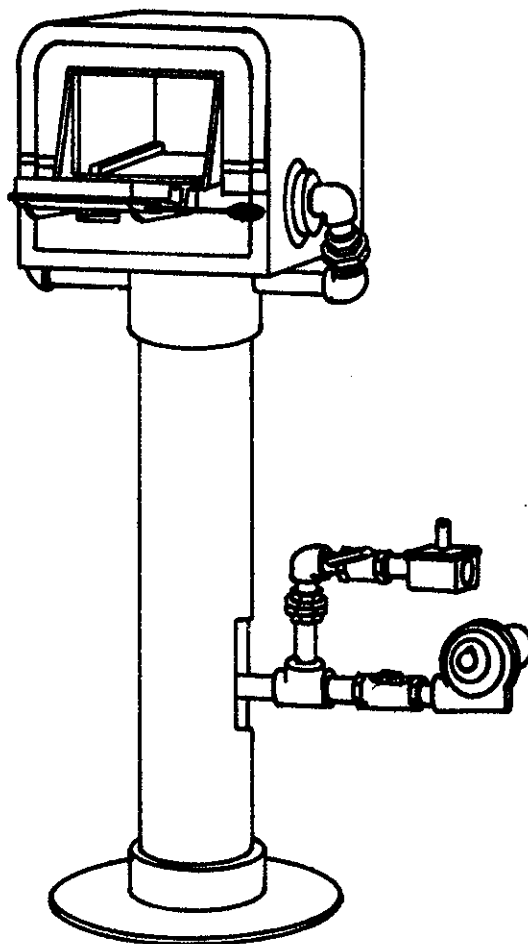


INSTRUCTIONS
INSTALLATION & OPERATION
FURNACE NO.



JOHNSON GAS APPL. CO.
CEDAR RAPIDS, IOWA

INSTRUCTIONS FOR BLOWER TYPE FURNACE WITH MANUAL
TEMPERATURE CONTROL AND NO SAFETY EQUIPMENT

FOR FURNACES WITHOUT SPARK IGNITION, CONNECT THE BLOWER MOTOR TO 115 VOLT ELECTRICAL SOURCE. FOR FURNACES WITH SPARK IGNITION, CONNECT THE TRANSFORMER AND BLOWER AS SHOWN ON THE WIRING DIAGRAM.

CONNECT THE GAS SUPPLY LINE TO THE FURNACE GAS INLET. ON NATURAL GAS, THE PRESSURE SHOULD BE 4" WATER COLUMN MINIMUM TO 14" WATER COLUMN MAXIMUM. ON L.P. GAS, THE PRESSURE SHOULD BE 11" WATER COLUMN. PRESSURE READINGS ARE TO BE TAKEN WITH THE FURNACE IN OPERATION.

SET THE BLOWER AIR SHUTTER ABOUT 1/4" OPEN AND START THE BLOWER MOTOR.

IF YOU HAVE SPARK IGNITION, TURN THE SPARK ON. IF YOU HAVE A GAS PILOT, IGNITE THE PILOT BURNER. IF YOU HAVE AN OVEN FURNACE WITHOUT A PILOT, OPEN THE FRONT DOOR AND HOLD A LIGHTED TAPER OR TORCH SO THAT THE FLAME IS NEAR ONE OF THE BURNERS.

SLOWLY TURN THE NO. 1 LEVER HANDLE VALVE TOWARD THE OPEN POSITION UNTIL YOU REACH THE POINT WHERE THE BURNERS IGNITE. MAKE MINOR ADJUSTMENTS TO THE VALVE TO OBTAIN A STEADY ROAR FROM THE BURNERS. THE DOOR TO THE OVEN TYPE FURNACE CAN BE CLOSED.

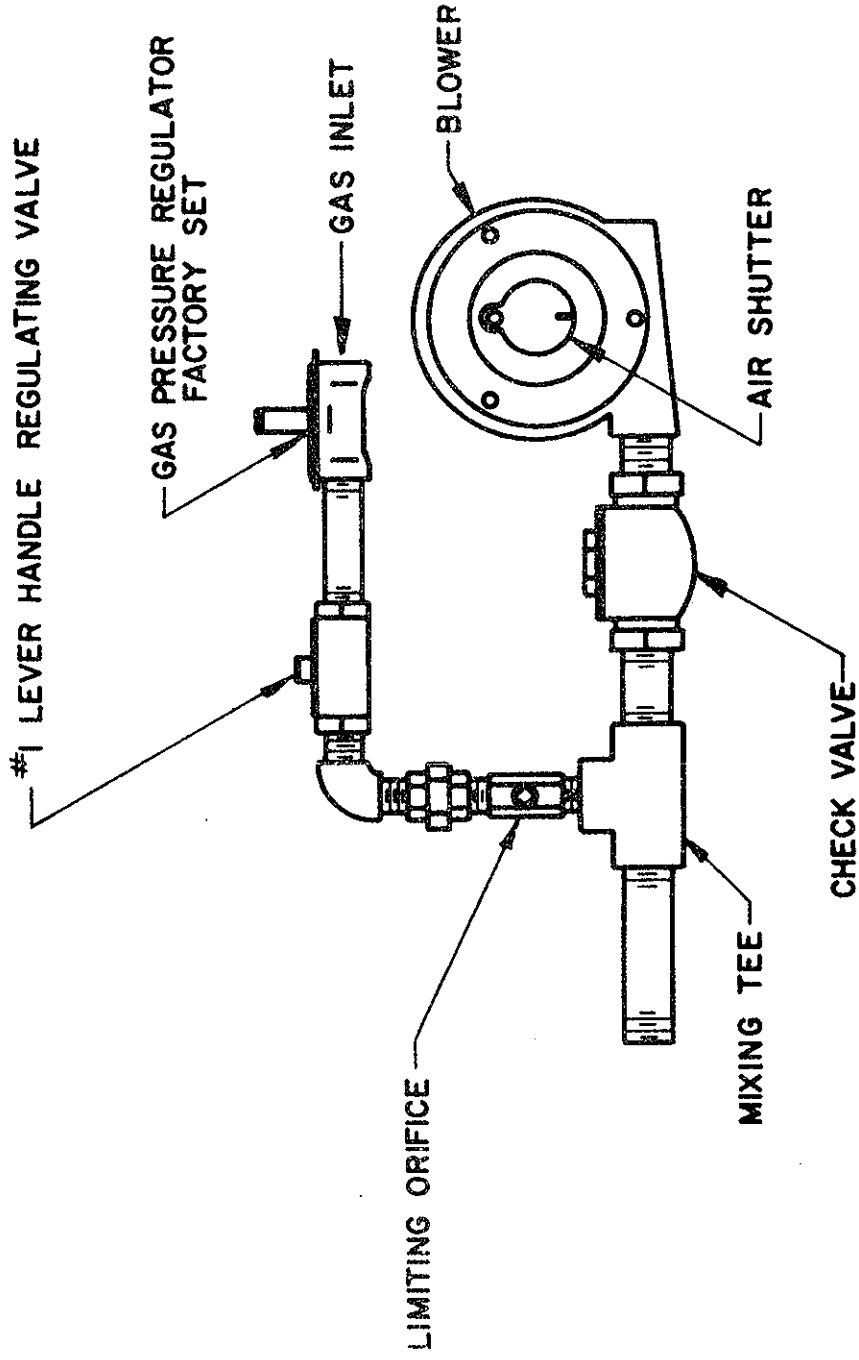
FOR FURNACES WITH SPARK IGNITION, THE SPARK CAN BE TURNED OFF AFTER THE BURNERS IGNITE.

AFTER THE FURNACE HAS WARMED UP, ADJUST THE NO. 1 VALVE TO OBTAIN A SHARP TAIL OF FLAME OUT THE FURNACE EXHAUST OPENINGS. NO FLAME MEANS NOT ENOUGH GAS. A LONG, LAZY FLAME MEANS TOO MUCH GAS.

IF YOU DESIRE TO INCREASE THE GAS INPUT, OPEN THE BLOWER SHUTTER A SMALL AMOUNT AND THEN RE-ADJUST THE NO. 1 VALVE TO RE-OBTAIN THE SHARP TAIL OF FLAME. REPEAT THIS PROCEDURE UNTIL THE DESIRED OR MAXIMUM GAS INPUT IS REACHED.

TO SHUT DOWN THE FURNACE, TURN OFF THE NO. 1 VALVE FIRST AND THEN TURN OFF THE BLOWER MOTOR.

PIPING DIAGRAM-BLOWER TYPE FURNACE WITH MANUAL TEMPERATURE CONTROL ONLY



VENTING REQUIREMENTS

JOHNSON FURNACES

1. POT FURNACES, FORGES, AND MELTING FURNACES,
SINGLE UNITS OR MULTIPLE INSTALLATIONS

FOR EXHAUST HOODS APPROXIMATELY 6'6" TO 7'
ABOVE FLOOR, THE EXHAUST FAN SHOULD BE
SUFFICIENT TO PROVIDE A 200 FPM FACE
VELOCITY AT THE HOOD.

2. OVEN TYPE FURNACES (INCLUDES OVEN FORGES)
 - A. SINGLE INSTALLATIONS

FOR SINGLE INSTALLATIONS THE VENT REQUIREMENTS
SHOULD REDUCE FLUE GAS TEMPERATURE TO 500 OR
BELOW. FOR CFM REQUIREMENTS, DIVIDE BTU INPUT
OF THE FURNACE BY 225. (APPLICABLE WHERE THE
VENT HOOD IS 6" TO 8" ABOVE EXHAUST OPENINGS)

- B. FOR SINGLE OR MULTIPLE INSTALLATIONS WHEN SINGLE
EXHAUST HOOD IS 6'6" TO 7' ABOVE FLOOR, PROVIDE
FOR A 200 FPM FACE VELOCITY.

MAINTENANCE INSTRUCTIONS FOR JOHNSON FURNACES

Johnson equipment is designed to give the longest possible service at the lowest maintenance cost. Due to the high temperatures reached by Johnson furnaces certain repairs are required from time to time to keep them in good operating condition. We are listing below pertinent maintenance information.

OVEN TYPE HEAT TREATING FURNACES [#70, #120, #121, #142, #143, #654, #706]

A. GENERAL MAINTENANCE:

These furnaces are lined with high temperature insulating refractory. This refractory expands and contracts as the furnace heats and cools; and cracks will appear throughout the lining. These are normal and should not be cause for alarm and should NOT be filled with cement as it will cause the brick to spall. The door brick on the #70, #120, #121 & #654 furnaces should be replaced occasionally. It is furnished with inconel screws and washers to withstand the high temperatures. The door should NOT be used as a shelf or parts dragged across the door brick in the process of removing parts from the furnace. Also, avoid striking the sides of the furnace with tongs. The hearth plate will require replacement occasionally, as will the front and back hearth rests on which the plate is set. The hearth plate must be used with the channel edges up. Parts to be heated should be pre-heated or brought up to temperature with the furnace when possible; avoid placing a cold piece on a hot hearth plate. When the gas is turned off to the furnace, turn off the blower at once so the lining will cool gradually.

B. FURNACE RELINING AND FURNACE EXCHANGE:

The furnace should be used until the complete lining is considerably deteriorated. It should then either be replaced with a new lining or new furnace body from the factory. Complete sets of fire brick linings with special shapes to fit the furnace and cement for sealing the brick are available with easy-to-follow installation instructions. Many operators, however, prefer to take advantage of the special price on replacement furnace bodies. Check our repair parts list for prices. This method is popular because it insures an expertly relined furnace in operation at all times; it eliminates the time and trouble of relining the furnace in the customer's shop; and it eliminates the "down" time for returning to the factory for relining. WHEN ORDERING, SPECIFY IF FURNACE IS TO HAVE SAFETY PILOT PORT INSTALLED. FOR ADDITIONAL INFORMATION ON SAFETY EQUIPMENT SEE PAGE 3.

PYROMETER EQUIPMENT:

Occasional replacement must be made of the thermocouple elements, the protection tubes or of the complete thermocouple assembly. We carry replacement parts in stock for immediate delivery.

POT TYPE FURNACES [#920, #950, #568, #580, #565, #565A, #521, #575, #575A, & #575B]

A. FURNACE RELINING:

These furnaces are lined with a high-quality, wear-resistant, castable lining poured with molds used in our factory. These linings are very rugged, and the furnaces should be used until the linings are considerably deteriorated, and then replaced with new furnace bodies. The new bodies are furnished complete less blower equipment and pots or crucibles. Prices for the new bodies are given on the repair parts list. With this method the customers are assured of an expertly lined furnace; and they are never without a furnace to use in their shops. If the lid lining needs replacement before the furnace body, material can be supplied to be mixed with water and molded into the furnace lid or a refractory lid can be supplied.

B. FURNACE RELINING #900 CRUCIBLE FURNACE:

This furnace is lined with a precast lining that can be replaced in the shop or a new replacement body can be supplied.

C. USE OF POTS:

DO NOT use a pressed steel pot for melting aluminum. A graphite crucible is used in the crucible furnaces. A cast iron pot is also suitable when contamination of aluminum by the cast iron is not objectionable.

To extend pot life carry a neutral or slightly reducing flame [more gas than air]. A flame that is too blue is oxidizing and will cause rapid scaling of the pot.

Avoid infiltration of cyanide or other salts into the combustion chamber. If seepage or splashing is occurring, place a ring of dry, powdered fire clay under the flange of the pot.

Turn the pot a little each day so that a different part is exposed to the hottest gases.

Remove sludge or sediment from pot at least once a day. This acts as an insulator, causing local overheating of pot.

Remove the pot at regular intervals and thoroughly clean the inner surface. Also hammer off thin scale that forms on outside.

D. USE OF CRUCIBLES:

Crucibles should be kept in a warm, dry area. Before using a new crucible anneal it by placing it in a warm furnace and gradually raising the temperature at about five minute intervals over a period of forty five minutes until the crucible becomes red.

BLOWER MOTORS:

Motors on the blowers should be oiled occasionally. The brushes should be checked and replaced periodically to avoid wear on the armature.

FORGE FURNACES [#122 & #133]

The forge furnaces are lined with hard firebrick on all wearing surfaces. Individual firebricks can be easily replaced when desired. Lining for the lid or complete lining can be replaced when necessary. Sets of linings are furnished with simple instructions for installation.

SOFT METAL MELTING FURNACES [#379, #313 & #616]

A. FURNACE RELINING:

These furnaces can be relined with brick and castable material supplied by our Company. An instruction sheet accompanies the shipment.

B. GENERAL MAINTENANCE:

Avoid permitting metal to solidify in the pots. If the metal does "freeze" in the pot, turn one burner only on until the metal melts slowly; do not turn all burners on at once or the pot will crack. When melting metal, let small amount of metal form a molten pool before adding additional metal.

SMALL BENCH FURNACES [#101, #112, #108 & #118]

The burner tubes on these furnaces are slotted on the ends to retain the flame, and care should be taken about striking the ends with soldering irons. These tubes are made of cast iron and will give long service, but when the slots are knocked off, the tubes should be replaced to insure good combustion. The #108 and #118 furnaces are equipped with individual valves for each burner. The #101 and #112 furnaces are equipped with double valves. After considerable use the valve plugs will tighten causing the valves to "freeze". When this happens the complete valve will should be replaced as prompt replacement of the complete valve will avoid gas leakage. Linings for all these furnaces are carried in stock. Lining sets are supplied for those in which both hood and bottom are lined. This set consists of material to be molded in to the furnace body and includes a new angle iron.