



F3502-0013-pl-01 FMF Vacuum System Assy Injection Casting Furnace Parts List

July 1986

Changing the World's Energy Future

Doug Porter



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U.S. Department of Energy
Under DOE Idaho Operations Office
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PART NO.	DRAWING NO.	PART NAME OR DESCRIPTION	REMARKS	FOR PURCH. PARTS ONLY
				MATERIAL QTY.
	F3502-0013-FE	FME VACUUM SYSTEM ASSEMBLY-INJECTION CASTING FURNACE		
1	F3502-0020-ED	MANIFOLD	SEE F3502-0020-PL	1
2	F3502-0015-EB	ADAPTER PLATE, ACCUMULATOR OUTLET	SEE DRAWING	1
3	F3502-0014-EB	FURNACE, ACCUMULATOR OUTLET	SEE F3502-0014-PL	1
4	F3502-0072-EC	ACCUMULATOR	SEE F3502-0072-PL	1
5	F3502-0077-EC	MANIFOLD BYPASS	SEE F3502-0077-PL	1
6	F3502-0091-EB	TEE, ACCUMULATOR INLET	SEE F3502-0091-PL	1
7	F3502-0082-EB	ADAPTER PLATE, ACCUMULATOR INLET	SEE F3502-0082-PL	1
8	F3502-0078-EC	OUTLET PIPE, RUPTURE DISC	SEE F3502-0078-PL	1

SYM.	CHANGE	BY	CK.	DATE
2	DCN F3502-012			7-22-86
1	DCN F3502-014			7-25-86

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ASSEMBLY FME VACUUM SYSTEM ASSY INJECTION CASTING FURNACE
APP'D [Signature] CHECKED [Signature] DRAWN [Signature]
ASSEMBLY NO. F3502-0013-PL-02

ANL-146 14-422 ENGINEERING PARTS LIST MICROFILMED 7-31-86(0) 8-19-86(1) 8-27-87(2) 57-8652

PART NO.	DRAWING NO.	PART NAME OR DESCRIPTION	REMARKS	FOR PURCH. PARTS ONLY
				MATERIAL QTY.
	PT#1 CONTINUED FROM SHEET #2	AND MTG HARDWARE, PILOT VALVE JB-834202	PT#1 CONTINUED FROM SHEET #2	
		PILOT AIR SUPPLY 80 PSIG, ELECTRIC 120 VAC, AND LIMIT SWITCH ASSEMBLY (2-DPDT) 8706D	(CV5E)	
		WITH MTG HARDWARE TO ACTUATOR, ALL ASSEMBLED AND TESTED BY MARPAC MARK CONTROLS CORP.		
17		VALVE BALL (3"NPS) MARPAC VALVE N# 3-SS-B-410-RT (CV3E)	MFG STD	1
		0.4EM-C-VV FOR ARGON SERVICE VACUUM-80 PSIG, 200°F, WITH SMOOTH RAISED FACE, GASKET AREA	OR EQUAL	
		125 RMS OR BETTER, TO INCLUDE 97400 ACTUATOR		
		AND MTG HARDWARE, PILOT VALVE JB-834202		
		PILOT AIR SUPPLY 80 PSIG, ELECTRIC 120 VAC, AND LIMIT SWITCH ASSEMBLY (2-DPDT) 8706D WITH MTG HARDWARE TO ACTUATOR, ALL ASSEMBLED AND TESTED BY MARPAC MARK CONTROLS CORP.		
18		VALVE BALL (4"NPS) MARPAC VALVE N# 4-SS-B-410-RT (CV2)	MFG STD	1
		0.4EM-C-VV, FOR ARGON SERVICE VACUUM-80 PSIG, 200°F, WITH SMOOTH RAISED FACE, GASKET AREA	OR EQUAL	
		PT#20 CONTINUED ON SHEET #4		

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PART NO.	DRAWING NO.	PART NAME OR DESCRIPTION	REMARKS	FOR PURCH. PARTS ONLY
				MATERIAL QTY.
9	F3502-0093-EC	EXHAUST PIPE, RUPTURE DISC	SEE F3502-0093-PL	1
10	F3502-0076-EC	INLET PIPE, VACUUM PUMP	SEE F3502-0076-PL	1
11	F3502-0071-EB	INLET ELBOW, VACUUM PUMP	SEE F3502-0071-PL	1
12	F3502-0070-EB	OUTLET ELBOW, VACUUM PUMP	SEE F3502-0070-PL	1
13	F3502-0067-EC	OUTLET PIPE, VACUUM PUMP	SEE F3502-0067-PL	1
14	F3502-0077-EC	EXHAUST PIPE	SEE F3502-0077-PL	1
15		VALVE, SHUT-OFF, 1/4 O.D. TUBE TO 1/8 NPT IMPERIAL-EASTMAN N# 101-ET	OR EQUAL	1
16		VALVE BALL (3"NPS) MARPAC VALVE N# 3-SS-B-410-RT (CV5E)	MFG STD	1
		0.4EM-C-VV FOR ARGON SERVICE VACUUM-80 PSIG, 200°F, WITH SMOOTH RAISED FACE, GASKET AREA	OR EQUAL	
		125 RMS OR BETTER TO INCLUDE 97400 ACTUATOR	PT#1 CONTINUED ON SHEET #3	

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PART NO.	DRAWING NO.	PART NAME OR DESCRIPTION	REMARKS	FOR PURCH. PARTS ONLY
				MATERIAL QTY.
	PT#10 CONTINUED FROM SHEET #3	125 RMS OR BETTER, TO INCLUDE BEITIS CB 525	PT#10 CONTINUED FROM SHEET #3	
		ACTUATOR AND MTG HARDWARE, PILOT VALVE JB-834202, PILOT AIR SUPPLY 80 PSIG, ELECTRIC 120 VAC AND LIMIT SWITCH ASSEMBLY (2-DPDT) 37022 HFC WITH MOUNTING HARDWARE TO BEITIS CB ACTUATOR. VALVE MUST OPERATE FROM CLOSED TO FULL OPEN IN .75 SEC. OR LESS. ALL ASSEMBLED AND TESTED BY MARPAC MARK CONTROLS CORP.	(CV2)	
19		VALVE BALL (4"NPS) MARPAC VALVE N# 4-SS-B-410-RT (FCV2)	MFG STD	1
		0.4EM-C-VV FOR ARGON SERVICE VACUUM-80 PSIG, 200°F, WITH SMOOTH RAISED FACE, GASKET AREA	OR EQUAL	
		125 RMS OR BETTER		
20		VALVE BALL (2"NPS) MARPAC VALVE N# 2-SS-B-410-RT (CV4E)	MFG STD	1
		0.4EM-C-VV FOR ARGON SERVICE VACUUM-80 PSIG, 200°F, WITH SMOOTH RAISED FACE OR FLAT FACE.	OR EQUAL	
		GASKET AREA 125 RMS OR BETTER, TO INCLUDE 87400 ACTUATOR WITH MTG HARDWARE, 1000PSI	PT#20 CONTINUED ON SHEET #5	

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