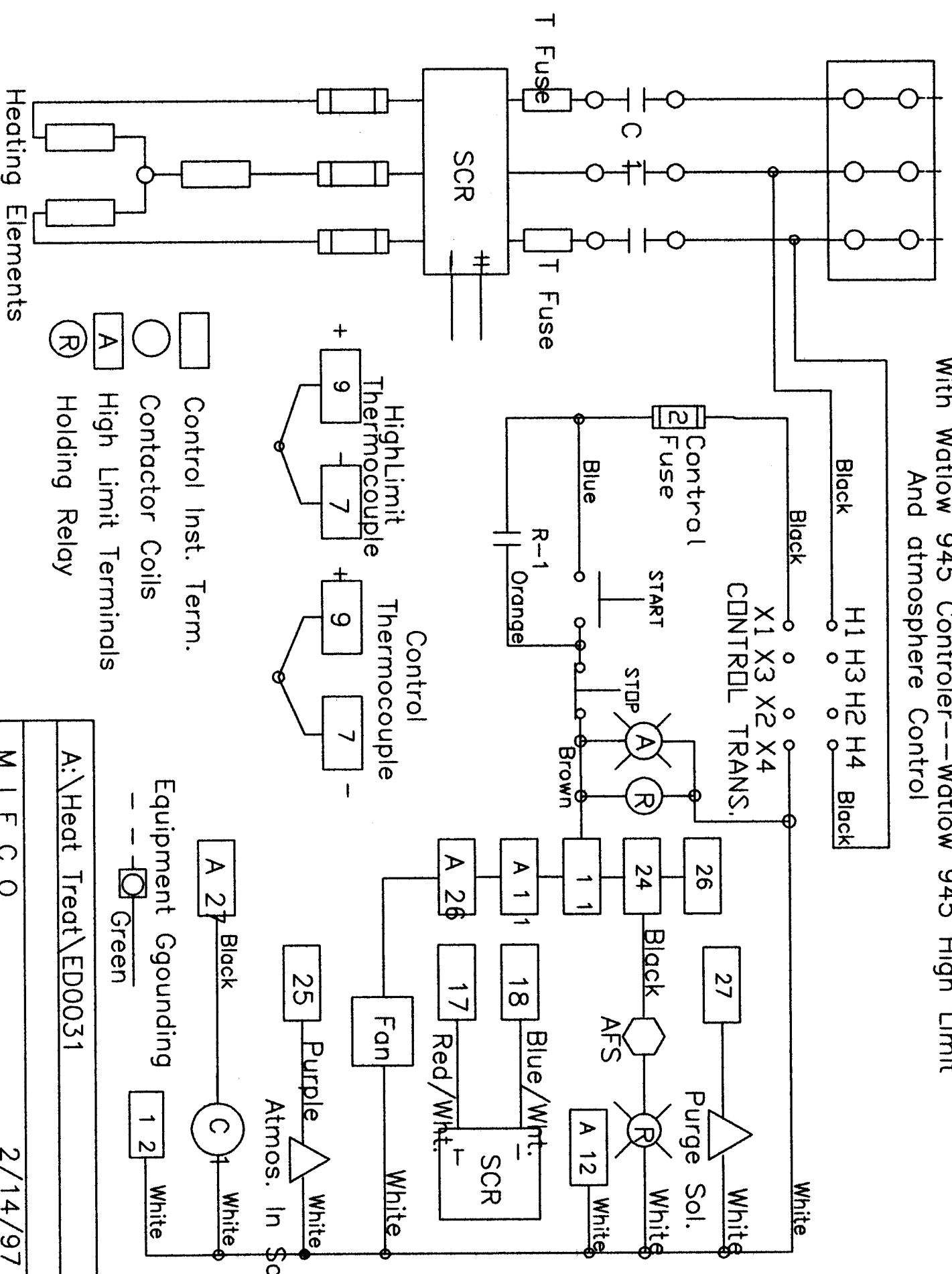


230/460 V--- 3 Ph.---60 Hz.

HTE 812 1 / HTE 1214 1
 With Watlow 945 Controller---Watlow 945 High Limit
 And atmosphere Control



Black H1 H3 H2 H4 Black

X1 X3 X2 X4
 CTRL. TRANS.

Control
 Fuse

Blue
 START
 STOP
 Brown

R-1
 Orange

High Limit Thermocouple
 Control Thermocouple

9 7 9 7

- Control Inst. Term.
- Contactor Coils
- High Limit Terminals
- Holding Relay

Equipment Grounding
 Green

A 27 Black
 C 1 White
 1 2 White

26 27 24 1 1 18 17
 Black Black AFS Purge Sol. White
 Fan White
 Atmos. In So.
 SCR
 Blue/Wht. Red/Wht.

A:\Heat Treat\ED0031

M I F C O

2/14/97