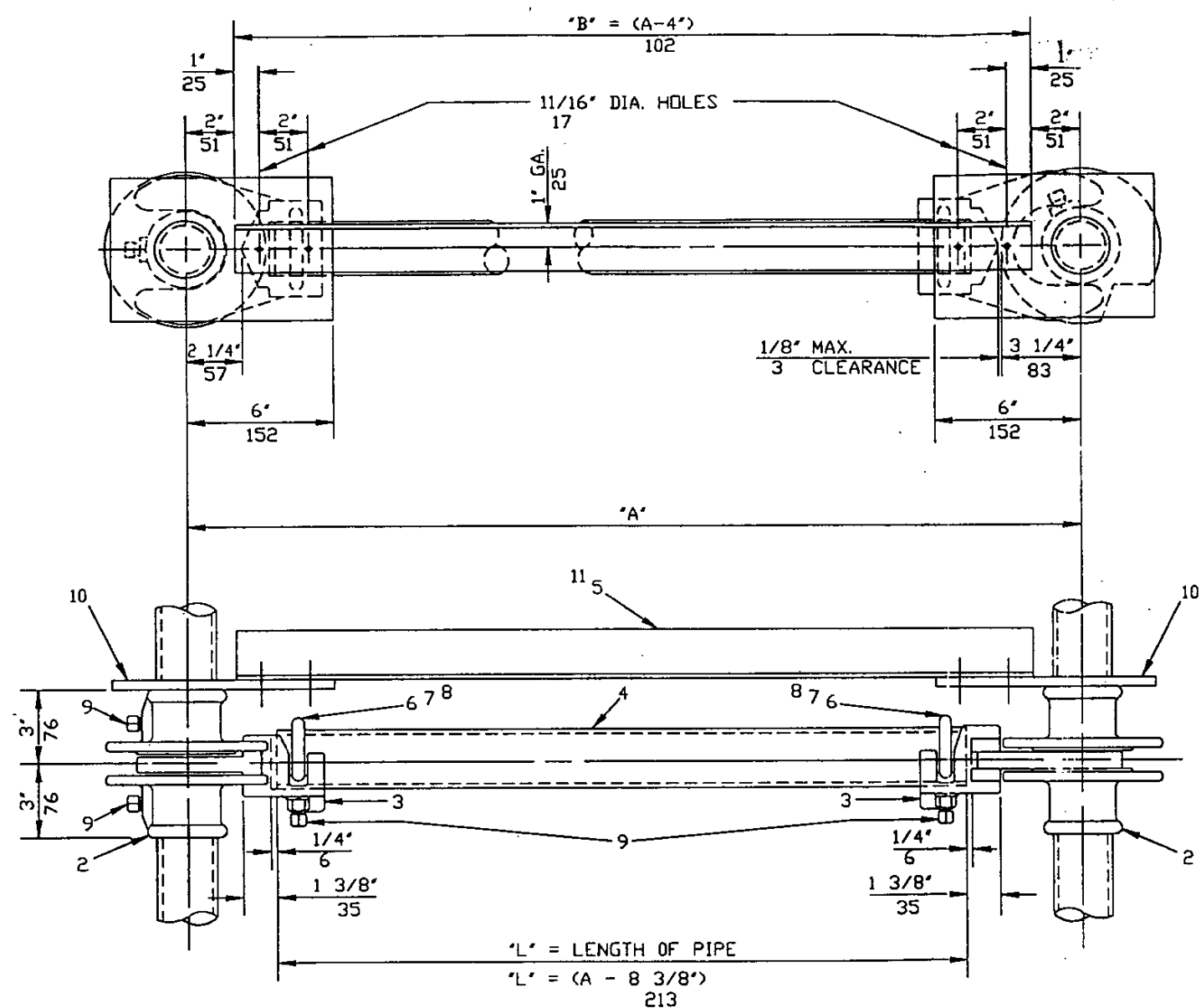


DWG. DIMENSIONED IN FEET & INCHES AND MILLIMETERS TO NEAREST MILLIMETER.

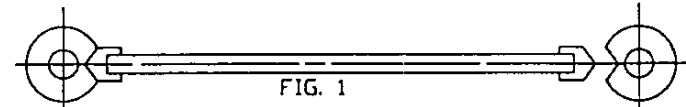


MIN. 'A' DIM.= 14'-356
MAX. 'A' DIM.= 16'-0" 4877

MARK			ITEM		PART NAME		DWG.	MARK	NOTE
303	302	301	1	1	INTERLOCK ASSEMBLY	THIS			*
1	2	2	2	2	DISC. CASTING (1 1/2" IPS)	308-864	001		
1	2	2	2	2	DISC. CASTING (2" IPS)	308-865	001		
2	2	2	3	3	STOP CASTING	217-953	301		
1	1	1	4	4	2" IPS GALV. ST'L PIPE (SCH.#10) x 'L' LG.				
1	1	1	5	5	3/16" x 2" x 2" GALV. ST'L ANGLE x 'B' LG.				
2	2	2	6	6	U-BOLT (2" IPS)	207-773	025		
4	4	4	7	7	1/2" GALV. ST'L LOCKWASHER				
4	4	4	8	8	1/2"-13 A.S. HEX. GALV. ST'L NUT				
6	6	6	9	9	1/2"-13 x 1 1/2" SQ. HD. FULL DOG PT. S.S. SET SCR. CODE# 812905				⊕
1		2	10	10	BEARING PLATE (1 1/2" IPS)	208-801	002		
1	2		10	10	BEARING PLATE (2" IPS)	208-801	003		
4	4	4	11	11	5/8"-11 x 1 1/4" A.S.H. GALV. SM. BOLT & NUT				
PRINT	PRINT	PRINT	12	12	INSTRUCTIONS (SALES PRINT)	THIS			

INSTALLATION AND ADJUSTMENT

1. BEARING PLATES (IT.-10) & DISC. CASTINGS (IT.-2) MUST BE PLACED ON OPER. PIPES AT APPROX. LOCATIONS. TIGHTEN PIERCING SET SCREWS SLIGHTLY TO HOLD DISC. CASTINGS IN PLACE.
2. ASSEMBLE ONE STOP CASTING (IT.-3) TO ONE END OF 2" PIPE (IT.-4) & PLACE BETWEEN FLANGES ON DISC. CASTING (IT.-2). PLACE THE OTHER STOP CASTING BETWEEN FLANGES ON THE OTHER CASTING. THEN DROP THE FREE END OF 2" PIPE INTO STOP CASTING USING U-BOLT TO HOLD 2" PIPE IN PLACE. WITH DISC. IN POSITION AS SHOWN, ADJUST 2" PIPE ASSEMBLY TO OBTAIN 1/8" MAX. CLEARANCE.
3. OPEN BOTH MAIN & GR'D. SWITCHES. POSITION DISC. ON BOTH OPER. PIPES SO THAT V-GROOVES FACE EACH OTHER & STOP CASTINGS ON BOTH ENDS OF 2" PIPE (IT.-4) CAN ENGAGE FULLY WITH BOTH DISC. CASTINGS. (SEE FIG.#1)
4. TIGHTEN U-BOLTS SECURELY. AFTER SEVERAL TRIAL OPERATIONS, TIGHTEN ALL PIERCING SET SCREWS (IT.-9) UNTIL HOLE IS ACTUALLY PUNCHED IN PIPE. AT THIS POINT THE EFFORT TO TIGHTEN SET SCREW WILL REDUCE SUBSTANTIALLY. CONTINUE TURNING UNTIL SET SCREW SEATS AND IS COMPLETELY TIGHT.
5. ASSEMBLE SUPPORT ANGLE (IT.-5) TO BEARING PLATES.



- ⊕ SHOP NOTE:
LUBRICATE THREADS OF SET SCREWS (IT.-9) WITH 'LUBRI-KOTE' TYPE A 1040 CR.
- * SPECIFY 'A' DIM.

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MECHANICAL INTERLOCK ASSEMBLY
FOR 1 1/2" & 2" I.P.S. OPER. PIPE

ASEA BROWN BOVERI
P.O. Box 38, Bland, Va. 24315
Telephone 703-688-3328

SCALE	3" = 12"	ASSY DWG
SHEET OF	FG JTZ WK	308-861 11

RELATED DWG'S:
308-862
308-863-WITHOUT CENTER YOKE & FOR USE WITH 2 1/2" IPS.
309-154-WITH CENTER YOKE & FOR USE WITH 2 1/2" IPS & 2" IPS.
309-551-WITHOUT CENTER YOKE & FOR USE WITH 2" EX. HV'Y IPS TO 2" EX. HV'Y IPS.
317-800-SPANISH

REV. DESCRIPTION & DATE
01 OCT. 5, 1965
REDRAWN ON AUTOCAD
TKI.
11 APR. 27, 1992 SED HWY