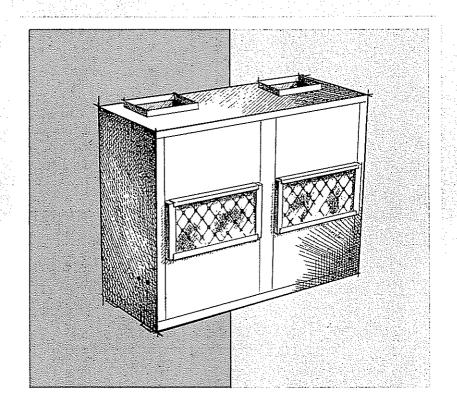
SERIES 100-240 HEAT RECOVERY SYSTEMS

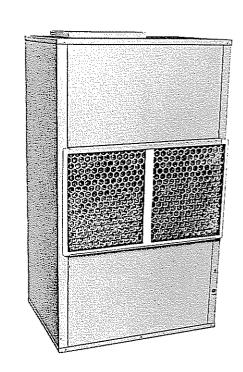


CLIMATE MASTER

ENGINEERING DATA

HEAT RECOVERY SYSTEMS

Vertical Water- to-Air Units



The Climate Master Series 100-240 Heat Recovery Units incorporate the latest technology in the design of large capacity water-to-air reverse cycle units.

The units are designed for connection to a closed loop water circulatory system

with a temperature range between 70°F and 95°F. When interconnected with other units on the loop the diversity of simul-

taneous heating and cooling with individual control year round provides outstanding performance—designed to give the developer, owner and occupant considerable benefits.

 Low Installation Costs due to simplified controls, no pipe insulation, less space require-

ments, minimum ducting and piping, reduced electrical installation, economical selection of auxiliary equipment, ease for future "add-ons."

- Economical Operating Costs due to energy transfer from those areas on cooling to those requiring heating, auxiliary heaters and coolers only operate when the system water loop exceeds the limits of 70° to 95°; night set-backs for reduced energy costs; economy ventilation cycles and morning warm-ups.
- Minimum Maintenance Costs all factory pack-

age equipment easily and simply serviced, no large complex mechanical systems requiring expensive operating personnel, low service requirements due to even operating temperatures.

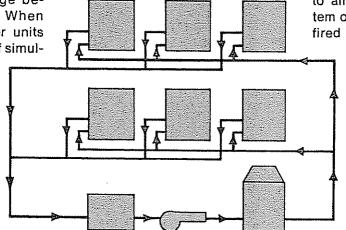
Flexibility — a size and shape to meet most de-

signer requirements, lends itself to all-electric no pollution system or supplementary gas or oil fired heaters (minimum size);

> used for new construction or renovation projects and add-on units can be made at future dates; areas can be individually metered; can be applied in harmony with other systems for maximum diversity.

> Occupant Satisfaction
>
> by having individual ized control of heating
>
>
> and cooling year round;

minimum disturbance for maintenance; quietness of operation; immediate load response; zone control for off-hour operations without having to heat or cool the entire building; no seasonal changeover. A system utilizing the simplest form of equipment to recover and use all those energies that once were discarded or not used such as radiant energy of the sun, lighting heat, equipment and people heat, building orientation — an air conditioning system combining all these features for maximum benefit to the owners' investment.



SPECIFICATIONS

CABINET

The reinforced cabinet is made of heavy gauge, galvanized steel, and painted electrostatically to prevent corrosion. The interior of the cabinet is lined with high density, coated insulation with improved thermal insulating and accoustical absorption characteristics. The units have access panels for ease of inspection and service to all components.

The control voltage wiring and control box are also accessible from the front of the unit. The supply air opening is provided with a duct collar and the return air incorporates a filter rack permitting removal of the filter in any direction.

Each unit is provided with a high velocity type disposable filter.

2. COMPRESSOR

The Hermetic Compressor is designed inherently for low noise and vibration characteristics with a new double scotch yoke compressor design. It has a solid state motor protection system with sensors in all three motor phases. In addition a crankcase heater will provide protection against liquid refrigerant flood back on start-up. The compressor is resiliently mounted on rails within the cabinet.

3. REVERSING VALVE

The Electro Magnetic Valve is of all metal hermetic construction and has an easily replaceable, moisture resistant, molded external electric solenoid coil.

4. REFRIGERANT-TO-WATER HEAT EXCHANGER

The counter flow condensing action heat exchanger is coaxial (tube-in-tube) spirally wound with booster fins on the refrigerant side to provide optimum heat transfer and low water pressure drop. The inner (water) tube is available in copper or cupro-nickel Construction designed to withstand water pressure of 500 psi.

The outer (refrigerant) tube is made of primed and painted steel.

Design working pressure on the refrigerant side is 450 psi.

5. AIR-TO-REFRIGERANT HEAT EXCHANGER

The large face area, fin coil heat exchanger utilizes staggered copper tubes with rippled and corrugated aluminum fins for added heat transfer. The custom designed refrigerant circuiting is designed for high sensible capacity, optimum pressure drops and efficiency.

6. REFRIGERANT CONTROL

6. REFRIGERANT CONTRUL.

The refrigerant flow is accurately metered to the evaporator through a thermostatic expansion valve with multiple distributor tubes to improve performance. The superheat for the valve has been factory set for optimum capacity. The valve also has replaceable power and cage assemblies. The refrigerant circuit is factory pressure and leak tested. Abnormal pressures within the refrigerant circuit are prevented with safety high and low pressure switches. Charging and service ports are provided on the high and low pressure sides of the unit as standard equipment.

7. BLOWER AND MOTOR

The belt driven blower wheel and housing is custom designed for quiet operation and efficient air delivery. The blower is mounted on permanently lubricated, maintenance free ball-bearings. The generously sized Ball Bearing Motor with V-Belt and variable pitch motor pulley is resiliently mounted on an adjustable motor base for easy belt adjustment and/or speed change. The drive package is designed for statics between .30 and 1.25 E.S.P. I.W.G.

8. CONTROLS

The control box, easily accessible from the front panel, includes a 24 volt control transformer, compressor contactor, blower and impedance relays. Completely factory wired, the circuit features a lock-out relay to provide a manual reset at the thermostat in case of interrupted operation by the safety controls.

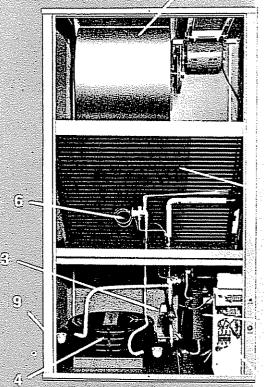
The Dual Units have a time delay relay which delays starting of the second compressor after the start of the first compressor.

The individual control components are designed for ease of inspection and serviceability. A terminal block is provided for convenient field wiring to the thermostat. A remote thermostat for comfort control is furnished wih the unit.

Also available optionally are controls and thermostat for automatic changeover from cooling to heating mode and vice versa,

Dual units incorporate externally stubbed water (FPT) connections for ease of installation.

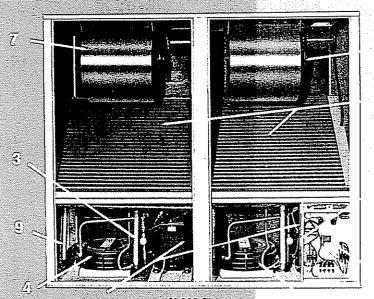
Models 200 and 240 are not ARI certified since they do not fall within the 135,000 BTUH scope limitations of ARI certification program.







V-100 Shown with access panels removed



V-200 Shown with access panels removed

SYSTEM CONTROLS

Controls for the Climate Master System provide the following functions:

- 1. Energize the cooler to reject excess heat as necessary to prevent system water temperature from exceeding the maximum limit (approximately 95°).
- 2. Energize the supplementary heater to add heat as necessary to prevent water temperature from dropping below 70°.
- Read out and sound alarms if there is a loss of water flow or if the temperature limits reach 70°F or 95°F.

Additional controls such as automatic pump alternators, no-flow relay panels, time-clocks, night thermostats and off hour timers can be added as optional features.

SAMPLE SELECTION

REQUIREMENTS:

7700 CFM @ approx. 75" External Static Pressure 460V — 3 Ph Power Supply COOLING: Entering Air 75° FDB/61° WB Entering Water 85°F

Leaving Water 100°F

HEATING: Entering Air 75°F Entering Water 75°F

Flow rate as required on cooling

1. SELECTION

2. COOLING

On the basis of airflow on page 5 the unit tentatively selected is Model V-200. The performance of this is derived as per below.

From table on page 9 the basic capacities for 7000 CFM. and 95°F leaving water are:

Total capacity = 170000 BtuH Sensible capacity = 146200 BtuH Heat rejection = 236000 BtuH

These capacities are affected by the increased airflow and leaving water temperature. Multipliers for these varying conditions are derived from the graph on page 9 and table

Percent on rated airflow = $(7700/7000) \times 100 = 110\%$ Airflow Water temp.

factor factor Total capacity = 170000x1.018x0.959 = 166000 BtuH Sensible capacity = 146200x1.065x0.959 = 149300 BtuH Heat rejection = 236000x1.060x0.968 = 242000 BtuH

GPM required (approx.) = 35

3. HEATING

From the table on page 9 the basic heating capacity with 7000 CFM, 70°F entering air 73° entering water and 35 GPM's.

Heating capacity = 196000 BtuH Heat of absorption = 136000 BtuH Power input = 182000 BtuH

Power input = 182000 BtuH

Correction for the 10% increased airflow on page 5 and 75°F entering water derived from page 9.

Airflow Water Temp.

factor factor Heating capacity = 196000x1.018x.975 = 194550 BtuH Heat of absorption = 136000x1.030x.985 = 138000 BtuH

Leaving water temperature is 65°F.

- a.) The airflow is available with the pulley setting at 3 turns open.
- b.) The water pressure drop for 35 GPM is 2.8 Psig as shown on the table on page 6.
- c.) The electrical information is available in the table on page 6. Compressor FLA (each) = 12.8 Blower FLA (each) = 3.3 Min. Circuit Ampacity is 35.4

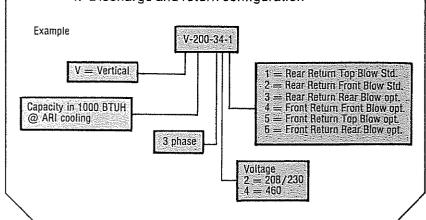
Max. Fuse Size is 45

ORDERING INFORMATION

4. OTHER DATA

When specifying and ordering it is important to indicate the following:

- 1. Configuration
- 2. Size (capacity in 1000 BTUH @ ARI cooling)
- 3. Phase and voltage required
- 4. Discharge and return configuration



in line with policy of product improvement Climate Master reserves the right to change dimensions and ratings.

SPECIFICATIONS

BLOWER PERFORMANCE

	MOTOR	PULLEY			CFM (@ AV	AILABI	E EX	TERN/	L ST	ATIC (LW.G.		
MODEL	HP	SETTING	0.3	0.4	0.5	0.6	0.7	0.8	0.9	1.0	1.1	1.2	1.3	1.4
V 100	1½	CLOSED 1 TURN OPEN 2 TURNS OPEN 3 TURNS OPEN 4 TURNS OPEN 5 TURNS OPEN		4000	3700	 3800 3400		3600 3200	3700 3300 —	3800 3400 — —	3950 3500 3100 — —	3650 3100 — — — —	3300	
V 120	2	CLOSED 1 TURN OPEN 2 TURNS OPEN 3 TURNS OPEN 4 TURNS OPEN 5 TURNS OPEN			 4400 4050	 4500 4150 3800	4300 3900 3500	4400 4000 3600	4150 3750	4350 3900 — —	4050 3600 — —	4250 3750 — — —	3950	3600
V 200	(2) 1½	CLOSED 1 TURN OPEN 2 TURNS OPEN 3 TURNS OPEN 4 TURNS OPEN 5 TURNS OPEN		8000		7600 6800	7800 7000 6200	7200 6400	7400 6600 —	7600 6800 —	7850 7000 6200 — —	7250 6000 — — —	6600 — — — —	40000000000000000000000000000000000000
V240	(2) 2	CLOSED 1 TURN OPEN 2 TURNS OPEN 3 TURNS OPEN 4 TURNS OPEN 5 TURNS OPEN	9000	8600	8800 8100	9000 8300 7600	8600 7800 7000	8800 8000 7200	8300 7500	8700 7500 — —	8100 7200 — —	8500 7500 — — —	7900	7200 — — — —

CORRECTION FACTORS

A. VARIATION OF AIRFLOW (MODELS 100 & 200)

PERCENT OF RATED CFM	80	85	90	95	100	105	110	115	120
TOTAL COOLING & HEATING CAPACITY MULTIPLIER	.950	.963	.975	.988	1.000	1.009	1.018	1.027	1.035
SENSIBLE COOLING CAPACITY MULTIPLIER	.910	.933	.955	.978	1.000	1.033	1.065	1.098	1.130
COOLING HEAT OF REJECTION MULTIPLIER	.970	.978	.985	.993	1.000	1.030	1.060	1.090	1.120
HEATING MODE HEAT OF ABSORPTION MULTIPLIER	.935	.952	.968	.984	1.000	1.015	1.030	1.045	1.060

B. VARIATION OF AIRFLOW (MODELS 120 & 240)

PERCENT OF RATED CFM	80	85	90	95	100	105	110	115	120
TOTAL COOLING & HEATING CAPACITY MULTIPLIER	.940	.955	.970	.985	1.000	1.005	1.010	1.015	1.020
SENSIBLE COOLING CAPACITY MULTIPLIER	.890	.918	.945	.973	1.000	1.020	1.040	1.060	1.080
COOLING HEAT OF REJECTION MULTIPLIER	.964	.973	.982	.991	1.000	1,026	1.052	1.078	1.104
HEATING MODE HEAT OF ABSORPTION MULTIPLIER	.928	.946	.964	.982	1.000	1.012	1.024	1.036	1.048

WATER PRESSURE DROP DATA

G.P.M.	13		15	20		25	30		33
P.D. (P.S.I.G.)	1.5		1,8	3.0		5.1	7.8		9.7
MODEL 120							100 -115		
G.P.M.	15		20	25		30	35		40
P.D. (P.S.I.G.)	1.3		1.6	2.3		3.2	4.5		6.1
WODEL 200									
G.P.M.	26	30	35	40	45	50	55	60	70
P.D. (P.S.I.G.)	2.0	2.3	2.8	3.5	4.4	5.6	6.8	8.3	10.2
MODEL 240									
G.P.M.	30	35	40	45	50	55	60	70	80
P.D. (P.S.I.G.)	1.8	1.9	2.1	2,4	2.8	3.2	3.7	5.0	6.6

MOD	EL MENTE SERVICE SERVICE	V100-32	V100-34	V120-32	V120-34	V200-32	V200-34	V240-32	V240-34
NO. OF CIRCL	JITS	1	1	1	1	2	2	2	2
VOLTAGE		208/230	460	208/230	460	208/230	460	208/230	460
PHASE		3	3	3	3	3	3	3	3
MIN. CIRCUIT	AMPACITY	39	19.3	47.3	23.5	71.4	35.4	86.6	43
MAX. FUSE SI	ZE*	60	30	70	35	90	45	110	50
COMPRESSOR		26.4	12.8	31.8	15.9	26.4	12.8	31.8	15.9
	COMPRESSOR L.R.A. (EA.)		97	194	97	194	97	194	97
BLOWER F.L.A	. (EA.)	6.0	3.3	7.2	3,6	6.0	3.3	7.2	3.6
BLOWER MOT	OR-HP	11	/2	2	2	(2)	11/2	(2)	2
BLOWER WHE	EL DIA. (INS.)		15	1/a			(2)	151/8	
BLOWER WHE	EL LEN. (INS.)		15	1/4	***************************************		(2)	151/4	
REF. TO AIR	DEPTH (INS.)	2.	1	3.	.2	2.	1	3,	2
HEAT	(SQ. FT.) FACE AREA	8.7	75	9.	38	17.5		18.76	
EXCHANGER	FINS/INCH				1	5			

^{*}TIME DELAY TYPE

NOTES:

FILTER SIZE

V-100	V-120 V-200 V-240
(1) 24x40x1	(1) 26x40x1 (2) 24x40x1 (2) 26x40x1

OPERATING WEIGHT LBS. APPROX.

V-100	· V-120	V-200	V-240
870	1000	1700	1950

PIPING CONNECTIONS

	- V-100	V-120	V-200	V-240
Water Inlet	11/4	11/4	11/2	.11/2
Water Outlet	11/4	11/4	11/2	11/2
Drain	1	1	1	1

^{1.)} Minimum voltage for 208/230 volt models is 197 volts.

^{2.)} All models are available with controls suitable for use with an automatic changeover thermostat.

ENGINEERING DATA

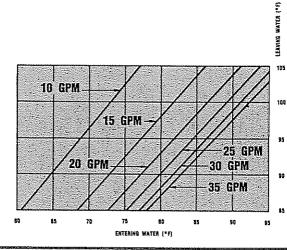
100

COOLING

In accordance with
ARI 240-67:
Cooling Capacity
100,000 BTUH*
Power Input 9700 Watts
Unit E.E.R. 10.3
*Basic capacities with
3500 CFM of
80°F DB/67° entering air
13.3 GPM of Water
entering at 75°F
leaving at 95°F

	BASEL	BASED ON 3500 CFM & 95°F LEAVING WATER								
ENTERING AIR (°F)	TOTAL CAPACITY		HEAT OF REJECTION							
MET BULB	(BTUH)	75	80	85	90	95	(BTUH)			
61	85,000	73,100	81,600				118,000			
64	93,000	69,000	79,100	89,300			125,500			
67	100,000	63,000	74,000	85,000			132,500			
70	106,000		67,700	78,000	89,000		139,000			
73	112,000			72,800	84,000	93,000	145,000			
76	117,000				73,500	89,500	150,500			
79	121,000				65,300	74,500	156,000			

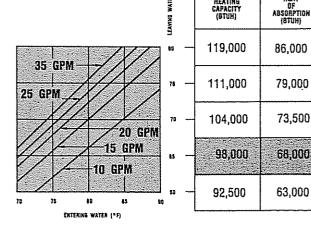
VARIATION OF ENTERING WATER TEMPERATURE AND FLOW RATE MULTIPLIER



	TOTAL A SENSIBLE CAPACITY MULTIPLIER	HEAT REJECTION MULTIPLIER	POWER INPUT (WATTS)
_	0.915	0.940	10,200
	0.959	0.968	9,950
	1.000	1.000	9,700
	1.031	1.022	9,400
Į	1.059	1.041	9,100

HEATING

In accordance with ARI 240-67: Heating Capacity 85,000 BTUH* Power Input 8200 Watts *Based on 3500 CFM of 70°F Entering AIr 13.3 GPM of 60°F Entering Water Unit C.O.P. 3.04 VARIATION OF ENTERING WATER TEMPERATURES & FLOW RATE



WATER (*F)

VARIATION OF ENTERING AIR TEMPERATURES ON HEATING MODE

ENTERING AIR (°F)	60	65	70	75	. 80
HEATING CAPACITY MULTIPLIER	1.06	1.03	1.000	0.975	0.960
HEAT OF ABSORPTION MULTIPLIER	1.08	1.04	1.000	0.985	0.970
POWER INPUT MULTIPLIER	0.98	0.99	1.000	1.030	1.060

10,500

10,000

9,500

9,100

8,700

120

ENGINEERING DATA

COOLING

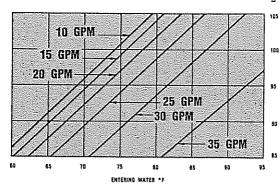
In accordance with
ARI 240-67:
Cooling Capacity
120,000 BTUH*
Power Input 12,400 Watts
Unit E.E.R. 9.8
*Basic capacities with
4200 CFM of
80 °F DB/67 °F WB
entering air
16.2 GPM of Water
entering at 75 °F
leaving at 95 °F

	BASEL	ON 420	O CFM &	95°F LEA	VING WA	TER .				
ENTERING AIR (°F)	TOTAL CAPACITY		SENSIBLI ENTERING	HEAT OF						
WET BULB	(BTUH)	75	80	85	90	95	REJECTION (BTUH)			
61	108,000	94,000	104,800			<u> </u>	147,500			
64	114,000	86,500	99,200	111,700			155,000			
67	120,000	78,000	91,000	104,500			162,000			
70	125,000		82,500	95,000	107,500		169,000			
73	130,000	M		84,500	97,500	110,000	176,000			
76	134,000			***************************************	85,800	100,000	183,000			
79	138,000		_		73,200	88,900	189,500			

WATER "F

LEAVING WATER

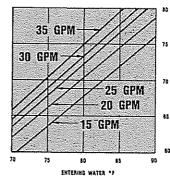
VARIATION OF ENTERING WATER TEMPERATURE AND FLOW RATE MULTIPLIER



	TOTAL & SENSIBLE CAPACITY MULTIPLIER	HEAT REJECTION MULTIPLIER	POWER INPUT (WATTS)
	0.920	0.940	13,200
	0.970	0.975	12,750
	1.000	1.000	12,400
_	1.028	1.024	12,100
_	1.052	1.043	11,900

HEATING

In accordance with ARI 240-67: Heating Capacity: 102,000 BTUH* Power Input 9700 Watts *Based on 4200 CFM of 70°F Entering Air 16.2 GPM of 60°F Entering Water Unit C.O.P. 3.08 VARIATION OF ENTERING WATER TEMPERATURES & FLOW RATE



	HEATING CAPACITY (BTUH)	HEAT OF Absorption (BTUH)	POWER INPUT (WATTS)
_	146,000	114,000	12,400
	136,000	102,000	12,000
_	127,000	93,000	11,550
_	119,000	86,000	11,050
	112,000	80,000	10,500

VARIATION OF ENTERING AIR TEMPERATURES ON HEATING MODE

ENTERING AIR (°F)	60	65	70 :	75 -	- 80
HEATING CAPACITY MULTIPLIER	1.06	1.03	1.000	0.975	0.960
HEAT OF ABSORPTION MULTIPLIER	1.08	1.04	1.000	0.985	0.970
POWER INPUT MULTIPLIER	0.98	0.99	1.000	1.030	1.060

ENGINEERING DATA

200

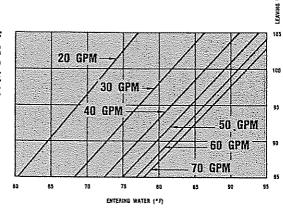
COOLING

In accordance with
ARI 240-67:
Cooling Capacity
200,000 BTUH*
Power Input 19,400 Watts
Unit E.E.R. 10.3
*Basic capacities with
7000 CFM of
80°F DB/67°F WB
entering air
26.5 GPM of Water
entering at 75°F
leaving at 95°F

	BASEI						
ENTERING AIR (°F)	TOTAL CAPACITY		HEAT OF REJECTION				
WET BULB	(BTUH)	7 5	80	85	90	95	(BTUH)
61	170,000	146,200	163,200				236,000
64	186,000	138,000	158,200	178,600			251,000
67	200,000	126,000	148,000	170,000	_		265,000
70	212,000		135,400	156,000	178,000		278,000
73	214,000			145,600	168,000	186,000	290,000
76	234,000				147,000	179,000	301,000
79	242,000				130,600	149,000	312,000

*

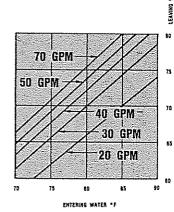
VARIATION OF ENTERING WATER TEMPERATURE AND FLOW RATE MULTIPLIER



	TOTAL & SENSIBLE CAPACITY MULTIPLIER	HEAT REJECTION MULTIPLIER	POWER INPUT (WATTS)
	0.915	0.940	20,400
	0.959	0.968	19,900
	1.000	1.000	19,400
-	1.031	1.022	18,800
_	1.059	1.041	18,200

HEATING

In accordance with ARI 240-67: Heating Capacity: 170,000 BTUH* Power Input: 16,400 Watts *Based on 7000 CFM of 70°F Entering Air 26.6 GPM of 60°F Entering Water Unit C.O.P. 3.04 VARIATION OF ENTERING WATER TEMPERATURES & FLOW RATE



	HEATING CAPACITY (STUH)	HEAT OF ABSORPTION (HUTB)	POWER INPUT (WATTS)	
	238,000	172,000	21,000	
	222,000	158,000	20,000	
	208,000	147,000	19,000	
	196,000	136,000_	18,200	
_	185,000	126,000	17,400	

VARIATION OF ENTERING AIR TEMPERATURES ON HEATING MODE

ENTERING AIR (°F)	60	65	70	75	80
HEATING CAPACITY MULTIPLIER	1.06	1.03	1.000	0.975	0.960
HEAT OF ABSORPTION MULTIPLIER	1.08	1.04	1.000	0.985	0.970
POWER INPUT MULTIPLIER	0.98	0.99	1.000	1.030	1.060

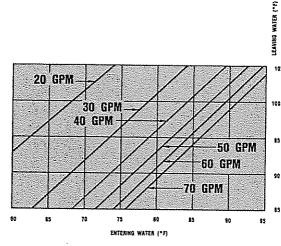
ENGINEERING DATA

COOLING

In accordance with
ARI 240-67:
Cooling Capacity
240,000 BTUH*
Power Input 24,800 Watts
Unit E.E.R. 9.8
*Basic capacities with
8400 CFM of
32.4 GPM of Water
entering at 75°F
leaving at 95°F

	BASEI	ON 840	O CFM &	95°F LEA	VING WA	TER		
ENTERING AIR (°F)	TOTAL CAPACITY		SENSIBLE CAPACITY (BTUH) for Entering air °f dry bulb					
WET BULB	(BTUH)	7 5	80	85	90	95	REJECTION (BTUH)	
61	216,000	188,000	209,600				295,000	
64	228,000	173,000	198,400	223,400			310,000	
67	240,000	156,000	182,000	209,000	*******		324,000	
70	250,000		165,000	190,000	215,000		338,000	
73	260,000	*****		169,000	195,000	220,000	352,000	
76	368,000				171,600	200,000	366,000	
79	267,000				146,400	177,800	379,000	

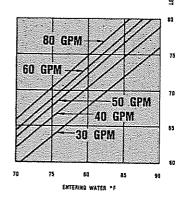
VARIATION OF ENTERING WATER TEMPERATURE AND FLOW RATE MULTIPLIER



	TOTAL & SENSIBLE CAPACITY MULTIPLIER	SENSIBLE REJECTION			
. —	0.920	0.940	26,400		
_	0.970	0.975	25,500		
_	1.000	1.000	24,800		
•••	1.028	1.024	24,200		
	1.052	1.043	23,800		

HEATING

In accordance with ARI 240-67: Heating Capacity 204,000 BTUH* Power Input 19,400 Watts "Based on 8400 CFM of 70°F Entering Air 32.4 GPM of 60°F Entering Water Unit C.O.P. 3.08 VARIATION OF ENTERING WATER TEMPERATURES & FLOW RATE



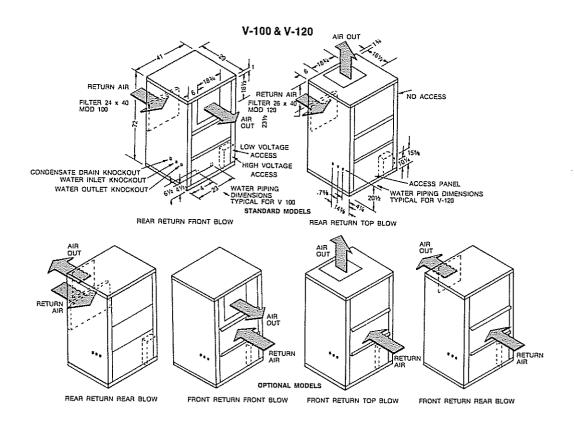
WATER .

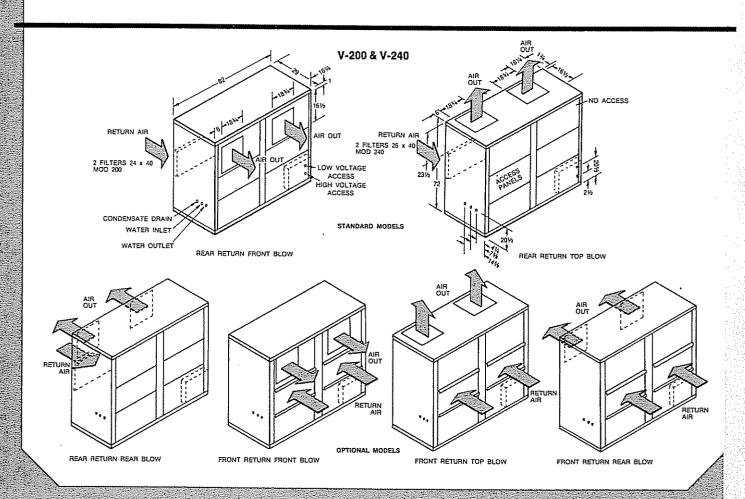
HEATING CAPACITY (BTUH)	HEAT OF ABSORPTION (BTUH)	POWER INPUT (WATTS)
292,000	228,000	24,800
272,000	204,000	24,000
254,000	186,000	23,100
238,000	172,000	22,100
224,000	160,000	21,000
	292,000 272,000 254,000 238,000	292,000 228,000 272,000 204,000 254,000 186,000 238,000 172,000

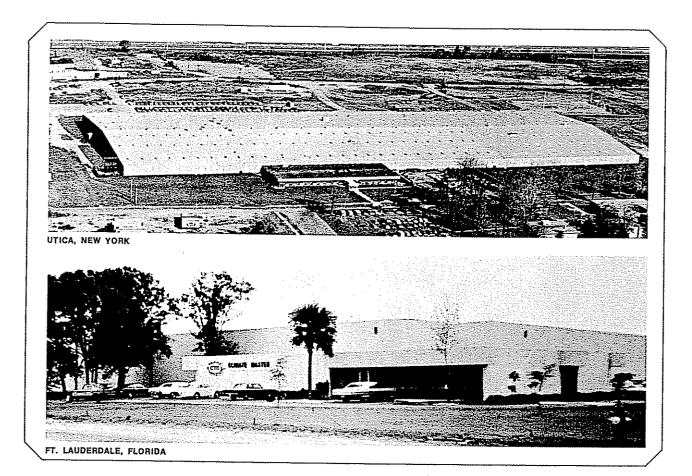
VARIATION OF ENTERING AIR TEMPERATURES ON HEATING MODE

ENTERING AIR (°F)	60	65	70 .	75	80
HEATING CAPACITY MULTIPLIER	1.06	1.03	1,000	0.975	0.960
HEAT OF ABSORPTION MULTIPLIER	1.08	1.04	1.000	0.985	0.970
POWER INPUT MULTIPLIER	0.98	0.99	1.000	1.030	1.060

DIMENSIONAL DATA







EXPERIENCE & SALES LEADERSHIP IN WATER-TO-AIR COOLING AND HEATING.

Climate Master incorporates the latest techniques in tooling, metal working, metal preparation, automatic electrostatic painting and oven drying producing maximum durability and finish of all metal components and cabinetry.

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Modern assembly line production means uniformity of product and quality control assuring that each unit receives an electrical component check, pressure test, weighted charge, and has been operated through all its cycles before packaging for shipment.

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