



TECHNICAL MANUAL

Installation, Operation and Maintenance Instructions

TD 321-3

Tray Dryer

Insinger Machine Company
6245 State Road
Philadelphia, PA 19135-2996

800-344-4802
Fax: 215-624-6966
www.insingermachine.com

TECHNICAL MANUAL
including Installation, Operation, and Maintenance Instructions
FOR
TRAYDRYERS
MODEL: TD 321-3



Thank you for Purchasing this quality Insinger product.

On the space provided please record the Model, Serial Number and Start-up date of this unit:

Model: _____

Serial Number: _____

Start-up Date: _____

When referring to this equipment please have this information available.

Each piece of equipment at Insinger is carefully tested before shipment for proper operation. If the need for service should arise please contact your local Authorized Insinger Service Company. A Service Network Listing is provided within this manual. Check this list for your local authorized servicer.

For proper activation of the *Insinger Limited Warranty* a SureFire™ Start-up should be completed on your machine. Refer to the Introduction section in this manual for an explanation of Insinger's SureFire™ Start-up and Check-out Program.

Please read the Insinger Limited Warranty and all installation and operation instructions carefully before attempting to install or operate your new Insinger product.

To register your machine for warranty by phone, fax, or the internet or for answers to questions concerning installation, operation, or service contact our Technical Services Department:

Toll-Free	800.344.4802
Fax	215.624.6966
Email	service@insingermachine.com
World-Wide Web	http://www.insingermachine.com

Thank you.
Insinger



PART 1
TECHNICAL INFORMATION

TRAYDRYER
MODEL: TD 321-3
Table of Contents

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- * Drive Assembly
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- * Chain Assembly
- * Hook-up Kit
- * Guide Rail Assembly
- * Guide Rail Installation



Thank you for Purchasing this quality Insinger product.

On the space provided please record the Model and Serial Number of this unit:

Model: _____

Serial Number: _____

When referring to this equipment please have these numbers available.

Each piece of equipment at Insinger is carefully tested before shipment for proper operation. If the need for service should arise please contact your local Authorized Insinger Service Company. If you do not know the name of your Authorized Service Company please contact our Technical Services Department toll-free, 800/344-4802.

For proper activation of the *Insinger Limited Warranty* the **Warranty Registration Card** provided with your unit must be returned within 30 days of the installation date.

Please read the Insinger Limited Warranty and all installation and operation instructions carefully before attempting to install or operate your new Insinger product.

Thank you.

Insinger Machine Company



Project _____
 Item _____
 Quantity _____
 CSI - 11400 _____
 Approval _____
 Date _____



TD-321

Automatic Tray Dryer

- Automatic conveyor tray dryer provides 99% dry trays
- Unique Air Wiper design reduces ability for bacteria to grow on wet, stacked trays
- Drier and cleaner workplace—less racking of trays for drying
- Increased productivity
- Capacity is compatible with the tray washer and based on a 15” tray
- Designed for left or right hand conveyor travel, as specified.
- Furnished only as an added component to a TRAC 321-2, TRAC 321-2 RPW or TRAC 878 traywasher

STANDARD FEATURES

- Stainless steel frame, legs and feet
- Top mounted NEMA 12 control panel
- SureFire® Start-Up & Check-Out Service

OPTIONS

- Security package
- Tray Stacker

SPECIFIER STATEMENT

Specified unit will be an Insinger TD-321 automatic tray dryer. Features include conveyor-belt for tray drying, left or right specification, and compatibility with TRAC tray washers.



Additional Information

Capacity Per Hour	Compatible with the tray washer and based on a 15" tray
Motor Size	10 hp (blower) 1/15 hp (conveyor)
Shipping Weight	700 lbs.
Additional Current Draw Amps when Connected to Tray Washer	Electrical
208/3/60	31.0
240/3/60	28.2
380/3/50	17.0
480/3/60	14.1

SPECIFICATIONS

CONSTRUCTION- Hood and tank constructed of 16 gauge 18-8 type 304 S/S. Hood unit of all welded seamless construction. S/S frame, legs and feet.

CONVEYOR- One stainless steel roller conveyor chain with tray cradles, through both washer and dryer. Width between guide rails is factory adjustable from 1.5: to 3.7". Conveyor accommodates trays up to 15" high. Conveyor drive system includes direct drive gear motor with frictionless, trouble-free overload release system continuously running.

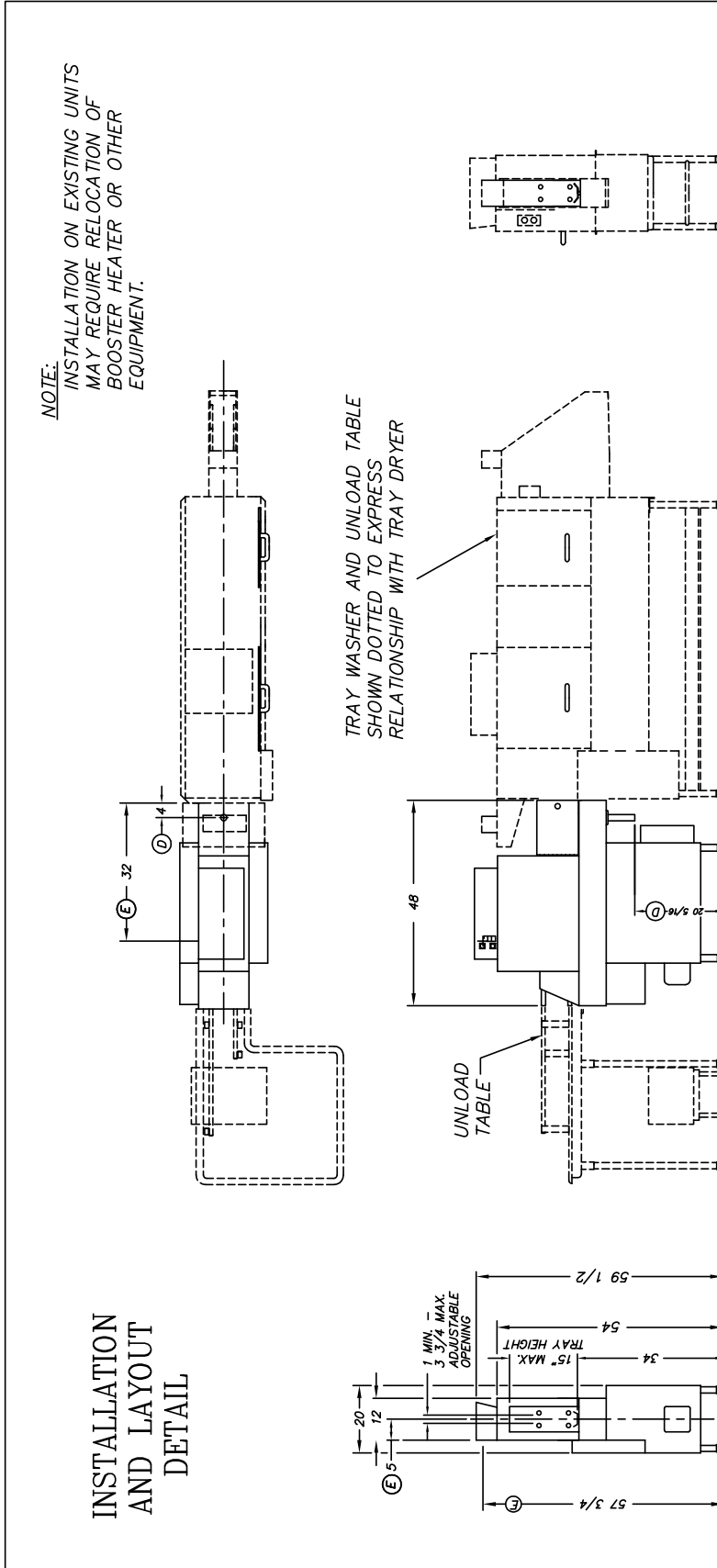
CONTROLS- Top-mounted control cabinet, NEMA 12 rated, housing motor controls and overload protection, transformer and contactors. All controls safe low voltage 24 VAC.

BLOWER- 10 hp regenerative blower with Insinger's specially designed "air wiper" mounted on either side of conveyor. "Air wipers" are mounted on a diagonal to sweep water in controlled movement preventing splashing and uneven results.

DRAIN- All water is drained back into TRAC 321-2, TRAC 321-2 RPW or TRAC 878 with gravity drain connection. Factory installed drain connection to tray washer provided if dryer is ordered with a TRAC 321-2, TRAC 321-2 RPW or TRAC 878.

UNLOAD TABLE- A stainless steel tray unload table receives clean trays. Table constructed with guide rails which ease the trays onto table.

Technical Drawings



NOTE: HOOK UP KIT FOR CONNECTION TO INSINGER
TRAY WASHER AVAILABLE, DWG. # 1361-105.

Information and Specifications
Subject to Change Without Notice.

INSTALLATION CONNECTIONS	
LTR	DESCRIPTION
E	ELECT. SERVICE - BLOWER MTR.
D	DRAIN
	1 1/2 O.D. TUBE
	SIZE
	10 HP

ELECTRICAL CHARACTERISTICS	
VOLTAGE	AMPS
208	31
230	28.2
460	14.1
380	17

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208	31
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460	14.1
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VOLTAGE	AMPS
208	31
230	28.2
460	14.1
380	17

INSINGER
SINGLE TANK CONVEYOR TYPE DISHWASHING MACHINE
Philadelphia, PA 19135
(215) 624-4800
FAX (215) 624-6966
DRWN: EMM 01.17.00 SCALE 1/2" = 1'
REV: KBM 07.29.08 TD321-3R
FILE: STD TD321-3R

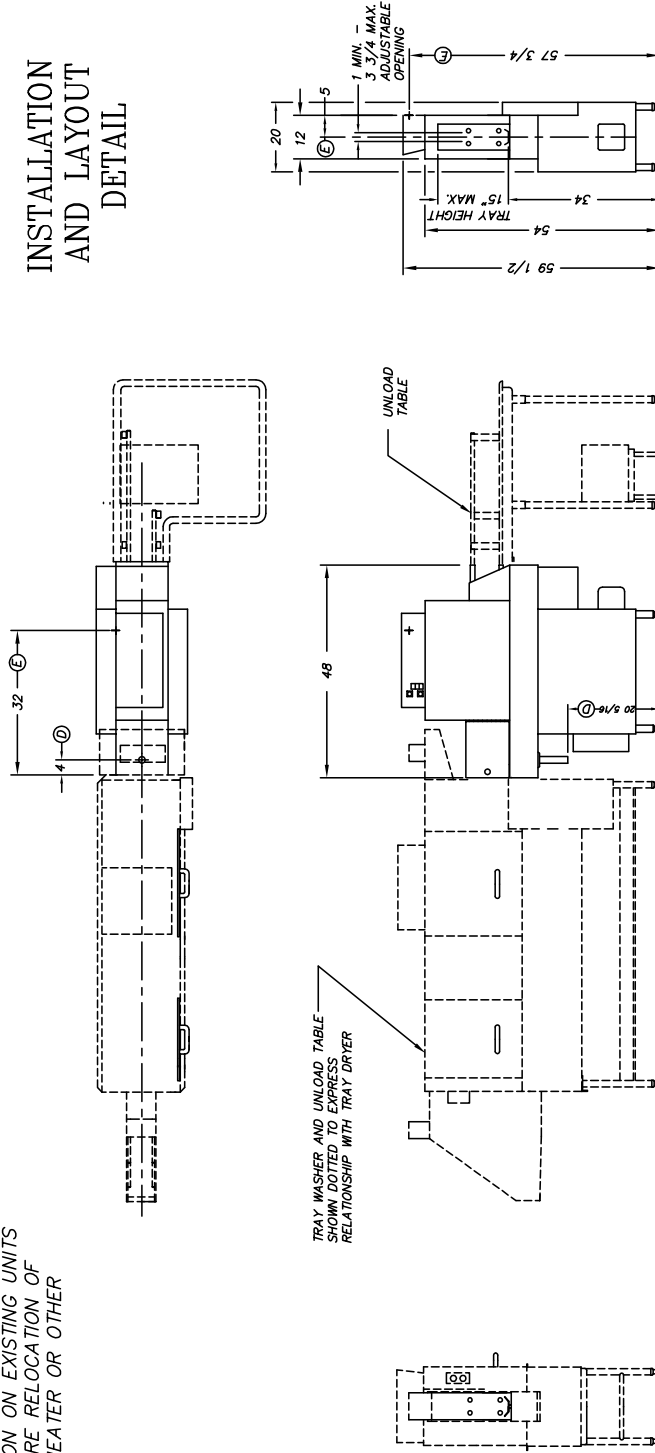
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TD 321-3 TRAY DRYER
SINGLE TANK CONVEYOR TYPE DISHWASHING MACHINE
Philadelphia, PA 19135
(215) 624-4800
FAX (215) 624-6966
DRWN: EMM 01.17.00 SCALE 1/2" = 1'
REV: KBM 07.29.08 TD321-3R
FILE: STD TD321-3R

Technical Drawings

NOTE:

INSTALLATION ON EXISTING UNITS
MAY REQUIRE RELOCATION OF
BOOSTER HEATER OR OTHER
EQUIPMENT.



TRAY DRYER
UNLOAD END SHOWN

LEFT TO RIGHT FEED

NOTE: HOOK UP KIT FOR CONNECTION TO INSINGER
TRAY WASHER AVAILABLE, DWG. # 1361-105.

Information and Specifications
Subject to Change Without Notice.

ELECTRICAL CHARACTERISTICS	
VOLTAGE	AMPS
208	31
230	28.2
460	14.1
380	17
CUSTOMER FUSE	
FRN-R-60	
FRN-R-60	
FRS-R-30	
FRS-R-35	

TD 321-3 TRAY DRYER
SINGLE TANK CONVEYOR TYPE DISHWASHING MACHINE
Philadelphia, PA 19135
(215) 624-4800
FAX (215) 624-6966
INSINGER
DRWN: EMW 01.17.00 SCALE
REV: KBM 07.29.08 1/2" = 1' TD321-3L G
FILE: STD TD321-3L

INSTALLATION CONNECTIONS	
LTR	DESCRIPTION
E	SIZE
D	TO HP
	ELECTRICAL CONNECTION
	1 1/2 O.D. TUBE
	DRAIN

THE INFORMATION ON THIS DRAWING IS THE PROPERTY OF INSINGER MACHINERY COMPANY AND IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM. ANY VIOLATION OF THIS POLICY WILL BE PROSECUTED TO THE FULL EXTENT OF THE LAW.



PART 2
INSTALLATION and OPERATION
INSTRUCTIONS

TD 321-3
INSTALLATION INSTRUCTIONS
Section A

A.1 PLACEMENT

- A.1.1 Carefully uncrate machine. Take caution to not damage components which may be mounted on the top or sides of the machine.
- A.1.2 Set unit in place and adjust the feet to level the machine.

Step A.1.3 is for traydryers being retrofitted onto an existing traywasher:

- A.1.3 A significant amount of re-work must be done to install the traydryer at an existing installation.
 - A.1.3.1 Remove the booster and all piping associated with the booster. Remove the unload table from the end of the traywasher.
 - A.1.3.2 Place the traydryer at the end of the traywasher. Connect the two machines together with the bolts provided.
 - A.1.3.3 Re-connect the booster, piping, and unload table.

For installation of a new traywasher and traydryer refer to the installation instructions in the traywasher manual.

A.2 ELECTRICAL CONNECTIONS

- A.2.1 Connect electrical lines sized for the correct voltage, current and phase of the machine. These should agree with machine requirements indicated on the nameplate and labels in control panel.
- A.2.2 A single-point electrical connection is provided for the control circuit and motors.

Electrical connections must be made to a circuit breaker or fused disconnect as provided by the end-user and required by local codes. A wiring diagram is laminated inside the control panel.

IMPORTANT: As with any 3 phase system, an electrician should check all motors for proper phasing, i.e., motors must be running in direction indicated by arrow on housing.

A.4 HVAC

- A.4.1 Ventilation connections are provided on the traywasher.

A.6 Tabling

- A.6.1 Unload tables should be pitched towards the machine to return excess water into the machine.

TD 321-3
OPERATION and CLEANING INSTRUCTIONS
Section B

Insinger dishmachines are user-friendly, making them the easiest dishwashers on the market to operate and maintain.

By following the operation procedure and general cleaning procedures your Insinger dishwasher will give you years of trouble free service.

B.1 Operation Instructions

- B.1.1 Adjust the guide rails for proper clearance for the largest tray being run through the traydryer. The largest tray should have no more than 1/4" clearance on either side.

IMPORTANT: Failure to properly adjust the tray guides may result in jamming of the machine and possible tray damage.

- B.1.2 Move the power toggle switch to the "ON" position. The amber "ON" pilot light will illuminate.
- B.1.3 To begin operation depress the START button. The conveyor and blower will start.
- B.1.4 Follow the operating procedures for the traywasher.
- B.1.5 To stop the operation depress the STOP button and move the power toggle switch to the "OFF" position.
- B.1.6 Refer to the cleaning procedures for proper clean-up of the dishmachine.
- B.1.7 Report any unusual occurrences to qualified service personnel.

The following cleaning procedures should be done daily, at the end of the shift.

B.2 Cleaning Procedures, Daily

- B.2.1 Remove all internal removable parts.
- B.2.2 Remove any debris from the interior of the machine.
- B.2.3 Clean the interior of the machine with a damp cloth.

Do not hose down the machine



PART 3
MAINTENANCE and REPAIR
PROCEDURES

TD 321-3
MAINTENANCE and REPAIR PROCEDURES
Section A

Following is a basic guide for traydryer preventive maintenance and the repair and replacement of common traydryer parts. Refer to the Basic Service Guide for troubleshooting tips.

A.1 MAINTENANCE

A.1.1 Daily - Refer to the operation and cleaning instructions provided in this manual for daily cleaning procedures.

A.1.2 Weekly

A.1.2.1 The entire machine should be wiped down using an industrial grade stainless steel cleaner.

A.1.2.2 Inspect the air filter for dirt. Remove excess dirt. Do not immerse the air filter in water. If in need of replacement, replace with Insinger P/N 1165-66.

A.1.2.3 Under the supervision of your detergent supplier the machine interior must be properly de-limed.

☞ The water quality in some areas requires de-liming to be done more frequently. Contact your detergent supplier for recommended de-liming frequency.

A.1.3 Quarterly

A.1.3.1 Inspect the conveyor belt for wear. Replace as necessary.

A.1.3.2 Replace the air filter with Insinger P/N 1165-66.

A.1.3.3 Inspect the blower flexible tubing. Replace where necessary.

A.1.4 Bi-annually

A.1.4.1 Grease motor bearings with a grease gun using 1-2 strokes of a medium Polyurea Grease such as Shell Dolium R.

IMPORTANT: Over greasing motor may cause premature machine failure.

A.1.3.5 Remove the side panel and clean the blower compartment of dust or debris.

A.2 MAINTENANCE PROCEDURES

IMPORTANT: ELECTRICAL POWER MUST BE TURNED-OFF BEFORE SERVICING EQUIPMENT.

A.2.1 Replacement of Conveyor belt

A.2.1.1 With power to the machine turned "OFF" locate the master link on the conveyor belt.

A.2.1.2 Loosen the 2 adjustment bolts located at the load end of the machine.

A.2.1.3 Remove the cotter pin from the master link. Remove the master link.

A.2.1.4 Pull the conveyor belt from the machine.

A.2.1.5 Install the new conveyor belt by reverse of the above.

A.2.1.6 If belt jams see the Basic Service Guide symptom #5.

TD 321-3
MAINTENANCE and REPAIR PROCEDURES
Section A

A.2.2 Replacement of Blower Flexible Tubing

A.2.2.1 With power to the machine turned "OFF", remove the access panel located on the side of the machine.

A.2.2.3 Locate the flexible tubing at the blower (refer to dwg. # 1361-97) and loosen the two hose clamps at each end of the flexible tubing.

A.2.2.4 Remove the flexible tubing by pulling it off its fitting.

A.2.2.5 Replace the flexible tubing by slipping it over its mating fitting. Secure it by tightening the hose clamps.

A.2.2.6 Replace the access panel.

A.2.3 Blower Motor Lubrication

A.2.3.1 With power to the machine turned "OFF", remove the access panel located on the side of the machine.

A.2.3.2 Locate the grease fitting on the motor. Using 1 to 2 full strokes from a grease gun apply grease to the motor. Use a Medium Polyurea grease such as Shell Dolium R.

☞ Take CAUTION to NOT overgrease the motor.

TD 321-3
MAINTENANCE and REPAIR PROCEDURES
Section B

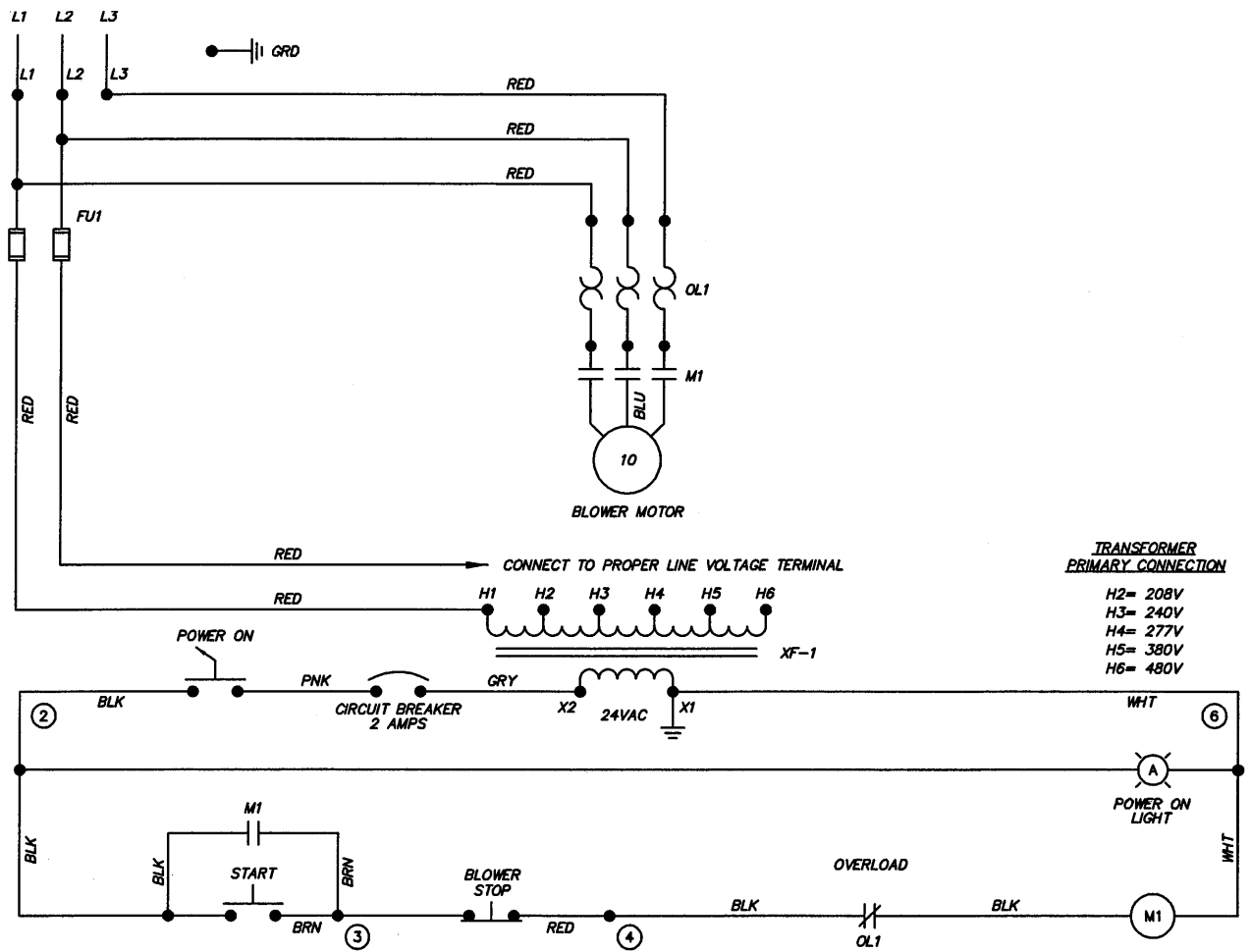
BASIC SERVICE GUIDE

SYMPTOM	POSSIBLE CAUSE	Solution
1. Conveyor does not operate	a. Motor overload(s) tripped	a. Check power supply b. Conveyor jammed c. Reset overload
2. Blower does not operate	a. Blower motor overload tripped b. Blower motor failure	a. Reset overload b. Replace blower motor
3. Trays jam	a. Obstruction in path	a. Remove obstruction
4. Trays not dry Please note: trays will NOT be completely dry	a. Blower not operating b. Flexible tubing ruptured c. Intake filter dirty	a. See symptom #2 b. Replace flexible tubing c. Replace filter
5. Belt sticks on sprockets	a. Belt tension too high	a. Loosen adjustment bolts



PART 4

**ELECTRICAL SCHEMATICS and
ELECTRICAL REPLACEMENT PARTS**

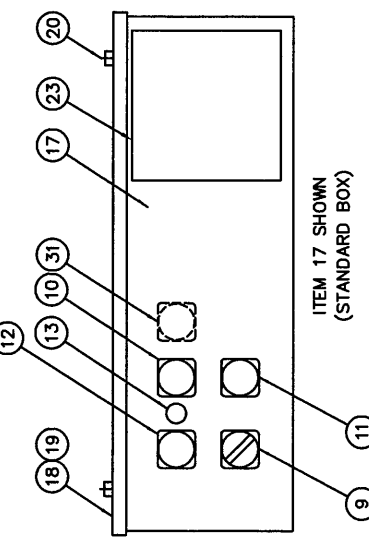
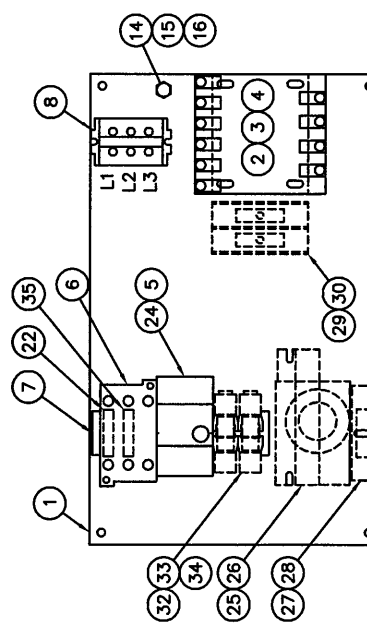
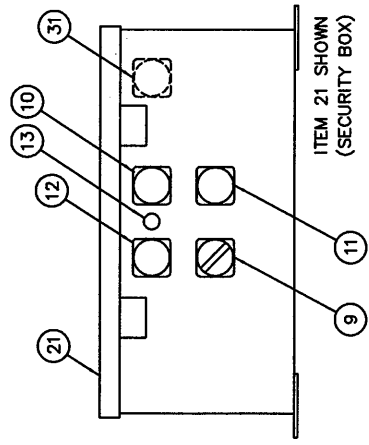
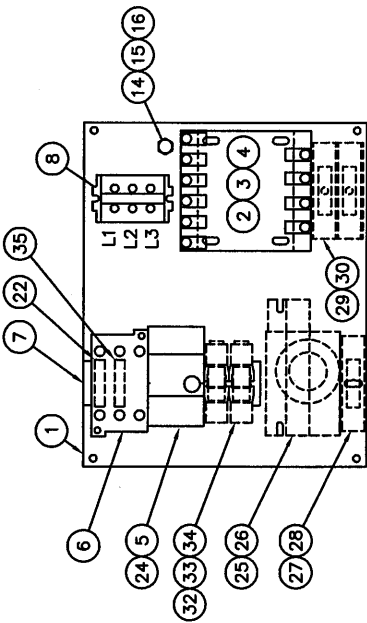


			TITLE	TRAY DRYER WIRING DIAGRAM	DWG. NO.	WTD001
F	1500	12.1.96				
E	1278	10.04.95				
REV	ECN NO	DATE			DRWN/DATE	RAF
FILE:	WIRE\WTD001			Insinger	Philadelphia, PA 19135 (215) 624-4800 FAX (215) 624-6966	06.27.95

ITEM	DESCRIPTION	PART NO.	QTY
29	FUSE BLOCK, 2 POLE (250 VA XFMR)	DE9-185	1
30	FUSE (250 VA TRANSFORMER PRIMARY)	DE9-169	2
	460 V FNG-R-1.8	DE9-174	
	230 V FNG-R-3.5	DE9-175	
	208 V FNG-R-4	DE9-175	
31	PILOT LIGHT ASSY - RED	DE8-61	1
32	RELAY BASE	DE2-37	2
33	RELAY	DE2-38	2
34	RELAY HOLD DOWN SPRING	DE3-43	2
35	AUXILIARY CONTACT, NC	DE1-61AE	1

ITEM	DESCRIPTION	PART NO.	QTY
22	AUXILIARY CONTACT, NO	DE1-62AE	AR
23	NAME PLATE	SK-2114D	1
24	OVERLOAD BASE	DE2-60	1
FOLLOWING USED WITH STAND ALONE TRAY DRYER:			
25	DC DRIVE CONTROL	2M510	4
26	POTENTIOMETER BRACKET	1094-115	1
27	FUSE BLOCK, 1 POLE (DC MOTOR)	DE9-42	1
28	FUSE (DC MOTOR)	FNG-R-2.25	1
29	TRANSFORMER (DRY, 250 VA, NOT SHOWN)	DE6-26	1

ITEM	DESCRIPTION	PART NO.	QTY
1	COMPONENT MOUNTING PLATE	SK-3772	1
	STANDARD (14 3/4 x 9 1/8)		
	SECURITY PACKAGE (10 3/4 x 8 7/8)	DE9-215	1
2	TRANSFORMER (50 VA, 24 VAC)	DE6-8	1
3	FUSE BLOCK KIT (50 VA XFMR)	DE9-163	1
4	FUSE (50 VA TRANSFORMER PRIMARY)	DE9-196	2
	460 V FNG-R-.5	DE9-196	
	380 V FNG-R-.5	DE9-196	
	220 - 230 V FNG-R-.75	DE9-166	
	208 V FNG-R-.75	DE9-166	
5	OVERLOAD RELAY	DE2-58	1
	460/3/60	DE2-57	
	380/3/50	DE2-62	
	230/3/60	DE2-61	
	220/3/50	DE2-62	
	208/3/60	DE2-62	
6	CONTACTOR	DE1-93	1
	460/3/60	DE1-56AE	
	380/3/50	DE1-55AE	
	230/3/60	DE1-55AE	
	220/3/50	DE1-55AE	
	208/3/60	DE1-55AE	
7	DIN RAIL (35 mm)	DE9-84	1
8	TERMINAL BLOCK ASSY	DE3-3	1
9	SELECTOR SWITCH ASSY	DE8-58	1
10	PUSHBUTTON ASSY, START	DE8-64	1
11	PUSHBUTTON ASSY, STOP	DE8-65	1
12	PILOT LIGHT ASSY - YELLOW	DE8-62	1
13	CIRCUIT BREAKER (2A)	DE9-31	1
14	GROUNDING STUD, 1/4-20	D309C-GC-4G	1
15	LOCKWASHER, 1/4	D313C-G5	1
16	HEX NUT, 1/4-20	D312C-GC-2	1
17	CONTROL BOX	1361-45	1
18	CONTROL BOX COVER	1361-46	1
19	GASKET	9007-001	1
20	NUT	D312C-EF-5	4
21	CONTROL BOX	SK-3808	1



TITLE TD-321 TRAY DRYER CONTROL PANEL LAYOUT

Philadelphia, PA 19135 DRWN/DATE
(215) 624-4800 MFJ
FAX (215) 624-6966

INSINGER FILE: SKETCH/ SK-3069 SCALE 1=4 DWG. NO. SK-3069

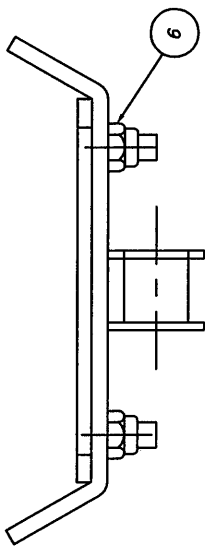
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REV ECN NO DATE

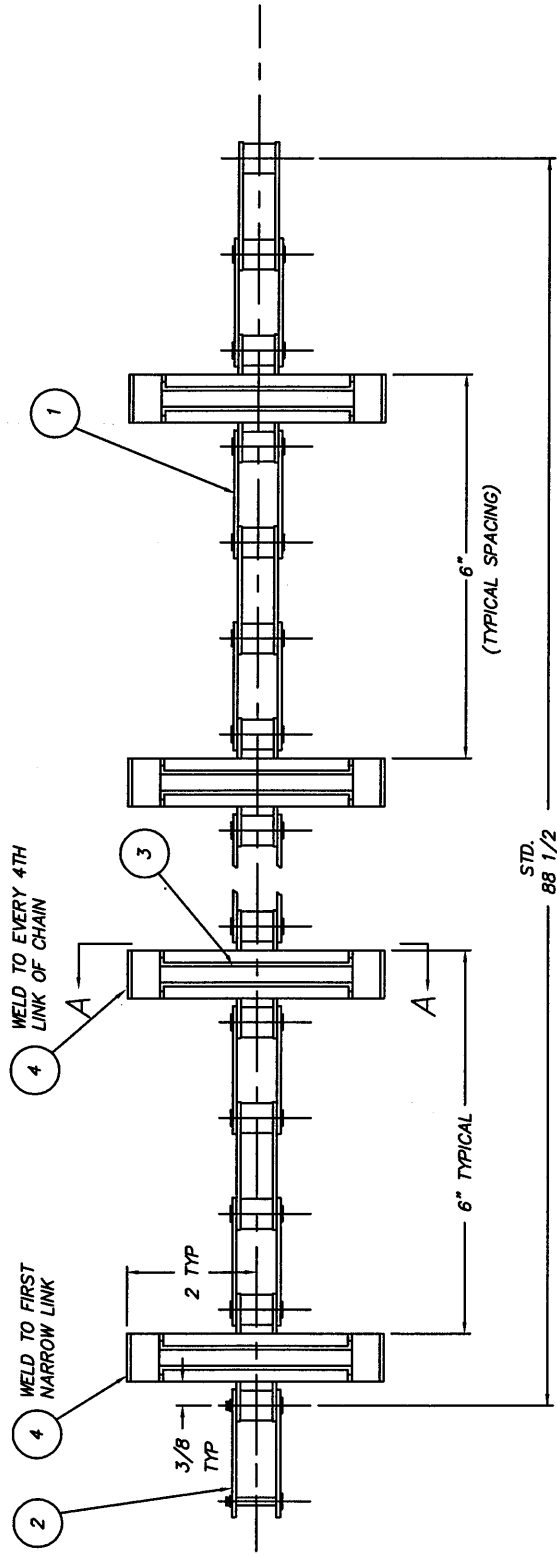


PART 5
REPLACEMENT PARTS

ITEM	PART NO.	DESCRIPTION	STD	60"
1	D308C-1 1/2	CHAIN	1	1
2	D308C-1 1/2 CL	CONNECTING LINK	1	1
3	1361-241	CROWN & RETAINER ASSY	15	19
4	1361-130	CRADLE	15	19
5	-	-	-	-
6	D312C-EF-5	LOCKNUT #10-32	30	38



SECTION A-A
(FULL SCALE)



STD.
88 1/2
(59 LINKS)

KRISPY KREME DONUTS
60" LONG TANK
75 LINKS - 112 1/2"

NOTE:
USE WELDING FIXTURE MADE OF PARTS SK-4613, '14 & '15
CRADLES (ITEM #4) ARE WELDED TO NARROW LINKS ONLY.

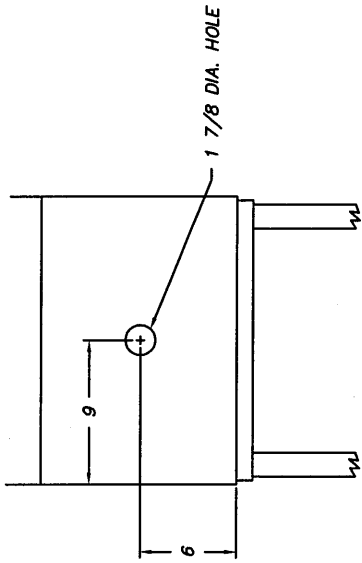
TOLERANCES		TITLE		NEXT ASSY DWG. NO.	
D	2412	FRACTIONS ±1/64	CHAIN ASSY	REQD	1361-102
C	1966	DECIMALS	INDIVIDUAL DRIVE	SCALE	1
B	1938	XXX ± .005	MAT'L	USED ON	TD 321-3
A	788	XX ± .01	AS NOTED	1=2	
REV	ECN NO	DATE	UNLESS OTHERWISE SPECIFIED	DRWN/DATE	
FILE:	PARTS\1361-102			PG	6.25.92



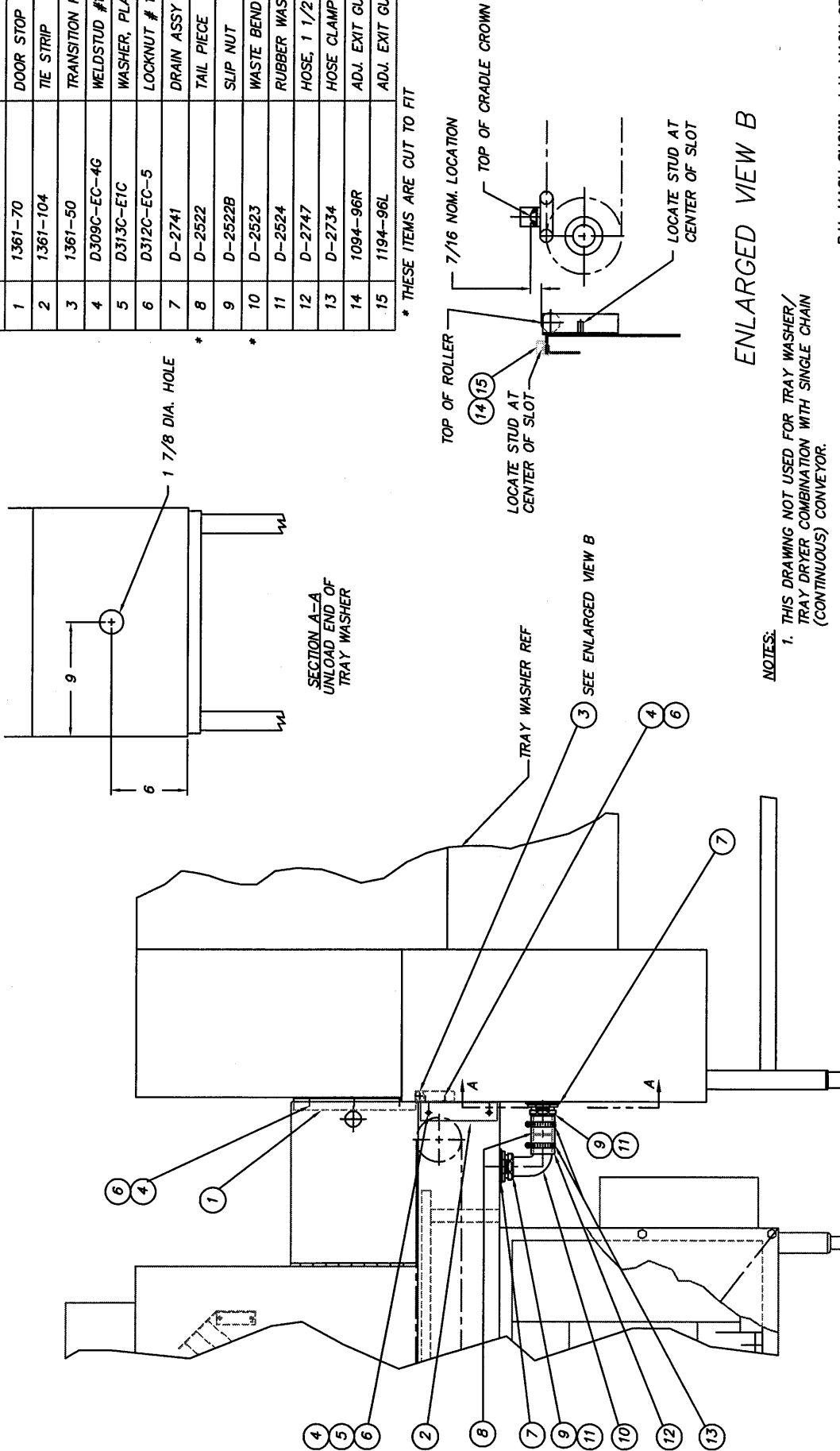
Philadelphia, PA 19135
(215) 624-4800
FAX (215) 624-6966

ITEM	PART NO.	DESCRIPTION	QTY.
1	1361-70	DOOR STOP	2
2	1361-104	TIE STRIP	2
3	1361-50	TRANSITION ROLLER ASSY	1
4	D309C-EC-4G	WELDSTUD #10-32 X 1/2	18
5	D313C-ETC	WASHER, PLAIN # 10	8
6	D312C-EC-5	LOCKNUT # 10-32	18
7	D-2741	DRAIN ASSY	2
8	D-2522	TAIL PIECE	1
9	D-2522B	SLIP NUT	2
10	D-2523	WASTE BEND	1
11	D-2524	RUBBER WASHER	2
12	D-2747	HOSE, 1 1/2 ID X 3 LG.	1
13	D-2734	HOSE CLAMP	2
14	1094-96R	ADJ. EXIT GUIDE	1
15	1194-96L	ADJ. EXIT GUIDE	1

* THESE ITEMS ARE CUT TO FIT



SECTION A-A
UNLOAD END OF
TRAY WASHER



ENLARGED VIEW B

NOTES:

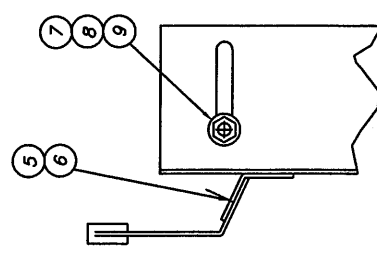
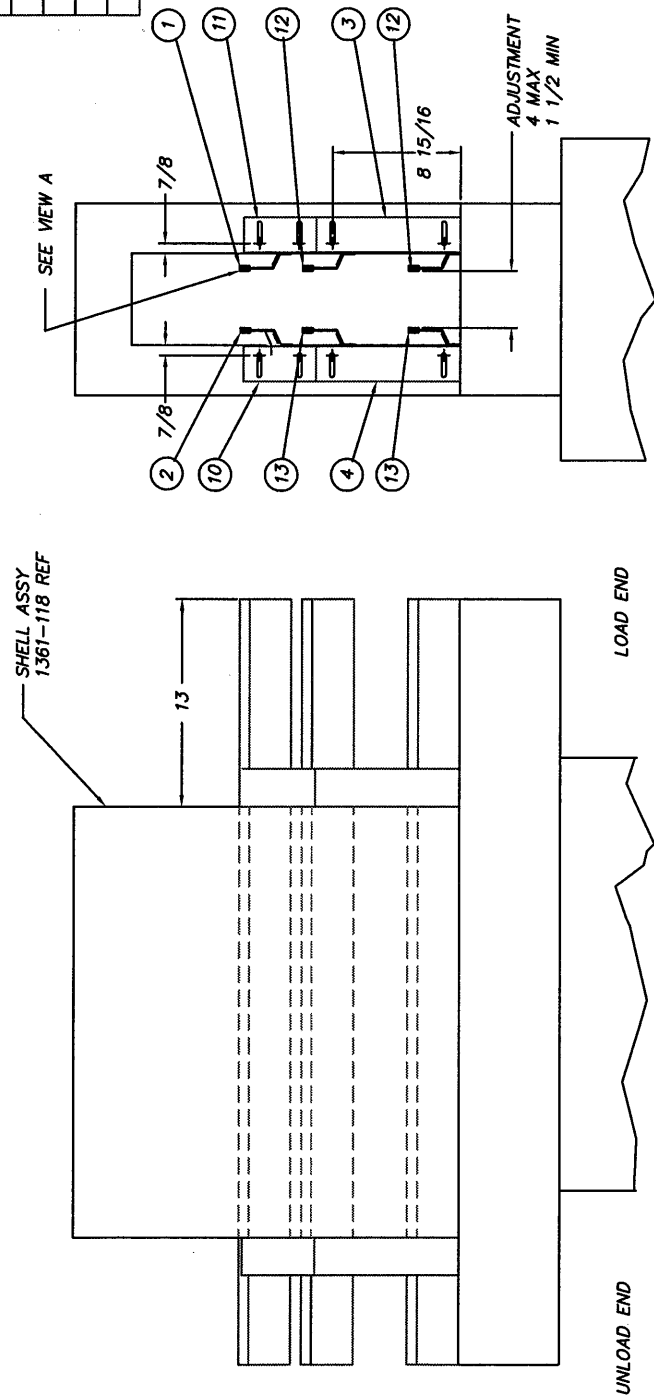
- THIS DRAWING NOT USED FOR TRAY WASHER/
TRAY DRYER COMBINATION WITH SINGLE CHAIN
(CONTINUOUS) CONVEYOR.

R.H. MACH SHOWN L.H. MACH OPPOSITE

TOLERANCES	TITLE	SCALE	USED ON
FRACTIONS ±1/64	HOOK-UP KIT	1:8	TD321-3
DECIMALS .XXX ±.005			
.XX ±.01			
ANGULAR ±1/2			
UNLESS OTHERWISE SPECIFIED			

- ECN# 840 3.17.93
- ECN# 800 1.13.93
- ECN# 788 12.15.92
- ECN# 688 7.29.92

ITEM	PART NO.	DESCRIPTION	QTY.
1	1361-90R	GUIDE RAIL ASSY	1
2	1361-90L	GUIDE RAIL ASSY	1
3	1361-78R	ADJ. GUIDE RAIL BRACKET	2
4	1361-78L	ADJ. GUIDE RAIL BRACKET	2
5	D309C-DC-3G	WELDSTUD #8-32 X 3/8	12
6	D312C-DC-5	LOCKNUT #8	12
7	D309C-EF-4G	WELDSTUD #10-32 X 1/2	16
8	D313C-E1	WASHER PLAIN # 10	16
9	D312C-EF-5	LOCKNUT #10-32	16
10	1361-76L	ADJ. GUIDE RAIL BRACKET	2
11	1361-76R	ADJ. GUIDE RAIL BRACKET	2
12	1361-128R	GUIDE RAIL ASSY	2
13	1361-128L	GUIDE RAIL ASSY	2



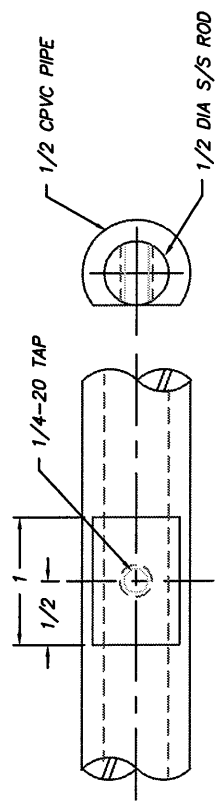
VIEW A
SCALE 1:2

TOLERANCES	FRACIONS ±1/64	DECIMALS	.XX ± .005	.XX ± .01	ANGULAR ±1/2	UNLESS OTHERWISE SPECIFIED
TITLE	GUIDE RAIL INSTALLATION	3" EXTRA HIGH	MATL.	AS NOTED	SCALE	1:8
REG.	1361-773	1	USED ON	7D321-3	DWG. NO.	1361-108
<p>R.H. MACH SHOWN L.H. MACH OPPOSITE</p> <p>Philadelph. PA 19135 Machine Company (215) 624-8800 FAX (215) 624-6966</p>						

NOTE:
GUIDE RAILS TO ALIGN WITH GUIDE
RAILS IN TRAY WASHER

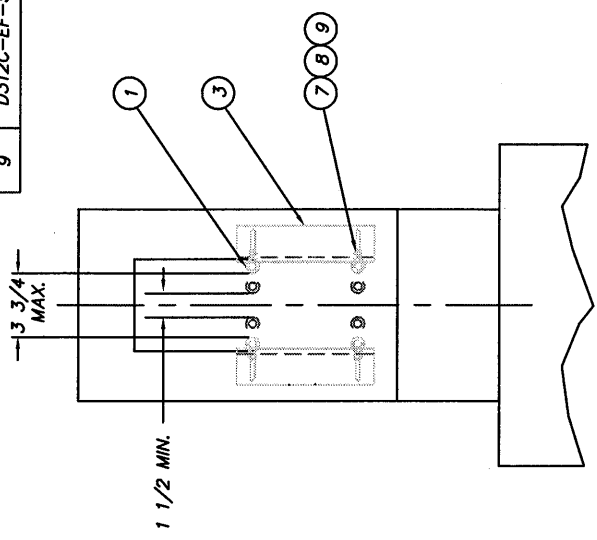
ECN NO. 788 12.12.92
 ECN NO. 726 9.24.92
 ECN NO. 688 7.29.92
 FILE: PARTS\1361-108

ITEM	PART NO.	DESCRIPTION	QTY.
1	1098-168	GUIDE RAIL ASSY	4
2	-	-	-
3	1361-151	ADJ. GUIDE RAIL BRACKET	4
4	-	-	-
5	-	-	-
6	-	-	-
7	D309C-EF-4G	WELDSTUD #10-32 X 1/2	4
8	D313C-E1	WASHER PLAIN # 10	8
9	D312C-EF-5	LOCKNUT #10-32	8

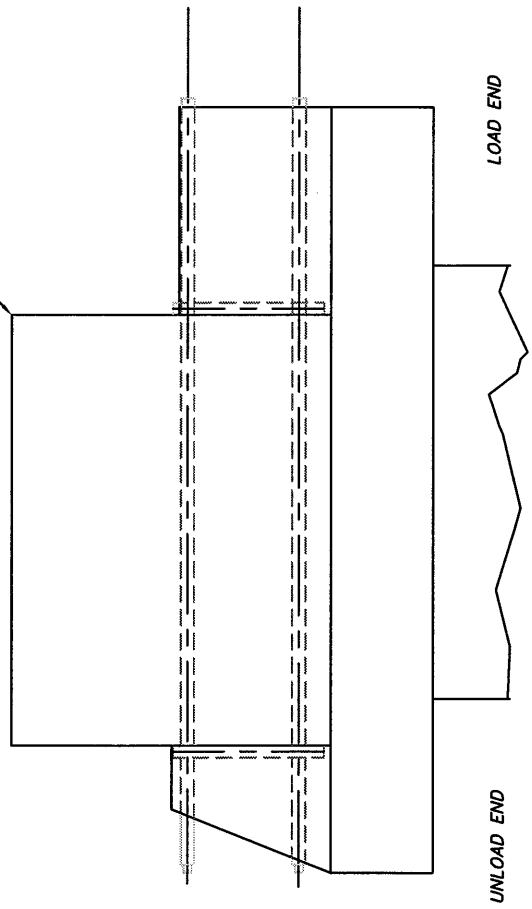


TYPICAL AT GUIDE ATTACHMENT

SHELL ASSY
1361-2 REF



TYPICAL BOTH ENDS



NOTE:
GUIDE RAILS TO ALIGN WITH GUIDE
RAILS IN TRAY WASHER.

R.H. MACH SHOWN L.H. MACH OPPOSITE

TOLERANCES	±1/64
FRACTIONS	±1/64
DECIMALS	±.005
XXX ±	.01
XX ±	.01
ANGULAR	±1/2
UNLESS OTHERWISE SPECIFIED	

TITLE	GUIDE RAIL INSTALLATION	REQ. 1	DWG. NO. 1361-98
MAT'L.	AS NOTED	SCALE 1:8	USED ON TD321-3
NEXT ASSY	1361-1		

ECN# 1207 6.13.95
FILE: PARTS\1361-98

Philadelphia, PA 19135
(215) 624-8800
INSINGER FAX (215) 624-8966
PG 6.16.92



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