

## **TTVac-H Assembly Drawings**

### **Machine Assembly**

TTVac-H	TTVac-H Assembly
00-6059	TTVac Frame Assembly
00-6784	TTVac-H Vacuum Nozzle Assembly
00-0805	Shut-Off Valve Assembly
00-5810	TTVac Waste Tank Assembly
00-7782	3/4 HP Vacuum Pump Assembly 100 VAC
00-3506	On/Off Switch Assembly, Eaton 8-12 A
00-7783	3/4 HP Vacuum Pump Assembly 200 VAC
00-3505	On/Off Switch Assembly, Eaton 4-6.3 A
00-4136	Pump – Vacuum 3/4 HP Parts List
00-4153	Waste Tank Sub-Assembly
00-4512	Product Table
00-6785	FRL Assembly
00-5873	Clipper Vacuum “H” Nozzle Assembly
00-5969	Clipper Trigger Valve Assembly
28-4636	3/8” Air Supply Hose

### **Schematics**

63-0071	Pneumatic Schematic (Low Voltage 110-120 VAC)
63-0090	Pneumatic Schematic (High Voltage 220-240 VAC)
63-2003	CVW Vacuum Schematic

### **Options**

#### **Caster Option**

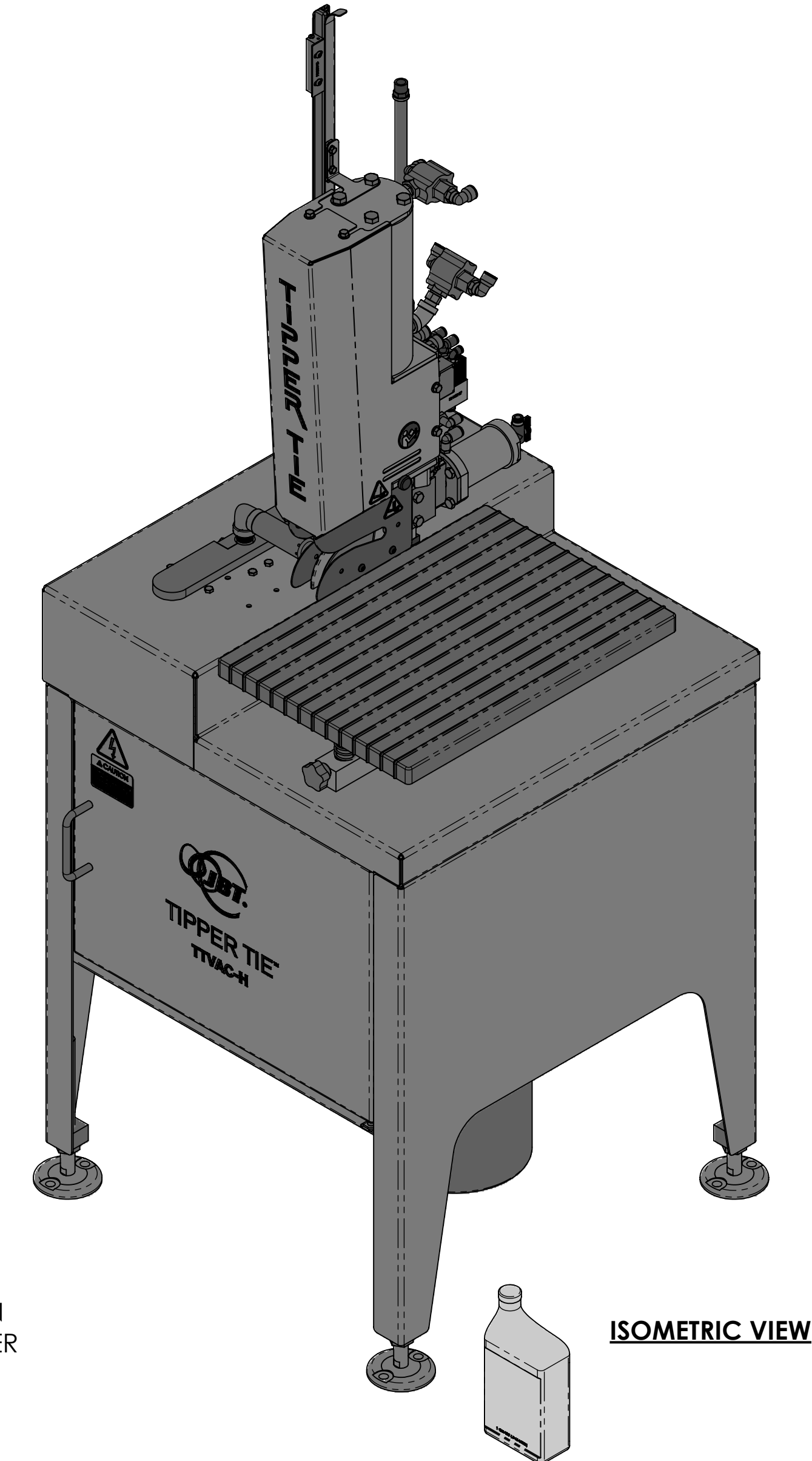
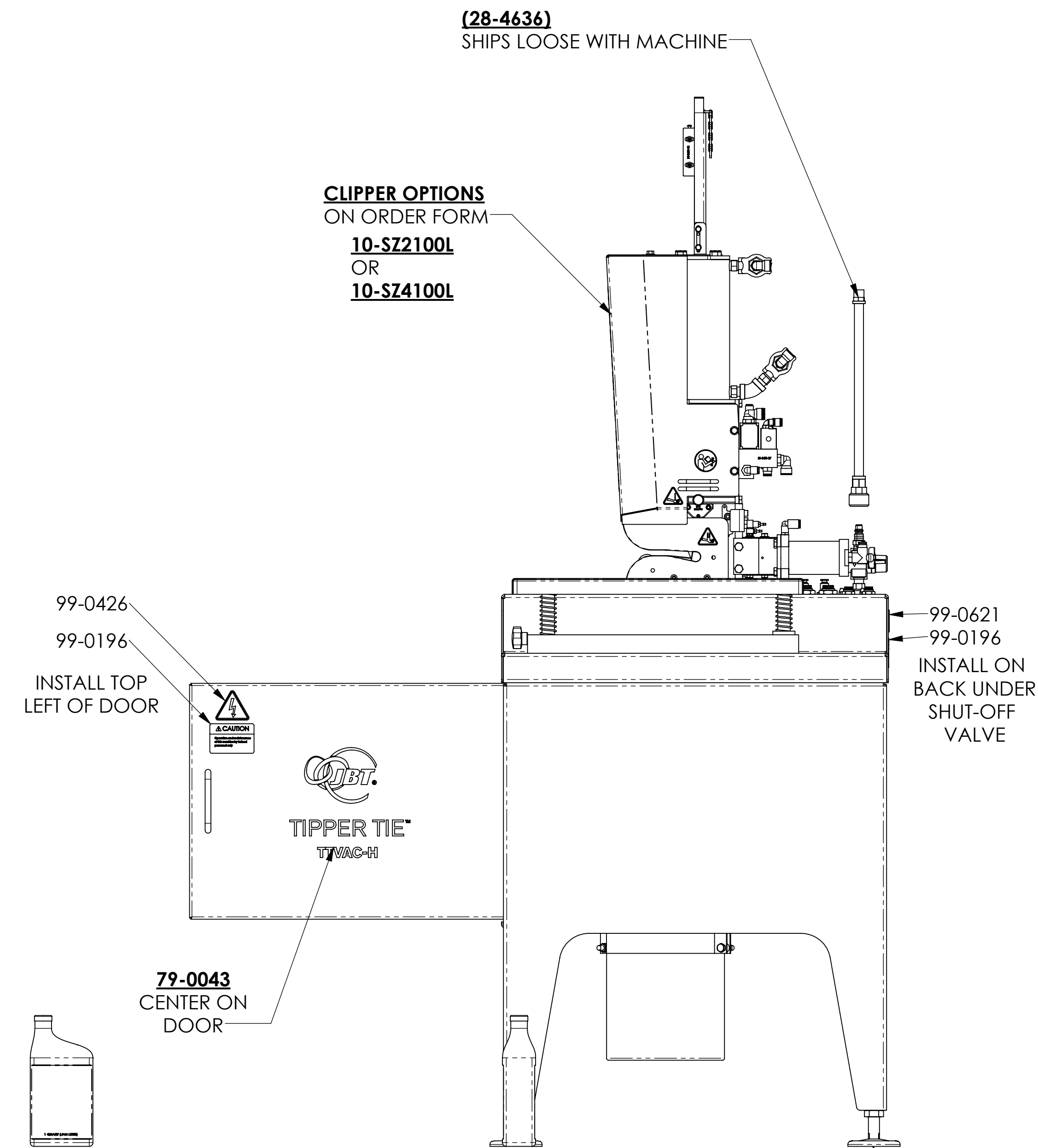
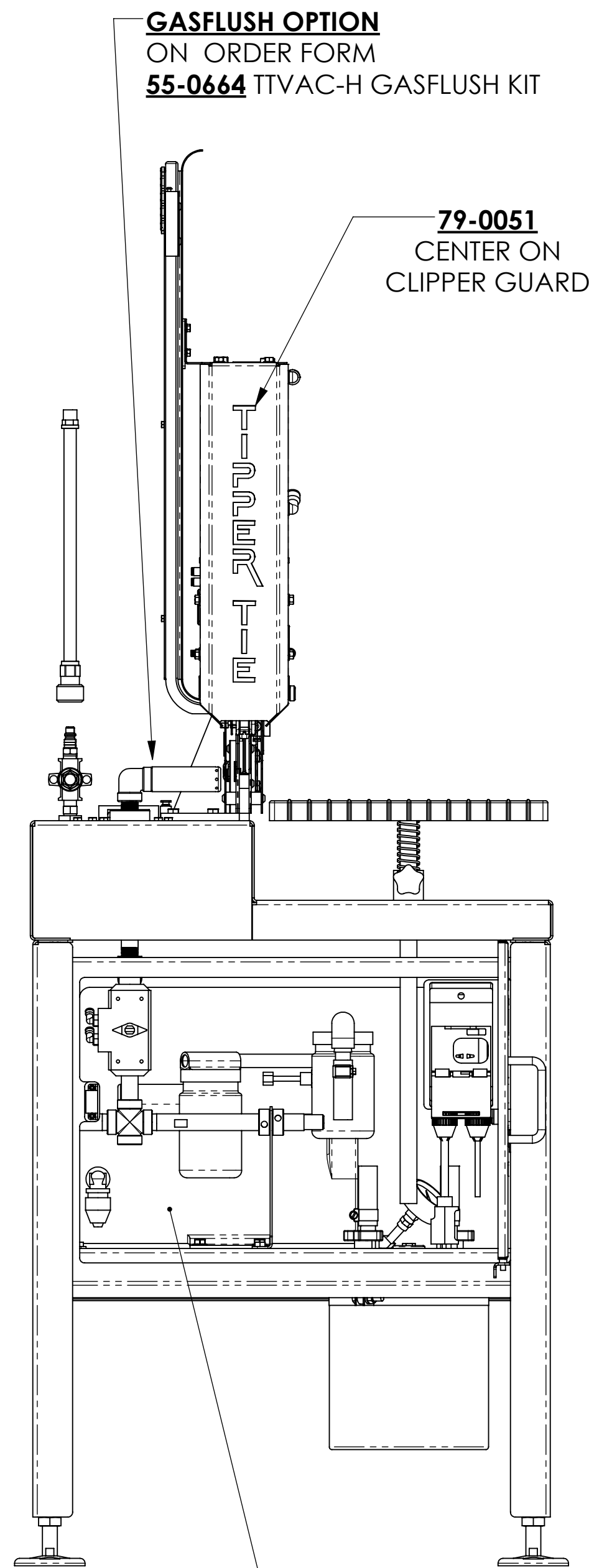
00-0898	Caster Assembly Kit
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#### **Gasflush Option**

55-0664	TTVac-H Gasflush Kit
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ITEM NO.	QTY	PART NUMBER	DESCRIPTION	ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	00-5810	TTVAC WASTE TANK ASSEMBLY	69	3	99-1181	4MM ID FLAT WASHER SST
2	1	00-5969	CLIPPER TRIGGER VALVE ASSEMBLY	70	2	99-1182	5MM ID FLAT WASHER SST
3	1	00-6059	TTVAC FRAME ASSEMBLY	71	2	99-1183	6MM ID FLAT WASHER SST
4	1	00-6784	TTVAC-H VACUUM NOZZLE ASSEMBLY	72	2	99-1242	3MM ID LOCKWASHER SST
5	1	00-6785	FRL ASSEMBLY	73	1	99-1243	4MM ID LOCKWASHER SST
6	1	01-0157	SUB-PRODUCT TABLE	74	1	99-1397	MAGNET CATCH
7	1	01-0159	PRODUCT TABLE	75	1	99-7470	TTVAC LOCK BAR

8	1	01-0421	CVW-GF SLOT GUARD BLOCK
9	1	01-1773	TTCV-H TRIGGER BLOCK
10	1	07-0623	TTVAC-H TABLE TOP
11	1	07-0706	TTVAC DOOR ASSEMBLY
12	1	09-0349	CVW-GF SLOT GUARD
13	1	10-0900	CVW BUMPER BRACKET
14	1	10-0902	CVW GUIDE BRACKET
15	1	10-6974	TTVAC CORD BRACKET
16	1	10-8112	MAGNET SPACER
17	2	10-8117	TTVAC-H LEVER BRACKET
18	1	17-0095	SPRING-EXTN .50 X 4.50 SST .045
19	2	17-0151	SPRING-COMP .94 X 9.00 SST.090
20	1	20-0179	SOLID 5 LOBE KNOB W/M8X30 STUD
21	1	21-0373	VALVE-SHUT OFF 3/8 NPT
22	1	21-0375	VLV-3WAY1/8PORTS 2HANDTIEDOWN
23	1	24-9933	1 QT GAST AD220 SAE 10 OIL
24	2	28-0168	3/8 BSP MUFFLER PLASTIC
25	1	28-0172	PLFTG-BLKHD UNION 12MM SST
26	1	28-0182	PLFTG-MALE CONN 12MM-3/8BSPT
27	2	28-0198	PLFTG-MALE CONN 6MM-1/8BSPT
28	1	28-0199	PLFTG-MALE ELBOW 6MM-1/8BSPT
29	1	28-0214	PLFTG-PLUG-IN RED 4MM-6MM
30	1	28-0216	PLFTG-MALE ELBOW 4MM-1/8BSPT
31	5	28-0319	PLFTG-BLKHD UNION 6MM SST
32	2	28-0320	1/2 BSP MUFFLER PLASTIC
33	4	28-0521	3/4 IN VACUUM HOSE
34	2	28-0552	HOSE CLAMP 6812 SS
35	1	28-3640	3/8 MUFFLER
36	1	28-4636	3/8 HOSE ASSY 8 FT LG
37	1	28-7185	1/8 NPT MUFFLER SINTERED BRZ
38	1	28-9056	3/8 QDISC FITTING BRASS
39	1	28-9093	3/8 HEX NIPPLE BRASS
40	2	28-9555	PLFTG-BLKHD CONN 8MM-3/8BSPT
41	2	28-9556	PLFTG-BLKHD CONN 12MM-1/2BSPT
42	1	28-9779	3/8 NPT BULKHEAD FITTING
43	2	29-0650	M5 X 10 MM LG HH SST DIN 933
44	4	29-0668	M6 X 12 MM LG HH SST DIN 933
45	2	29-0670	M6 X 16 MM LG HH SST DIN 933
46	2	29-0687	M8 X 16 MM LG HH SST DIN 933
47	16	29-0688	M8 X 20 MM LG HH SST DIN 933
48	3	29-0689	M8 X 25 HEX HEAD SST DIN 933
49	2	29-0781	M6 X 35 MM LG HH SST DIN 931
50	2	29-0868	M4 X 10 MM LG SH SST
51	2	29-0869	M4 X 12 MM LG SH SST
52	1	29-0873	M4 X 25 MM LG SH SST
53	2	29-0900	M5 X 70 MM LG SH SST
54	2	29-1125	M3 HEX NUT SST
55	3	29-1126	M4 HEX NUT SST
56	2	29-1128	M6 HEX NUT SST
57	19	29-1129	M8 HEX NUT SST
58	2	29-1169	M4 ACORN CAP NUT SST DIN 1587
59	2	29-1170	M5 ACORN CAP NUT SST DIN 1587
60	4	29-1388	DRIVE SCREW - SST
61	1	29-9315	3/8-16 X 1 LG HH SST
62	1	32-4215	TTVAC-H TRIGGER PLATE
63	1	37-0058	CVW VACUUM PIPE BUMPER
64	1	38-0866	LOCK BAR BEARING
65	2	99-0196	LBL-CAUTION OPR MAINT BY TRAIN
66	1	99-0426	LABEL-INT'L ELECTRICAL SYMBOL
67	1	99-0621	LABEL-INT'L LOCK-OUT (LARGE)
68	1	99-1030	NAME PLATE PNEUM-ELECTRCL CE

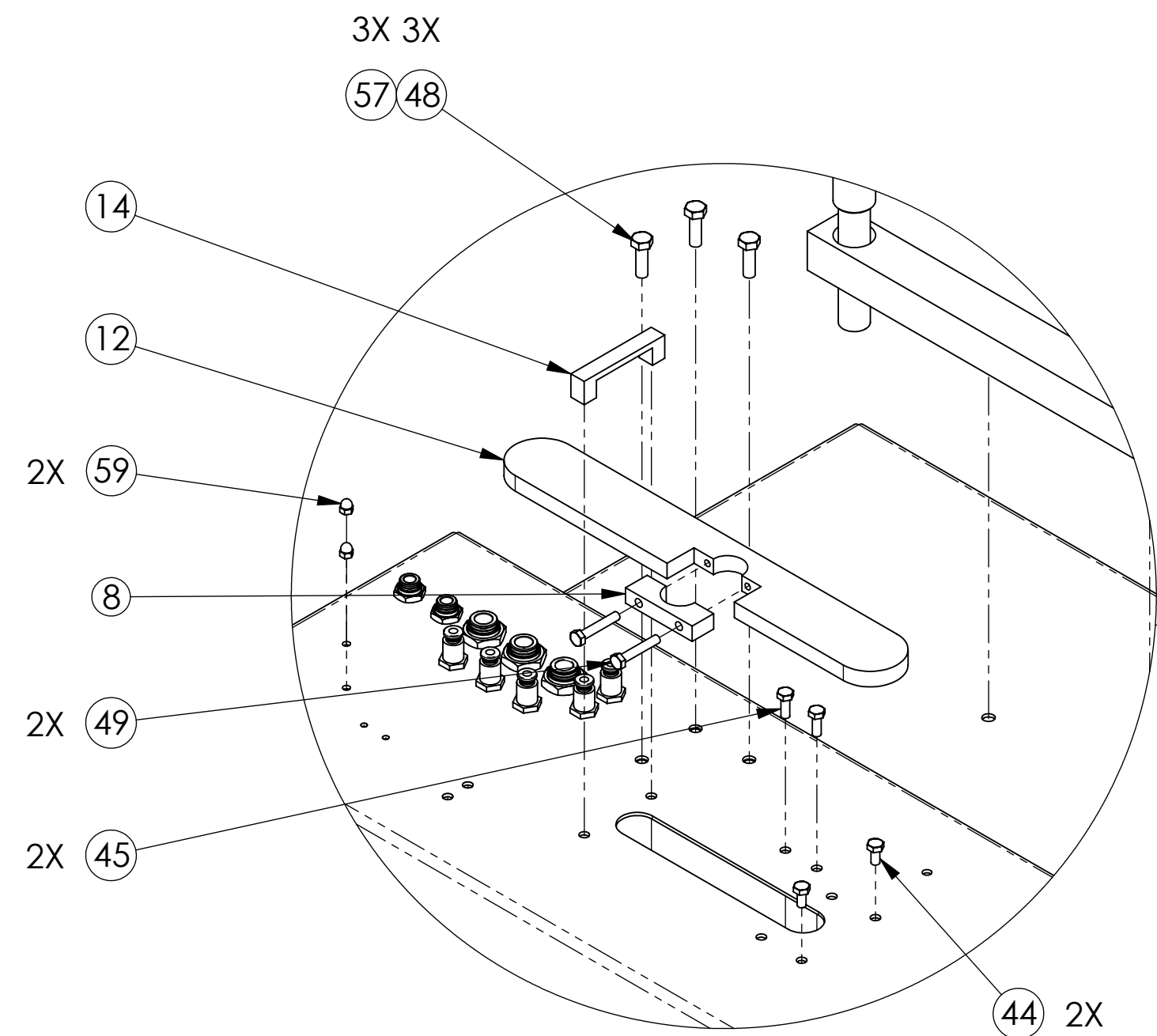


**VACUUM PUMP VOLTAGE OPTIONS**  
ON ORDER FORM - CHOOSE ONE  
**00-7782** 3/4HP 100V CLASS VACUUM PUMP ASSEMBLY  
OR  
**00-7783** 3/4 HP 200V CLASS VACUUM PUMP ASSEMBLY

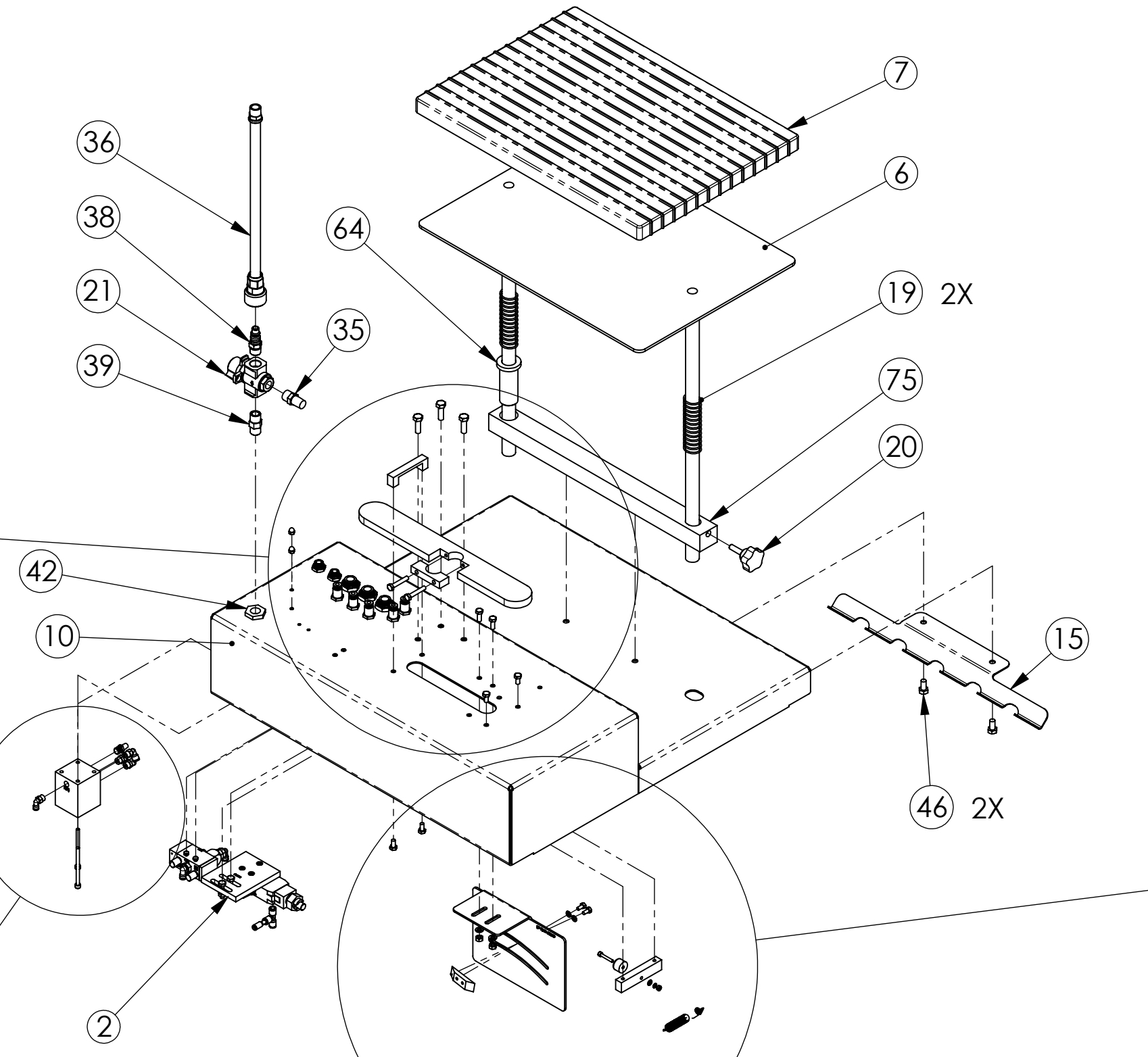
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07		SEE ECN TTVAC-H-07	11/29/23	CJS	03		SEE ECN TTVAC-H-03	07/25/23	CJS
06		SEE ECN TTVAC-H-06	11/17/23	CJS	02		SEE ECN TTVAC-H-02	06/21/23	CJS
05		SEE ECN TTVAC-H-05	11/01/23	CJS	01		SEE ECN TTVAC-H-01	06/07/23	CJS

	CHECKED BY DATE	S.GRIGGS 10/12/22	TTVAC-H ASSEMBLY
	APPROVED BY DATE	S.GRIGGS 10/12/22	
DRAWN BY DATE	J.NICHOLS 10/12/22	RELEASED BY DATE	J.NICHOLS 10/12/22
SCALE	1:6	PART NO.	<b>TTVAC-H-08</b>
DO NOT SCALE DRAWING		SHEET 1 of 4	

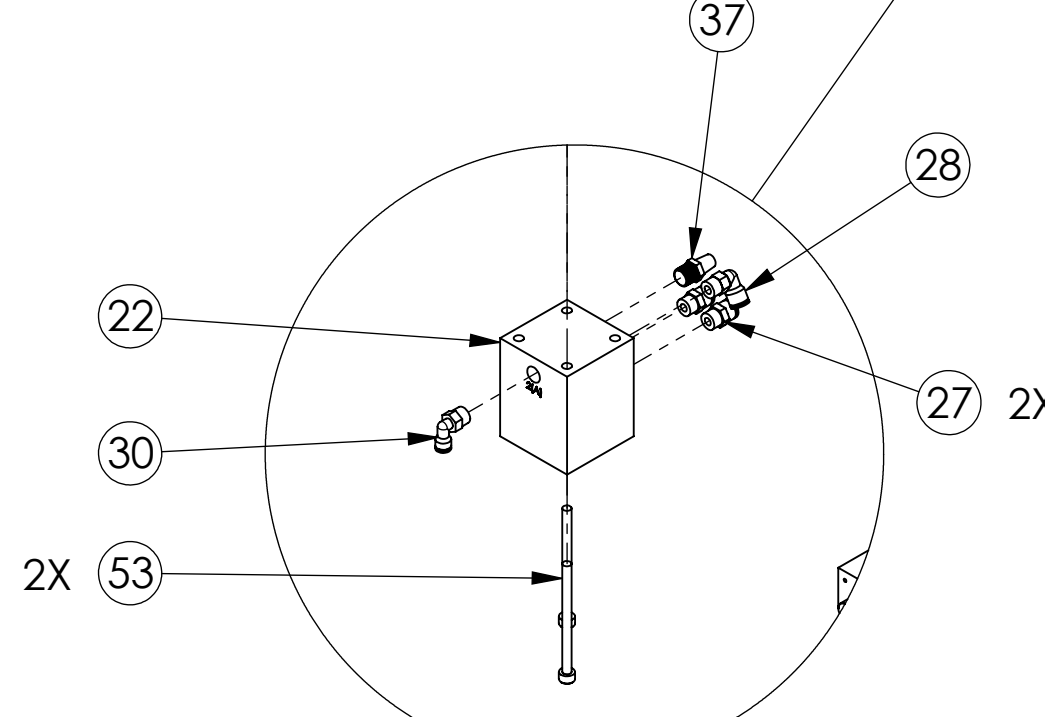
ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	00-5810	TTVAC WASTE TANK ASSEMBLY
2	1	00-5969	CLIPPER TRIGGER VALVE ASSEMBLY
3	1	00-6059	TTVAC FRAME ASSEMBLY
4	1	00-6784	TTVAC-H VACUUM NOZZLE ASSEMBLY
5	1	00-6785	FRL ASSEMBLY
6	1	01-0157	SUB-PRODUCT TABLE
7	1	01-0159	PRODUCT TABLE
8	1	01-0421	CVW-GF SLOT GUARD BLOCK
9	1	01-1773	TICAV-H TRIGGER BLOCK
10	1	07-0623	TTVAC-H TABLE TOP
11	1	07-0706	TTVAC DOOR ASSEMBLY
12	1	09-0349	CVW-GF SLOT GUARD
13	1	10-0900	CVW BUMPER BRACKET
14	1	10-0902	CVW GUIDE BRACKET
15	1	10-6974	TTVAC CORD BRACKET
16	1	10-8112	MAGNET SPACER
17	2	10-8117	TTVAC-H LEVER BRACKET
18	1	17-0095	SPRING-EXTN .50 X 4.50 SST .045
19	2	17-0151	SPRING-COMP .94 X 9.00 SST.090
20	1	20-0179	SOLID 5 LOBE KNOB W/M8X30 STUD
21	1	21-0373	VALVE-SHUT OFF 3/8 NPT
22	1	21-0375	VLV-3WAY1/8PORTS 2HANDTIEDOWN
23	1	24-9933	1 QT GAST AD220 SAE 10 OIL
24	2	28-0168	3/8 BSPT MUFFLER PLASTIC
25	1	28-0172	PLFTG-BLKHD UNION 12MM SST
26	1	28-0182	PLFTG-MALE CONN 12MM-3/8BSPT
27	2	28-0198	PLFTG-MALE CONN 6MM-1/8BSPT
28	1	28-0199	PLFTG-MALE ELBOW 6MM-1/8BSPT
29	1	28-0214	PLFTG-PLUG-IN RED 4MM-6MM
30	1	28-0216	PLFTG-MALE ELBOW 4MM-1/8BSPT
31	5	28-0319	PLFTG-BLKHD UNION 6MM SST
32	2	28-0320	1/2 BSP MUFFLER PLASTIC
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34	2	28-0552	HOSE CLAMP 6812 SS
35	1	28-3640	3/8 MUFFLER
36	1	28-4636	3/8 HOSE ASSY 8 FT LG
37	1	28-7185	1/8 NPT MUFFLER SINTERED BRZ
38	1	28-9056	3/8 QDISC FITTING BRASS
39	1	28-9093	3/8 HEX NIPPLE BRASS
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46	2	29-0687	M8 X 16 MM LG HH SST DIN 933
47	16	29-0688	M8 X 20 MM LG HH SST DIN 933
48	3	29-0689	M8 X 25 HEX HEAD SST DIN 933
49	2	29-0781	M6 X 35 MM LG HH SST DIN 931
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51	2	29-0869	M4 X 12 MM LG SH SST
52	1	29-0873	M4 X 25 MM LG SH SST
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54	2	29-1125	M3 HEX NUT SST
55	3	29-1126	M4 HEX NUT SST
56	2	29-1128	M6 HEX NUT SST
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69	3	99-1181	4MM ID FLAT WASHER SST
70	2	99-1182	5MM ID FLAT WASHER SST
71	2	99-1183	6MM ID FLAT WASHER SST
72	2	99-1242	3MM ID LOCKWASHER SST
73	1	99-1243	4MM ID LOCKWASHER SST
74	1	99-1397	MAGNET CATCH
75	1	99-7470	TTVAC LOCK BAR



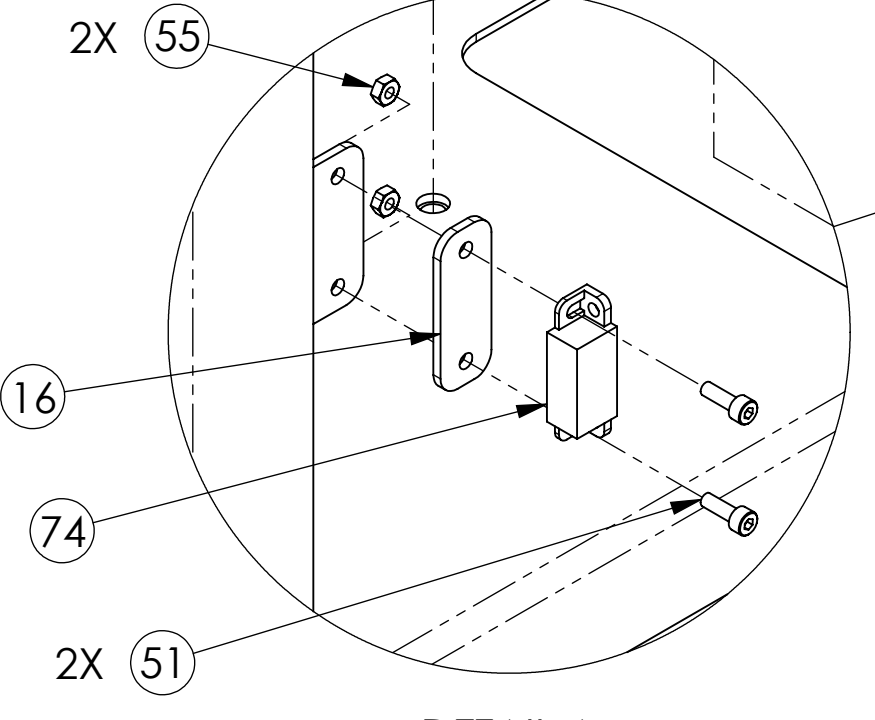
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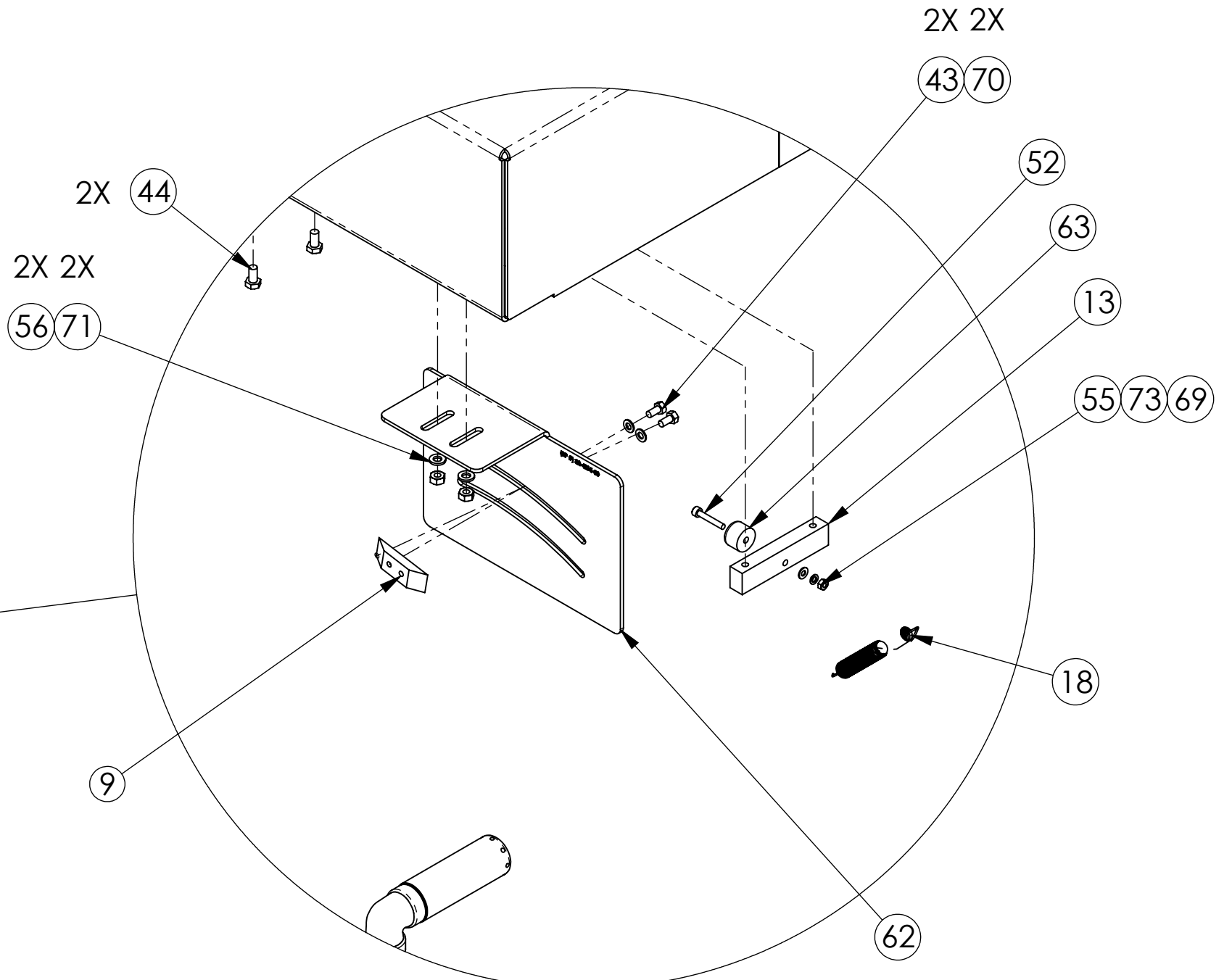
DETAIL C  
SCALE 1 : 4



DETAIL D  
SCALE 1 : 4



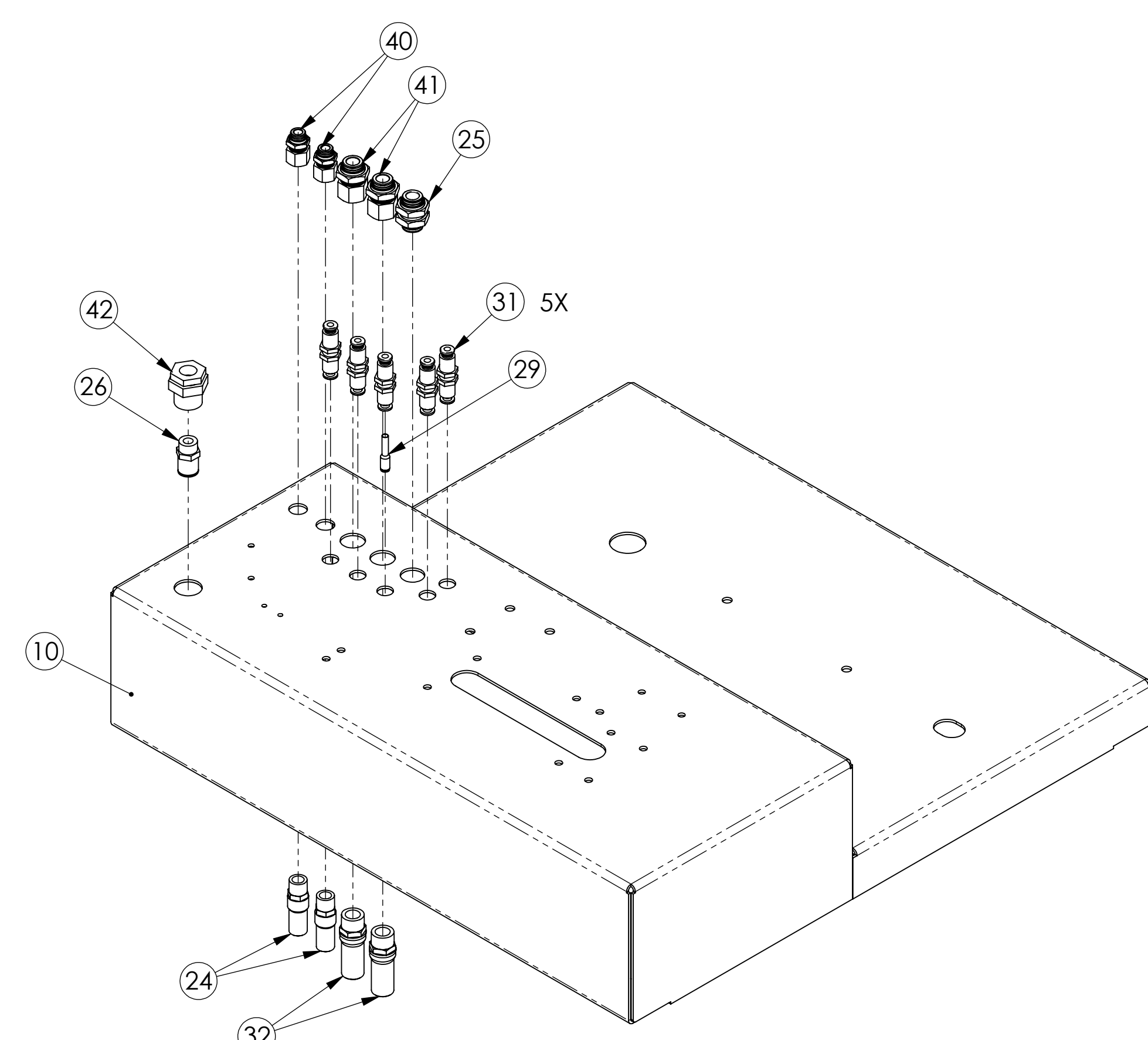
DETAIL A  
SCALE 1 : 2



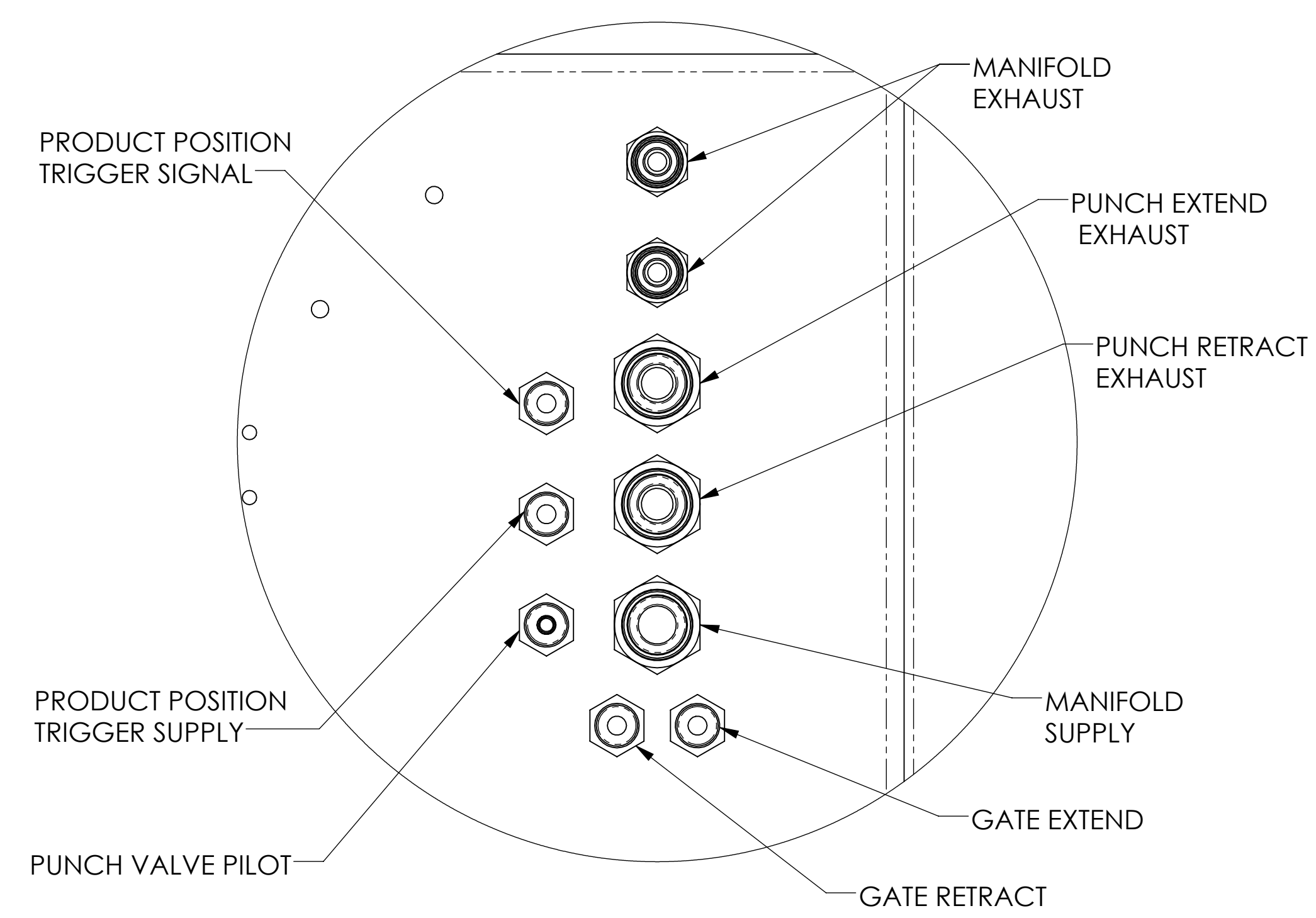
DETAIL B  
SCALE 1 : 4

	CHECKED BY DATE S.GRIGGS 10/12/22	<b>TTVAC-H ASSEMBLY</b>
	APPROVED BY DATE S.GRIGGS 10/12/22	
DRAWN BY DATE J.NICHOLS 10/12/22	RELEASED BY DATE J.NICHOLS 10/12/22	PART NO. <b>TTVAC-H-08</b>
SCALE 1:8	DO NOT SCALE DRAWING	SHEET 2 of 4

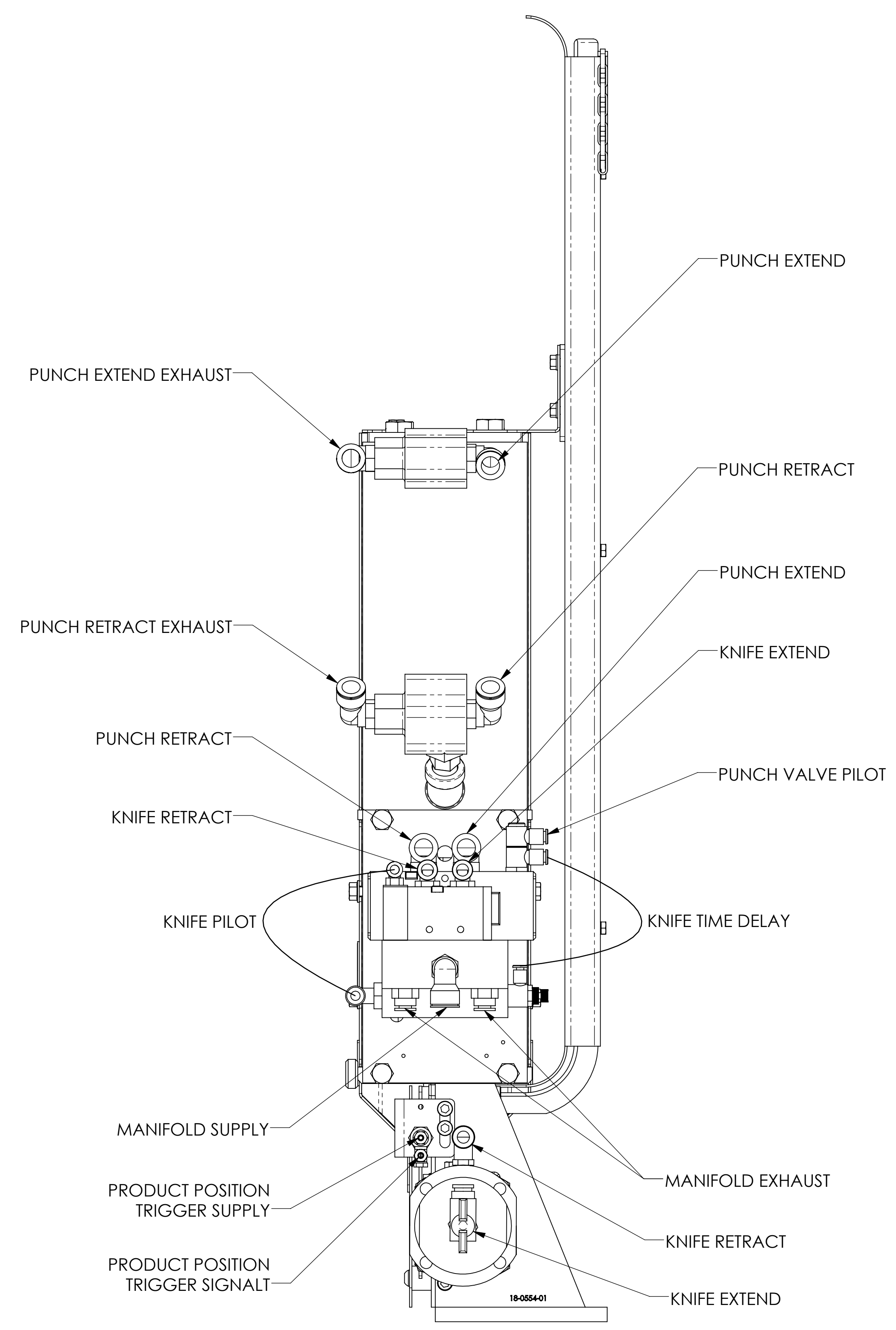
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3	1	00-6059	TTVAC FRAME ASSEMBLY
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5	1	00-6785	FRL ASSEMBLY
6	1	01-0157	SUB-PRODUCT TABLE
7	1	01-0159	PRODUCT TABLE
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9	1	01-1773	TTCV-H TRIGGER BLOCK
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11	1	07-0706	TTVAC DOOR ASSEMBLY
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25	1	28-0172	PLFTG-BLKHD UNION 12MM SST
26	1	28-0182	PLFTG-MALE CONN 12MM-3/8BSPT
27	2	28-0198	PLFTG-MALE CONN 6MM-1/8BSPT
28	1	28-0199	PLFTG-MALE ELBOW 6MM-1/8BSPT
29	1	28-0214	PLFTG-PLUG-IN RED 4MM-6MM
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38	1	28-9056	3/8 QDISC FITTING BRASS
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41	2	28-9556	PLFTG-BLKHD CONN 12MM-1/2BSPT
42	1	28-9779	3/8 NPT BULKHEAD FITTING
43	2	29-0650	M5 X 10 MM LG HH SST DIN 933
44	4	29-0668	M6 X 12 MM LG HH SST DIN 933
45	2	29-0670	M6 X 16 MM LG HH SST DIN 933
46	2	29-0687	M8 X 16 MM LG HH SST DIN 933
47	16	29-0688	M8 X 20 MM LG HH SST DIN 933
48	3	29-0689	M8 X 25 HEX HEAD SST DIN 933
49	2	29-0781	M6 X 35 MM LG HH SST DIN 931
50	2	29-0868	M4 X 10 MM LG SH SST
51	2	29-0869	M4 X 12 MM LG SH SST
52	1	29-0873	M4 X 25 MM LG SH SST
53	2	29-0900	M5 X 70 MM LG SH SST
54	2	29-1125	M3 HEX NUT SST
55	3	29-1126	M4 HEX NUT SST
56	2	29-1128	M6 HEX NUT SST
57	19	29-1129	M8 HEX NUT SST
58	2	29-1169	M4 ACORN CAP NUT SST DIN 1587
59	2	29-1170	M5 ACORN CAP NUT SST DIN 1587
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62	1	32-4215	TTVAC-H TRIGGER PLATE
63	1	37-0058	CVW VACUUM PIPE BUMPER
64	1	38-0866	LOCK BAR BEARING
65	2	99-0196	LBL-CAUTION OPR MAINT BY TRAIN
66	1	99-0426	LABEL-INT'L ELECTRICAL SYMBOL
67	1	99-0621	LABEL-INT'L LOCK-OUT (LARGE)
68	1	99-1030	NAME PLATE PNEUM-ELECTRICAL CE
69	3	99-1181	4MM ID FLAT WASHER SST
70	2	99-1182	5MM ID FLAT WASHER SST
71	2	99-1183	6MM ID FLAT WASHER SST
72	2	99-1242	3MM ID LOCKWASHER SST
73	1	99-1243	4MM ID LOCKWASHER SST
74	1	99-1397	MAGNET CATCH
75	1	99-7470	TTVAC LOCK BAR



**BULKHEAD FITTINGS**  
SCALE 1:4



**BULKHEAD FITTINGS**  
SCALE 2:3



	CHECKED BY DATE S.GRIGGS 10/12/22	<b>TTVAC-H ASSEMBLY</b>
	APPROVED BY DATE S.GRIGGS 10/12/22	
DRAWN BY DATE J.NICHOLS 10/12/22	RELEASED BY DATE J.NICHOLS 10/12/22	SIZE: <b>D</b> SCALE: 1:3 PART NO.: <b>TTVAC-H-08</b> DO NOT SCALE DRAWING SHEET 3 of 4

SEE SHEET 3 FOR CLIPPER FITTING CALLOUTS

MAIN AIR SUPPLY

SEE SHEET 3 FOR BULKHEAD FITTING CALLOUT

MAIN AIR SUPPLY

TWO HAND TIE DOWN VALVE 21-0375

GATE VALVE/CLIPPER TRIGGER ASSY. 00-5969

VACUUM PUMP ASSY. 00-7782 OR 00-7783

VACUUM NOZZLE ASSY. 00-6784

TO WASTE TANK

FROM WASTE TANK

FROM VACUUM PUMP

TO VACUUM NOZZLE

TTVAC WASTE TANK ASSY. 00-5810

MAIN AIR SUPPLY IN

CLIPPER MANIFOLD SUPPLY TO BULKHEAD

CLIPPER TRIGGER SUPPLY

ROLLER VALVE SUPPLY

TWO HAND TIE DOWN VALVE SUPPLY

GATE VALVE SUPPLY

PRODUCT POS. TRIGGER SUPPLY TO BULKHEAD

FRL ASSEMBLY SCALE 2:5

VACUUM VALVE CLOSE

VACUUM VALVE OPEN

ROLLER VALVE SUPPLY

REAR ISOMETRIC VIEW

GATE VALVE PILOT

GATE RETRACT TO BULKHEAD

GATE EXTEND TO BULKHEAD

PUNCH VALVE PILOT TO BULKHEAD

END OF STROKE POWER AIR (CLIPPER TRIGGER VALVE)

FRONT ISOMETRIC VIEW

GATE VALVE SUPPLY

CLIPPER TRIGGER SUPPLY

END OF STROKE POWER AIR (CLIPPER TRIGGER VALVE)

GATE VALVE/CLIPPER TRIGGER SCALE 2:5

TWO HAND TIE DOWN VALVE SUPPLY FROM FRL MANIFOLD

GATE VALVE PILOT

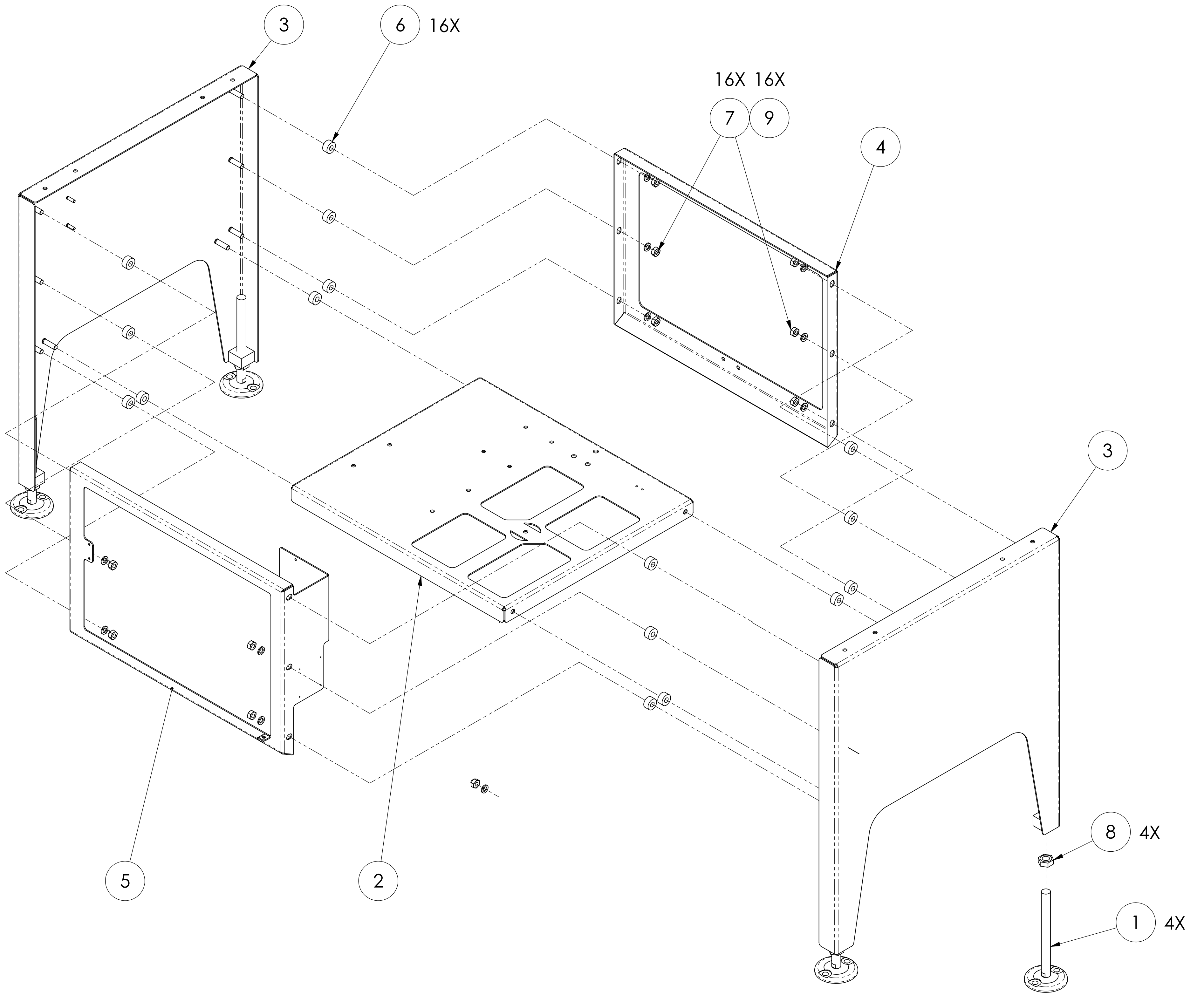
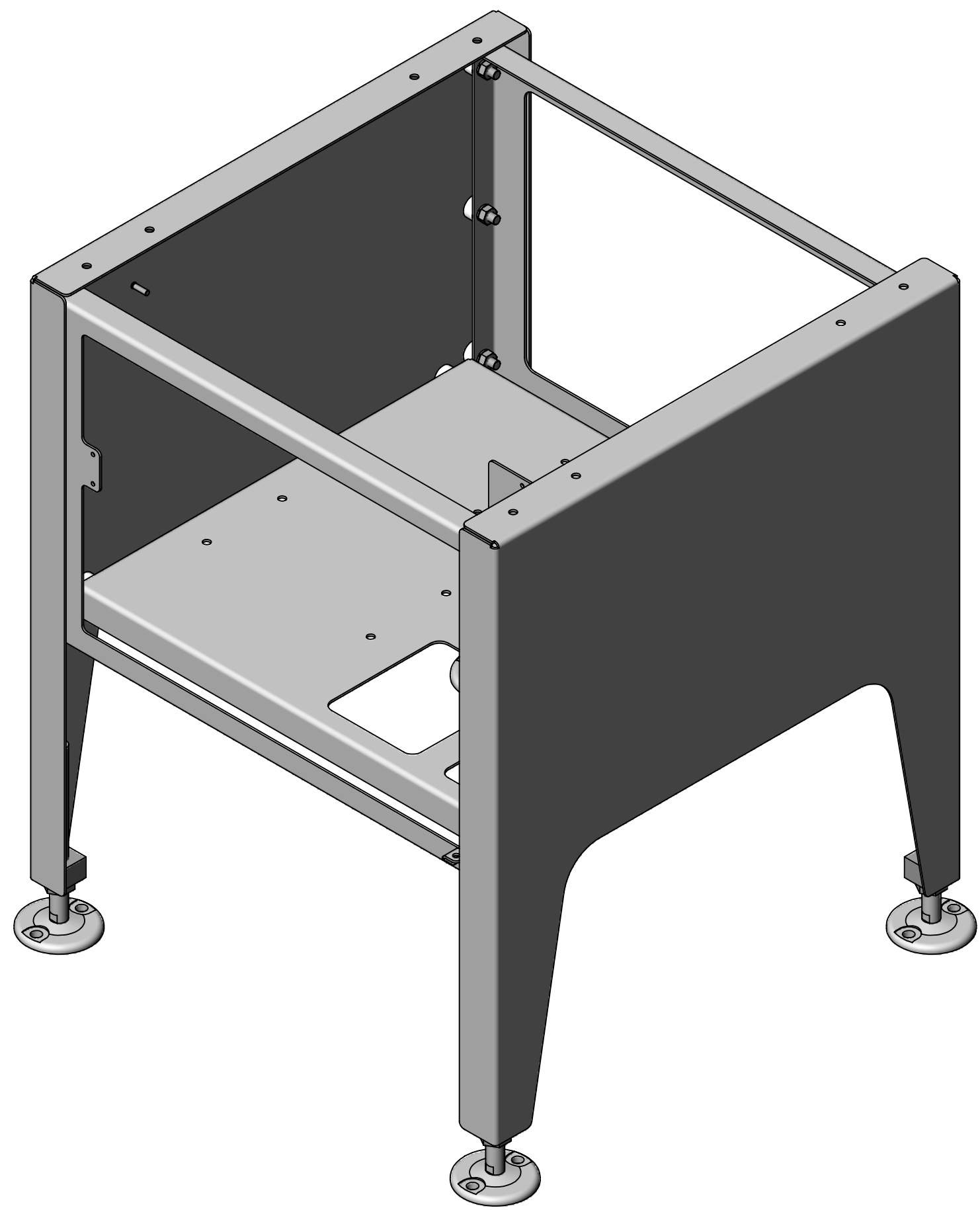
PRODUCT POS. TRIGGER SIGNAL

VACUUM NOZZLE POS. SIGNAL

TWO HAND TIE DOWN VALVE SCALE 2:5

	CHECKED BY DATE S.GRIGGS 10/12/22	TTVAC-H ASSEMBLY
	APPROVED BY DATE S.GRIGGS 10/12/22	
DRAWN BY DATE J.NICHOLS 10/12/22	RELEASED BY DATE J.NICHOLS 10/12/22	PART NO. TTVAC-H-08
SCALE 1:5	DO NOT SCALE DRAWING	SHEET 4 of 4

ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	4	01-0782	LEVELER FOOT - 3/4 X 8 STUD
2	1	07-0624	TTVAC LOWER FRAME
3	2	07-0625	TTVAC FRAME SIDE WELDMENT
4	1	10-8113	TTVAC STIFFENER-REAR
5	1	10-8114	TTVAC FRONT SUPPORT WELDMENT
6	16	16-1344	SPACER-.50 RND 1 X .44 DELRIN
7	16	29-1133	M10 HEX NUT SST
8	4	29-9628	3/4-10 HEX JAM NUT SST
9	16	99-1247	10MM ID LOCKWASHER SST



NO.	ZONE	DESCRIPTION	DATE	APPROVED	NO.	ZONE	DESCRIPTION	DATE	APPROVED
					01		SEE ECN 00-6059-01	11/29/23	CJS

	CHECKED BY DATE	S. GRIGGS 2/14/23	<b>TTVAC FRAME ASSEMBLY</b>
	APPROVED BY DATE	M. LOWDER 2/14/23	
DRAWN BY DATE	S. GRIGGS 2/14/23	RELEASED BY DATE	S. GRIGGS 2/14/23
SCALE	1:5	PART NO.	00-6059-01
DO NOT SCALE DRAWING		SHEET 1 of 1	

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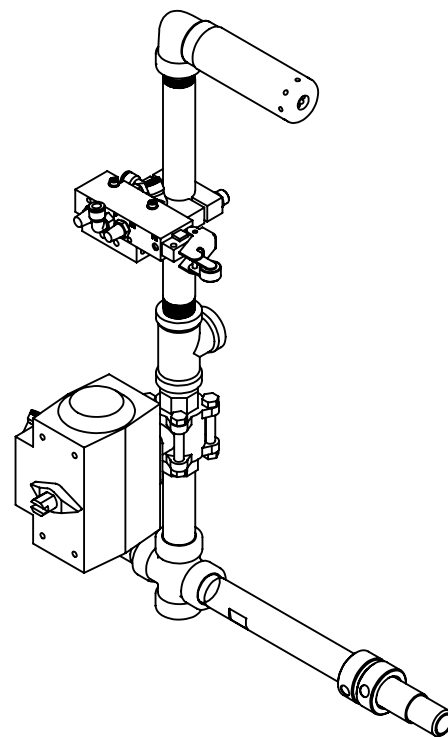
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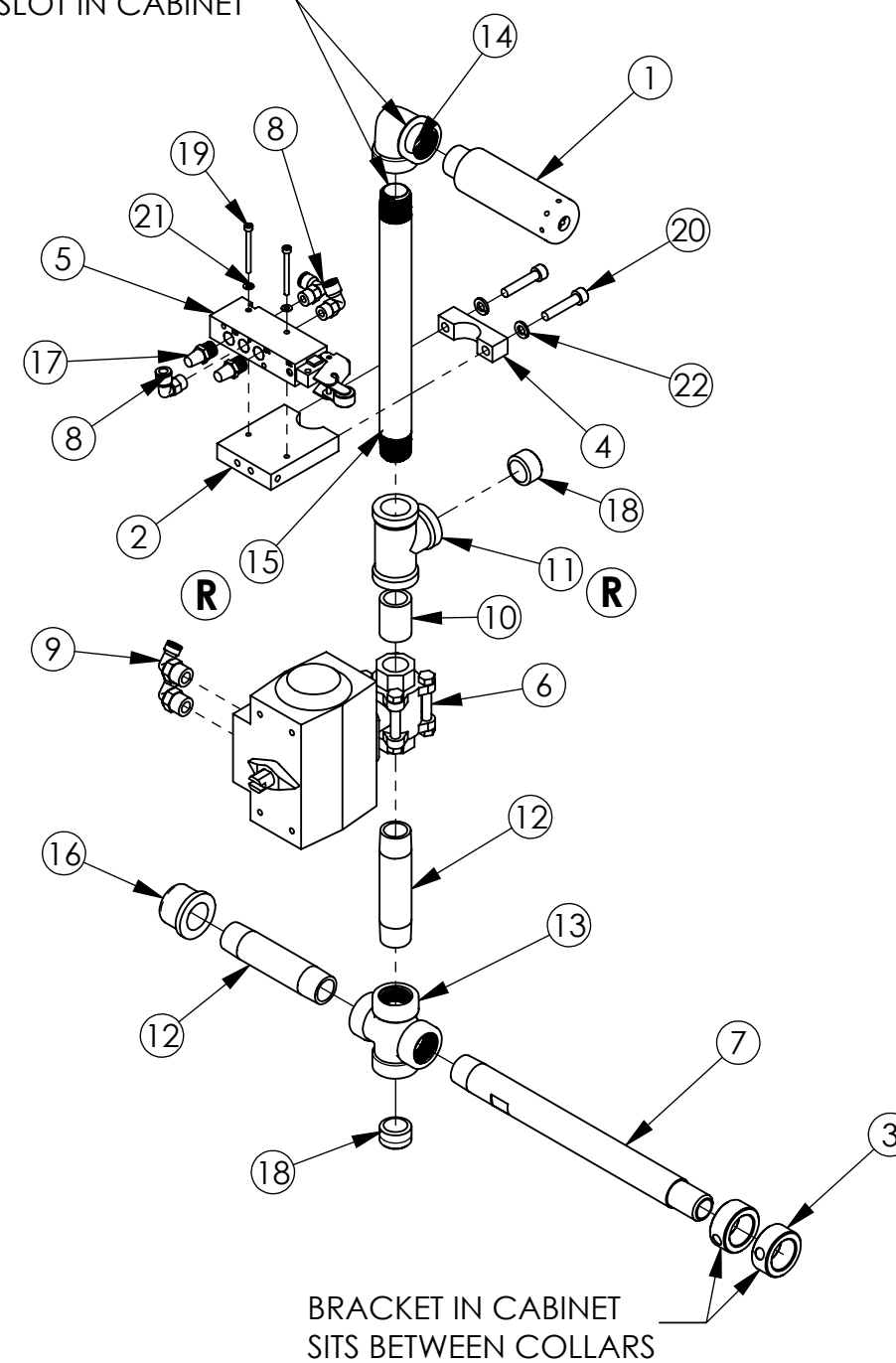
2

1

ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	00-5873	CLIPPER VAC (H) NOZZLE
2	1	10-6979	TTVAC-H VALVE BRACKET
3	2	16-0976	COLLAR-SPCL CLIPPER VACS B C F
4	1	16-1349	COLLAR-SPCL TTVAC-H
5	1	21-0377	VLV-MECHNCL 5PORT ROLLER LEVER
6	1	21-0419	VALVE-BALL 1/2 INCH W/ ACTUATOR
7	1	21-0617	NIPPLE-SPCL FOR CLIPPER VAC
8	3	28-0199	PLFTG-MALE ELBOW 6MM-1/8BSPT
9	2	28-0306	PLFTG-MALE ELBOW 6MM-1/4BSPT
10	1	28-0545	1/2 CLOSE NIPPLE SST
11	1	28-0783	1/2 NPT UNION TEE SST
12	2	28-1060	1/2 X 3-1/2 NIPPLE SST
13	1	28-1065	1/2 NPT CROSS SST
14	1	28-1066	1/2 X 90 DEG ELBOW SST
15	1	28-1146	1/2 NPT X 8 1/2 PIPE NIPPLE SST
16	1	28-1235	1/2 NPT CAP CPLT, 304 SST
17	2	28-7185	1/8 NPT MUFFLER SINTERED BRZ
18	2	28-9137	1/2 ALLEN PIPEPLUG FLUSH MT SST
19	2	29-0859	M3 X 35 MM LG SH SST
20	2	29-0909	M6 X 30 MM LG SH SST
21	2	99-1180	3MM ID FLAT WASHER SST
22	2	99-1245	6MM ID LOCKWASHER SST



CONNECT ONCE PIPE IS THROUGH SLOT IN CABINET



04		SEE ECN 00-6784-04	09/05/23	CJS
03		SEE ECN 00-6784-03	08/23/23	CJS
02		SEE ECN 00-6784-02	08/02/23	CJS
01		SEE ECN 00-6784-01	07/25/23	CJS
NO.	ZONE	DESCRIPTION	DATE	APPROVED

### REVISIONS



DRAWN BY DATE  
J.NICHOLS 10/12/22

CHECKED BY DATE  
S.GRIGGS 10/12/22

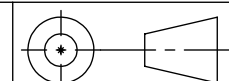
APPROVED BY DATE  
S.GRIGGS 10/12/22

RELEASED BY DATE  
J.NICHOLS 10/12/22

## TTVAC-H VACUUM NOZZLE ASSEMBLY

SIZE

B



PART NO.

00-6784-04

SCALE 1:5

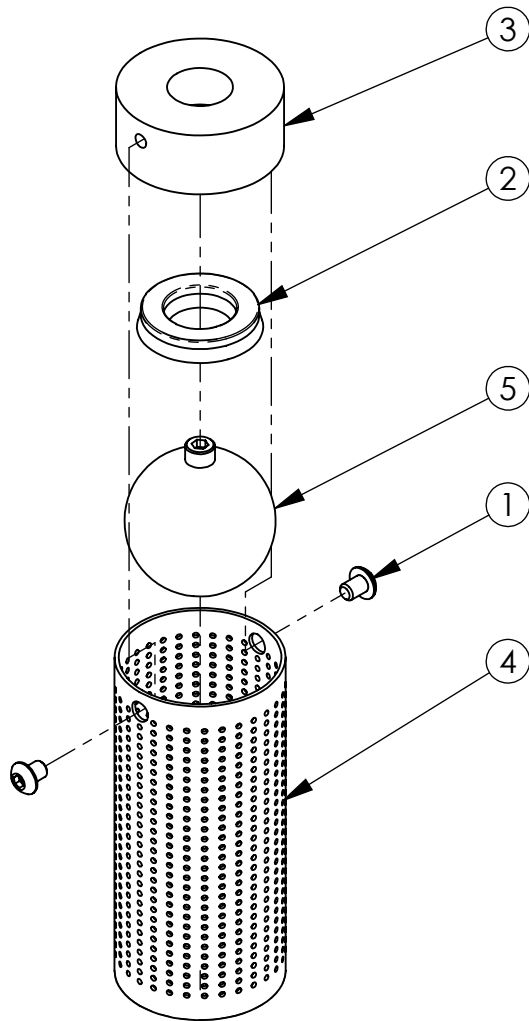
DO NOT SCALE DRAWING

SHEET 1 of 1

REVISIONS

NO.	DESCRIPTION	DATE	APPROVED	NO.	DESCRIPTION	DATE	APPROVED
01	NO ECN DATA						

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	29-9179	10-32 X 1/4 LG BH SST	2
2	41-0849	U CUP #AN-6226-16	1
3	99-0768	CONNECTOR	1
4	99-0769	FILTER	1
5	99-0848	BALL	1



CHECKED BY DATE  
ST 09/02/11

APPROVED BY DATE  
ST 09/02/11

RELEASED BY DATE  
CDS 09/02/11

SHUT-OFF VALVE ASSY

SIZE  
**A**

PART NO.  
**00-0805-01**

SCALE 1:2

DO NOT SCALE  
DRAWING

SHEET 1 of 1

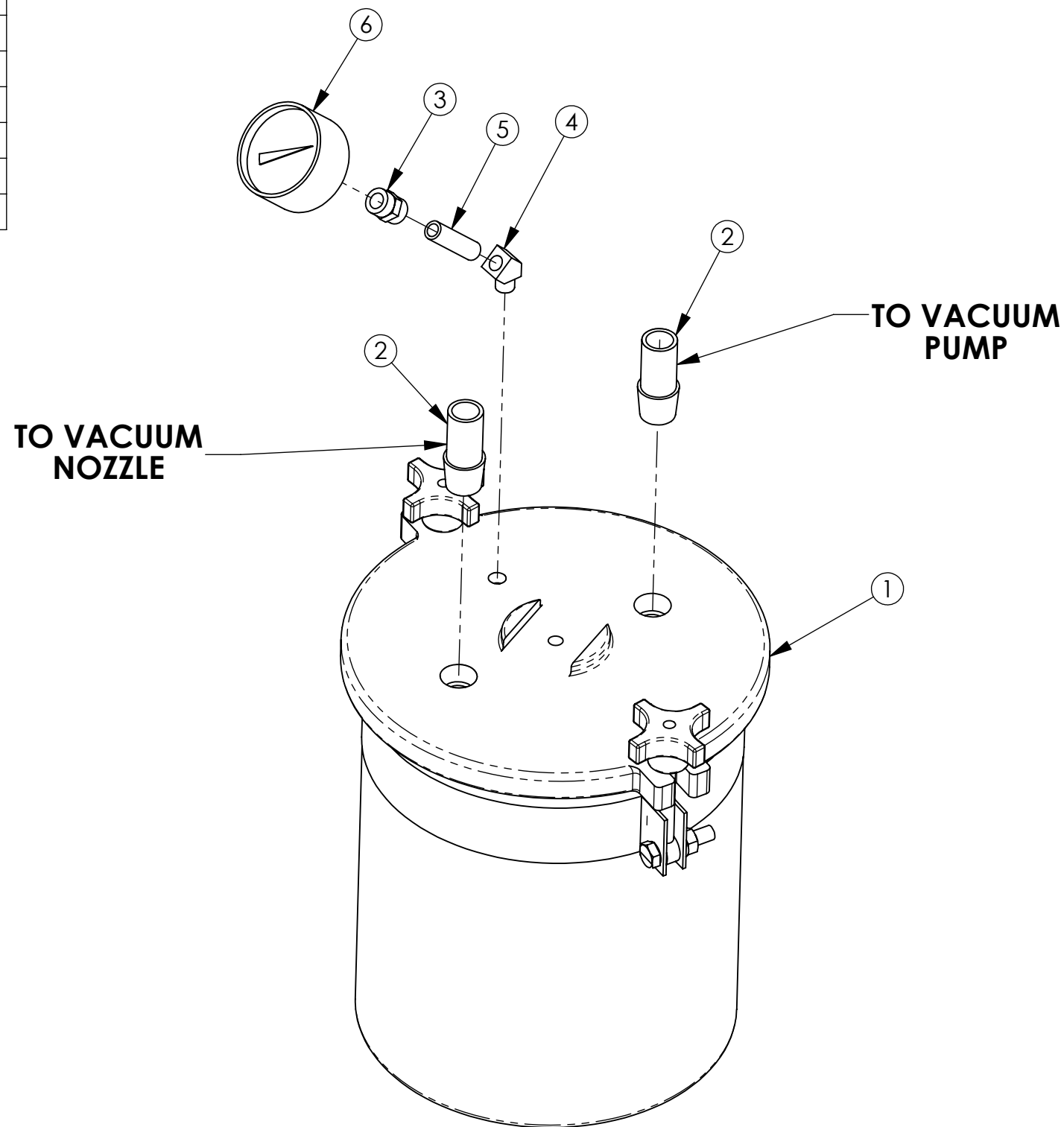
4

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1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	00-4153	WASTE TANK SUB-ASSY	1
2	28-0399	1/2 NPT HALF NIPPLE SST MOD 28-1234	2
3	28-9057	1/8 NPT COUPLING BRASS	1
4	28-9070	1/8 X 45 DEG STREET ELBOW BRASS	1
5	28-9104	1/8 X 1-1/2 NIPPLE	1
6	31-0852	GAUGE-0-30 PSI 2.00 IN DIAL	1



NO.	ZONE	DESCRIPTION	DATE	APPROVED
REVISIONS				



CHECKED BY DATE  
S.GRIGGS 04/21/21

APPROVED BY DATE  
S.GRIGGS 04/21/21

RELEASED BY DATE  
J.NICHOLS 04/21/21

TTVAC WASTE TANK ASSEMBLY A

SIZE B

SCALE 1:12

PART NO. 00-5810-00

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SHEET 1 of 1

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4

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D

C

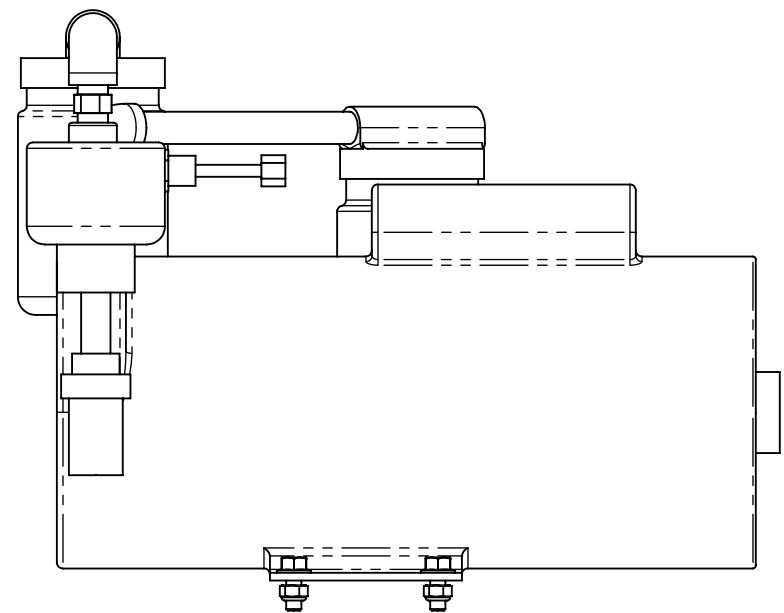
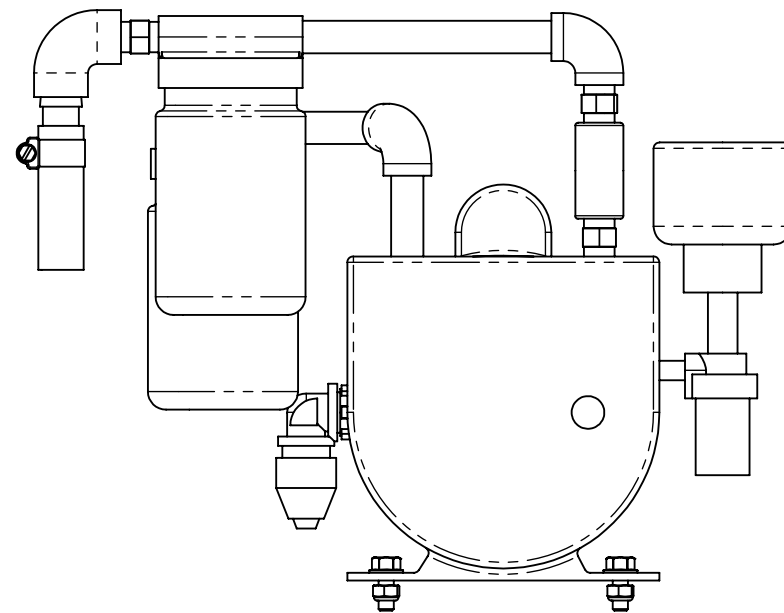
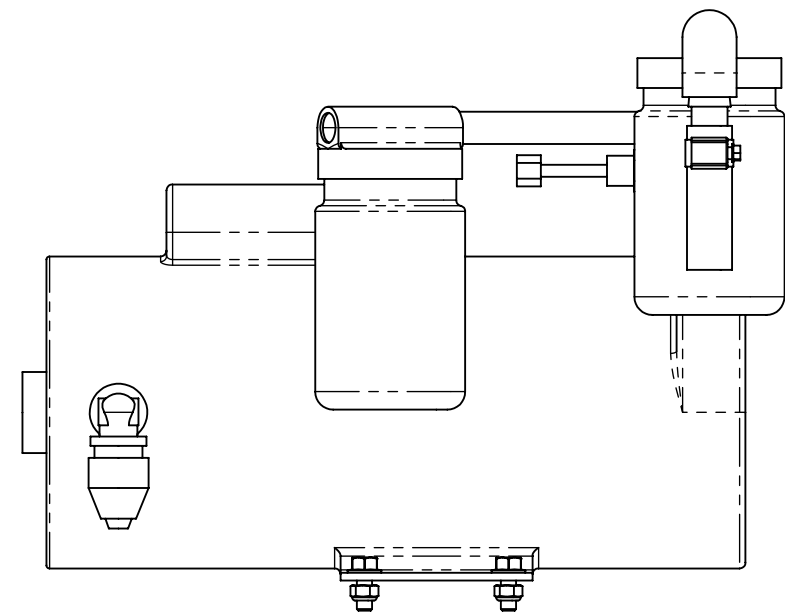
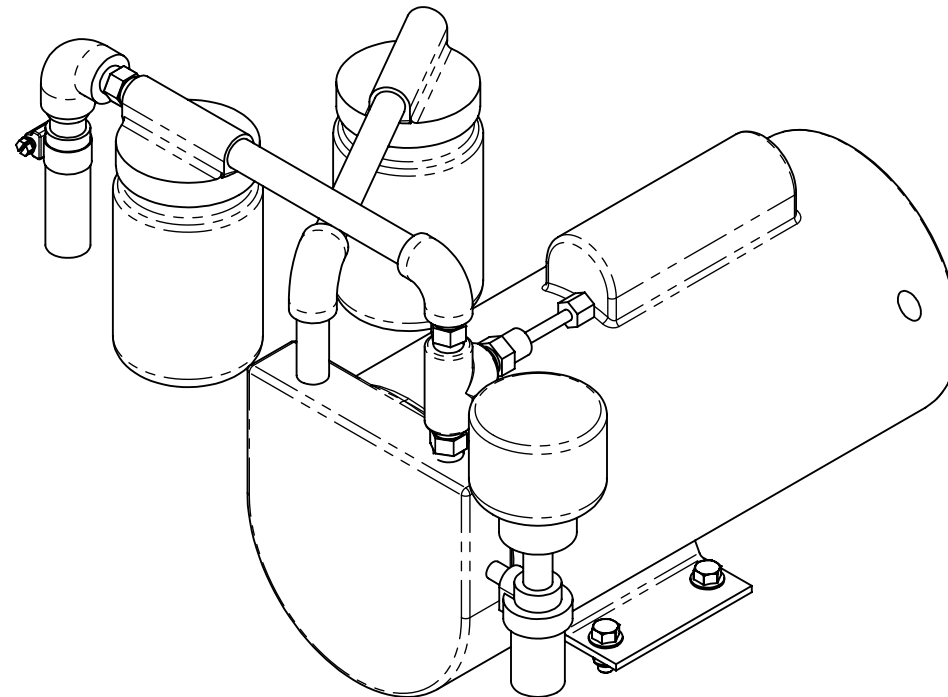
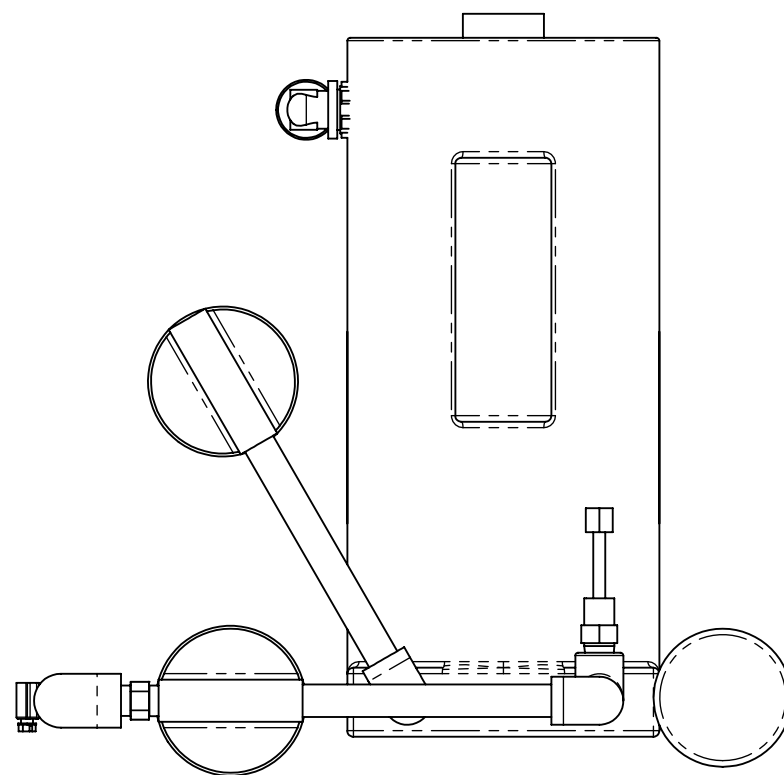
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B

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A

A



04		SEE ECN 00-7782-04	10/13/23	CJS
03		SEE ECN 00-7782-03	08-10-23	SDG
02		SEE ECN 00-7782-02	04/27/21	JAN
01		SEE ECN 00-7782-01	04/22/21	JAN
NO.	ZONE	DESCRIPTION	DATE	APPROVED

REVISIONS



DRAWN BY DATE  
J.NICHOLS 2/3/21

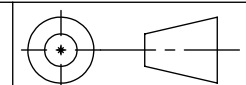
CHECKED BY DATE  
S.GRIGGS 2/3/21

APPROVED BY DATE  
S.GRIGGS 2/3/21

RELEASED BY DATE  
J.NICHOLS 2/3/21

### 3/4 HP 100V CLASS VAC PUMP ASSY

SIZE  
B



PART NO.  
**00-7782-04**

SCALE  
1:4

DO NOT SCALE DRAWING

SHEET 1 of 2

4

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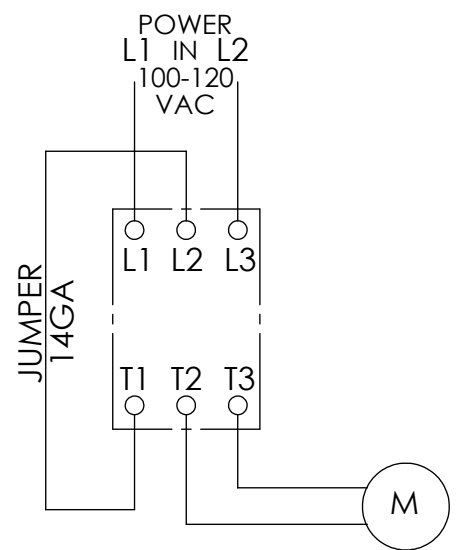
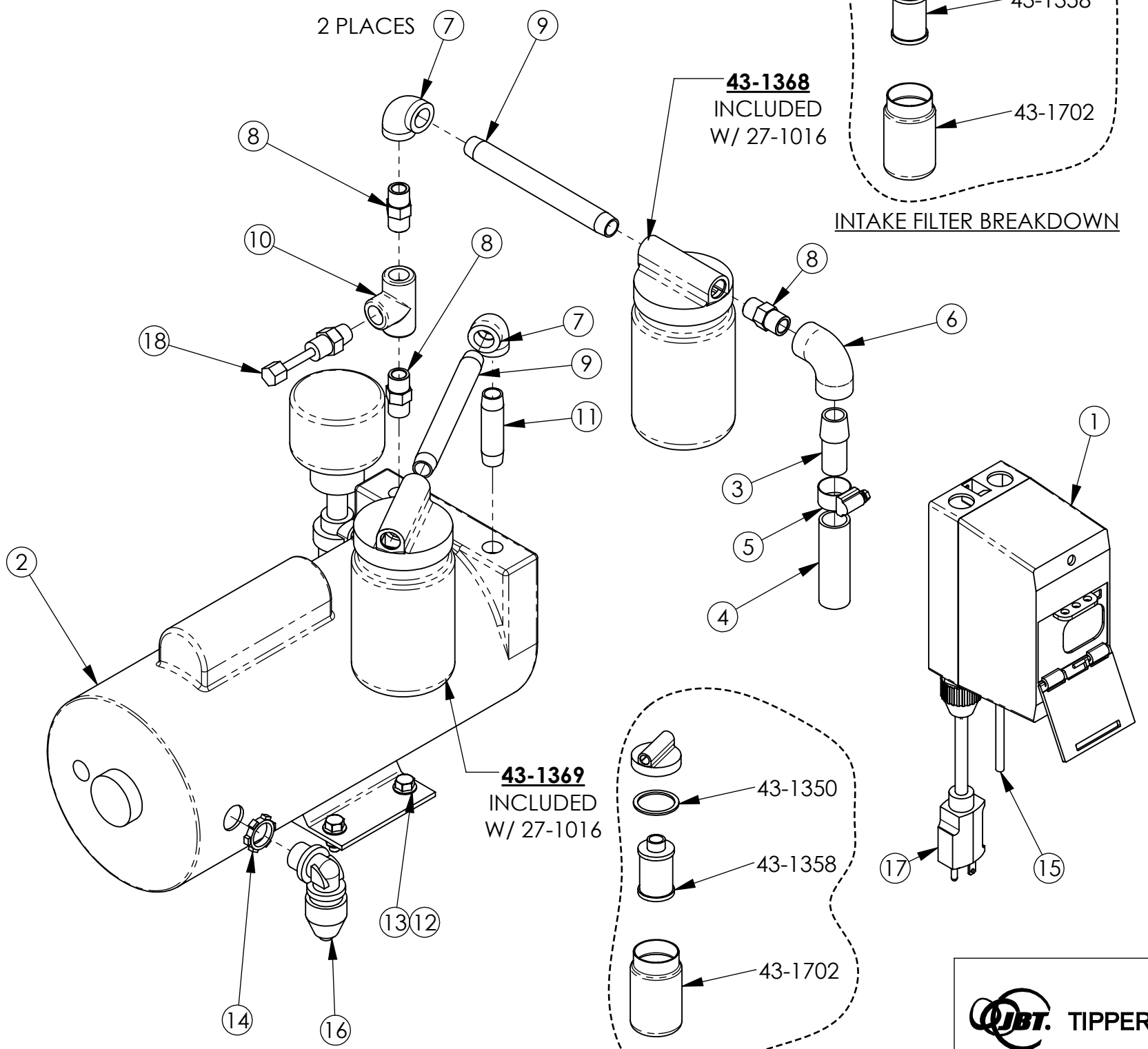
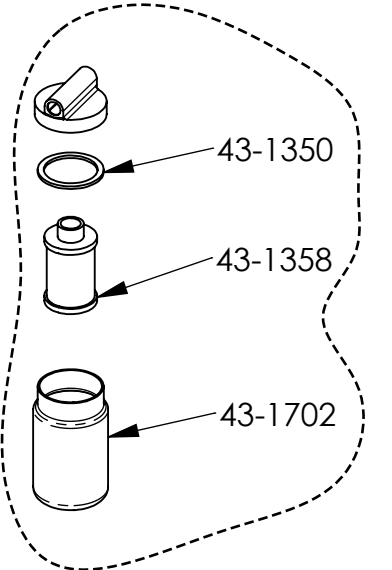
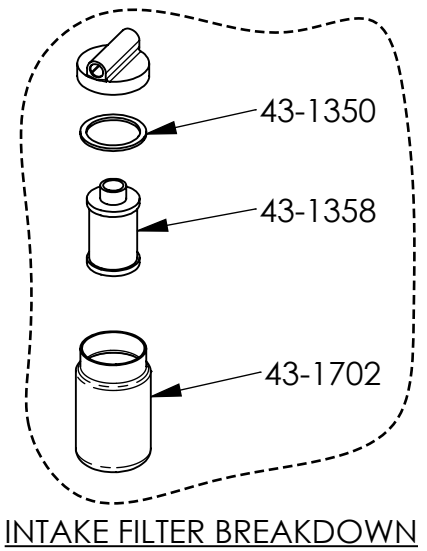
D

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ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	00-3506	ON/OFF SW ASSY EATON 8-12 A
2	1	27-1016	PUMP-VACUUM 3/4 HP 8.0 CFM
3	1	28-0399	1/2NPTHALFNIPPLESST MOD28-1234
4	1	28-0521	3/4 IN VACUUM HOSE
5	1	28-0552	HOSE CLAMP 6812 SS
6	1	28-9085	3/8 X 1/2 ELBOW GALV
7	2	28-9089	3/8 ELBOW GALV
8	3	28-9093	3/8 HEX NIPPLE BRASS
9	2	28-9128	3/8 X 6 NIPPLE SST
10	1	28-9149	3/8 TEE GALV
11	1	28-9467	3/8 X 2-1/2 NIPPLE SST
12	4	29-0178	M8 ELASTIC LOCKNUT SST
13	4	29-1711	M8 X 20 MM LG HFLG SST DIN 6921
14	1	30-0031	LOCKNUT-SEALING .50 CONDUIT
15	1	30-0063	CA-SUTO-16/3 AWG YELLOW
16	1	30-0242	CONN-CORDGRIP 90DEG1/2 .25/.40
17	1	30-0246	CORD-PWR A 14/3 125V 15A 9FT
18	1	43-1389	VAC. RELIEF VLV #AA840



	CHECKED BY DATE S.GRIGGS 2/3/21	<b>3/4 HP 100V CLASS VAC PUMP ASSY</b>	
	APPROVED BY DATE S.GRIGGS 2/3/21		
DRAWN BY DATE J.NICHOLS 2/3/21	RELEASED BY DATE J.NICHOLS 2/3/21	SIZE <b>B</b> 	PART NO. <b>00-7782-04</b>
SCALE 1:8		DO NOT SCALE DRAWING	SHEET 2 of 2

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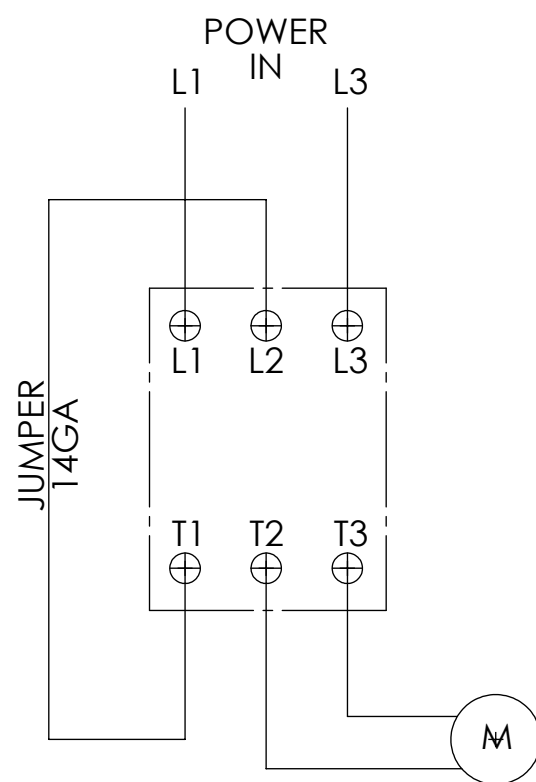
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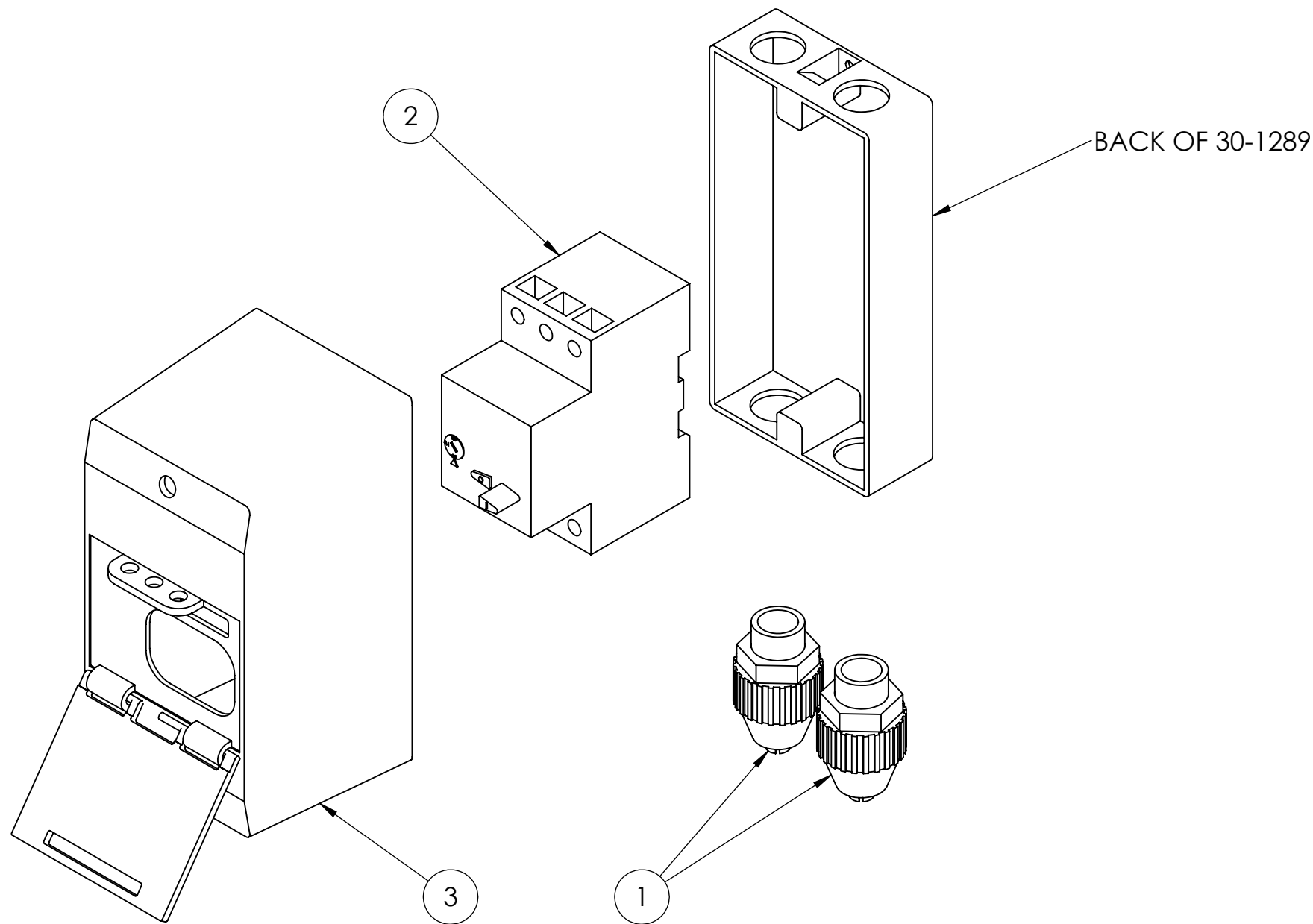
2

1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	30-0009	CONN-FLEX CORD STRAIGHT .50 HUB	2
2	30-1288	EATON MOTOR STARTER 8-12 AMP	1
3	30-1289	EATON PB ENCLOSURE	1



SWITCH WIRING



NO.	ZONE	DESCRIPTION	DATE	APPROVED
01		SEE ECN 00-3506-01	09/07/11	ST
REVISIONS				

**SW**

**TIPPER TIE**<sup>®</sup>

A DOVER INDUSTRIES COMPANY

DRAWN BY DATE  
CDS 03/24/10

CHECKED BY DATE  
MP 03/24/10

APPROVED BY DATE  
MP 03/24/10

RELEASED BY DATE  
CDS 03/24/10

ON/OFF SWITCH ASSY. EATON 8-12 A

SIZE **B**

PART NO.  
**00-3506-01**

SCALE 1:5

DO NOT SCALE DRAWING

SHEET 1 of 1

4

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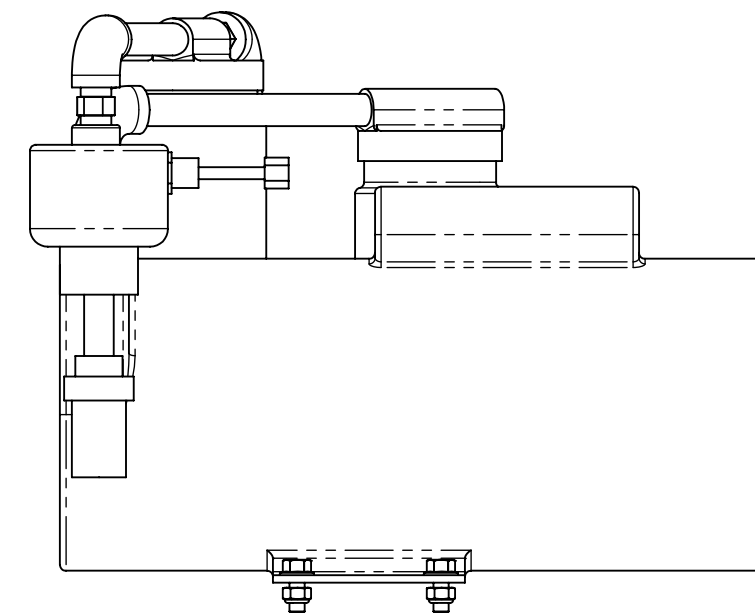
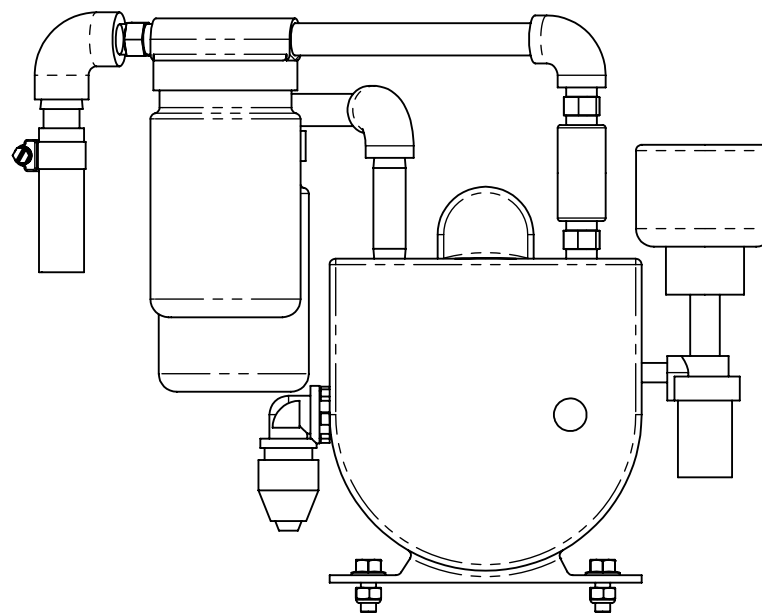
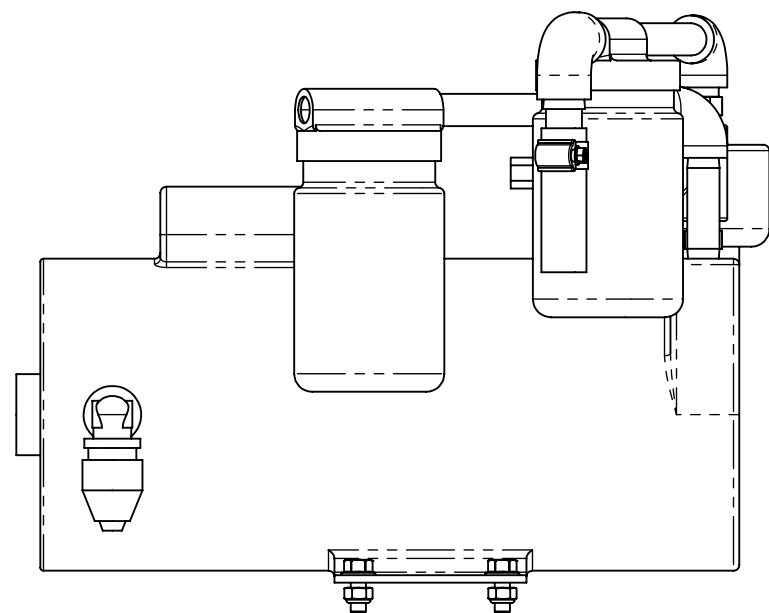
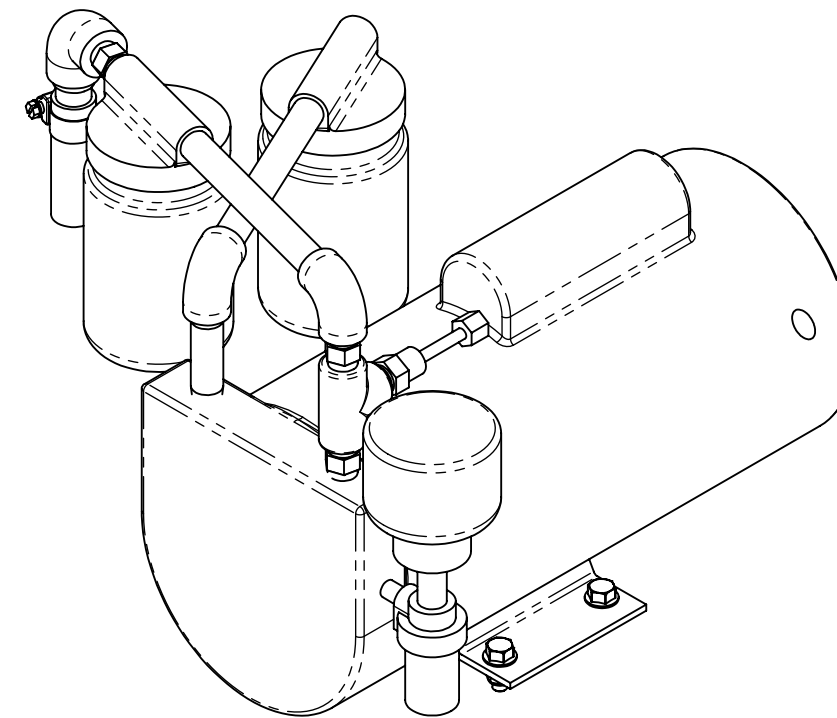
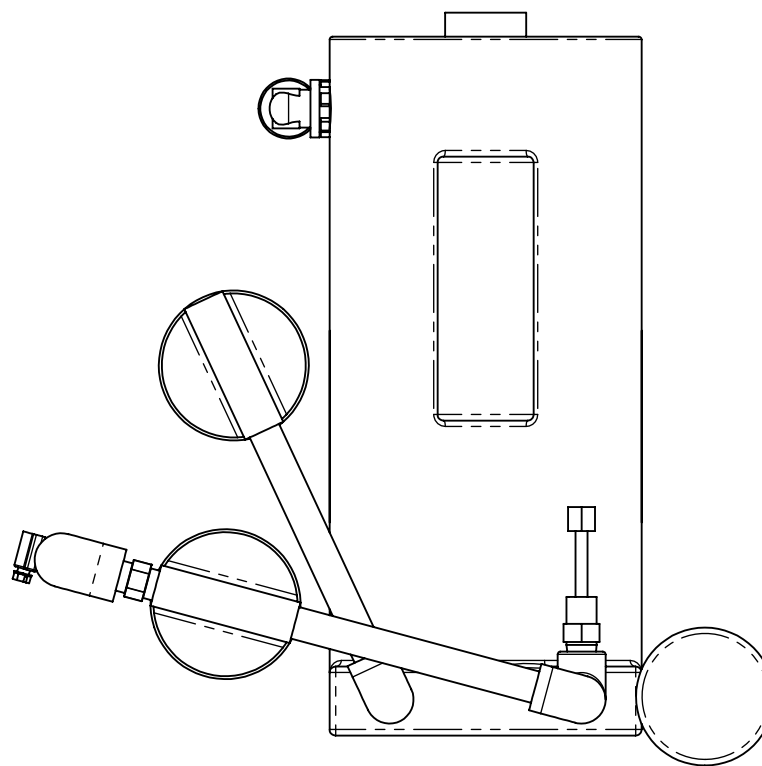
C

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NO.	ZONE	DESCRIPTION	DATE	APPROVED
02		SEE ECN 00-7783-02	10/13/23	CJS
01		SEE ECN 00-7783-01	08-10-23	SDG
REVISIONS				



DRAWN BY DATE  
J.NICHOLS 2/3/21

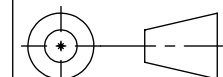
CHECKED BY DATE  
S.GRIGGS 2/3/21

APPROVED BY DATE  
S.GRIGGS 2/3/21

RELEASED BY DATE  
J.NICHOLS 2/3/21

### 3/4 HP 200V CLASS VAC PUMP ASY

SIZE  
**B**



PART NO.  
**00-7783-02**

SCALE  
1:4

DO NOT SCALE DRAWING

SHEET 1 of 2

4

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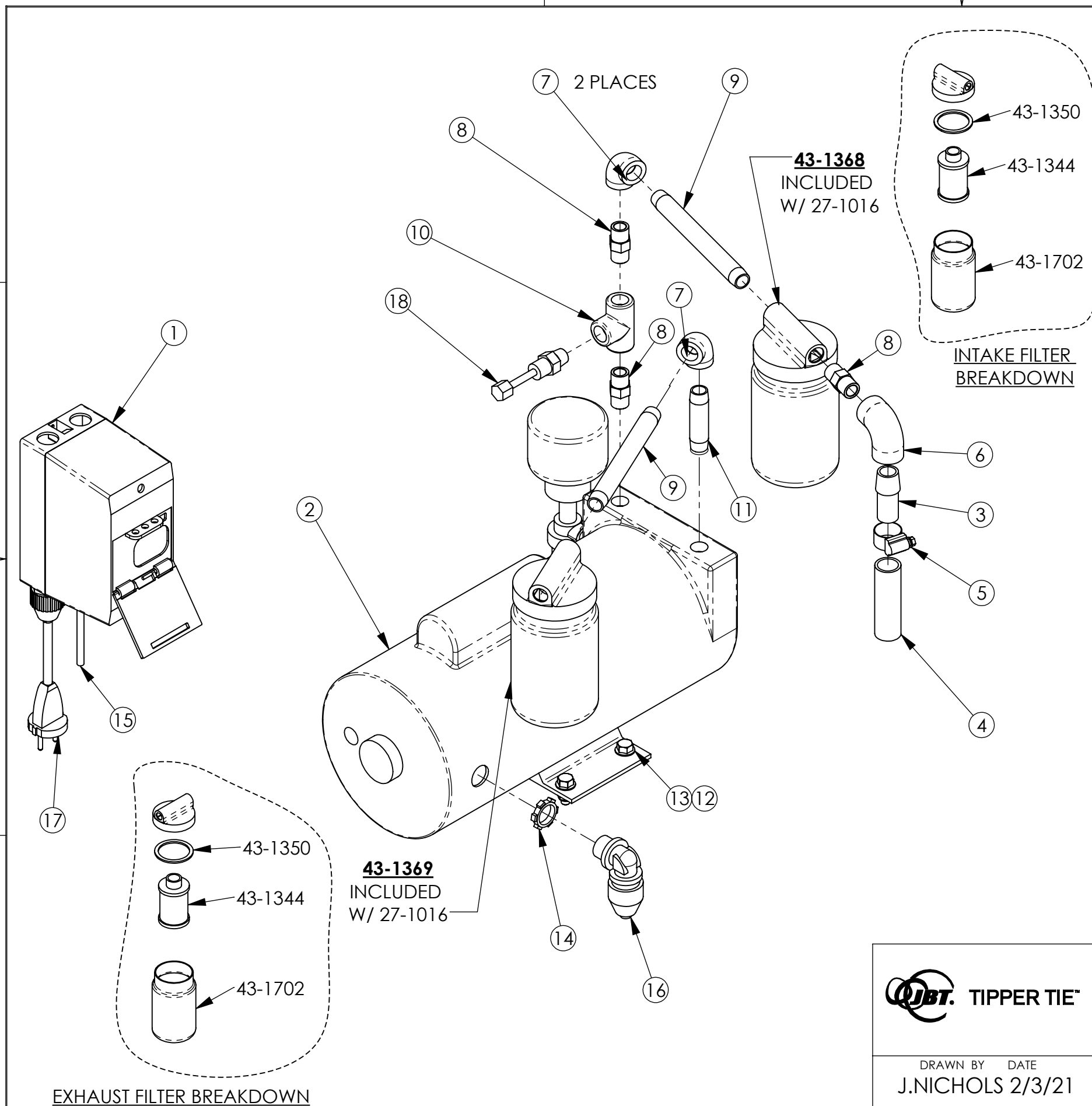
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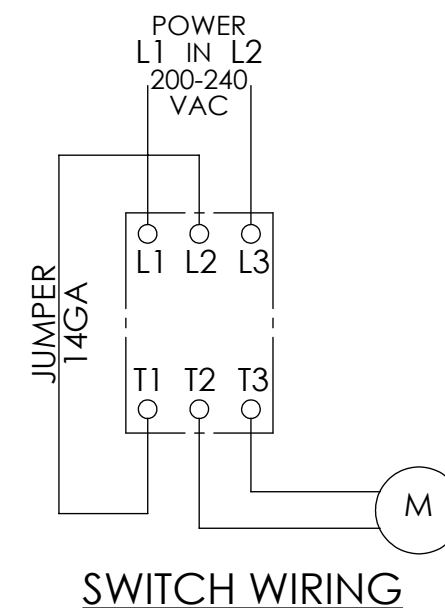
B

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A



ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	00-3505	ON/OFF SW ASSY EATON 4-6.3 A
2	1	27-1016	PUMP-VACUUM 3/4 HP 8.0 CFM
3	1	28-0399	1/2NPTHALFNIPPLESST MOD28-1234
4	1	28-0521	3/4 IN VACUUM HOSE
5	1	28-0552	HOSE CLAMP 6812 SS
6	1	28-9085	3/8 X 1/2 ELBOW GALV
7	2	28-9089	3/8 ELBOW GALV
8	3	28-9093	3/8 HEX NIPPLE BRASS
9	2	28-9128	3/8 X 6 NIPPLE SST
10	1	28-9149	3/8 TEE GALV
11	1	28-9467	3/8 X 2-1/2 NIPPLE SST
12	4	29-0178	M8 ELASTIC LOCKNUT SST
13	4	29-1711	M8 X 20 MM LG HFLG SST DIN 6921
14	1	30-0031	LOCKNUT-SEALING .50 CONDUIT
15	1	30-0063	CA-SUTO-16/3 AWG YELLOW
16	1	30-0242	CONN-CORDGRIP 90DEG 1/2 .25/.40
17	1	30-0356	CORD INTL PWRPLY 3COND UNSHLD
18	1	43-1389	VAC. RELIEF VLV #AA840



	CHECKED BY DATE S.GRIGGS 2/3/21	<b>3/4 HP 200V CLASS VAC PUMP ASY</b>		
	APPROVED BY DATE S.GRIGGS 2/3/21			
DRAWN BY DATE J.NICHOLS 2/3/21	RELEASED BY DATE J.NICHOLS 2/3/21	SIZE <b>B</b>		PART NO. <b>00-7783-02</b>
		SCALE 1:8	DO NOT SCALE DRAWING	SHEET 2 of 2

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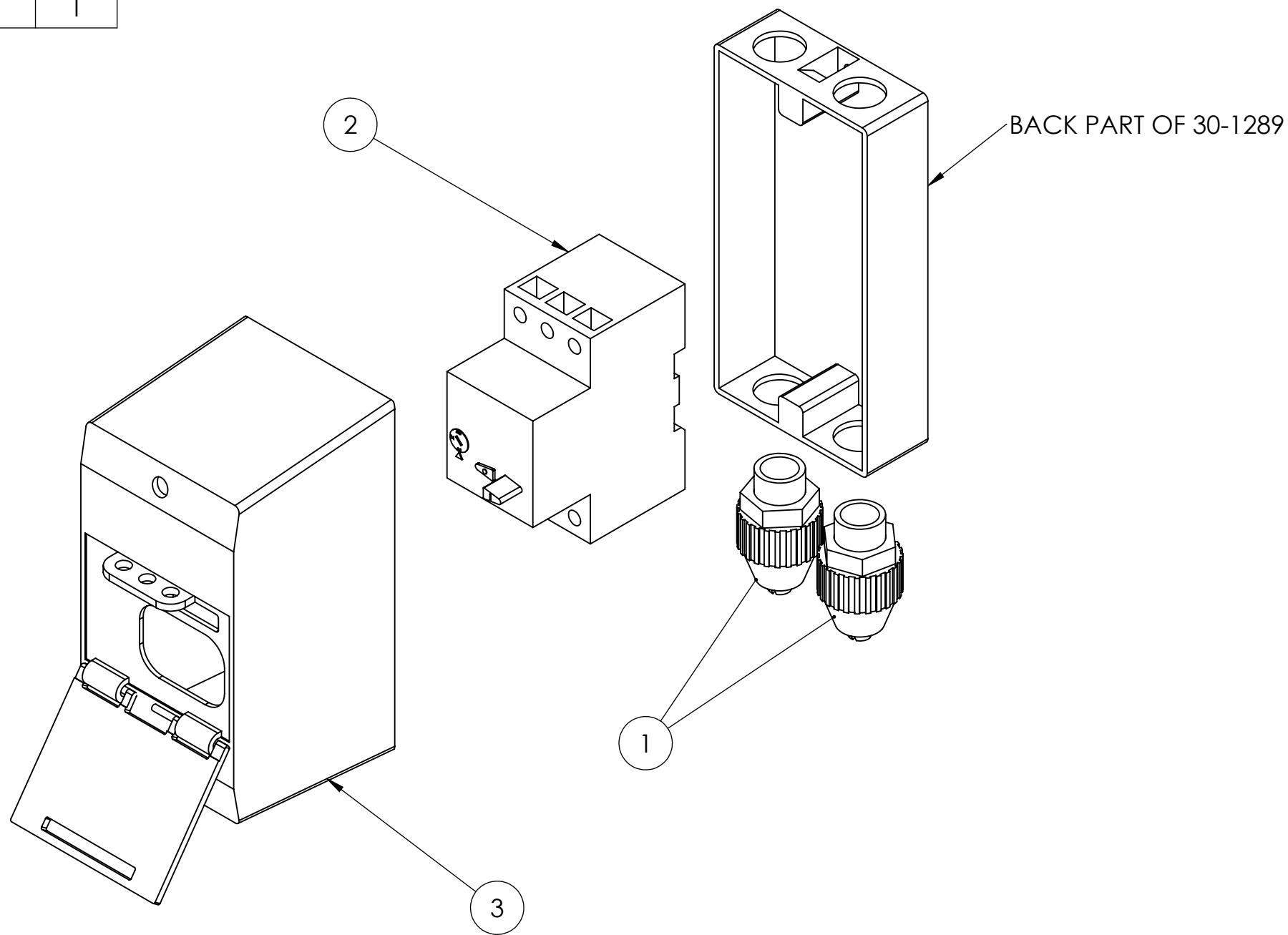
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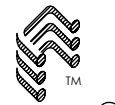
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	30-0009	CONN-FLEX CORD STRAIGHT .50 HUB	2
2	30-1287	EATON MOTOR STARTER 4-6.3 AMP	1
3	30-1289	EATON PB ENCLOSURE	1



NO.	ZONE	DESCRIPTION	DATE	APPROVED
REVISIONS				

**SW**



**TIPPER TIE**<sup>®</sup>

A DOVER INDUSTRIES COMPANY

DRAWN BY: CDS    DATE: 03/24/10

CHECKED BY: MP    DATE: 03/24/10

APPROVED BY: MP    DATE: 03/24/10

RELEASED BY: CDS    DATE: 03/24/10

ON/OFF SWITCH ASSY. EATON 4-6.3 A

SIZE: **B**

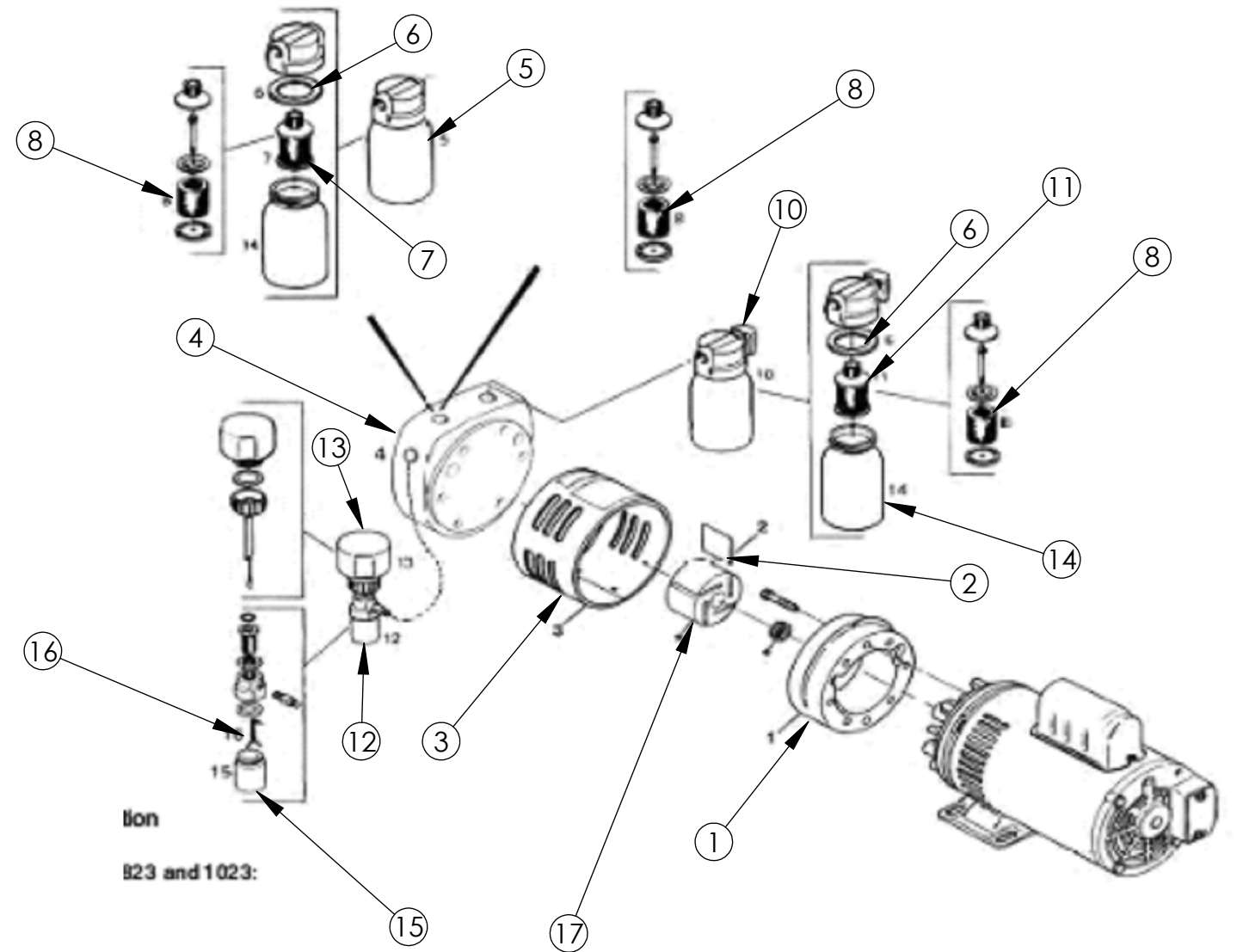
PART NO.: **00-3505-00**

SCALE: 1:5

DO NOT SCALE DRAWING

SHEET: 1 of 1

REF #	DESCRIPTION	QTY.	TIPPER TIE P/N
1	BODY	1	43-2000
2	VANE	4	43-2001
3	SHROUD	1	43-2002
4	END PLATE	1	43-2003
5	INTAKE FILTER ASSY	1	43-1368
6	COVER GASKET	1	43-1350
7	FILTER ELEMENT ASSY	2	43-1358
8	CARTRIDGE	2	43-1344
10	EXHAUST MUFFLER ASSY	2	43-1369
11	MUFFLER ELEMENT ASSY	2	43-1359
12	CONSTANT LEVEL OILER	1	43-1316
13	OIL RESERVOIR	1	43-1314
14	JAR	2	43-1702
15	JAR	1	43-1701
16	WICK	1	43-1392
17	ROTOR	1	43-2006



**REF. 27-1016**

				<b>SW</b>  <b>TIPPER TIE</b> <sup>®</sup> <small>A DOVER INDUSTRIES COMPANY</small>	CHECKED BY DATE ST 11/18/11	<b>PUMP - VACUUM 3/4 HP PARTS LIST</b>		
					APPROVED BY DATE ST 11/18/11			
NO.	ZONE	DESCRIPTION	DATE	APPROVED	DRAWN BY DATE CDS 11/18/11	RELEASED BY DATE CDS 11/18/11	SIZE <b>B</b>	PART NO. <b>00-4136-00</b>
REVISIONS							SCALE 1:1	DO NOT SCALE DRAWING SHEET 1 of 1

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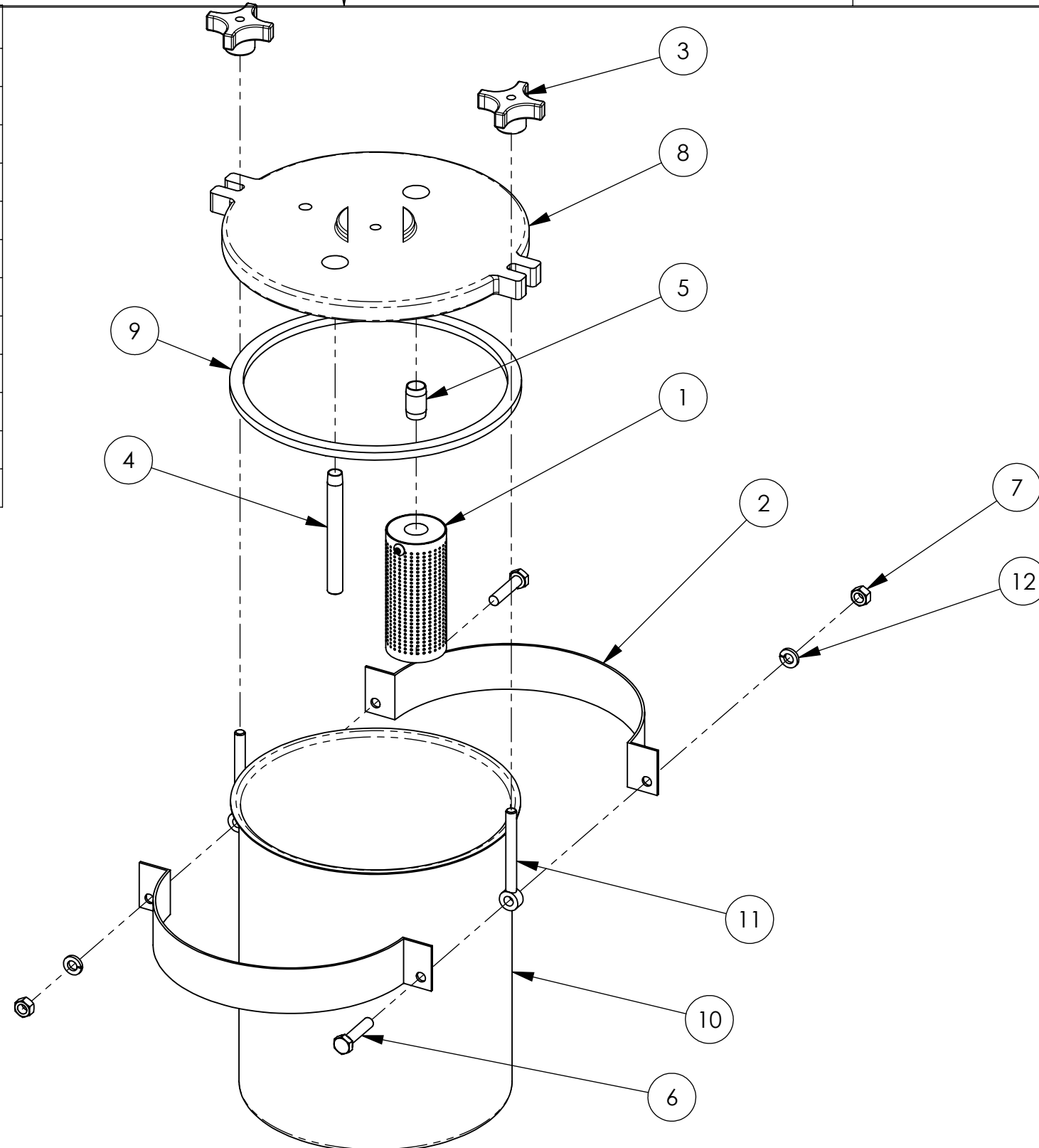
4

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1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	00-0805	SHUT-OFF VALVE ASSY	1
2	10-2792	BRACKET	2
3	20-0178	KNOB	2
4	28-0502	3/8 X 4 LG PIPE NIPPLE FOR WASTE TANK	1
5	28-9098	3/8 CLOSE NIPPLE BRASS	1
6	29-9314	5/16-18 X 1-1/4 LG HH SST	2
7	29-9425	5/16-18 HEX NUT SST	2
8	32-0104	WASTE TANK COVER	1
9	40-0977	GASKET QUAD-X,Q4444366Y	1
10	99-0401	TANK	1
11	99-0905	EYE BOLT	2
12	99-9608	5/16 SPLIT LOCK WASHER SST	2



NO.	ZONE	DESCRIPTION	DATE	APPROVED
05		NO ECN DATA		
REVISIONS				

**SW**

**TIPPER TIE**  
A DOVER INDUSTRIES COMPANY

CHECKED BY: ST DATE: 09/01/11

APPROVED BY: ST DATE: 09/01/11

RELEASED BY: CDS DATE: 09/01/11

DRAWN BY: CDS DATE: 09/01/11

**WASTE TANK SUB-ASSY**

SIZE: **B**

PART NO.: **00-4153-05**

SCALE: 1:8

DO NOT SCALE DRAWING

SHEET: 1 of 1

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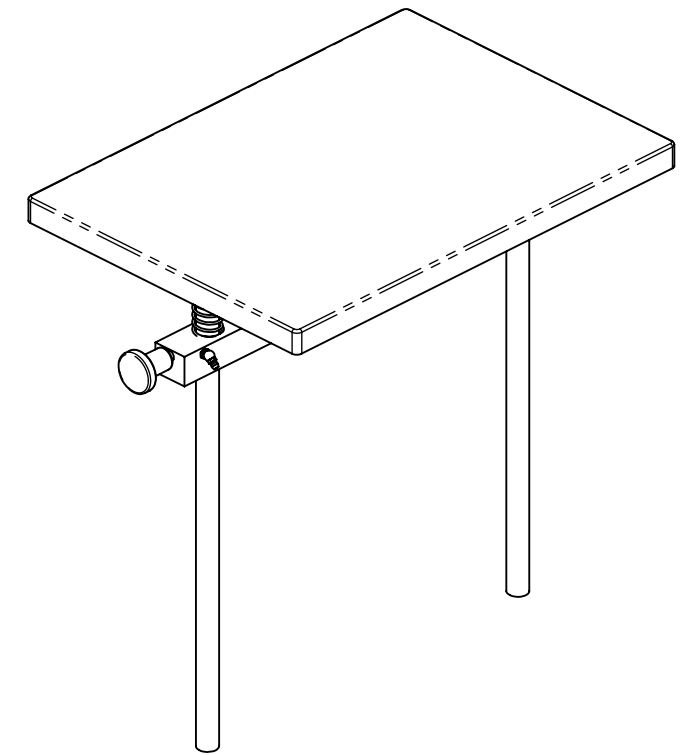
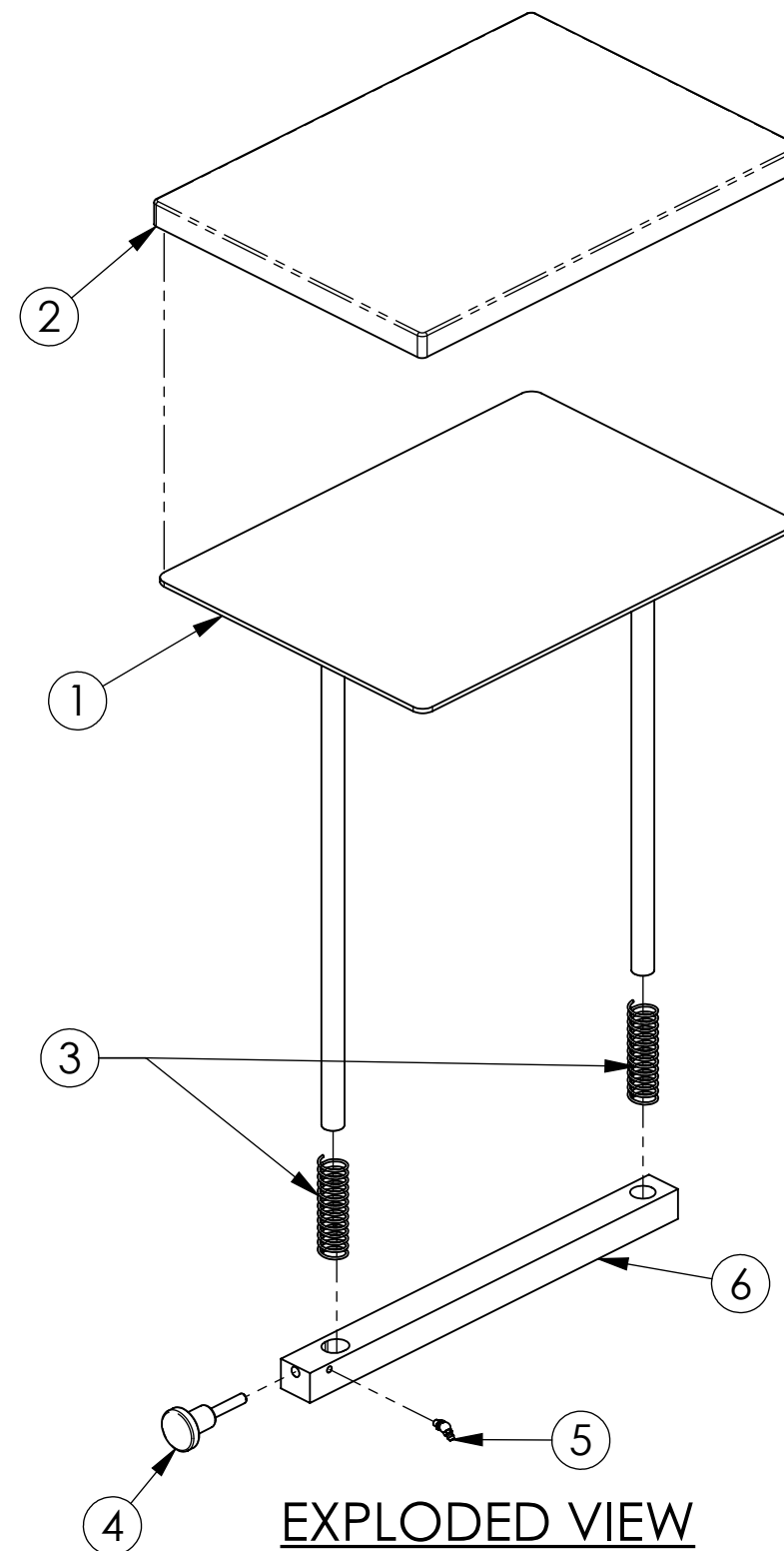
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1

ITEM NO.	QT Y.	PART NUMBER	DESCRIPTION
1	1	01-0157	SUB PLATE FOR PRODUCT TABLE
2	1	01-0159	PRODUCT TABLE
3	2	17-0151	SPRING-COMP .94 X 9.00 SST .090
4	1	20-0154	KNOB FOR LOCK BAR
5	1	28-4521	1/4 NPT 65 DEG GREASE FITTING
6	1	99-0148	LOCK BAR



ASSEMBLED VIEW

EXPLODED VIEW

NO.	ZONE	DESCRIPTION	DATE	APPROVED
01		SEE ECN 00-4512-01	07/24/15	KLP
REVISIONS				

**SW**  
**TIPPER TIE™**  
a DOVER company

CHECKED BY	DATE
ST	03/26/12
APPROVED BY	DATE
ST	03/26/12
RELEASED BY	DATE
CDS	03/26/12

DRAWN BY: CDS    DATE: 03/26/12

**PRODUCT TABLE ASSEMBLY**

SIZE		PART NO.
<b>B</b>		<b>00-4512-01</b>
SCALE	1:7	SHEET 1 of 1

DO NOT SCALE DRAWING

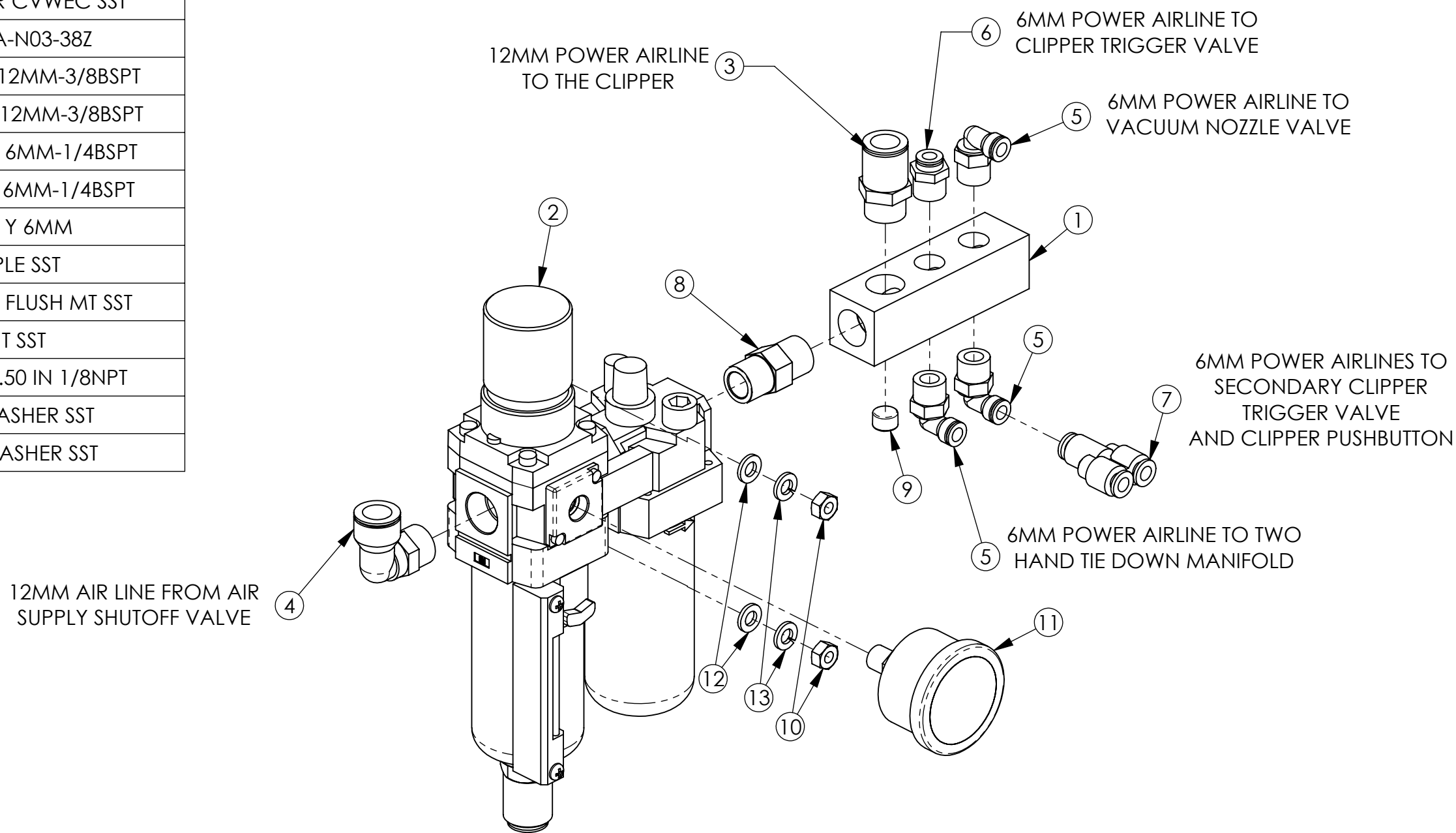
4

3

2

1

ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	1	21-0206	MANIFOLD-FLR FOR CVWEC SST
2	1	24-0035	SMC FLR AC31A-N03-38Z
3	1	28-0182	PLFTG-MALE CONN 12MM-3/8BSPT
4	1	28-0186	PLFTG-MALE ELBOW 12MM-3/8BSPT
5	3	28-0306	PLFTG-MALE ELBOW 6MM-1/4BSPT
6	1	28-0332	PLFTG-MALE CONN 6MM-1/4BSPT
7	1	28-0479	PLFTG-UNION Y 6MM
8	1	28-0498	3/8 HEX NIPPLE SST
9	1	28-9135	1/8ALLEN PIPEPLUG FLUSH MT SST
10	2	29-1128	M6 HEX NUT SST
11	1	31-0922	GAUGE-0-160 PSI 1.50 IN 1/8NPT
12	2	99-1183	6MM ID FLAT WASHER SST
13	2	99-1245	6MM ID LOCKWASHER SST



NO.	ZONE	DESCRIPTION	DATE	APPROVED
02		SEE ECN 00-6785-02	07/25/23	CJS
01		SEE ECN 00-6785-01	01/20/23	JAN
REVISIONS				

**JBT. TIPPER TIE™**

CHECKED BY	DATE
S.GRIGGS	10/12/22
APPROVED BY	DATE
S.GRIGGS	10/12/22
RELEASED BY	DATE
J.NICHOLS	10/12/22

DRAWN BY DATE  
J.NICHOLS 10/12/22

## FRL ASSEMBLY

PART NO. **00-6785-02**

SIZE **B**

SCALE **1:2**

DO NOT SCALE DRAWING

SHEET **1** of **1**

QTY. REQ. PER ASS'Y		APPLICATION			REVISIONS			
NEXT	FINAL	NEXT ASSY	USED ON	NO	DESCRIPTION	DATE	APPROVED	
1	1	00 5870	CV-H					

UNLESS OTHERWISE SPECIFIED:

REMOVE ALL BURRS

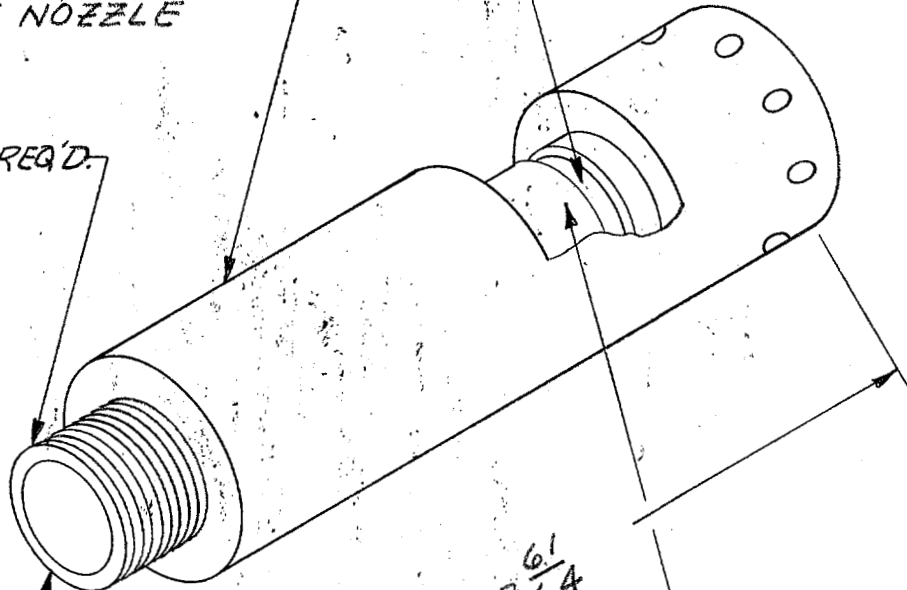
BREAK ALL SHARP EDGES .015 R MAX.

✓ J25 FINISH ALL OVER

FILL GROOVE WITH SILICON CAULK AND ALLOW TO DRY PRIOR TO ASSEMBLY.

28-5872, 1 REQ'D.  
SHORT NOZZLE

28-5367 1 REQ'D.  
NIPPLE



APPLY #416 LOCKTITE AROUND OUTSIDE DIAMETER PRIOR TO ASSEMBLY.

PRESS INTO PLACE TO DIMENSION SHOWN WITH STRAIGHT THREADS PROTRUDING. SEAL WITH SILICON CAULK.

TOLERANCES UNLESS OTHERWISE NOTED.  
FRACTIONS: ± 1/64  
ANGLES: ± 1°  
3 PLACE DECIMALS: ± .005  
2 PLACE DECIMALS: ± .01

DRAWN BY DATE  
RJS 1-30-79

CHECKED BY DATE  
CMM 1-31-79



MATERIAL  
N/A

APPROVED BY DATE  
[Signature] 2-1-79

CLIPPER VAC "H" NOZZLE  
FOR SAFETY GUARD CONVERSION

SURFACE TREATMENT  
N/A

RELEASED BY DATE  
[Signature]

SIZE  
A

DRAWING NO  
00-5873

SCALE NONE

SHEET 1 of 1

4

3

2

1

ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	1	10-0809	CVW GATE VALVE BRACKET
2	1	21-0223	VLV-3PORT 2POS1/4PORTSAIRPILOT
3	1	21-0259	VLV-MCHNCL 5PORT METAL SEAL PB
4	1	21-5003	SENSOR ENDOF STROKE 1/4 TO 1/4
5	1	28-0214	PLFTG-PLUG-IN RED 4MM-6MM
6	1	28-0216	PLFTG-MALE ELBOW 4MM-1/8BSPT
7	1	28-0300	PLFTG-UNION TEE 6MM
8	5	28-0306	PLFTG-MALE ELBOW 6MM-1/4BSPT
9	1	28-0329	1/4 BSPT PIPE PLUG SST
10	2	28-0504	1/8 BSPT MUFFLER
11	2	28-1686	1/4NPT MUFFLER SINTERED BRONZE
12	2	29-0639	M4 X 35 MM LG HH SST DIN 933
13	2	29-0672	M6 X 25 MM LG HH SST DIN 933
14	3	29-0875	M4 X 35 MM LG SH SST
15	5	29-1126	M4 HEX NUT SST
16	2	29-1128	M6 HEX NUT SST
17	3	99-1181	4MM ID FLAT WASHER SST
18	2	99-1183	6MM ID FLAT WASHER SST
19	3	99-1243	4MM ID LOCKWASHER SST
20	2	99-1245	6MM ID LOCKWASHER SST

ASSEMBLED VIEW  
1:4 SCALE

ASSEMBLED VIEW  
1:2.5 SCALE

NO.	ZONE	DESCRIPTION	DATE	APPROVED
02		SEE ECN 00-5969-02	10/18/23	CDS
01		SEE ECN 00-5969-01	07/25/23	CJS
REVISIONS				

DRAWN BY DATE  
J.NICHOLS 1/19/23

CHECKED BY DATE  
S.GRIGGS 1/19/23

APPROVED BY DATE  
S.GRIGGS 1/19/23

RELEASED BY DATE  
J.NICHOLS 1/19/23

## CLIPPER TRIGGER VALVE ASSEMBLY

SIZE  
B

PART NO.  
**00-5969-02**

SCALE  
1:2

DO NOT SCALE DRAWING

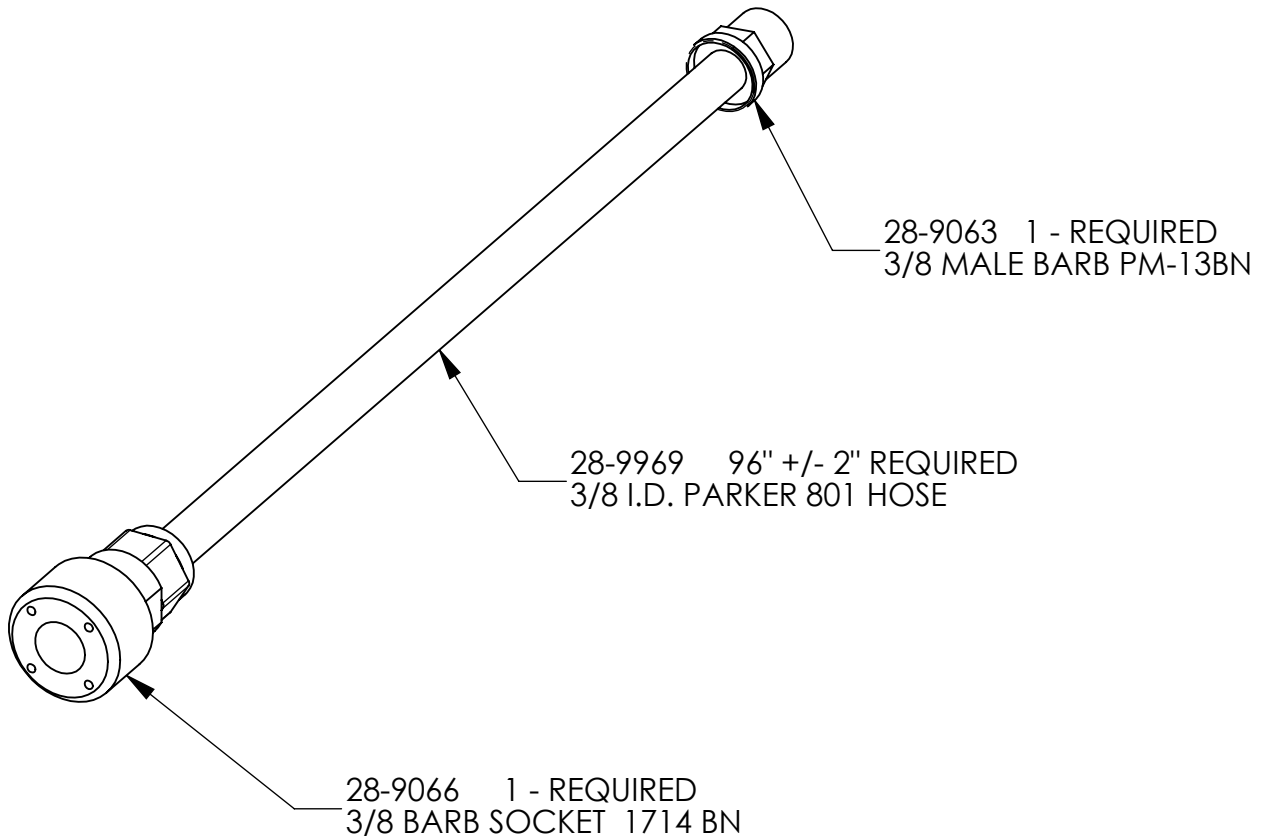
SHEET 1 of 1

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REVISIONS

NO.	DESCRIPTION	DATE	APPROVED	NO.	DESCRIPTION	DATE	APPROVED

USED ON-  
 Z2105  
 Z2115  
 Z4135  
 Z4136



CHECKED BY DATE  
 JM 06-10-04

APPROVED BY DATE  
 JM 06-10-04

RELEASED BY DATE  
 ST 06-10-04

3/8 HOSE ASSY 8 FT LG

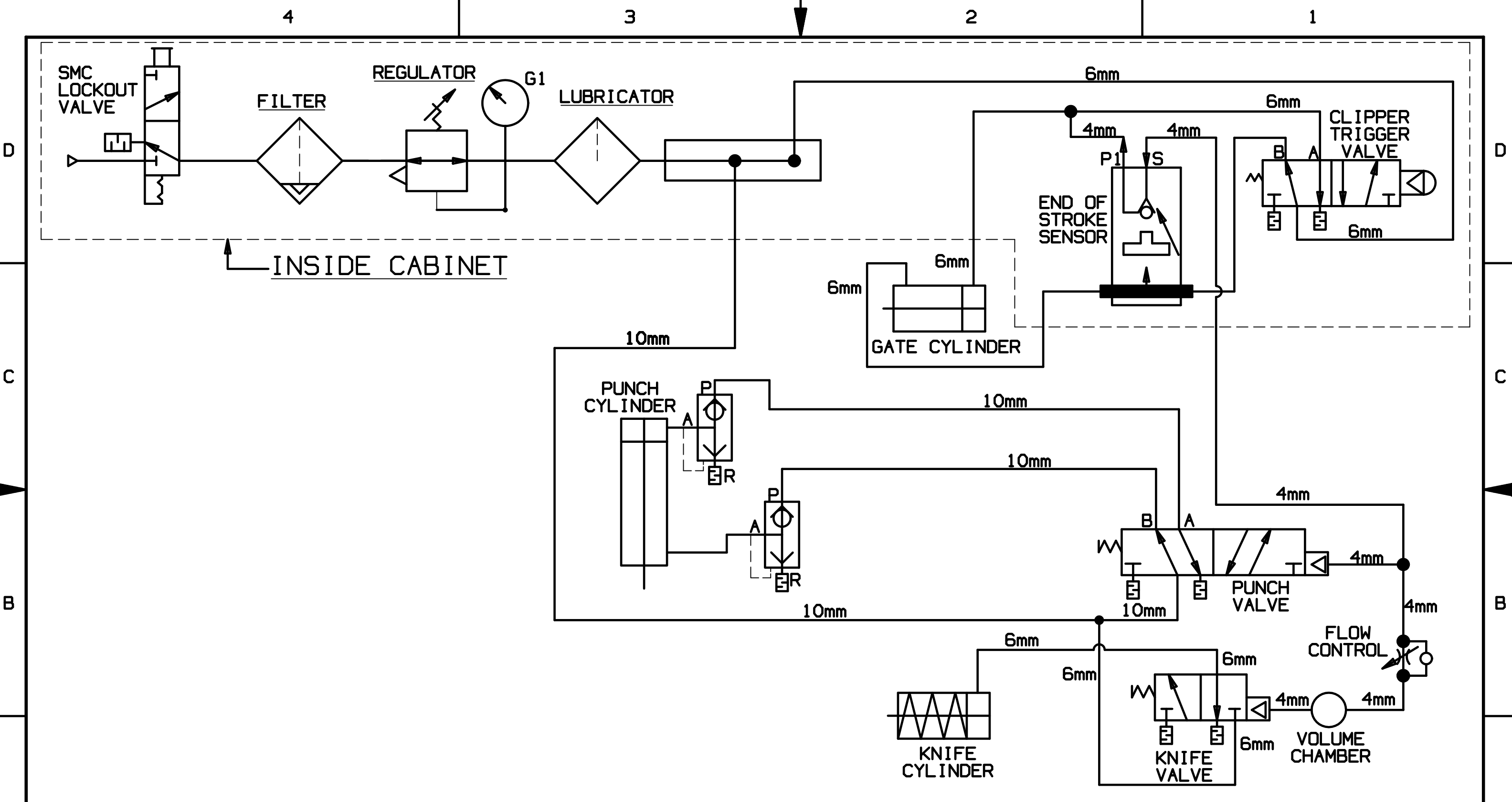
SIZE  
**A**

PART NO.  
**28-4636-01**

SCALE 1:2

DO NOT SCALE  
 DRAWING

SHEET 1 of 1



01	SEE ECN 63-0071-01	8/25/15	K.POLING
NO.	DESCRIPTION	DATE	APPROVED
	REVISIONS		

**TIPPER TIE**  
ASTRO INDUSTRIES COMPANY

CHECKED BY	DATE
T.GLASS	11/11/93
APPROVED BY	DATE
T.GLASS	11/11/93
RELEASED BY	DATE
B.DIGESO	11/11/93

**CVW PNEUMATIC SCHEMATIC**

SIZE	PART NO.
<b>B</b>	63-0071-01
SCALE	DO NOT SCALE DRAWING
	SHEET 1 of 1



4

3

2

1

D

D

C

C

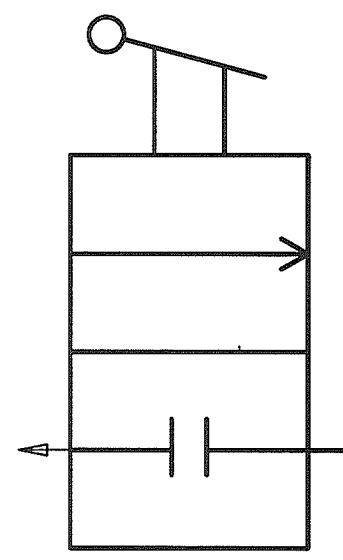
B

B

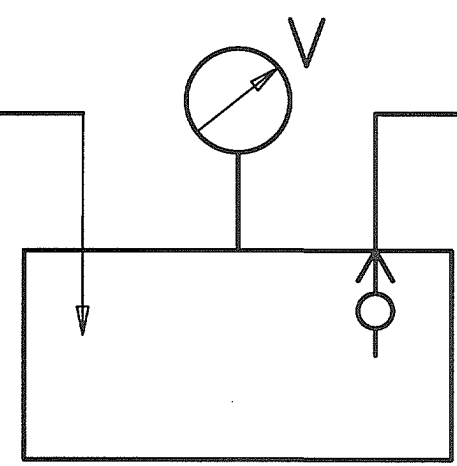
A

A

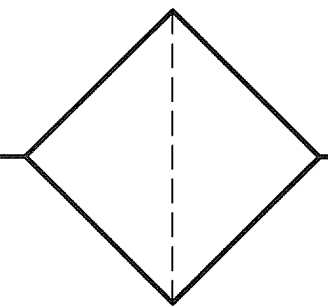
TO NOZZLE



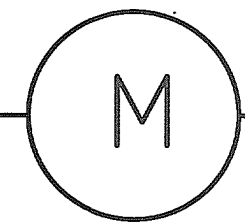
1/4 TURN BALL VALVE



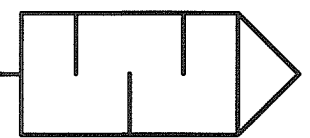
WASTE TANK




FILTER



VACUUM PUMP MOTOR



NO.	ZONE	DESCRIPTION	DATE	APPROVED
00		REDRAWN, NO CHANGES & ASSIGNED A PART #		
REVISIONS				

  
**TIPPER TIE**<sup>®</sup>  
ASBESTOS INDUSTRIES COMPANY

DRAWN BY: JOM      DATE: 6-5-03

CHECKED BY	DATE
JOM	6-5-03
APPROVED BY	DATE
JOM	6-5-03
RELEASED BY	DATE
JOM	6-5-03



**CVW VACUUM SCHEMATIC**

SIZE	PART NO.
<b>B</b>	63-2003-00
SCALE NONE	DO NOT SCALE DRAWING
SHEET 1 of 1	

REVISIONS							
NO.	DESCRIPTION	DATE	APPROVED	NO.	DESCRIPTION	DATE	APPROVED

1001417	CVW CASTER MOUNTING PLATE	4
2900210	1/2-13 X 1" LONG FH SCREW	4
2909425	5/16-18 HEX NUT	16
2909591	5/16-18 X 7/8" LONG HH SCREW	16
9900283	CASTER, 2 1/2" DIA SWIVEL W/BRAKE	2
9900284	CASTER, 2 1/2" DIA, RIGID	2
9909608	5/16" SPLIT LOCKWASHER	16

NOTE:  
PARTS ARE SHIPPED LOOSE  
FOR CUSTOMER ASSEMBLY.

 <p><b>TIPPER TIE®</b> A <small>TRIM</small> INDUSTRIES COMPANY</p>	CHECKED BY    DATE JOM    9-19-03	OPTIONAL CASTER ASSEMBLY KIT		
	APPROVED BY    DATE JOM    9-19-03			SIZE 
DRAWN BY    DATE JOM    9-19-03	RELEASED BY    DATE JOM    9-19-03	SCALE    N/A	DO NOT SCALE DRAWING	SHEET 1 of 1

4

3

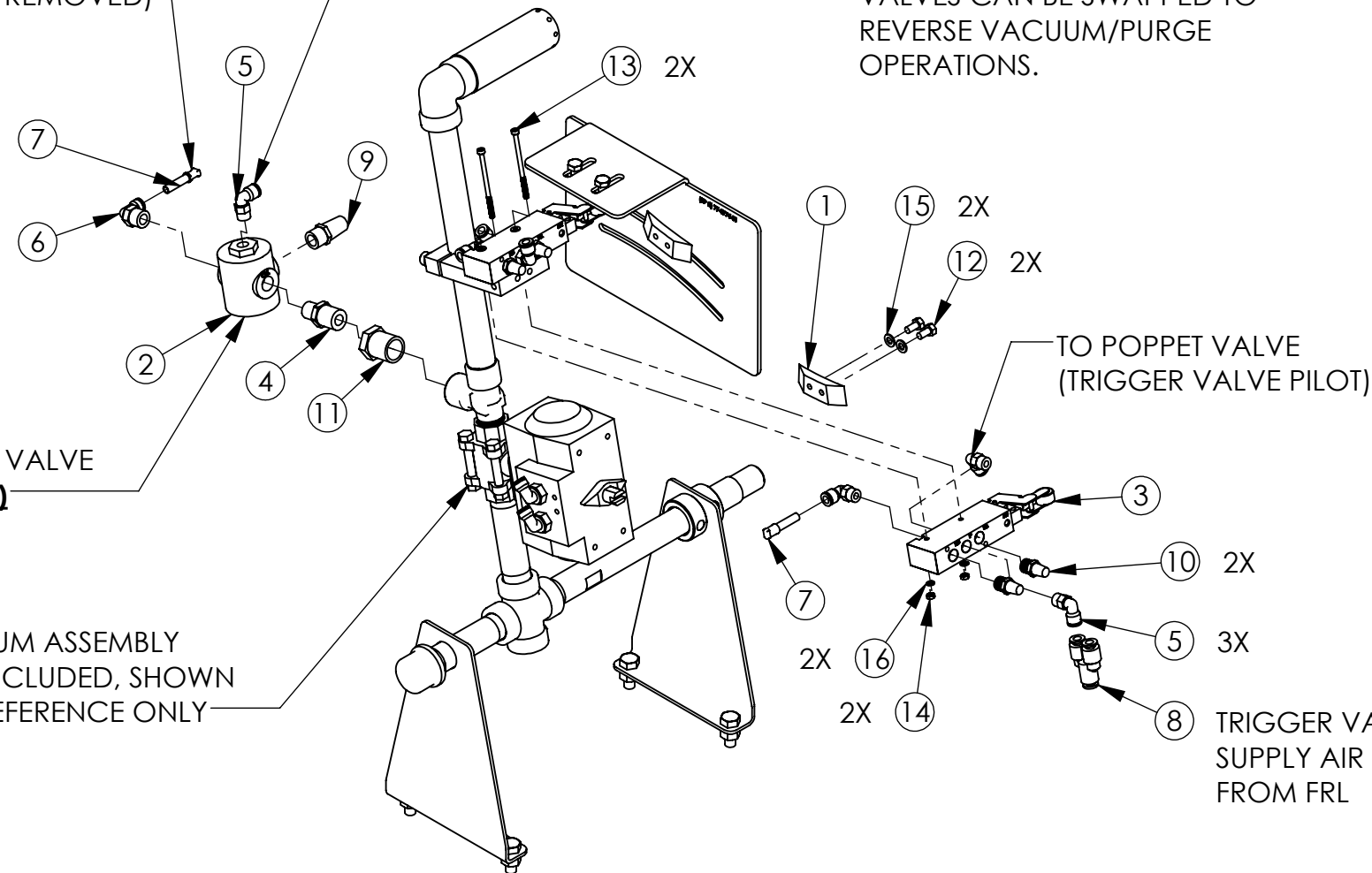
2

1

ITEM NO.	GASFLUSH KIT/QTY.	PART NUMBER	DESCRIPTION
1	1	01-1773	TTCV-H TRIGGER BLOCK
2	1	21-0002	VALVE-3 WAY POPPET SR
3	1	21-0377	VLV-MECHNCL 5PORT ROLLER LEVER
4	1	28-0001	3/8 x 1/4 HEX NIPPLE BRASS
5	4	28-0199	PLFTG-MALE ELBOW 6MM-1/8BSPT
6	1	28-0306	PLFTG-MALE ELBOW 6MM-1/4BSPT
7	2	28-0322	PLFTG-PLUG 6MM
8	1	28-0479	PLFTG-UNION Y 6MM
9	1	28-1686	1/4NPT MUFFLER SINTERED BRONZE
10	2	28-7185	1/8 NPT MUFFLER SINTERED BRZ
11	1	28-9052	1/2 X 3/8 BUSHING BRASS
12	4	29-0650	M5 X 10 MM LG HH SST DIN 933
13	2	29-0863	M3 X 55 MM LG SH SST
14	2	29-1125	M3 HEX NUT SST
15	4	99-1182	5MM ID FLAT WASHER SST
16	2	99-1242	3MM ID LOCKWASHER SST

GAS FLUSH SUPPLY  
(TO BE INSERTED HERE  
AND PLUG REMOVED)

FROM TRIGGER  
VALVE PILOT



POPPET VALVE  
**(21-002)**

VACUUM ASSEMBLY  
NOT INCLUDED, SHOWN  
FOR REFERENCE ONLY

\*TRIGGER BLOCK (01-1773)  
TO BE INSTALLED INTO  
TRIGGER PLATE. TRIGGER  
BLOCKS CAN BE MOVED TO  
CHANGE TIMING. TRIGGER  
VALVES CAN BE SWAPPED TO  
REVERSE VACUUM/PURGE  
OPERATIONS.

TRIGGER VALVE  
SUPPLY AIR  
FROM FRL

A

NO.	ZONE	DESCRIPTION	DATE	APPROVED
01		SEE ECN 55-0664-01	07/25/23	CJS
REVISIONS				



DRAWN BY DATE  
C.SNIDER 06/19/23

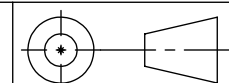
CHECKED BY DATE  
S.GRIGGS 06/19/23

APPROVED BY DATE  
S.GRIGGS 06/19/23

RELEASED BY DATE  
C.SNIDER 06/19/23

TTVAC-H GASFLUSH KIT

SIZE  
B



PART NO.  
**55-0664-01**

SCALE 1:5

DO NOT SCALE DRAWING

SHEET 1 of 1