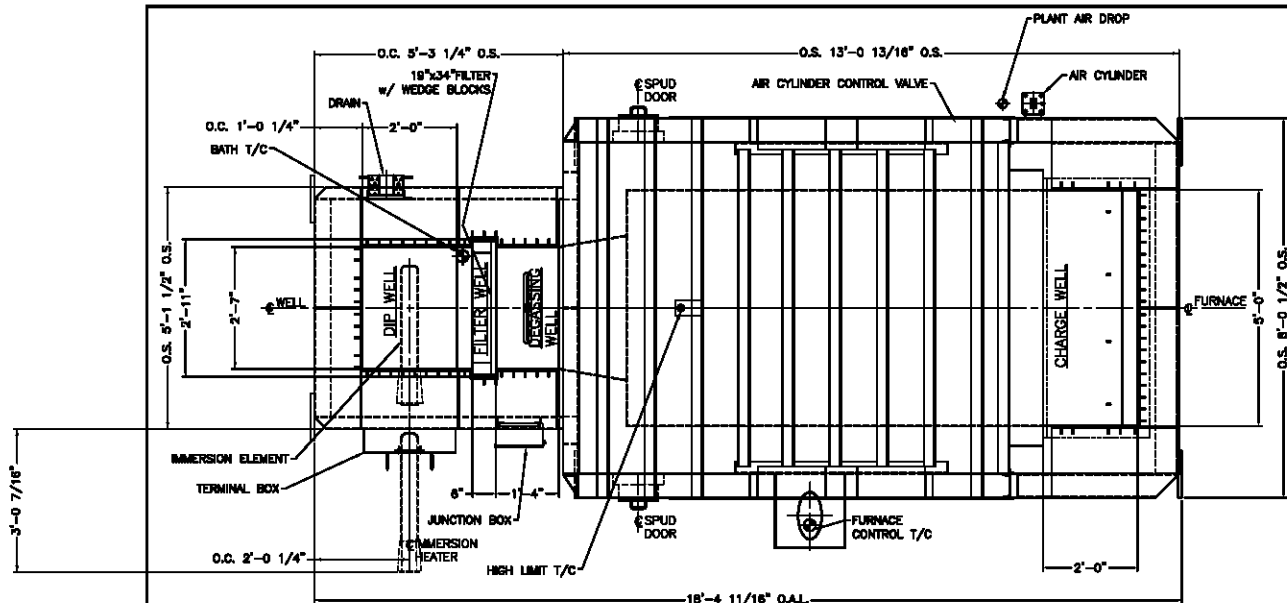
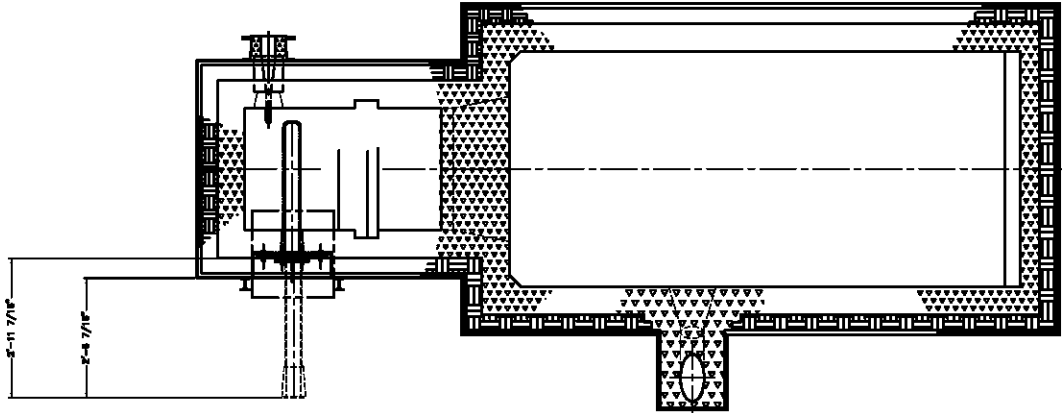
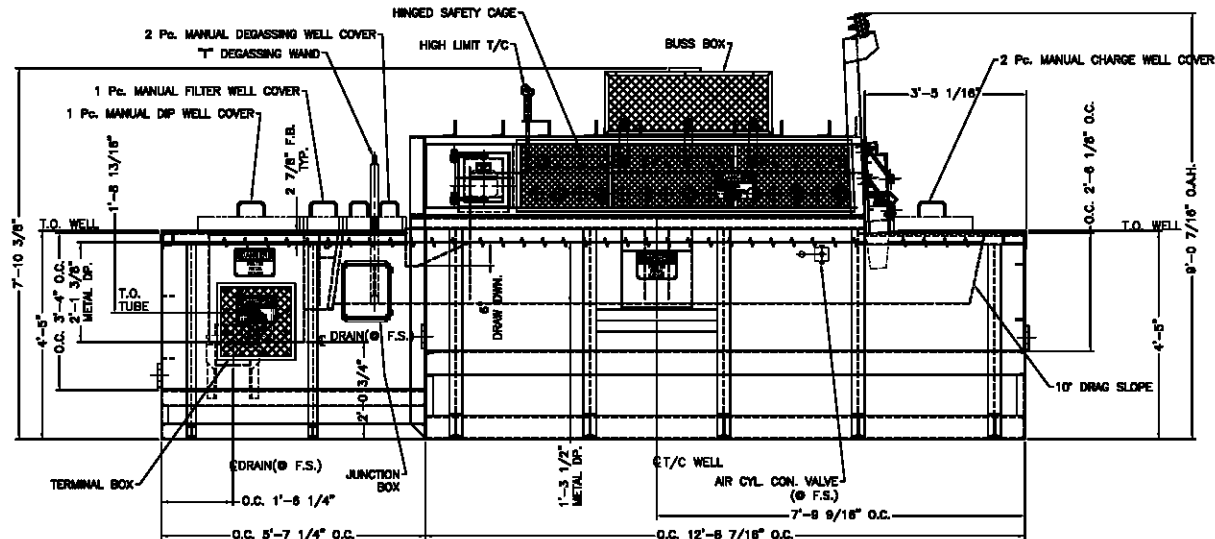




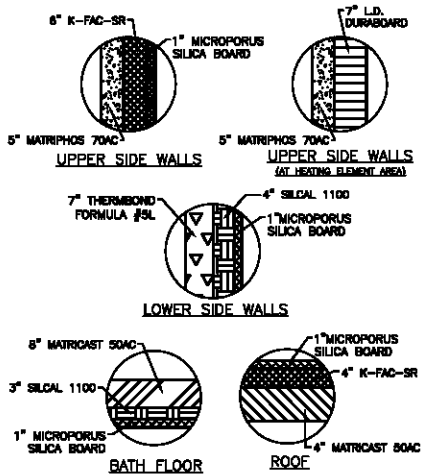
PLAN VIEW



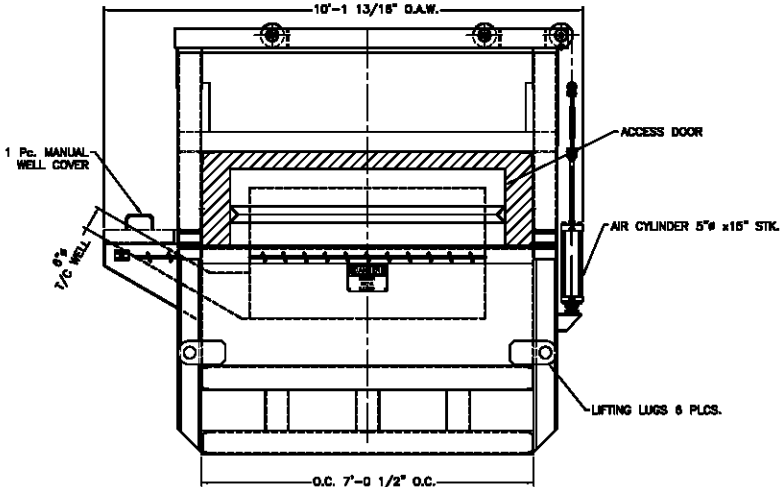
SIDE VIEW

- *NOTES:
1. MOLTEN METAL CAPACITIES BASED ON .089p.c.i. (154p.c.i.) FOR THE WGT. OF ALUMINUM.
 2. 6" OF DRAW DOWN YIELDS 4.250# TAKE OUT.

ACCEPTANCE			
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REFRACTORY DETAILS



END VIEW

#	DESCRIPTION	DATE	APPROVED
1	MIRROR DRUM HEATER & JCT. BOX	9-27-10 JMW	
2	ADD NOTE #2		
3	UPDATED REFRACTORY CALL-OUTS	10-16-10 DMB	
4	MOVE JCT. BOX	11-18-10 JMW	

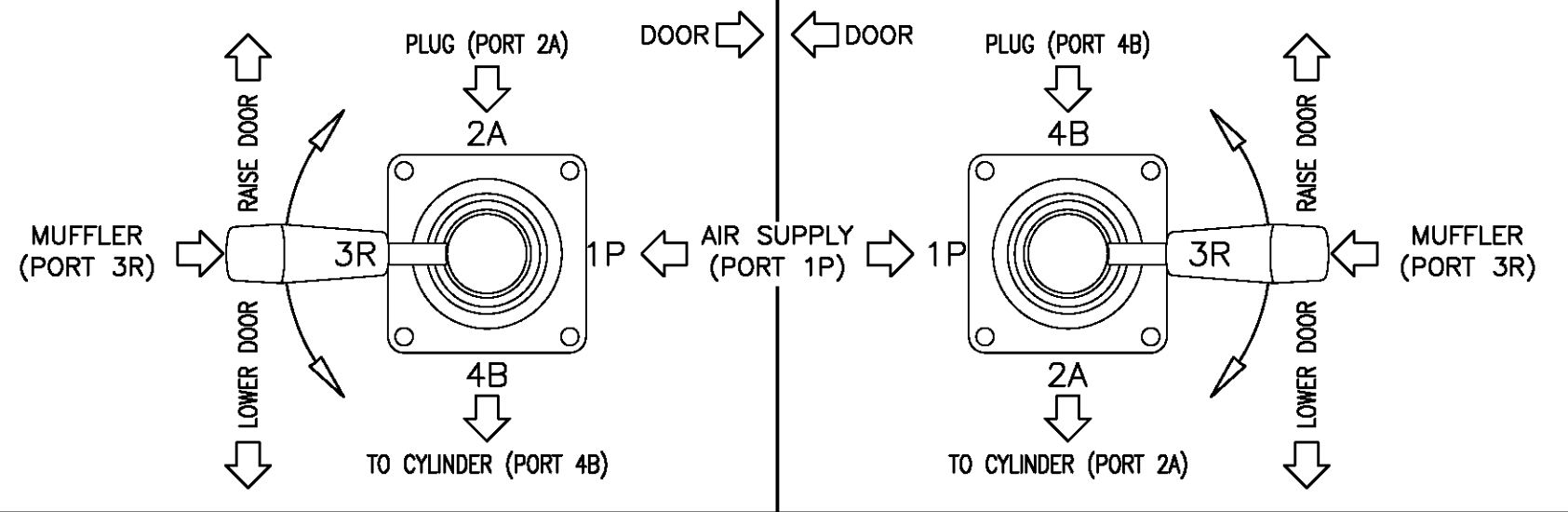
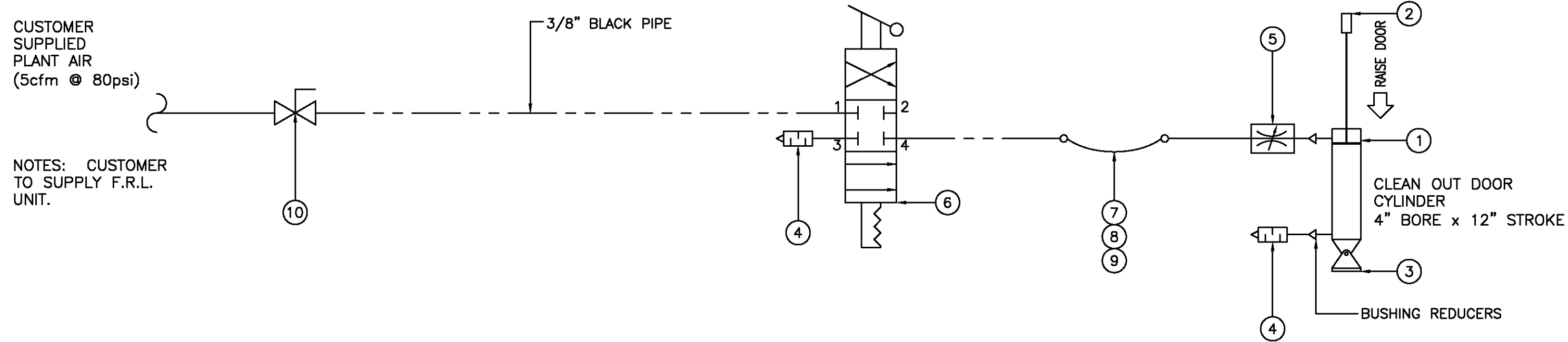


SCHAEFER FURNACES
1007-0710-0054
NEW JERSEY 0710-0054

Schaefer Furnaces
A Division Of The Schneider Group, Inc.
SCHAEFER FURNACES
2000 CONSTRUCTION • INSULATING
DIVISION, 6000 6000
GIBBS DIE CAST
HENDERSON, KY

RECORD	PAGE
10-0054-0	1

BILL OF MATERIAL		
NO.	QTY	DESCRIPTION
1	1	J12-33-B1-5"x 12" Norgren air cylinder 5" bore 12" Stk
2	1	49030A Norgren Rod Clevis W/Standard Pin
3	1	49020A Norgren Eye Bracket 3/4 Pin Hole
4	1	MS003A Norgren sintered bronze muffler 3/8 NPT
5		N800B Parker Flow Control Valve or equivalent
6	1	VHLA300-03 Norgren manual pneumatic valve 3/8 NPT
7	1	9190608-6-6-6-15 3/8 x15 Long pneumatic hose, steel braid cover, female swivel JIC fittings
8	1	2404-06-06 3/8 male JIC to 3/8 male NPT
9	1	2405-06-06 3/8 male JIC to 3/8 female NPT
10	1	3/8 NPT self venting ball valve w/safety pad lock



APPROVED

SIGNED _____ DATE _____

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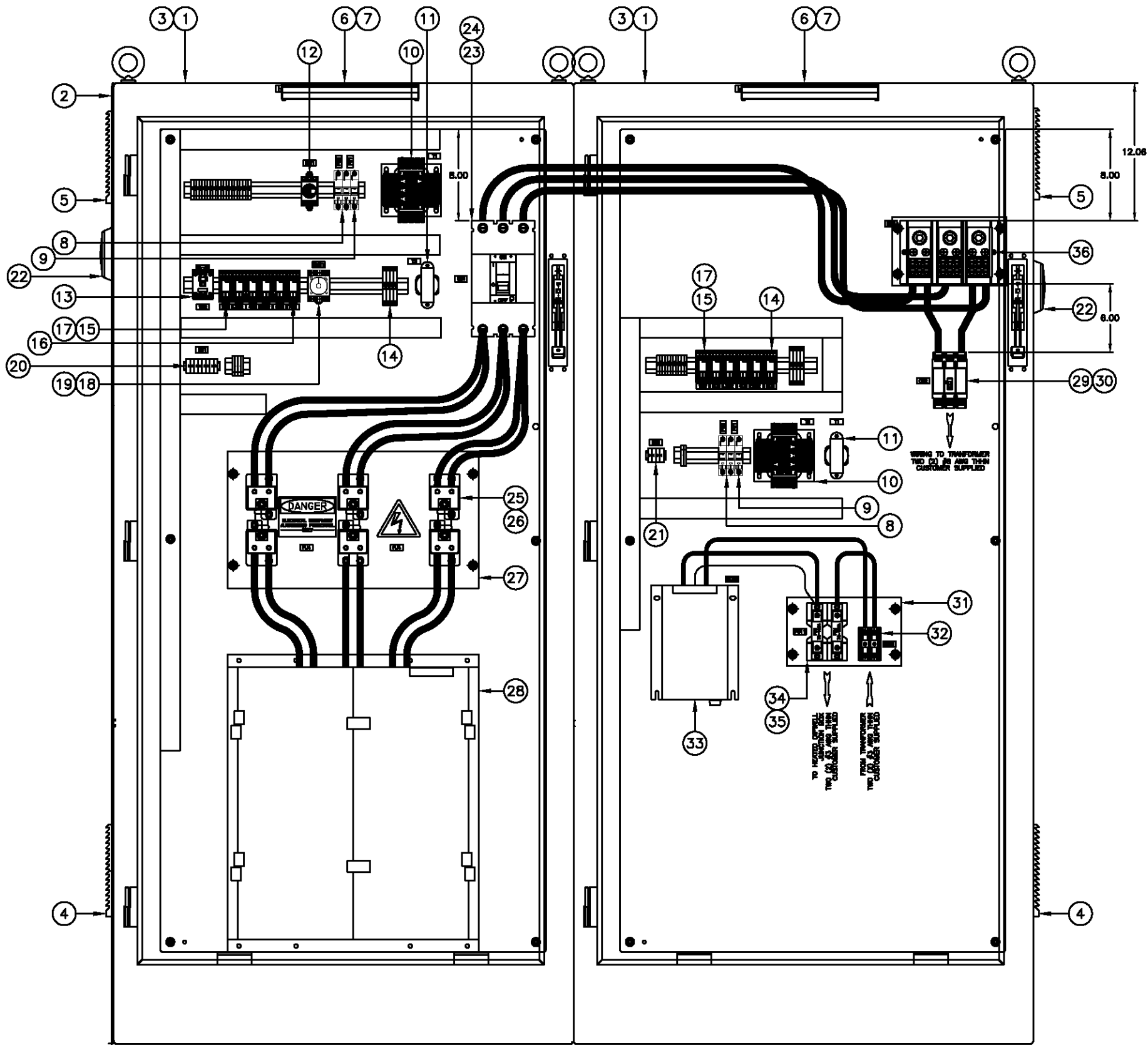
DESCRIPTION
12500/hr Electric
Reverb Furnace
377kVA (325kW)
w/10.5 kW Heated
Dipwell
Electrical Schematic
S.N. 007-0710-0054
QUANTITY
FLEWME
AutoCAD 2000

SCHAEFER FURNACES, INC.
A Division Of The Schaefer Group, Inc.
INDUSTRIAL FURNACES
DESIGN • CONSTRUCTION • INSTALLATIONS
DAYTON, OHIO 45410

Gibbs Die Casting Corp
Henderson Ky

RECORD

SCALE	PAGE 1 of 1
NAME	DATE
DRAWN Joe Goetz	12/20/09
REXED	
No. 10-0054-3A	



BILL OF MATERIAL		
NO.	QTY	DESCRIPTION
1	2	AMOD84X4018FTC Hoffman Type 12 for Flange-Mount Dis
2	1	AMOD8418FEP Hoffman flat end plate
3	2	A21CHVA Hoffman adpt plt for Automation disconnect
4	2	TFP61 Hoffmann cooling fan 140CFM/120VAC .36A
5	2	TEP6 Hoffmann exhaust grill
6	2	ALF16D12R Hoffman Lighting package w/integrally door sw
7	2	F8T5 Florescent light bulb for Hoffman ALF16D12R light
8	2	WMZS2D03 Eaton circuit breaker 2-pole, D trip curve, 3A
9	2	WMZS1B06 Eaton circuit breaker 1-pole, B trip curve, 6A
10	2	E750WB Heavy Duty transformer, 750VA
11	2	P-8357 Stancor transformer 100VA, 120V/24Vac
12	1	SD1-016-RR Automatic Direct Load switch, 16A rating
13	1	700-CF220B A.B. Control Relay, 2NO/2NC 480V 60Hz coil
14	2	MDL-2 Bussmann fuse 2 amp or equal
15	10	700-HC24A1-4 A.B. GP relay, 4PDT, 120VAC, Pilot Light
16	2	700-HC24A2-4 A.B. GP relay, 4PDT, 24VAC, Pilot Light
17	12	700-HN103 A.B. Relay Bases 4PDT
18	1	TP411X Fuji Timer base surface mount
19	1	MS4SM-AP-ADC Fuji Timer multi-mode w/sel tmr range
20	1	IKU6SC Flex-core shorting terminal block 6 pole
21	1	IKU4SC Flex-core shorting terminal block 4 pole
22	2	870 N5 Edwards Alarm Buzzer
23	1	L3P-600-STAC Automatic Direct L frame 600 amp MCCB
24	1	F4S04C Automatic Direct NEMA 1/12 flexible shaft handle
25	3	66031T Ferraz Shawmut fuse Blocks class T fuses
26	3	JJS-600 Bussmann fuse 600 amp
27	1	06-0074-4e Shield 1/4 Plexiglas 12x24
28	1	3629C-V-480V-500A-4/20-IL450 Control Concepts
		3 Phase Phase-Angle SCR power controller, 480V, 500A
29	1	G3P-040 Automatic Direct (MCCB), 40A, 480 VAC, 3-pole
30	1	F0S03C Automatic Direct (MCCB) flex shaft handle
31	1	10-0054-4e Shield 1/4 Plexiglas 6" x 10"
32	1	9080 LBA262101 Square D distribution block 2P 175 amp
33	1	1029C-V-120V-120A-IL68-R4/20mA-I0/5 Control Concepts
		1-Phase Phase-Angle, SCR power controller, 120V, 120A
34	2	T30100 2CR Bussmann or equal fuse block 2 pole 100A
35	2	2 JJJ-100 Bussmann or equal fuse 100 amp
36	1	PDB-24-500-3 Ilaco distribution block (2)500kcmil-4 (4)4/0-6

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DESCRIPTION
1250lb/hr Electric
Reverb Furnace
377kVA (325kW)
w/10.5 kW Heated
Dipwell
Electrical Enclosure
S.N. 007-0710-0054
QUANTITY
FLEWEE
AutoCAD 2000



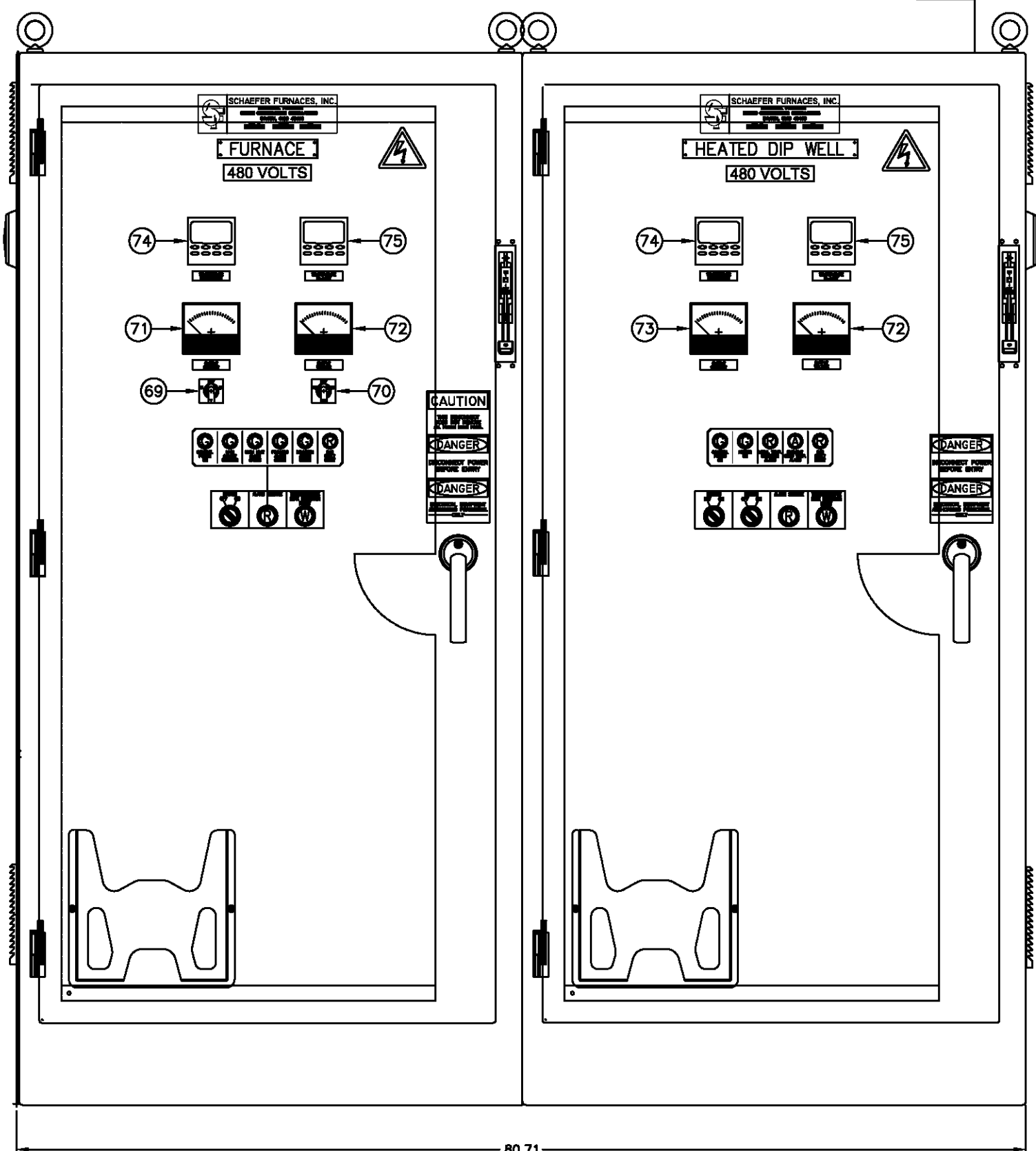
SCHAEFER FURNACES, INC.
A Division Of The Schaefer Group, Inc.
INDUSTRIAL FURNACES
DESIGN • CONSTRUCTION • INSTALLATIONS
DAYTON, OHIO 45410

Gibbs Die Casting Corp
Henderson Ky

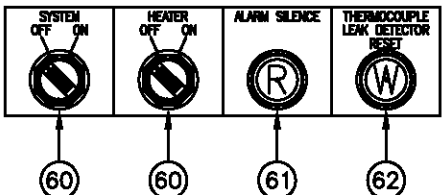
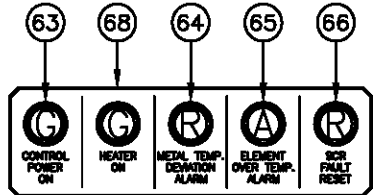
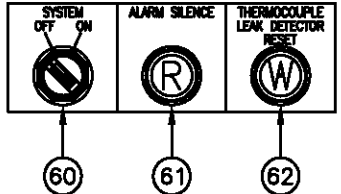
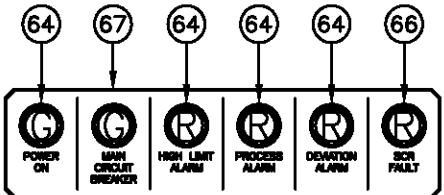
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SCALE	1 of 2
NAME	DATE
DRAWN for goetz CHECKD	08/04/10
No. 10-0054-4-1	

CUSTOMER
480V AC
3 Ph
60 Hz
450 FLA

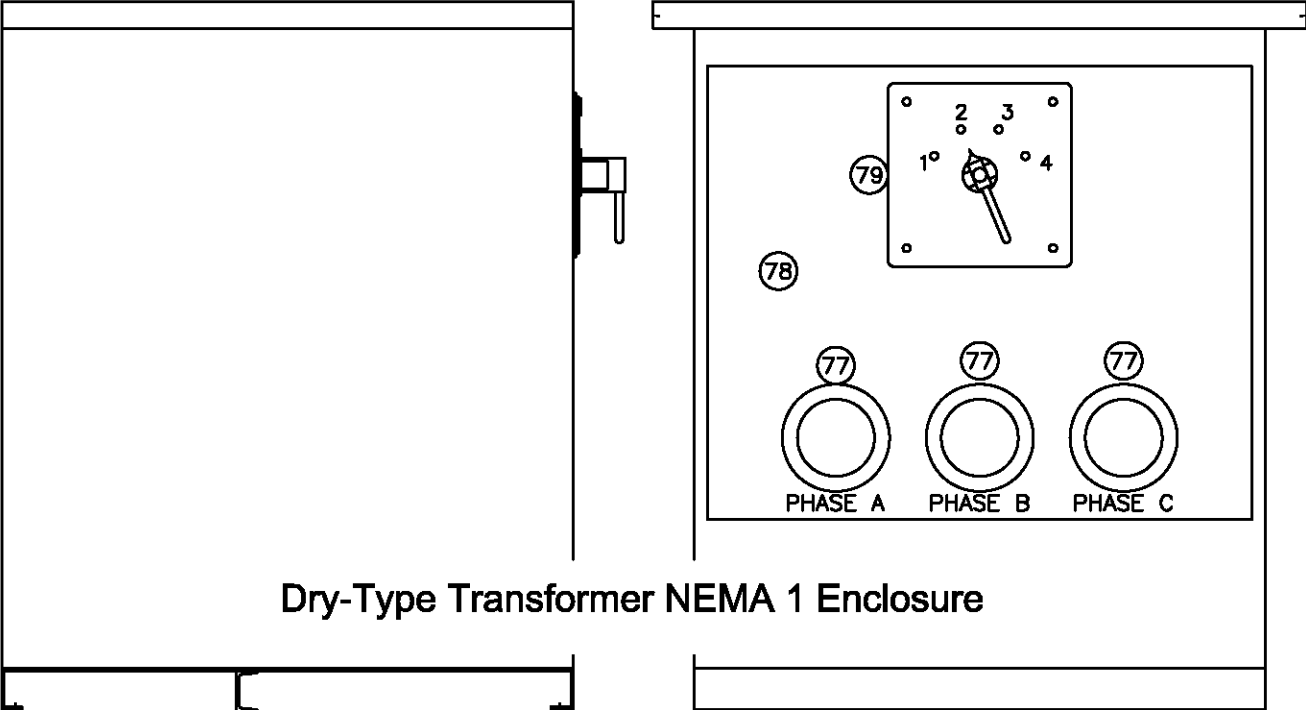
L1
L2
L3



Two (2) Single-Door enclosure for flange-mount disconnect
84.0" (2133.6mm) height x 39.5" (1003mm) width x 18.0" (457mm) depth



BILL OF MATERIAL		
NO.	QTY	DESCRIPTION
60	3	800T H2A A.B. Selector Switch
61	2	800T PB16R A.B. III. Push Button (red)
62	2	800T QB24W A.B. III. Push Button (white 24vdc)
63	4	HW4P-1FQD-G120 IDEC 22mm pilot light (green)
64	4	HW4P-1FQD-R120 IDEC 22mm pilot light (red)
65	1	HW4P-1FQD-R120 IDEC 22mm pilot light (red)
66	2	HW4L-M1F10QDR120V IDEC 2mm ill PB (red), 120V,
67	1	09-0070-4f Custom legend plate see drawing
68	1	10-0054-4f Custom legend plate see drawing
69	1	CS42325-G16-L22LBBZ9325 C3 controls Switches : Ammeter
70	1	CS41312-G16-L22LBBZ9312 C3 controls Switches : Voltmeter
71	1	CLE8-A4A152 Flex-Core AC Ammeter, 0-1500 Amps
72	2	CLE8-V4A300 Flex-Core AC Voltmeter, 0-300 AC Volts
73	1	CLE8-A4A151 Flex-Core AC Ammeter, 0-150 Amps
74	1	DC3200-CE-000R-100-00000-00-0 Temperature Controller
75	1	DC2500-E0-0L00-100-10000-00-0 Temperature High Limit
76	1	-
77	1	19RL-152 Flex-Core Current transformers, 1500:5
78	1	AFP Transformer 325kW, (377kVA) 480V-3Ph-60Hz
79	1	RS3-804-AM155928 RoMan 4 pos tap switch,
46	1	AFP Transformer 325kW, (377kVA) 480V-3Ph-60Hz
47	1	58-151 Flex-core Current Transformer, 150:5 Ratio



Dry-Type Transformer NEMA 1 Enclosure

APPROVED

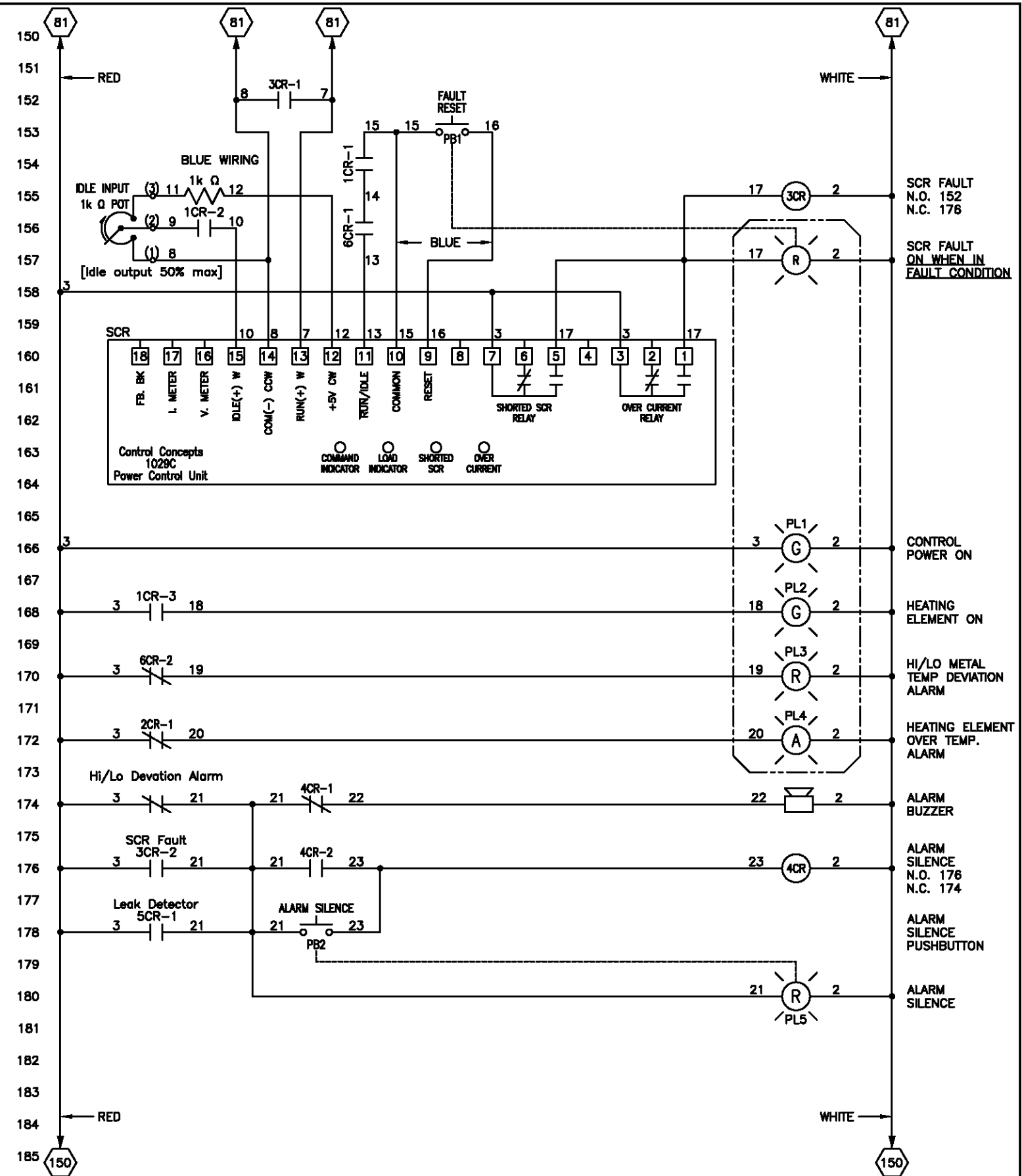
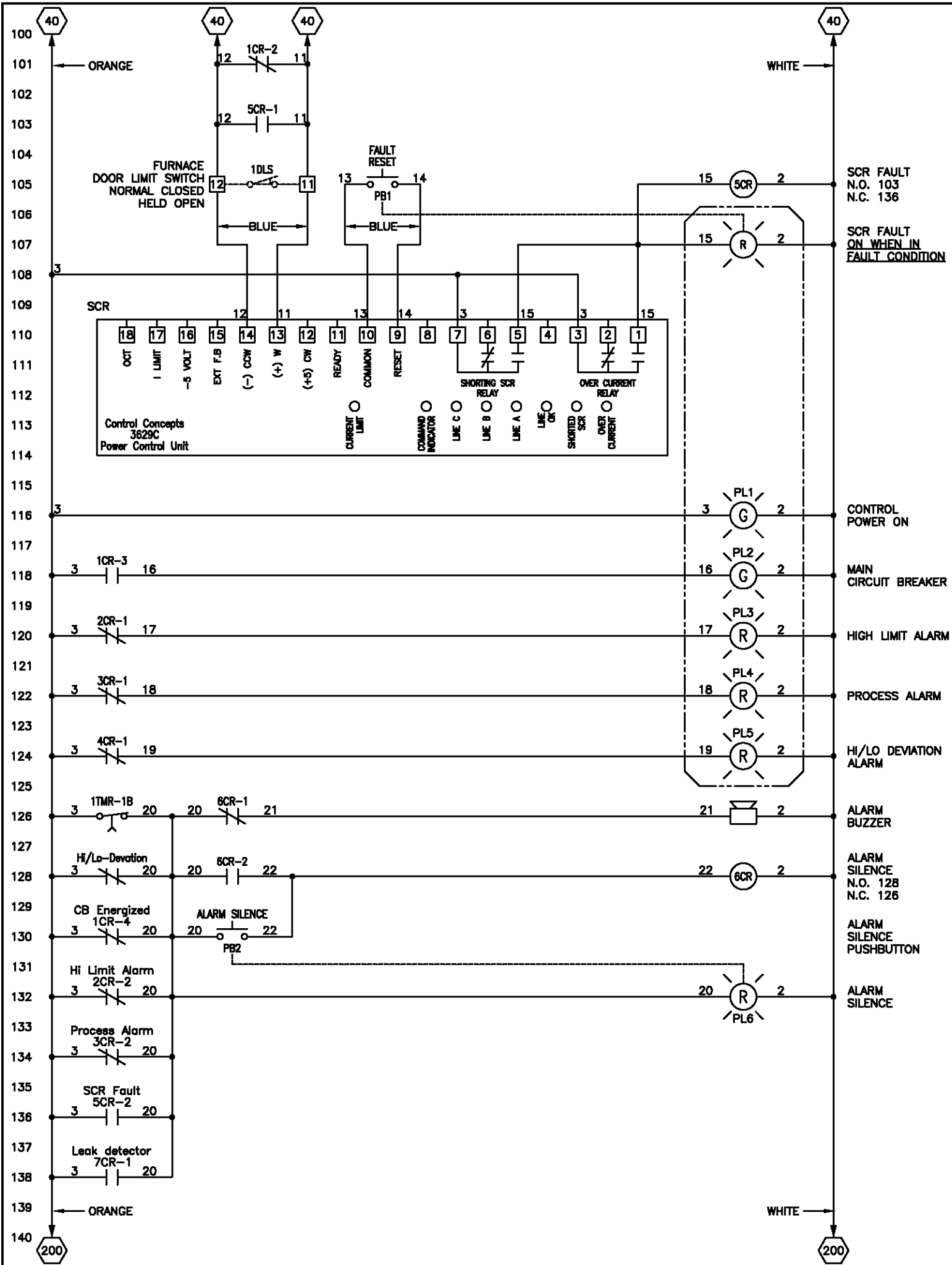
SIGNED _____ DATE _____

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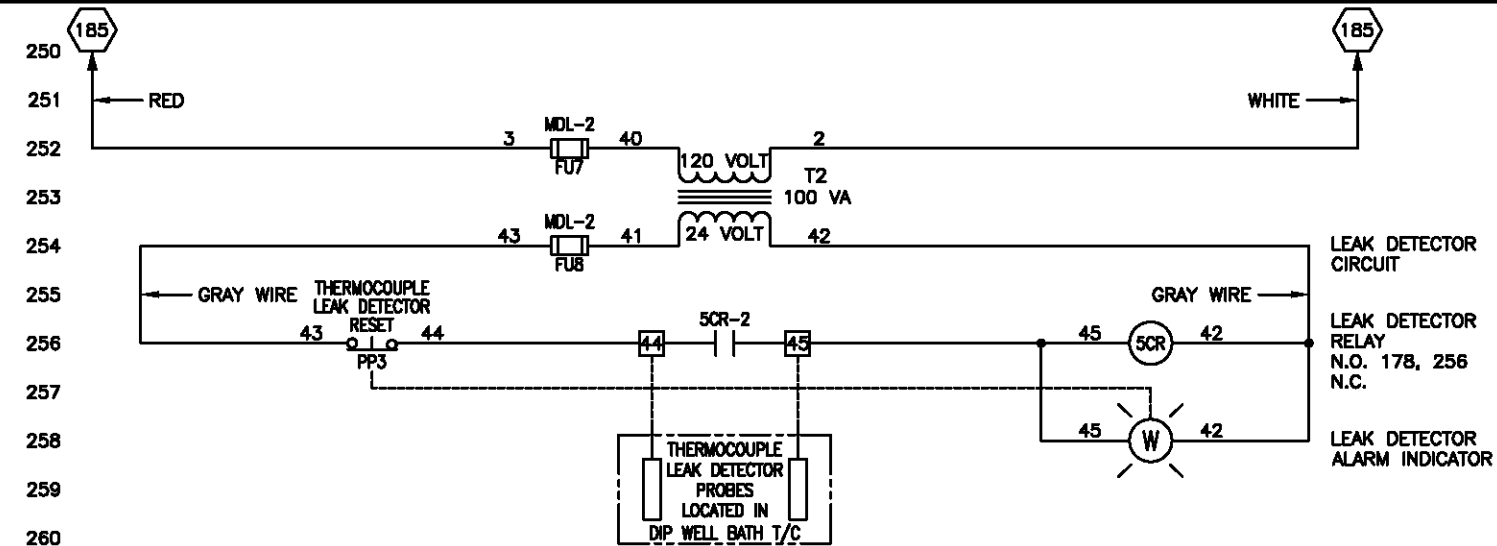
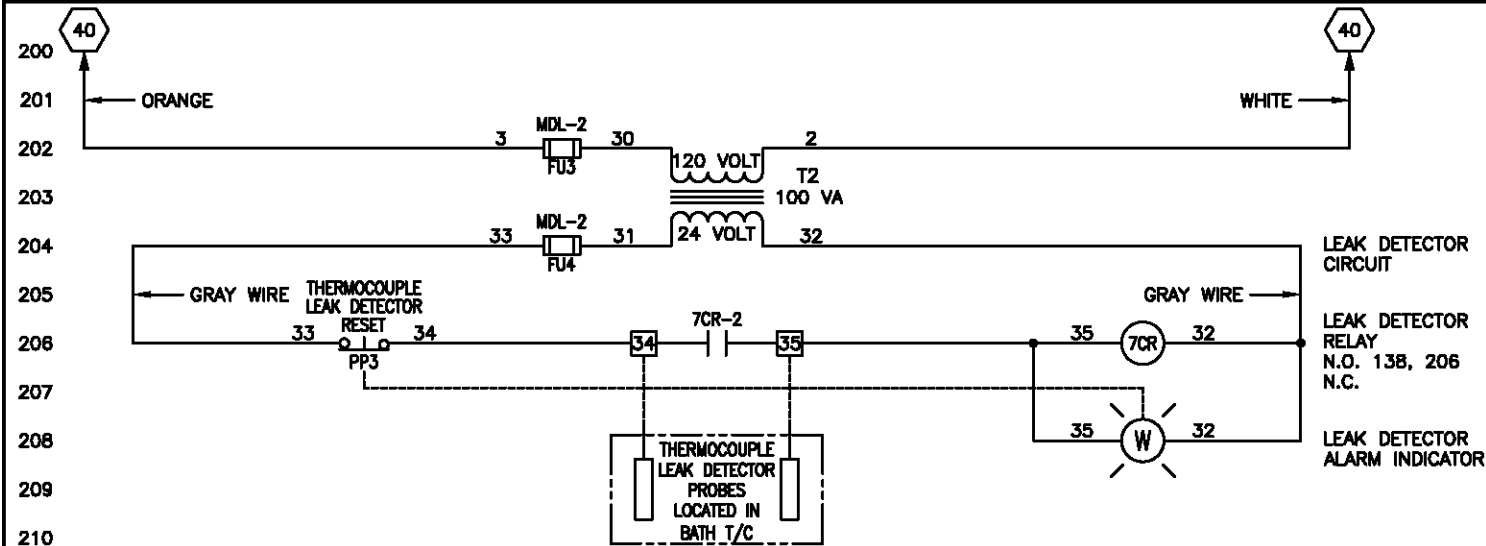
DESCRIPTION
1250kW Electric
Reverberatory Furnace
377kVA (325kW)
w/10.5 kW Heated
Dipwell
Electrical Enclosure
SA 007-0710-0054
QUANTITY
FILENAME
AutoCAD 2000

SCHAEFER FURNACES, INC.
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INDUSTRIAL FURNACES
DESIGN • CONSTRUCTION • INSTALLATIONS
DAYTON, OHIO 45410
Gibbs Die Casting Corp
Henderson Ky

RECORD
PAGE 2 of 2
SCALE
NAME
DATE
DRAWN
JOB
DATE
08/04/10
No.
10-0054-4-2



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			PAGE 2 of 5
	SCALE		SDM
	NAME Joe Goetz		DATE 12/20/09
Gibbs Die Casting Corp Henderson Ky			No. 10-0054-4B



APPROVED

SIGNED _____ DATE _____

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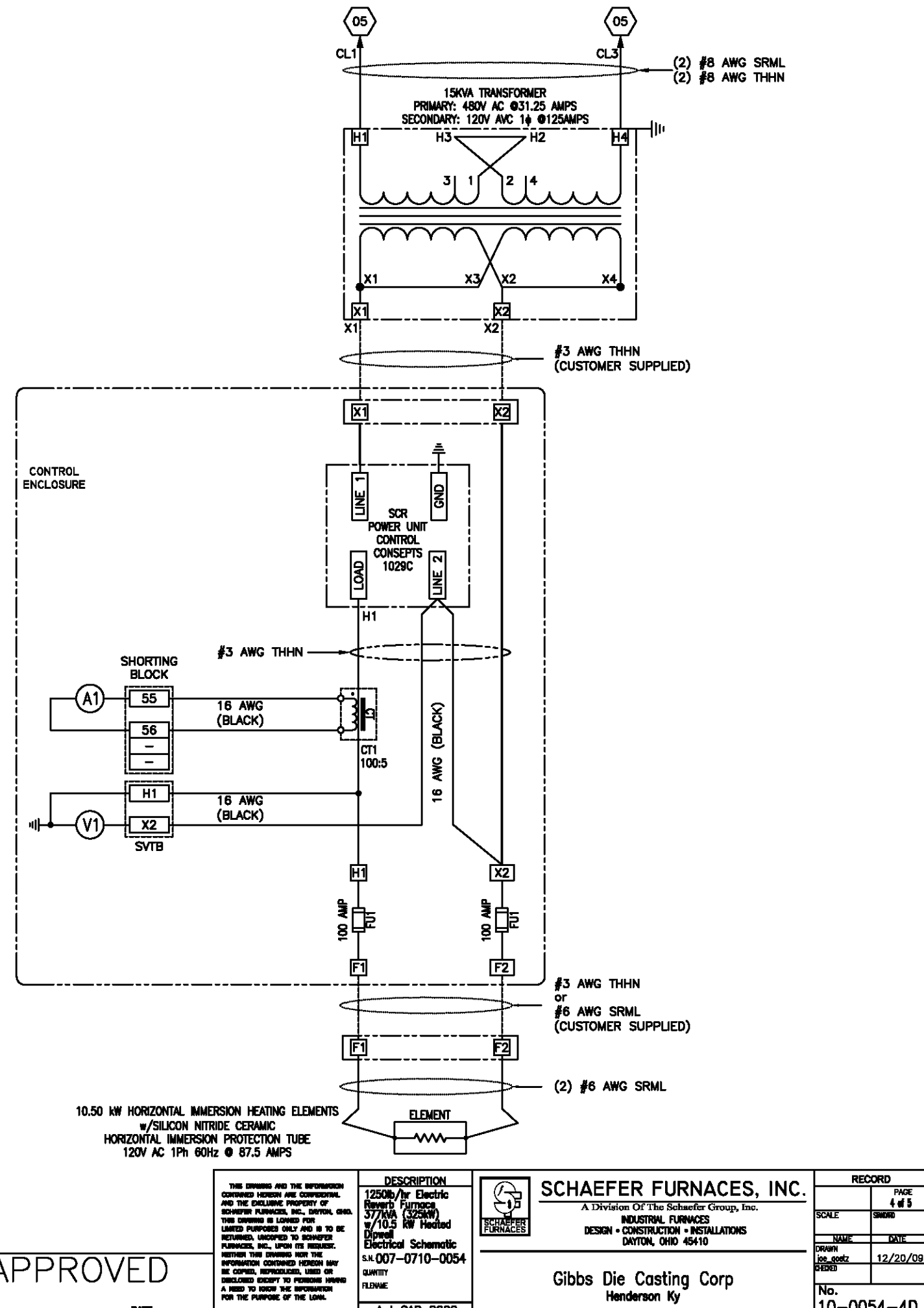
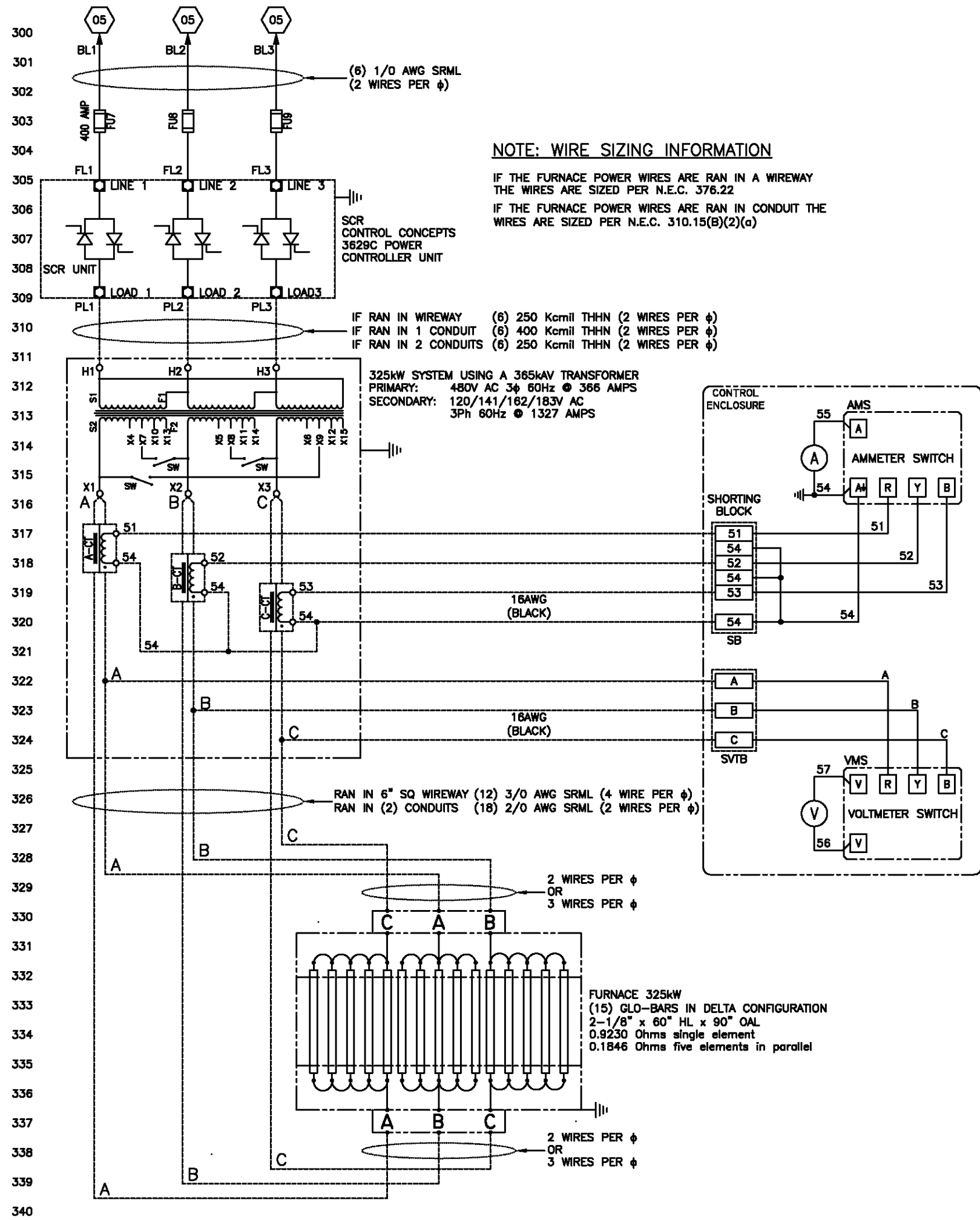
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1250lb/hr Electric Reverb Furnace
377kVA (325kW)
w/10.5 kW Heated Dipwell
Electrical Schematic
S.N. 007-0710-0054
QUANTITY
FILENAME
AutoCAD 2000



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Gibbs Die Casting Corp
Henderson Ky

RECORD	
PAGE	3 of 5
SCALE	AS SHOWN
NAME	DATE
DRAWN Joe Goetz	12/20/09
CHECKED	
No.	10-0054-4C

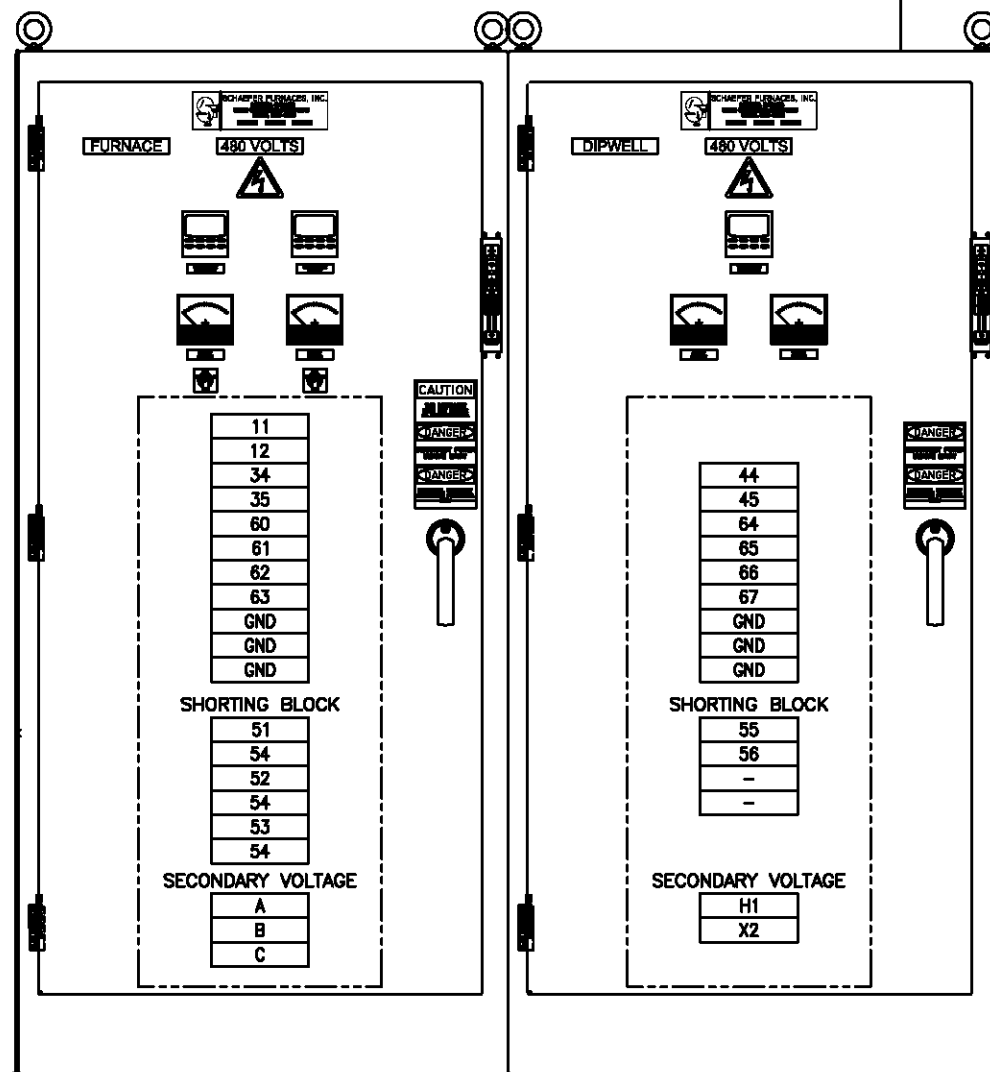


CUSTOMER
480V AC
3 Ph
60 Hz
450 FLA

L1

L2

L3



(9) 16 AWG THHN WIRE (2 spare)

11, 12, 34, 35, 44, 45, GND

(4) TYPE K THERMOCOUPLE WIRE

60, 61, 62, 63, 64, 65, 66, 67

(2) #8 AWG THHN (2) #3 AWG THHN

CL1, CL3 X1, X2

(2) #3 AWG THHN or #6 AWG SRML

H1, X1

JUNCTION BOX

(2) 16 AWG SRML WIRE
11, 12

TYPE K THERMOCOUPLE WIRE
60, 61

TYPE K THERMOCOUPLE WIRE 62, 63
(2) 16 AWG SRML WIRE 34, 35

TYPE K THERMOCOUPLE WIRE 66, 67
(2) 16 AWG SRML WIRE 44, 45

DOOR LIMIT SWITCH

11 1DLS 12
N.C. HELD OPEN

60 YELLOW
61 [ROOF] T/C 1
RED

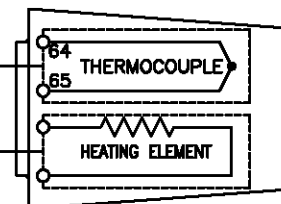
62 YELLOW
63 [BATH] T/C 2
RED
34 Leak Detector
35 OPTIONAL

66 YELLOW
67 [BATH] T/C 2
RED
44 Leak Detector
45 OPTIONAL

FURNACE

TYPE K THERMOCOUPLE WIRE

64, 65



10.5kW IMMERSION
HEATING ELEMENT
120V AC 1φ
87.5 Amps

WIRE SIZING INFORMATION

IF POWER WIRES ARE RAN IN A WIREWAY
THE WIRES ARE SIZED PER N.E.C. 376.22
PL1, PL2, PL3, GND
(6) 250 kcmil THHN (2 WIRES PER φ)

IF POWER WIRES ARE RAN IN CONDUIT
THE WIRES ARE SIZED PER N.E.C. 310.15(B)(2)(a)
PL1, PL2, PL3, GND
RAN IN 1 CONDUIT (6) 400 kcmil THHN (2 WIRES PER φ)
RAN IN 2 CONDUITS (6) 250 kcmil THHN (2 WIRES PER φ)
PL1, PL2, PL3

(10) 16 AWG THHN WIRE

3, 6, 51, 52, 53, 54, A, B, C, GND

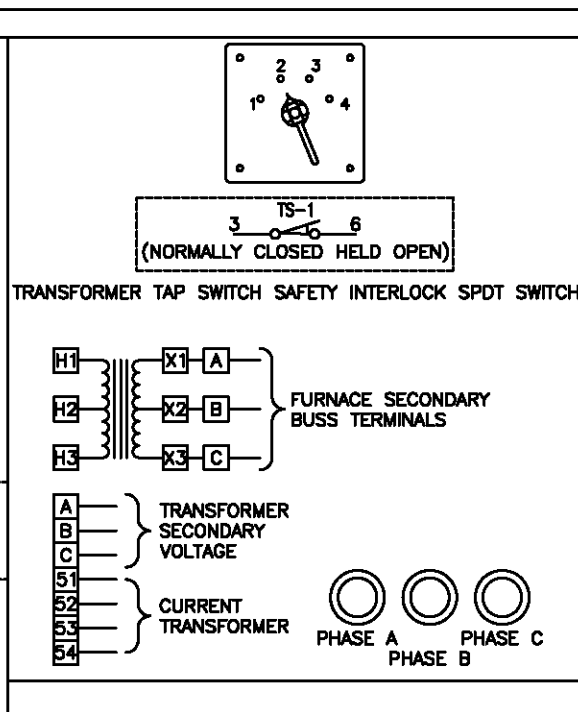
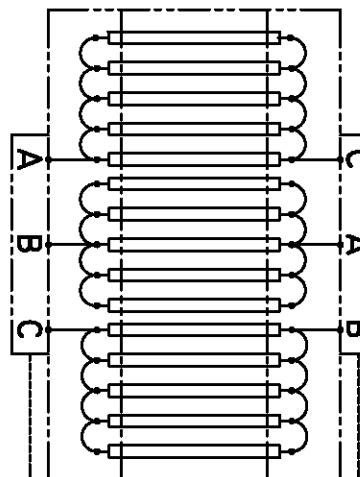
WIRE SIZING INFORMATION

IF POWER WIRES ARE RAN IN A WIREWAY
THE WIRES ARE SIZED PER N.E.C. 376.22
A, B, C, GND
(12) 3/0 AWG SRML (4 WIRE PER φ)

IF POWER WIRES ARE RAN IN CONDUIT
THE WIRES ARE SIZED PER N.E.C. 310.15(B)(2)(a)
A, B, C,
RAN IN (2) CONDUITS (18) 2/0 AWG SRML (2 WIRES PER φ)

A, B, C

FURNACE 325kW
(15) GLO-BARS
IN A DELTA CONFIGURATION
2-1/8" x 60" HL x 90" OAL
0.9230 Ohms single element
0.1846 Ohms elements in parallel



APPROVED

SIGNED DATE

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DESCRIPTION
12500/yr Electric
Reverb Furnace
377kVA (325kW)
w/10.5 kW Heated
Dipwell
Electrical Schematic
S.N.007-0710-0054
QUANTITY
FLAME
AutoCAD 2000

SCHAEFER FURNACES, INC.
A Division Of The Schaefer Group, Inc.
INDUSTRIAL FURNACES
DESIGN • CONSTRUCTION • INSTALLATIONS
DAYTON, OHIO 45410
Gibbs Die Casting Corp
Henderson Ky

RECORD
PAGE 5 of 5
SCALE
NAME DATE
12/20/09
No. 10-0054-4E