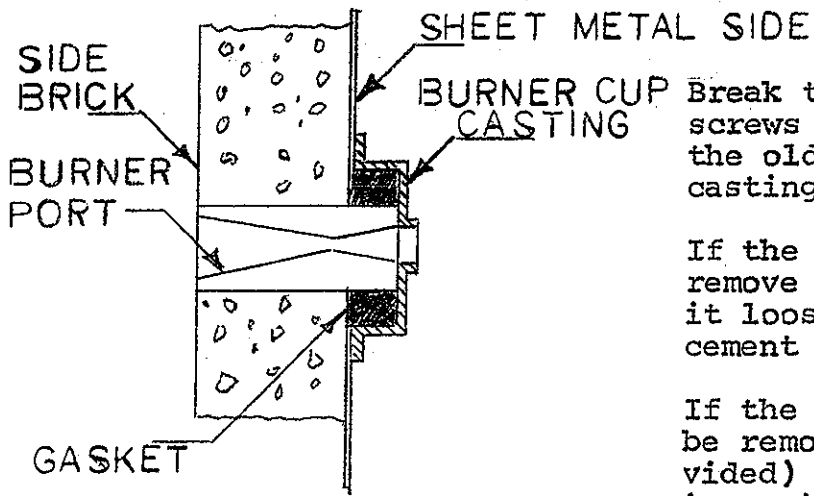


REPLACING PORT & GASKET IN OVEN FURNACES

Break the union in the piping. Loosen the screws and remove the cup casting. Remove the old gasket and any cement from the cup casting.

If the burner port is cracked or deteriorated remove it by tapping the sides lightly to break it loose or crack it. Remove any chunks of cement that remain on the side brick.

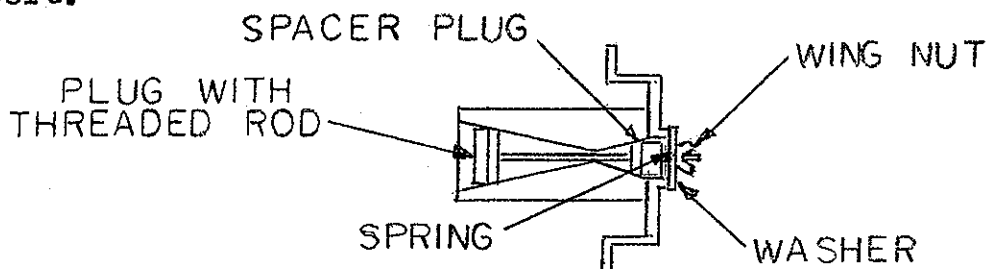
If the burner port is okay and doesn't have to be removed. Place the new burner port (provided) in the center of the burner cup casting, with the small port hole against the casting. Fasten the port in position using

the holding fixture provided. (See sketch at bottom of page.) Place the gasket strip inside the cup casting and around the burner port. Using your thumbs or a block of wood, press the gasket material down, inside the cup casting until it is just above the top of the cup casting.



Disassemble the holding fixture and remove the burner port by rotating it gently. Put a thin layer of cement around the outside of the burner port that is in the side brick. Put a thin layer of cement on the side brick next to the burner port.

Slide the gasket and cup casting over the burner port by rotating the cup casting. Line up the holes in the sheet metal side and cup casting. Tighten the screws and pull the cup casting against the sheet metal side. Make sure the end of the burner port is against the cup casting and the holes through the center are lined up and clear of cement. If the old burner port is to be replaced, repeat the same procedure as above except do not remove the burner port from the cup casting. Put a 1/8" layer of cement around the outside of the burner port. Insert the port through the hole in the side brick. Line up the holes in the sheet metal and cup casting. Use the screws and draw the burner port and cup casting in place. Make sure the end of the burner port is against the cup casting and the holes through the center are lined up and clear of cement. If the hole in the side brick was too large, fill in the space with cement. Allow the cement to set for about one hour, then gently, remove the holding fixture and proceed to another port.

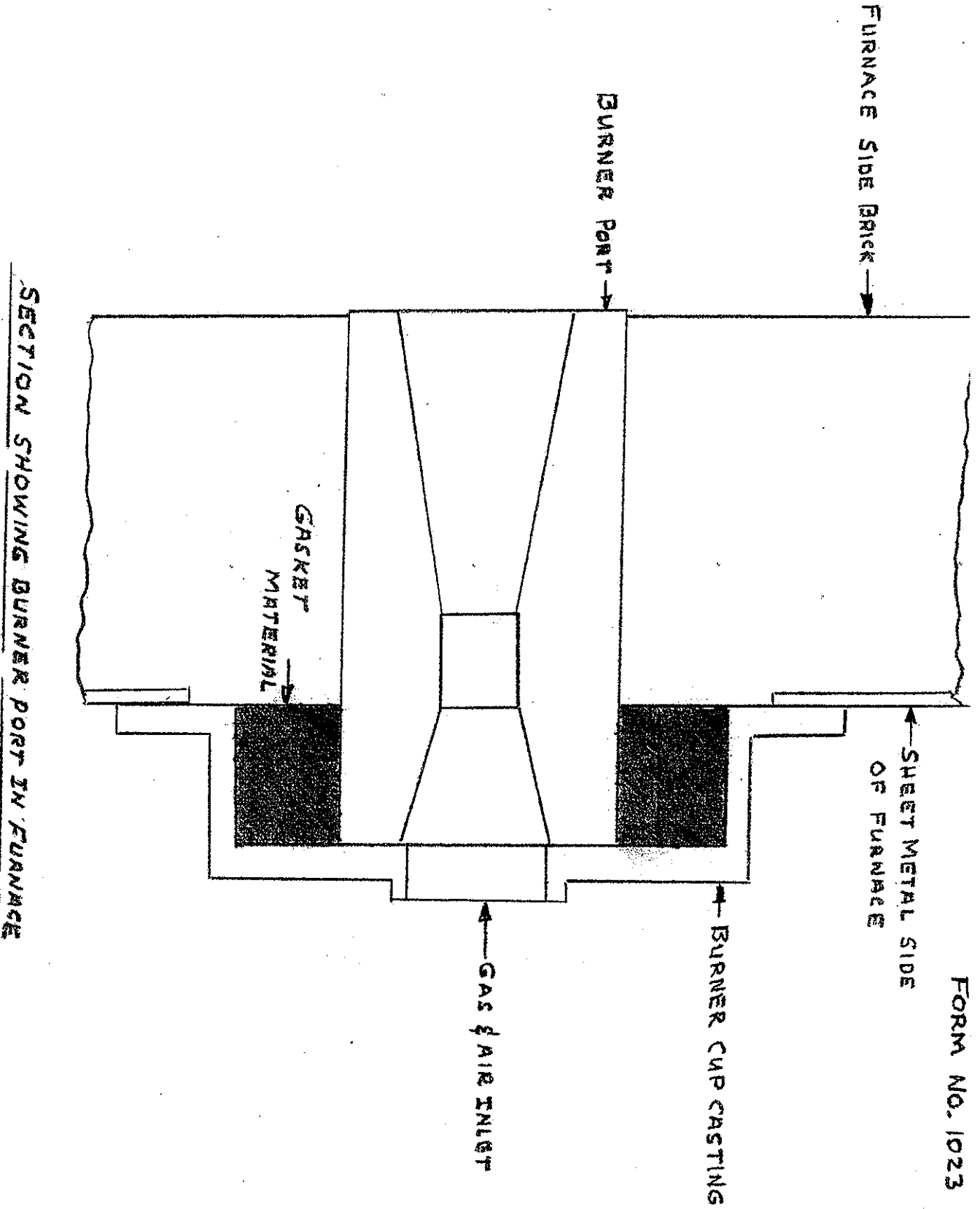


DATE _____ BY _____

ENGINEERING NO. _____

SUBJECT _____

PART NO. **FORM NO. 1023**



SECTION SHOWING BURNER PORT IN FURNACE

SUBJECT REPLACING REFRACTORY BURNER PORT T NO. _____

SEE FORM NO 1023

IF YOUR OLD REFRACTORY BURNER PORT WAS BROKEN OR CRACKED; REMOVE THE OLD PORT BY TAPPING THE SIDES GENTLY AND TURNING THE PORT WITH A PIPE WRENCH.

TAKE THE NEW BURNER PORT, GASKET AND PORT CUP AND PUT CEMENT AROUND THE OUTSIDE OF THE BURNER PORT. SLIDE THE NEW PORT INTO PLACE WITH THE SCREW HOLES LINED UP, PUT THE SCREWS BACK IN PLACE AND TIGHTEN. REMOVE ANY EXCESS CEMENT FROM AROUND THE PORT CUP. IF ANY OF THE LINING HAS CHIPPED OFF, FILL IN WITH CEMENT. ALLOW CEMENT TO SET UP FOR AT LEAST 8 HOURS, REPLACE PIPING.