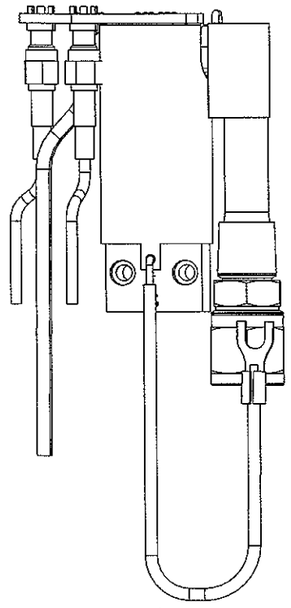
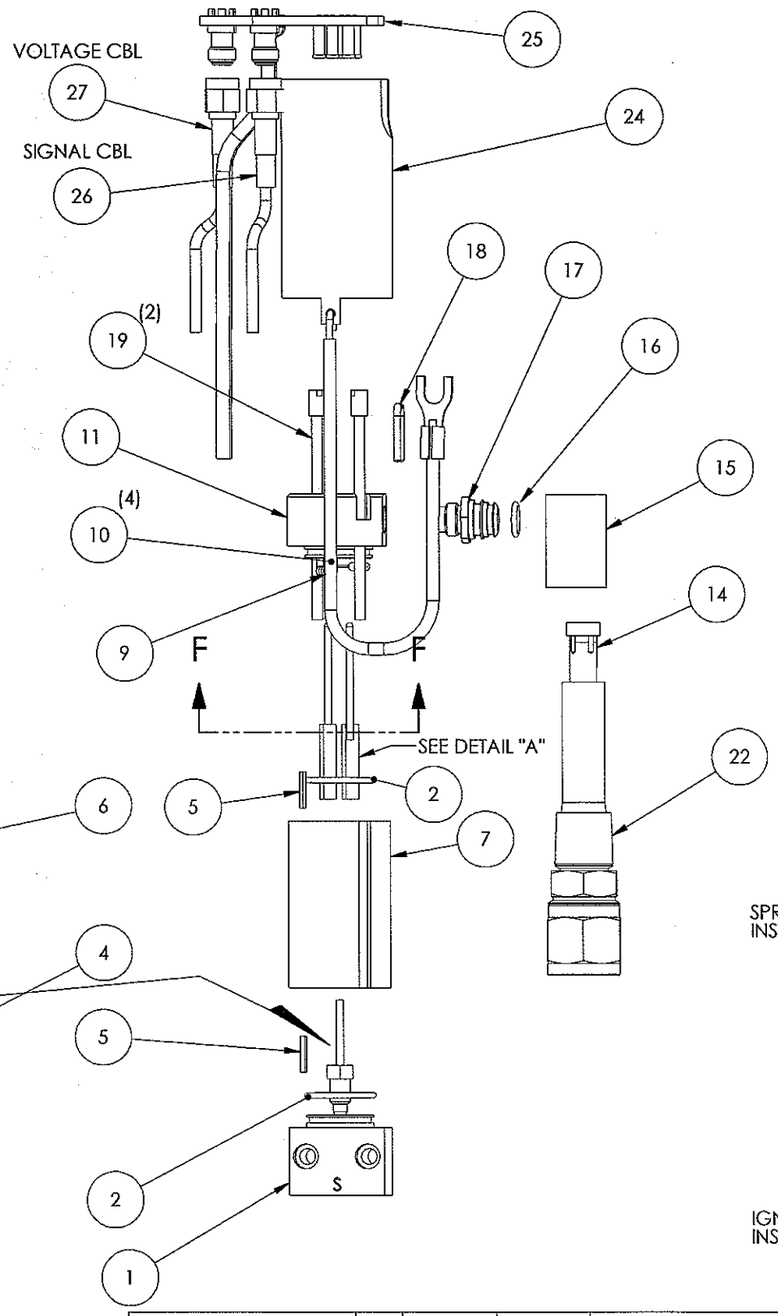
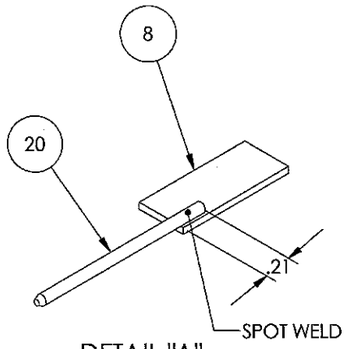
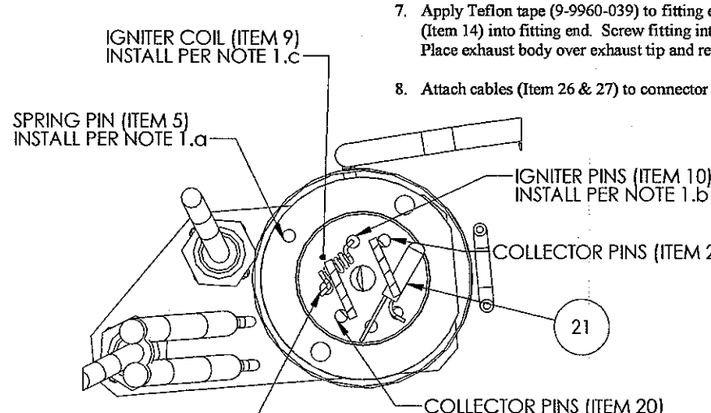






DETAIL "A"
TWO REQ'D.



SECTION F-F
SCALE 2 : 1

NOTES:

1. Build cap assembly:
   a. Press spring pin (Item 5) into hole in shoulder face of cap (Item 11).
   b. From the smaller diameter end of the cap, press 4 igniter pins (Item 10) into their holes. The tapered ends go first. The ends stop flush with the opposite surface of the cap.
   c. Weld the igniter coil (Item 9) to the ends of the igniter pins farthest from the flat face. Coil should be below top of pins. Trim off excess coil wire. Ensure coils are separated. Weld RTD (item 21) to the ends of the remaining pins. Trim off excess wire. Check both devices for continuity.
   d. Weld collector plate (Item 8) to collector pin (Item 20) per "Detail A" press the collector plate assemblies into their holes in the cap using an installation fixture. Apply pressure only to the ends of the pins and not to the plates. The free ends of the collector plate pins stop flush with the opposite surface of the cap. The inner surfaces should be parallel and .220" apart.
   e. Thoroughly degrease assembly with methanol and bake dry at 75 deg C.
   f. Very lightly lubricate o-ring (Item 2) with Petroleum based grease, wipe off excess and install on smaller diameter end.

2. Build base assembly:
   a. Press spring pin (Item 5) into its hole next to cylindrical end of base (Item 1).
   b. Screw flame tip isolator (Item 4) into cylindrical end of base, lightly. Insert flame tip (Item 6) into isolator. Press into hole until it bottoms. Torque assembly only enough to seat and retain flame tip (2-5 In-lbs.).
   c. Degrease and bake as with cap.
   d. Lubricate, wipe and install o-ring (Item 2) in groove in cylindrical end.

3. Place body (Item 7) on base. Its internal baffle will surround the flame Tip. Align the hole in the body with the spring pin. Wiggling the body while pressing to the base will help the body seat fully over the o-ring.

4. Put cap in place on body. Align the spring pin with the hole in the body. Wiggle parts while assembling to seat over the o-ring. Install long screws (Item 19) and tighten (2-3 in-lbs).

5. Place shield (Item 24) over FID.

6. Lubricate o-ring (Item 16) and install on exhaust tip (Item 17). Screw Exhaust tip into cap. Tighten enough to seat (3-6 in lbs.). With all openings plugged, assembly should hold 5 psig without leaking.

7. Apply Teflon tape (9-9960-039) to fitting end (Item 22). Install flame gap pin (Item 14) into fitting end. Screw fitting into exhaust body (Item 15) (15-20 in-lbs.). Place exhaust body over exhaust tip and retain with clip (Item 18).

8. Attach cables (Item 26 & 27) to connector board (Item 25). Install on assembly.

SI METRIC						
THIRD ANGLE PROJECTION						
	D	2-17-06	HM	ECO-XX-5001513	EM	DLT
MATERIAL: SEE ORDER	C	10-6-05	HM	ECO-XX-5001141	EM	BLB
	B	8-19-05	HM	ECO-XX-5001017	EM	BLB
FINISH: N/A	A	8-12-05	HM	REL'D ECO-XX-5000240	DLT	BLB
	REV	DATE	DRN	DESCRIPTION	CHKD	APPD
PROJ. FILE NO. G-00001	FILE NAME: CE21276D1.SLDDRW, DATE: 1-27-06, TIME: 10:25 A.M.					

GEOMETRIC TOLERANCES & DIMENSIONS PER ANSI Y14.5 LATEST REVISION

UNLESS OTHERWISE NOTED ALL DIMENSIONS IN INCHES
XXX ±.015
XXXX ±.005
ANGULAR ±0° 30'
FINISH 200 RA MAX

BREAK ALL SHARP CORNERS TO .008-.015 RADIUS AND REMOVE ALL BURRS

EMERSON. Process Management

TITLE
ASSEMBLY MICRO-FID MODEL 700 G.C.

DRN MANCHA	DATE 10/25/04	DWG NO. CE-21276		REV D	
CHKD DLT	DATE 8/12/05				
APPD BLB	DATE 8/12/05	SCALE 1:2	P/N 2-3-0700-131	SHT 1 OF 1	