



# Rigging and Assembly Instructions

## MTT INDUCED DRAFT COOLING TOWERS

EVAPCO Products are Manufactured Worldwide

### EVAPCO, Inc. — World Headquarters & Research/Development Center

**EVAPCO, Inc.** • P.O. Box 1300 • Westminster, MD 21158 USA  
PHONE: 410-756-2600 • FAX: 410-756-6450 • E-MAIL: [marketing@evapco.com](mailto:marketing@evapco.com)

#### EVAPCO North America

##### EVAPCO, Inc.

**World Headquarters**  
P.O. Box 1300  
Westminster, MD 21158 USA  
Phone: 410-756-2600  
Fax: 410-756-6450  
E-mail: [marketing@evapco.com](mailto:marketing@evapco.com)

##### EVAPCO East

5151 Allendale Lane  
Taneytown, MD 21787 USA  
Phone: 410-756-2600  
Fax: 410-756-6450  
E-mail: [marketing@evapco.com](mailto:marketing@evapco.com)

##### EVAPCO Midwest

1723 York Road  
Greenup, IL 62428 USA  
Phone: 217-923-3431  
Fax: 217-923-3300  
E-mail: [evapcomw@evapcomw.com](mailto:evapcomw@evapcomw.com)

##### EVAPCO West

1900 West Almond Avenue  
Madera, CA 93637 USA  
Phone: 559-673-2207  
Fax: 559-673-2378  
E-mail: [contact@evapcowest.com](mailto:contact@evapcowest.com)

##### EVAPCO Iowa

925 Quality Drive  
Lake View, IA 51450 USA  
Phone: 712-657-3223  
Fax: 712-657-3226

##### EVAPCO Iowa

**Sales & Engineering**  
215 1st Street, NE  
P.O. Box 88  
Medford, MN 55049 USA  
Phone: 507-446-8005  
Fax: 507-446-8239  
E-mail: [evapcomn@evapcomn.com](mailto:evapcomn@evapcomn.com)

##### EVAPCO Northwest

5775 S.W. Jean Road, Suite 104  
Lake Oswego, Oregon 97035 USA  
Phone: 503-639-2137  
Fax: 503-639-1800

##### EVAPCO Newton

701 East Jourdan Street  
Newton, IL 62448 USA  
Phone: 618-783-3433  
Fax: 618-783-3499  
E-mail: [evapcomw@evapcomw.com](mailto:evapcomw@evapcomw.com)

##### EVAPCO-BLCT Dry Cooling, Inc.

981 US Highway 22 West  
Bridgewater, New Jersey 08807 USA  
Phone: 1-908-379-2665  
E-mail: [info@evapco-blct.com](mailto:info@evapco-blct.com)

##### Refrigeration Valves & Systems Corporation

*A wholly owned subsidiary of EVAPCO, Inc.*  
1520 Crosswind Dr.  
Bryan, TX 77808 USA  
Phone: 979-778-0095  
Fax: 979-778-0030  
E-mail: [rvs@rvscorp.com](mailto:rvs@rvscorp.com)

##### EvapTech, Inc.

*A wholly owned subsidiary of EVAPCO, Inc.*  
8331 Nieman Road  
Lenexa, KS 66214 USA  
Phone: 913-322-5165  
Fax: 913-322-5166  
E-mail: [marketing@evaptech.com](mailto:marketing@evaptech.com)

##### Tower Components, Inc.

*A wholly owned subsidiary of EVAPCO, Inc.*  
5960 US HWY 64E  
Ramseur, NC 27316  
Phone: 336-824-2102  
Fax: 336-824-2190  
E-mail: [mail@towercomponentsinc.com](mailto:mail@towercomponentsinc.com)

#### EVAPCO Europe

**EVAPCO Europe BVBA  
European Headquarters**  
Industrieterrein Oost 4010  
3700 Tongeren, Belgium  
Phone: (32) 12-395029  
Fax: (32) 12-238527  
E-mail: [evapco.europe@evapco.be](mailto:evapco.europe@evapco.be)

##### EVAPCO Europe, S.r.l.

Via Ciro Menotti 10  
I-20017 Passirana di Rho  
Milan, Italy  
Phone: (39) 02-939-9041  
Fax: (39) 02-935-00840  
E-mail: [evapcoeuropa@evapco.it](mailto:evapcoeuropa@evapco.it)

##### EVAPCO Europe, S.r.l.

Via Dosso 2  
23020 Piateda Sondrio, Italy

##### EVAPCO Europe GmbH

Meerbuscher Straße 64-78  
Haus 5  
40670 Meerbusch, Germany  
Phone: (49) 2159-69560  
Fax: (49) 2159-695611  
E-mail: [info@evapco.de](mailto:info@evapco.de)

##### Flex coil a/s

*A wholly owned subsidiary of EVAPCO, Inc.*  
Knøsgårdvej 115  
DK-9440 Aabybro Denmark  
Phone: (45) 9824 4999  
Fax: (45) 9824 4990  
E-mail: [info@flexcoil.dk](mailto:info@flexcoil.dk)

##### EVAPCO S.A. (Pty.) Ltd.

*A licensed manufacturer of EVAPCO, Inc.*  
18 Quality Road  
Isando 1600  
Republic of South Africa  
Phone: (27) 11-392-6630  
Fax: (27) 11-392-6615  
E-mail: [evapco@evapco.co.za](mailto:evapco@evapco.co.za)

##### Evap Egypt Engineering Industries Co.

*A licensed manufacturer of EVAPCO, Inc.*  
5 El Nasr Road  
Nasr City, Cairo, Egypt  
Phone: 2 02 24022866/2 02 24044997  
Fax: 2 02 24044667/2 02 24044668  
E-mail: [Primacool@link.net](mailto:Primacool@link.net) / [Shady@primacool.net](mailto:Shady@primacool.net)

#### EVAPCO Asia/Pacific

**EVAPCO Asia/Pacific Headquarters**  
1159 Luoning Rd. Baoshan Industrial Zone  
Shanghai, P. R. China, Postal Code: 200949  
Phone: (86) 21-6687-7786  
Fax: (86) 21-6687-7008  
E-mail: [marketing@evapcochina.com](mailto:marketing@evapcochina.com)

##### EVAPCO (Shanghai) Refrigeration Equipment Co., Ltd.

1159 Luoning Rd., Baoshan Industrial Zone  
Shanghai, P.R. China, Postal Code: 200949  
Phone: (86) 21-6687-7786  
Fax: (86) 21-6687-7008  
E-mail: [marketing@evapcochina.com](mailto:marketing@evapcochina.com)

##### Beijing EVAPCO Refrigeration Equipment Co., Ltd.

Yan Qi Industrial Development District  
Huai Rou County  
Beijing, P.R. China, Postal Code: 101407  
Phone: (86) 10 6166-7238  
Fax: (86) 10 6166-7395  
E-mail: [evapcoobj@evapcochina.com](mailto:evapcoobj@evapcochina.com)

##### EVAPCO Australia (Pty.) Ltd.

34-42 Melbourne Road  
P.O. Box 436  
Riverstone, N.S.W. Australia 2765  
Phone: (61) 2 9627-3322  
Fax: (61) 2 9627-1715  
E-mail: [sales@evapco.com.au](mailto:sales@evapco.com.au)

##### EVAPCO Composites Sdn. Bhd

No. 70 (Lot 1289) Jalan Industri 2/3  
Rawang Integrated Industrial Park  
Rawang, Selangor, 48000 Malaysia  
Phone: 60 3 6092-2209  
Fax: 60 3 6092-2210

##### EvapTech Asia Pacific Sdn. Bhd

*A wholly owned subsidiary of EvapTech, Inc.*  
B-6-1, IOI Boulevard  
Jalan Kenari 5, Bandar Puchong Jaya  
47170 Puchong, Selangor Darul Ehsan  
Malaysia  
Phone: (60-3) 8070-7255  
Fax: (60-3) 8070-5731  
E-mail: [marketing-ap@evaptech.com](mailto:marketing-ap@evaptech.com)

Visit EVAPCO's Website at: <http://www.evapco.com>

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## Introduction

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Thank you for purchasing your EVAPCO cooling tower, this manual will provide instructions for installation of the cooling tower. If any questions arise during the installation, please contact your local EVAPCO representative or your local Evapco Headquarters.

## Method of Shipment

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All 4' wide units are shipped as one, fully assembled unit. All other units ship in 2 partially assembled sections. Refer to the Table 1 below for the section of this manual to reference on your specific cooling tower. Miscellaneous items, such as sealer, bolts, nuts and washers, and any other required materials, are packaged and placed inside the pan for shipment. The following table has the box size and page number to the applicable manual for step-by-step instructions on how to assemble the MTT.

**Before commencement of rigging and assembly, ensure all loose articles are removed from the basin. All personnel carrying out the rigging and assembly of any EVAPCO Cooling Towers should adhere to specific site safety rules and regulations. All equipment utilized must conform to local standards and relevant Workplace Health & Safety regulations, and must be used in accordance with the manufacturer's instructions.**

| Box Size (ft x ft)   | Section  | Section | Page |
|--|--|---------|------|
| All 4 x 6<br>All 4 x 9   | MTT 14-2F6 - 14-3G6<br>MTT 14-2E9 - 14-3F9   | A       | 3    |
| All 8 x 8<br>2 Layer 10 x 10<br>2 Layer 12 x 12                              | MTT 18-2G8 - 18-4J8<br>MTT 110-2G10 - 110-2J10<br>MTT 112-2I12 - 112-2M12                                | B       | 4-5  |
| All remaining 10 x 10<br>All remaining 12 x 12<br>All 16 x 16<br>All 20 x 20 | MTT 110-3H10 - 110-4K10<br>MTT 112-3J12 - 112-4N12<br>MTT 116-2L16 - 116-4O16<br>MTT 120-3N20 - 120-4Q20 | C       | 6-8  |

**Table 1** – Rigging Manual Reference according to Box Size

## Storage

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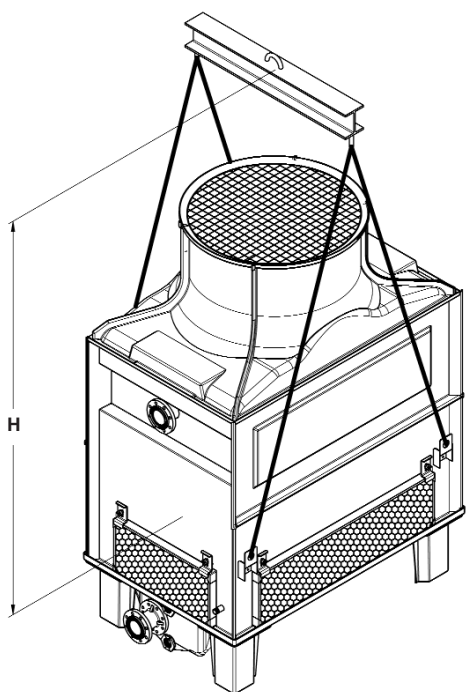
Do not place tarps or other coverings over the top of the units if the units are to be stored before installation. Excessive heat can build up if the units are covered, causing possible damage to the PVC eliminators, PVC louvers, or PVC fill. For extended storage beyond six months rotate the fan and fan motor shaft(s) monthly. The fan shaft bearings should also be purged and regreased prior to start-up if it has been stored.

**Section A: Units Shipped Fully Assembled**

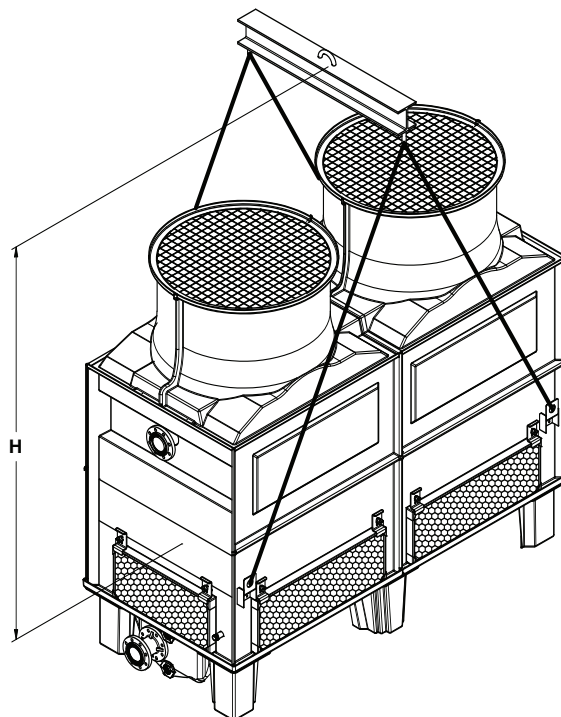
All 4' wide units ship as one fully assembled section. All four (4) lifting ears on the casing section are to be used for lifting and final positioning of the unit as shown in Figure 1 and Figure 2. Spreader bars are recommended for the lift and must be a minimum dimension of "H". See Table 2 for minimum "H" dimensions.

These lifting devices should not be used for extended lifts or where any hazard exists unless safety slings are employed under the section. (See "Extended Lifts" on page 10 for proper arrangement.)

Ensure the unit orientation is correct with respect to pipe work before bolting down using an M16 concrete bolt (if using recommended pier support). See page 11 for general information regarding start up.



**Figure 1** – Fully Assembled Unit, All 4'x6' models



**Figure 2** – Fully Assembled Unit, All 4'x9' models

| Box Size (ft x ft) | Min. "H" Dim. Spreader Bar (ft/mm) |
|--------------------|------------------------------------|
| 4 x 6              | 9 / 2743                           |
| 4 x 9              | 10 / 3048                          |

**Table 2** – Minimum H Dimension



### Section B: Units Shipped with Casing Section Attached to Basin Section

The unit shall arrive in two sections; the casing section bolted to the basin with sealer tape and the fan section separately. The unit may not be rigged as a fully assembled tower.

#### Rigging Basin-Casing Section

Lifting Ears are located on the sides of the cooling tower, adjacent to the water inlet connection for lifting and final positioning purposes as shown in Figure 3. The spreader bar of the crane must be a minimum dimension of "H" above the top of the section being lifted to prevent undue strain on the lifting devices. See Table 3 for the minimum "H" dimension. These lifting devices should not be used for extended lifts or where any hazard exists unless safety slings are employed under the section. (See "Extended Lifts" on page 11 for proper arrangement.)

Bolt the bottom section to the plinths and **remove the timber from the eliminator section.**

| Box Size (ft x ft) | Min. "H" Dim. Spreader Bar (ft/mm) |
|--------------------|------------------------------------|
| 8 x 8              | 10 / 3048                          |
| 10 x 10            | 11 / 3353                          |
| 12 x 12            | 12 / 3658                          |

Table 3 – Minimum "H" Dimension for Rigging Basin-Casing Sections

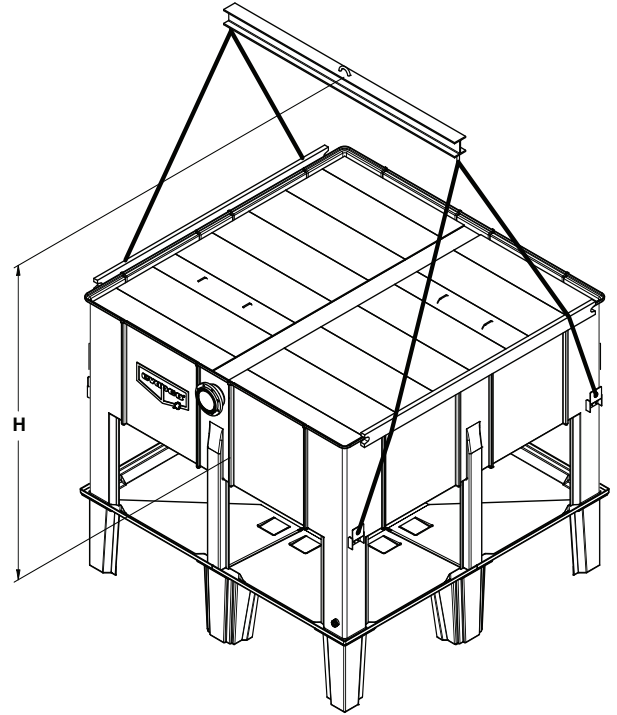


Figure 3 – Casing and Basin Rigging

#### Rigging Fan Section

All fan sections are to be rigged as a four-point lift. The four pick points are on the mechanical equipment support as shown in Figure 4. The hook of the crane must be a minimum dimension "H" above the top section being lifted to prevent undue strain on the lifting lugs and the fibreglass. See Table 4 for the minimum "H" dimensions.

| Box Size (ft x ft) | Min. "H" Dim. Spreader Bar (ft/mm) |
|--------------------|------------------------------------|
| 8x8                | 8 / 2438                           |
| 10x10              | 10 / 3048                          |
| 12x12              | 10 / 3048                          |

Table 4 – Minimum "H" Dimension for Rigging Fan Section

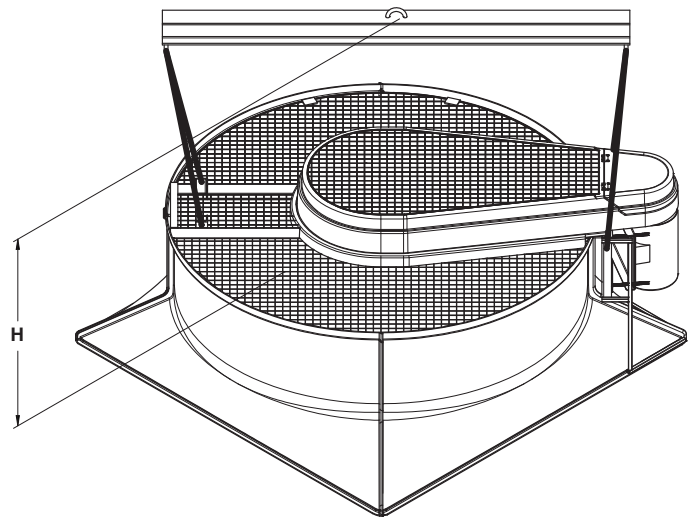
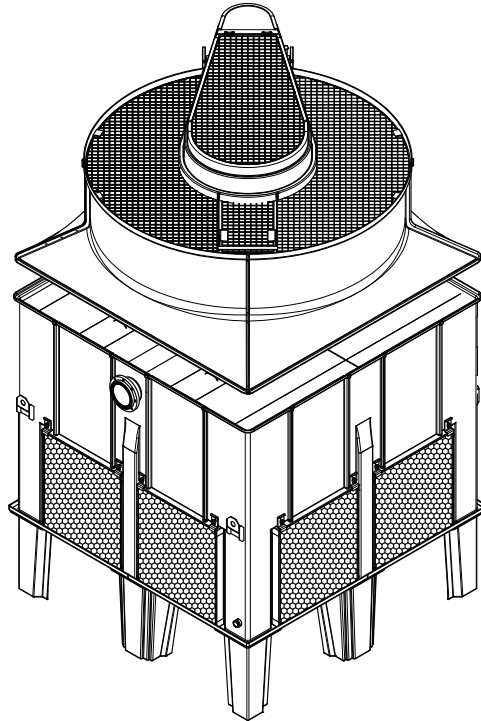


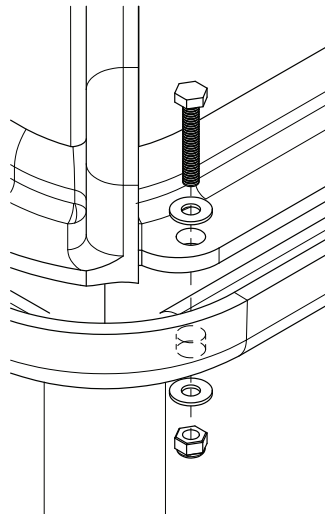
Figure 4 – Fan Section Rigging

The fan section will then be set directly on top of the casing as shown in Figure 5. The installer must ensure that the fan section is oriented such that the motor is accessible for maintenance.



**Figure 5 – Fan Section Above Casing**

Bolt the two sections together with the hardware provided in the rigging box as shown in Figure 6. Orientation markings are on the individual sections to assist the installer with assembly. **No sealer tape is required between the fan and casing sections.**



**Figure 6 – Attachment Point**



Section C: Units Shipped with Fan Section Sitting on Basin Section

These units shall arrive in two sections, the fan section shall be on the basin, and the casing section separate. Note: The fan section will not be rigidly attached to the basin section. These units may not be rigged as a fully assembled tower.

Rigging Fan Sections

The fan section should first be detached and lifted from the basin. All fan sections are to be rigged as a four-point lift. The four pick points are on the mechanical equipment support as shown in Figure 7. The hook of the crane must be a minimum dimension "H" above the top section being lifted to prevent undue strain on the lifting lugs and the fiberglass. See Table 5 for the minimum "H" dimensions.

| Box Size (ft x ft) | Min. "H" Dim. Spreader Bar (ft/mm) |
|--------------------|------------------------------------|
| 10 x 10            | 10 / 3048                          |
| 12 x 12            | 10 / 3048                          |
| 16 x 16            | 13 / 3962                          |
| 20 x 20            | 17 / 5182                          |

Table 5 – Minimum "H" Dimension for Rigging Fan Section

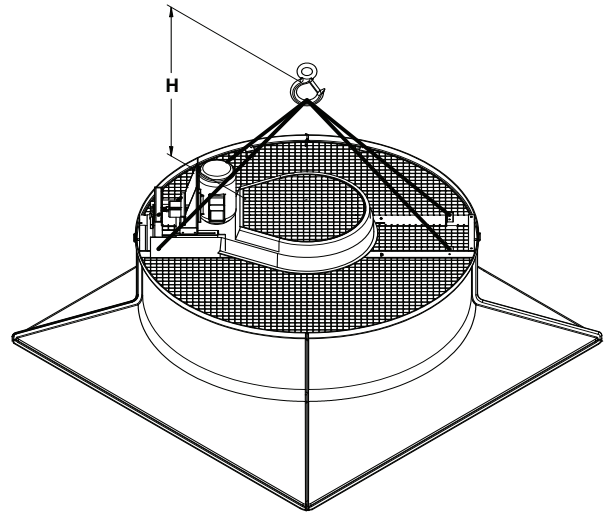


Figure 7 – Fan Section Rigging

If the basin and fan section is required to be picked at the same time, then pass soft slings under the basin, between the corner feet according to Figure 8. The minimum H dimension is shown below in Table 6.

| Box Size (ft x ft) | Min. "H" Dim. Spreader Bar (ft/mm) |
|--------------------|------------------------------------|
| 10 x 10            | 11 / 3353                          |
| 12 x 12            | 12 / 3658                          |
| 16 x 16            | 17 / 5182                          |
| 20 x 20            | 22 / 6707                          |

Table 6 – Minimum "H" Dimension for Rigging Basin-Casing Sections

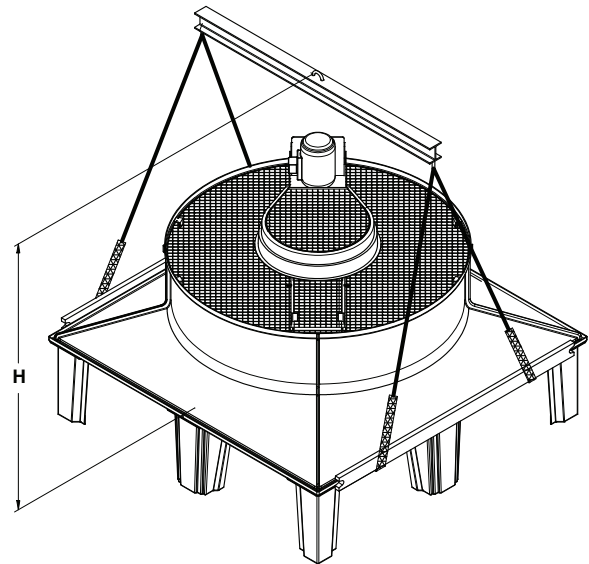
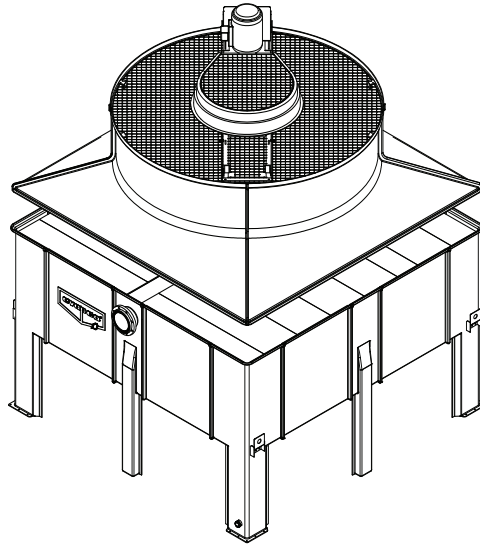


Figure 8 – Lifting Fan and Basin Sections Together

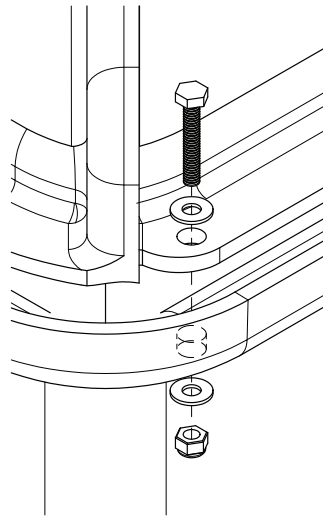
These lifting devices should not be used for extended lifts or where any hazard exists unless safety slings are employed under the section. (See "Extended Lifts" on page 11 for proper arrangement.)

Lift the fan section and place it on the Casing Section as shown in Figure 9. The installer must ensure that the fan section is oriented such that the motor is accessible for maintenance.



**Figure 9 – Fan Section Above Casing**

Bolt the two sections together with the hardware provided in the rigging box as shown in Figure 10. Orientation markings are on the individual sections to assist the installer with assembly. **No sealer tape is required between the fan and casing sections.**



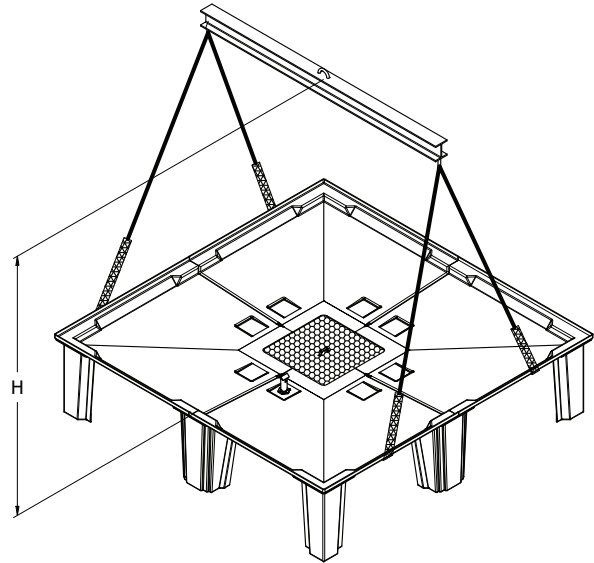
**Figure 10 – Attachment Point**

## Rigging Basin Section

The basin sections are placed into position using soft slings. Pass the slings below and between the basin and basin feet as shown in figure 11. The spreader bar of the crane must be a minimum dimension of "H" above the lip of the basin to prevent undue strain on the fibreglass. Refer to Table 7 below for the minimum "H" dimensions. Ensure that the basin is oriented correctly with respect to the pipe work and the rest of the unit. Then, bolt the basin to the plinths or supports (hardware not provided).

| Box Size (ft x ft) | Min. "H" Dim. Spreader Bar (ft/mm) |
|--------------------|------------------------------------|
| 10 x 10            | 11 / 3353                          |
| 12 x 12            | 12 / 3658                          |
| 16 x 16            | 17 / 5182                          |
| 20 x 20            | 22 / 6707                          |

**Table 7** – Minimum "H" Dimension for Rigging Fan Section

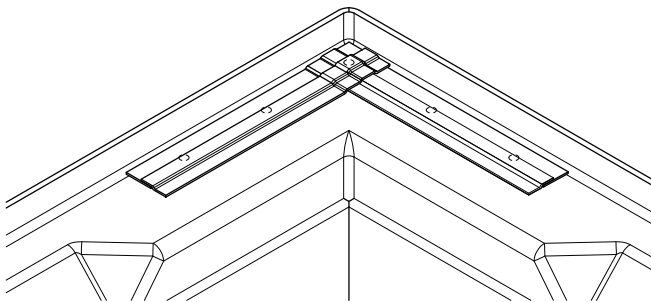


**Figure 11** – Basin Section Rigging

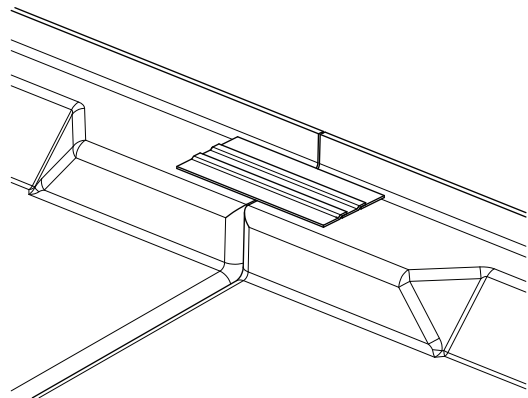
## Sealer Tape Application

Before assembling the basin and casing section, wipe the perimeter of the basin lip to remove any dirt or moisture. The sealer tape should be placed over the mounting hole centreline at the corner and intermediate bolting locations (per the drawing). At the corner, ensure that the sealer tape overlap as shown in figure 12. The intermediate attachment points of the casing to the basin must use sealer tape as well as show in Figure 13.

**Always remove the paper backing from the sealer tape.**



**Figure 12** – Corner Sealer Tape Application



**Figure 13** – Intermediate Section Sealer Tape Application



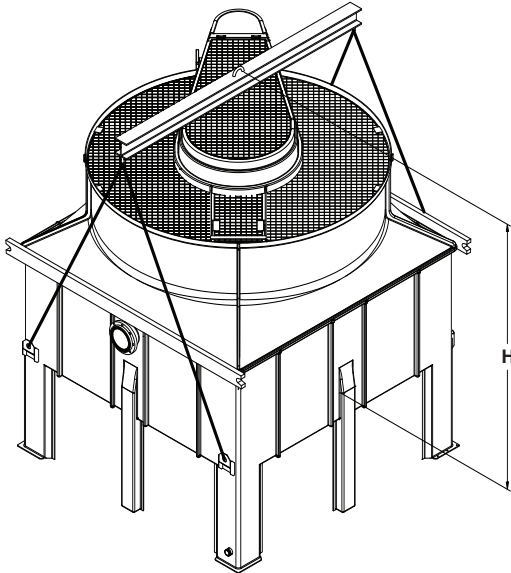
**Rigging Fan-Casing Sections**

All casing sections are to be rigged as a four point lift. The four pick points are on the side of the tower, adjacent to the inlet connection as shown in Figure 14. The hook of the crane must be a minimum dimension “H” above the pick point of the section being lifted to prevent undue strain on the lifting lugs and fiberglass. See Table 8 for the minimum “H” dimensions.

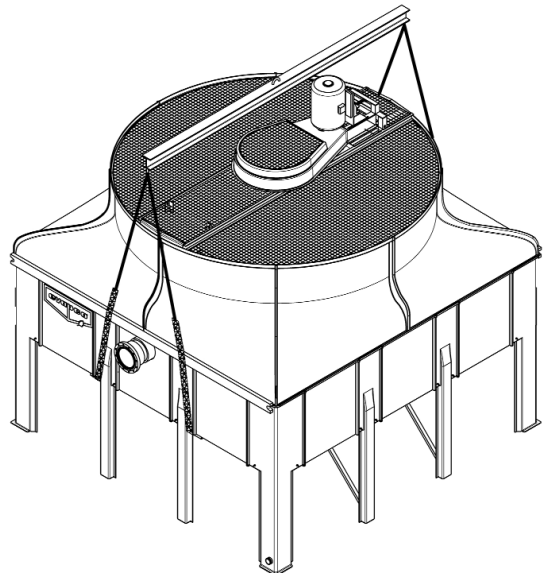
These lifting devices should not be used for extended lifts or where any hazard exists unless safety slings are employed under the section. (See “Extended Lifts” on page 11 for proper arrangement.)

| Box Size (ft x ft) | Min. “H” Dim. Spreader Bar (ft/mm) |
|--------------------|------------------------------------|
| 10 x 10            | 11 / 3353                          |
| 12 x 12            | 12 / 3658                          |
| 16 x 16            | 17 / 5182                          |
| 20 x 20            | 22 / 6707                          |

**Table 8 – Minimum “H” Dimension for Rigging Fan-Casing Section**



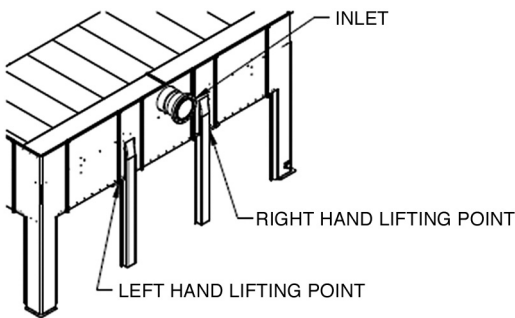
**Figure 14 – Fan-Casing Section Rigging (10 x 10 and 12 x 12)**



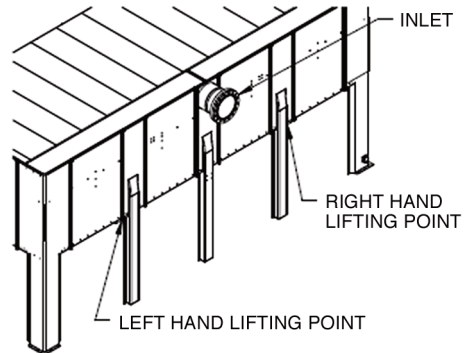
**Figure 15 – Fan-Casing Section (16 x 16 and 20 x 20)**

For all MTT 16 x 16 and 20 x 20, reference to appendix 1 and 2 is required.

To lift the fan-casing section, pass soft slings through the louver openings shown in figure 15a or 15b. Special lifting tubing is installed at the factory to protect the fiberglass. The hook of the crane must be a minimum dimension “H” above the pick point of the section being lifted to prevent undue strain on the fiberglass. See Table 8 for the minimum “H” dimensions.

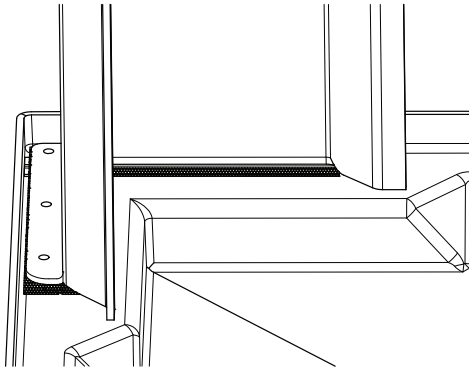


**Figure 15a – 16x Rigging Strap Locations**

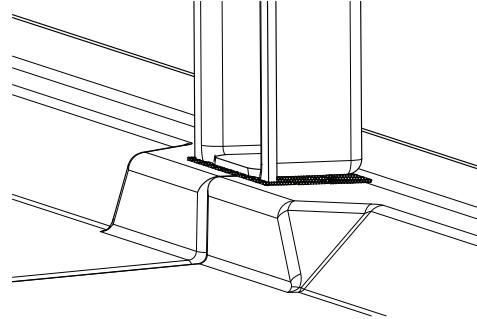


**Figure 15B – 20x Rigging Strap Locations**

Lower the fan-casing section and place it on the basin section as shown in Figures 16 and 17. Bolt the two sections together with the hardware provided in the rigging box as shown in Figure 10. Orientation markings are on the individual sections to assist the installer with assembly.



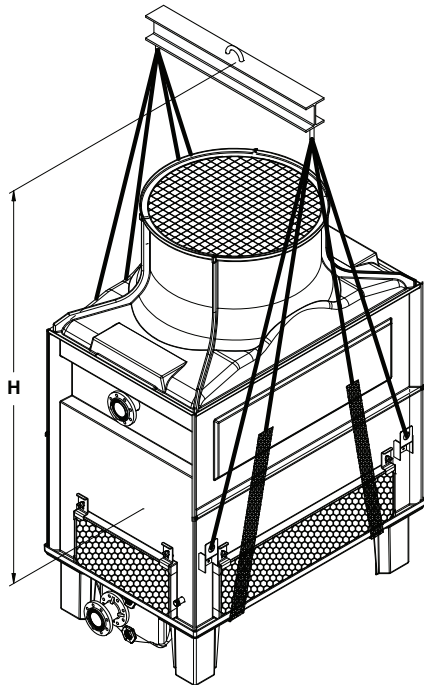
**Figure 16** – Corner Sealer Tape Application



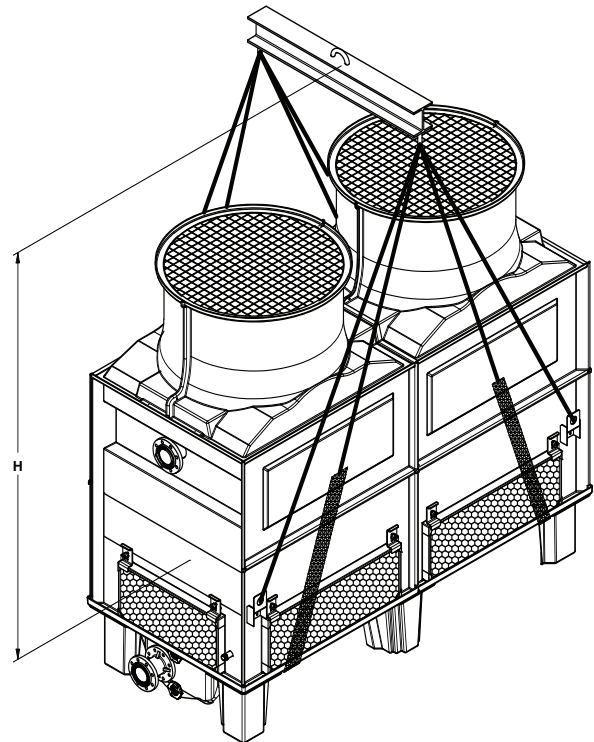
**Figure 17** – Intermediate Section Sealer Tape Application

## Extended Lifts

Important: The lifting devices and lifting lugs should be used for final positioning only and for lifting where no danger exists. If they are used for extended lifts, safety slings should be provided under the sections. Safety slings and skids must be removed before final positioning of the units. Refer to the Figures 18-21 below.



**Figure 18** – Safety Slings for Extended Lift on 4 x 6



**Figure 19** – Safety Slings for Extended Lift on 4 x 9

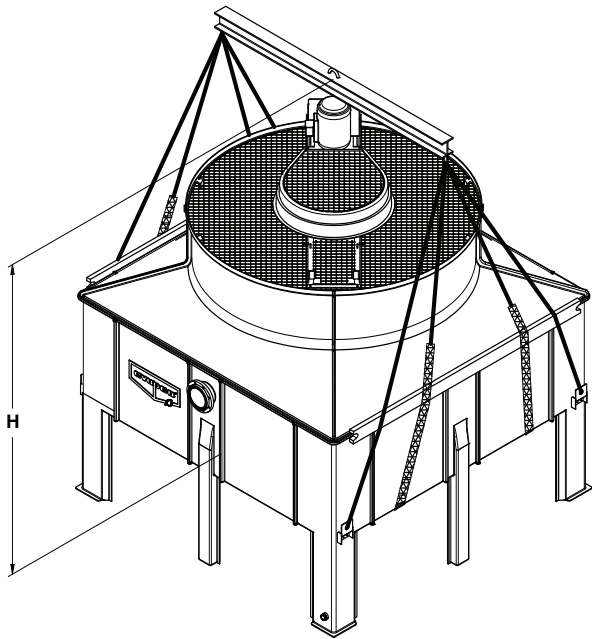


Figure 20 – Safety Slings for Extended Lift on Fan-Casing Section

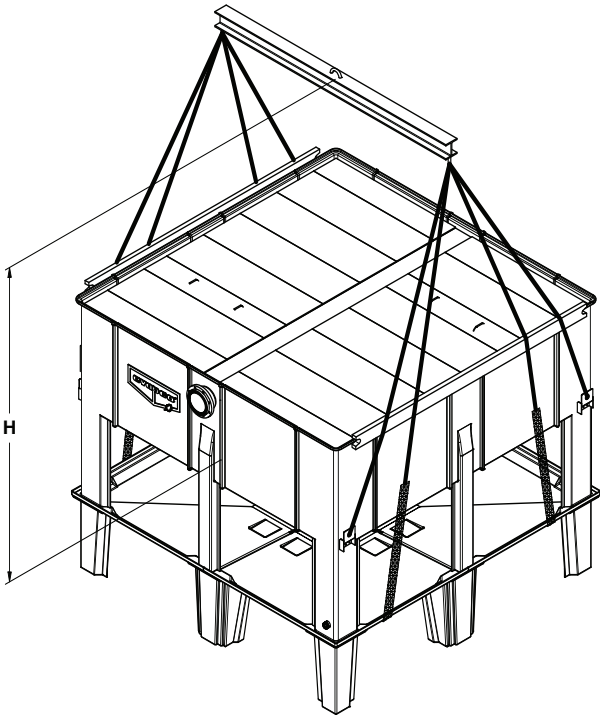


Figure 21 – Safety Slings for Extended Lift on Casing-Basin Section

**General Information - Start-up & Maintenance Start-up Details**

**Shipping Chocks and Debris**

Remove any chocks that have been placed inside the unit for shipping purposes. Clean all debris from the pan prior to start-up. Make sure all louvers are in place and secured with retainer clips as shown in Figure 22.

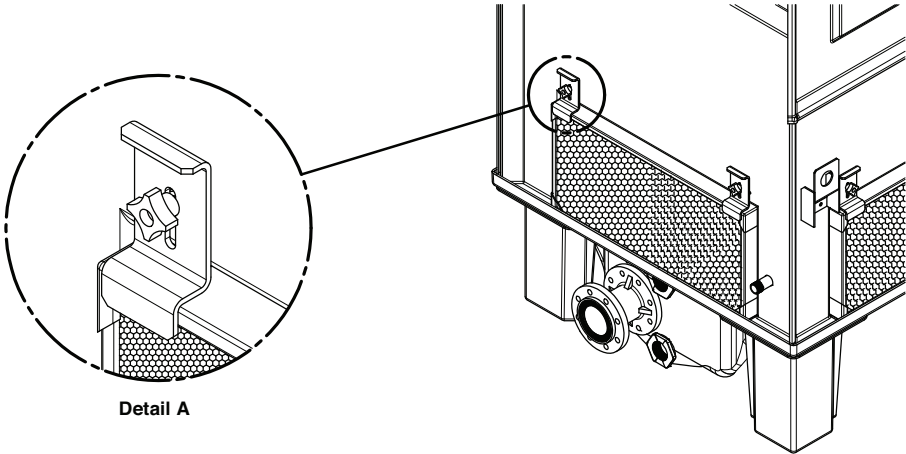


Figure 22 – Louver Retainer Clips



## Bleed-off Line, Overflow and Drain

Make sure a bleed line and valve, overflow and drain are installed on the pump discharge side of the system piping to a convenient drain. The bleed-off valve should be open. For installation details, see the "Operation and Maintenance Instructions, Bulletin 113 (latest edition).

## Strainer

Check the strainer(s) in the pan to make sure they are in the proper location over the pump suction, alongside of the anti-vortex hood as shown in Figure 23.

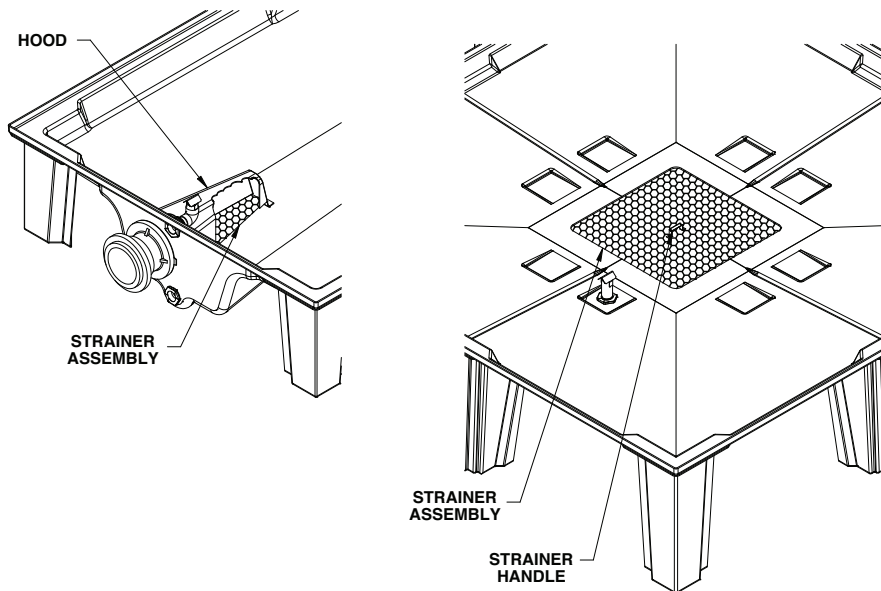


Figure 23 – Strainer Locations

## Adjustment of Float Valve

The float valve should be adjusted to maintain the proper water level as specified in the maintenance instructions. At start-up, the pan should be filled to the overflow level. The water level can be checked during operation by opening the removable louver section at the valve while the pump is running and the fans are off.

## Screens

Protective fan screens are provided across the top of the fan cylinders of all models. Check and tighten all bolts.

## Starting Sequence

Before starting the unit, check that all access openings, safety screens and covers are in place. Start the unit as outlined below:

1. Fill the pan to the overflow level.
2. Start the water pumps (by others). Check the water flow to the unit by checking the spray water pressure at the water inlet. It should be the same as the pressure indicated in the submittal package.
3. Start the fans. Check the fans for proper rotation. Directional arrows are on the side of the fan cylinder.



## **Maintenance**

Once the installation is complete and the unit is turned on, it is important that it be properly maintained. Maintenance is not difficult or time-consuming but must be done regularly to assure full performance of the unit. Refer to the maintenance instructions enclosed with the unit for proper maintenance procedures.

## **Freeze Protection**

Proper freeze protection must be provided if the unit is located in a cold climate. Refer to maintenance instructions as well as product bulletins for further information.

|  |  |  |
|--|--|--|
| <p><b>CONFIDENTIAL</b><br/>This document is the property of Evapco, Inc. It should not be copied or disclosed without prior written authorization.</p> | <p>PART NO.<br/><b>954-30011GA</b></p>   | <p>REV. NO.<br/>-</p>  |
| <p><b>16X LIFTING STRAP LOCATIONS<br/>TYP. FRONT &amp; REAR</b></p>  | <p><b>20X LIFTING STRAP LOCATIONS<br/>TYP. FRONT &amp; REAR</b></p>  | <p><b>16X/20X LIFTING GEN ARR</b></p> <p><b>STEP 1. ORIENT HOLES IN TUBING WITH HOLES IN DRIP ANGLE AND USE TUBE TO DRILL OUT PANELS.</b></p> <p><b>STEP 2. BOLT TUBING IN PLACE FOR LIFTING WITH STRAPS.</b></p> <p><b>TYP. BOLTING</b></p> |
| <p><b>EVAPCO, INC.</b></p>   |  |  |
| <p><b>REVISIONS</b></p>  |  |  |
| <p><b>STAINLESS STEEL OPTION</b></p> <p>PART NO. RAW MATL.</p>   | <p>DATE <b>12/16/13</b> SCALE <b>N.T.S.</b> CUT SIZE <b>N.C.</b></p> <p>DRAWN BY <b>MER</b> CHECKED BY <b>MER</b> PART NO. <b>954-30011GA</b></p> <p>REV. NO. <b>-</b></p> <p>NEXT ASSEMBLY:</p> |  |
| <p><b>NOTE:</b></p> <p>1. ALL 1/4Ø HOLES SHOULD BE 11/32Ø</p> <p>2. USE STAINLESS STEEL N.C. SET-UP SHEET</p>  |  |  |



Appendix 2

|   |  |                       |
|---|--|-----------------------|
| <p><b>CONFIDENTIAL</b><br/>This document is the property of Evapco, Inc. It should not be copied or disclosed without prior written authorization.</p>  | <p>PART NO.<br/><b>954-30012GA</b></p> | <p>REV. NO.<br/>-</p> |
|   |  |                       |
|   |  |                       |
|   | <p>TYP. BOLTING</p>                    |                       |
| <p>STEP 1. UNFASTEN AND REMOVE TUBING AFTER POSITIONING CASING. (4) PLCS.<br/>STEP 2. APPLY SEALER TAPE ON SURFACES AS SHOWN.<br/>STEP 3. BOLT REMOVABLE DRIP ANGLES IN PLACE AS SHOWN. (4) PLCS.</p> |  |                       |
| <p><b>EVAPCO, INC.</b></p>  |  |                       |
| <p>16X/20X DRIP ANG ATTACH GEN ARR</p>  |  |                       |
| <p>TITLE</p>  | <p>RAW MATL</p>                        | <p>CUT SIZE</p>       |
| <p>GA</p>   | <p>SCALE</p>                           | <p>N.C. INFO.</p>     |
| <p>DATE</p>   | <p>12/9/13</p>                         | <p>N.T.S.</p>         |
| <p>DRAWN BY</p>   | <p>MER</p>                             | <p>CHKD BY</p>        |
| <p>NEXT ASSEMBLY:</p>   | <p>954-30012GA</p>                     | <p>REV. NO.</p>       |
| <p>REVISIONS</p>  |  |                       |
| <p>STAINLESS STEEL OPTION</p>   |  |                       |
| <p>PART NO.</p>   | <p>RAW MATL</p>                        | <p>NOTE:</p>          |
| <p>1. ALL 1/4Ø HOLES SHOULD BE 11/32Ø<br/>2. USE STAINLESS STEEL N.C. SET-UP SHEET</p>  |  |                       |



**EVAPCO, Inc.** • P.O. Box 1300 • Westminster, MD 21158 USA  
PHONE: 410-756-2600 • FAX: 410-756-6450 • E-MAIL: [marketing@evapco.com](mailto:marketing@evapco.com)

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