

NOTE: HEATING ELEMENT VOLTAGE RATING MUST BE 470 VOLTS.

TOLERANCES UNLESS
OTHERWISE SPECIFIED

FRACTIONS	-	$\frac{1}{16}$
.0	-	.032
.00	-	.015
.000	-	.005
ANGLES	-	1°

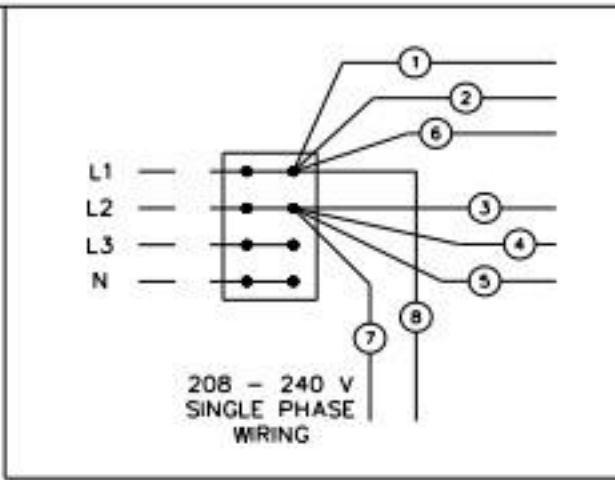
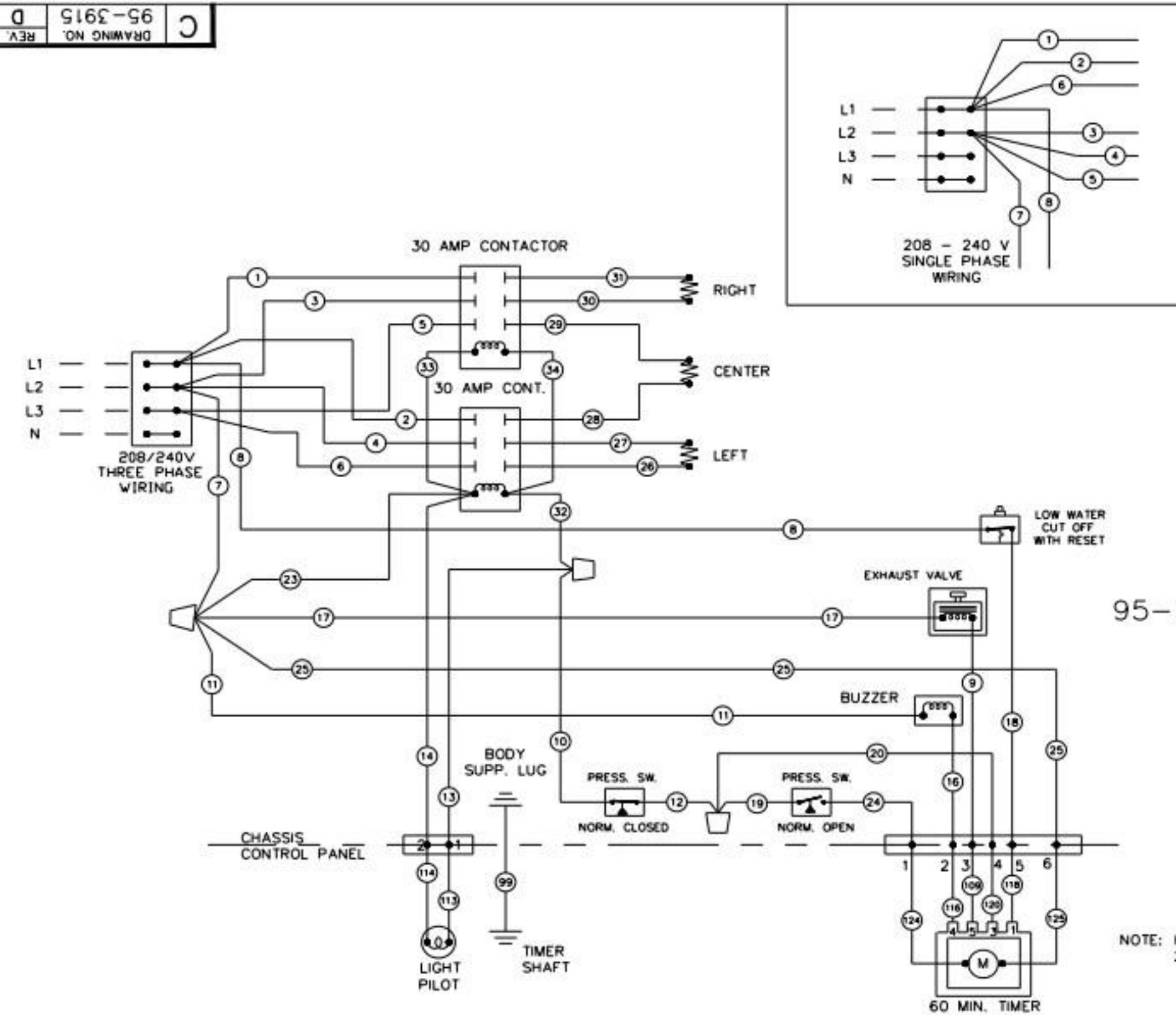
DE-BURNING - MARKET FORCE SPECIFICATION#127
CLASS I ☐ CLASS II ☐ CLASS III ☐

USED ON
95-3094

Market Forge INDUSTRIES INC. EVERETT, MA 02149

WIRING DIAGRAM-STE 440/460/480 VOLTS

DRAWN	AE	CHECKED	ENG. APP.	C	(DRAWING NO) 95-3914	REV. C
DATE	12-30-97	SCALE	INFO. APP.			

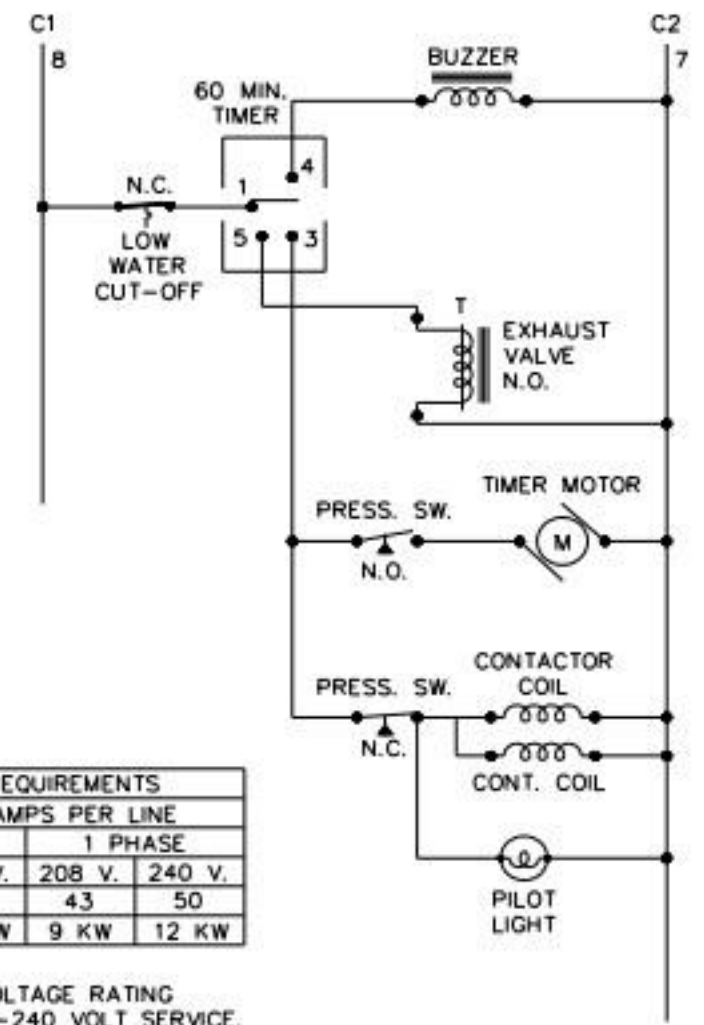


95-3915-D

POWER REQUIREMENTS			
NOMINAL AMPS PER LINE			
3 PHASE		1 PHASE	
208 V.	240 V.	208 V.	240 V.
25	29	43	50
9 KW	12 KW	9 KW	12 KW

NOTE: HEATING ELEMENT VOLTAGE RATING
236 VOLTS FOR 208-240 VOLT SERVICE.

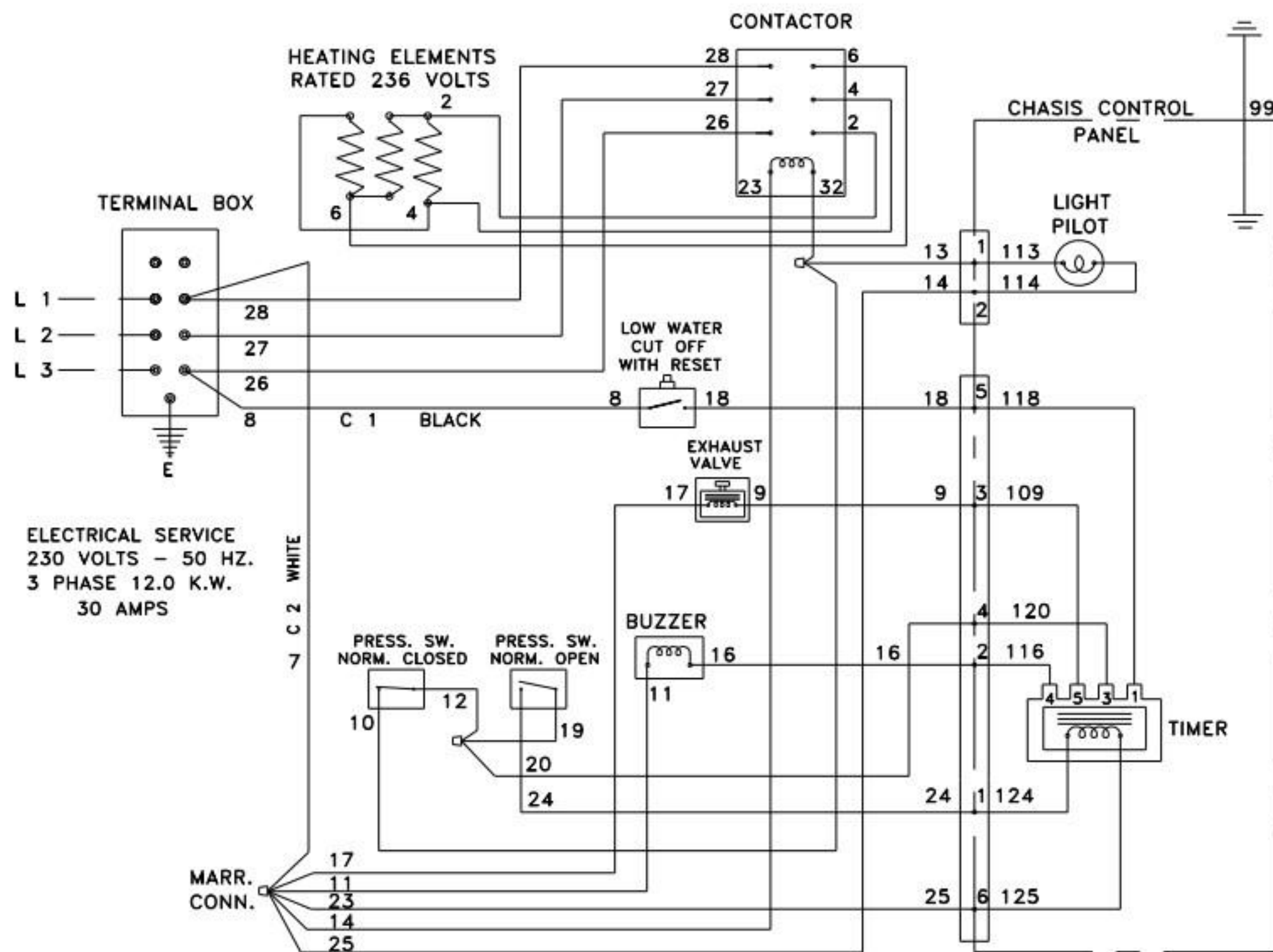
208-240 V. 50 & 60 HZ



CONTROL CIRCUIT

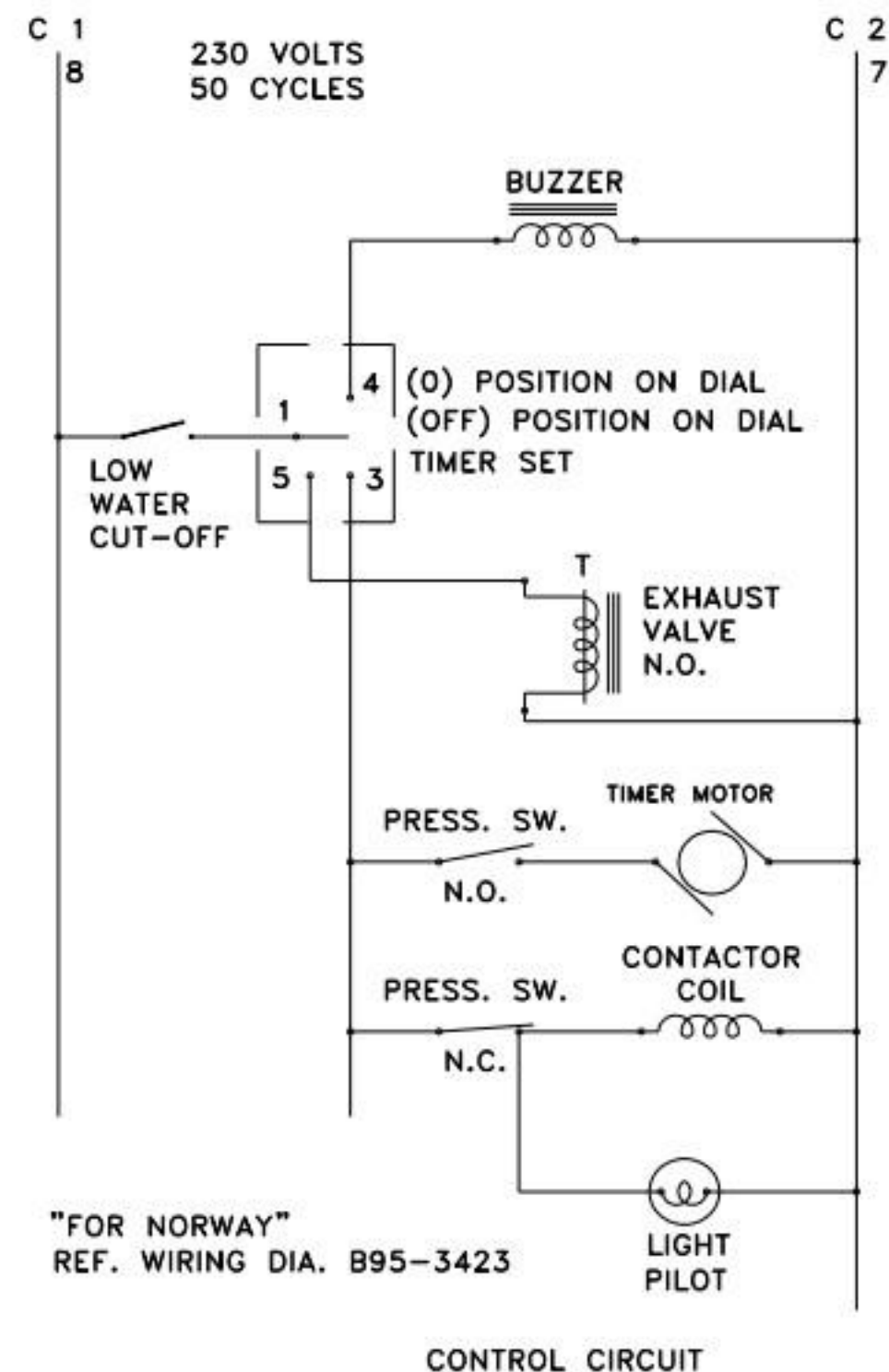
SYM	DATE	REV./EDM #	BY
C	9/12/96	UPDATE TO AUTOCAD DB	ECN 10055
D	4/2/07	REMOVED PER MARKED UP AND DRAWING TO COMPLY TO JUL 97. SEE RECORD PRINT.	ECN 10822

TOLERANCES UNLESS OTHERWISE SPECIFIED		DE-BURRING - MARKET FORGE SPECIFICATION 127	
FRACTIONS		CLASS I CLASS II CLASS III	
.0		+ .032	
.00		+ .015	
.000		+ .005	
ANGLES		+ 1°	
USED ON		Market Forge INDUSTRIES INC. EVERETT, MA 02149	
A10-6598		WIRING DIAGRAM-STE 208-240 V., 1 Ø, 3 Ø	
95-3944		DRAWN R. COHN	
95-3945		CHECKED	
95-3952		ENG. APP.	
DATE 9/12/96		SCALE FULL	
		WFL APP.	
		C	
		DRAWING NO. 95-3915	
		REV. D	



WIRING:

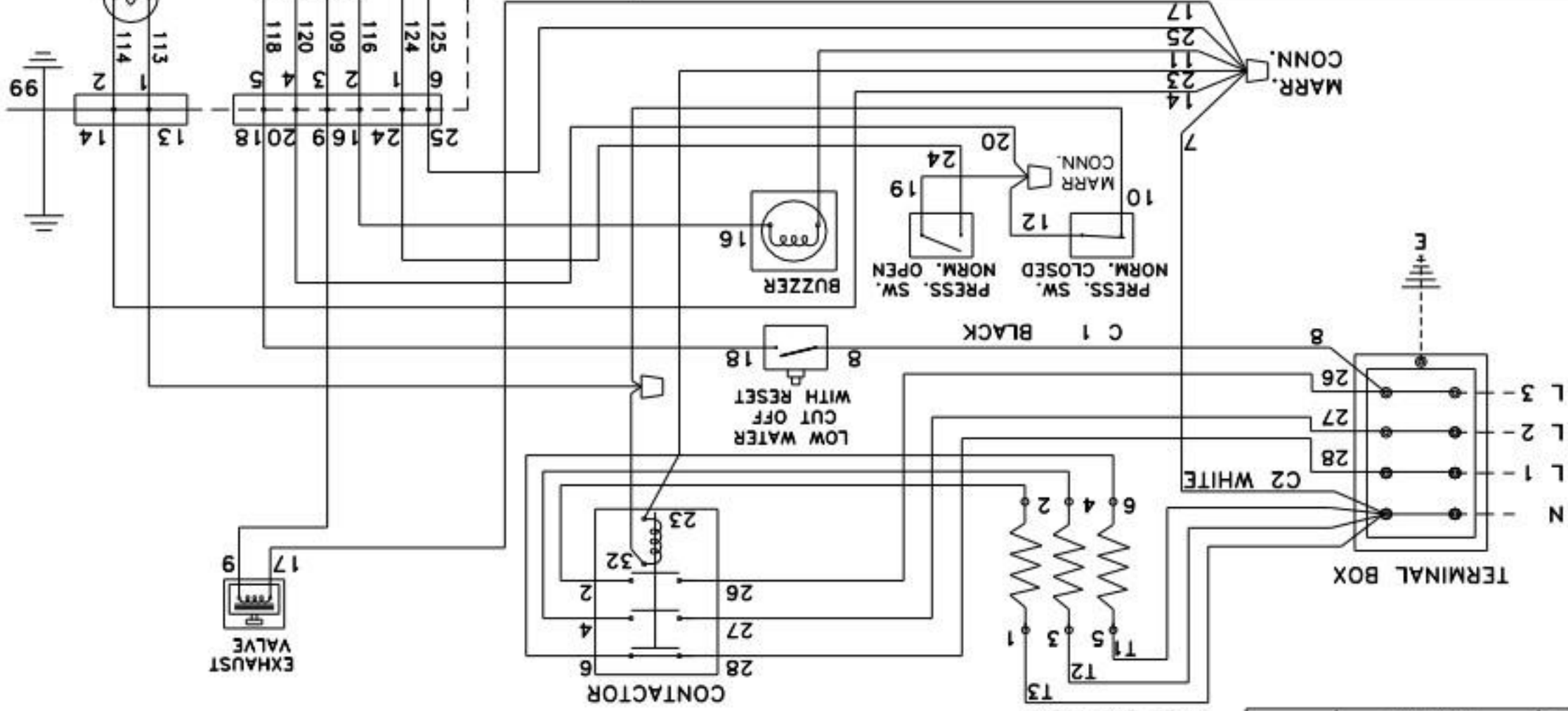
1. LEADS 13, 14, 113, 114 ARE 18 AWG. 16 STRAND.
ALL OTHER CONTROL WIRING #16 AWG 28 STRAND
U.L. CSA LISTED G.E. CLR 125-LINK 600 V. 125°C
2. HEATING ALL WIRING #10 AWG 105 STRAND U.L. CSA
LISTED GE.S1-53032 600V. 125°C.



SYM	DATE	REV/COM#	BY
A	7-16-74	REMOVE SLOWER CONTROL, THERMOSTAT & ON-OFF SW. ECH 5056	C.P.
B	9-3-76	ADDED VOLTAGES AND WIRING NOTE, ECO 5060	F.B.
C	2-27-91	REVISD TO SHOW PANEL MT. COMP'S. EDM 9109	C.P.

C	DRAWING NO. 95-3423	B
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HEATING ELEMENTS RATED 236 VOLTS



FOR 3 PHASE-4 WIRE CONNECTION: (380/220 OR 415/240 V.)
 CONNECT L1 L2 L3 TO THE 3 INCOMING PHASE
 CONNECT N TO THE INCOMING NEUTRAL
 CONNECT E TO THE INCOMING EARTH (GROUND WIRE)

FOR 3 PHASE-3 WIRE CONNECTION: (380V. OR 415 V.)
 CONNECT L1 L2 L3 TO THE 3 INCOMING PHASE
 CONNECT E TO THE INCOMING EARTH (GROUND WIRE)

DO NOT CONNECT ANY INCOMING WIRES TO N
 REMOVE CONTROL CIRCUIT WIRE C1 FROM L3
 REMOVE CONTROL CIRCUIT WIRE C2 FROM N
 CONNECT SEPARATE 220/240 VOLT SUPPLY ONLY TO C1 C2
 FOR SINGLE PHASE CONNECTION: (220V./ OR 240V.)
 BRIDGE L1 L2 L3 AND CONNECT TO INCOMING PHASE
 CONNECT N TO INCOMING NEUTRAL
 CONNECT CONTROL CIRCUIT WIRE C1 TO L3
 CONNECT CONTROL CIRCUIT WIRE C2 TO N

NOTE: FOR NORWAY
 230V., 3PH., 50 HZ., 3 WIRE
 ELECTRICAL SERVICE USE
 WIRING DIA. B95-3775

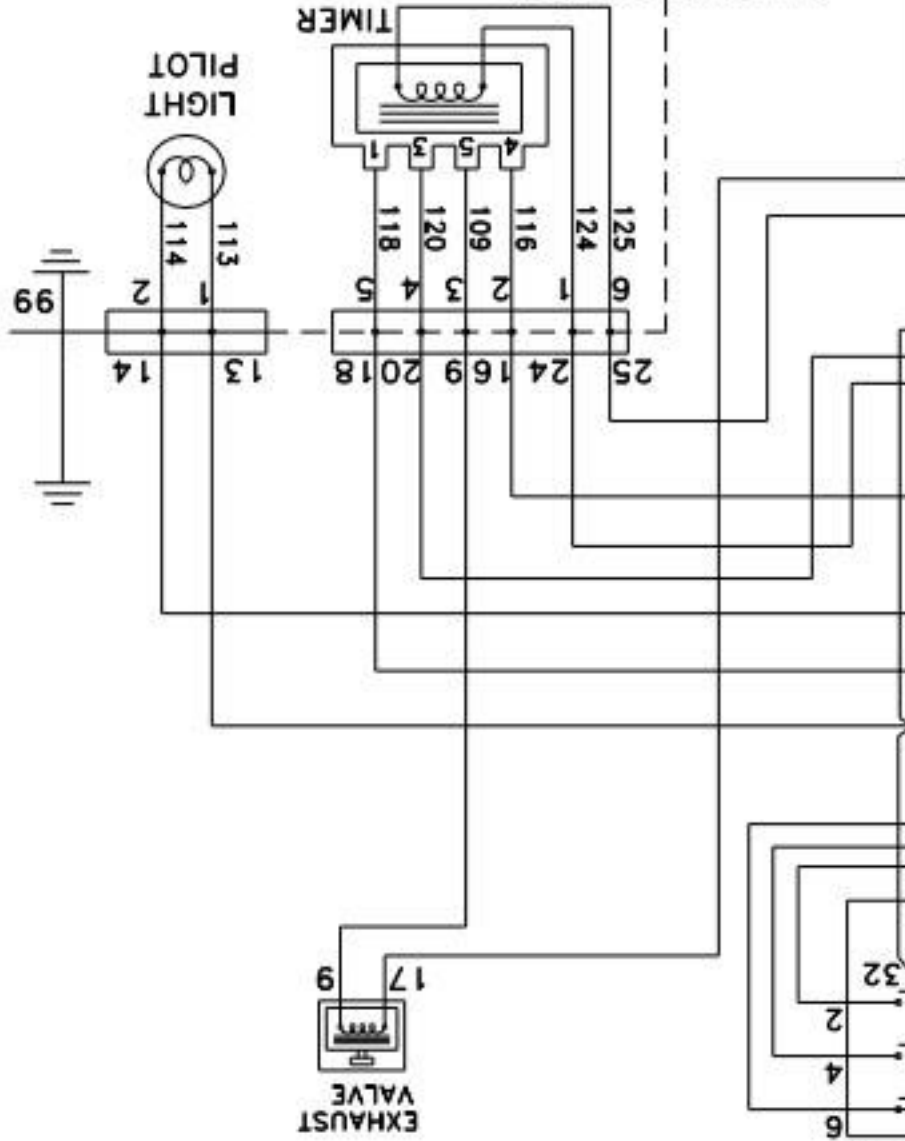
TOLERANCES UNLESS OTHERWISE SPECIFIED

FRACTIONS $\pm 1/16$

ANGLES
 .0 .032 .005
 .00 .015 .000
 - - -
 + + +

POWER REQUIREMENTS			
NOMINAL AMPS. PER WIRE			
1 PHASE			
380 V.	415 V.	220 V.	240 V.
16	17	48	51
12.0 KW			

CHASSIS CONTROL PANEL



USED ON
 B95-3502
 B/M 95-3096

DE-BURING - MARKET FORGE SPECIFICATION#127
 CLASS I ☐ CLASS II ☐ CLASS III ☐

MARKET FORGE

WIRING AND SCHEMATIC DIAGRAM FOR STEAM-IT
 MODEL ST-E FOR USE IN WESTERN EUROPE

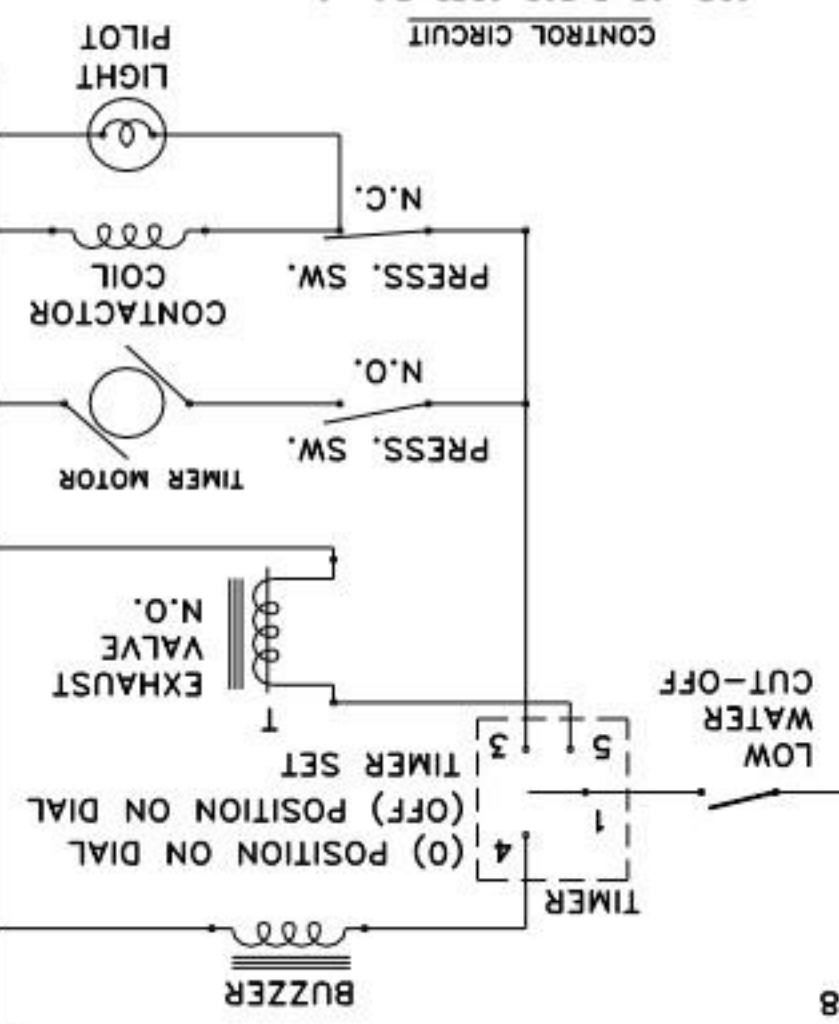
DRAWN A.E.	CHECKED	ENG. APP.	MFG. APP.
DATE 7-21-97	SCALE	NONE	

B

95-3423

C

220/240 VOLTS 50 CYCLES



MODEL ST-E FOR OPERATION ON
 380/415 VOLT- 3 PHASE SUPPLY
 OR
 220/240 VOLT-SINGLE PHASE SUPPLY
 50 CYCLES
 ALL HEATING ELEMENTS RATED 236 VOLTS

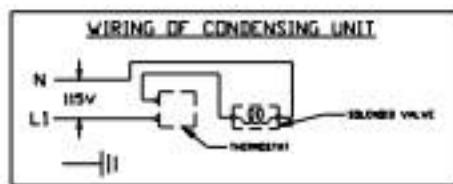
WIRING:
 1. CONTROLS-ALL WIRING #16 AWG 26 STRAND U.L.
 CSA LISTED G.E. CLR125X-LINK 600 V. 125°C.
 2. HEATING-ALL WIRING #10 AWG 105 STRAND U.L.
 CSA LISTED G.E. SI-53032 600V. 125°C.

EVERETT, MA 02149

ITEM	PART #	DESCRIPTION	QTY
1	C95-2119	STEAM CONDENSING UNIT	1
2	C95-2219	THERMOSTAT BOX ASSEMBLY	1
3*	B95-0086	EXHAUST LINE STERILIZER	1
3*	B95-0260	EXHAUST LINE STEAM-IT	1
4*	10-1017	COMPR. ADAPTER, 3/8 IPS X 5/8 O.D.	1
5	15-7057	COPPER TUBING, 3/8 O.D.	22 1/4'
6	10-1775	RD HD MACH SCREW, 1/4-20	2
7	10-2500	LOCKWASHER, 1/4	2
8	10-2308	HEX NUT, 1/4-20	2
9	10-1812	RD HD MACH SCREW, 10-32	2
10	10-2505	LOCKWASHER, 10	2
11	10-2340	HEX NUT, 10-32	2
12	B95-4009	FRONT TEMPLATE (7" LONG)	1
13	B95-4010	BACK TEMPLATE (11" LONG)	1

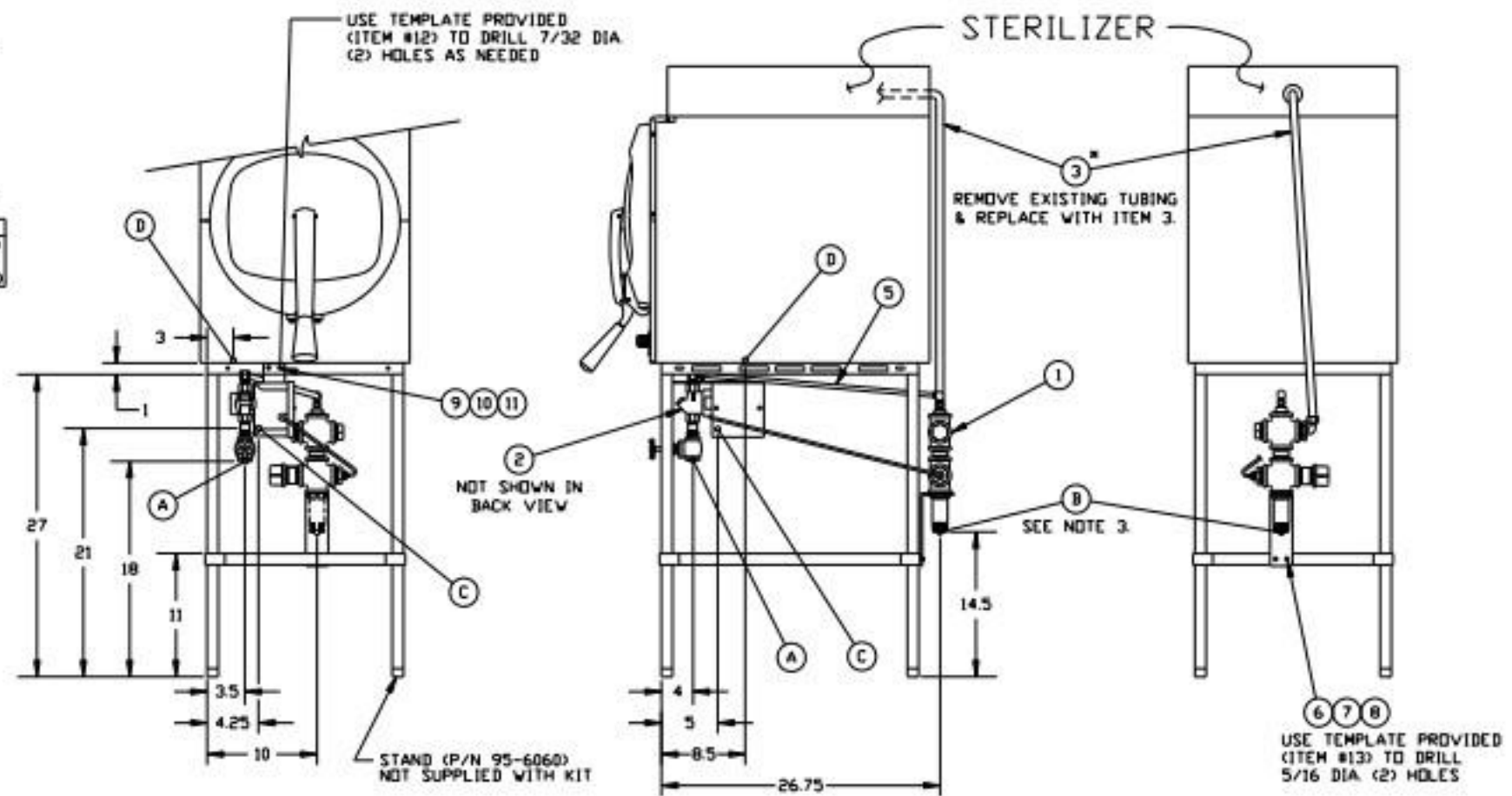
- NOTES:
- *1. B95-0086 USED ON STERILIZER ONLY.
B95-0260 & 10-1017 USED ON STEAM-IT ONLY.
 - UNIT MUST BE GROUNDED AND ALL WIRING TO COMPLY WITH LOCAL CODES.
 - PIPE TO OPEN DRAIN. DO NOT MAKE SOLID CONNECTION TO SEWER.
 - CONDENSING UNIT TO BE INSTALLED AS TO HAVE A BACK TO FRONT PITCH.

SERVICE CONNECTIONS REQUIRED	
A	1/2" I.P.S. COLD WATER CONNECTION
B	1" I.P.S. DRAIN CONNECTION (SEE NOTE 3.)
C	115V ELEC. CONN. - 7/8 DIA. KNOCKOUT (COND. UNIT)
D	ELECTRICAL CONNECTION



NOM. AMPS PER WIRE * STERILIZER					
PHASE	3 PHASE	1 PHASE	208V (197-219)	236V (220-240)	
VOLTS	208	236	208	236	DR
AMPS	34	31	58	53	

NOM. AMPS PER WIRE * STEAM-IT					
PHASE	3 PHASE	1 PHASE	208V (197-219)	236V (220-240)	
VOLTS	208	240	440	480	208 240
AMPS	25	29	16	16	4.3 50



INSTALLATION INSTRUCTIONS - COLD WATER CONDENSING UNIT STERILIZER & STEAM-IT A17-0072 REV. C

SYN	DATE	REV	EDM	BY	D.L.
C	12/21/00				