



ALLIS-CHALMERS

INSTRUCTIONS

Assembly

Shelter-Clad

HOUSINGS

5 kv and 15 kv Class

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Read these assembly instructions carefully and completely before beginning assembly. Keep these instructions handy for future reference. Throughout these instructions a typical 5kv unit is used for illustration purposes. A 15 kv unit will be shown and noted where instructions are substantially different.

WARRANTY

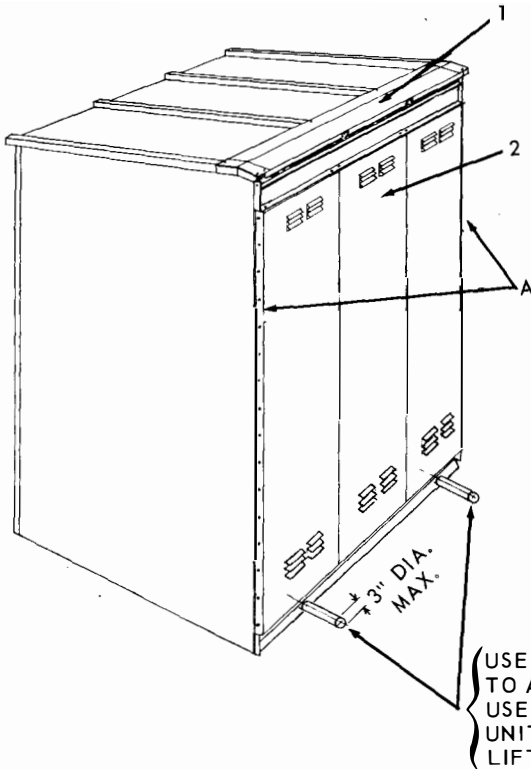
Company warrants the title of the equipment and also warrants the equipment to be of the kind and quality described herein and free of defects in workmanship and material at the inception of the applicable period specified below.

No other warranty shall be implied, and any statutory warranties shall be deemed waived.

If within one year from date of shipment (or if the equipment is installed by Company or the work of installation is supervised by a Company representative, within one year from date of completion of installation or eighteen months from date of shipment, whichever occurs first), Purchaser discovers that the equipment is not as warranted and promptly notifies Company of such failure, Company shall be obligated, and shall have the right, to remedy such failure by, at Company's option, adjustment, or repair, or replacement of the whole or any part of the equipment affected by such failure, Purchaser shall assume all responsibility and expense for removal, reinstallation, and freight in connection with the foregoing remedies. Company's obligation and right as aforesaid shall be extended on any replacement parts for one year after date of replacement. Company shall have the right of disposal of parts replaced by it hereunder.

Company's liability to Purchaser whether in contract or in tort arising out of warranties, representations, instructions, or defects from any cause, shall be limited exclusively to correcting the equipment and under the conditions as aforesaid.

SINGLE AISLE



1. Set the factory assembled equipment into place. See general arrangement drawing for location.
2. Remove seal material from top of Front Plate Assembly, (Item 2).
3. Unbolt and remove gable piece (Item 1).
4. Before unbolting Front Plate Assembly (Item 2) provide a means for preventing it from falling; then unbolt at position "A".

NOTE

This wall weighs about 125 pounds per unit and must be removed as a single assembly.

5. Remove blocking material from top of front wall.
6. Move Front Plate (Item 2) to its permanent location as indicated on the General Arrangement Floor Plan.

7. Remove aisle beam (Item 3) from the top of the Front Plate Assembly (Item 2) and place in position "B" with end clip angles near top of beam.
8. Put Roof Covers, (Item 4) in place to hold top of front wall in place.

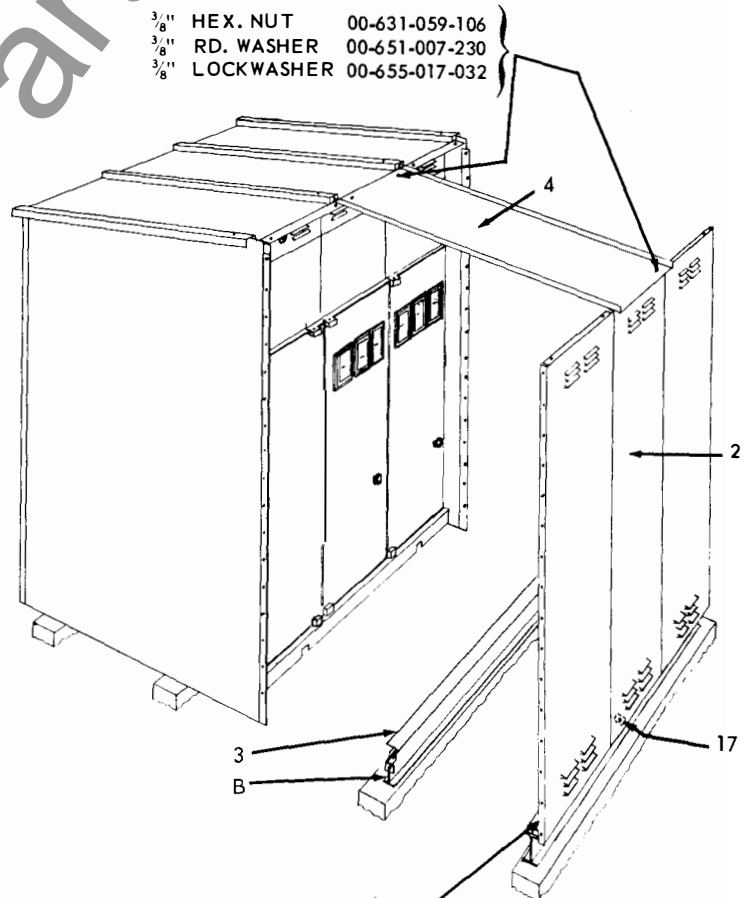
NOTE

Place a Roof Cover one unit in from each end example: One a 7 unit Group the 2nd and 6th units would be used.

9. Align aisle wall ends and ends of center beam clip angles with ends of switchgear. Place two sets of floor plates in position, one unit in from each end of switchgear group, where group length permits. With floor plates tightly against switchgear unit floor plates, check and adjust center beam and aisle wall beam locations. These should be such that a good floor plate fit with minimum cracks between plates is attained and held to provide a smooth surface for breaker wheels. Check aisle wall squareness with switchgear by diagonal measurements at floor level, corner to corner should be equal. Tighten anchor bolts to secure beam locations.

10. With roof cover hardware loose, plumb front wall and tighten hardware to secure.

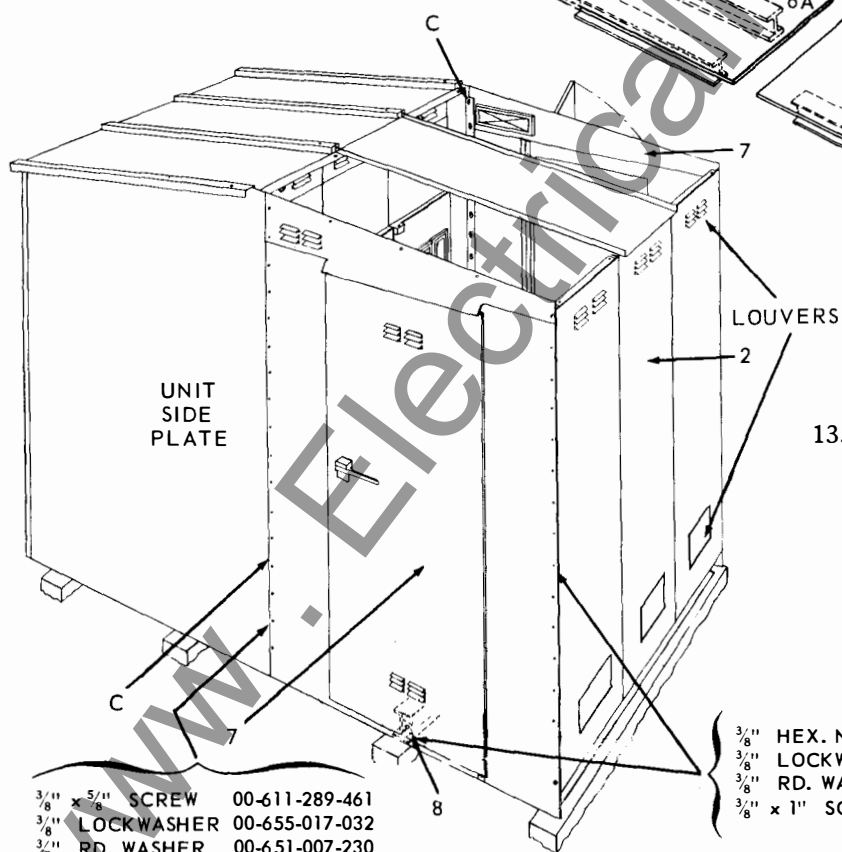
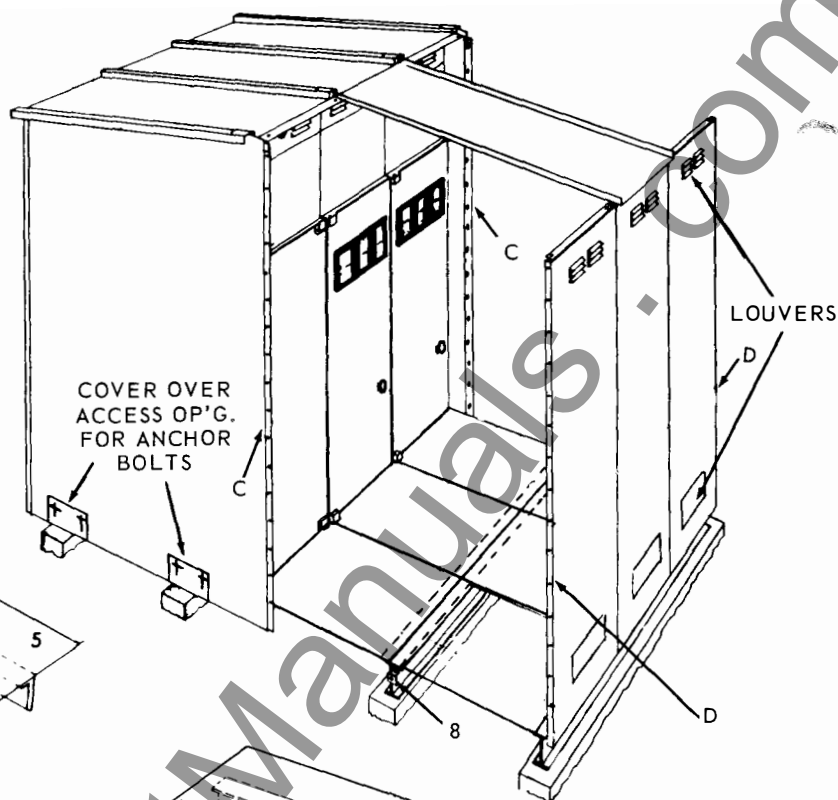
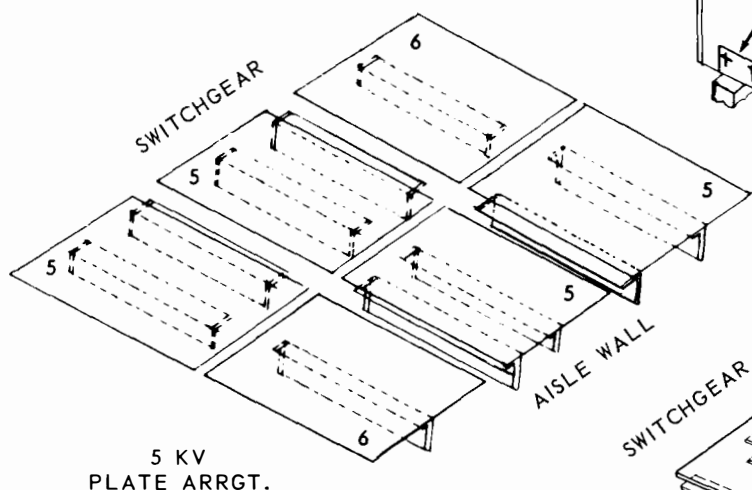
$\frac{3}{8}$ " HEX. NUT 00-631-059-106
 $\frac{3}{8}$ " RD. WASHER 00-651-007-230
 $\frac{3}{8}$ " LOCKWASHER 00-655-017-032



$\frac{3}{8}$ " x 1" SCREW 00-611-289-466
 $\frac{3}{8}$ " RD. WASHER 00-651-007-230
 $\frac{3}{8}$ " LOCKWASHER 00-655-017-032

11. Install all floor plates using 5 kv or 15 kv pattern as shown below. As each plate overlaps, the protruding member of the next sequence of installation should be determined accordingly. Each set of floor plates should be centered on their respective unit to equalize the splits between floor plates and prevent a tolerance build-up and wide crack at end of group.

12. Put Weather Stripping in position "C" and "D".



13. Raise Door Assemblies (Item 7) into place. Bolt to Front Plate Assembly (Item 2) and Unit Side Plate.

3/11 x 5/11 SCREW 00-611-289-461
3/11 LOCKWASHER 00-655-017-032
3/11 RD. WASHER 00-651-007-230

3/8" HEX. NUT 00-631-059-106
3/8" LOCKWASHER 00-655-017-032
3/8" RD. WASHER 00-651-007-230
3/8" x 1" SCREW 00-611-289-466

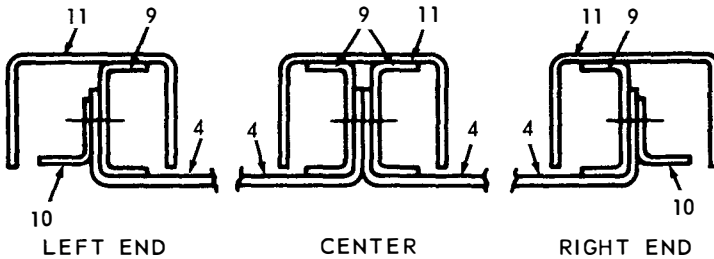
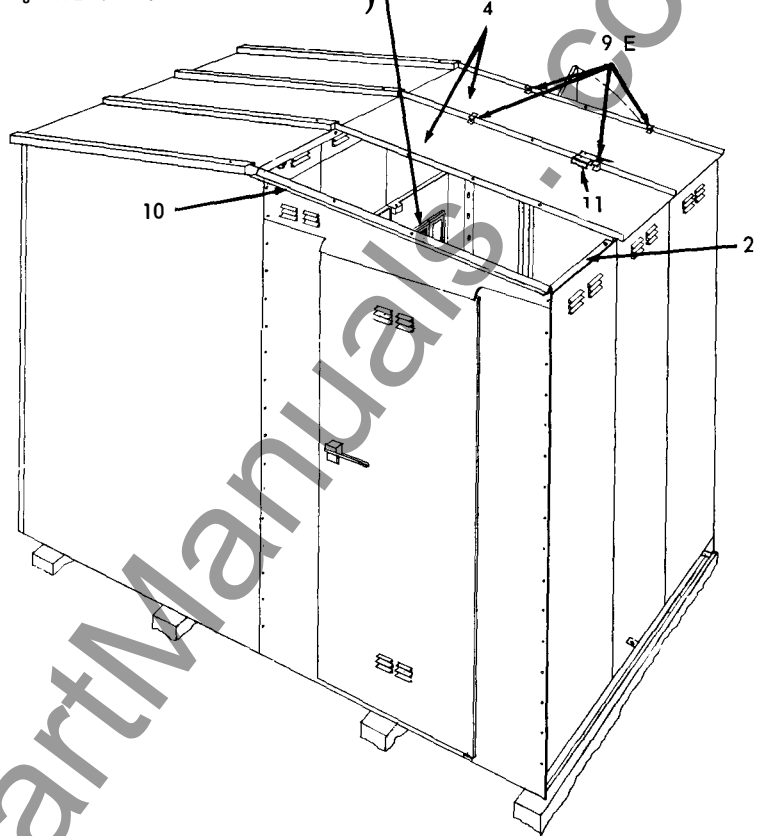
14. Put all Roof Covers (Item 4) in place and bolt to Front Plate Assembly (Item 2) and Roof Support.

15. Fasten Roof Covers together using Bracket (Item 9) at position "E". See view A.

16. Add Trim Angles (Item 10) at each end of aisle.

17. Install Roof Channels (Item 11) by setting the channels so that the welded clip inside the channel engages the Bracket (Item 9) of the Roof Deck Joint; then slide toward peak.

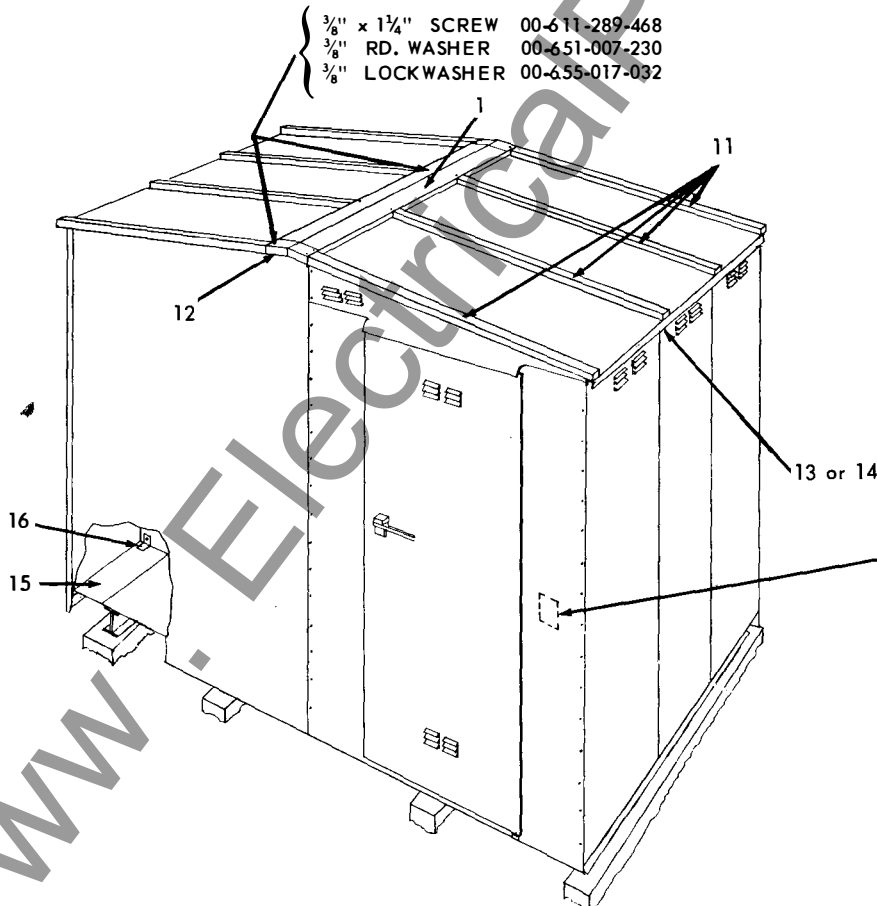
$\frac{3}{8}$ " x $1\frac{1}{4}$ " SCREW 00-611-289-468
 $\frac{3}{8}$ " LOCKWASHER 00-655-017-032
 $\frac{3}{8}$ " HEX. NUT 00-631-059-106



$\frac{3}{8}$ " RD. WASHER 00-651-007-230
 $\frac{3}{8}$ " LOCKWASHER 00-655-017-032
 $\frac{3}{8}$ " HEX. NUT 00-631-059-106
 $\frac{3}{8}$ " x $1\frac{1}{4}$ " SCREW 00-611-289-468

EACH
CONNECTION

VIEW A



$\frac{3}{8}$ " x $1\frac{1}{4}$ " SCREW 00-611-289-468
 $\frac{3}{8}$ " RD. WASHER 00-651-007-230
 $\frac{3}{8}$ " LOCKWASHER 00-655-017-032

18. Put Roof Gable Assembly (Item 1) into place, position of Item 11 is adjustable to fit into notches of Item 1.

19. Bolt Item 1 into place using weld nuts in Item 11.

20. Add End Gable Assembly (Item 12) at each end. Fasten Cover (Item 13 or Item 14) to roof.

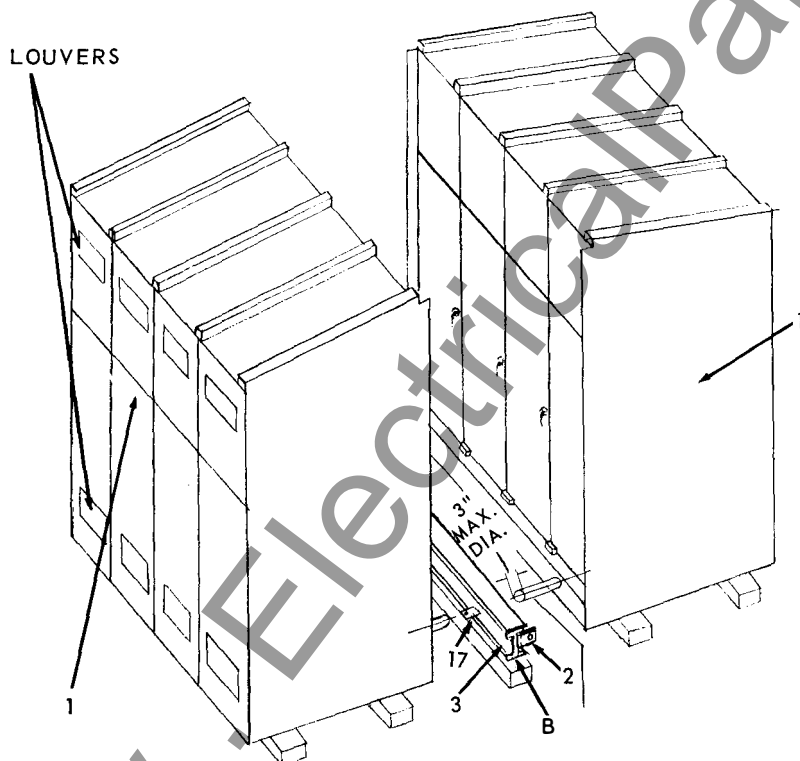
21. Move light switch box from temporary location above units to final mounting on Door Frame on side away from unit.

22. Drill Cable Cover (Item 15) to suit customers conduit, clamp as shown with Item 16.

ITEM	DESCRIPTION	5 KV		15 KV	
		PART NO.	MK	PART NO.	MK
1	ROOF GABLE ASSEM.	18-177-200		18-184-208	
2	FRONT PLATE ASSEM.	18-286-858		18-294-111	
3	BEAM	18-178-210		18-702-162	
4	ROOF COVER ASSEM. (AISLE)	18-177-195	501	18-299-861	501
5	FLOOR PLATE ASSEM.	18-652-057	502	18-294-120	501
5A	FLOOR PLATE ASSEM.			18-657-246	554
6	FLOOR PLATE ASSEM.	18-652-057	501	18-294-121	501
6A	FLOOR PLATE ASSEM.			18-657-246	555
7	DOOR ASSEM L.H.	18-454-339	501	18-454-345	501
7A	DOOR ASSEM R.H.	18-454-339	502	18-454-345	502
8	ANGLE	18-657-223	573	18-657-206	513
9	BRACKET	18-176-985	001	18-184-206	001
10	ANGLE	18-177-261	001	18-184-213	004
11	ROOF CHANNEL ASSEM.	18-176-983	501	18-299-862	501
12	END GABLE ASSEM.	18-177-259	501	18-184-218	501
13	COVER (FORMED)	18-287-990		18-184-210	
14	COVER (FORMED)	18-287-994		18-294-117	
15	COVER OR PLATE	18-177-174 PLATE	001	18-184-217 COVER	001
16	ANGLE	18-178-032	001	18-178-032	001
17	CLAMP WASHER	18-628-853	001	18-628-853	001

NOTE: THE ABOVE TABLE IS FOR STANDARD PARTS ONLY.

COMMON AISLE



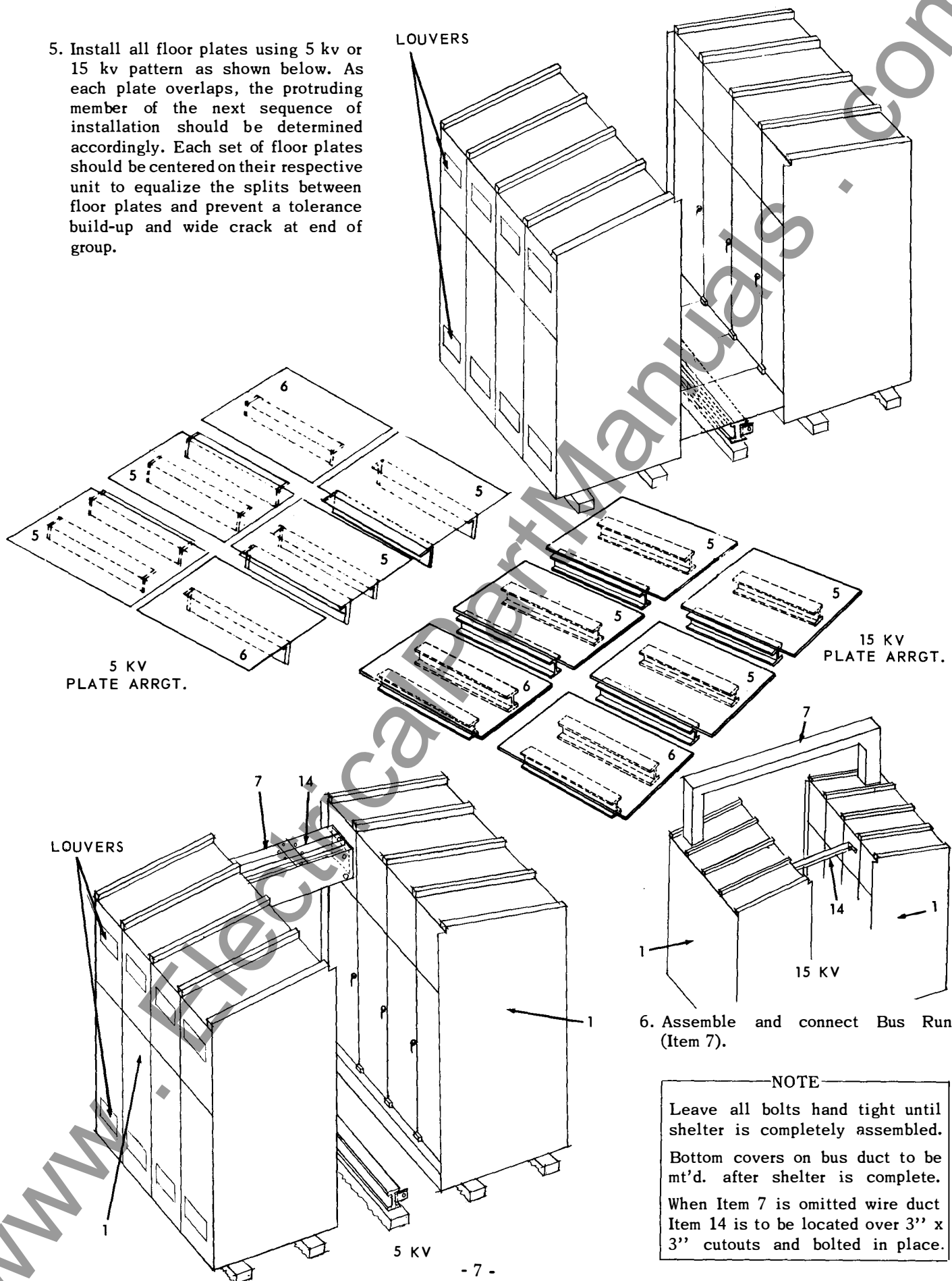
1. Set the factory assembled equipment (Items 1) in place as shown on the General Arrangement Drawing.
2. Remove protective coverings from the equipment.
3. Place Aisle Beam (Item 3) in position "B" and bolt to anchor bolts in position shown on General Arrangement Drawing.
4. Mount (Item 2) as shown to ends of Beam (Item 3).

The Following Items Are Shipped Separately :

Floor beam Item 3 – 1 per substation
 Door assemblies Item 4 – 2 per substation
 Floor plates Item 5 & 6 – 1 per unit
 Bus run Item 7 (optional on 5 kv only)
 Roof decks Item 9 – 1 for each 2 units
 Roof channels Item 10
 Hoods Item 11
 Angle Item 2 – 2 per substation
 Trim angle Item 13 – 4 per substation
 Wire Duct Item 14 (used when Item 7 is omitted)
 Cover Item 8A – 4 per substation
 Cover Item 15
 Angle Item 16

USE 2½" PIPE SK. 80 FOR 5 KV UNITS UP TO AND INCLUDING 4 UNIT GROUPS.
 USE 2½" PIPE EXTRA HEAVY FOR 15 KV UNITS AND 5 TO 7 UNIT 5-KV GROUPS.
 LIFT PIPES FURNISHED BY CUSTOMER.

5. Install all floor plates using 5 kv or 15 kv pattern as shown below. As each plate overlaps, the protruding member of the next sequence of installation should be determined accordingly. Each set of floor plates should be centered on their respective unit to equalize the splits between floor plates and prevent a tolerance build-up and wide crack at end of group.



NOTE

Leave all bolts hand tight until shelter is completely assembled.

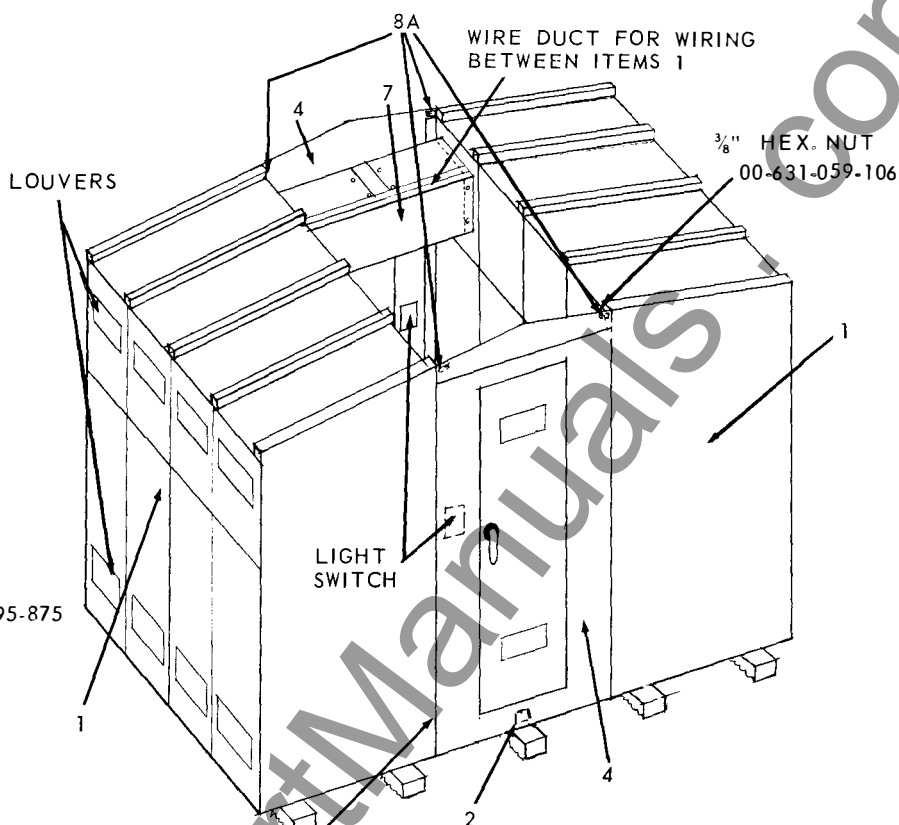
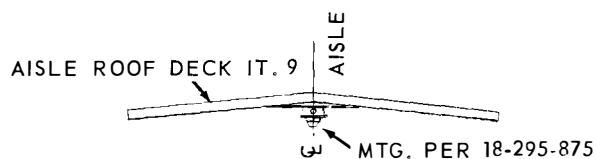
Bottom covers on bus duct to be mt'd. after shelter is complete.

When Item 7 is omitted wire duct Item 14 is to be located over 3" x 3" cutouts and bolted in place.

7. Raise Aisle End Plate (door assemblies, Item 4) into place. Bolt to units. Bolt to aisle sill using Angle (Item 2).

8. Move light switch box from temporary location above instrument panel to final assembly on door frame.

8a. Mount Item 8A in place.



$\frac{3}{8}$ " x $\frac{5}{8}$ " SCREW 00-611-289-461
 $\frac{3}{8}$ " LOCKWASHER 00-655-017-032
 $\frac{3}{8}$ " RD. WASHER 00-651-007-230

9. Place roof decks (Item 9) into place and fasten with the bolts provided.

10. Fasten roof decks together using Bracket (Item 12). See View A.

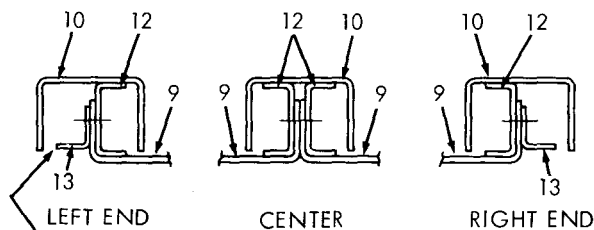
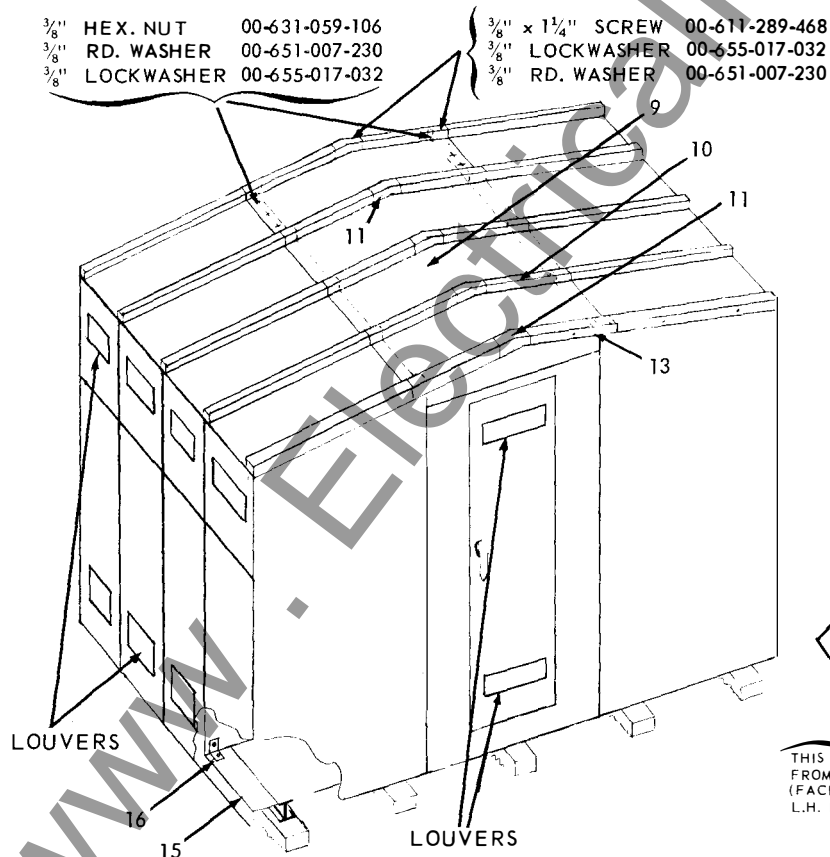
11. Add trim angle (Item 13) to end of group.

12. Install Covers (Item 10) by setting so that clips inside engage the I-Beam washer.

13. Bolt Hoods (Item 11) in place.

14. Tighten all bolts to complete assembly.

15. Drill Cable Cover (Item 15) to suit customers conduit and clamp as shown with Item 16.



THIS ANGLE REMOVED FROM UNIT L.H. END (FACING D/O) & MT'D ON L.H. END OF WORK SPACE.

$\frac{3}{8}$ " HEX. NUT 00-631-059-106
 $\frac{3}{8}$ " LOCKWASHER 00-655-017-032
 $\frac{3}{8}$ " RD. WASHER 00-651-007-230
 $\frac{3}{8}$ " x $1\frac{1}{4}$ " SCREW 00-611-289-468

VIEW A

ITEM	DESCRIPTION	5 KV		15 KV	
		PART NO.	MK	PART NO.	MK
1	FACTORY ASSEM. EQUIPMENT				
2	FORMED – ANGLE	18-657-223	573	18-657-206	513
3	BEAM	18-193-151		18-193-151	
4	DOOR ASSEM.	18-454-339	503	18-454-345	504
5	FLOOR PLATE R.H. & INTER.	18-288-736	501	18-299-880	501
6	FLOOR PLATE – L.H.	18-288-736	502	18-299-881	501
7	BUS RUN	18-453-547	SEE GENERAL ARR'G'T.		
8					
8A	COVER	18-179-735	001	18-190-433	001
9	ROOF DECK	18-288-735	501	18-299-878	501
10	COVER	18-179-730	501	18-190-430	501
11	HOOD	18-288-739	001	18-701-569	001
12	BRACKET	18-176-985	001	18-184-206	001
13	ANGLE	18-179-733	001	18-190-438	001
14	WIRE DUCT	18-191-039	002	18-191-039	001
15	COVER OR PLATE	18-177-174 PLACE	001	18-184-217 COVER	001
16	ANGLE	18-178-032	001	18-178-032	001
17	CLAMP WASHER	18-628-853	001	18-628-853	001

NOTE: THE ABOVE TABLE IS FOR STANDARD PARTS ONLY.

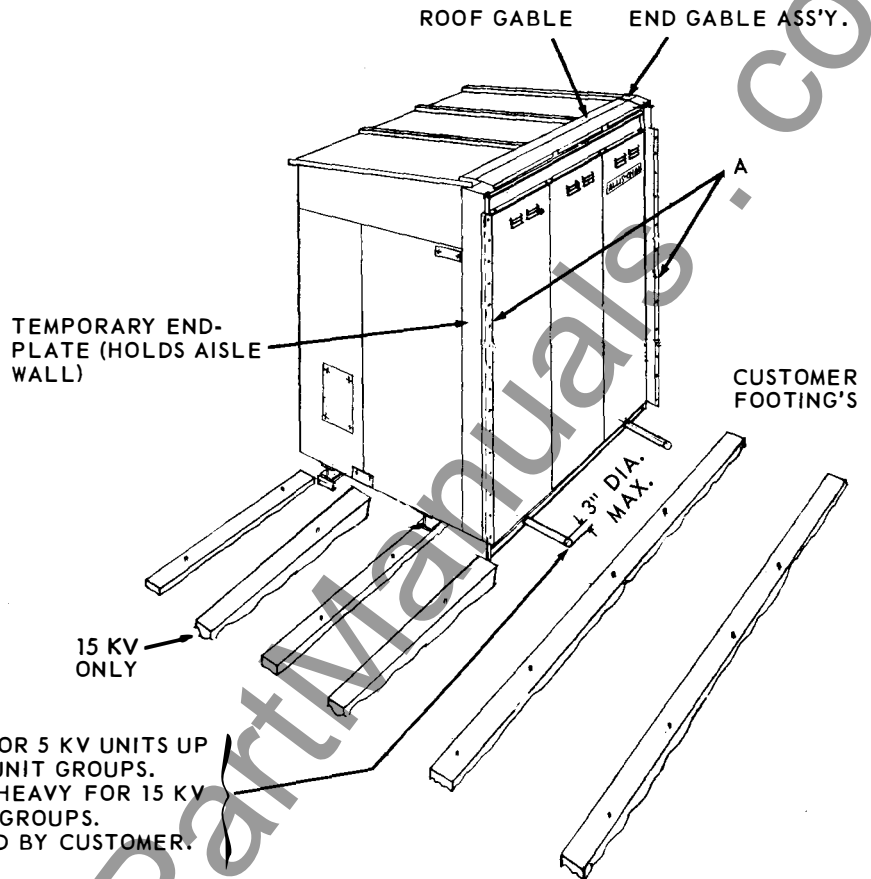
SINGLE AISLE - WITH WORK SPACE

1. Set the factory assembled equipment into place as indicated on the General Arrangement drawing.
2. Remove seal material from top of front plate assembly.
3. Unbolt and remove roof gable.
4. Before unbolting front plate assembly, provide a means for preventing it from falling, then unbolt at position "A".

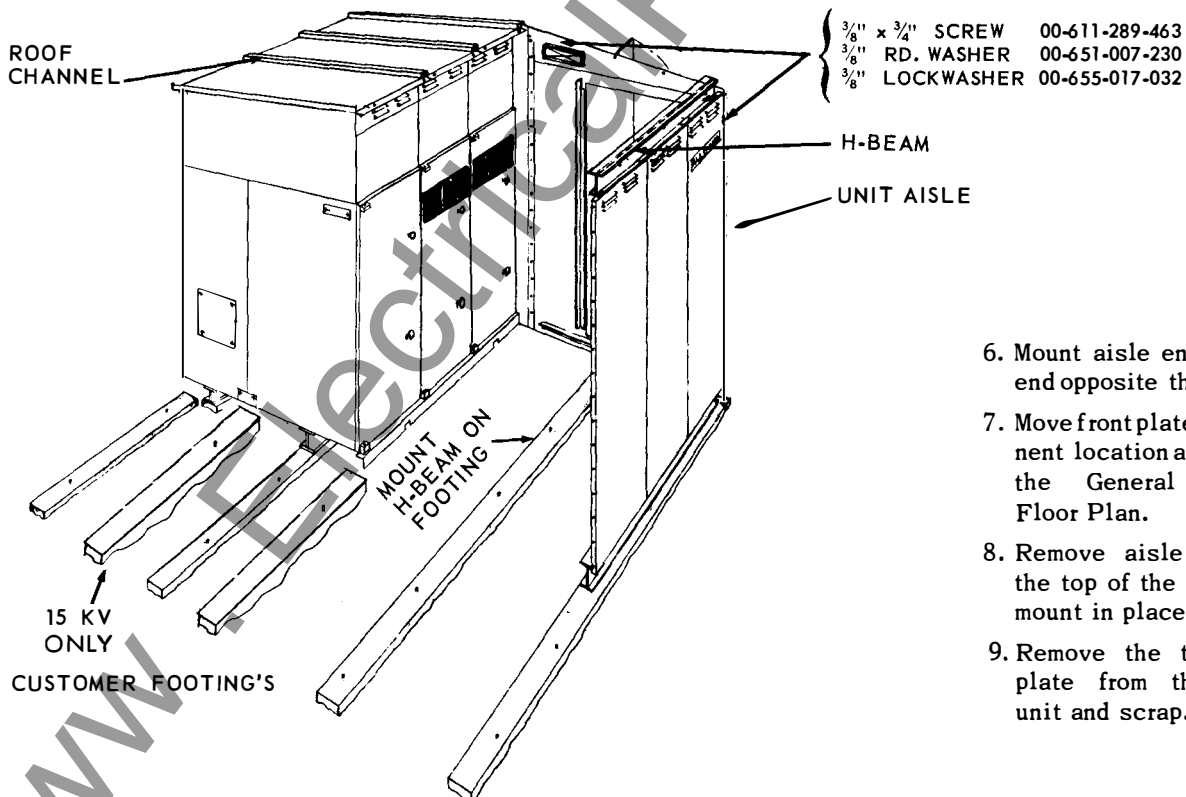
NOTE

This wall weighs about 125 pounds per unit and must be removed as a single assembly.

5. Remove blocking material from top of front plate assembly.



USE 2½" PIPE SK. 80 FOR 5 KV UNITS UP TO AND INCLUDING 4 UNIT GROUPS.
USE 2½" PIPE EXTRA HEAVY FOR 15 KV AND 5 TO 7 UNIT 5½-KV GROUPS.
LIFT PIPES FURNISHED BY CUSTOMER.



6. Mount aisle end plate at the end opposite the work space.
7. Move front plate to its permanent location as indicated on the General Arrangement Floor Plan.
8. Remove aisle H-beam from the top of the front wall and mount in place.
9. Remove the temporary end plate from the switchgear unit and scrap.

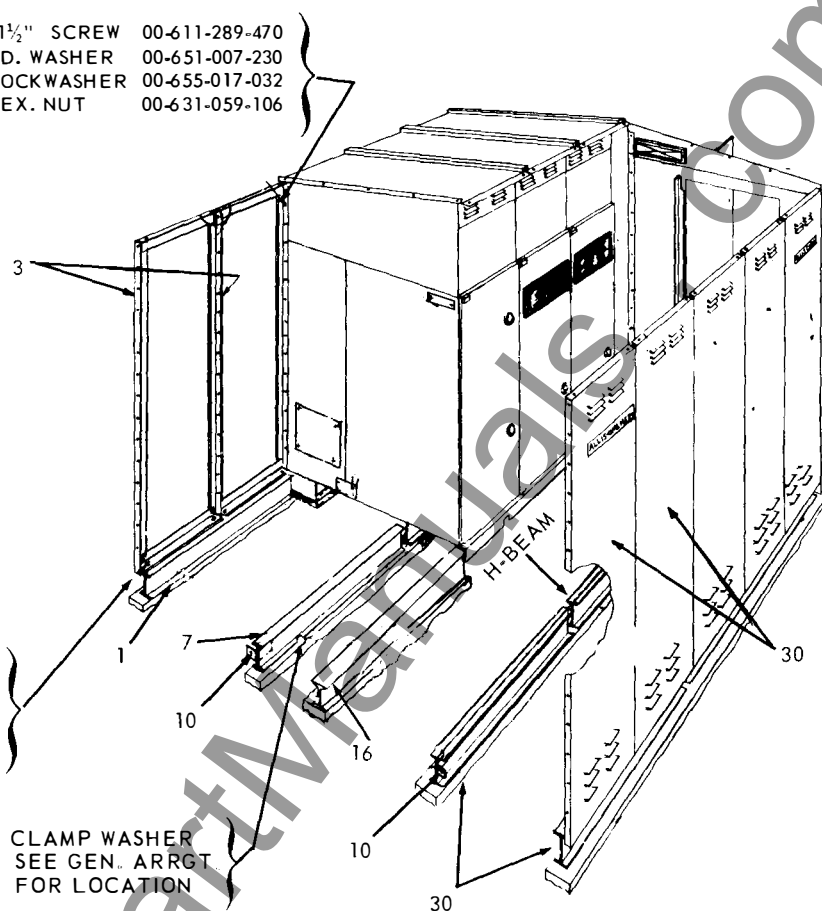
5 KV

10. Put the work aisle and work space beams in position as indicated on the General Arrangement Floor Plan (Items 1, 7 and 16).
11. Assemble front plates. See General Arrangement for location of special panels (fans, etc.).
12. Bolt Angle Rings (Item 3) together and to switchgear unit and to beam (Item 1).
13. Mount angles (Item 10) to ends of beams.

$\frac{3}{8}$ " x $1\frac{1}{2}$ " SCREW 00-611-289-470
 $\frac{3}{8}$ " RD. WASHER 00-651-007-230
 $\frac{3}{8}$ " LOCKWASHER 00-655-017-032
 $\frac{3}{8}$ " HEX. NUT 00-631-059-106

$\frac{1}{2}$ " HEX. NUT 00-631-059-108
 $\frac{1}{2}$ " LOCKWASHER 00-655-017-036
 $\frac{1}{2}$ " RD. WASHER 00-651-007-300
 $\frac{1}{2}$ " x $1\frac{1}{4}$ " SCREW 00-611-315-546

CLAMP WASHER
SEE GEN. ARRGT.
FOR LOCATION



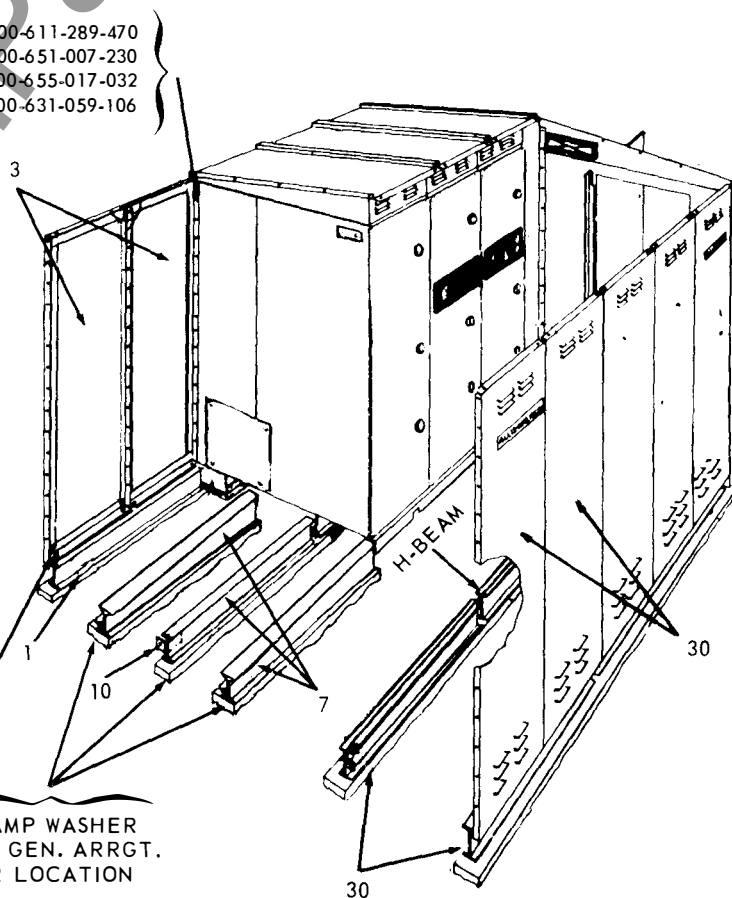
15 KV

10. Put the work aisle and work space beams in position as indicated on the General Arrangement Floor Plan (Items 1,7).
- 11 Assemble front plates. See General Arrangement for location of special panels (fans, etc.).
12. Bolt Plates (Item 3) together and to switchgear unit and to beam (Item 1).
13. Mount angles (Item 10) to ends of beams.

$\frac{3}{8}$ " x $1\frac{1}{2}$ " SCREW 00-611-289-470
 $\frac{3}{8}$ " RD. WASHER 00-651-007-230
 $\frac{3}{8}$ " LOCKWASHER 00-655-017-032
 $\frac{3}{8}$ " HEX. NUT 00-631-059-106

$\frac{1}{2}$ " HEX. NUT 00-631-059-108
 $\frac{1}{2}$ " LOCKWASHER 00-655-017-036
 $\frac{1}{2}$ " RD. WASHER 00-651-007-300
 $\frac{3}{8}$ " x $1\frac{1}{4}$ " SCREW 00-611-315-546

CLAMP WASHER
SEE GEN. ARRGT.
FOR LOCATION



5 KV

14. Add Tee Members (Item 14) between walls at each joint (view "E" and "D").
15. Mount Items 8 and 9 (framing angles) at the end of the space. Use flat head screw 00-615-331-466 to hold Items 8 and 9 together before end cover (Item 4) is mounted. Discard after mounting end cover.
16. Bolt end cover (Item 4) to rear angle ring (Item 3) and to bottom clip angle on beam and to Items 8 and 9.
17. Put floor plates into place and mount Item 5.

NOTE

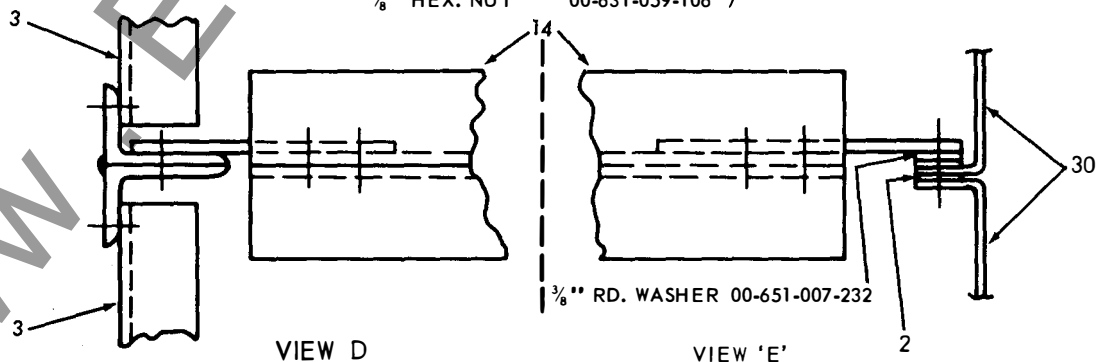
Floor plates in front of switchgear are arranged the same as SINGLE AISLE.

$\frac{3}{8}$ " x $1\frac{1}{2}$ " SCREW 00-611-289-470
 $\frac{3}{8}$ " RD. WASHER 00-651-007-230
 $\frac{3}{8}$ " LOCKWASHER 00-655-017-032
 $\frac{3}{8}$ " HEX. NUT 00-631-059-106

$\frac{3}{8}$ " HEX. NUT 00-631-059-106
 $\frac{3}{8}$ " LOCKWASHER 00-655-017-032
 $\frac{3}{8}$ " RD. WASHER 00-651-007-230
 $\frac{3}{8}$ " x $1\frac{1}{2}$ " SCREW 00-611-289-470

$\frac{3}{8}$ " HEX. NUT 00-631-059-106
 $\frac{3}{8}$ " LOCKWASHER 00-655-017-032
 $\frac{3}{8}$ " RD. WASHER 00-651-007-230
 $\frac{3}{8}$ " x 1" SCREW 00-611-289-466

$\frac{3}{8}$ " x $1\frac{1}{2}$ " SCREW 00-611-289-470
 $\frac{3}{8}$ " RD. WASHER 00-651-007-230
 $\frac{3}{8}$ " LOCKWASHER 00-655-017-032
 $\frac{3}{8}$ " HEX. NUT 00-631-059-106



15 KV

14. Add Beam (Item 14) between walls at each joint (view F).
15. Mount Item 9 at the end of the work space.

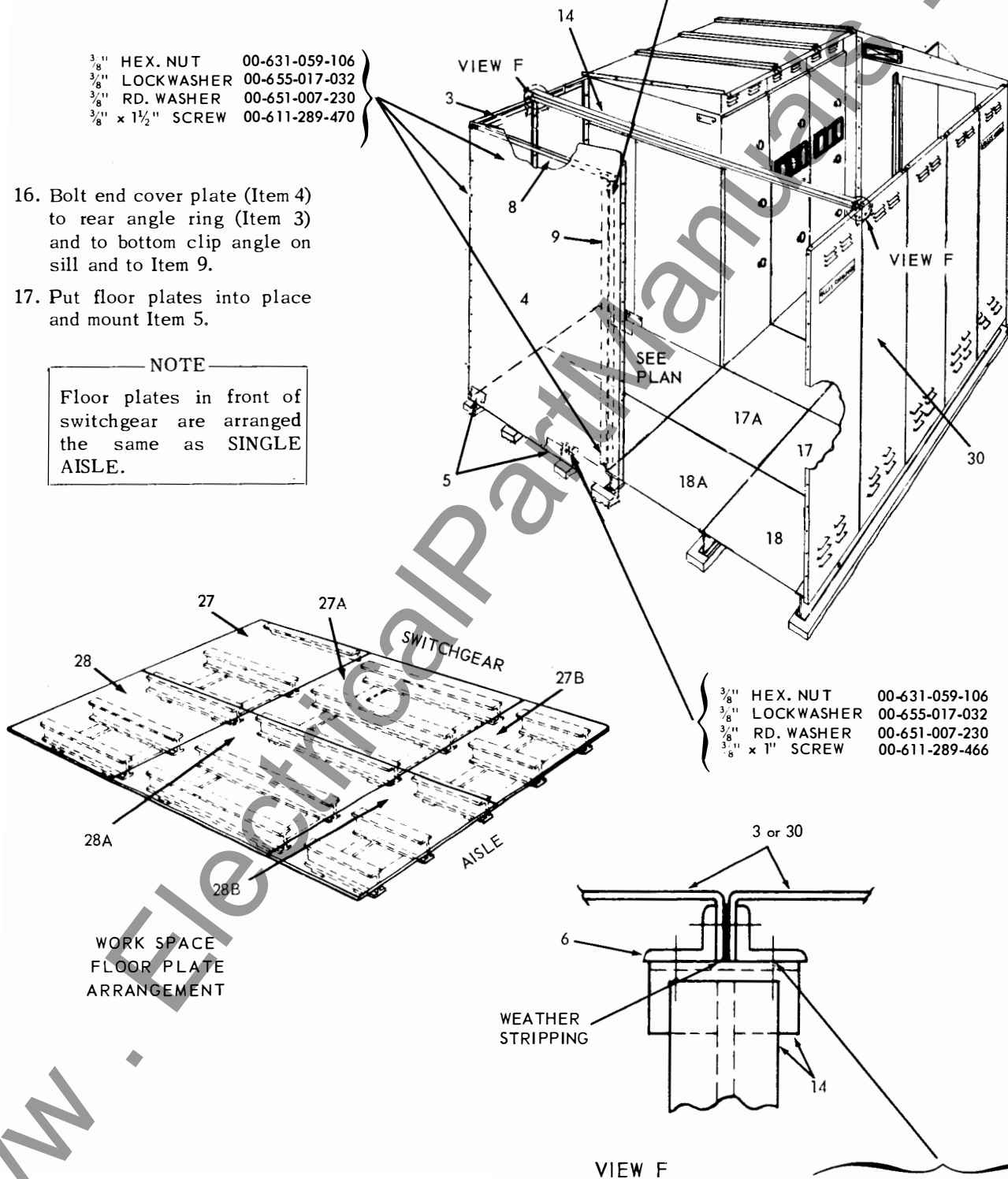
$\frac{3}{8}$ " x $1\frac{1}{2}$ " SCREW	00-611-289-470
$\frac{3}{8}$ " RD. WASHER	00-651-007-230
$\frac{3}{8}$ " LOCKWASHER	00-655-017-032
$\frac{3}{8}$ " HEX. NUT	00-631-059-106

$\frac{3}{8}$ " HEX. NUT	00-631-059-106
$\frac{3}{8}$ " LOCKWASHER	00-655-017-032
$\frac{3}{8}$ " RD. WASHER	00-651-007-230
$\frac{3}{8}$ " x $1\frac{1}{2}$ " SCREW	00-611-289-470

16. Bolt end cover plate (Item 4) to rear angle ring (Item 3) and to bottom clip angle on sill and to Item 9.
17. Put floor plates into place and mount Item 5.

NOTE

Floor plates in front of switchgear are arranged the same as SINGLE AISLE.

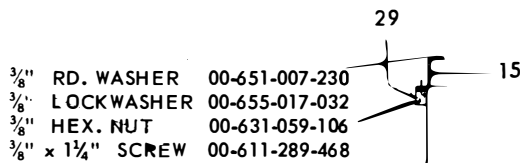
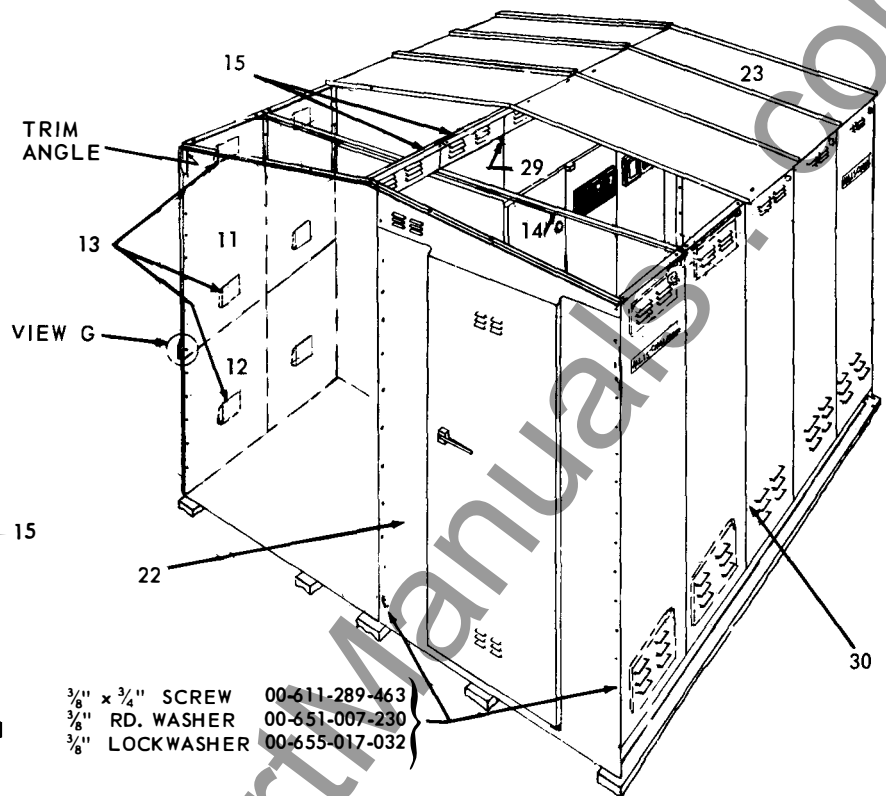


$\frac{3}{8}$ " HEX. NUT	00-631-059-106
$\frac{3}{8}$ " LOCKWASHER	00-655-017-032
$\frac{3}{8}$ " RD. WASHER	00-651-007-230
$\frac{3}{8}$ " x 1" SCREW	00-611-289-466

$\frac{1}{2}$ " HEX. NUT	00-631-059-108
$\frac{1}{2}$ " LOCKWASHER	00-655-017-036
$\frac{1}{2}$ " RD. WASHER	00-651-007-300
$\frac{1}{2}$ " x $1\frac{1}{2}$ " SCREW	00-611-315-546

5 KV

18. Position and bolt into place the door frame assembly (Item 22).
19. Bolt Angle (Item 29) to end of switchgear. Bolt roof supports (Item 15) between the Tee Members (Item 14) and on Item 29 on switchgear (Sect. 'A-A') and members on end plate.
20. Put all roof decks (Item 23) in place and bolt to the top of the end plate and to the roof support (Item 15).
21. Mount trim-angle.



SECT. A-A

- #14 SPEED NUT 00-639-061-228
- #14 SCREW 00-611-461-375
- 1/4" RD. WASHER 00-651-007-160

- 1/4" x 3/4" SCREW 00-611-289-375
- 1/4" RD. WASHER 00-651-007-160
- 1/4" LOCKWASHER 00-655-017-026



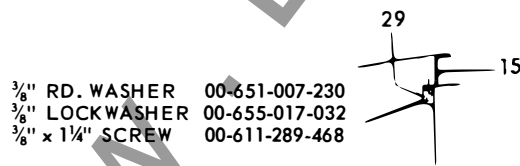
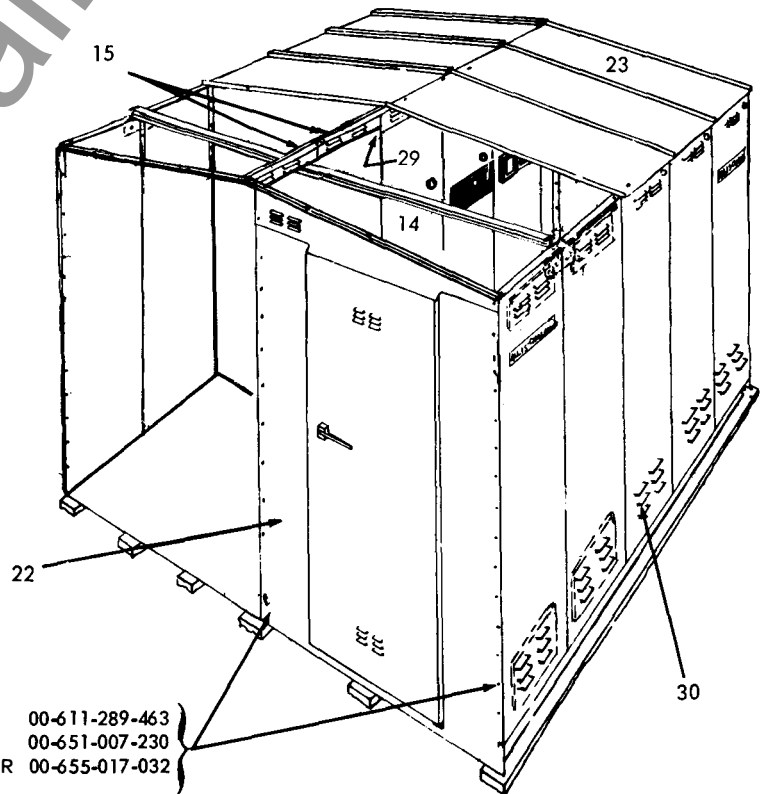
VIEW G

- 3/8" x 3/4" SCREW 00-611-289-463
- 3/8" RD. WASHER 00-651-007-230
- 3/8" LOCKWASHER 00-655-017-032

ITEM 2 IS TO BE CUT TO FIT AND CEMENTED TO REAR PLATES 11 AND 12.

15 KV

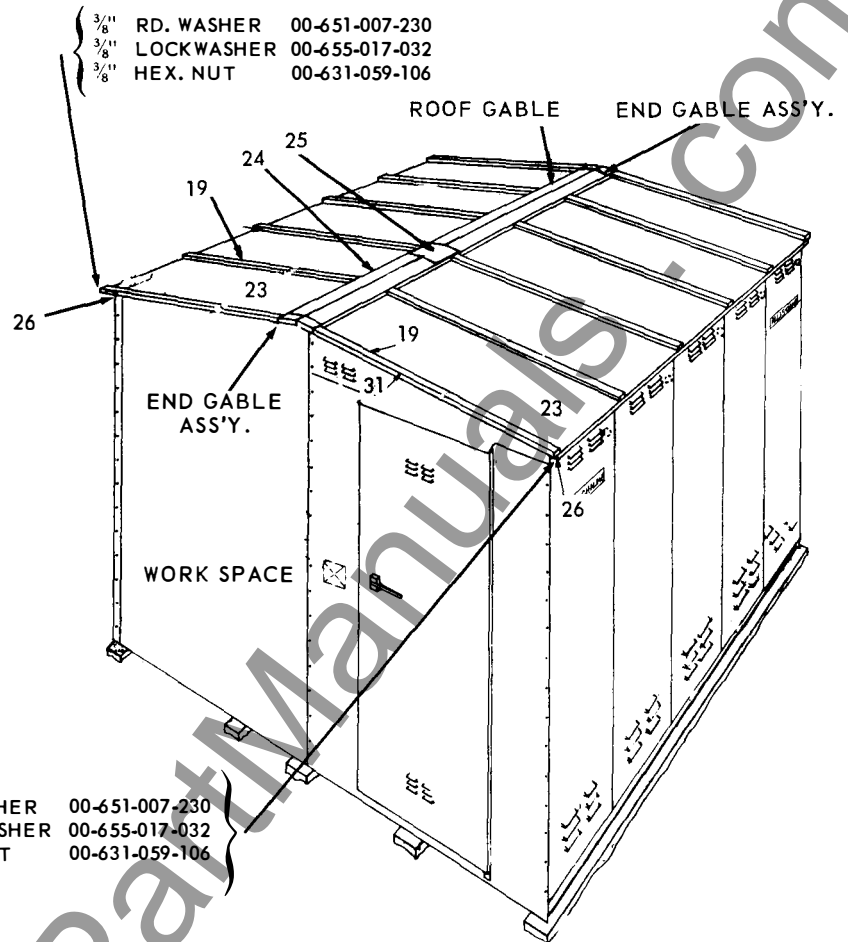
18. Position and bolt into place the door frame assembly (Item 22).
19. Bolt Angle (Item 29) to end of switchgear. Bolt roof supports (Item 15) between the Beam Assembly (Item 14) and Item 29 on switchgear (Sect. 'A-A') and members on end cover.
20. Put all roof decks (Item 23) in place and bolt to the top of the end plate and to the roof support (Item 15).



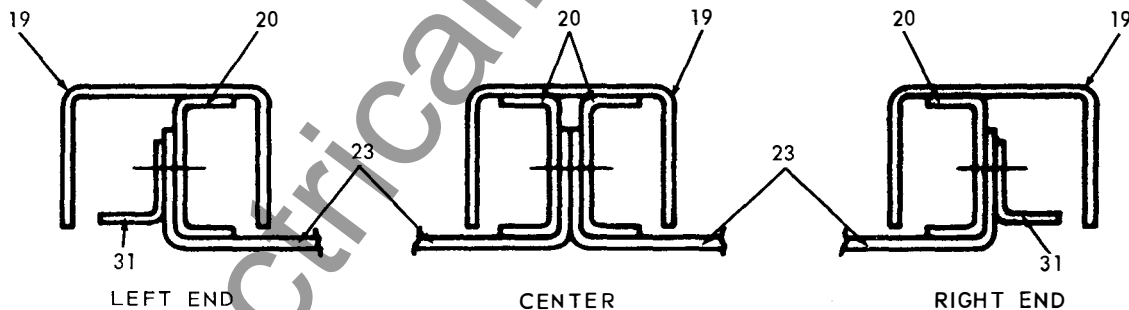
SECT. A-A

- 3/8" x 3/4" SCREW 00-611-289-463
- 3/8" RD. WASHER 00-651-007-230
- 3/8" LOCKWASHER 00-655-017-032

22. Fasten roof decks (Item 23) together using bracket (Item 20). See view A.
24. Install roof channels (Item 19) by setting the channels so that the welded clip, inside the channel engages the channel bracket (Item 20) of the roof deck. Then slide toward peak.
25. Put roof gable (Item 24) and roof gable from sheet 1 into place. Position of Item 19 is adjustable to fit into notches of roof gables.
26. Mount gable cover (Item 25) at gable joint.
27. Bolt roof gable into place using weld nuts in channel (Item 19). Mount Item 26 (formed cover) to underside of Item 23 as shown.
28. Move light switch mounting (from temporary shipping position) next to door on door frame.
29. Mount and connect lights per wiring diagram.



$\frac{3}{16}$ "	RD. WASHER	00-651-007-230
$\frac{3}{16}$ "	LOCKWASHER	00-655-017-032
$\frac{3}{16}$ "	HEX. NUT	00-631-059-106



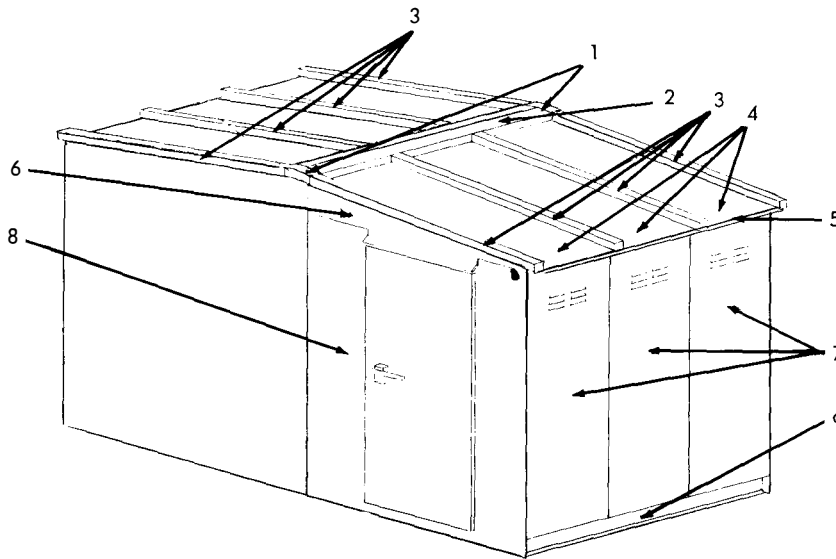
$\frac{3}{16}$ "	HEX. NUT	00-631-059-106	} EACH CONNECTION
$\frac{3}{16}$ "	LOCKWASHER	00-655-017-032	
$\frac{3}{16}$ "	RD. WASHER	00-651-007-230	
$\frac{3}{16}$ " x $1\frac{1}{4}$ "	SCREW	00-611-289-468	

VIEW A

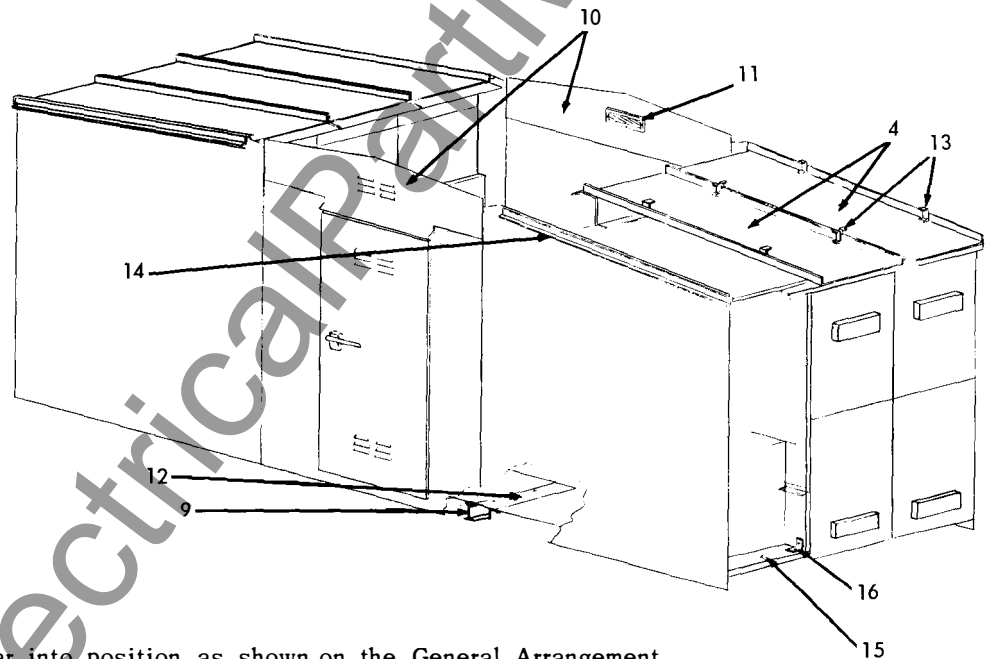
ITEM	DESCRIPTION	5 KV		15 KV	
		PART NO.	MK	PART NO.	MK
1	BEAM	18-195-382	003	18-702-161	002
2	WEATHERSTRIP	00-437-051	011	00-437-051	011
3	ANGLE RING OR PLATE	18-702-408 AN. RG.	501	18-294-111 PLATE	501
4	END COVER	18-712-943	501	18-657-252	541
5	COVER	18-650-504	001	18-650-504	001
6	COVER OR ANGLE MTD. ON IT. 27	18-179-162 COVER	001	18-700-528 ANGLE	001
7	BEAM	18-712-418	002	18-702-162	002
8	ANGLE ASSY.	18-288-521	502	-	
9	ANGLE OR FRAME	18-179-167 ANGLE	501	18-364-274 FRAME	501
10	ANGLE	18-184-139	001	18-191-509	001
11	REAR PLATE	18-186-421	501	-	
12	REAR PLATE	18-186-420	501	-	
13	HURRICANE BOX MTG.	18-707-148	501	-	
14	TEE ASSY. OR BEAM	18-193-417 Tee Assy.	501	18-646-894 BEAM	501
15	ROOF SUPPORT	18-287-025	003	18-646-895	
16	BEAM	18-181-213	002	-	
17	FLOOR PLATE ASSY.	18-652-057	502	18-294-120	501
17A	FLOOR PLATE ASSY.	-		18-657-246	554
18	FLOOR PLATE ASSY.	18-652-057	501	18-294-121	501
18A	FLOOR PLATE ASSY.	-		18-657-246	555
19	ROOF CHANNEL	18-176-983	501	18-294-115 Unit Side	503
				18-299-862 Aisle Side	501
20	BRACKET	18-176-985	001	18-184-206	001
21	CLAMP WASHER	18-628-853	001	18-628-853	001
22	DOOR MTG. L.H.	18-454-339	501	18-454-345	501
23	ROOF COVER	18-177-195	501	18-294-114 Unit Side	503
				18-299-861 Aisle Side	501
24	ROOF GABLE ASSY.	18-177-200	502	18-184-208	502
25	GABLE COVER INT.	18-176-981	001	18-176-981	001
26	FORMED COVER	18-287-990	002	18-184-210	002
27	FLOOR PLATE ASSY.	18-656-890	520	18-700-518	502
27A		-		18-700-519	506
27B		-		18-700-519	507
28		18-656-890	519	18-700-520	505
28A		-		18-700-520	506
28B		-		18-700-520	507
29	ANGLE	18-179-171	002	18-179-171	002
30	AISLE WALL ASSY.	18-654-637	523	18-656-901	502
31	ANGLE	18-177-261	001	18-184-213	004

NOTE: THE ABOVE TABLE IS FOR STANDARD PARTS ONLY.

EXPANDING SINGLE AISLE TO COMMON AISLE

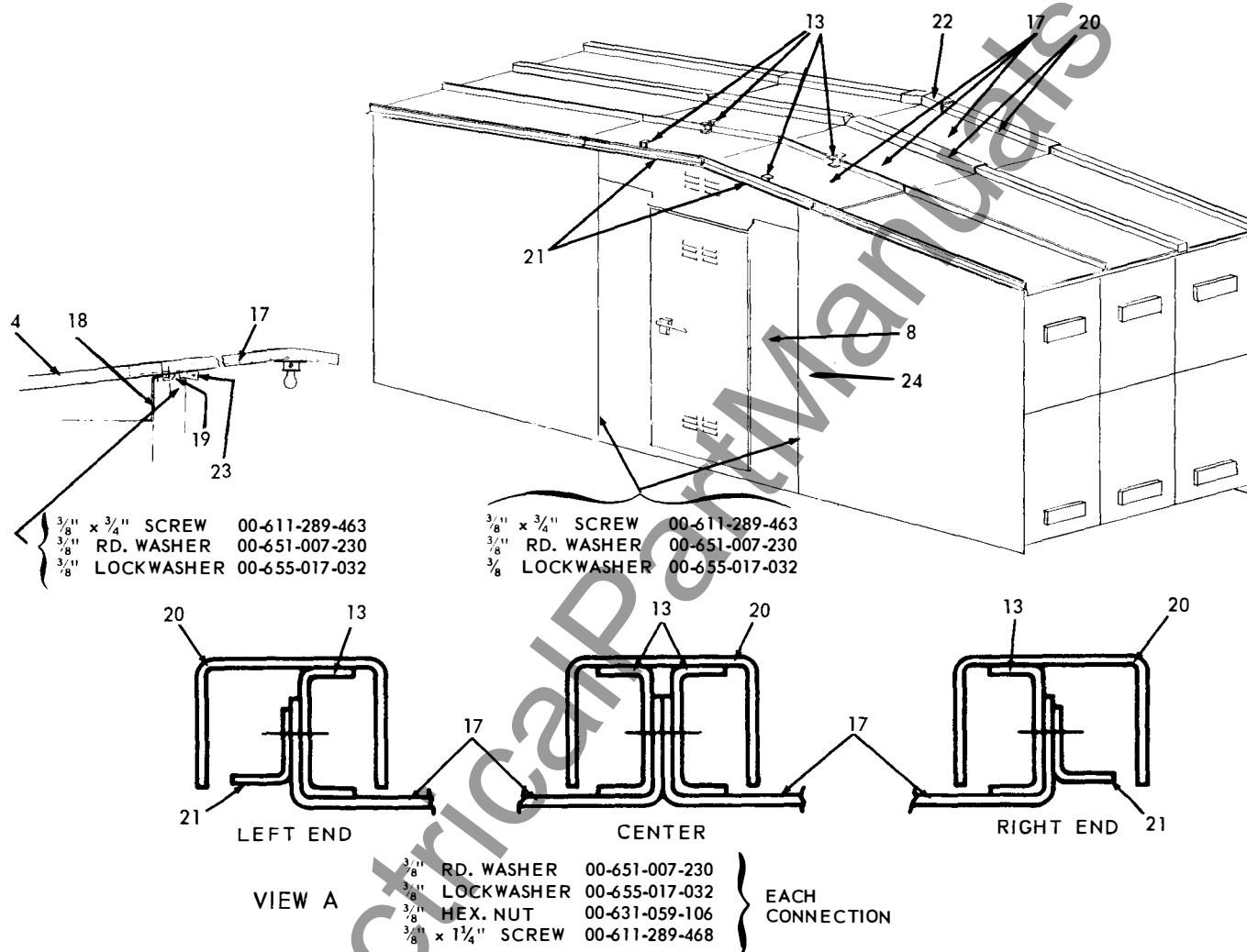


1. From the existing switchgear remove the Gable End (Item 1), and the Roof Gable (Item 2). Scrap these parts.
2. Remove and save the Roof Channel (Item 3), Roof Cover (Item 4), Formed Cover (Item 5) with all its associated hardware.
3. Remove and scrap Plate (Item 6) from above the door.
4. Remove Front Plate (Item 7) by unbolting from door frames (Item 8) and from I-Beam (Item 9). Scrap Plates.



5. Move new switchgear into position as shown on the General Arrangement Floor Plan.
6. Bolt to door frames at both ends of the line up.
7. Install new Plates (Item 10) mounting Filter (Item 11) salvaged from front Plate (Item 7).
8. Install adaptor floor Plates (Item 12) between the new units and the I-Beam (Item 9).
9. Mount Roof Covers (Item 4) on the new units, bolting together using special Channel Brackets (Item 13) similar to the aisle construction just disassembled.
10. Add Trim Angle (Item 14) at each end of the group.
11. When installing conduit, Drill Plate (Item 15) to suit and clamp down with Angle (Item 16).

12. Place aisle Roof Decks (Item 17) into place bolting to the Roof Support (Item 18) using Bevel washers (Item 19).
13. Bolt Roof Decks (Item 17) together using Brackets (Item 13). See view A.
14. Mount Covers (Item 20) in place by sliding onto Brackets (Item 13).
15. Add Trim Angle (Item 21) to each end of the aisle.
16. Bolt Hoods (Item 22) over the roof channels.
17. Add Covers (Item 23) to seal crack at top of Door Frame (Item 8) and end Plate (Item 24) joint mount light as shown.



ITEM	DESCRIPTION	5 KV	
		PART NO.	MK
1	GABLE END ASSEM.	18-177-259	501
2	ROOF GABLE ASSEM.	18-177-200	
3	ROOF CHANNEL ASSEM.	18-176-983	501
4	ROOF COVER ASSEM.	18-177-195	501
5	FORMED COVER	18-287-990	001
6	PLATE	18-297-103	
7	FRONT PLATE	18-286-858	
8	DOOR MOUNTING	18-454-339	
9	I-BEAM		
10	PLATE	18-288-740	
11	AIR FILTER	18-156-742	001

12	FLOOR PLATE	18-179-742	001
13	BRACKET	18-176-985	001
14	ANGLE	18-177-261	001
15	PLATE	18-177-174	001
16	ANGLE	18-178-032	001
17	DECK	18-288-735	501
18	ROOF SUPPORT	18-287-025	001
19	SQ. BEVEL WASHER	00-659-035	414
20	COVER	18-179-730	001
21	ANGLE	18-179-733	001
22	HOOD	18-288-739	001
23	COVER	18-179-735	001
24	END PLATE ASSEM.	18-286-860	

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