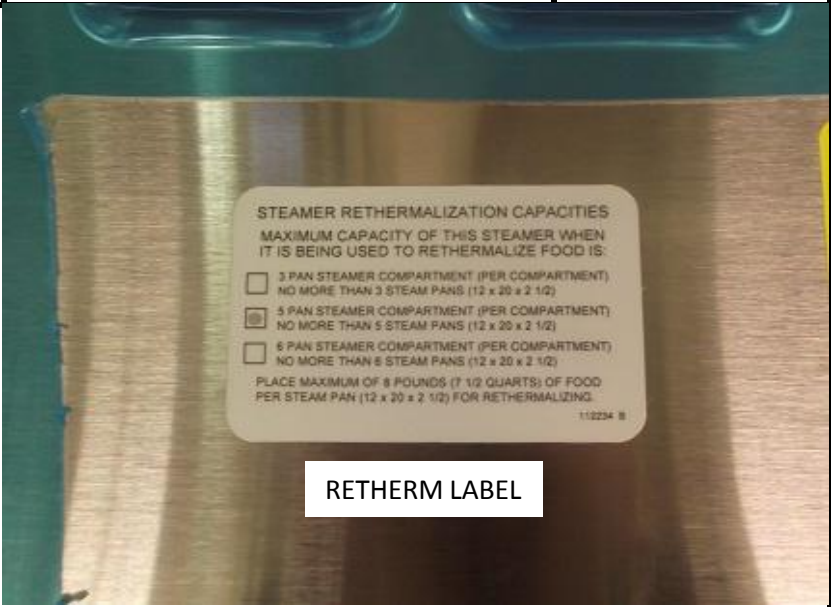


MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1	 TQC  WORK CONTENT  VERIFY	
REVISED BY: C. Schmauder				

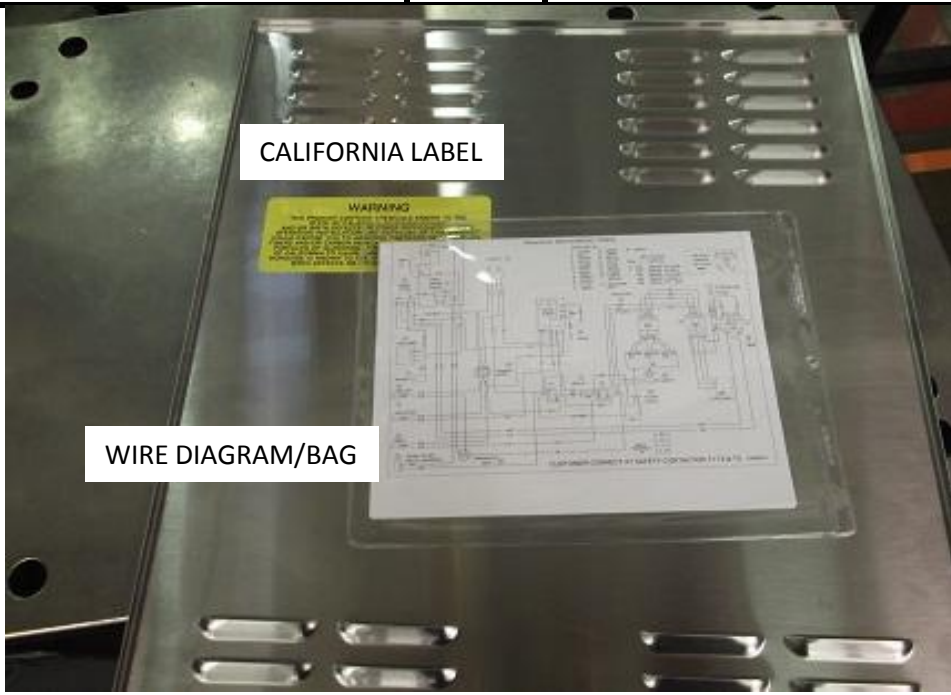


REMOVE PAPER FROM SELECTED LOATIONS ON SIDE SHEETING.
PUNCH HOLE IN 5-PAN BOX ON RETHERM LABEL.
AFFIX LABELS ON SIDE SHEETING.

REMOVE PAPER FROM SELECTED LOATIONS ON SIDE SHEETING.
PUNCH HOLE IN 5-PAN BOX ON RETHERM LABEL.
AFFIX LABELS ON SIDE SHEETING.

PART#	DESCRIPTION	QTY		PART#	DESCRIPTION	QTY
109113	SIDE SHEET	1				
112234	REHERM LABEL	1				
110850	CANADA LABEL	1				
111535	WARNING LABEL	1				

MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1		 TQC  WORK CONTENT  VERIFY	
REVISED BY: C. Schmauder					



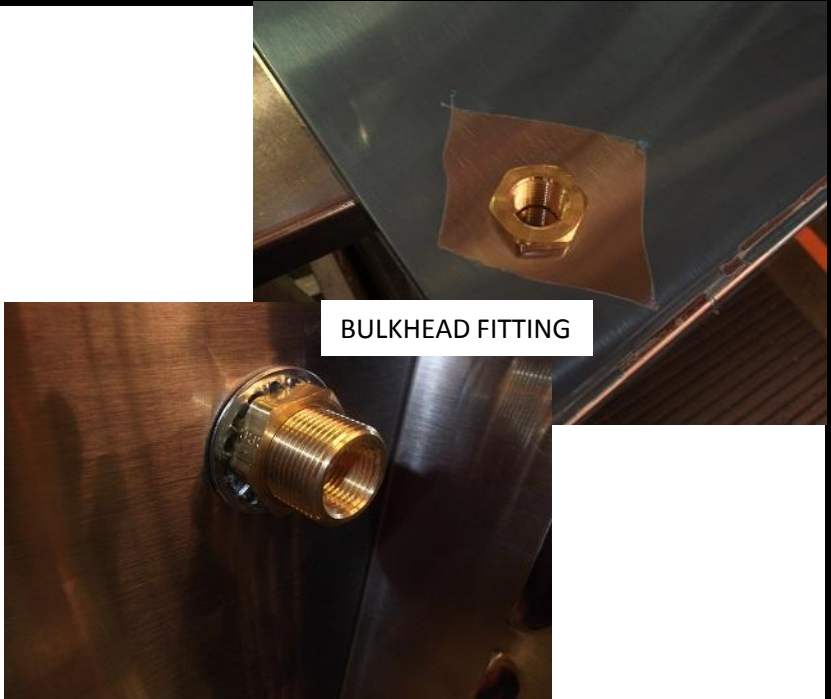
WIRE DIAGRAM/BAG

CALIFORNIA LABEL

APPLY CALIFORNIA LABEL ON INSIDE OF SHEETING WHICH LABELS WERE ADDED.
 PLACE 1 PIECE OF DOUBLE SIDED TAPE ON PANEL AND PLACE WIRE DIAGRAM INSIDE OF BAG.
 AFFIX BAG TO DOUBLE SIDED TAPE.

PART#	DESCRIPTION	QTY		PART#	DESCRIPTION	QTY
105182	CALIFORNIA LABEL (REF)	1				
SEE ORDER	WIRE DIAGRAM	1				
108845	BAG	1				
01209	DOUBLE SIDED TAPE	A/R				

MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1	 TQC  WORK CONTENT  VERIFY	
REVISED BY: C. Schmauder				



REMOVE PAPER FROM TOP/BACK SHEETING.
 AFFIX SERIAL TAG WITH MYLAR COVER OVER TOP TO SHEETING.
 AFFIX SERVICE AND CLEARANCE LABES TO SHEETING.
 ATTACH BULKHEAD FITTING TO SHEETING. FITTING GOES THROUGH THE TOP AND SECURED WITH INTERNAL WASHER AND NUT ON THE INSIDE OF THE SHEETING.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
109109	TOP BACK SHEETING	1	106157	BULKHEAD FITTING	
NO P/N	SERIAL TAG	1			
113062	MYLAR COVER	1			
104350	SERVICE LABEL	1			
101831	CLEARANCE LABEL	1			

MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1	 TQC  WORK CONTENT  VERIFY	
REVISED BY: C. Schmauder				



SPRAY SANASHEEN ON DOOR AND INSIDE OF CAVITY. WIPE DOWN ALL SURFACES.
 PLACE SPLASH GUARD PAN INSIDE OF OVEN.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
109467	SPLASH GUARD	1			

MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1	 TQC  WORK CONTENT  VERIFY	
REVISED BY: C. Schmauder				



AFFIX OPERATING INSTRUCTIONS AND DOORS HOT LABEL TO FRONT OF DOOR.

PART#	DESCRIPTION	QTY		PART#	DESCRIPTION	QTY
108889	OPERATING LABEL	1				
14919	DOORS HOT LABEL	1				

MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1	 TQC  WORK CONTENT  VERIFY	
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APPLY A THIN BEAD OF CLEAR RTV TO THE FRONT EDGE OF THE TOP BACK SHEETING.
CONNECT VENT HOSE TO THE BULKHEAD FITTING IN THE TOP SHEETING.

 SEE QOP 2

PART#	DESCRIPTION	QTY		PART#	DESCRIPTION	QTY

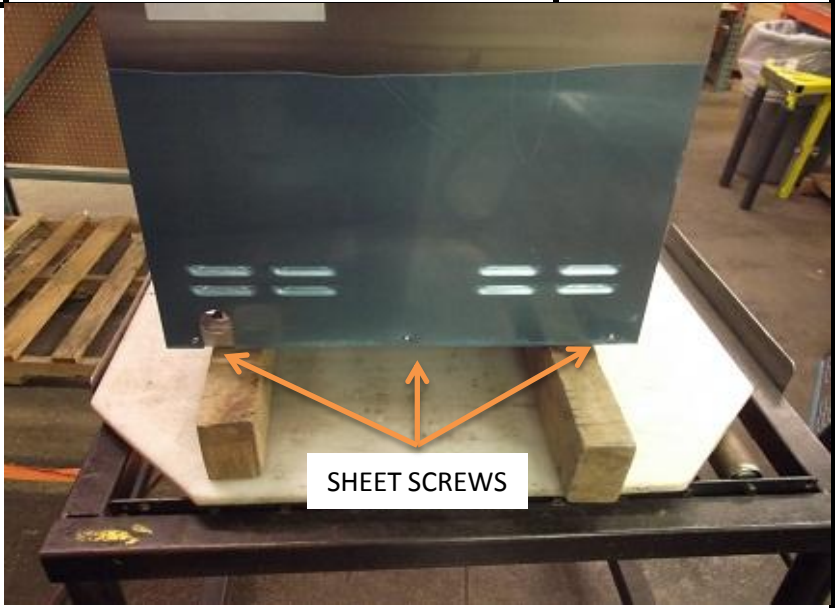
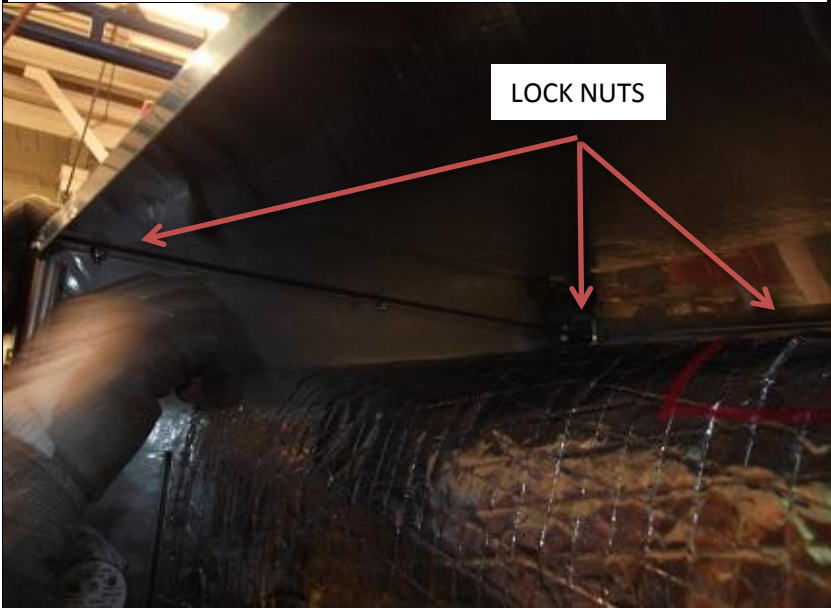
MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1	 TQC  WORK CONTENT  VERIFY	
REVISED BY: C. Schmauder				



SLIDE THE FRONT EDGE OF THE TOP/BACK SHEETING UNDER THE FRONG EDGE OF THE FACE BUT OVER THE NUTS ON THE STUDS.
(SANDWICH THE SHEETING EDGE BETWEEN NUTS AND FACE)
USE BAR CLAMP TO HOLD TOP SHEETING IN PLACE.
TIGHTEN HOSE CLAMPS ON VENT HOSE.
▲ SEE QOP 2

PART#	DESCRIPTION	QTY		PART#	DESCRIPTION	QTY

MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1	 TQC  WORK CONTENT  VERIFY	
REVISED BY: C. Schmauder				



TIGHTEN LOCK NUTS UNDER SHEETING TO LOCK SHEETING IN PLACE.
ATTACH BACK TO SHEETING TO THE BASE PAN WITH 3 SHEET SCREWS.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
104080	SHEET SCREW	3			

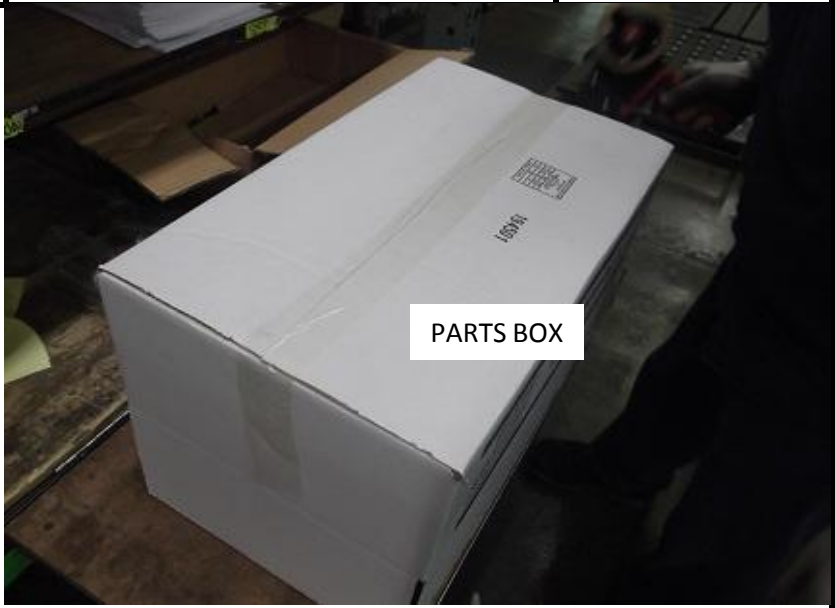
MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1	 TQC  WORK CONTENT  VERIFY	
REVISED BY: C. Schmauder				



ATTACH SIDE SHEETING WITH LABELS ON IT TO THE RIGHT SIDE OF THE OVEN.
ATTACH BLANK SIDE SHEETING TO THE LEFT SIDE OF THE OVEN.
2 SHEET SCREWS ON EACH SIDE.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
104080	SHEET SCREWS	4			
109113	SIDE SHEETING	1			

MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1	 TQC  WORK CONTENT  VERIFY	
REVISED BY: C. Schmauder				



REMOVE FOOT PLATE FROM 4 LEG ASSEMBLIES.
 GET 4 PAINTED FOOT PLATES.
 GET PARTS BOX AND TAPE UP BOTTOM.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
06162	LEG ASSEMBLY	4			
06162LC	PAINTED FOOT	4			
194501	PARTS BOX	1			

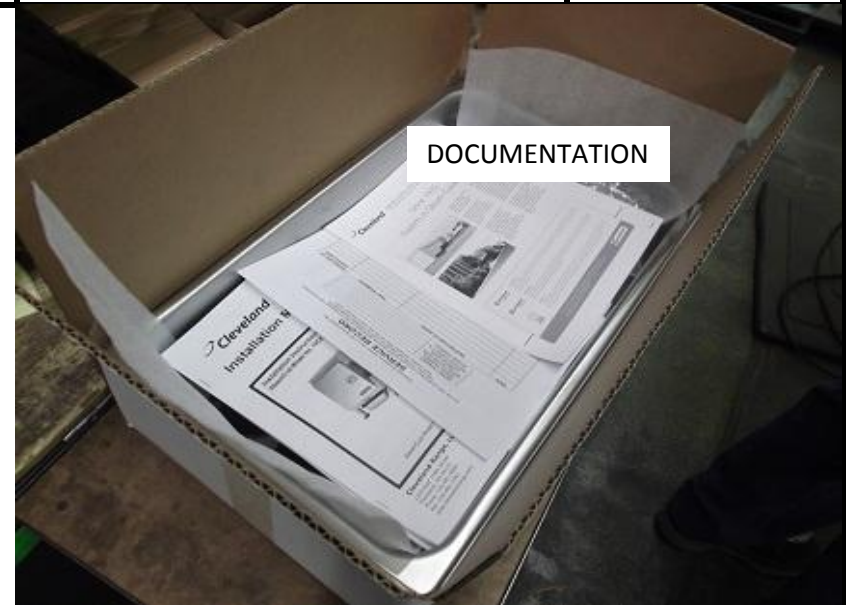
MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1	 TQC  WORK CONTENT  VERIFY	
REVISED BY: C. Schmauder				



PLACE DRAIN PAN IN BOTTOM OF THE BOX.
 PLACE A LAYER OF PROTECTIVE FOAM SHEET INSIDE OF PAN.
 PLACE PAINTED FEET AND LEGS IN PAN.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
16851	DRAIN PAN	1			

MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1	 TQC  WORK CONTENT  VERIFY	
REVISED BY: C. Schmauder				

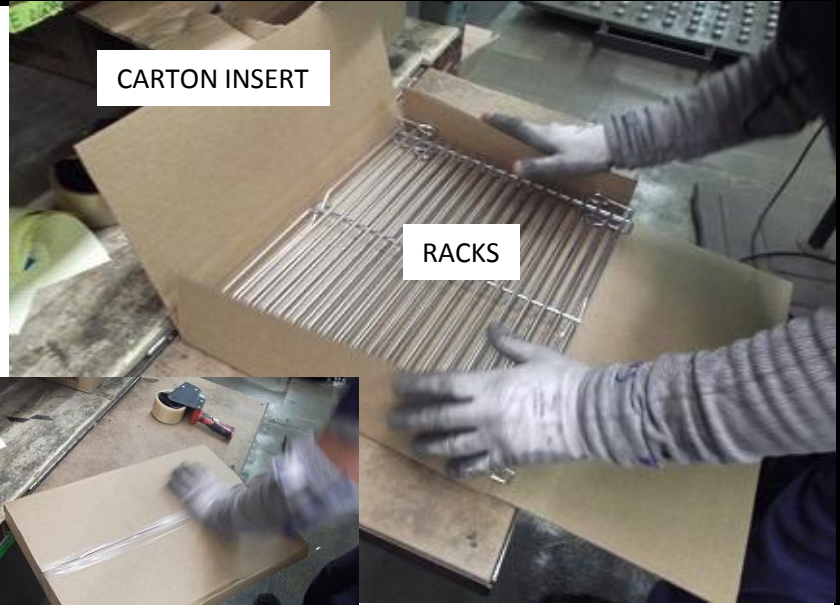


WRAP UP BRASS TUBE IN FOAM SHEET AND PLACE IN BOX.
 PLACE OPERATING MANUALS, SERVICE MANUALS AND DOCUMENTATION IN BOX.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
193261	BRASS TUBE	1	1SCE-INM	INSTRUCTION MANUAL	1
1SCE-OPM	OPERATING MANUAL	1			
260APE	RECORD KEEPING	1			
260APH	CUSTOMER DIRECTORY	1			
260AVZ	RATING PLATE DATA	1			

MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1	 TQC  WORK CONTENT  VERIFY	
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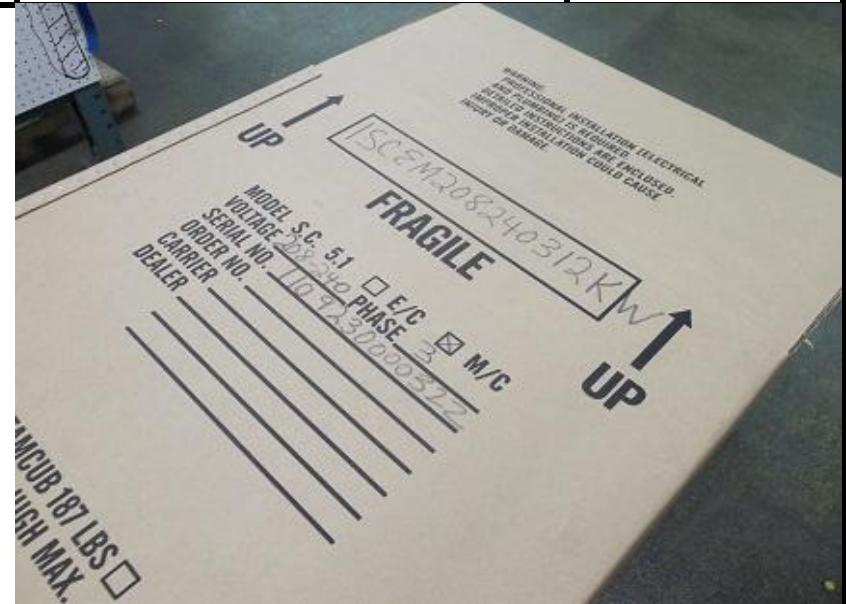
REVISED BY: C. Schmauder



CLOSE UP BOX AND TAPE SHUT.
 PLACE 2 PAN RACKS ON CARTON INSERT.
 FOLD UP INSERT AND TAPE SHUT.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
414232	PAN RACKS	2			
104360	CARTON INSERT	1			

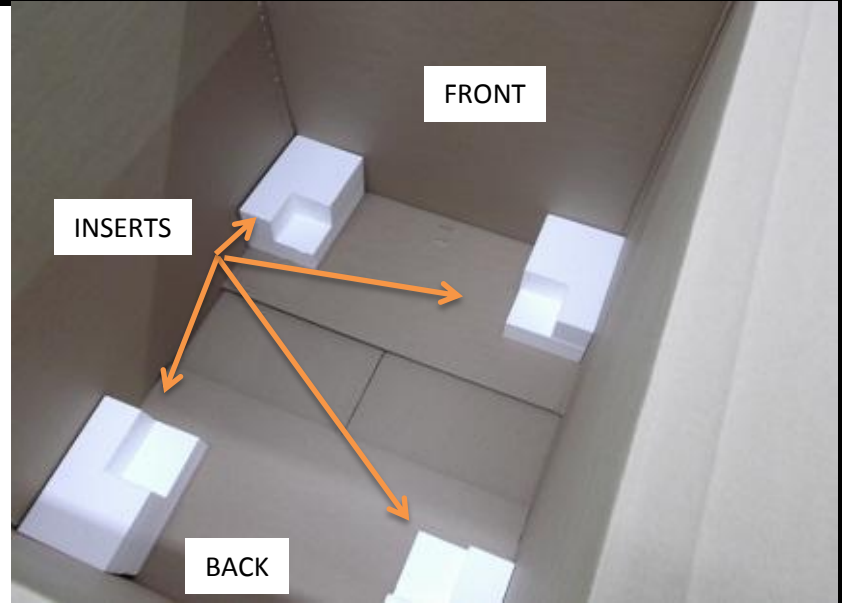
MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1	 TQC  WORK CONTENT  VERIFY	
REVISED BY: C. Schmauder				



FOLD UP BOTTOM OF CARTON AND STAPPLE FOLDS TOGETHER.
 WRITE SHIPPING INFORMATION ON BOX ACCORDING TO WORK ORDER.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
104239	CARTON	1			

MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1	 TQC  WORK CONTENT  VERIFY	
REVISED BY: C. Schmauder				

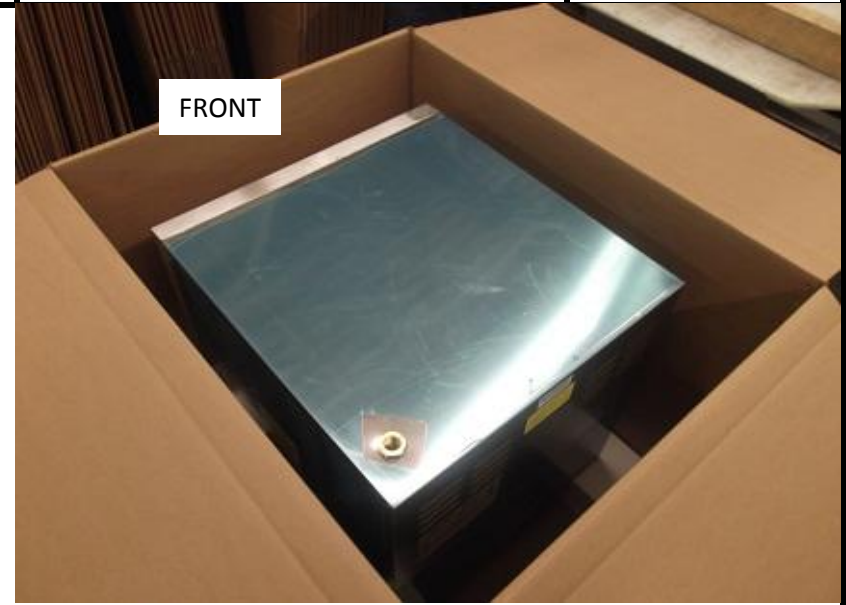



PLACE SKID ON FLOOR AND BOX OVER TOP OF SKID.
PLACE INSERTS INTO BOTTOM OF THE CARTON.

 BACK INSERTS HAVE A SMALLER RECESS IN THE INSERT.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY
41946	SKID	1			
109294	INSERTS	1			

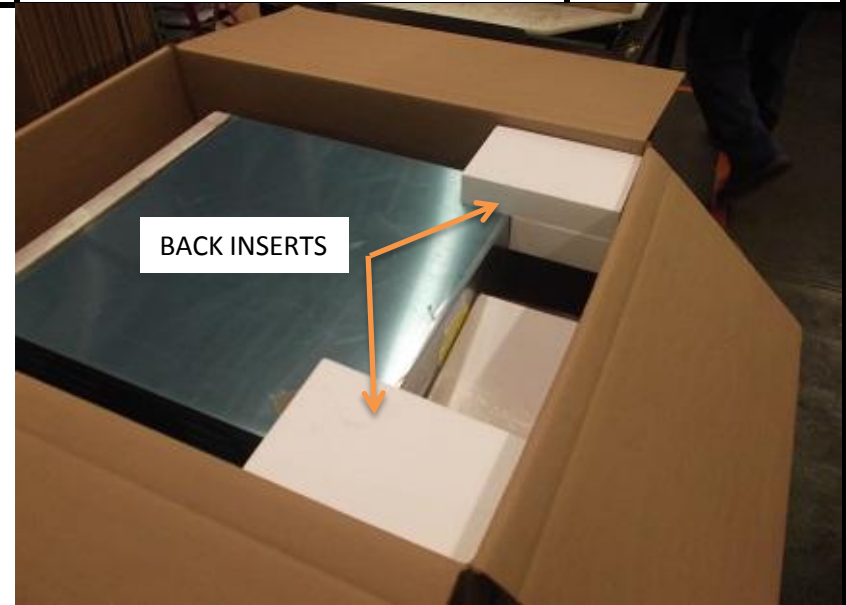
MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1	 TQC  WORK CONTENT  VERIFY	
REVISED BY: C. Schmauder				



PICK UP OVEN WITH SUCKTION DEVICE AND PLACE IN BOX.
 MAKE SURE OVEN DOOR IS TO THE FRONT SIDE OF THE INSERTS.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY

MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1	 TQC  WORK CONTENT  VERIFY	
REVISED BY: C. Schmauder				

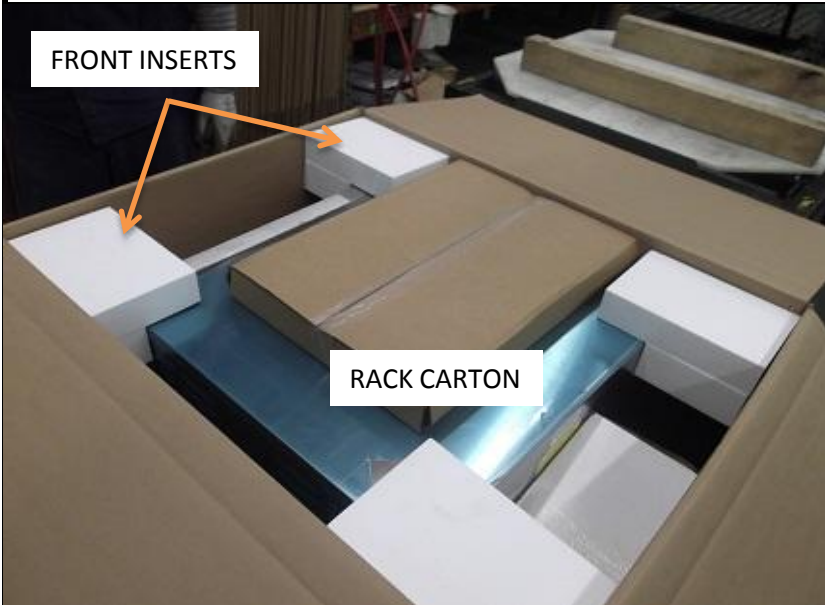


PLACE BOX WITH PAN, LEGS, AND DOCUMENTATION IN THE CARTON ON THE BACK SIDE OF THE OVEN.
 PLACE BACK INSERTS ON CORNERS OF OVEN.

 BACK INSERTS HAVE A SMALLER RECESS IN THE INSERT.

PART#	DESCRIPTION	QTY		PART#	DESCRIPTION	QTY
109294	INSERTS	1				

MODEL CUB	PROCESS ID BOX	REVISION LEVEL 1	 TQC  WORK CONTENT  VERIFY	
REVISED BY: C. Schmauder				



PLACE FRONT INSERTS ON THE FRONT CORNERS OF THE OVEN.
 PLACE RACK CARTON ON TOP OF THE OVEN.
 FOLD OVER TOP OF CARTON AND STAPPLE SHUT.

PART#	DESCRIPTION	QTY	PART#	DESCRIPTION	QTY