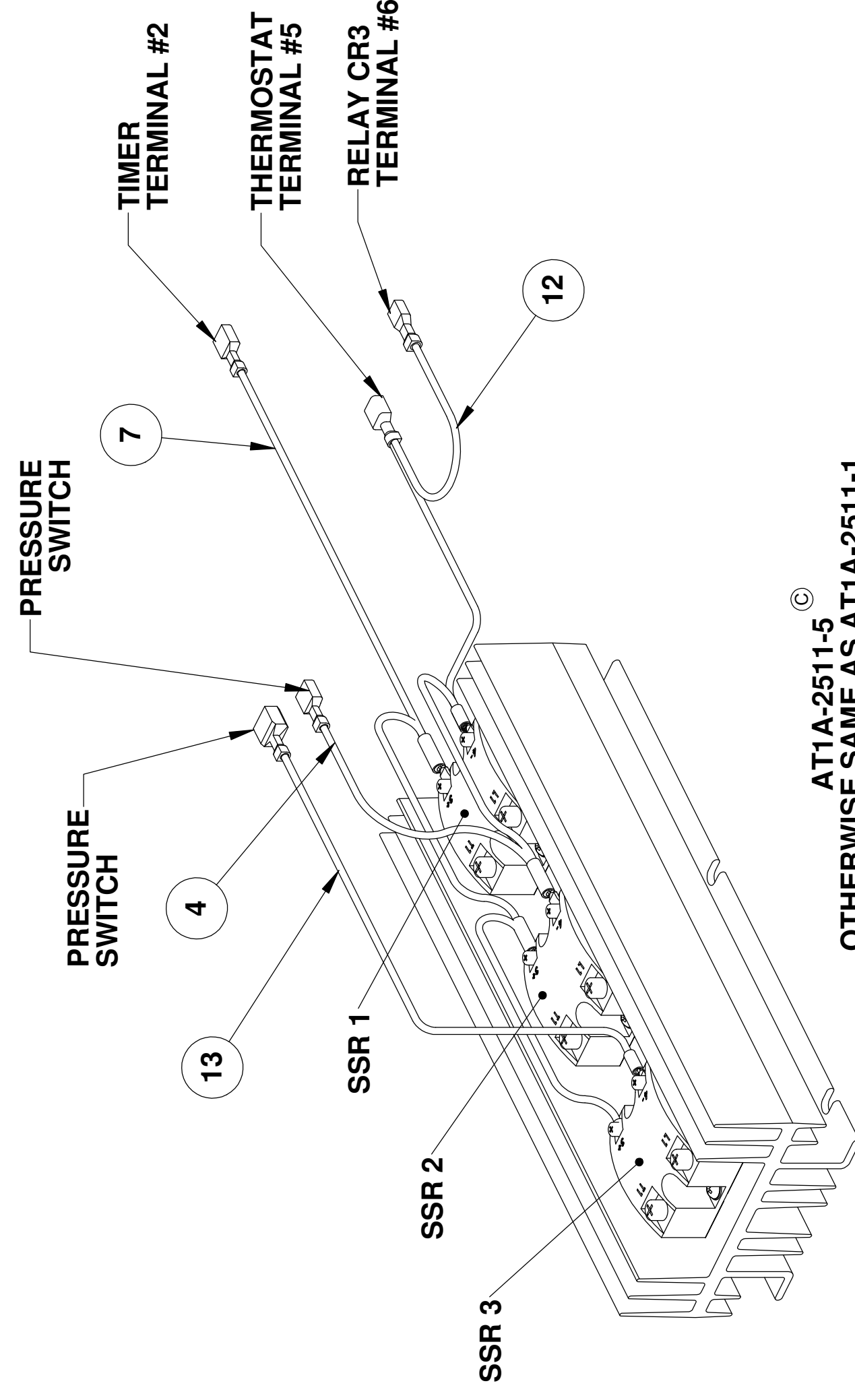
AT1A-2511-1



AT1A-2511-2
 OTHERWISE SAME AS AT1A-2511-1



AT1A-2511-3
 OTHERWISE SAME AS AT1A-2511-1



AT1A-2511-5
 OTHERWISE SAME AS AT1A-2511-1

QTY	AT1A-2511-5	QTY	AT1A-2511-3	QTY	AT1A-2511-2	QTY	AT1A-2511-1	PART NO.	ITEM	DESCRIPTION
1	-	-	-	-	-	-	-	AT0A-1454-8	13	WIRE HARNESS ASSY
1	-	-	-	-	-	-	-	AT0A-1454-7	12	WIRE HARNESS ASSY
6	6	4	2	AT0F-2666-30000	11	WASHER, #8 INTERNAL TOOTH LOCK				
6	6	4	2	AT0F-2755-31030	10	SCREW, #8-32UNC X 3/8 PHILIPS ROUND HEAD MACHINE				
3	3	2	1	AT0E-2996-1	9	PAD, SSR HEAT SINK				
3	3	2	1	AT0E-2059-3	8	RELAY, SOLID STATE				
1	1	-	-	AT0A-1454-6	7	WIRE HARNESS ASSY, TRIPLE SSR ORANGE				
-	-	-	-	AT0A-1454-5	6	WIRE HARNESS ASSY, DOUBLE SSR ORANGE				
-	-	-	-	AT0A-1454-4	5	WIRE HARNESS ASSY, SINGLE SSR ORANGE				
1	1	-	-	AT0A-1454-3	4	WIRE HARNESS ASSY, TRIPLE SSR WHT/BRN				
-	-	-	-	AT0A-1454-2	3	WIRE HARNESS ASSY, DOUBLE SSR WHT/BRN				
-	-	-	-	AT0A-1454-1	2	WIRE HARNESS ASSY, ALL SSR WHT/BRN				
1	1	-	-	AT0E-2206-2	1	HEAT SINK, 10.50" LONG				
-	-	-	-	AT0E-2206-1	1	HEAT SINK, 7.00" LONG				

ECN	REV	DESCRIPTION	DATE	APPR
340	D	CHGD: (AT1A-2511-1 & 2) TIMER TERMINAL #2 WAS THERMOSTAT TERMINAL #5; THERMOSTAT TERMINAL #5 WAS THERMOSTAT TERMINAL #2	05-08-07	GLS/ALB
325	C		02-09-07	LR/WALB
281	B	UPDATED PICTORIALY	02-22-06	GLS/ALB
220	A	CHGD: (AT1A-2511-1) MNTG LOCATION OF ITEM ADDED, 31" LONG, 12" LONG, SSR1, SSR2, SSR3, THIS SURFACE UP	04-22-05	RP/ALB

AT1A-2511-5

OTHERWISE SAME AS AT1A-2511-1

Unless otherwise specified, Dimensions are in inches

Bends 90°

Tolerances:

Angular ±1°

2 Place Decimal ±.02

3 Place Decimal ±.005

Tolerance ±.005

Material: N/A

Finish: N/A

Comments: Do Not Scale Drawing

Name	Date
Drawn	3-22-05
ATP	3-22-05
Checked	GLS
Project Eng	GLS
Material	3-22-05

AcuTemp Products, Inc	
8415 N. Clinton Park	
Fort Wayne, IN 46825	

HEAT SINK ASSY	
Size	D
Drawing No.	AT1A-2511
Rev	D
Scale	1:1.5 EDR: 088
Sheet 1 of 1	

BASE MODEL	SUPPLY VOLTAGE	PHASE / FREQUENCY	CONTROL SERIES	ENERGY INPUT (WATT)	TIMER CONFIGURATION	THERMOSTAT CONFIGURATION	R/L CONFIGURATION	LEG CONFIGURATION
S 6	2 0 8	3	D	0 8 0	3	0	0	0
1 2	3 4 5	6	7	8 9 10	11	12	13	14

MODEL STRING DIGIT:

(B)

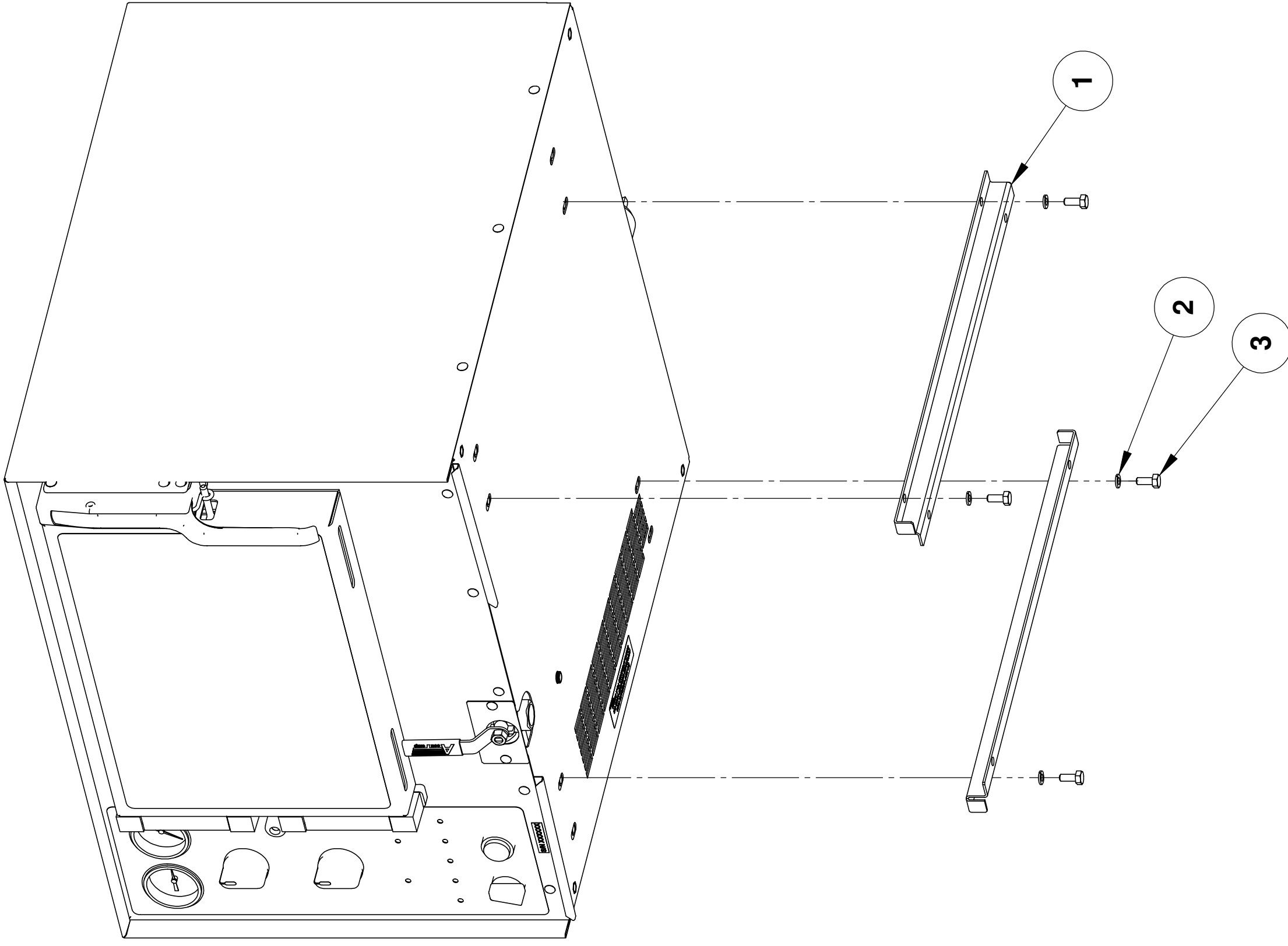
**DETAILED PRODUCT SPECIFICATION DRAWING
FOR THE 14TH MODEL STRING DIGIT IN THE AT1T-2611
STEAMER MODEL STRING CONFIGURATION**

MODULE, SPECIAL OPTION

- 0 = Drain Pan Rails
- 2 = Maritime Specs (6 Pan Only)
- 4 = Prison Specs (6 Pan Only)
- 5 = 4" Legs with Bullet Feet

423	C	CHG'D: (SHT 4 BOM) AT0F-3448-51066 WAS AT0F-3448-51056	06-30-08	DPS/ALB
364	B	CHG'D: (MODEL STRING DIGIT 11) 3 WAS 1 ADDED: (AT1T-3079-4 BOM) SHEET #4	08/15/07	GLS/DDI
340	A	CHG'D: (SHT 2 & 3) AT0F-2875-51060 WAS AT0F-2875-51051, SHT 1, 3 MARITIME WAS NAVY	06-05-07	GLS/ALB
328	REV	RELEASED TO PRODUCTION	10/10/06	GLS/ATP
ECN	REV	DESCRIPTION	DATE	APPR
		REVISIONS		

Unless otherwise specified, Dimensions: Inches		Drawn	Name	Date	AccuTemp Products, Inc. 8415 N. Clinton Park Fort Wayne, IN 46825
Bends: 90°	Tolerances:	Checked	ATP	10/10/2006	
Angular ±1°	2 Place Decimal ±.02	Project Eng	LRW	10/10/2006	Title: MODULE, SPECIAL OPTION
3 Place Decimal ±.005	T.I.R. ±.005	Material:	GLS	10/10/2006	
GD&T Per ANSI Y14.5M	Comments:	Finish:	N/A		Size: Drawing No.: C AT1T-3079
Do Not Scale Drawing			N/A		Rev. C
					Scale: 1:1 ECN: 328 Sheet 1 of 5



**INSTALLATION OF DRAIN PAN RAILS TO STEAMER ASSEMBLY
(3 PAN STEAMER SHOWN, 6 PAN STEAMER IS THE SAME)**

AT1T-3079-0

SPECIAL CONFIGURATION 0

DESCRIPTION
• Drain Pan Rails

MODIFICATIONS:
• Add Drain Pan Rails Only (No Bullet Feet)

(A)

4	AT0F-2875-51050	3	SCREW, 1/4-20UNC X 5/8 HEX HEAD MACHINE
4	AT0F-1922-50000	2	WASHER, 1/4" HELICAL SPRING LOCK
2	AT1M-2872-1	1	DRAIN PAN BRACKET
QTY AT1T-3079-0	PART NUMBER	ITEM	DESCRIPTION

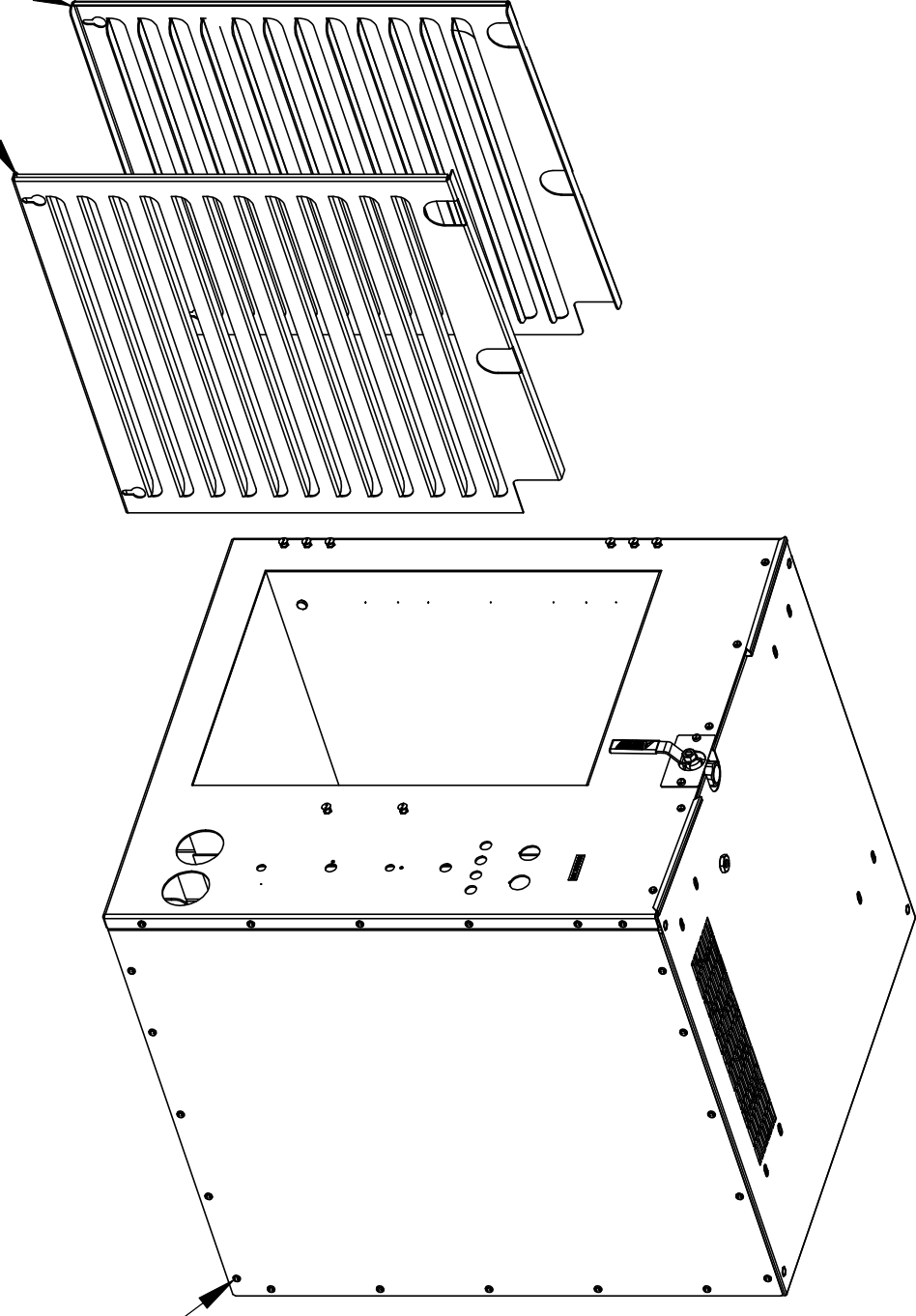
Unless otherwise specified, Dimensions: Inches Bends: 90° Tolerances: Angular ±1° 2 Place Decimal ±.02 3 Place Decimal ±.005 T.I.R. ±.005 GD&T Per ANSI Y14.5M Comments:		Drawn ATP	Checked LRW	Project Eng GLS	Material: N/A	Date 10/10/2006
Do Not Scale Drawing		Finish: N/A		Title: MODULE: SPECIAL OPTION		AccuTemp Products, Inc. 8415 N. Clinton Park Fort Wayne, IN 46825
Size: Drawing No.: C		Drawing No.: AT1T-3079		Rev.: C		Scale: 1:4 ECN: 328
						Sheet 2 of 5

NOTES:

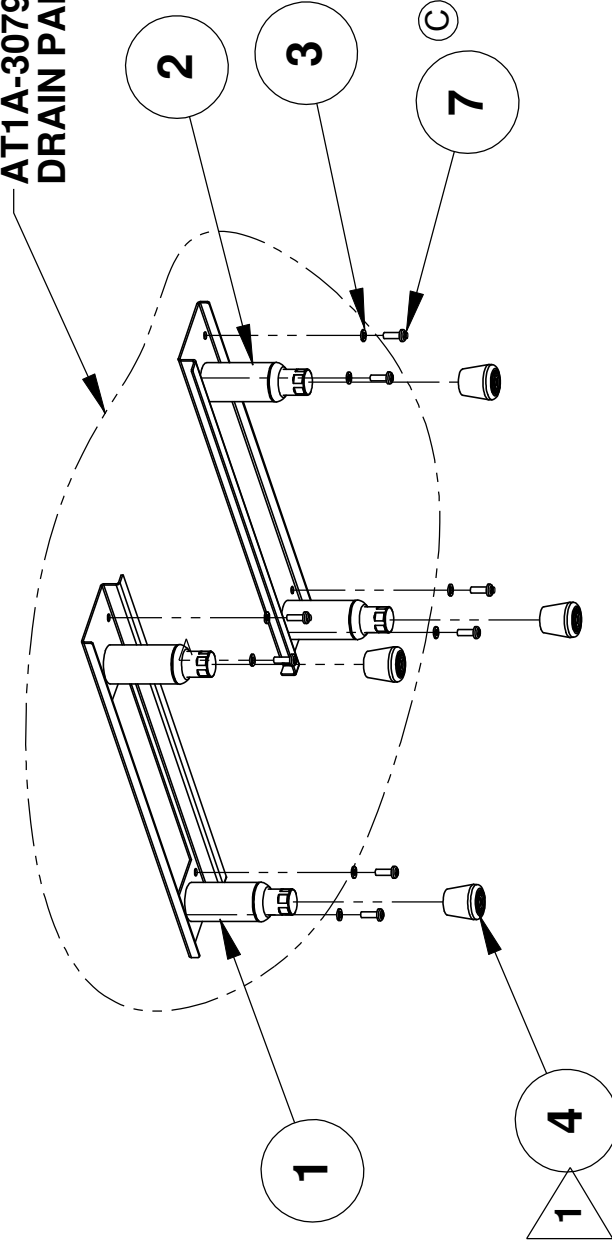
1 PACK ITEM 4 INTO THE BAG SHOWN ON AT1A-3387.

AT1A-3377 MODULE
PAN RACK SOLID

AT1A-3377 MODULE
SCREWS, TAMPER
PROOF TRUSS HEAD



AT1A-3079-4 MODULE
DRAIN PAN RAILS



AT1T-3079-4

SOME COMPONENTS ARE REMOVED FOR CLARITY

SPECIAL CONFIGURATION 4

DESCRIPTION

- Tamper Proof Screw, (2) Pan Rack Solid


MODIFICATIONS:

- Add 4" Legs with Bullet Feet (No Separate Drain Pan Rails)

PART NUMBER	ITEM	DESCRIPTION
8	AT0F-3448-51066	7 SCREW, 1/4-20 x 3/4" DRL SPAN PAN HD MACH
4	AT0H-3040-1	4 RUBBER BULLET FOOT TIP
8	AT0F-1922-50000	3 WASHER, 1/4" HELICAL SPRING LOCK
1	AT1A-3038-1	2 LEG BASE RIGHT ASSEMBLY
1	AT1A-3038-2	1 LEG BASE LEFT ASSEMBLY
AT1T-3079-4	QTY	

©

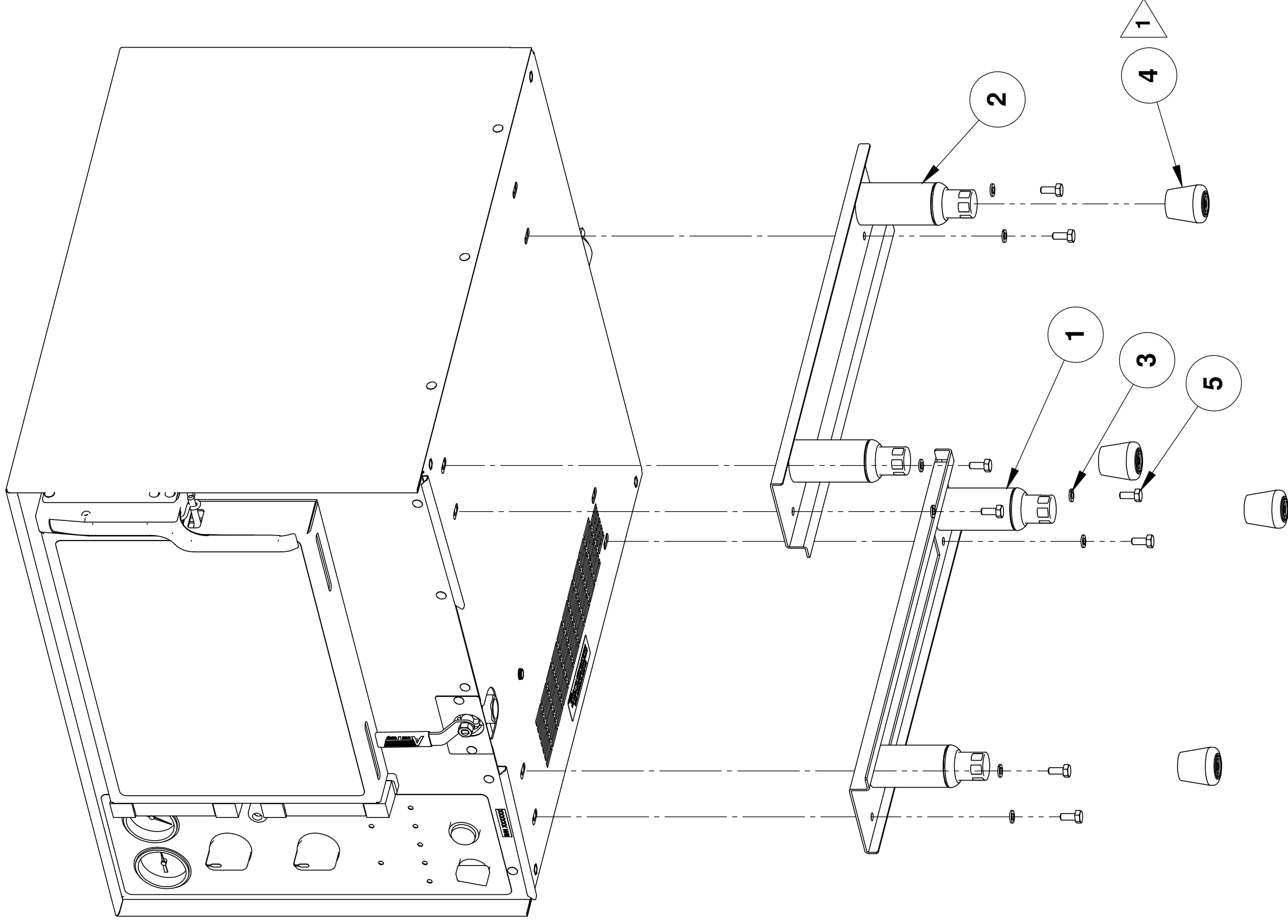
®

		AccuTemp Products, Inc. 8415 N. Clinton Park Fort Wayne, IN 46825	
Drawn	ATP	Date	10/10/2006
Checked	LRW	Date	10/10/2006
Project Eng	GLS	Date	10/10/2006
Material:	N/A	Title:	
Unless otherwise specified, Dimensions: Inches Bends: 90° Tolerances: Angular ±1° 2 Place Decimal ±.02 3 Place Decimal ±.005 T.I.R. ±.005 √125 Micro Inches GD&T Per ANSI Y14.5M Comments:		Size: Drawing No.: C AT1T-3079	
Do Not Scale Drawing		Rev. C Scale: 1:1 ECN: 328 Sheet 4 of 5	

**MODULE:
SPECIAL OPTION**

NOTES:

1 PACK ITEM 4 INTO THE BAG SHOWN ON AT1A-3387.



**INSTALLATION OF FEET TO STEAMER ASSEMBLY
(3 PAN STEAMER SHOWN, 6 PAN STEAMER IS THE SAME)**
**SPECIAL CONFIGURATION 5
AT1T-3079-5**

DESCRIPTION

- 4" Legs with Bullet Feet

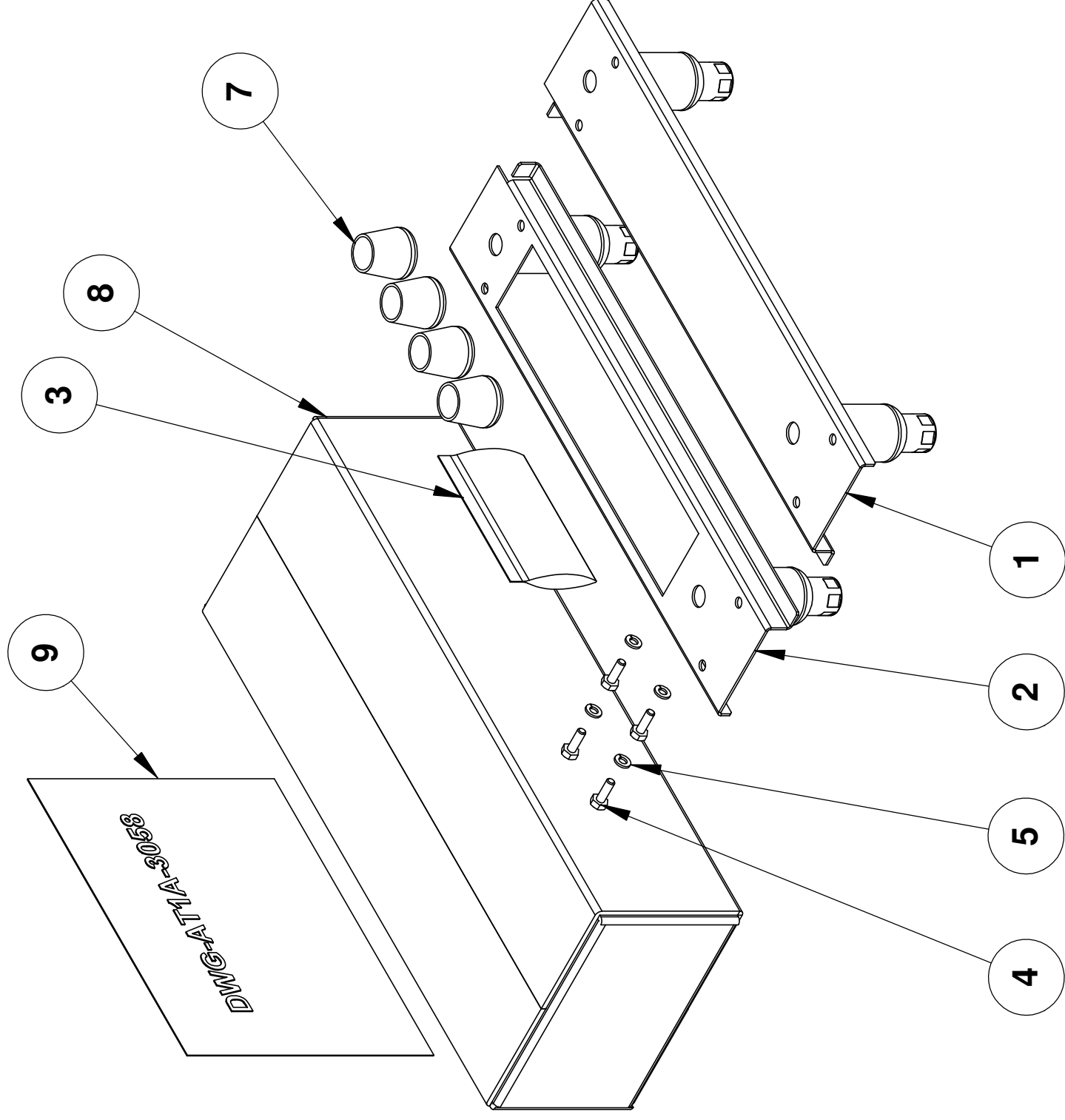
MODIFICATIONS:

- Add 4" Legs with Bullet Feet (No Separate Drain Pan Rails)

QTY	PART NUMBER	ITEM	DESCRIPTION
8	AT0F-2875-51050	5	SCREW, 1/4-20UNC X 5/8 HEX HEAD MACHINE
4	AT0H-3040-1	4	RUBBER BULLET FOOT TIP
8	AT0F-1922-50000	3	WASHER, 1/4" HELICAL SPRING LOCK
1	AT1A-3038-1	2	LEG BASE RIGHT ASSEMBLY
1	AT1A-3038-2	1	LEG BASE LEFT ASSEMBLY
AT1T-3079-5			

Unless otherwise specified, Dimensions: Inches		Drawn	Name	Date	AccuTemp Products, Inc 8415 N. Clinton Park Fort Wayne, IN 46825
Bends: 90°	Tolerances:	Checked	ATP	10/10/2006	
Angular ±1°	2 Place Decimal ±.02	Project Eng	LRW	10/10/2006	Title: MODULE: SPECIAL OPTION
3 Place Decimal ±.005	T.I.R. ±.005	Material:	GLS	10/10/2006	
GD&T Per ANSI Y14.5M	Comments:	Finish:	N/A		Size: Drawing No.: C AT1T-3079
Do Not Scale Drawing			N/A		Rev. C
					Scale: 1:4 ECN: 328

- NOTE:**
D 1. ITEM #4 AND #5 TO BE INSERTED INTO ITEM #3.
 THEN INSERT ITEM #1, #2, #3, #7 AND #9 INTO ITEM #8
 AND SEAL WITH TAPE.



AT1A-3030-1 ^(B)
LEG ASSEMBLY KIT

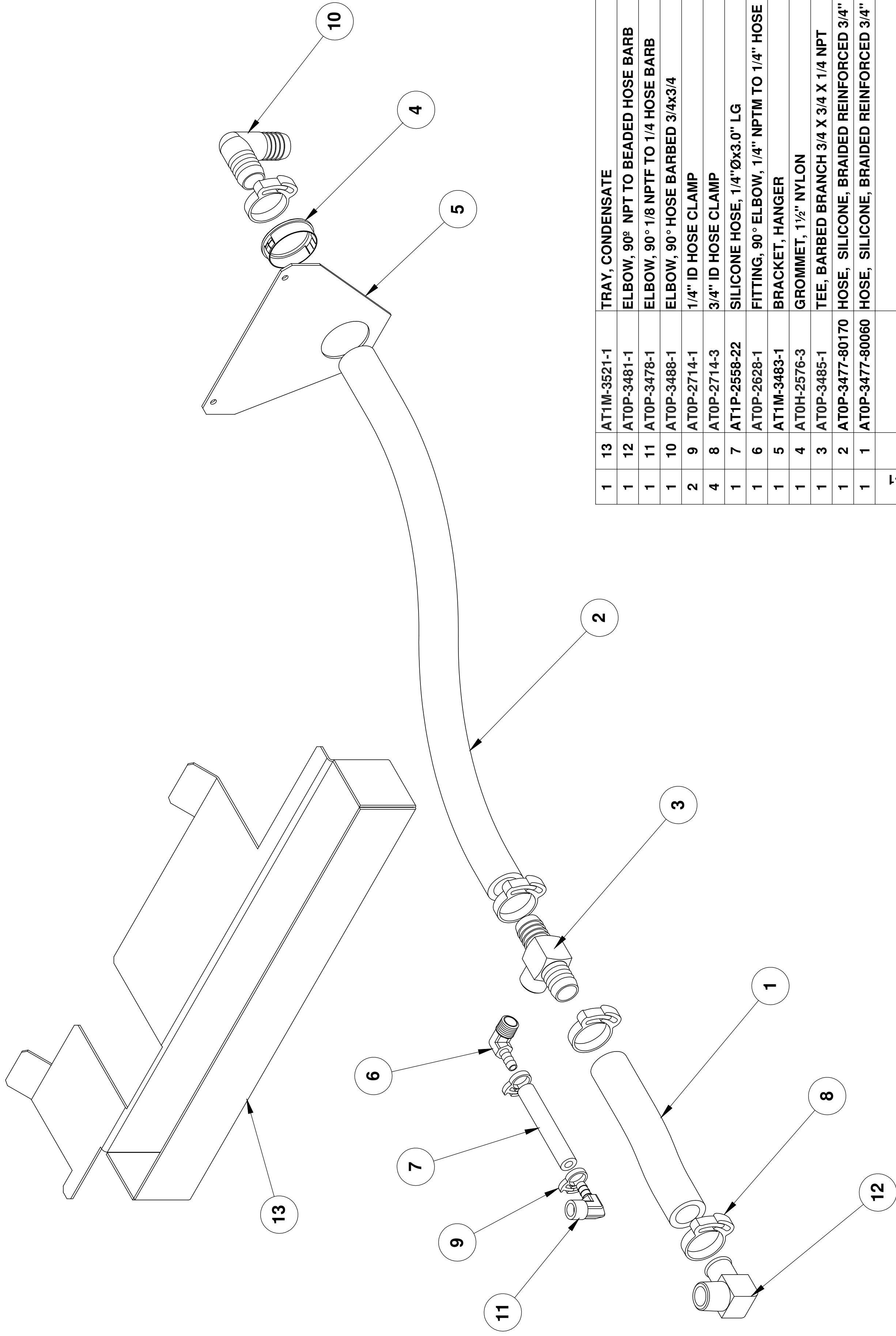
(C) ^(A)

QTY	PART NUMBER	ITEM	DESCRIPTION
1	AT1T-3058-1	9	INSTALLATION INSTRUCTIONS, LEG BASE ASSY
1	AT0S-3039-1	8	CARDBOARD BOX 19 1/2 X 7 1/4 X 4 3/8
4	AT0H-3040-1	7	RUBBER BULLET FOOT TIP
		6	
4	AT0F-1922-50002	5	WASHER, 1/4" HELICAL SPRING LOCK
4	AT0F-2875-51062	4	SCREW, 1/4-20UNC X 3/4 HEX HEAD MACHINE
1	AT0H-2782-1	3	BAG, 3 X 5 RECLOSABLE
1	AT1A-3038-2	2	LEG BASE LEFT ASSEMBLY
1	AT1A-3038-1	1	LEG BASE RIGHT ASSEMBLY

ECN	REV	DESCRIPTION	DATE	APPR	DPS/ATP	GLS/ATP	GLS/ALB	GLS/ATP	RP / ALB	APPR
332	D	RMV'D: ITM 6 ATP-LABEL2; CHG'D: NOTE 1	4/16/2007		DPS/ATP					
249	C	CHG'D: ITM 9 DESCRIPTION WAS INSTALLATION INSTRUCTIONS, 6 PAN STEAMER FEET	11/28/2006		GLS/ATP					
298	B	RMV'D: AT1A-3030-2 (REPLACE WITH AT1A-3030-1 BOTTOM AIR VENT CONFIGURATION)	9/18/2006		DPS/ALB					
208	A	ADDED: ITM 10, AT1T-3058-1 TO ALL GPS	2/28/2005		GLS/ATP					
	-	EDR-081 RELEASED TO PRODUCTION	1/13/05		RP / ALB					
	REV	DESCRIPTION	DATE	APPR						
REVISIONS										

Unless otherwise specified: Dimensions: Inches Bends: 90° Tolerances: Angular: +1° 2 Place Decimal ±.02 3 Place Decimal ±.005 T.L.R.: .005 1/125 Micro Inches GD&T Per ANSI Y14.5M Comments: Do Not Scale Drawing	Drawn: ALB Checked: RP Project Eng: RP Material: N/A	Name: ALB Date: 01-13-05	AccuTemp AccuTemp Products, Inc. 8415 N. Clinton Park Fort Wayne, IN 46825
Scale: 1:4	EDR: 078	Sheet 1 of 1	

Size: C	Drawing No.: AT1A-3030	Rev: D
Title: LEG BASE ASSEMBLY KIT		



AT1A-3463-1

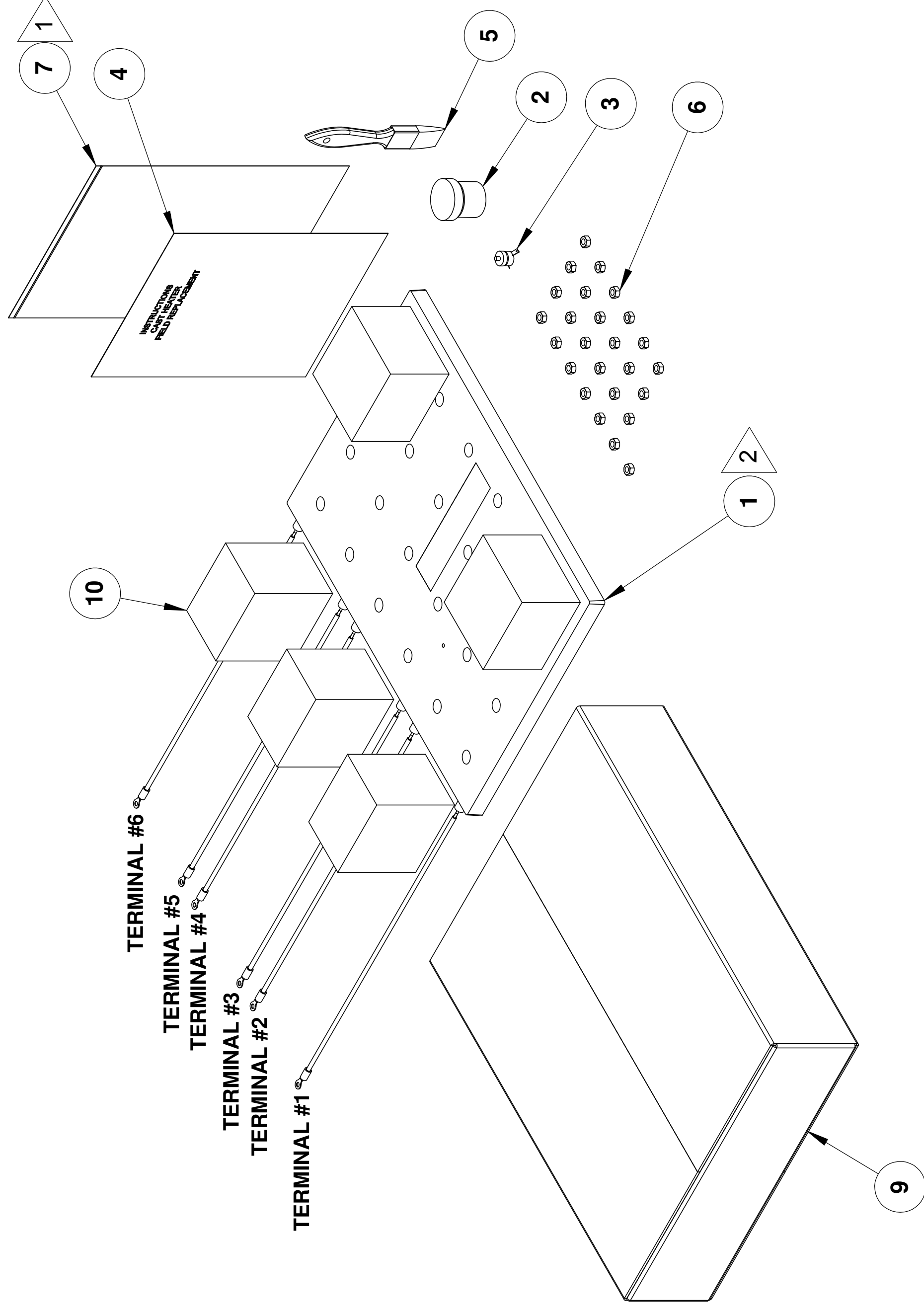
QTY	ITEM	PART NUMBER	DESCRIPTION
1	13	AT1M-3521-1	TRAY, CONDENSATE
1	12	AT0P-3481-1	ELBOW, 90° NPT TO BEADED HOSE BARB
1	11	AT0P-3478-1	ELBOW, 90° 1/8 NPTF TO 1/4 HOSE BARB
1	10	AT0P-3488-1	ELBOW, 90° HOSE BARBED 3/4x3/4
2	9	AT0P-2714-1	1/4" ID HOSE CLAMP
4	8	AT0P-2714-3	3/4" ID HOSE CLAMP
1	7	AT1P-2558-22	SILICONE HOSE, 1/4"Øx3.0" LG
1	6	AT0P-2628-1	FITTING, 90° ELBOW, 1/4" NPTM TO 1/4" HOSE BARB
1	5	AT1M-3483-1	BRACKET, HANGER
1	4	AT0H-2576-3	GROMMET, 1 1/2" NYLON
1	3	AT0P-3485-1	TEE, BARBED BRANCH 3/4 X 3/4 X 1/4 NPT
1	2	AT0P-3477-80170	HOSE, SILICONE, BRAIDED REINFORCED 3/4" IDx17" LG
1	1	AT0P-3477-80060	HOSE, SILICONE, BRAIDED REINFORCED 3/4" IDx6" LG

Unless otherwise specified, Dimensions: Inches Bends: 90° Tolerances:		Name	Date
Angular	±1°	GLS	5/1/2008
2 Place Decimal	±.02	GLS	5/1/2008
3 Place Decimal	±.005	GLS	5/1/2008
T.I.R.	±.005		
GD&T Per ANSI Y14.5M			
Comments:		N/A	
Do Not Scale Drawing		N/A	

AccuTemp Products, Inc. 8415 N. Clinton Park Fort Wayne, IN 46825	AccuTemp	Rev. A
Title: KIT, STEAMER DRAIN		Size: Drawing No.: AT1A-3463
Scale: 1:1		ECN: 422
Sheet 1 of 1		

422	A	REV	RELEASED TO PRODUCTION	06-27-08	GLS/ALB
ECN	REV	DESCRIPTION	DATE	APPR	REVISIONS

PART NUMBER	RATED VOLTAGE / WATTAGE									
	208V 6.0KW	230V 7.3KW	240V 8.0KW	380V 6.7KW	400V 7.4KW	415V 8.0KW	440V 9.0KW	480V 10.7KW		
AT1A-3530-1										
AT1A-3530-2			240V 6.0KW							
AT1A-3530-3	208V 8.0KW		240V 10.7KW	380V 9.0KW	400V 10.0KW	415V 10.7KW			480V 14.0KW	
AT1A-3530-4	208V 12.0KW		240V 16.0KW	380V 13.0KW	400V 14.8KW	415V 16.0KW	440V 18.0KW			
AT1A-3530-6	208V 10.0KW									
AT1A-3530-7	208V 17.0KW									



NOTES:

1 PLACE ITEMS 2 THRU 6 INTO ITEM 7.

2 WRAP ITEM 1 WITH ITEM 8.

QTY	AT1A-3530-7	AT1A-3530-6	AT1A-3530-4	AT1A-3530-3	AT1A-3530-2	AT1A-2615-1	ITEM	PART NUMBER	DESCRIPTION
5	1	1	1	1	1	1	10	AT0S-3535-1	PLANK FOAM
AR	AR	AR	AR	AR	AR	AR	9	AT0S-3533-1	BOX, CARDBOARD
1	1	1	1	1	1	1	8	AT0S-2770-1	FOAM OR BUBBLE WRAP
25	25	25	25	25	25	25	7	AT0H-2782-2	BAG, 9 X 12 RECLOSABLE
1	1	1	1	1	1	1	6	AT0F-3401-1	NUT, SPECIAL LOCKING 1/4-20UNC-2B
1	1	1	1	1	1	1	5	AT0H-3532-1	PAINT BRUSH
1	1	1	1	1	1	1	4	AT1T-3534-1	INSTRUCTIONS, CAST HEATER FIELD REPLACEMENT
1	1	1	1	1	1	1	3	AT1E-2653-3	OVERTEMP SWITCH
1	1	1	1	1	1	1	2	AT0H-3412-2	WAKEFIELD 120 THERMAL JOINT COMPOUND
1	-	-	-	-	-	-	1	AT1A-3531-7	CAST HEATER ASSEMBLY
-	1	-	-	-	-	-	1	AT1A-3531-6	CAST HEATER ASSEMBLY
-	-	-	1	-	-	-	1	AT1A-3531-4	CAST HEATER ASSEMBLY
-	-	-	-	1	-	-	1	AT1A-3531-3	CAST HEATER ASSEMBLY
-	-	-	-	-	1	-	1	AT1A-3531-2	CAST HEATER ASSEMBLY
-	-	-	-	-	-	1	1	AT1A-3531-1	CAST HEATER ASSEMBLY

Unless otherwise specified:
 Dimensions: Inches
 Bends: 90°
 Tolerances:
 Angular: ±1°
 2 Place Decimal
 1 Place Decimal
 1 PL ±.005
 1.125 Micro Inches
 GD&T Per ANSI Y14.5M
 Comments:
 Do Not Scale Drawing

Drawn	ALB	Date	5/8/2008
Checked	LRW	Date	5/8/2008
Project Eng	LRW	Date	5/8/2008
Material:	N/A		
Finish:	N/A		

AccuTemp Products, Inc.
 8415 N. Clinton Park
 Fort Wayne, IN 46825

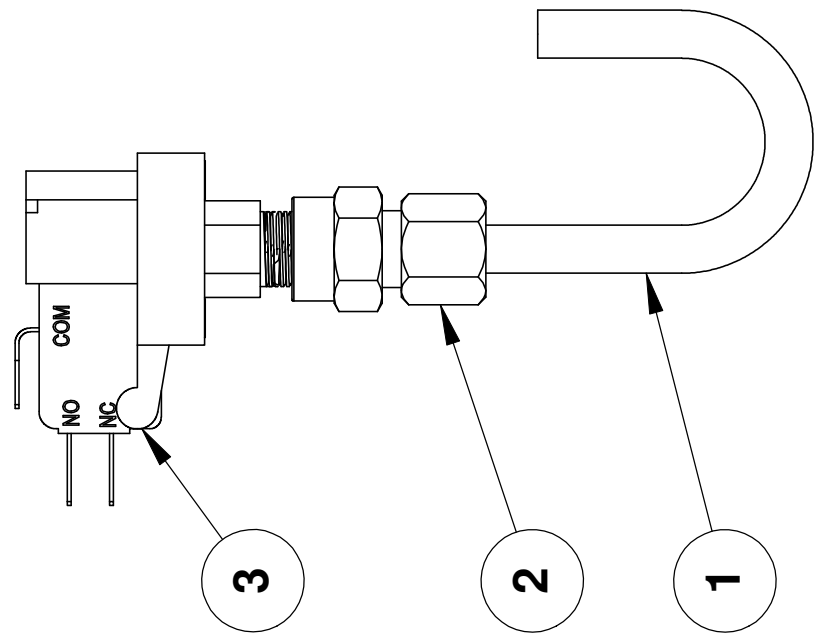
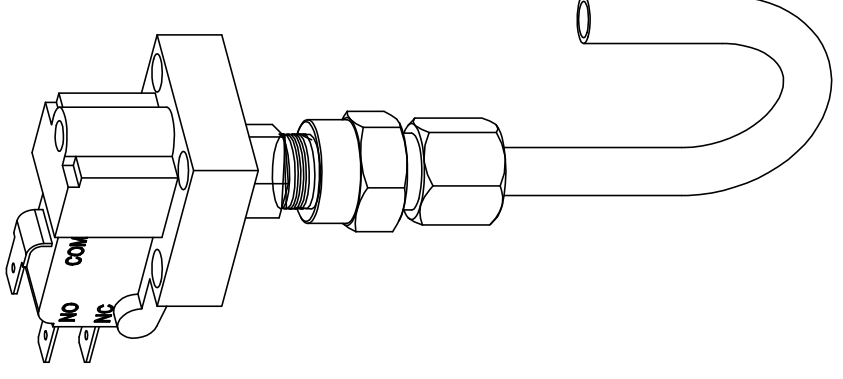
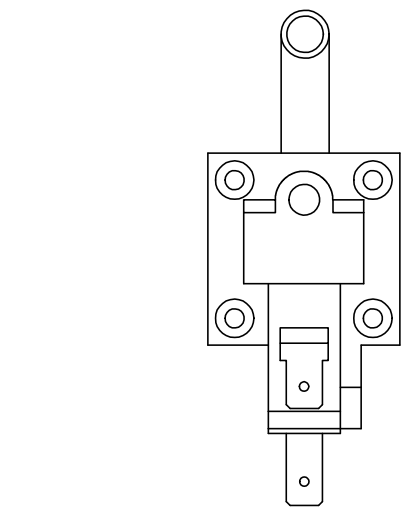
CAST HEATER REPLACEMENT KIT

Rev. **A**
 Size: Drawing No. **AT1A-3530**
 Scale: 1:5 ECN: 0

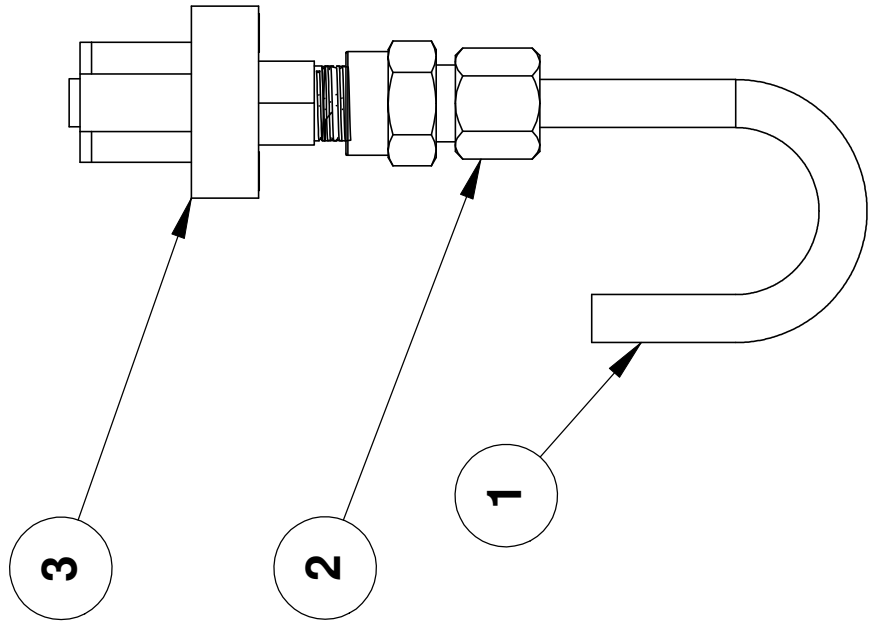
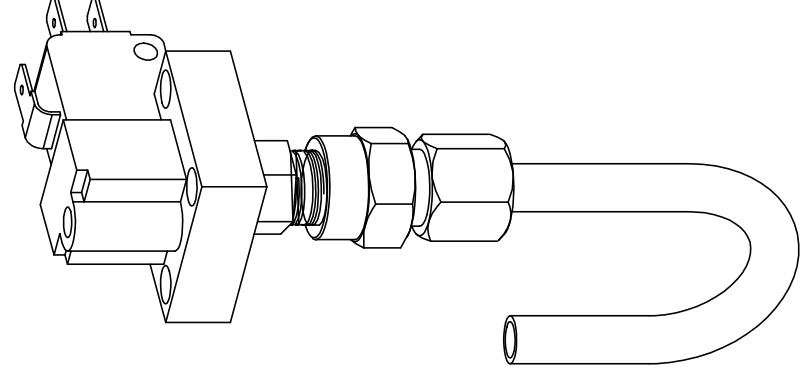
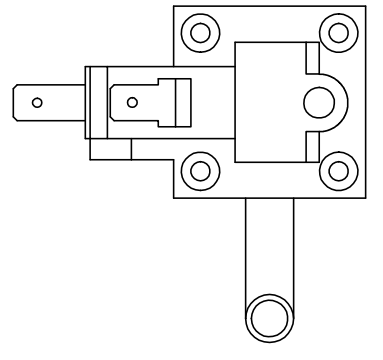
410	A	RELEASED TO PRODUCTION	05-15-08	LRW/ALB
ECN	REV	DESCRIPTION	DATE	APPR
REVISIONS				

NOTES: UNLESS OTHERWISE SPECIFIED

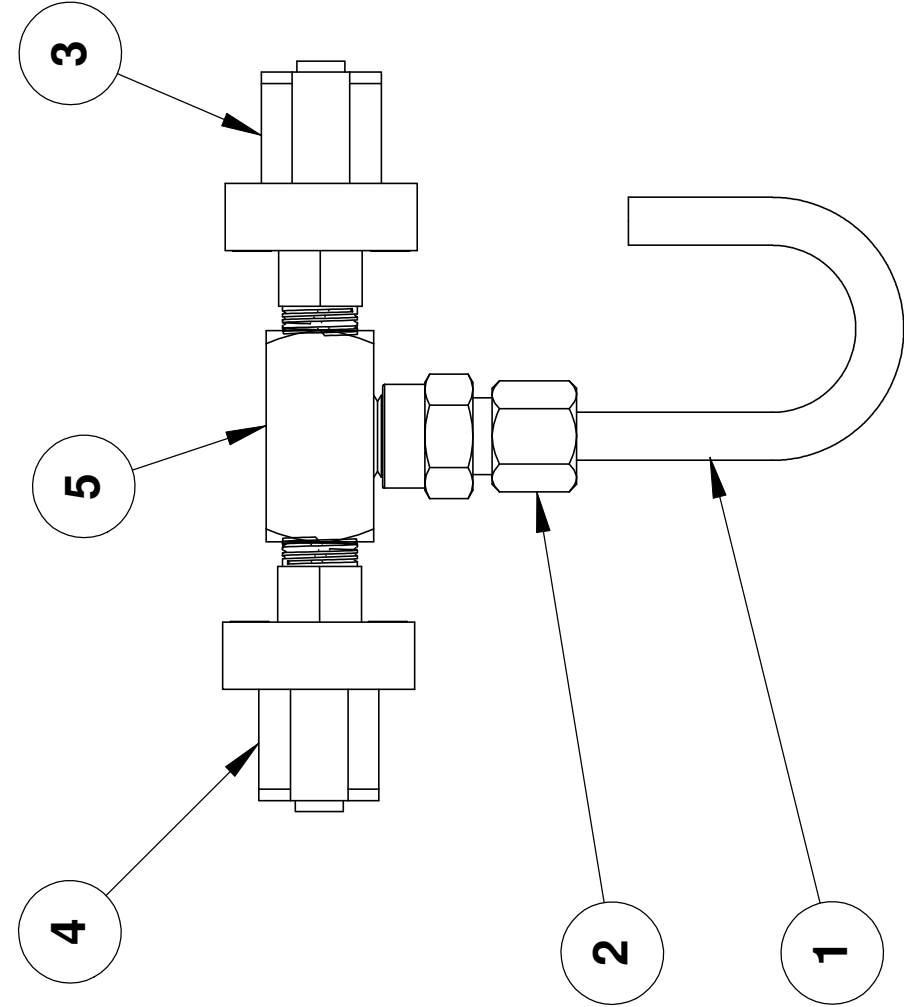
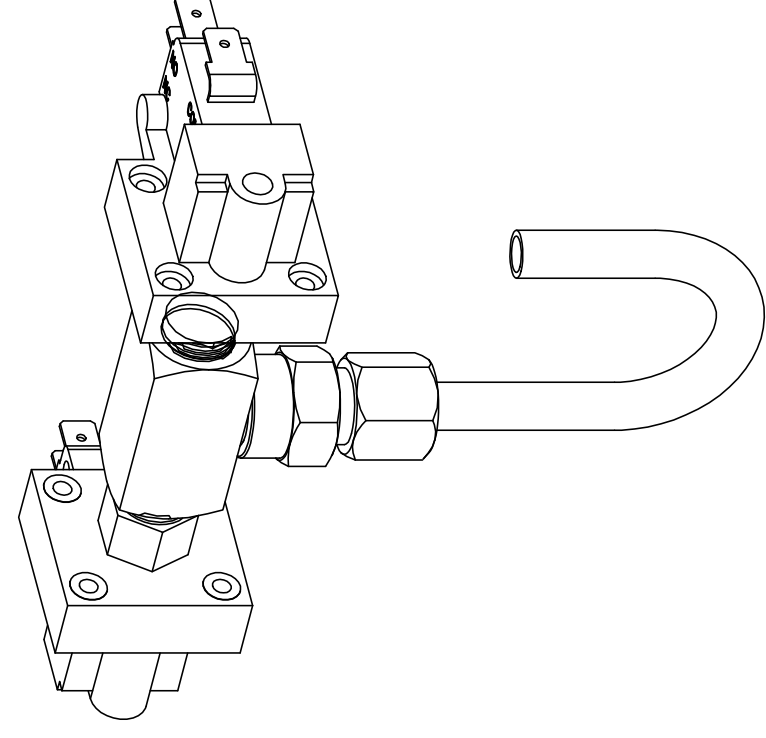
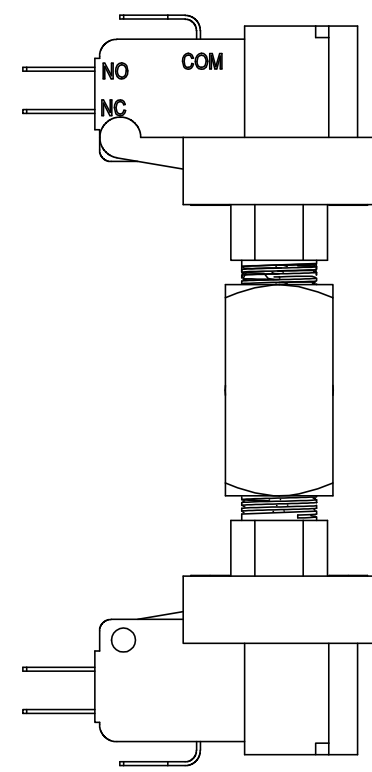
1. ALL PIPE THREADS TO BE SEALED WITH TEFLON THREAD SEALANT TAPE.



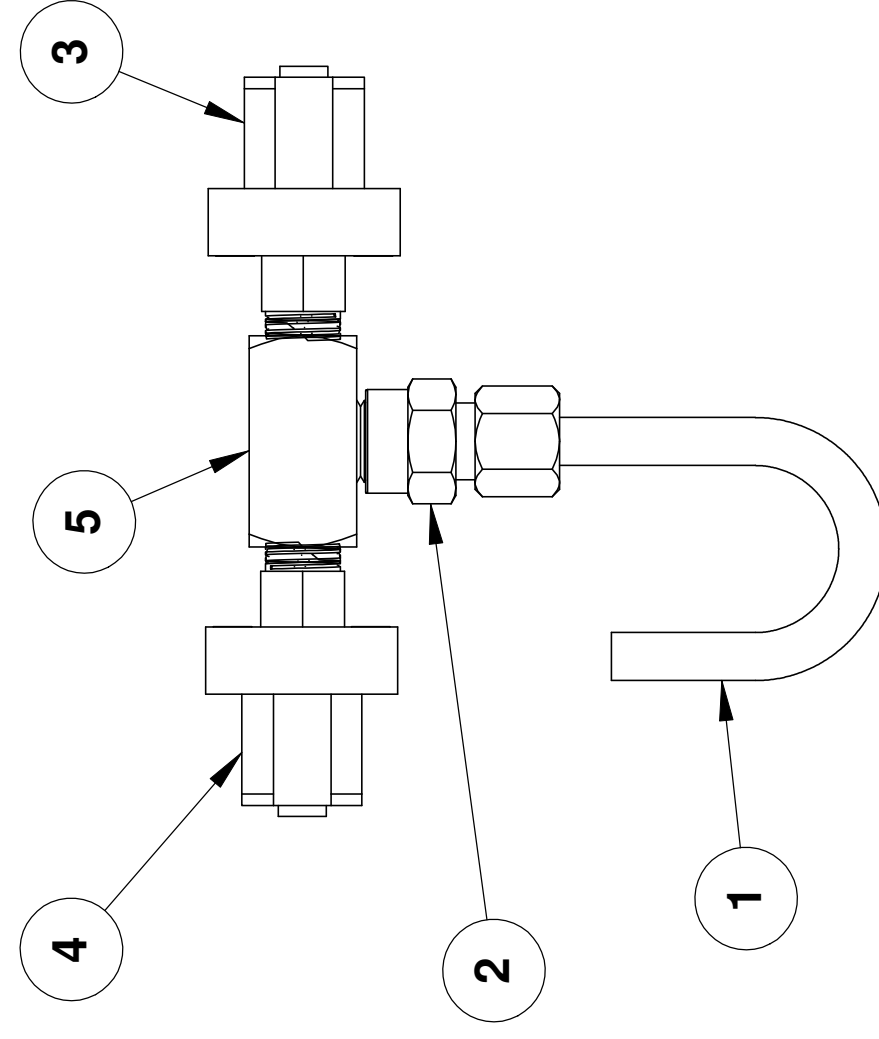
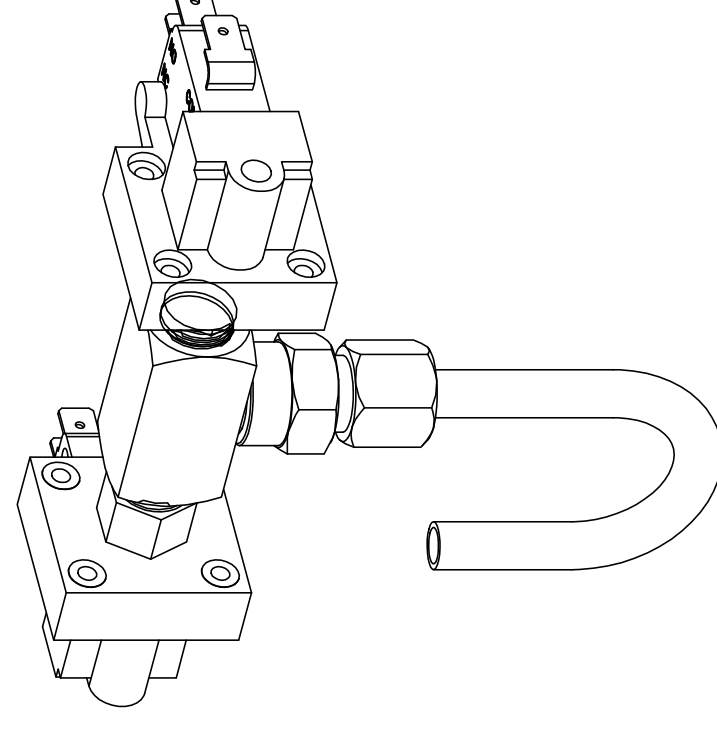
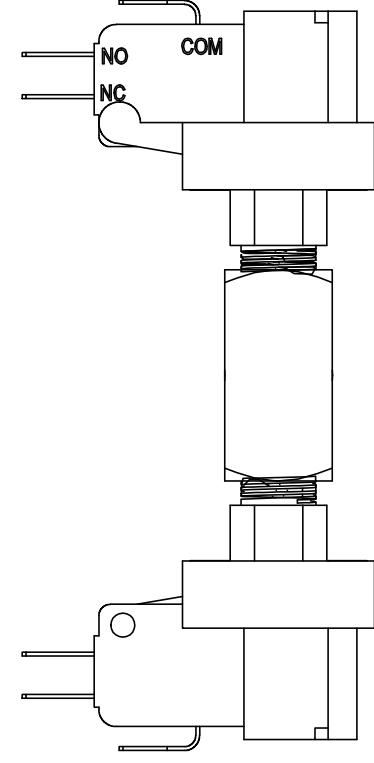
AT1A-3295-1



AT1A-3295-2



AT1A-3295-3



AT1A-3295-4

AR	AR	AR	AR	AR	AR	AR	AR	AR	AR	AR		
1	1	1	1	1	1	1	1	1	1	1	6	1/4" TEFLON TAPE
1	1	1	1	1	1	1	1	1	1	1	5	TEE MALE BRANCH
1	1	1	1	1	1	1	1	1	1	1	4	PRESSURE SWITCH, HIGH
1	1	1	1	1	1	1	1	1	1	1	3	PRESSURE SWITCH, LOW
1	1	1	1	1	1	1	1	1	1	1	2	COMPRESSION FITTING TO FEMALE NPT
1	1	1	1	1	1	1	1	1	1	1	1	TUBING, PRESSURE SWITCH
QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	ITEM
AT1A-3295-4	AT1A-3295-3	AT1A-3295-2	AT1A-3295-1	AT0P-3063-1	AT0P-2858-2	AT1E-2647-2	AT1E-2647-1	AT0P-3293-1	AT1P-3297-1	AT0P-3063-1	AT1A-3295-1	PART NUMBER

Unless otherwise specified, Dimensions: Inches		Name	Date
Tolerances:		ALB	7/11/2005
Angular	±.1°	Drawn	Checked
2 Place Decimal	±.02	Project Eng	11/2005
3 Place Decimal	±.005	Material	
1/16" Fractional	±.005		
1/32" Fractional	±.005		
1/64" Fractional	±.005		
1/128" Fractional	±.005		
1/256" Fractional	±.005		
Comments: Do Not Scale Drawing			
Title: PRESSURE SWITCH ASSEMBLY			
Drawing No.: AT1A-3295		Rev: -	
Size: D		Finish: N/A	
Scale: 1:1		EDR: 130	
		Sheet 1 of 1	

ECN	REV	DESCRIPTION	DATE	LEC/ALB	APPR
-	-	EDR-130 RELEASED TO PRODUCTION	08-22-06	LEC/ALB	APPR
REVISIONS					

WARRANTY

LIMITED WARRANTY

One Year – Parts and Labor U.S. & Canada Only

AccuTemp Products, Inc. (AccuTemp) warrants that your AccuTemp equipment will be free of defects in material and workmanship under normal use for a period of twelve (12) months from installation or fifteen (15) months from date of shipment from AccuTemp, whichever date first occurs (the Warranty Period). Registration of AccuTemp equipment is required at the time of installation. Damage to AccuTemp equipment that occurs during shipment must be reported to the carrier, and is not covered under this warranty. The reporting of any damage during shipment is the sole responsibility of the commercial purchaser/user of such AccuTemp equipment.

AccuTemp provides an active service department, which should be contacted and advised of service issues, regardless of the warranty period. During the warranty period, AccuTemp agrees to repair or replace, at its option, F.O.B. factory, any part which proves to be defective due to defects in material or workmanship, provided the equipment has not been altered in any way and has been properly installed, maintained, and operated in accordance with the instructions in the AccuTemp Owners Manual. During the warranty period, AccuTemp also agrees to pay for any factory authorized equipment service agency (within the continental United States and Canada) for reasonable labor required to repair or replace, at our option, F.O.B. factory, any part which proves to be defective due to defects in materials or workmanship, provided the service agency has received advance approval from AccuTemp factory service to perform the repair or replacement. This warranty includes travel time not to exceed two hours and mileage not to exceed 50 miles (100 miles round trip), but does not include post start-up assistance or training, tightening of loose fittings or external electrical connections, minor adjustments, maintenance, or cleaning. AccuTemp will not reimburse the expense of labor required to replace parts after the expiration of the warranty period.

Proper installation is the responsibility of the dealer, owner-user, or installing contractor and is not covered by this warranty. Improper installation can affect your warranty. Installation is the responsibility of the Dealer, Owner/User or the Installation Contractor. See the Installation section of the Owners Manual. While AccuTemp products are built to comply with applicable standards for manufacturers, including Underwriters Laboratories (UL) and National Sanitation Foundation (NSF), it is the responsibility of the owner and the installer to comply with any applicable local codes that may exist.

AccuTemp makes no other warranties or guarantees, whether expressed or implied, including any warranties of performance, merchantability, or fitness for any particular purpose. AccuTemp's liability on any claim of any kind, including negligence, with respect to the goods and services covered hereunder, shall in no case exceed the price of the goods and services, or parts thereof, which gives rise to the claim. In no event shall AccuTemp be liable for special, incidental, or consequential damages, or damages in the nature of penalties.

This constitutes the entire warranty, which supersedes and excludes all other warranties, whether written, oral, or implied.