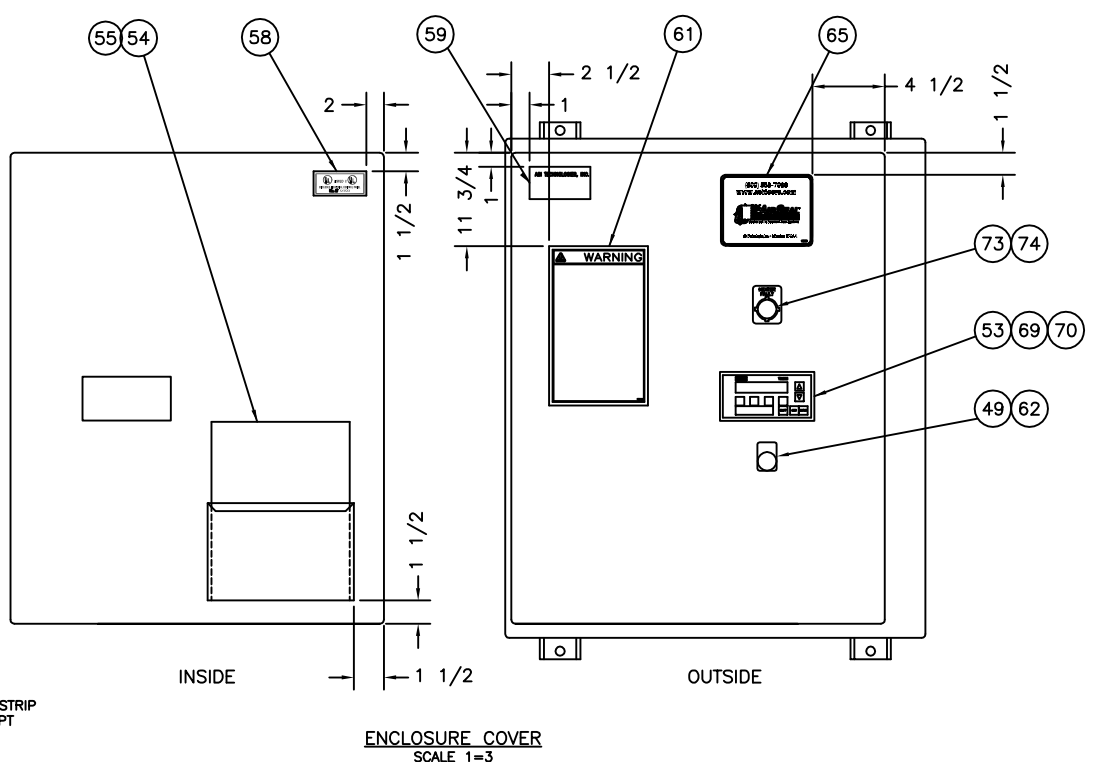


| BILL OF MATERIAL |                                           |          |      |     |                                        |
|------------------|-------------------------------------------|----------|------|-----|----------------------------------------|
| QTY              | DESCRIPTION                               | PART NO. | ITEM | QTY |                                        |
| 2                | BARRIER, TERMINAL BLOCK                   | 22A009   | 40   | 1   | ENCLOSURE, 30 X 24, DRILLED            |
| 6                | BLOCK, TERMINAL, GROUNDING                | 22A102   | 41   | 1   | SUBPANEL                               |
| 1                | SEPARATOR, LINK RAIL                      | 22A019   | 42   | 1   | CONNECTOR, MECHANICAL, ALUMINUM        |
| 3                | LINK, RAIL, 2 POSITION                    | 22A010   | 43   | 1   | BLOCK, POWER DISTRIBUTION              |
| 1                | BLOCK, FUSE, 3 POLE, CLASS CC             | 23A261   | 44   | 2   | BRACKET, DIN RAIL                      |
| 1                | SCR, 45 AMP, 277-600V                     | 23B067   | 45   | 1   | RAIL, DIN, 175 mm                      |
| 1                | SWITCH, SELECTOR, 2-POS.                  | 23A262   | 49   | 1   | RAIL, DIN, 300 mm                      |
| 1                | DISPLAY, TEXT                             | 23A260   | 53   | 1   | RAIL, DIN, 375 mm (14.76")             |
| 1                | ENVELOPE                                  | 17A036   | 54   | 1   | TRANSFORMER, 208/230/460V TO 24/120V   |
| 1                | DRAWING, AIR-SEAL DOOR                    | 18D230   | 55   | 1   | VARIABLE FREQUENCY DRIVE, 460 VAC      |
| 1                | LABEL, SUBPANEL                           | 17B020   | 56   | 1   | CONTACTOR, HEATER                      |
| 1                | LABEL, UL 508                             | 17A107   | 58   | 1   | PROGRAMMABLE LOGIC CONTROLLER          |
| 1                | LABEL, RATING PLATE                       | 17A213   | 59   | 1   | PROGRAM, SIEMENS PLC                   |
| 1                | LABEL, AIR-SEAL WARNING                   | 17B026   | 61   | 1   | EXPANSION MODULE, PLC, 4 ANALOG INPUT  |
| 1                | NAMPELATE, 2 POSITION, OFF/ON             | 22A096   | 62   | 1   | EXPANSION MODULE, PLC, 2 ANALOG OUTPUT |
| 1                | LABEL, AIR-SEAL LOGO                      | 17B029   | 65   | 1   | POWER SUPPLY, 24VDC, 1.3 AMPS          |
| 4                | SCREW, #6-32 X .375", PAN, PHL, TYPE "F"  | 41A720   | 66   | 1   | BLOCK, FUSE, 2 POLE, MIDGET            |
| 30               | SCREW, #10-32 X .375", PAN, PHL, TYPE "F" | 41A721   | 67   | 2   | FUSE, CLASS CC, 1 AMP                  |
| 8                | SCREW, #10-32 X 1.000", PAH, PHL, ZN      | 41A176   | 68   | 1   | FUSE, MIDGET, 6/10 AMP                 |
| 1                | LABEL, AIR-SEAL DISPLAY INSERT            | 17A217   | 69   | 1   | FUSE, MIDGET, 3 AMP                    |
| 1                | LABEL, OPTIMIZER, AIR-SEAL DOOR           | 17A214   | 70   | 18  | BLOCK, TERMINAL                        |
| 1                | COVER, SAFETY, POWER DISTRIBUTION BLOCK   | 22A0152  | 71   | 3   | BLOCK, TERMINAL                        |
|                  |                                           |          | 72   | 4   | RETAINER, END                          |
| 1                | LIGHT, PILOT                              | 23A040   | 73   | 1   | BLOCK, FUSE, 3 POLE, FORM 101          |
| 1                | NAMEPLATE, HEATER FAULT                   | 22A104   | 74   | 3   | FUSE, FORM 101, 63 AMPS                |
| 1                | LABEL, DRILLING ENCLOSURE                 | 17A231   | 75   | 3   | FUSE, CLASS CC, 12 AMP                 |
|                  |                                           |          |      | 18  | LABEL, TERMINAL BLOCK                  |



| REV | CHG# | DATE     | BY  | REVISION                                                                | REV | CHG# | DATE    | BY  | REVISION                                                                                      |
|-----|------|----------|-----|-------------------------------------------------------------------------|-----|------|---------|-----|-----------------------------------------------------------------------------------------------|
| L   | 3004 | 01/15/16 | DEN | DEL 23A0381, CHG 23A0380                                                | H   | 2604 | 9-27-07 | TJK | ADDED TORQUE #5 & #6.                                                                         |
| K   | 2920 | 1-7-14   | DEN | CHANGE DISTRIBUTION BLOCK & COVER 23A0480 WAS 23A206 22A0152 WAS 22A103 | G   | 2483 | 5-24-06 | TJK | ADDED NOTE #4                                                                                 |
| J   | 2860 | 02/18/13 | KWG | 22A006 WAS 22B027                                                       | F   | 2349 | 8-5-05  | TJK | NO CHANGE ON THIS SHEET                                                                       |
| I   | 2811 | 2-13-12  | DEN | CHG ITEM #14 & #72                                                      | E   | 2330 | 3-8-05  | TJK | ADDED (1) 17A231, ITEM #75                                                                    |
|     |      |          |     |                                                                         | D   | 2136 | 4-21-03 | TDR | ADDED TORQUE AND STRIP LENGTH NOTES ADDED ITEMS 72, 73, 74 ADDED HEATER FAULT INDICATOR LIGHT |
|     |      |          |     |                                                                         | C   | 2105 | 11-7-02 | TDR | ITEM 41 WAS 11B039                                                                            |
|     |      |          |     |                                                                         | B   | 2065 | 8-19-02 | TDR | SHIFTED COMPONENTS                                                                            |
|     |      |          |     |                                                                         | A   | 1893 | 7-29-02 | TDR | DREW MISSING TERMINAL & DIVIDER                                                               |

SHEET 1 OF 3

PART TO BE CLEAN, DEBURRED, AND FREE OF SHARP EDGES

**ASI DOORS, INC.**  
5848 NORTH 95th COURT MILWAUKEE, WISCONSIN 53225

ASM, PLC, CONTROL PANEL  
AIR-SEAL DOOR, 460 VAC

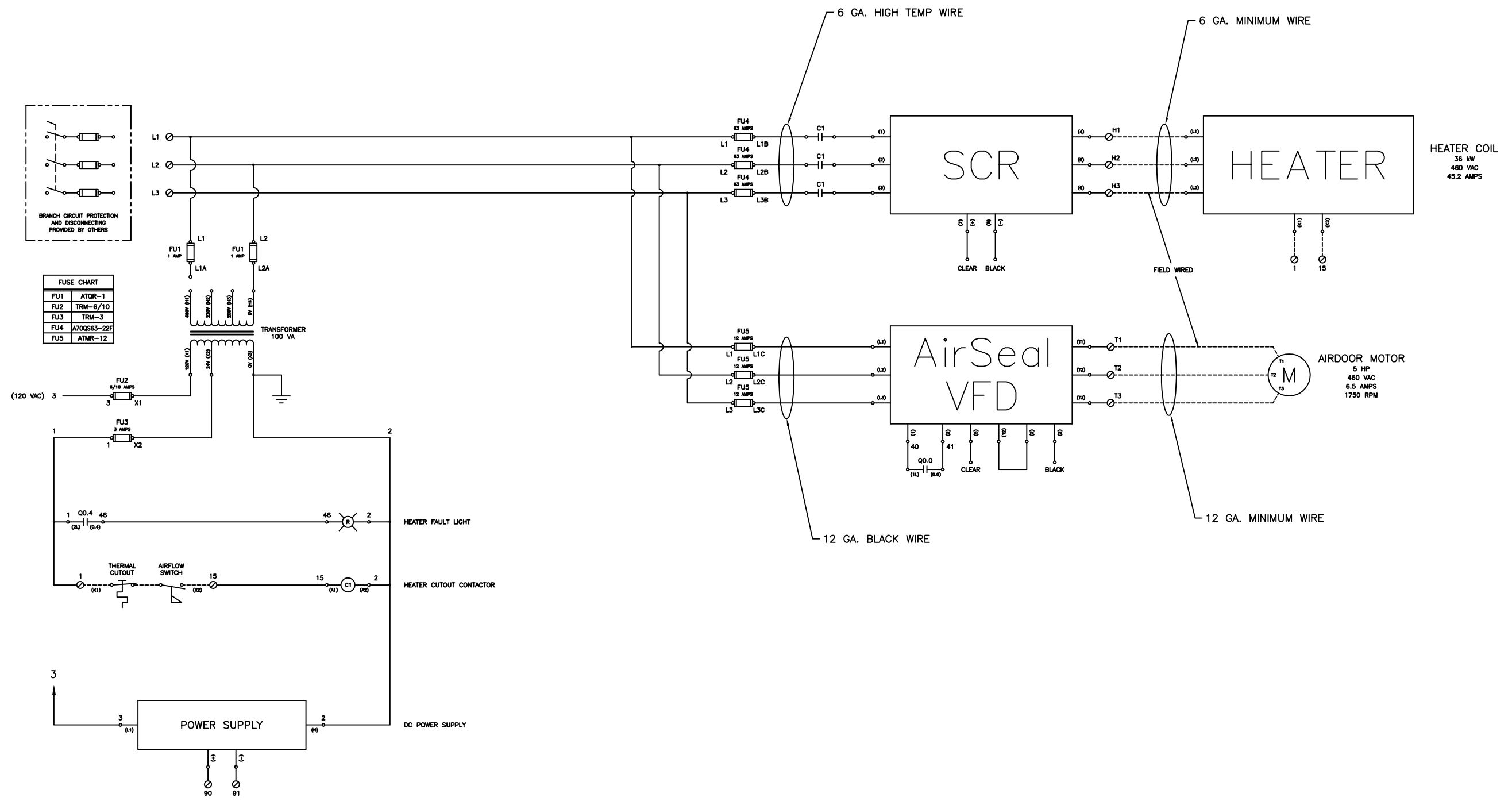
TOLERANCES UNLESS OTHERWISE NOTED  
X.X ±.06 X.XX ±.03 X.XXX ±.010  
DIA, FINISH ±.005 ANGLES ±1°

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OWN BY EDR # DATE 3-13-02  
TDR 2001

EXP. NO. DRAWING NO. REV NO.  
18D230 L

SCALE 1=1



NOTE: ——— FACTORY WIRED  
 - - - - - FIELD WIRED

SHEET 2 OF 3

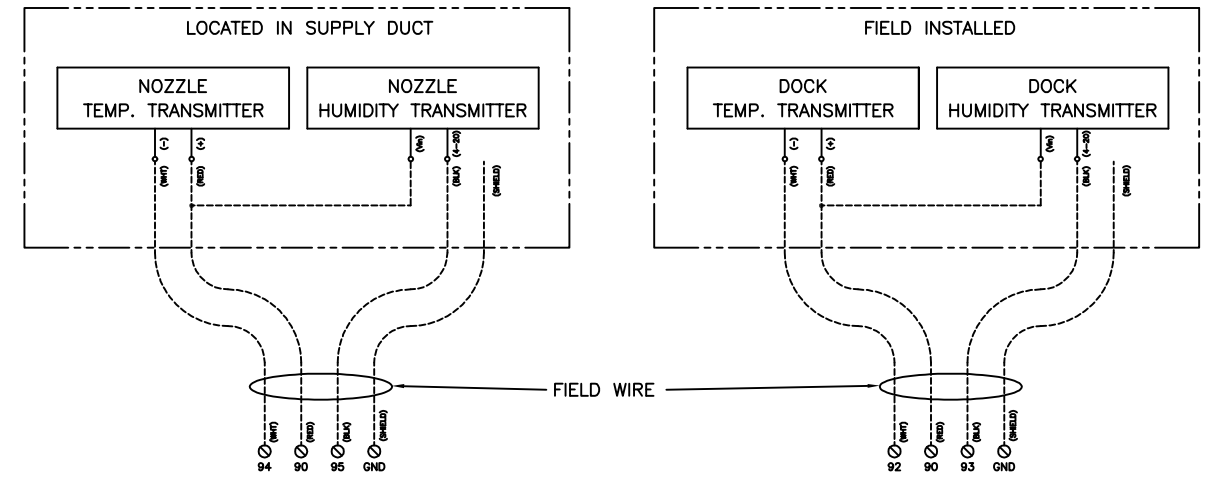
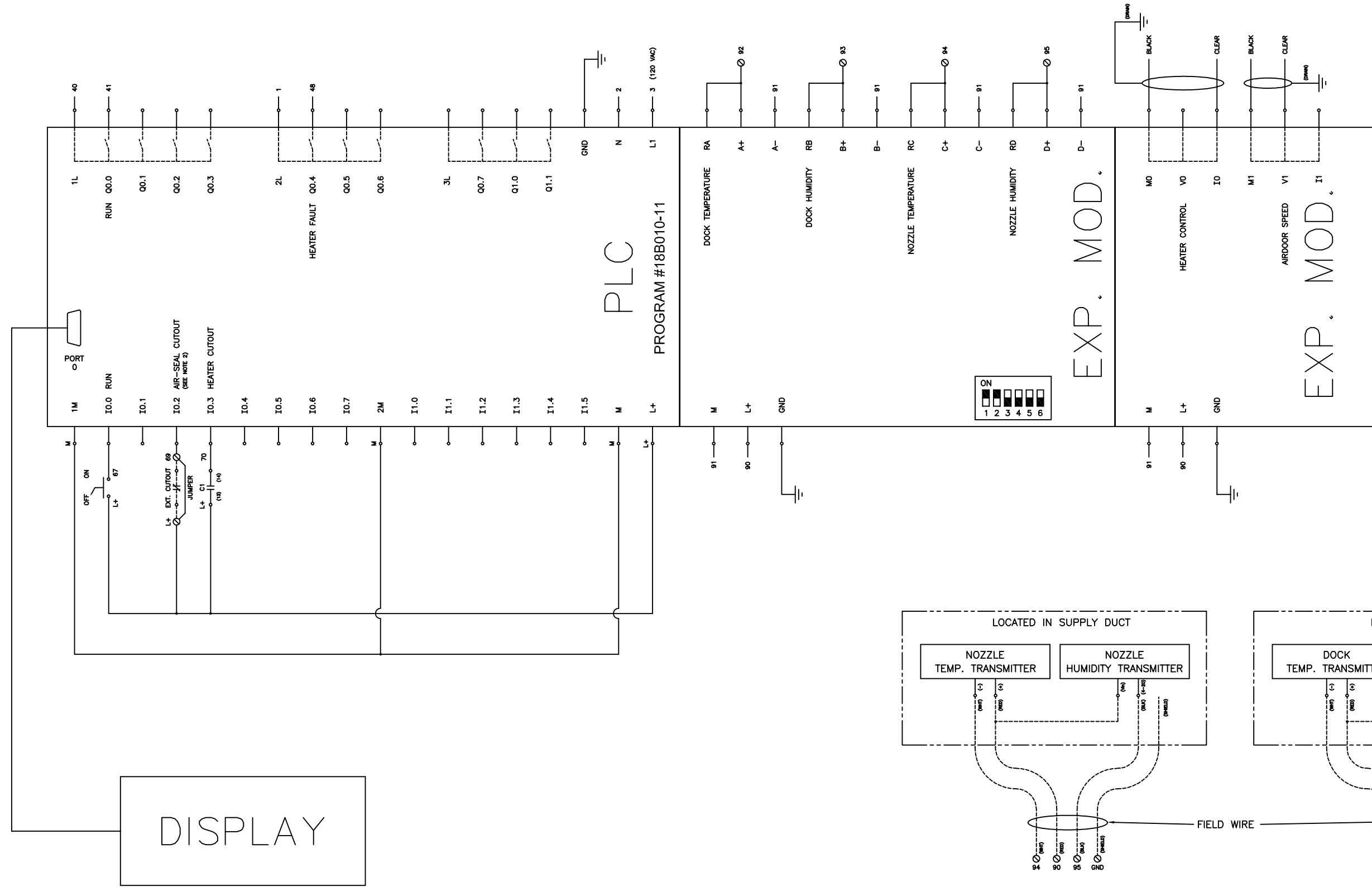
PART TO BE CLEAN, DEBURRED, AND FREE OF SHARP EDGES

**ASI DOORS, INC.**  
 5848 NORTH 95th COURT MILWAUKEE, WISCONSIN 53225

ASM, PLC, CONTROL PANEL  
 AIR-SEAL DOOR, 460 VAC

| REV | CHG# | DATE     | BY  | REVISION                          | REV | CHG# | DATE    | BY  | REVISION                            |
|-----|------|----------|-----|-----------------------------------|-----|------|---------|-----|-------------------------------------|
| L   | 3004 | 01/15/16 | DEN | DEL 23A0381, CHG 23A0380          | H   | 2604 | 9-27-07 | TJK | ADDED NOTES #5 & #6.                |
| K   | 2920 | 1-7-14   | DEN | CHANGE DISTRIBUTION BLOCK & COVER | G   | 2483 | 5-24-06 | TJK | ADDED NOTE #4                       |
| J   | 2860 | 02/18/13 | KWG | 23A0480 WAS 23A206                | F   | 2349 | 8-5-05  | TJK | NO CHANGE ON THIS SHEET             |
| I   | 2811 | 2-13-12  | DEN | CHG ITEM #14 & #72                | E   | 2330 | 3-8-05  | TJK | ADDED (1) 17A231, ITEM #75          |
|     |      |          |     |                                   | D   | 2136 | 4-21-03 | TDR | ADDED TORQUE AND STRIP LENGTH NOTES |
|     |      |          |     |                                   | C   | 2105 | 11-7-02 | TDR | ADDED ITEMS 72, 73, 74              |
|     |      |          |     |                                   | B   | 2065 | 8-19-02 | TDR | ADDED HEATER FAULT INDICATOR LIGHT  |
|     |      |          |     |                                   | A   | 1893 | 7-29-02 | TDR | ITEM 41 WAS 11B039                  |
|     |      |          |     |                                   |     |      |         |     | SHIFTED COMPONENTS                  |
|     |      |          |     |                                   |     |      |         |     | DREW MISSING TERMINAL & DIVIDER     |

|                                   |            |           |             |                                                                                                                                                                                                                                   |
|-----------------------------------|------------|-----------|-------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
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| DAI FINISHES ±.005                | ANGLES ±.1 |           |             |                                                                                                                                                                                                                                   |
| OWN BY                            | EGR #      | DATE      | EXP. NO.    | DRAWING NO.                                                                                                                                                                                                                       |
| TDR                               | 2001       | 3-13-02   |             | 18D230                                                                                                                                                                                                                            |
| NEXT ASM.                         | SCALE      | 1=1       |             | REV NO.                                                                                                                                                                                                                           |
|                                   |            |           |             | L                                                                                                                                                                                                                                 |



- NOTES: 1) ——— FACTORY WIRED  
 - - - - - FIELD WIRED
- 2) IF THE AIR-SEAL DOOR IS INTERLOCKED, REMOVE THE JUMPER BETWEEN L+ AND 69 AND WIRE IN THE INTERLOCK CONTACTS(S). AIR-SEAL DOOR WILL OPERATE WHEN L+ TO 69 IS CLOSED.

SHEET 3 OF 3

PART TO BE CLEAN, DEBURRED, AND FREE OF SHARP EDGES

**ASI DOORS, INC.**

5848 NORTH 95th COURT MILWAUKEE, WISCONSIN 53225

TITLE ASM, PLC, CONTROL PANEL  
 AIR-SEAL DOOR, 460 VAC

| REV | CHG# | DATE     | BY  | REVISION                                                                 | REV | CHG# | DATE    | BY  | REVISION                                                                                            |
|-----|------|----------|-----|--------------------------------------------------------------------------|-----|------|---------|-----|-----------------------------------------------------------------------------------------------------|
| L   | 3004 | 01/15/16 | DEN | DEL 23A0381, CHG 23A0380                                                 | H   | 2604 | 9-27-07 | TJK | ADDED NOTE #5 & #6.                                                                                 |
| K   | 2920 | 1-7-14   | DEN | CHANGE DISTRIBUTION BLOCK & COVER 23A0480 WAS 23A206 22A0152 WAS 22A1153 | G   | 2483 | 5-24-06 | TJK | ADDED NOTE #4                                                                                       |
| J   | 2860 | 02/18/13 | KWG | 22A006 WAS 22B027                                                        | F   | 2349 | 8-5-05  | TJK | NO CHANGE ON THIS SHEET                                                                             |
| I   | 2811 | 2-13-12  | DEN | CHG ITEM #14 & #72                                                       | E   | 2330 | 3-8-05  | TJK | ADDED (1) 17A231, ITEM #75                                                                          |
|     |      |          |     |                                                                          | D   | 2136 | 4-21-03 | TDR | ADDED TORQUE AND STRIP LENGTH NOTES<br>ADDED ITEMS 72, 73, 74<br>ADDED HEATER FAULT INDICATOR LIGHT |
|     |      |          |     |                                                                          | C   | 2105 | 11-7-02 | TDR | ITEM 41 WAS 11B039                                                                                  |
|     |      |          |     |                                                                          | B   | 2065 | 8-19-02 | TDR | SHIFTED COMPONENTS                                                                                  |
|     |      |          |     |                                                                          | A   | 1893 | 7-29-02 | TDR | DREW MISSING TERMINAL & DIVIDER                                                                     |

|                                                                                                      |                                                                                                                                                                                                                                   |
|------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| TOLERANCES UNLESS OTHERWISE NOTED<br>X.X ±.06 X.XX ±.03 X.XXX ±.010<br>DIA, RADIUS ±.005 ANGLES ±.1° | ASI DOORS, INC. RESERVES PROPRIETARY RIGHTS TO THIS DRAWING AND THE DATA SHOWN THEREON. SAID DRAWING AND/OR DATA ARE CONFIDENTIAL AND ARE NOT TO BE USED OR REPRODUCED FOR ANY PURPOSE WITHOUT WRITTEN CONSENT OF ASI DOORS, INC. |
| OWN BY EDR # DATE<br>TDR 2001 3-13-02                                                                | EXP. NO. DRAWING NO. REV. NO.<br>18D230 L                                                                                                                                                                                         |
| NEXT ASM. SCALE 1=1                                                                                  |                                                                                                                                                                                                                                   |