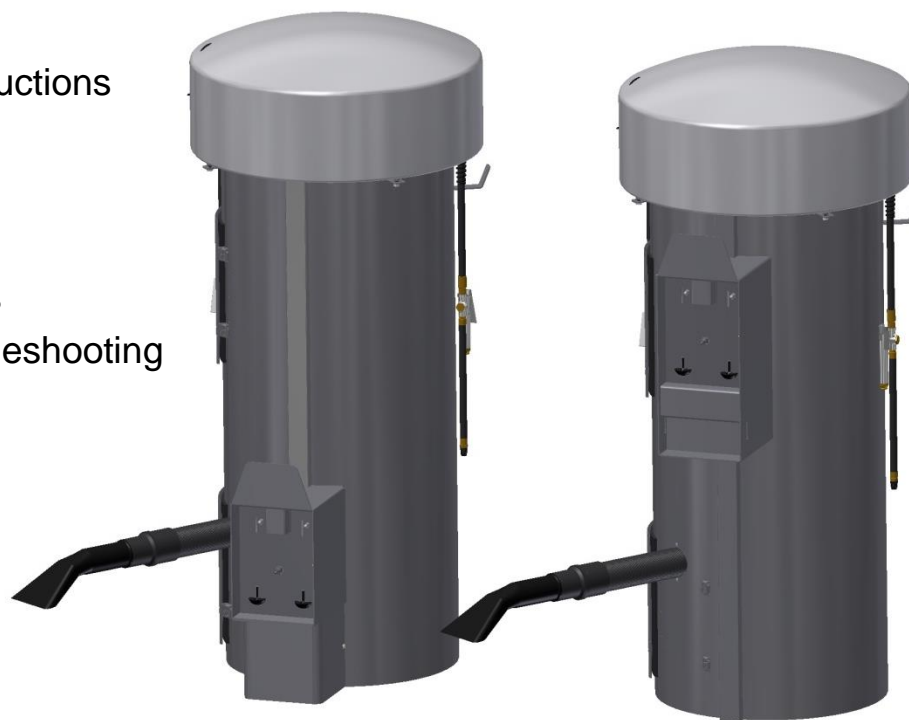




Models - 8648 Series Air/ Water/ Vacs

Page 2	Product Information
Page 3	Specifications
Page 4	Important Safety Instructions
Page 5-6	Product Dimensions
Page 7-10	Installation
Page 10-11	Programming
Page 12	Operating Instructions
Page 12-13	Maintenance & Troubleshooting
Page 14-17	Parts List
Page 18-19	Wiring Diagram



PRODUCT INFORMATION

Please take a moment to fill out the information below in order to aid us with any future sales or service inquiries. Model number and serial number information can be found on the serial tag located inside the control box and/or on the lower exterior of the can. Key number can be found on the tag that comes attached to the keys. There may be more than one key number depending on unit.

Please keep this information with your records.

MODEL#: _____

SERIAL#: _____

KEY NUMBER(S): _____

DATE PURCHASED: _____

DISTRIBUTOR: _____

**J.E. Adams Industries
1025 63rd Ave. S.W.
Cedar Rapids, IA 52404
1-800-553-8861
www.jeadams.com**

Specifications

Unit specifications: Gast twin cylinder compressor models

Voltage: 120VAC, 60Hz

Amperage: (1) 15 amp & (1) 20 amp dedicated service are required for this unit (both air and vac may run/vend at the same time)

Weight: 180-190 lbs with pallet

Vac Motor: (2) 120VAC vacuum motor

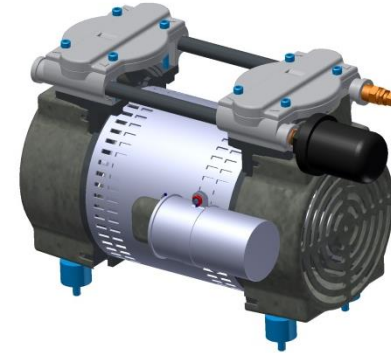
Fuses: (2) 10 amp inline fuses (vac motors)

Compressor: Gast 3/4 HP, 120VAC, 60HZ

Solenoid 120V, 60hz, .05amps

NOTES: Solenoid to be used with city water pressure only!

Not intended for human consumption!!



Gast compressor

Duty cycle time 4 minutes on, 4 minutes off.

NOTE: "UNIT INTENDED FOR COMMERCIAL USE ONLY"

IMPORTANT SAFETY INSTRUCTIONS

When using an electrical appliance, basic precautions should always be followed, including the following:

READ ALL INSTRUCTIONS BEFORE USING (THIS APPLIANCE)

WARNING – To reduce the risk of fire, electric shock, or injury:

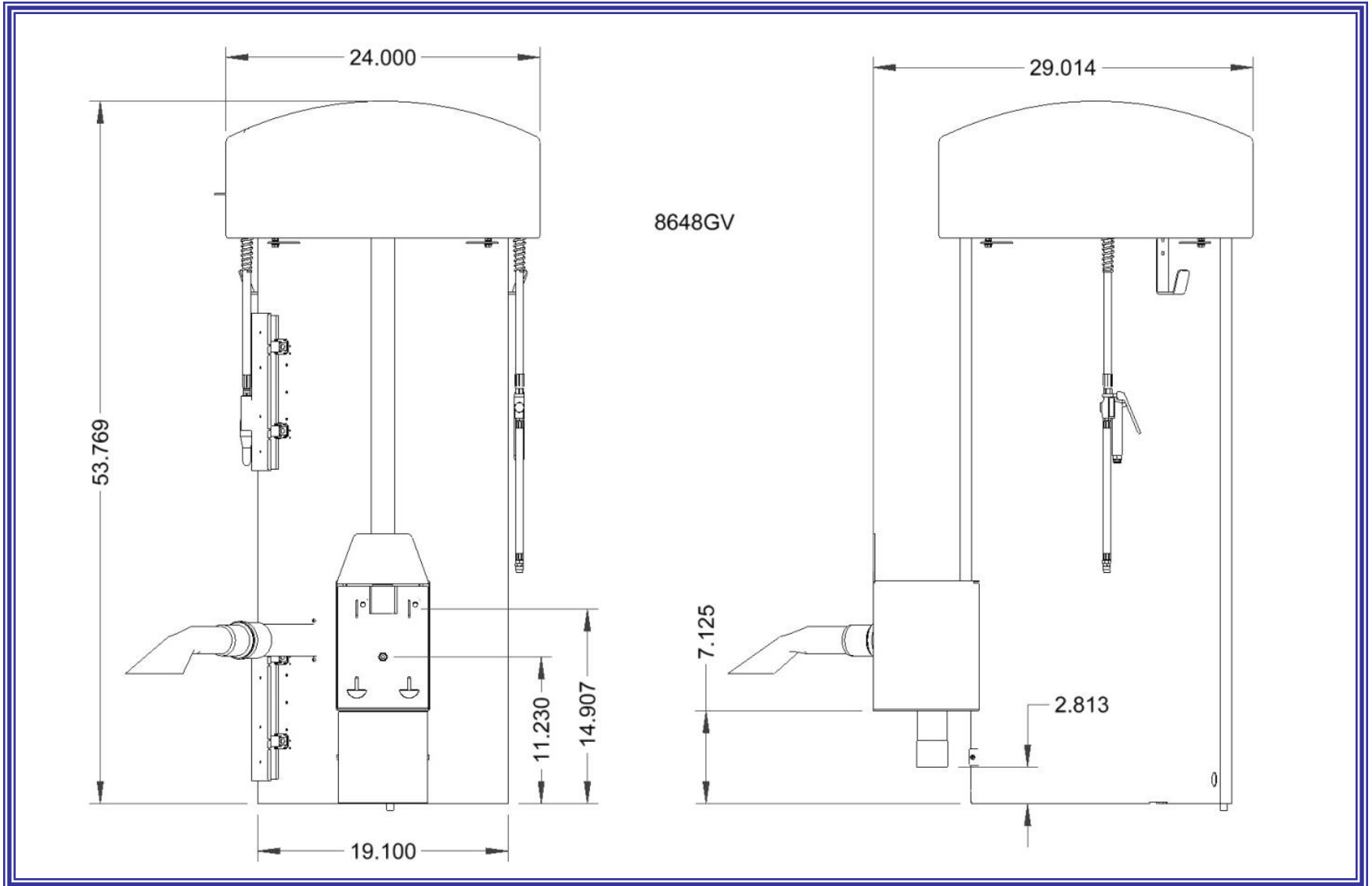
- Do not use on wet surfaces.
- Use only as described in manual. Use only manufactures recommended attachments.
- Do not allow to be used as a toy. Close attention is necessary when used by or near children.
- Do not put any object into openings. Do not use with any opening blocked; keep free of dust, lint, hair and anything that may reduce air flow.
- Keep hair, loose clothing, fingers, and all parts of body away from openings and moving parts.
- Do not use to pick up flammable or combustible liquids, such as gasoline, or use in areas where they may be present.
- Do not pick up anything that is burning or smoking, such as cigarettes, matches, or hot ashes.
- Do not use without dust bag and/or filters in place.



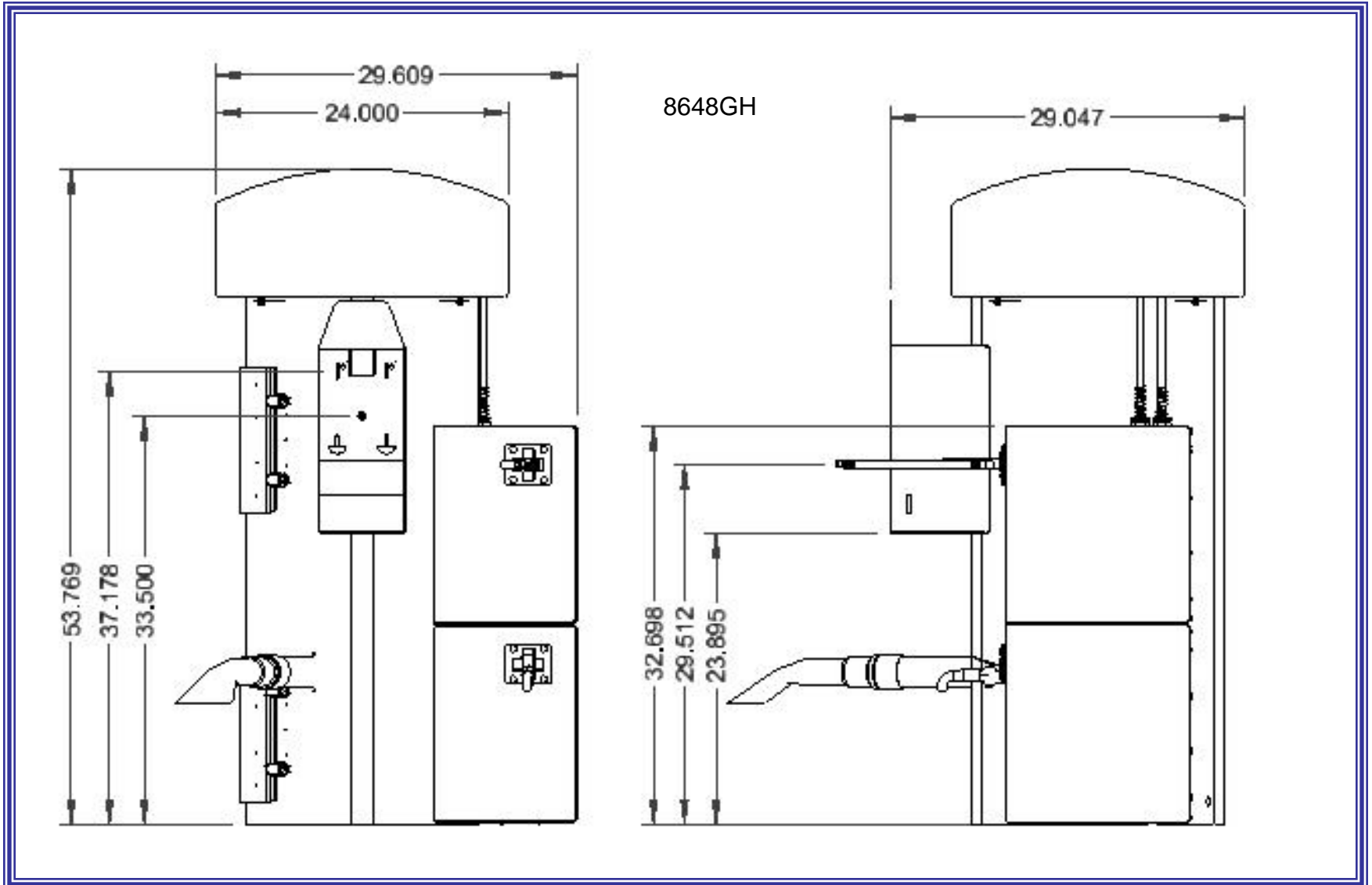
SAVE THESE INSTRUCTIONS

- **Installation Instructions:**
- Determine location to mount unit (“**DANGER**” “**THIS EQUIPMENT INCORPORATES PARTS SUCH AS SWITCHES, MOTORS, OR THE LIKE THAT TEND TO PRODUCE ARCS OR SPARKS THAT CAN CAUSE AN EXPLOSION. WHEN LOCATED IN GASOLINE-DISPENSING AND SERVICE STATIONS INSTALL AND USE AT LEAST 20 FEET (6 M) HORIZONTALLY FROM THE EXTERIOR ENCLOSURE OF ANY DISPENSING PUMP AND AT LEAST 18 INCHES (450 MM) ABOVE A DRIVEWAY OR GROUND LEVEL.**”
- Run electrical service to that location
- **Grounding Instructions:** This appliance must be connected to a grounded metal, permanent wiring system; or an equipment-grounding conductor must be run with the circuit conductors and connected to the equipment-grounding terminal or lead on the appliance.
- **Circuit must be protected by a GFCI device.**
- All local and national electric codes must be followed for installation and use.
- Licensed electricians are recommended for installation.

Product Dimensions

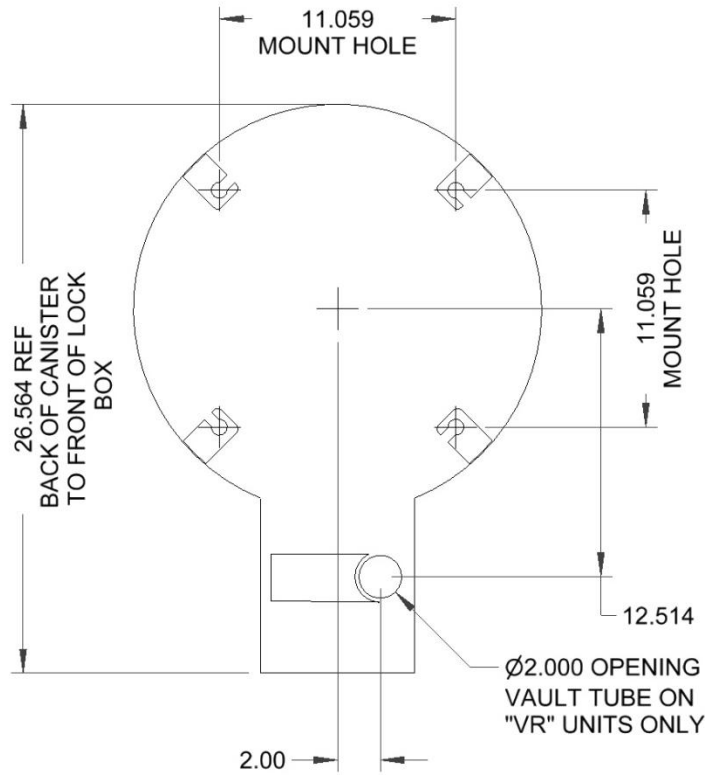


Product Dimensions

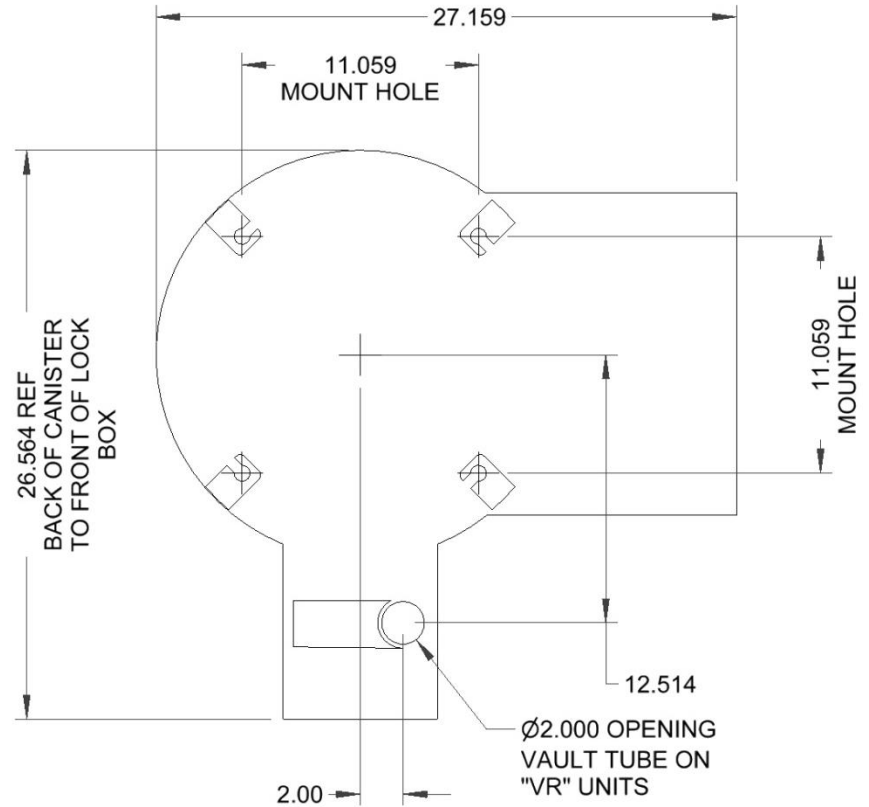


Installation:

PLAN VIEW



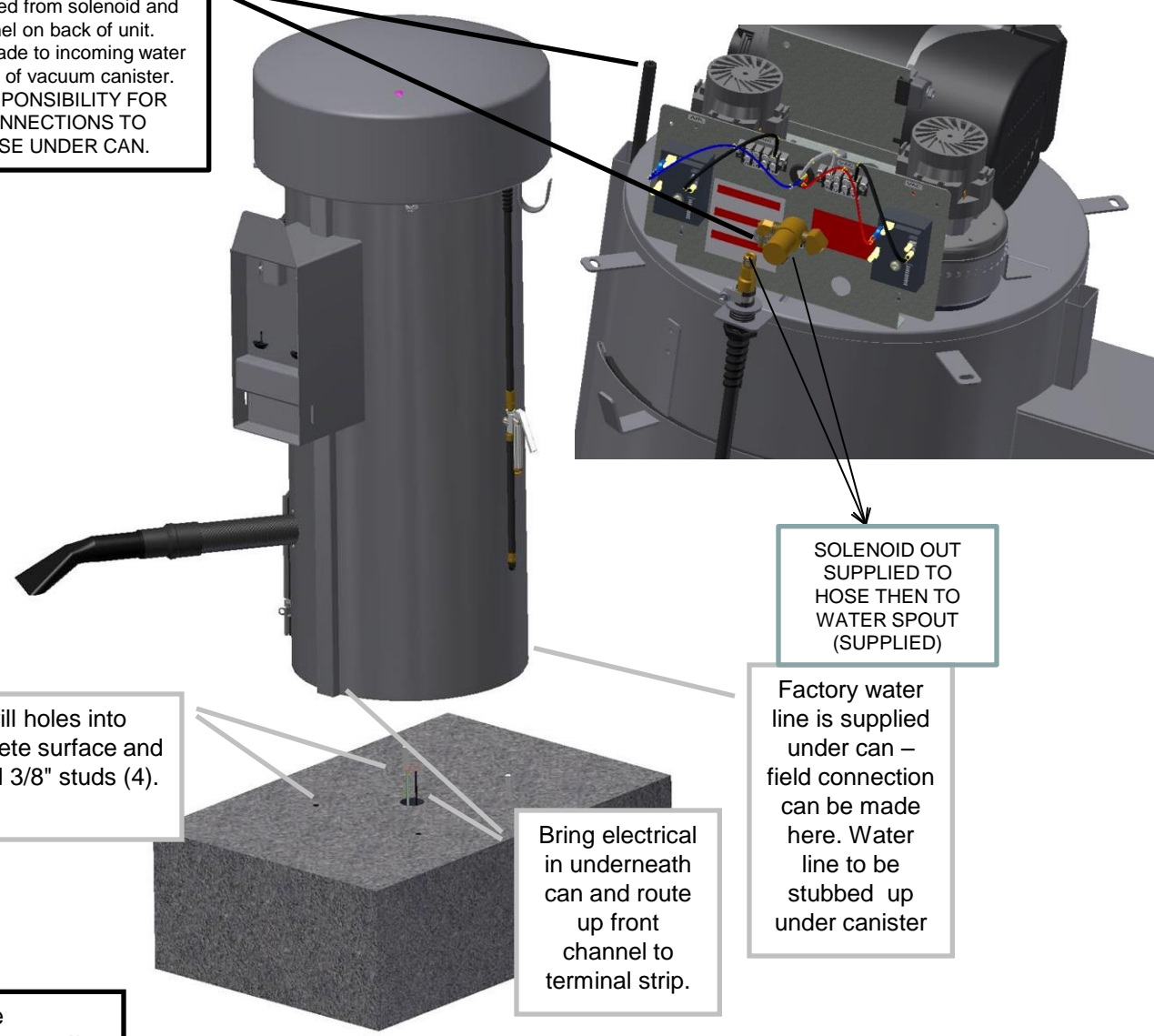
PLAN VIEW



NOTE: when mounting, provide clearance so cleanout doors can open!!

Installation:

Water line is supplied from solenoid and down rear channel on back of unit. Connection to be made to incoming water source underneath of vacuum canister. CUSTOMER RESPONSIBILITY FOR INCOMING CONNECTIONS TO PROVIDED HOSE UNDER CAN.



SOLENOID OUT SUPPLIED TO HOSE THEN TO WATER SPOUT (SUPPLIED)

Factory water line is supplied under can – field connection can be made here. Water line to be stubbed up under canister

Drill holes into concrete surface and install 3/8" studs (4).

Bring electrical in underneath can and route up front channel to terminal strip.

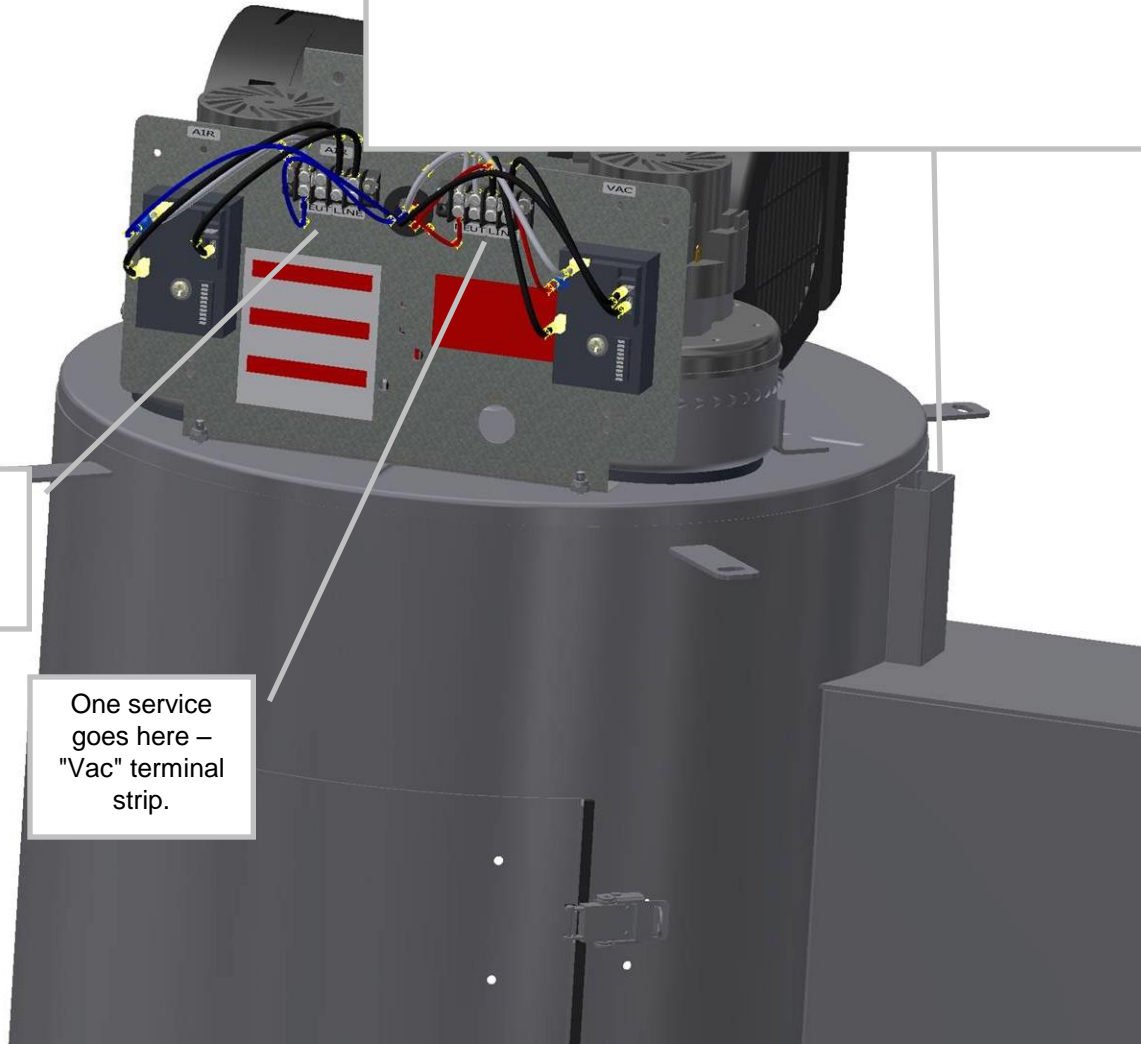
NOTE: when mounting, provide clearance so cleanout doors can open!!

Wiring – Coin Operated (dual electrical service)

Bring each electrical line up through this channel and join to terminal strip.

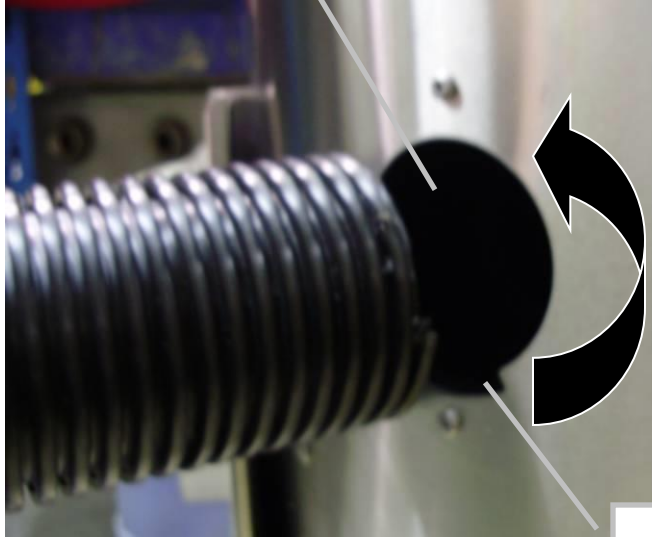
One service goes here –
"Air" terminal strip.

One service goes here –
"Vac" terminal strip.

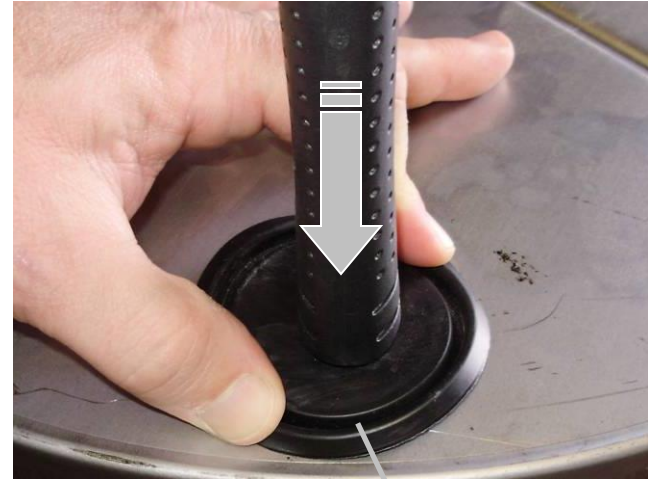


Once unit has been installed use 5871B8 cap plugs (supplied with unit) to seal holes in canister bottom located in lower cleanout door. Extra cap plugs are included with the unit in case plug becomes damaged during shipping removal.

To attach hose, thread into metal hole counter clockwise.



Edge of hose will need to start here.



To insert 5871B8 cap plugs into bottom holes, pinch cap plug into place using index finger and thumb. With edges of plug resting against edges of hole, firmly push down on plug with end of hammer or other blunt object until plug snaps into place.

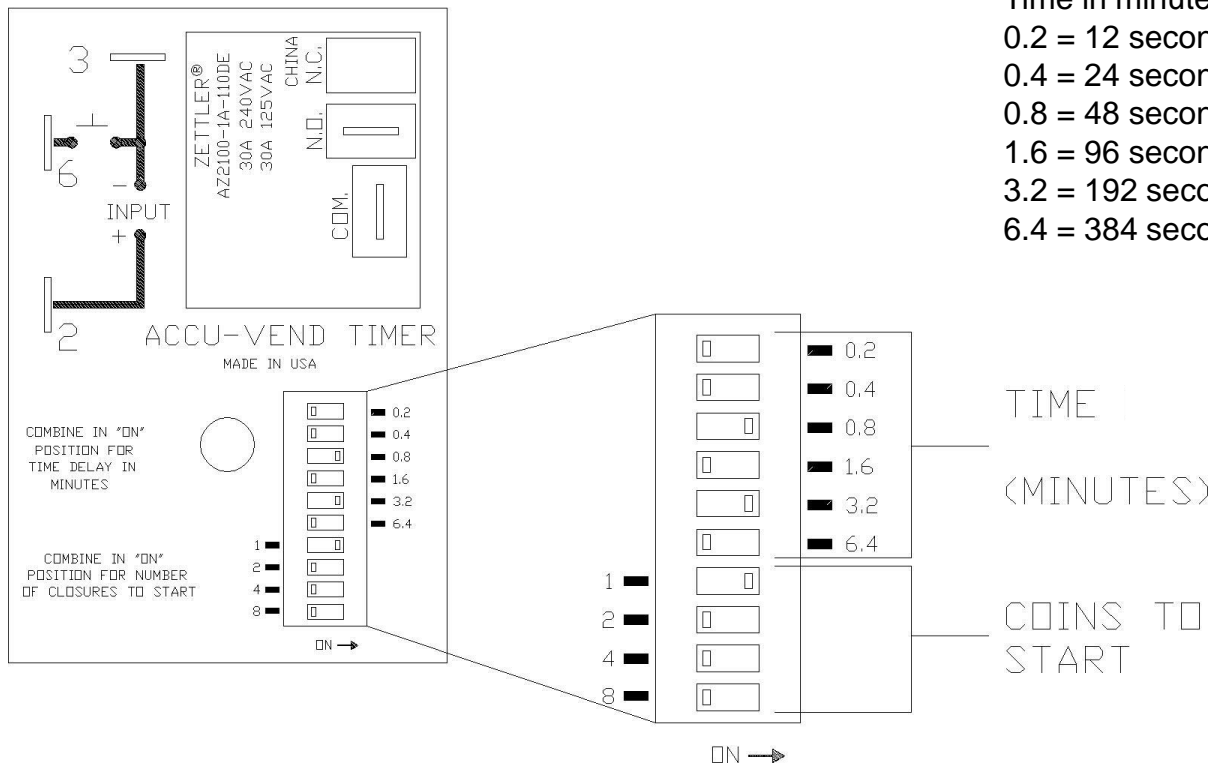
Programming Instructions:

Coin acceptor:

No programming to acceptor needed if unit was purchased with the standard Imonex Z3 acceptor (8149 JEA part number) as it is built accept US quarters. If different acceptor was purchased, see additional literature sent along with unit for programming info.

Programming:

The below timer pictured is the standard SSAC model that allows the end user to select the "coins to start" and the "total time" by settings series of dip switches. The number of "coins to start" dip switch is how many quarters are needed to make the machine come on. In the below example, the "one coin" dip is selected which makes the unit come on with one coin. The "total time" will then need to be set, but a good rule of thumb would be 4 minutes which requires dip switches 3.2 and .8 to be set to on. This scenario means 1 quarter will provide 4 minutes of vacuum time. The total time can always be changed by adding or subtracting time. If the operator would later decide to increase the cost of the unit to "2" quarters, the 2 dip switch would need to be in the on position (all others off) and the time dip switches would still be 3.2 and .8 dips selected for 4 minutes. Timer is non accumulating so "coins to start" setting is just to make the machine come on and "time" is total time regardless of coins to start.



Time in minutes dip switch settings:

0.2 = 12 seconds

0.4 = 24 seconds

0.8 = 48 seconds

1.6 = 96 seconds

3.2 = 192 seconds

6.4 = 384 seconds

Operating Instructions:

- Insert payment (coins) to start vacuum or air compressor.
- Once service is used, hang up hose.

Maintenance:

- **All servicing of machine should be conducted by an authorized service representative!**
- Filter bags should be accessed and shaken down weekly. It is recommended to keep a new set of bags on hand so that once every few months the bags can be replaced and then laundered.
- To maintain performance, empty dirt bin from the canister on a regular basis.
- Periodically inspect wires and connections for wear or fatigue.
- Check door and motor gaskets periodically for signs of wear or damage and replace as needed.
- Check vac hose, air hose, air chuck, and water spout for cracks or damage on a weekly basis.
- Air filter on compressor should be cleaned or replaced every 3 months under normal use.
- Clean canister with a stainless steel cleaner as needed. Decals can be cleaned with mild soap and water.
- Check motor brushes every month for excessive wear. Motor brushes should be changed immediately if they are shorter than $\frac{1}{4}$ ". **Please disconnect power before doing this!**



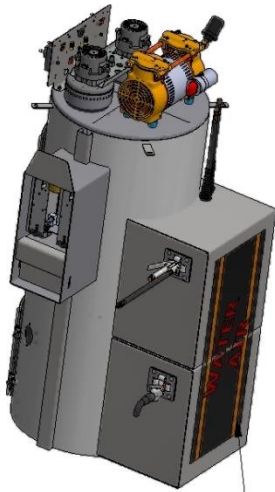
DISCONNECT POWER BEFORE SERVICING OR TROUBLESHOOTING!



Troubleshooting:

Problem	Possible cause	Solution
Unit is not powered.	Breaker inside unit is not in the on position.	Flip breaker on.
	No power to machine.	Check incoming power.
	Loose connection.	Check incoming power connection.
Machine is behaving erratically.	Is the incoming power at 120V?	Check voltage and monitor while machine runs. Low voltage can cause erratic behavior.
	Are any of the machines wires worn through or connections not making contact?	Inspect wiring and connections. Look for sharp bends in wires and places where wire is against the metal chassis.

Unit keeps tripping breaker.	Inadequate wire size ran to machine.	Call electrician and install proper wire size for 20amp service versus length or run.
	Wrong size breaker.	Install correct breaker (only if wire size is adequate to handle 20 amp breaker).
Fuses for vac motors keep blowing.	Inadequate wire size ran to machine.	Call electrician and install proper wire size for 20amp service versus length or run.
	Motor brushes may be bad or too short.	Replace motor brushes.
Lack of vacuum suction.	Vac hose clogged?	Clean debris from vac hose.
	Filter bags need cleaned or dirt chamber needs emptied?	Shake or clean filter bags or replace and empty lower dirt chamber.
	Vac hose is split?	Replace/repair vac hose.
	Cleanout door gaskets torn or worn?	Replace gaskets.
	Vac motor gaskets are worn or motor is not tight against.	Inspect/replace gaskets and assure motor is tight against them.
	Lower chamber cap plugs/mounting hole covers have popped out?	Open lower chamber and inspect plugs, order new if needed.
	Cleanout door gaskets torn or worn?	Replace gaskets.
	One of the vac motors is not working?	Check line motor fuse and replace. Replace motor if necessary.
Compressor runs but will not inflate tire.	Air is leaking from unit somewhere.	Turn power off to unit, apply chuck to air source with at least 30lbs of pressure and listen carefully for leaks inside cabinet or air hose. Replace faulty component if leaking.
	If no system leaks, is compressor putting out enough pressure?	If compressor cannot force air into tire, the compressor may have exceeded its life span and need rebuilt (about 1000 hours).
	Chuck washer is worn out?	Replace rubber washer inside chuck with JE Adams PN 8533-3CW.
	Temperature is below freezing and condensation off compressor has froze in air hose.	Remove air hose and chuck and bring into warm area to thaw. Optional air dry systems are available through JE Adams if frequent problem- please call.
Compressor hums, won't start.	Contacts on compressor may be dirty.	Remove protective guard from end of motor and clean contacts.
Water will not shut off.	Water solenoid is powered all the time. Remove power source to test.	If removing power and water still runs, replace solenoid.
Water will not come on.	Confirm there is voltage to solenoid.	If voltage is present, solenoid is bad - replace.



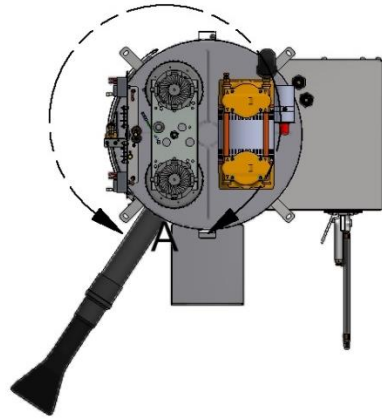
NOTE 1
 BEFORE PALLETING THE 3000 HOSE MUST BE INSTALLED.
 HOSE DOWN THE SERVICE CHANNEL IN THE BACK
 OF MACHINE. ONCE RAN THRU CHANNEL HOSE MUST EXIT
 CUTOT BEHIND SERVICE CHANNEL TO UNDERNEATH CANISTER.
 CUT DECAL IN HALF FOR UPPER AND
 LOWER HOSE REEL HOUSING.

BILL OF MATERIALS				BILL OF MATERIALS			
ITEM	PART NUMBER	DESCRIPTION	QTY	ITEM	PART NUMBER	DESCRIPTION	QTY
41	8153-1	LATCH, CLEANOUT DOOR	4	1	2036	HOSE, 2" X 15' BLACK VACUUM	1
42	8157	NUT, #6-32 KEPP NUT STAINLESS	9	2	2058	CLAW/CUFF ASSEMBLY, 2"	1
43	8159	DOOR GASKET	2	3	3000 (6FT)	1/4" NYLON HIGH PRESSURE HOSE - 6FT	1
44	8183	DECAL, WARNING	3	4	5035D3	DOWEL PIN	8
45	8204RW	COIN BOX, PIN LOCK WELDMENT	1	5	5600D4	3/8-16 X 1.5 HHCS	4
46	8305	ASSEMBLED SS DOME	1	6	5603D1	10 Std NC Nylock Nut	3
47	8426-1	DECAL, AIR WATER, 28 X 11	1	7	5603D11	1/2 Std NF Nylock Nut	1
48	8426-3	DECAL, DOME	1	8	5603D5	1/4 Std NC Nylock Nut	12
49	8429-1	DECAL, HANG HOSE	1	9	5606D22	WASHER, 3/8 FENDER	8
50	8429-17	DECAL, FACEPLATE	1	10	5606D7	FLAT WASHER, .160 ID X .500 OD	1
51	8437D001	DECAL, ETL LISTED	1	11	5609D1	LOCK WASHER, #10 INT TOOTH, ZP	4
52	8533-8	TIRE INFLATOR W/ GAUGE	1	12	5610D1	8x32 x 1/2 SLOT SCREW	4
53	8545-48	AIR HOSE ASSY, 1/4" X 48"	1	13	5611D1	NUT, 8-32 UNC KEPP-ZINC PLATE	2
54	8545-6	AIR HOSE ASSY, 1/4" X 72"	1	14	5611D4	NUT, 5/16-18 UNC KEPP- SS	4
55	8549	FLEX STRAIN RELIEF	2	15	5627D2	6-32 x .63 PD, PH, MS	1
56	8551	SOLENOID BRACKET	1	16	5635D4	BOLT, CARRIAGE, 1/4-20 UNC	8
57	8609SRW	FACEPLATE WELDMENT, DUAL DROP	1	17	5639D1	RUBBER GROMMET	1
58	8615-5W	CLEANOUT DOOR WELDMENT	2	18	5639D6	RUBBER GROMMET	1
59	8630	BOX	1	19	5643D1	SS HOSE CLAMP	1
60	8638	PIN LOCK	2	20	5647D2	1/8" SS POP RIVET	16
61	8646A	TIMER ASSEMBLY, AIR/VAC	1	21	5647D8	3/16" SS POP RIVET	14
62	8647	WATER SPOUT, 1/4" NPT	1	22	5827D1	FITTING, STREET ELBOW, 45 DEG, 1/4 NPT	1
63	8648W1-1RC	WELDMENT, AIR WATER/VAC CANISTER, REEL CRAFT	1	23	5871b8	PLUG, VAC BOTTOM 2-1/2"	8
64	8649	FITTING, 90D, 1/4 HB X 1/4 MNPT, BRASS	1	24	5920	BOOT, TOGGLE SWITCH	1
65	8673-11	GROUND WIRE 28"	1	25	5997	SWITCH, DPDT, 20A@120vac	1
66	8697	SOLENOID, 120/60-KIP-NORGREN	1	26	6025SHR	REEL CRAFT, BASE MOUNT	2
67	8732	NAMEPLATE PRODUCT SPECS	1	27	6027-1	RETAINER, ROLLER	2
68	8754	DECAL, WARNING	1	28	6027-2	COVER, HOSE GUIDE	4
69	8939	PALLET, DUAL, OVAL, SPECIALITY, 30" X 40"	1	29	6027-3	ROLLER, HOSE GUIDE	8
70	9862	COMPRESSOR, 3/4 HP TWIN CYL	1	30	6082	BAG, 9 X 12	1
71	B5722-002	NUT, 3/8-16 UNC HEX LOCK NUT	4	31	8047	BAG, 60 X 72	1
				32	8051G	BRACKET, MOTOR MOUNT	1
				33	8055EM	MOTOR, ELECTRO 120V	2
				34	8057	MOTOR GASKET	2
				35	8076	FILTER BAG	4
				36	8081	CABLE TIE MOUNT	2
				37	8084	CABLE TIE	10
				38	8085	CABLE TIE	4
				39	8108	#10 x 1/2 TAP SCREW	4
				40	8149	IMONEX COIN ACCEPTOR	2

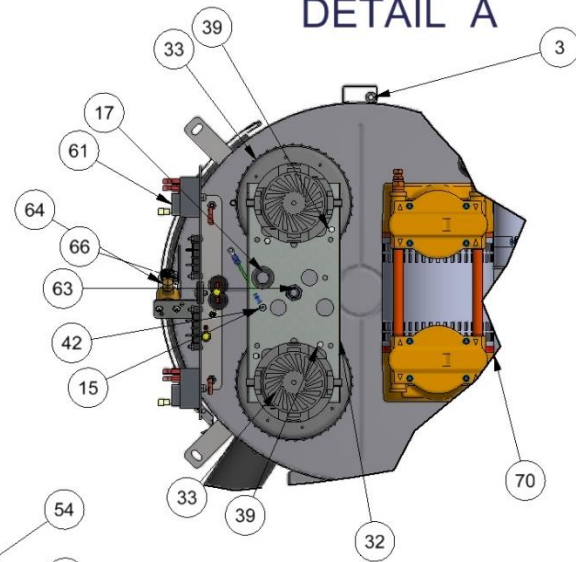
G	8081	REMOVED (1) 8545-6 AND ADDED (1) 8545-48	8-29-17	CAK
F	8046	REMOVED 5608D3 (2); ADDED 5610D1 (4), 5609D1 (4), 5611D1 (2), 8551 (1)		
E	7785	ADDED NOTE 1	6-10-16	CK
D	7733	REMOVED 8826 AND ADDED 5997	4-5-16	CK
C	7666	REMOVE 8427-1, 5639D4, 3054, ADD PARTS AS LISTED	020116	JF
B	7097	REMOVED (2) 6025-7 AND 8648W1-1 AND ADDED (2) 6025SHR & 8648W1-1RC	4-30-13	CK
REV	NO.	DESCRIPTION	DATE	BY

TITLE		AIR-WATER-VAC, 2DR, GAST, HOSE REEL	
UNSPECIFIED TOLERANCES	DRAWN BY		
1 PL ±.030	DATE		
2 PL ±.020	2/16/2012		
3 PL ±.003	SCALE	SHEET	PART NO.
ANGLE ± 1°		1 / 3	8648GH

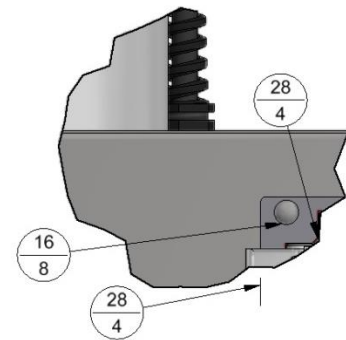
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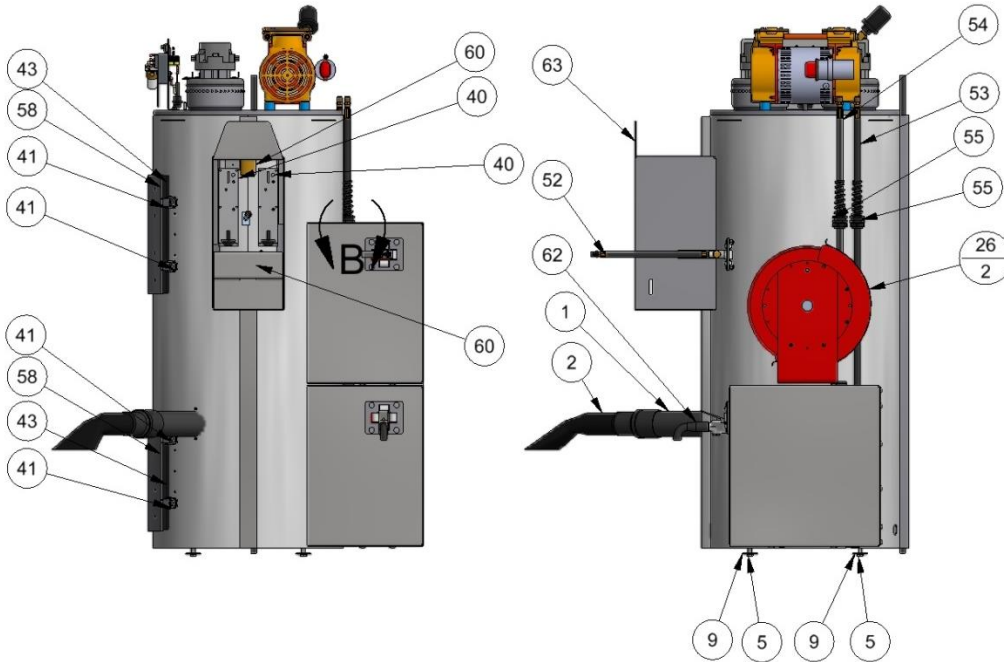
DETAIL A



DETAIL B



SHEET 2 OF 2



TITLE		AIR-WATER-VAC, 2DR, GAST, HOSE REEL		
UNSPECIFIED TOLERANCES	MATERIAL	CEDAR RAPIDS, IOWA		
1 PL ±.030	DRAWN BY			
2 PL ±.020	DATE			2/16/2012
3 PL ±.003	SCALE			SHEET NO
ANGLE ± 1°		PART NO	8648GH	
		REV	G	

REV	NO.	DESCRIPTION	DATE	BY
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39	8157	NUT, #6-32 KEPP NUT STAINLESS	9	1	2036	HOSE, 2" X 15' BLACK VACUUM	1
40	8159	DOOR GASKET	2	2	2058	CLAW/CUFF ASSEMBLY, 2"	1
41	8183	DECAL, WARNING	3	3	3000 (6FT)	1/4" NYLON HIGH PRESSURE HOSE - 6FT	1
42	8305	ASSEMBLED SS DOME	1	4	5600D4	3/8-16 X 1.5 HHCS	4
43	8426-1	DECAL, AIR WATER CANISTER	1	5	5601D4	1/4-20 x 3/4 HHCS-SS	2
44	8426-3	DECAL, DOME	1	6	5603D1	*Varies*	3
45	8427-1	DECAL, VACUUM	1	7	5603D11	1/2 Std NF Nylock Nut	1
46	8429-1	DECAL, HANG HOSE	1	8	5603D2	1/4 Std NC Nylock Nut	2
47	8429-17	DECAL, FACEPLATE	1	9	5603D5	1/4 Std NC Nylock Nut	4
48	8437D001	DECAL, ETL LISTED	1	10	5606D21	WASHER, FLAT, 3/4 SAE, ID 13/16	2
49	8532-25	AIR HOSE ASSY, 1/4" X 25'	2	11	5606D22	WASHER, 3/8 FENDER	8
50	8533-8	TIRE INFLATOR W/ GAUGE	1	12	5606D7	FLAT WASHER, .160 ID X .500 OD	1
51	8549	FLEX STRAIN RELIEF	2	13	5609D1	LOCK WASHER, #10 INT TOOTH, ZP	4
52	8551	SOLENOID BRACKET	1	14	5610D1	8x32 x 1/2 SLOT SCREW	4
53	8605	PALLET, VAC, 26" X 30.5"	1	15	5611D1	NUT, 8-32 UNC KEPP-ZINC PLATE	2
54	8609SRW	FACEPLATE WELDMENT, DUAL DROP	1	16	5627D2	6-32 x .63 PD, PH, MS	1
55	8615-5W	CLEANOUT DOOR WELDMENT	2	17	5639D4	RUBBER GROMMET	1
56	8630	BOX	1	18	5643D1	SS HOSE CLAMP	1
57	8638	PIN LOCK	1	19	5647D2	1/8" SS POP RIVET	16
58	8646A	TIMER ASSEMBLY, AIR/VAC	1	20	5647D8	3/16" SS POP RIVET	14
59	8647	WATER SPOUT, 1/4" NPT	1	21	5684D2	1/2" DIA. HOSE CLAMP	2
60	8648VRW-ADA	WELDMENT, AIR WATER/VAC CANISTER, VR	1	22	5800D6	90 DEG. NPT STREET ELBOW	1
61	8649	FITTING, 90D, 1/4 HB X 1/4 MNPT, BRASS	1	23	5827D1	FITTING, STREET ELBOW, 45 DEG, 1/4 NPT	1
62	8673-11	GROUND WIRE 28"	1	24	5871b8	PLUG, VAC BOTTOM 2-1/2"	8
63	8697	SOLENOID, 120/60-KIP-NORGREN	1	25	5920	BOOT, TOGGLE SWITCH	1
64	8732	NAMEPLATE PRODUCT SPECS	1	26	5997	SWITCH, DPDT, 20A@120vac	1
65	8754	DECAL, WARNING	1	27	6082	BAG, 9 X 12	1
66	9862	110VAC 3/4 TWIN GAST COMPRESSOR	1	28	8047	BAG, 60 X 72	1
67	B5722-002	NUT, 3/8-16 UNC HEX LOCK NUT	4	29	8051G	BRACKET, MOTOR MOUNT	1
				30	8055EM	MOTOR, ELECTRO 120V	2
				31	8057	MOTOR GASKET	2
				32	8076	FILTER BAG	4
				33	8081	CABLE TIE MOUNT	2
				34	8084	CABLE TIE	10
				35	8085	CABLE TIE	4
				36	8108	#10 x 1/2 TAP SCREW	4
				37	8149	IMONEX COIN ACCEPTOR	2
				38	8153-1	LATCH, CLEANOUT DOOR	4

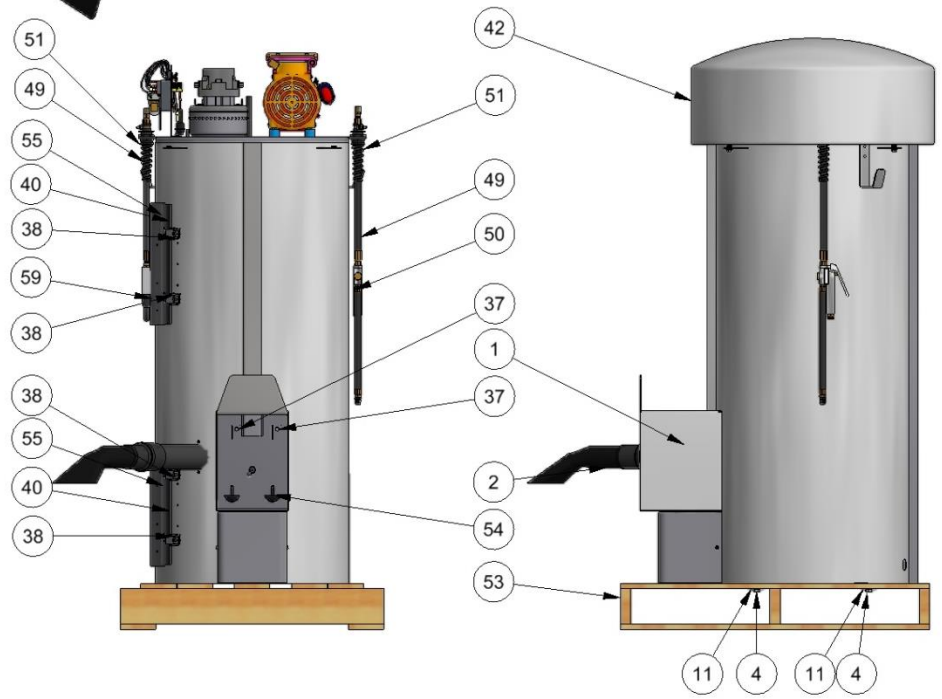
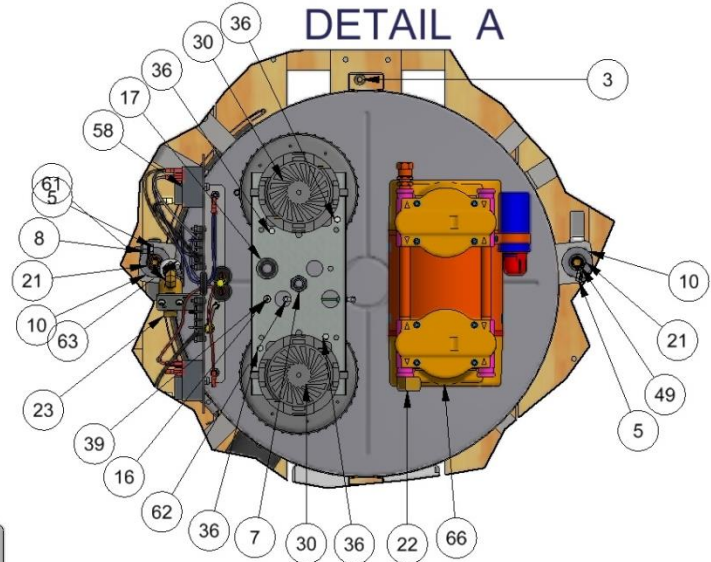
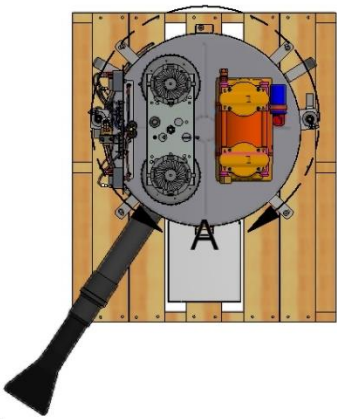


TITLE		AIR-WATER-VAC, 2DR, GAST, ADA VR	
UNSPECIFIED TOLERANCES 1 PL ±.030 2 PL ±.020 3 PL ±.003 ANGLE ±1°	APPROVED	CEDAR RAPIDS, IOWA	
	DRAWN BY	JOHN F	
	DATE	8/10/2016	
	SCALE	SHEET	PART NO. REV.
		1 / 3	8648GV-ADA A

A	8046	REMOVED 5608D3; ADD 5610D1 (4), 5609D1 (4), 5611D1 (2), 8551 (1)	7-18-19	CK
REV	NO.	DESCRIPTION	DATE	BY

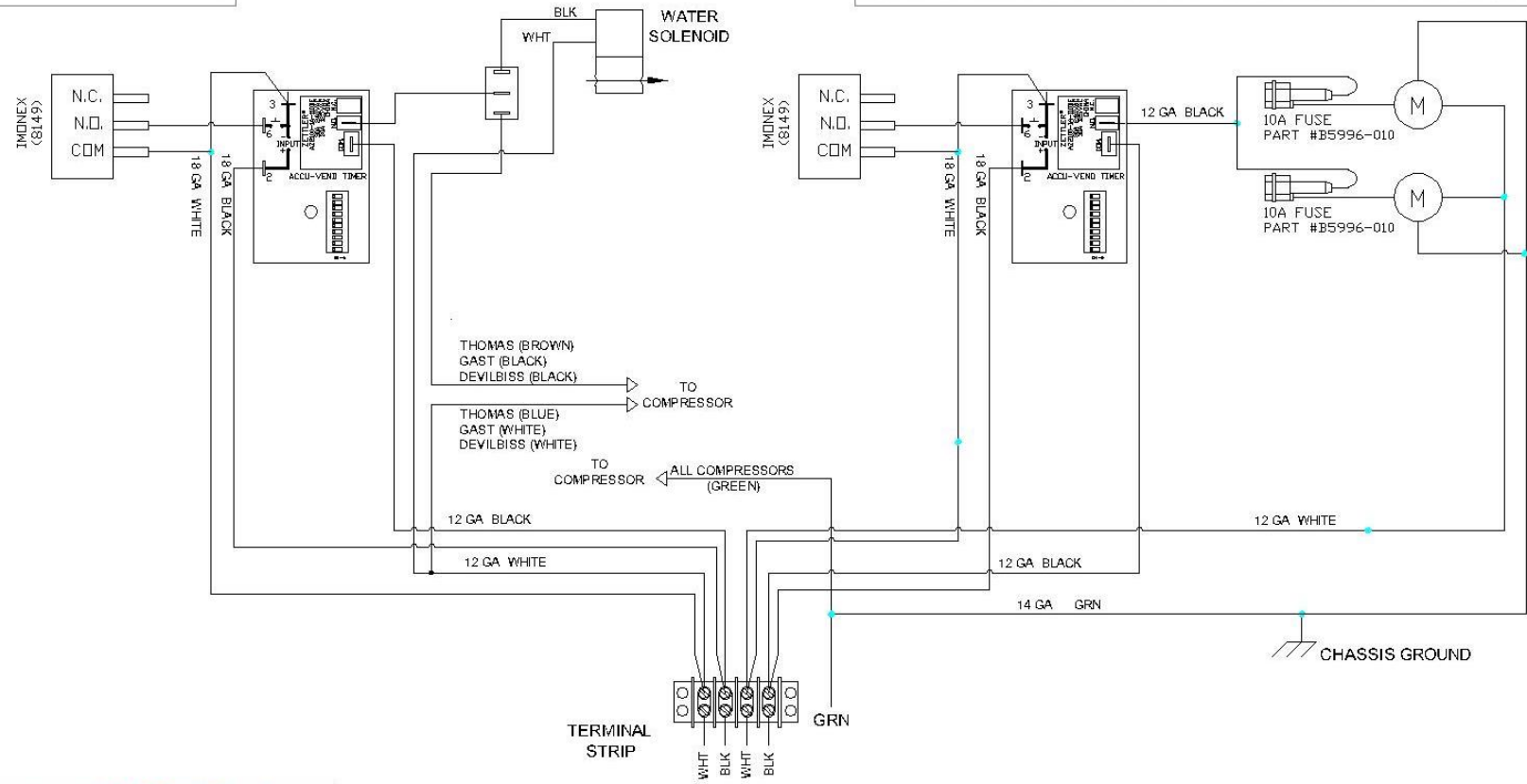
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DETAIL A



REV	NO.	DESCRIPTION	DATE	BY
THIS DOCUMENT SHALL NOT BE REPRODUCED NOR SHALL THE INFORMATION THEREIN BE USED BY OR DISCLOSED TO OTHERS EXCEPT AS AUTHORIZED BY J.E. ADAMS INDUSTRIES				

TITLE		AIR-WATER-VAC, 2DR, GAST, ADA VR		CEDAR RAPIDS, IOWA	
UNSPECIFIED TOLERANCES		MATERIAL			
1 PL ±.030		DRAWN BY JOHN F			
2 PL ±.020		DATE 8/10/2016			
3 PL ±.003		SCALE			
ANGLE ±1°		SHEET 2 / 3		PART NO. 8648GV-ADA REV. A	



!! IMPORTANT !!
*****2 SERVICES REQUIRED*****

A 20AMP SERVICE IS REQUIRED FOR THE VACUUM SIDE

A 10AMP OR 20AMP IS REQUIRED FOR THE AIR SIDE DEPENDING ON COMPRESSOR, (SEE BELOW FOR COMPRESSOR LIST)

FIELD WIRING MUST COMPLY WITH LOCAL AND NATIONAL ELECTRICAL CODES.

3/4HP THOMAS AND GAST 10AMP
 1-1/2HP DEVILBISS 20AMP

TITLE		8648_SSAC_8149_ALL COMPRESSORS	
MATERIAL		CEDAR RAPIDS, IOWA	
UNSPECIFIED TOLERANCES	SCALE	NONE	
1 PL ±.030	DRAWN BY	CK	
2 PL ±.010	DATE	2-17-12	
3 PL ±.003	REL FOR PROD.		
ANGLE ±1.0°	PART NO.	8648 SERIES	
	REV.		

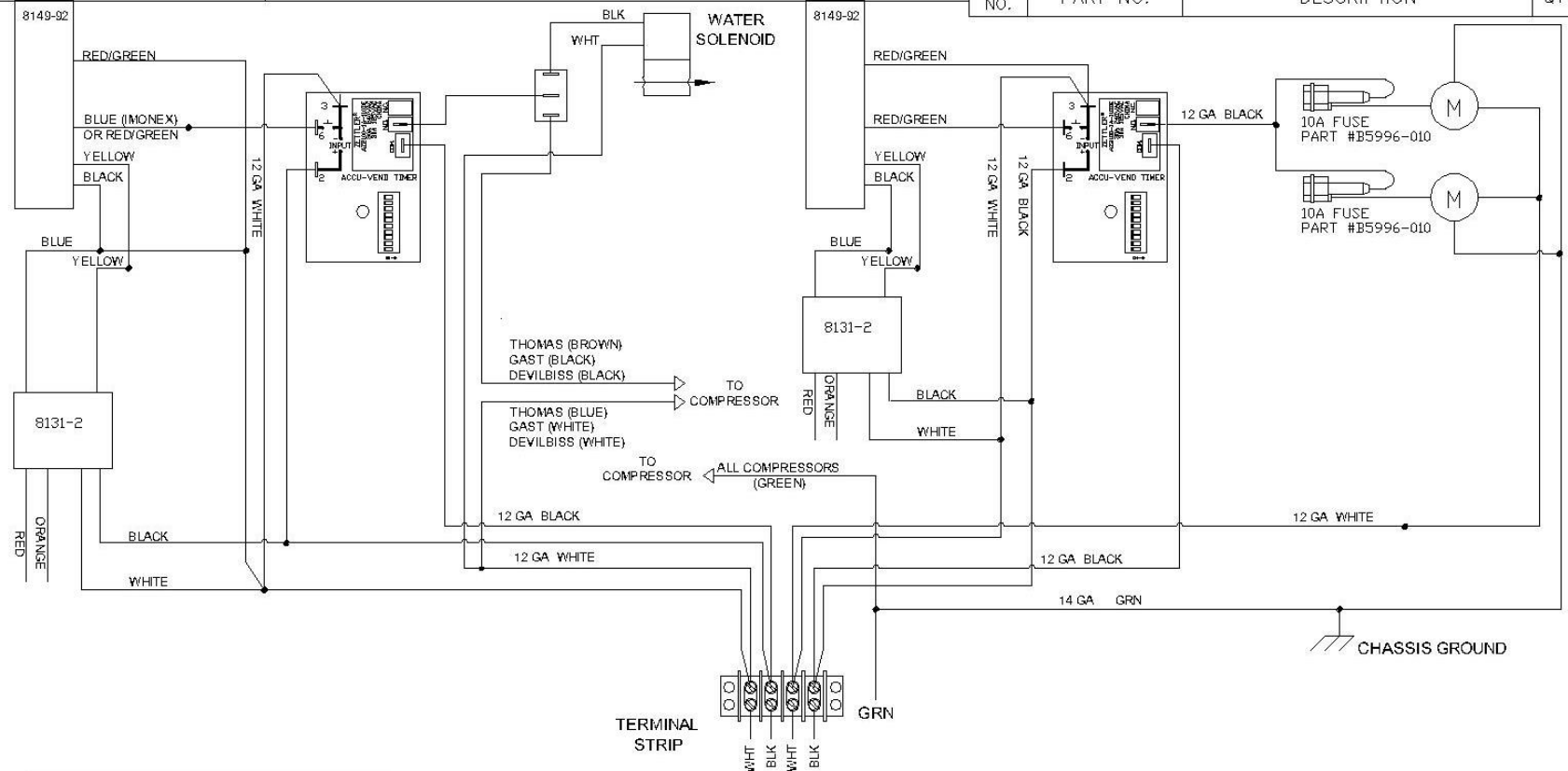
REV	NO.	DESCRIPTION	DATE	BY

PART NO. **8648 SERIES**

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BILL OF MATERIAL

ITEM NO.	PART NO.	DESCRIPTION	QTY.
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!! IMPORTANT !!
*****2 SERVICES REQUIRED*****

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A 10AMP OR 20AMP IS REQUIRED FOR THE AIR SIDE DEPENDING ON COMPRESSOR. (SEE BELOW FOR COMPRESSOR LIST)

FIELD WIRING MUST COMPLY WITH LOCAL AND NATIONAL ELECTRICAL CODES.

3/4HP THOMAS AND GAST 10AMP
 1-1/2HP DEVILBISS 20AMP

TITLE AIR WATER VAC - SSAC- 8149-92_ALL COMPRESSORS		CEDAR RAPIDS, IOWA	
SCALE	CK		REV.
UNSPECIFIED TOLERANCES	CK		
DATE	9-2-11		
FRACT. ± 1/32	REL. FOR PROD.	PART NO. 8648 SERIES	REV.
2 PL ± .020			
3 PL ± .010			
ANGLE ± 1.0°			

REV	NO.	DESCRIPTION	DATE	BY
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