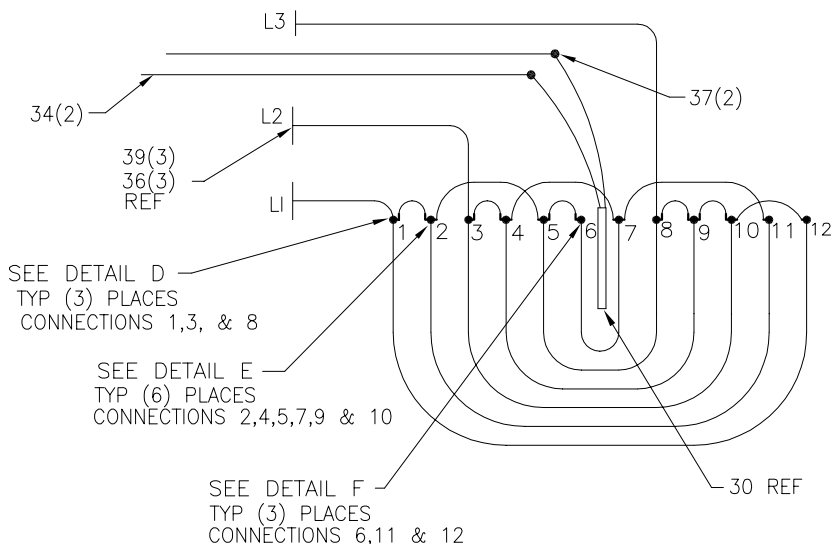




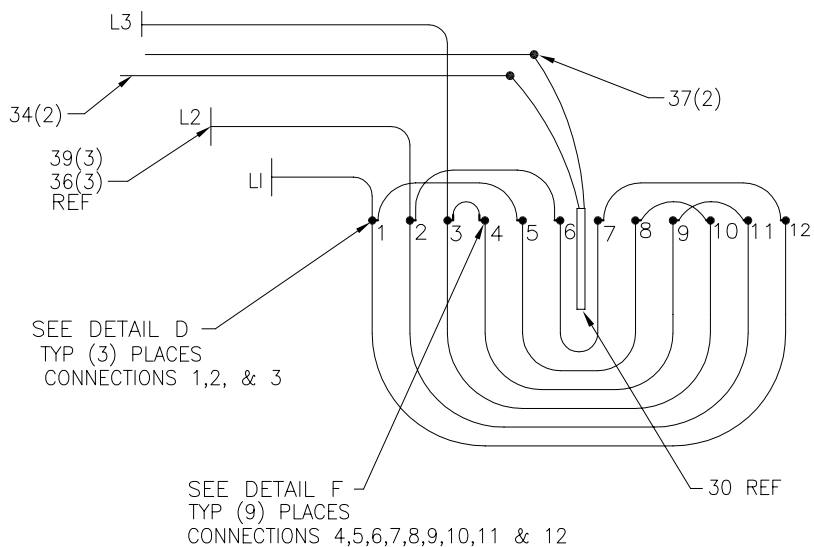
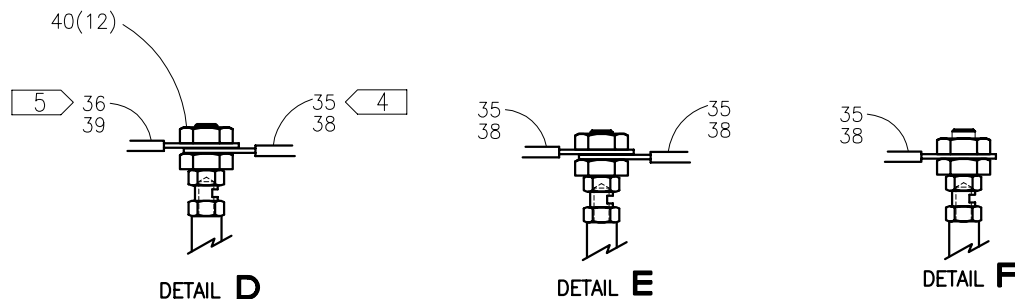
#1236A BUTT PLATE HEATER ASSEMBLY

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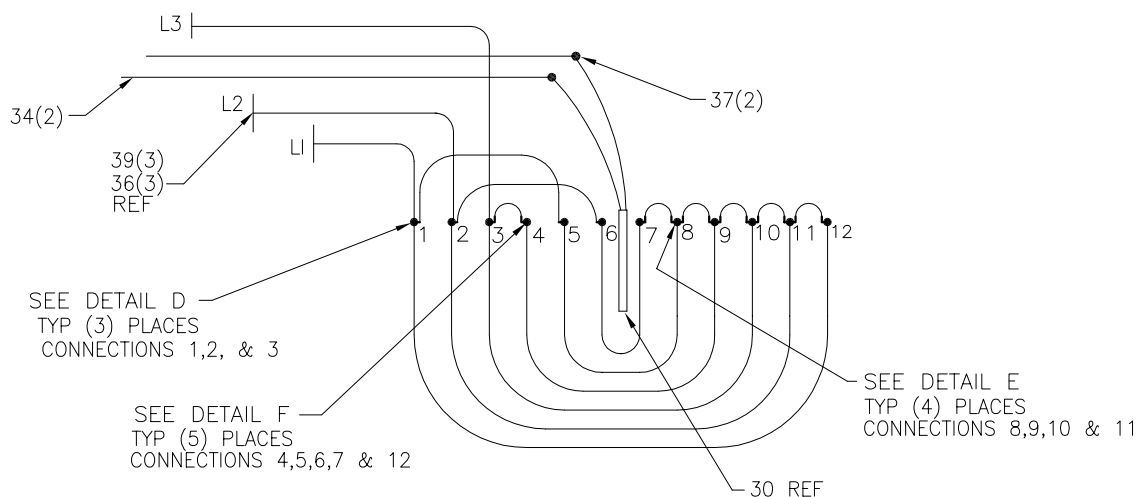
HEATER SCHEMATIC

220-240V, 50/60Hz, 3Ph
20,461 WATT



HEATER SCHEMATIC

480V, 60Hz, 3Ph
20,461 WATT



HEATER SCHEMATIC

415V, 50Hz, 3Ph
20,461 WATT

#1236A BUTT PLATE HEATER ASSEMBLYPARTS LIST

ITEM	PART NO.	QTY	DESCRIPTION
	3617401		Assembly
1			
2	2410602	1	Terminal Enclosure Cover Gasket
3	2410603	4	Terminal Enclosure Gasket
4	2413401	1	Heater Support Roller
5	3602005	1	Heat Sink Plate
6	3602923	1	Butt Plate Heater Body
7	3603102	1	Heater Terminal Enclosure
8	3603103	1	Heater Terminal Enclosure Cover
9	3604703	2	Heater Pivot Arm Splice Plate
10	3613001	1	Heater Roller Housing
11	3613102	2	Heater Gasket
12	3613201	1	Heater Roller Housing Roller Pin
13			
14	3617201	2	Butt Plate
15	3617301	15	Butt Plate Heater Coupling Nut
16			
17	MAE00117	5	1/2-13NC X 1" Lg. BHSCS
18	MAH00081	12	#10-32NF X 1/2" Lg. SHCS SS
19	MAH00084	4	5/16-18NC X 1-1/2" Lg. SHCS SS
20	MAH00086	2	3/8-16NC X 2-3/4" Lg. SHCS SS
21	MAH00142	34	5/16-18NC X 1" Lg. FHSCS SS
22	MBA00007	2	3/8-16NC Finished Hex Nut
23	3613303	5	Heater Splice Plate Nut
24	MBE00006	4	5/16" Regular Split Lock Washer
25	MBE00007	2	3/8" Regular Split Lock Washer
26	MBE00010	5	9/16" Regular Split Lock Washer
27	MFA00014	1	6MPT PLUG
28	MJK00002	1	Thermometer
29	MJQ00287	1	1/16" X 5" X 13-1/4" Gasket
30	MKI00002	1	100 OHM PLATINUM RTD
31	MLI00029	4.83FT	High/Low 1/2" Flexible Conduit
32	MLJ00012	1	1/2" straight Conduit Connector
33			
34	MLL00004	12FT	#18 Type TGGT Electrical Wire
35	MLL00025	3FT	#12 Type TGGT Electrical Wire

#1236A BUTT PLATE HEATER ASSEMBLY

ITEM	PART NO.	QTY	DESCRIPTION
36	MLL00043	18FT	#8 TGGT Electrical Wire
37	MLM00012	2	Connector
38	MLM00024	18	Ring Terminal
39	MLM00117	3	Ring Terminal
40	MBA00004	12	#10-24NC HEX NUT

DRAWING REVISION HISTORY LISTING

PART NO: 3617401

DESCRIPTION: #1236A BUTT PLATE HEATER ASSEMBLY

<u>APPR.</u>	<u>REV</u>	<u>DATE</u>	<u>BY</u>	<u>DESCRIPTION OF REVISION</u>
B	C	4/25/95	SWB	Scanned & reduced to 'A' size format. Created typed parts list. Combined Sht 1 & 2. Removed pivot arm.
SWB	D	4/15/96	SS	Change note #3 on page 2 of BOM, Sht. 2 to Sht. 8 and add Sht. 13.
SWB	E	11/18/97	DJL	ITEM 27 WAS INT. SNAP RING MCA00011. REVISED TO PIPE PLUG MFA00014.
TLW	---	12/15/97	TGW	REVISED NOTE 3 TO REMOVE REFERENCE TO SCHEMATIC 3600400. FURTHER REVISED NOTE 3 TO INCLUDE SCHEMATIC 3603000 (SHEETS 1, 6 & 9).
SWB	F	2/4/98	DJL	REVISED TO PROVIDE CLEARANCE BETWEEN HEATER PANEL AND SPLICE PLATE NUTS. REPLACED ITEM 17 (MAA00132) WITH MAE00117. REPLACED ITEM 23 (MBA00009) WITH 3613303 HEATER SPLICE PLATE NUT. REPLACED ITEM 26 (MBE00009) WITH 9/16 SPLIT LK WASHER (MBE00010). REMOVED ITEM 13 (3613302).
TLW	---	6/4/98	TGW	REVISED ITEM 32 P/N FROM (MLJ00001) TO (MLJ00012).
SWB	G	11/2/98	DJL	ADDED HEATER SCHEMATICS FOR DIFFERENT VOLTAGES. ADDED DETAILS D,E & F ON SHEET 1B. CHANGED NOTE 2, WAS WIRE PER SP-103 & REMOVED NOTE 3. REMOVED ITEM 33 MLJ00004 1/2" SEALING RING (NOT USED). REMOVED ITEM 1, 223901 HEATER TAG, (NOT USED). REDUCED LENGTH ON ITEM 34, #18 WIRE FROM 12' TO 10'. REDUCED LENGTH ON ITEM 35, #12 WIRE FROM 15' TO 3', AND ITEM 36, #10 WIRE FROM 20' TO 15'. REDUCED QTY OF ITEM 38 RING TERMINAL FROM 21 TO 18. (USED ON #12 WIRE) ADDED ITEM 39, RING TERMINAL USED ON #10 WIRE. ADDED ITEM 40, #10 HEX NUTS.
SWB	H	4/1/99	DJL	REMOVED ITEM -16 SPACERS, P/N 4815501. BUTT PLATE HEATER P/N 3602923 NOW HAS ELEMENT SUPPORT INSERTS TO ACCOMMODATE 1.875 SPACING. THIS CHANGE IS REFLECTED ON FUSION UNIT S.N. 99F0530 AND ON.
SWB	--	10/25/00	BWW	ITEMS 31, 34, & 36 CONDUIT & WIRE LENGTH WAS INCREASED TO ALLOW USE WITH T900 MACHINES ALSO. ADDED NOTE 3.
PJB	J	4/4/02	BEA	CORRECTED HEATER WATTAGE FROM 20,400 TO 20,461 TO MATCH AS BUILT CONDITION.
BWJ	K	01/30/04	BWW	REVISED LENGTH OF ITEM 31 MLI00001 FROM 4.5 FEET 4.83 TO ACCOMMODATE REROUTING OF POWER CABLE.
BWJ	L	4/13/04	ALK	CHANGED ITEM 31 FROM MLI00001 TO MLI00029, DUE TO SEALTITE CHANGE TO HIGH/LOW TEMP TYPE HC BECAUSE OF PROXIMITY TO HEATER SPLICE PLATE ON T900.
JRP	M	6/3/05	BEA	CHANGED ITEM 36 FROM #10 TGGT WIRE TO #8 TGGT WIRE, ADDED NOTE #4 AND NOTE #5 TO IMPROVE RELIABILITY.
SWB	N	11/09/05	BWW	CREATED EXPLODED ISOMETRIC VIEW AND ADDED NOTE 6 FOR CLARITY. UPDATED NOTE 1 TO CURRENT STANDARD.