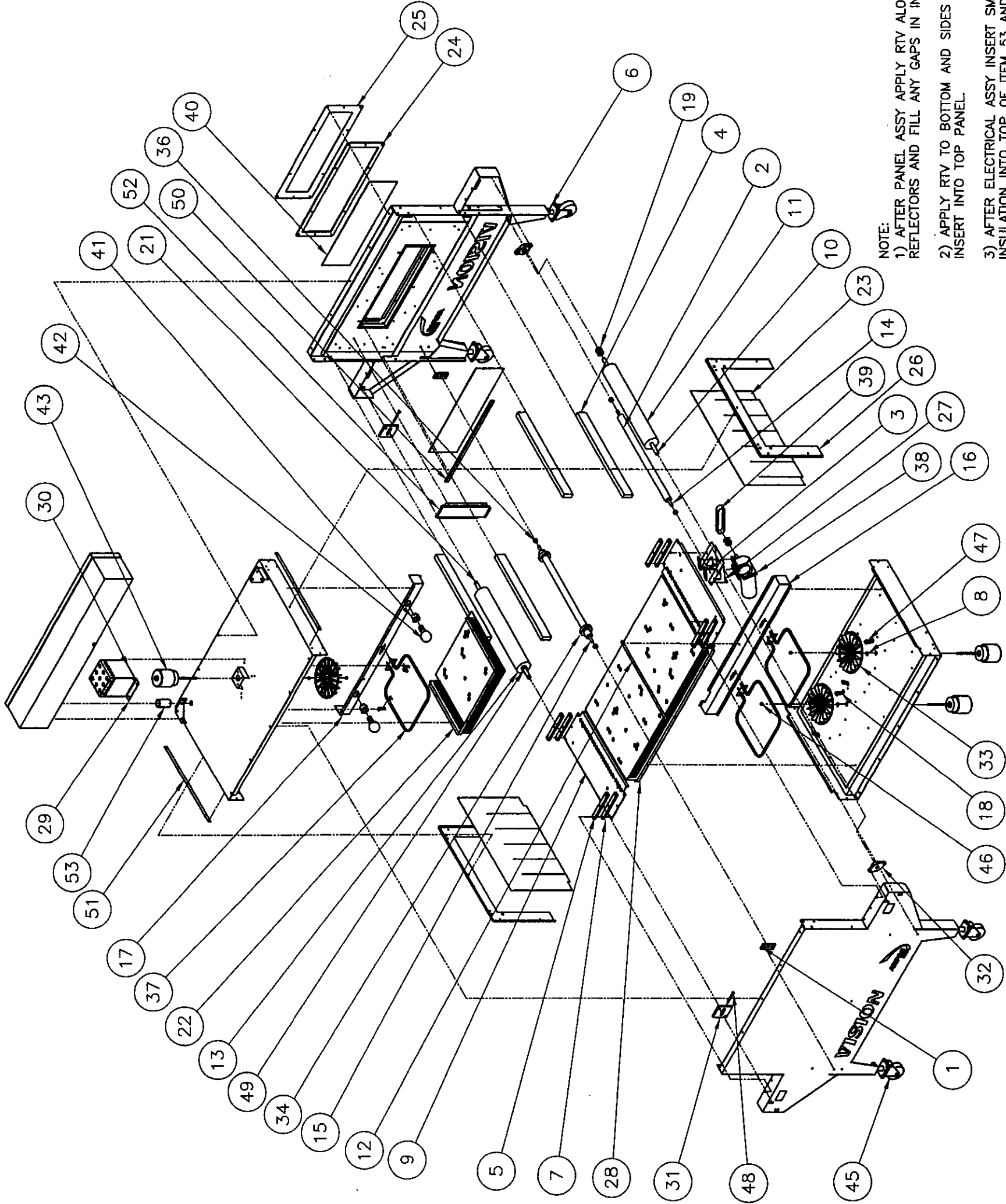
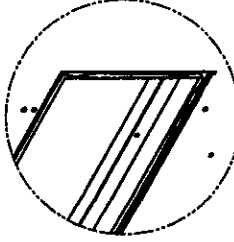
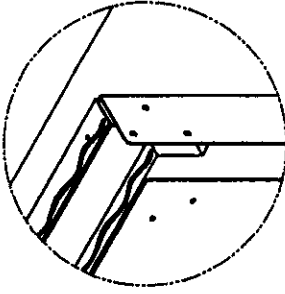


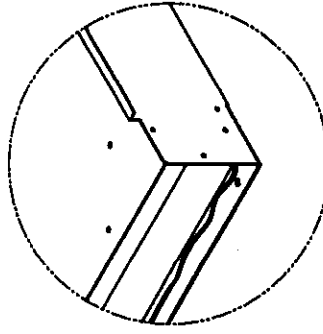
APPLY BEAD OF RTV ALL AROUND INNER PART OF FRAME AS SHOWN AFTER BOLTING PIECES TOGETHER. INSERT GLASS AND PRESS DOWN SO THAT GLASS IS BELOW EDGE OF FRAME.



APPLY BEAD OF RTV ALL AROUND ON INSULATION AREA AS SHOWN. INSERT GLASS AND FASTEN WITH TOP BRACKET (ITEM 50).



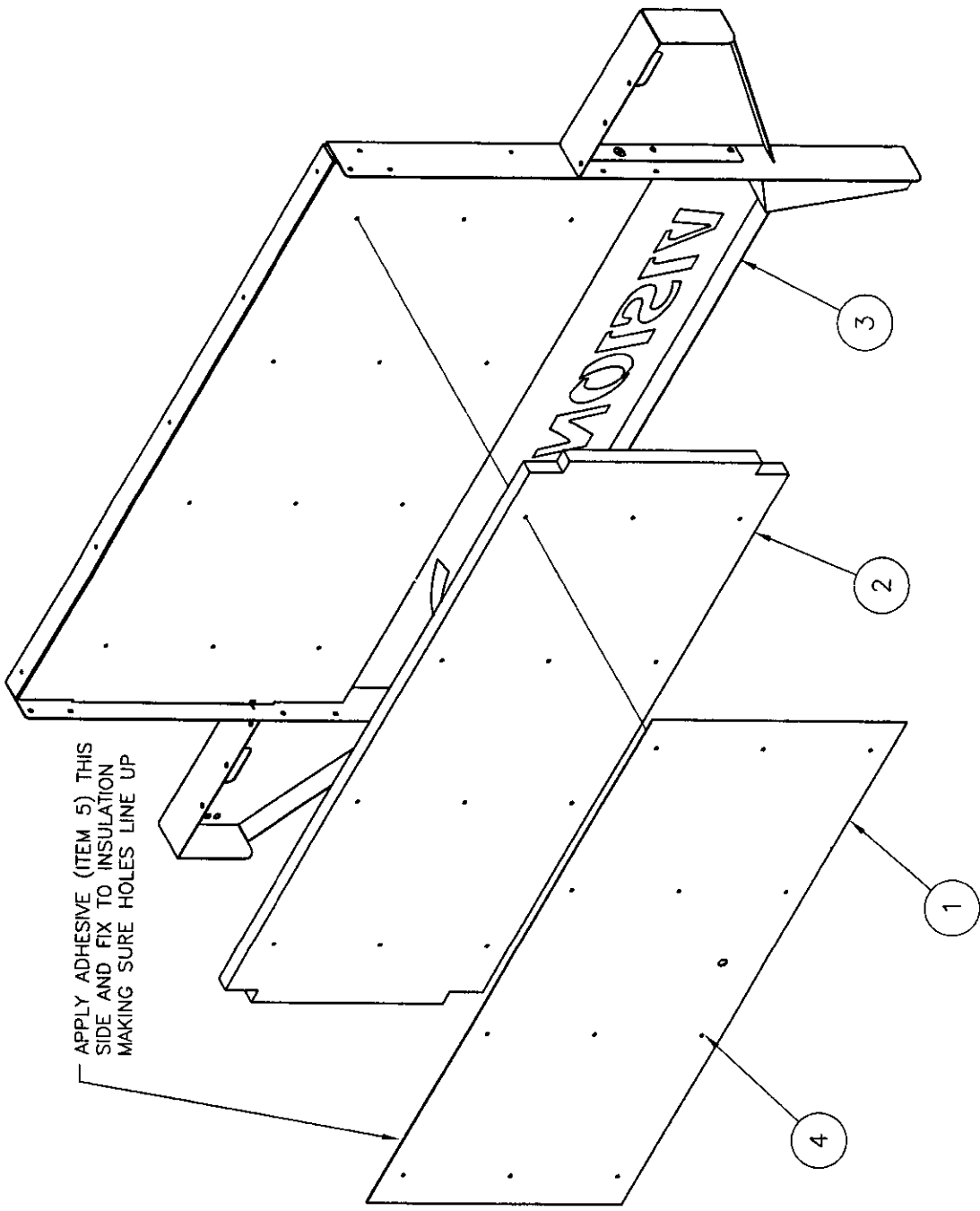
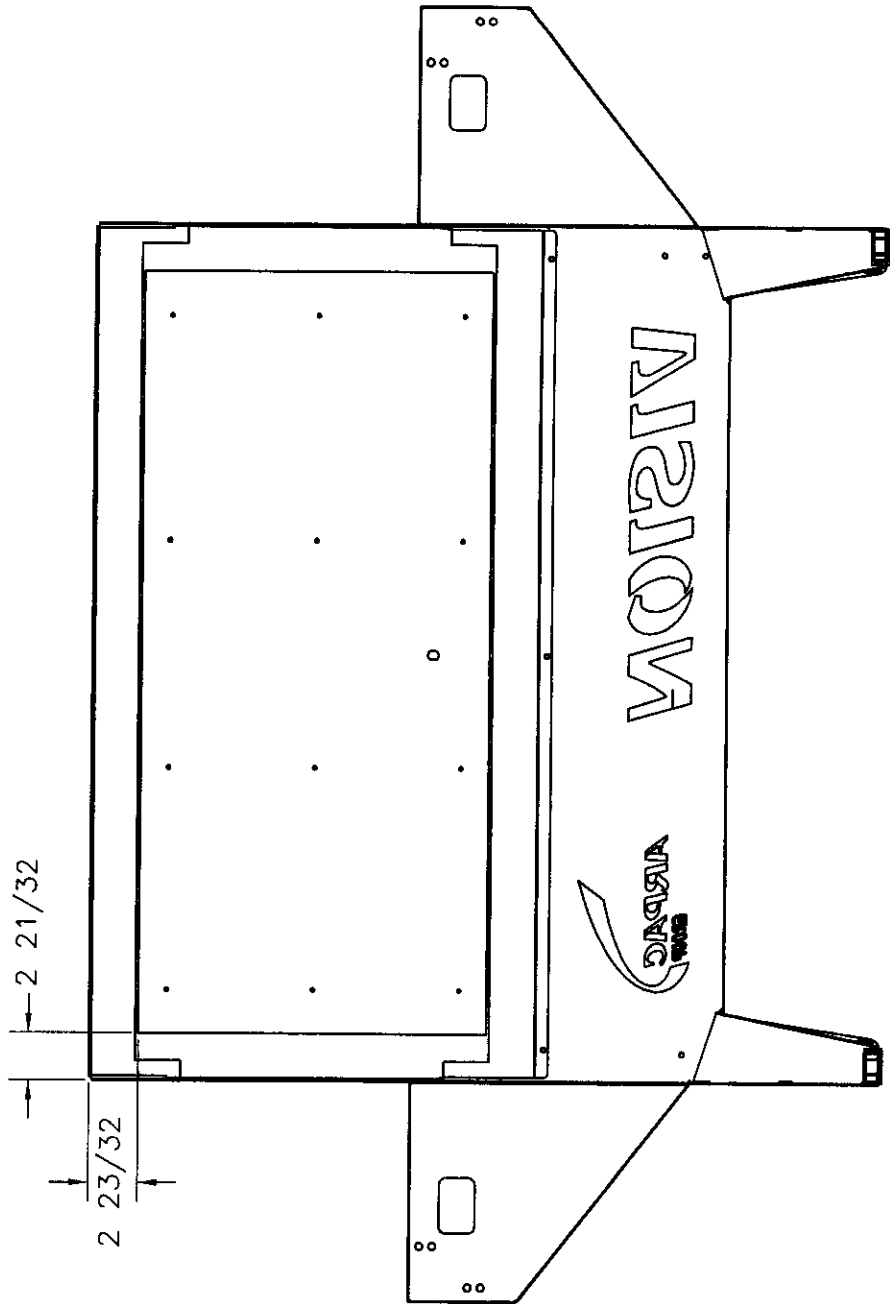
APPLY BEAD OF RTV ALL ALONG TOP OF INSULATION AND TOP OF PANEL INWARD FROM SCREW HOLES AS SHOWN BEFORE BOLTING PANELS TOGETHER.



APPLY BEAD OF RTV ALL ALONG TOP OF PANEL FLANGE INWARD FROM SCREW HOLES AS SHOWN BEFORE BOLTING PANELS TOGETHER.

- NOTE:
- 1) AFTER PANEL ASSY APPLY RTV ALONG CORNERS OF REFLECTORS AND FILL ANY GAPS IN INSULATION.
 - 2) APPLY RTV TO BOTTOM AND SIDES OF ITEM 53 AND INSERT INTO TOP PANEL.
 - 3) AFTER ELECTRICAL ASSY INSERT SMALL PIECE OF INSULATION INTO TOP OF ITEM 53 AND SEAL WITH RTV.
 - 4) CONNECT WIRES TO HEATING ELEMENTS AND POSITION CONNECTORS SO THAT THEY FIT THROUGH SLOT AND ELEMENTS CAN BE REMOVED WITHOUT TAKING OUT WIRE CHANNELS.

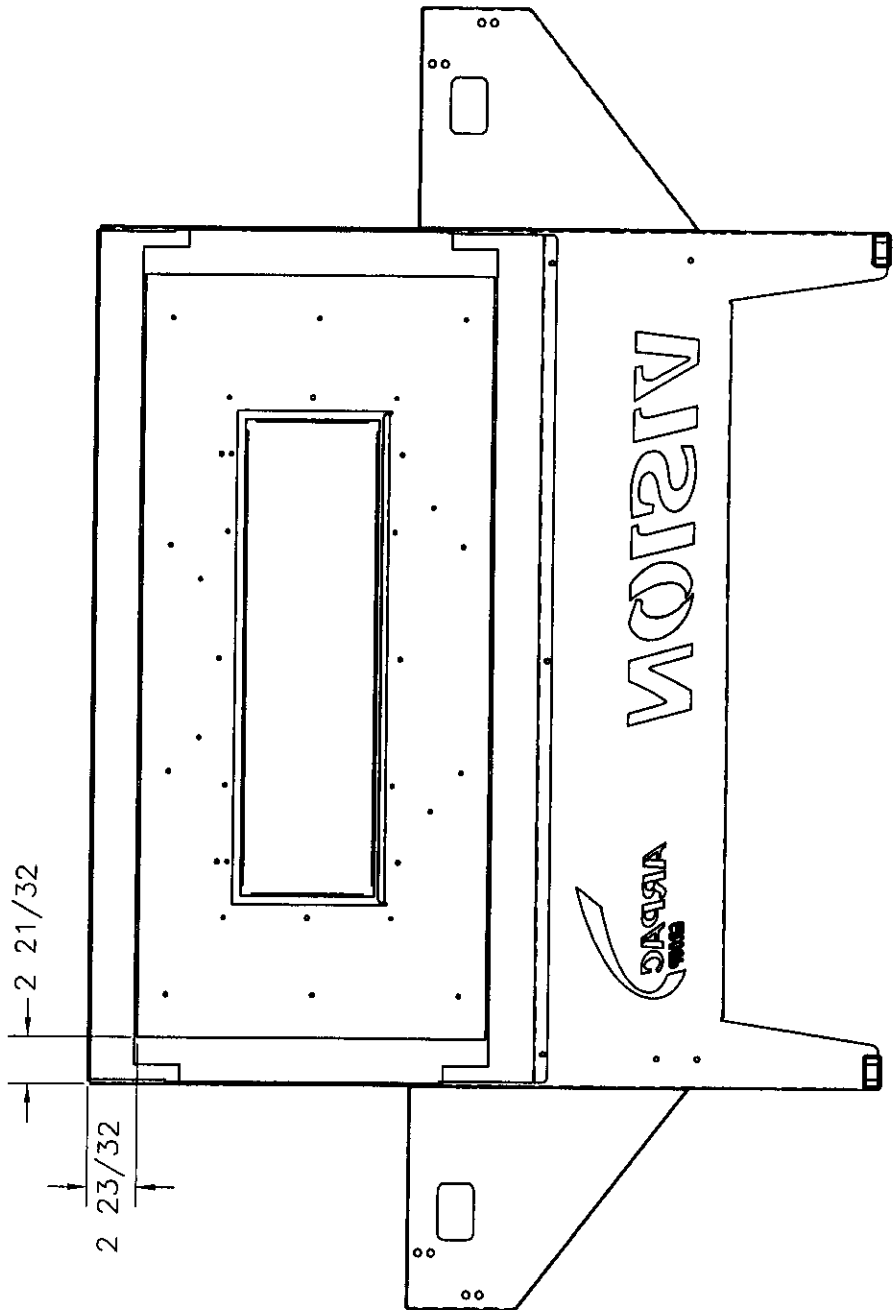
ARPAC		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED	FRACTIONS	1/16	
ALL DIMENSIONAL TOLERANCES:	TWO (2) DECIMALS	±0.010	
	THREE (3) DECIMALS	±0.005	
	ANGLES	±0.5°	
DRAWN: 7-14-05	BY: DCC	SCALE: N/A	SIZE: B
RELEASED: 7-14-05	FILENAME: 232032	APPROVED BY: DCC	
DESCRIPTION: ASSY, TUNNEL, VT122248			
DRAWING NUMBER: 232032			



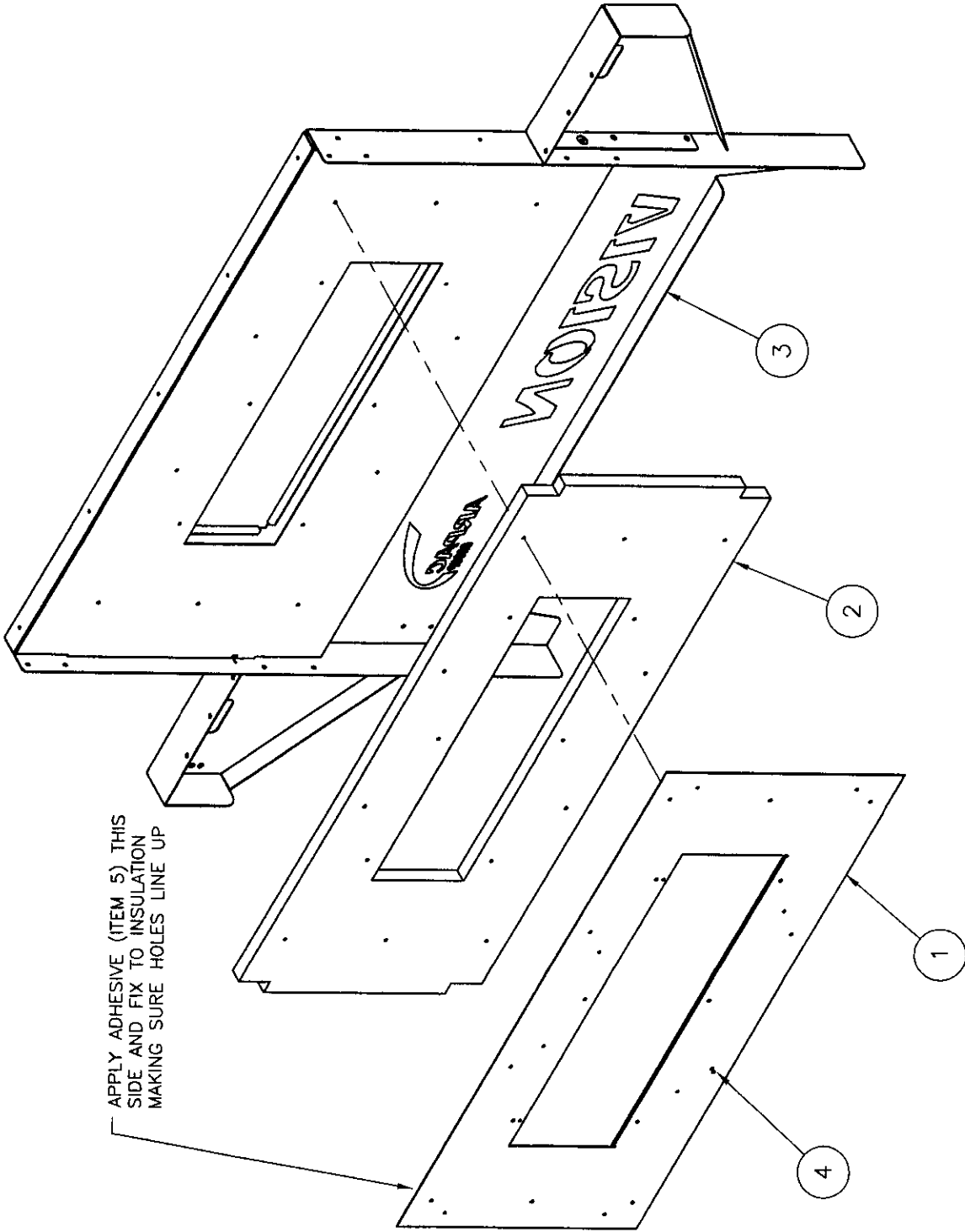
FINISH- NONE

ARPAC	9511 WEST RIVER ST. SCHILLER PARK, IL 60176						
	UNLESS OTHERWISE SPECIFIED	FRACTIONS					
	TWO (2) DECIMALS	± 1/64					
	THREE (3) DECIMALS	± 0.010					
ALL DIMENSIONAL TOLERANCES:		ANGLES	± 0.005				
DRAWN:	4-14-05	BY:	DCC	SCALE:	3/32"=1"	SIZE:	B
RELEASED:	4-14-05	FILENAME:	232011	APPROVED BY:	DCC		
DESCRIPTION:							
ASSY, PANEL, SIDE							
VT12XX48							
DRAWING NUMBER: 232011							

ITEM	QTY	PART NUM	DESCRIPTION
5	1	823268	ADHESIVE, HIGH-TEMP
4	12	817224	FSNR, RIVET, BLIND, 5 X 40
3	1	232010	WLDMT, PANEL, SIDE
2	1	232009	INSULATION, SIDE
1	1	232008	REFLECTOR, SIDE
BILL OF MATERIAL			



APPLY ADHESIVE (ITEM 5) THIS
SIDE AND FIX TO INSULATION
MAKING SURE HOLES LINE UP



FINISH- NONE

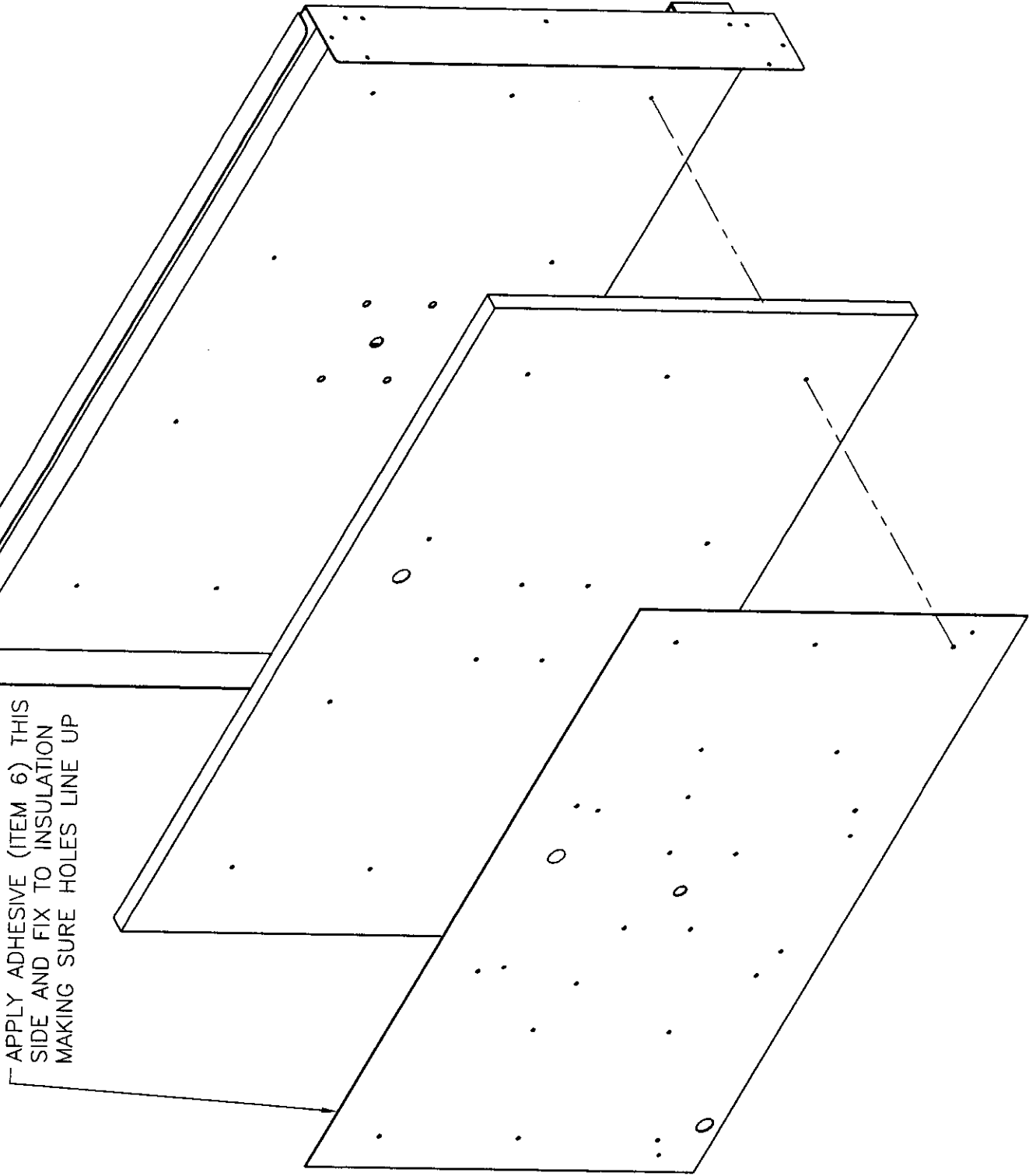
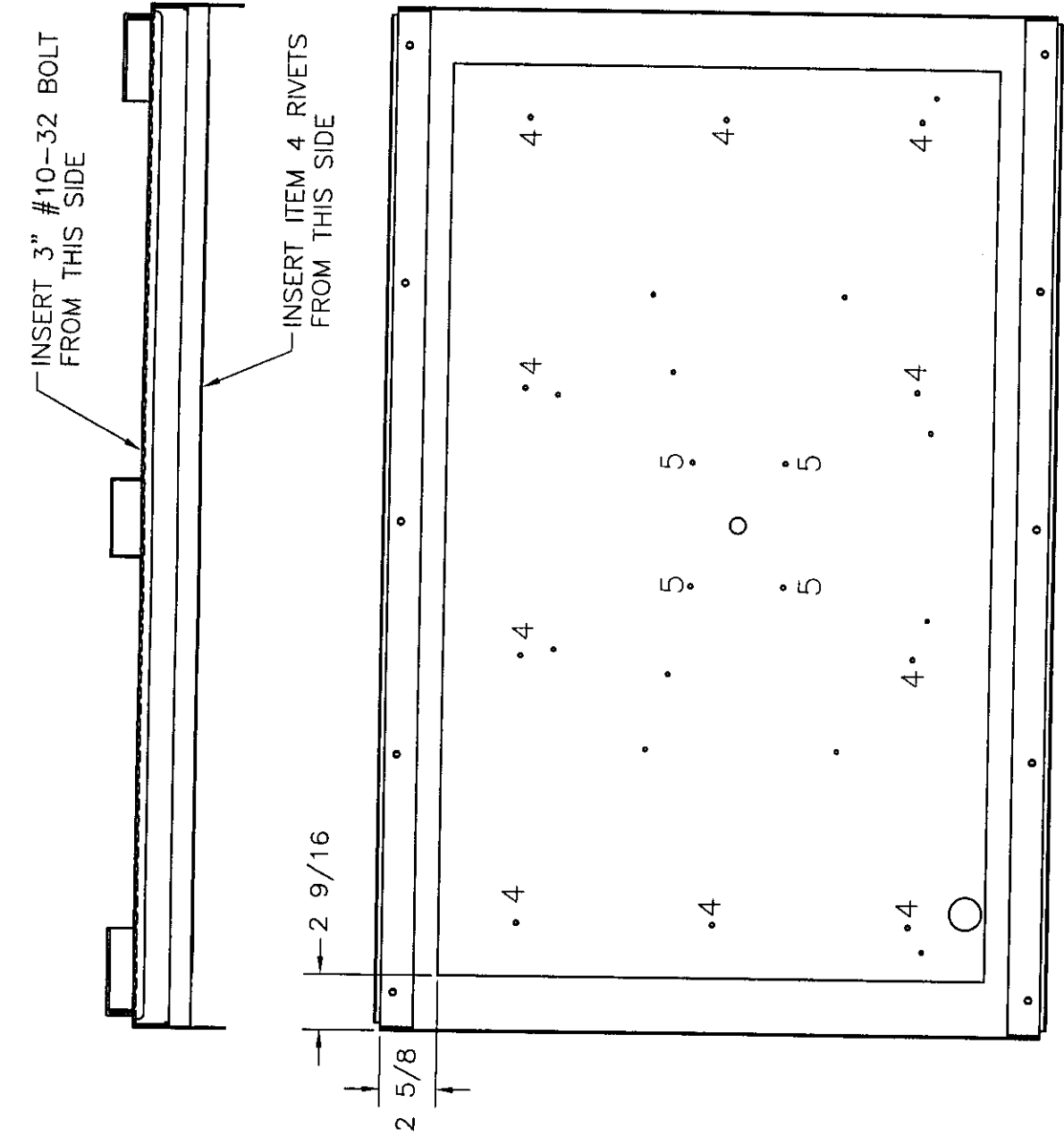
ITEM	QTY	PART NUM	DESCRIPTION
5	1	823268	ADHESIVE, HIGH TEMP.
4	12	817224	FSNR, RIVET, BLIND, 5 X 40
3	1	232020	WLDMT, PANEL, SIDE, WINDOW
2	1	232019	INSULATION, SIDE, WINDOW
1	1	232018	REFLECTOR, SIDE, WINDOW

BILL OF MATERIAL

ARPAC

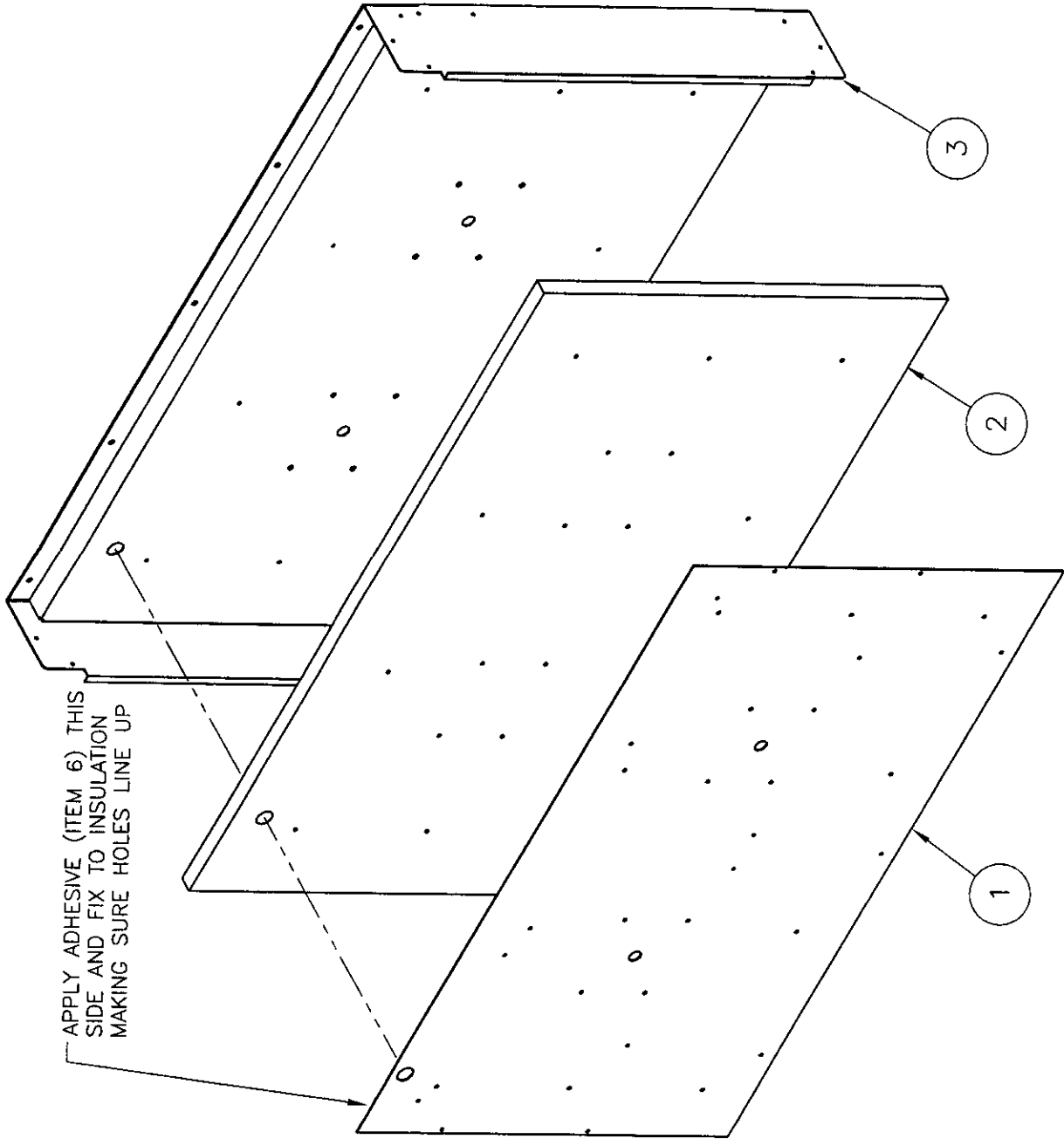
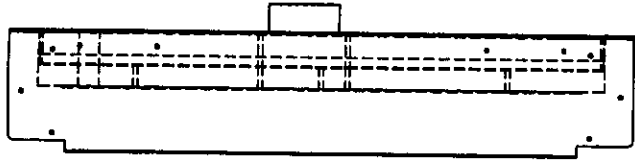
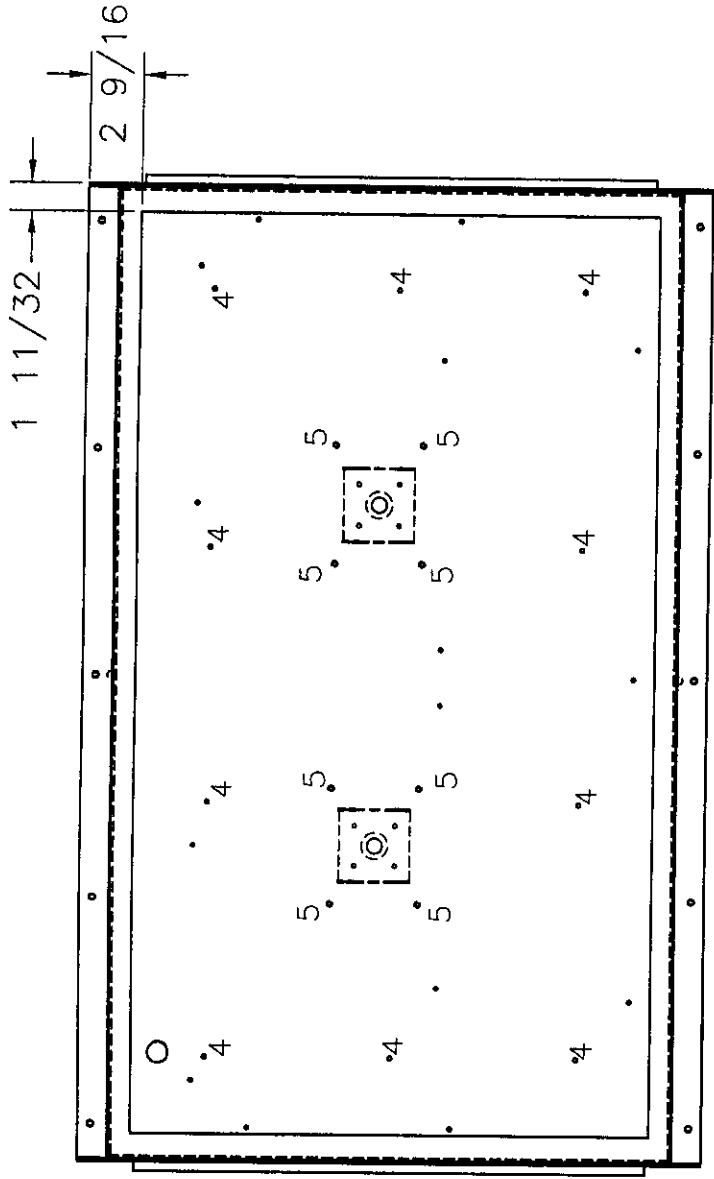
9511 WEST RIVER ST.
SCHILLER PARK, IL 60176

UNLESS OTHERWISE SPECIFIED ALL DIMENSIONAL TOLERANCES:	FRACTIONS TWO (2) DECIMALS THREE (3) DECIMALS ANGLES	± .004 ± .0010 ± .005
DRAWN: 4-14-05	BY: DCC	SCALE: 3/32"=1" SIZE: B
RELEASED: 4-14-05	FILENAME: 232021	APPROVED BY: DCC
DESCRIPTION: ASSY, PANEL, SIDE, WINDOW		
VT12XX48		
DRAWING NUMBER: 232021		



ARPAC		9511 WEST RIVER ST. SCHILLER PARK, IL 60176	
UNLESS OTHERWISE SPECIFIED		FRACTIONS	
ALL DIMENSIONAL TOLERANCES:		TWO (2) DECIMALS ± 0.010	
		THREE (3) DECIMALS ± 0.005	
		ANGLES ± 0.5°	
DRAWN:	4-12-05	BY:	DCC
RELEASED:	4-12-05	FILENAME:	231998
DESCRIPTION:		SCALE:	1/8"=1" SIZE: B
		APPROVED BY:	DCC
		ASSY, PANEL, TOP	
		VTXX2248	
		DRAWING NUMBER:	
		231998	

6	1	823268	ADHESIVE, HIGH TEMP
5	4	800246.003	FNSR, BOLT, #10-32 X 3" LG BL. OX.
4	10	817224	FNSR, RIVET, BLIND, 5X40, AL
3	1	231995	REFLECTOR, TOP
2	1	231997	INSULATION, PANEL, TOP
1	1	231996	WLDMT, PANEL, TOP
ITEM	QTY	PART NUM	DESCRIPTION
BILL OF MATERIAL			



INSERT ITEM 4 RIVETS
FROM THIS SIDE

INSERT ITEM 5 SCREWS
FROM THIS SIDE

6	.1	823268	ADHESIVE, HIGH-TEMP
5	4	800246.003	FSNR, BOL, #10-32 X 3" LG BLA, OX
4	10	817224	FSNR, RIVET, BLIND, 5X40, AL
3	1	232003	WDMT, PANEL, LWR
2	1	232002	INSULATION, LWR
1	1	232001	REFLECTOR, LWR
ITEM	QTY	PART NUM	DESCRIPTION

BILL OF MATERIAL

ARPAC 9511 WEST RIVER ST.
SCHILLER PARK, IL 60176

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONAL TOLERANCES:
FRACTIONS ±.164
TWO (2) DECIMALS ±.010
THREE (3) DECIMALS ±.005
ANGLES ±0.5°

DRAWN: 4-13-05 BY: DCC SCALE: NONE SIZE: B
RELEASED: 4-13-05 FILENAME: 232004 APPROVED BY: DCC

DESCRIPTION: ASSY, PANEL, LWR

VTXX2248

DRAWING NUMBER: 232004