

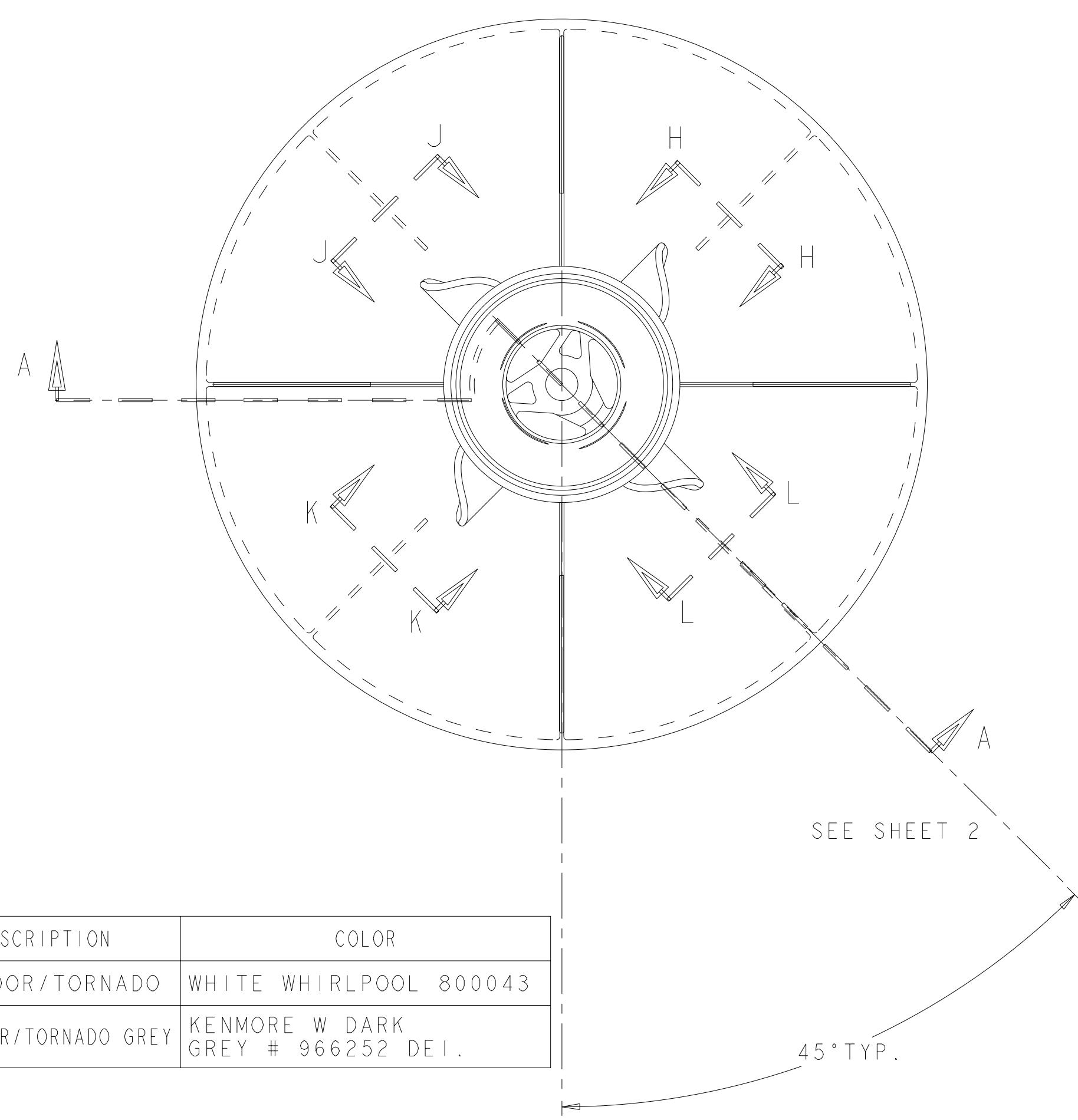
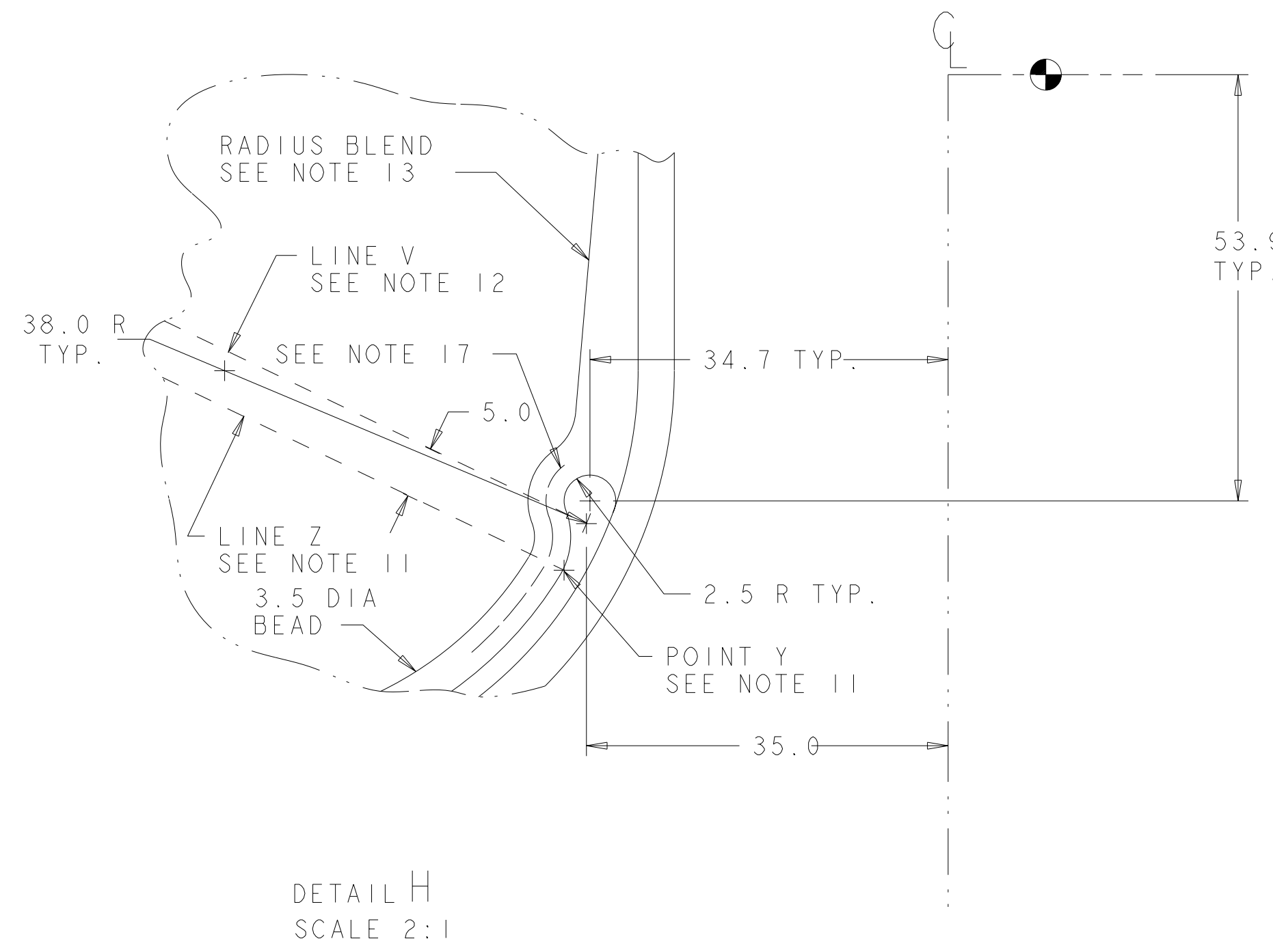
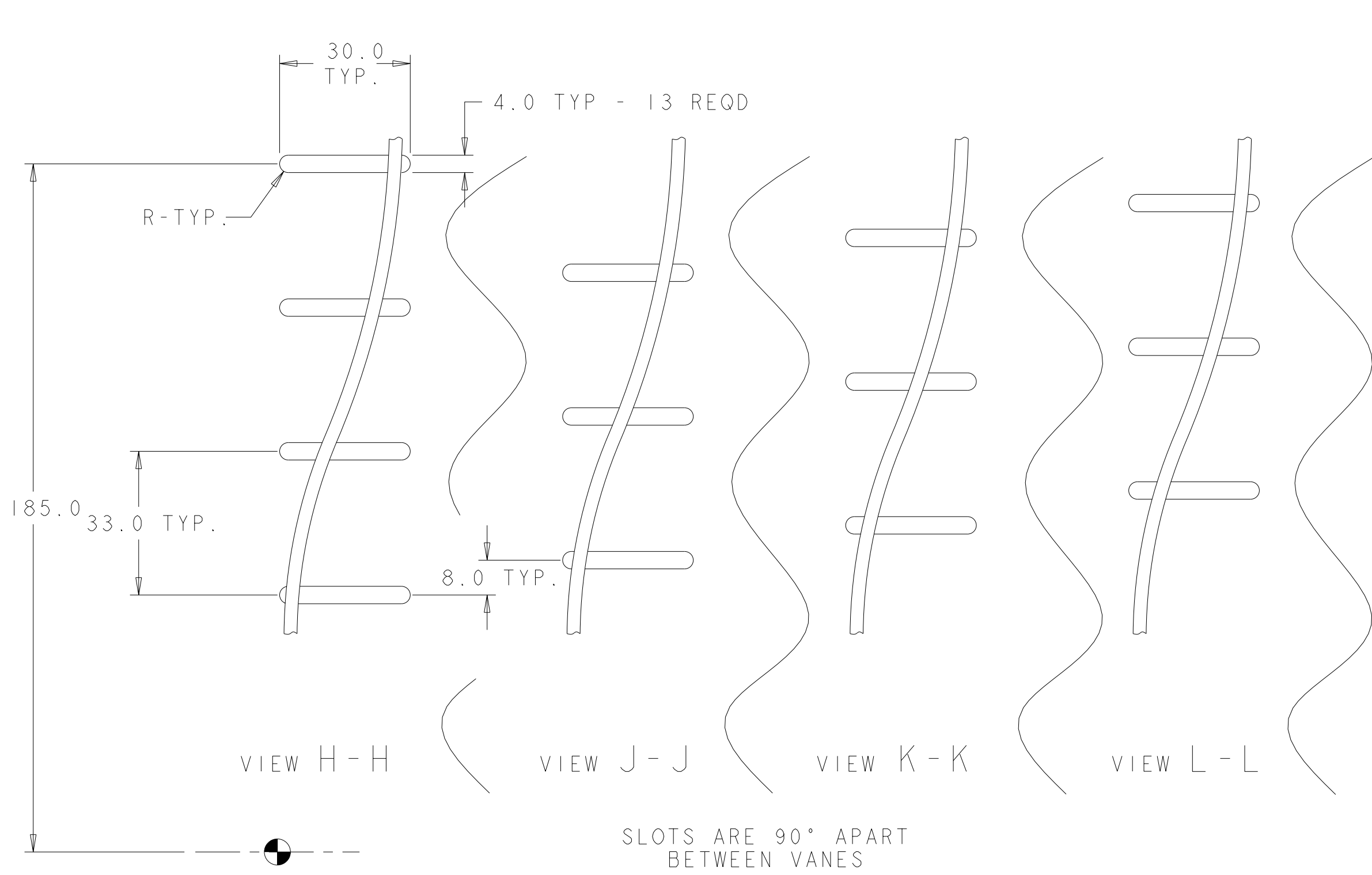
3968192

3

A34

1

REV	CHANGE	LOC	BY	DATE	E.C.N.	CKD
---	RELEASED	---	ONE	27MAY98	306291-B	AB
A	REDIMENSIONED 4 CURVED VANES TO SHOW ACCURATE DIMENSIONS.					
	ADD Ø60.00 REF. (SHEET 2) IN 2 PLCS.	C4				
	ADDED NOTE 19	A5				
	REDRAW SLOTS OF VIEWS "H-H", "J-J" "K-K", "L-L" AND DIMS RELATED	D8				
2	ADD * IN ALL DIMENSIONS RELATED WITH 4 CURVES VANES					
	120.0 * TYP. WAS 120.0 TYP.	A4				
	140.0 * WAS 140.0	A5				
	145.0 * TYP. WAS 145.0 TYP.	A5				
	328.0 DIA * WAS 328.0 DIA	A5				
	ADD PART REVISION CHART	D2				
3	RELEASE P/N 8567851	A8	ABA	26SEP05	464331	AT
4	IN NOTE 14: ADD EXON 1042 OR SCHULMAN PP3487	A5				
	3968192 TO REV. B					
	8567851 TO REV. A	A8				
E	ADDED NOTE 21	1A5	GRT	05DEC07	526503	IGY



PART No.	REV.	DESCRIPTION	COLOR
3968192	C	AGITADOR/TORNADO	WHITE WHIRLPOOL 800043
8567851	B	AGITADOR/TORNADO GREY	KENMORE W DARK GREY # 966252 DEL.

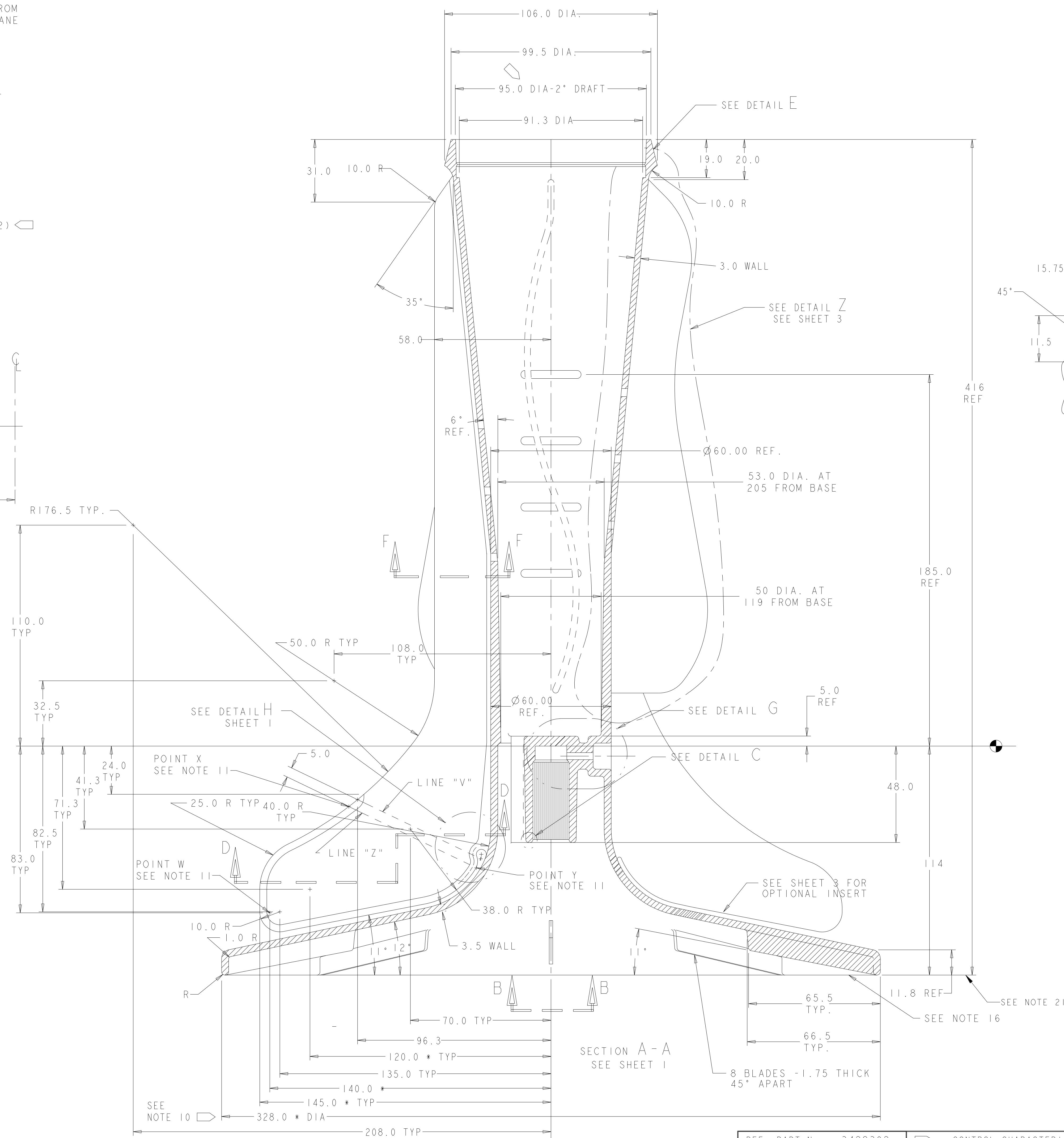
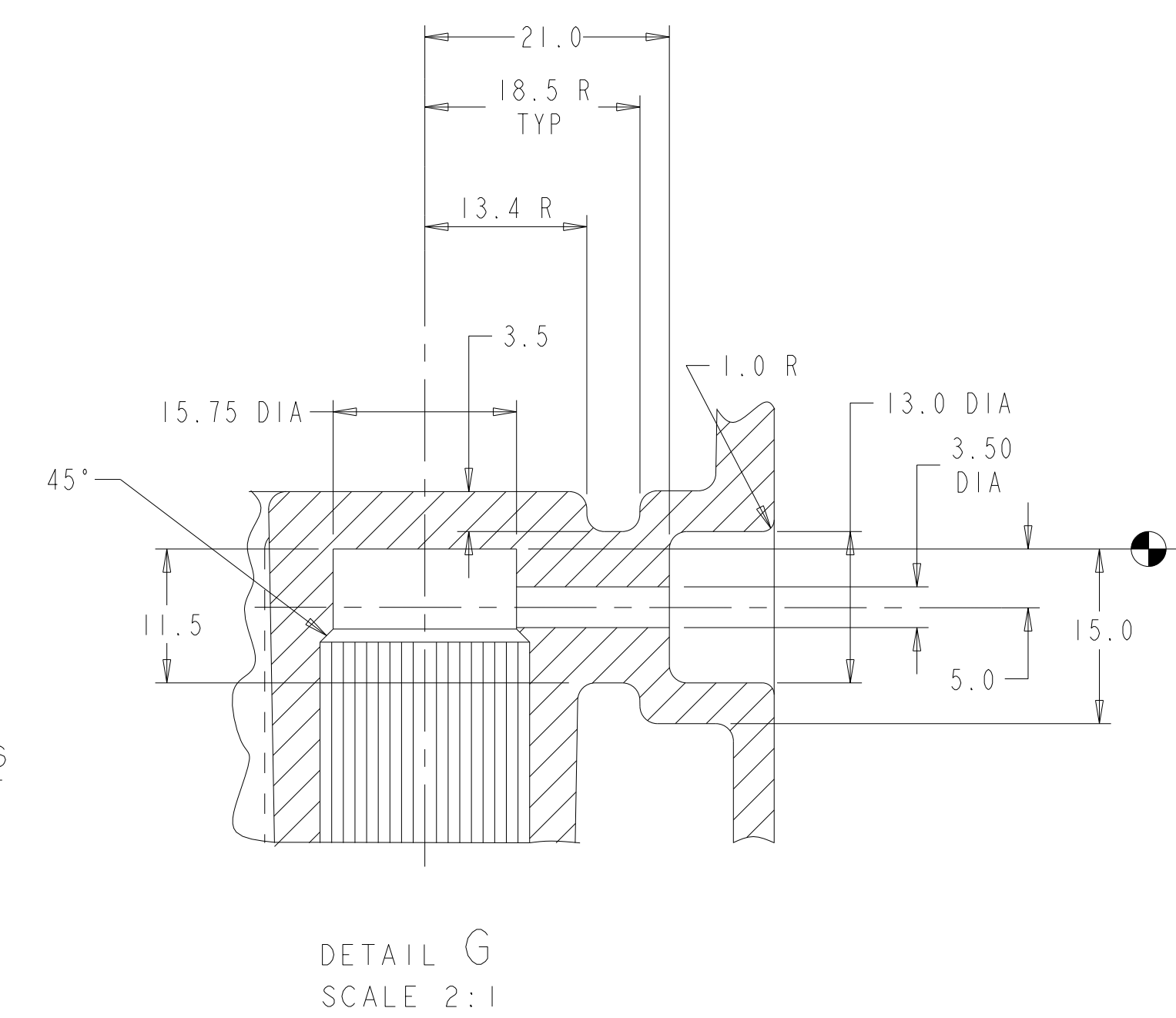
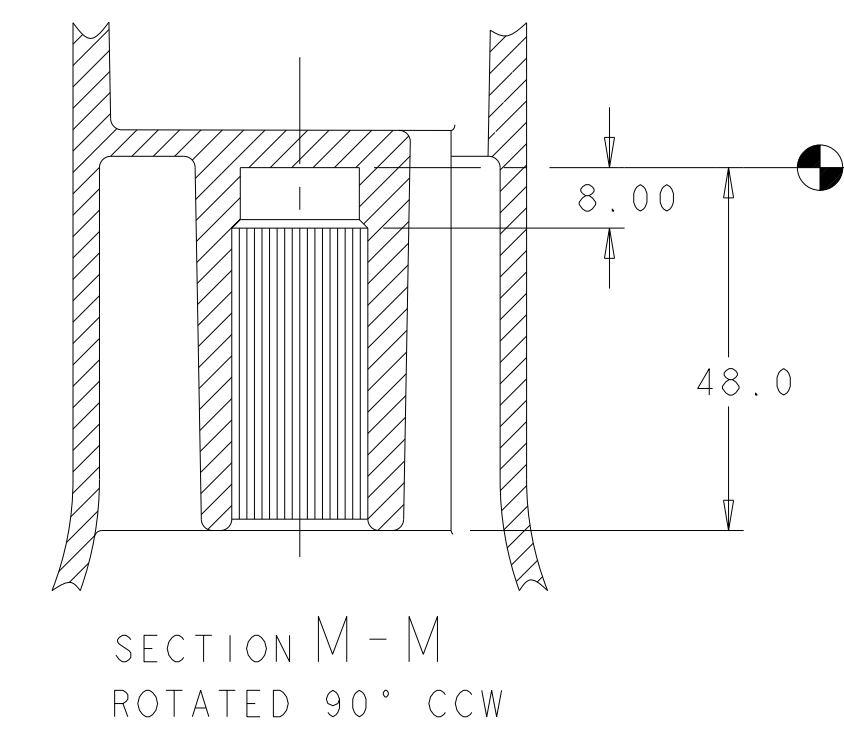
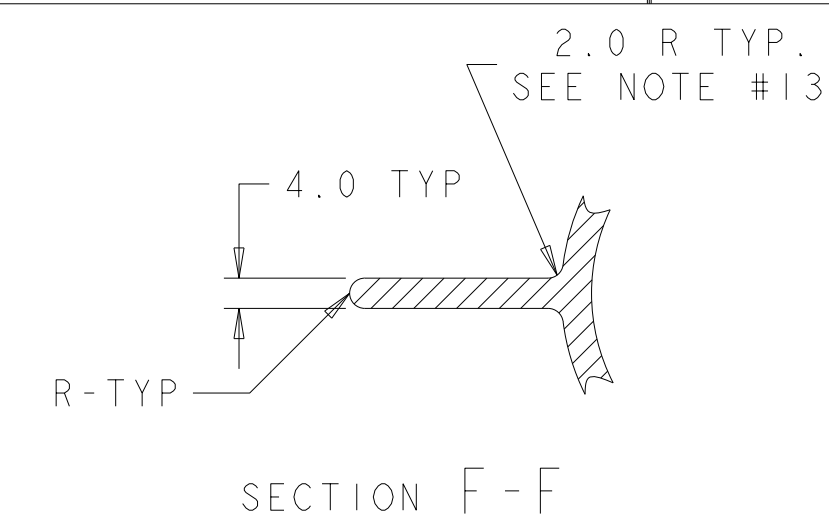
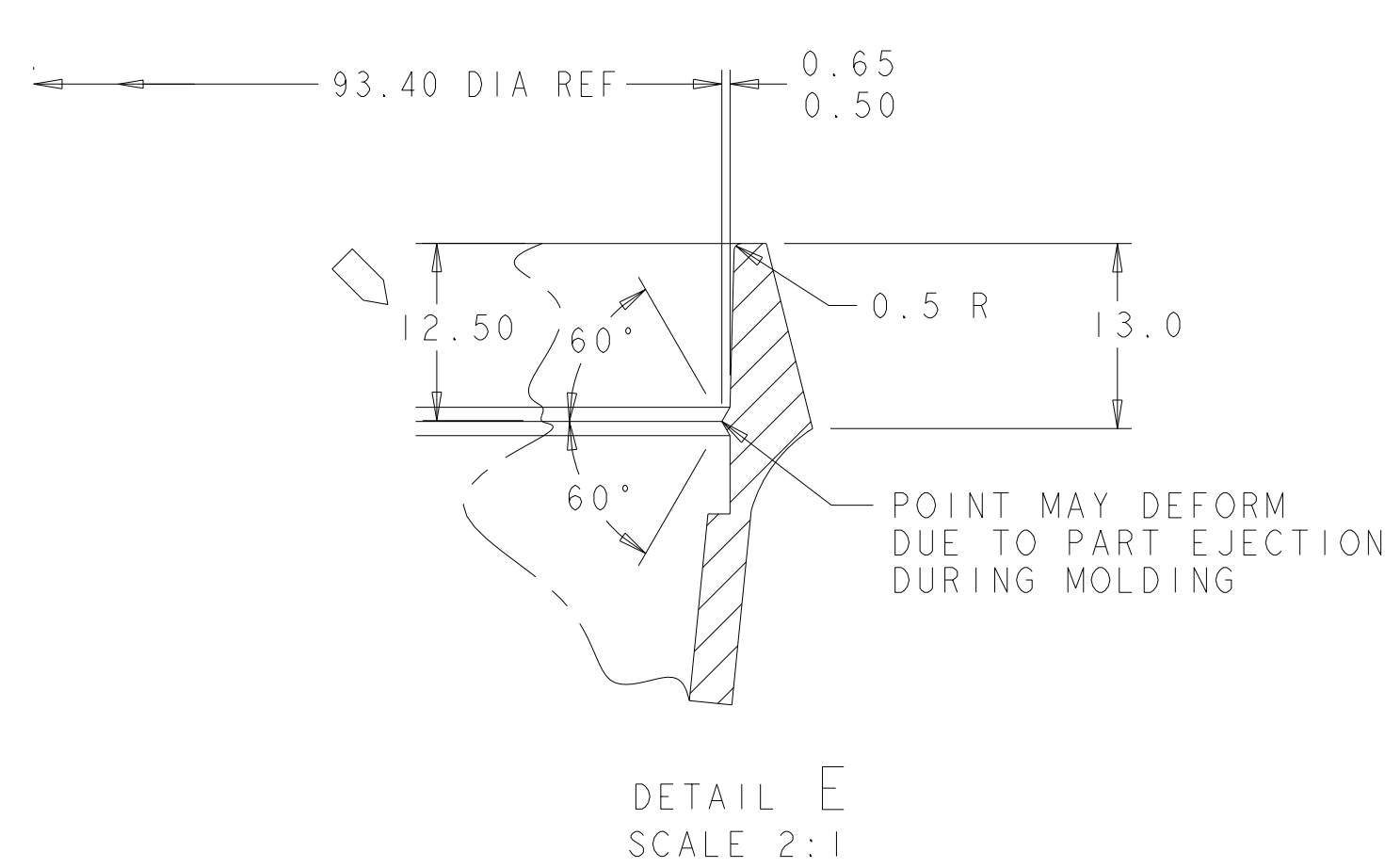
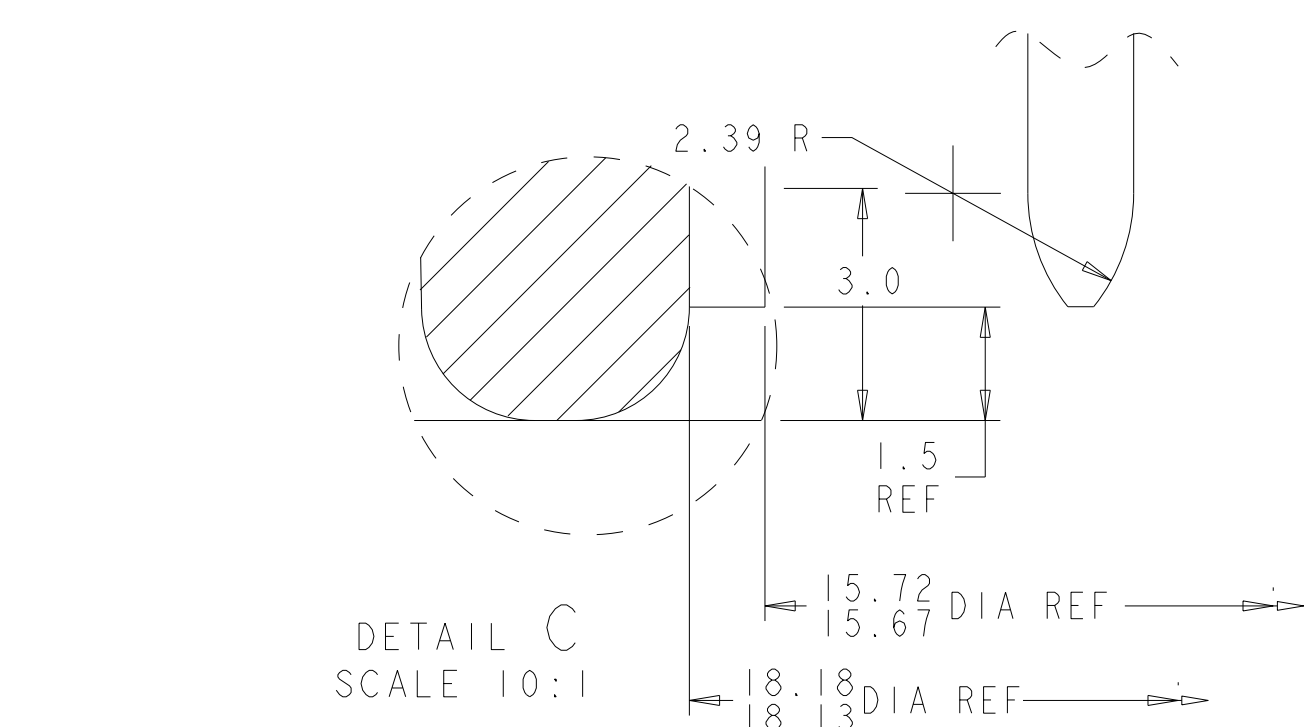
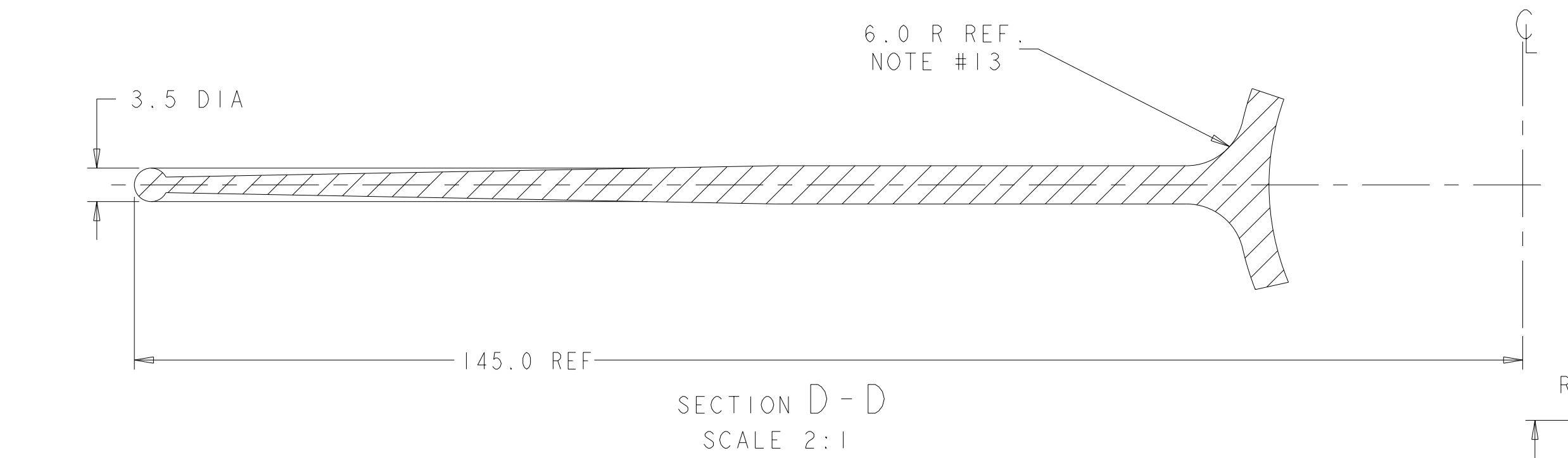
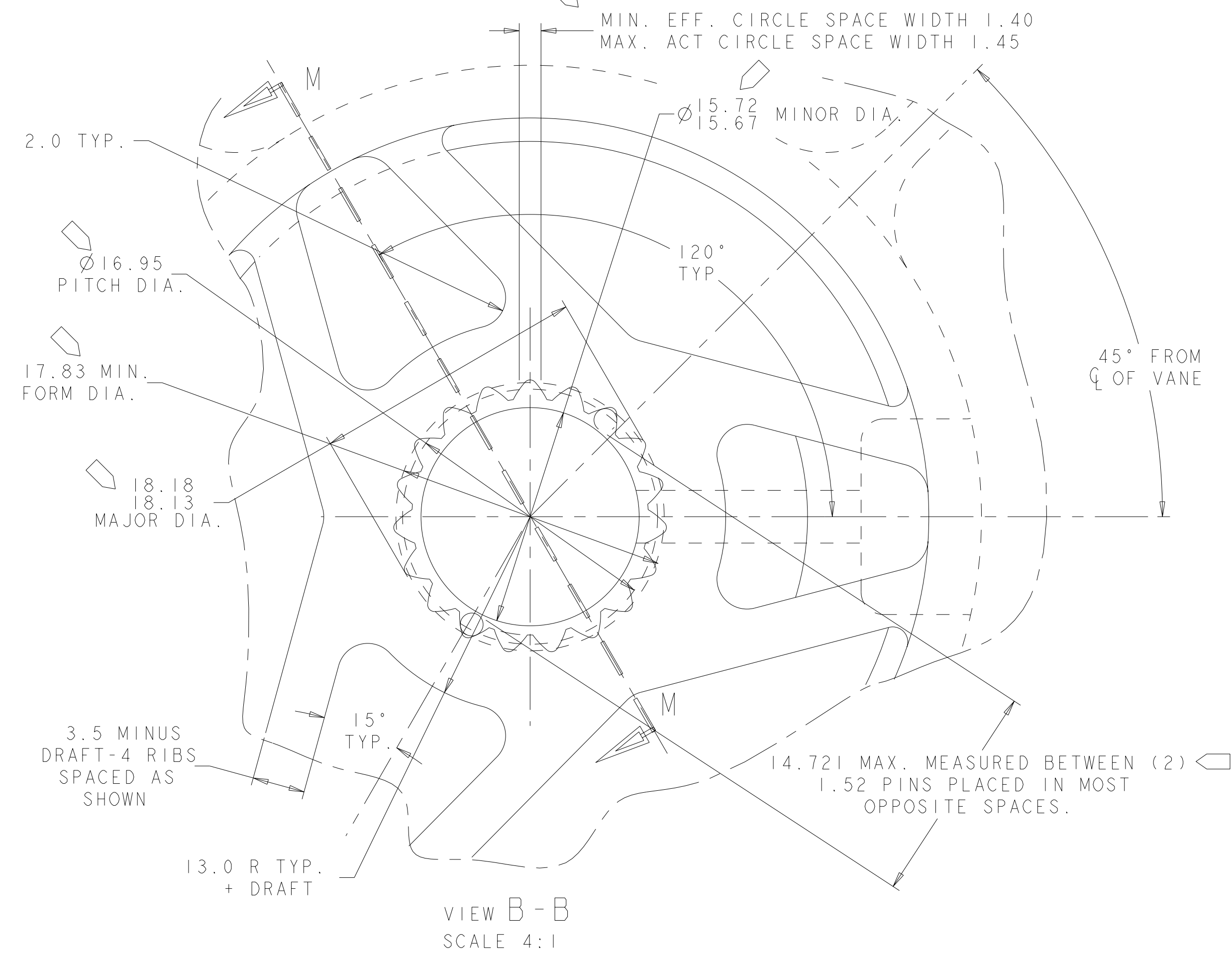
- NOTES:
1. WALL THICKNESS AS SPECIFIED.
 2. DRAFT TO BE 1° PER SIDE UNLESS OTHERWISE SPECIFIED.
 3. NO DRAFT PERMITTED FOR FULL LENGTH OF SPLINE.
 4. ALL RADII TO BE 1.5 UNLESS OTHERWISE SPECIFIED.
 5. ALL RADII MUST BLEND TO FORM SMOOTH CLEAN CONTOURS.
 6. FLASH REMOVAL AT 328 DIA. MACHINED AREA TO BE 1mm. MAX. WIDE.
 7. THERE IS TO BE NO FLASH OR RAW EDGE ON PART THAT COULD CATCH OR CAUSE WEAR TO THE MOST DELICATE FABRICS SUCH AS NYLON HOSE, SILK SLIP, ETC.
 8. FORCE REQUIRED TO REMOVE AGITATOR FROM NOMINAL AGITATOR SHAFT AT ROOM TEMPERATURE (18° TO 29° C) TO BE TO 356 N.
 9. TORQUE NECESSARY TO CRACK AGITATOR OR STRIP OUT SPLINES USING SPLINED SHAFT 3429845 SHALL BE 135 N.M. MIN. AT ROOM TEMPERATURE OR 55 N.M. MIN. AT 82° C.
 10. RUN-OUT OF 328mm. DIA WITH RELATION TO SPLINED HOLE TO BE 1.0mm T.I.R.
 11. LINE "Z" WILL BE OFFSET 5.0mm FROM LINE "V" AND SHALL TAPER FROM A THICKNESS OF 5.0mm AT (END) POINT "X" TO 1.7mm. AT (END) POINT "Y". THE THICKNESS OF THE REMAINDER OF THE FACE IS GIVEN BY A PLANE DEFINED BY POINTS "X", "Y" AND "W". THE THICKNESS AT POINT "W" = 1.7mm.
 12. VANE THICKNESS AT LINE "V" SHALL BE 5.0mm. ABOVE LINE "V", THICKNESS SHOULD BLEND TO 4.0mm. WITHIN A DISTANCE OF 50.0mm. FROM POINT "X".
 13. RADIUS AT INTERSECTION OF VANE WITH BARREL SHALL BE 6.0mm. AT THE ROOT OF VANE NEAR LINE "V", ABOVE LINE "V" RADIUS SHALL BLEND FROM 6.0mm. TO 2.0mm. WITHIN A DISTANCE OF APPROX. 50.0mm.
 14. MATERIAL: POLYPROPYLENE EXXON 1042 OR SCHULMAN PP3487 (PER DRAW ING RP11090.) 25% REGRIND PERMISSIBLE. COLOR: SEE CHART
 15. SET BASELINE
 16. MARK PER SPEC. C-33.
 17. BLEND 3.5mm. BEAD INTO VANE THICKNESS ABOVE POINT "Y".
 18. REVISIONS REQUIRE CODES APPROVAL DUE TO MATERIAL, FLAMMABILITY, NUMBER OF VANES AND DIMENSIONS.
 19. ALL DIMENSIONS RELATED TO 4 CURVED VANES TO BE ± 1%.
 20. ALL DIMENSIONS INDICATED WITH * ARE FOR REFERENCE ONLY.
 21. PLANICITY MAX PERMITTED ON THE AGITATOR BASE IS 2MM MAX.

REF. PART No. 3428392

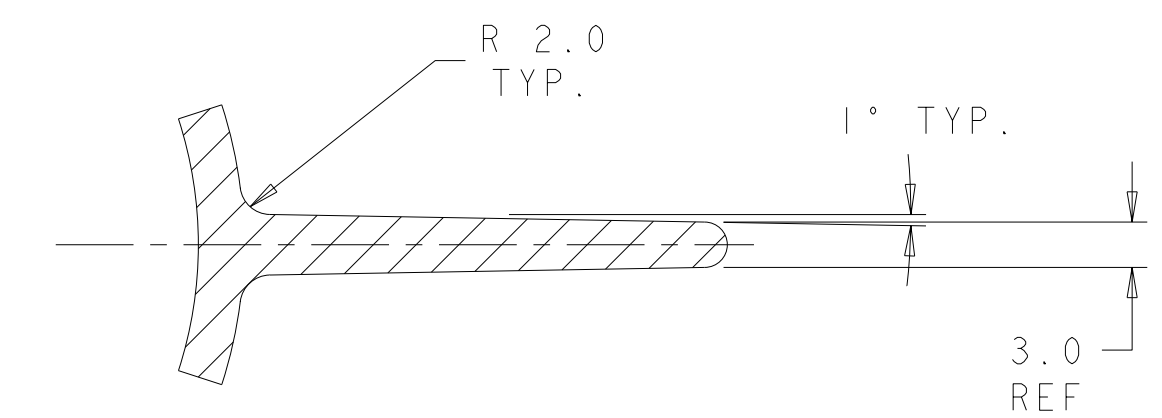
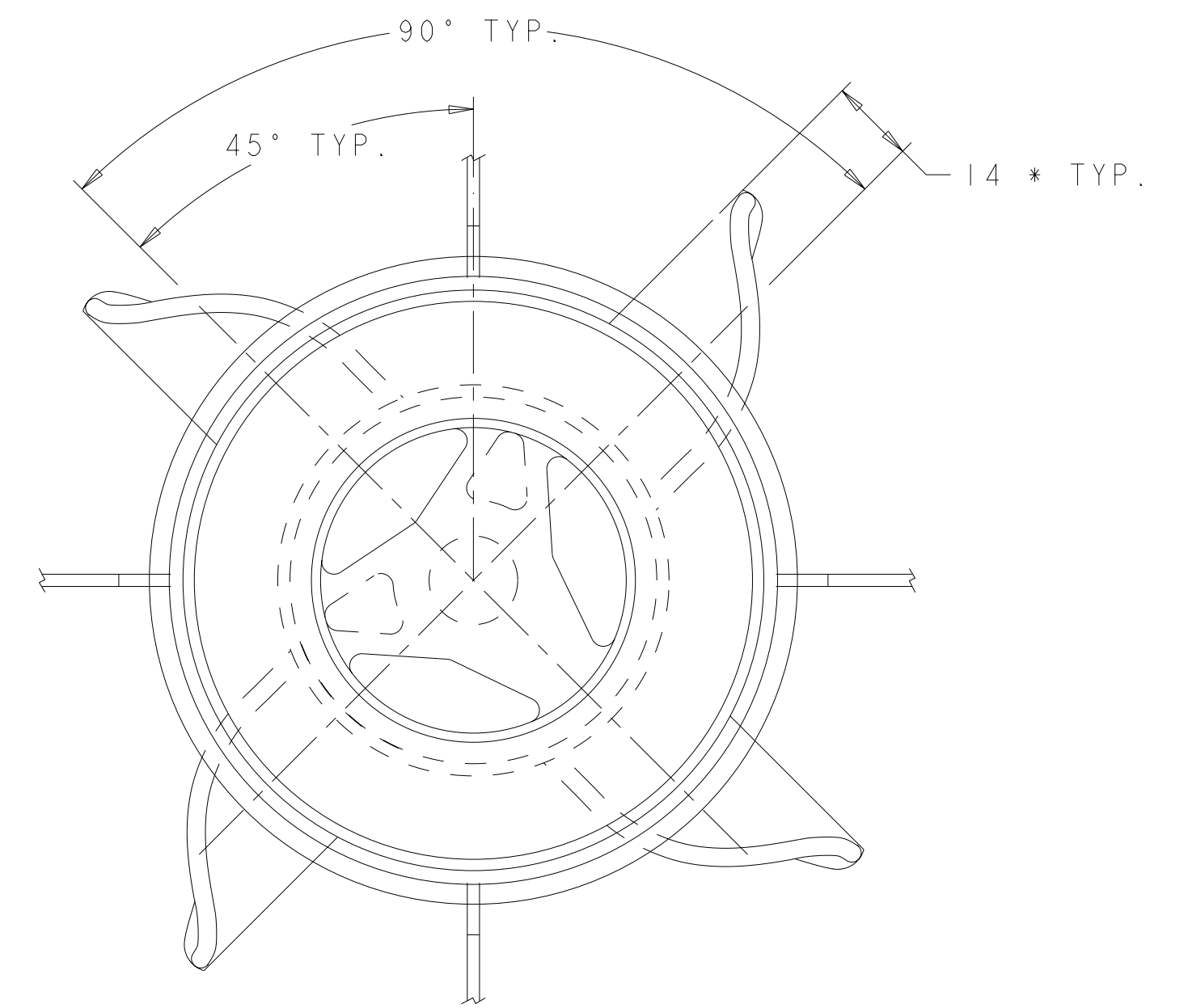
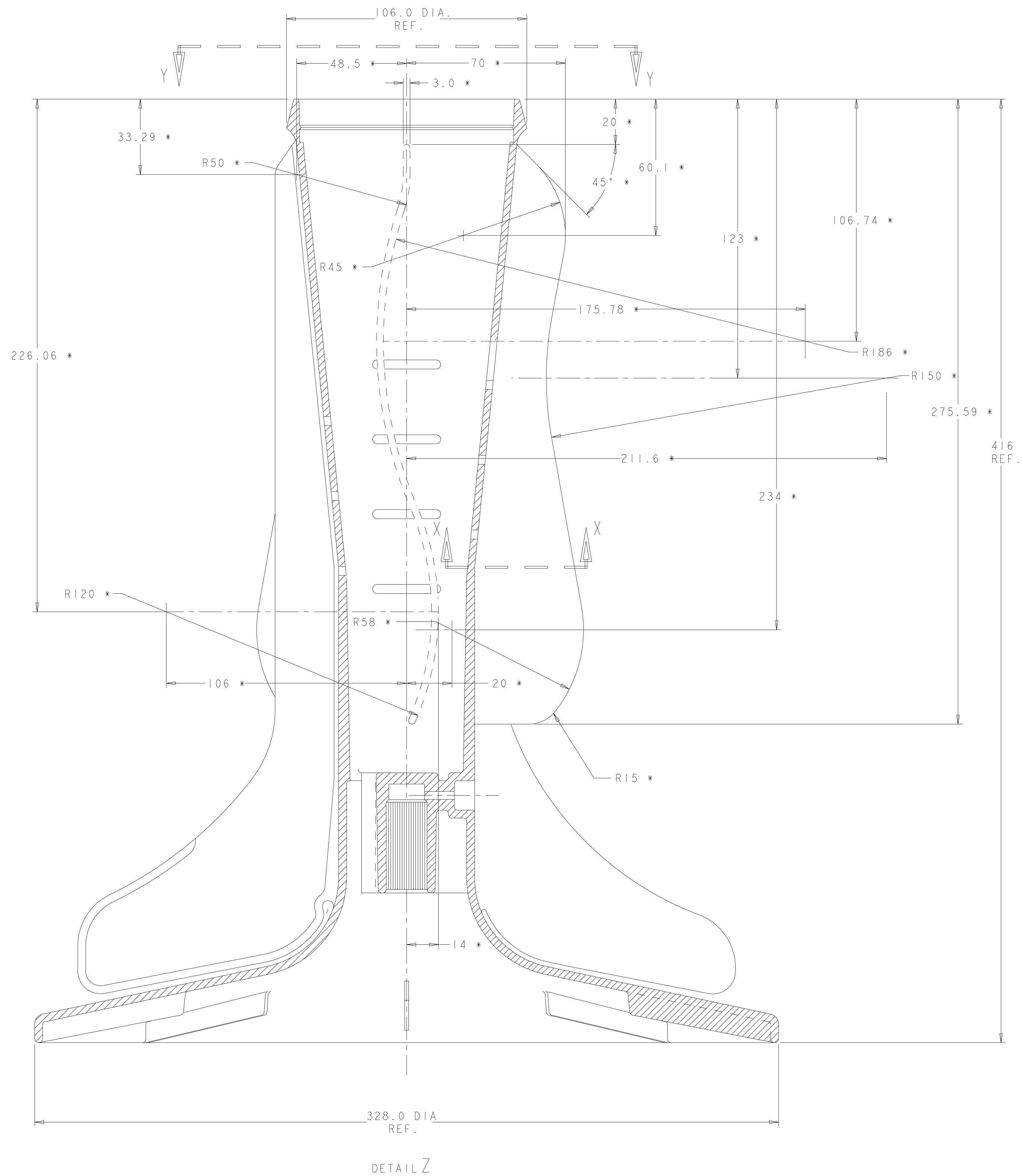
= CONTROL CHARACTERISTIC

3968192

INTERNAL SPLINE DATA	
TYPE OF SPLINE	INVOLUTE
MODULE	0.892
NO. OF TEETH	19
PRESSURE ANGLE	40°



CONFIDENTIAL		VENDOR MUST TREAT INFORMATION ON THIS SHEET IN CONFIDENCE AS DESCRIBED ON SHEET 1.	
PART	AGITATOR/TORNADO		
SCALE	FULL	SHEET 2 OF 3	REV
EXP. NO.	EXP-0669	E	
DRAWING NO.	3968192		
CETEC LAVADORAS		COMERCIAL ACROS WHIRLPOOL	
CARRETERA MIGUEL ALEMAN KM. 14.13 MOTOLCA, N.L., MEXICO		Acros 	



CONFIDENTIAL		VENDOR MUST TREAT INFORMATION ON THIS SHEET IN CONFIDENCE AS DESCRIBED ON SHEET 1.	
PART		AGITATOR/TORNADO	
SCALE FULL	SHEET 3 OF 3	COMERCIAL ACROS WHIRLPOOL  	
EXP. NO. EXP-0669	REV E	CETEC LAVADORAS CARRETERA MIGUEL ALEMAN KM. 13 APODACA, N.L., MEXICO	
DRAWING NO. 3968192			