UNITED STATES PATENT AND TRADEMARK OFFICE

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BEFORE THE PATENT TRIAL AND APPEAL BOARD

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DUKE MANUFACTURING CO.
Petitioner

v.

MARMON FOODSERVICE TECHNOLOGIES, INC.
Patent Owner

_____

Case: IPR2026-00483
Patent No. 10,512,363

DECLARATION OF NATASHA ZERBEY

Duke Manufacturing Co. EX1036
U.S. Patent No. 10,512,363

I, Natasha Zerbey, hereby declare as follows:

1. I am an ERP Systems Analyst for Duke Manufacturing Co. ("Duke") and have held this position since approximately 2023. In this role, I am responsible for supporting Duke within the Epicor ERP system. I make this declaration in connection with the above-referenced IPR proceeding on behalf of Duke.

2. Prior to my current role I was the Materials Manager for Duke from approximately 2020-2023. In this role I was responsible for the Materials Team and coordinating material inventory for Duke at its Sedalia manufacturing facility.

3. Prior to that role, I was a Materials Control Supervisor for Duke from approximately 2013-2020. In this role I was responsible for coordinating material inventory for Duke at its Sedalia manufacturing facility.

4. In my roles as the Materials Manager and Materials Control Supervisor, I would maintain the schedules for production, including creating the Job Traveler that would go to production for assembling customer orders and product inventory.

5. Duke uses Epicor as its Enterprise Resource Planning software.

6. As part of Duke's implementation of Epicor, Duke uses a feature called Job Traveler in which a report is generated for each job.

7. A job is a work order for manufacturing and could include multiple units of the product (*e.g.*, multiple units of the same model of IRHS unit) being manufactured.

8. Duke uses the Job Traveler Reports generated by Epicor in manufacturing and fulfilling each and every job at its Sedalia, Missouri manufacturing facility. Duke has been using Epicor since February 2013.

9. For example, for any given job fulfilled at the Sedalia, Missouri manufacturing facility, a Job Traveler is printed out. The Job Traveler will provide a bill of materials and instructions for assembly of the job, including line items for any manuals that are to ship with the unit—such as the Operators Manual P/N 229945D for the Infrared Heatsink (IRHS) Holding Unit of Exhibit 1005.

10. For each job, an inspector would verify that the units are built correctly, have been tested, and that all of the documentation—including operator manuals—specified by the Job Traveler are included with each unit.

11. An example of a Job Traveler Report for an IRHS job from January 2014 is included as Attachment A to this declaration.

12. Notably, while manuals—such as the Operators Manual P/N 229945—are listed as a line item in the Job Traveler Report that is printed out for fulfillment of the job, the Job Traveler Report would not include the Revision number of the Operator Manual.

13. Instead, during fulfillment the currently effective revision of the operator manual is included with each unit.

14. Upon completion of each unit, the inspector would update Epicor. Likewise, upon completion of the job, Epicor would be updated to show that the entire job was completed. The Job Traveler and the corresponding data is further saved within Epicor, thus allowing tracking and retrieval of the production history of each completed job.

15. I declare under penalty of perjury that the foregoing is true and correct. Executed this 9th day of June 2026.

Natasha Zerbey

Natasha Zerbey

ATTACHMENT A

Job Traveler

Job: 0177522 **Asm:** 0 **Drop Location:** IR **Usage:** 0 **Priority:** NORMAL
Container Type: **Job Code:**

Part: IRHS23-2082T2RS **Drawing #:** **Rev:** 1

Description: IRHS, 2X3, 208V, RIGHT, KM, 2 SIDE, SATELLITE, UL

For Stock	For Order	Schedule Dates		
5.00 EA		***Start Date:*** 1/22/2014	***Due Date:*** 01/27/2014	***Req. By:*** 1/28/2014 *Tuesday*

Total Qty: 5.00 EA

Must complete Required Quantity

Job Traveler

Job: 0177522 **Asm:** 0 **Drop Location:** IR **Usage:** 0 **Priority:** NORMAL
Container Type: **Job Code:**

Part: IRHS23-2082T2RS **Drawing #:** **Rev:** 1

RAW MATERIAL COMPONENTS:

Seq No.	Part	Description	Req. Qty	Added Mtl	Whse	Rel. OP	Status
70	166068	TRIVETTE, IRHS SHIPPER	5.0000 EA		SED-IRHS	400	***Backflush***
80	166069	CORNER, IRHS FOAM	20.0000 EA		SED-IRHS	400	***Backflush***
90	166062	LID, IRHS 2X3	5.0000 EA		SED-IRHS	400	***Backflush***
100	166063	BODY, IRHS 2X3	5.0000 EA		SED-IRHS	400	***Backflush***
110	166027	LABEL,DATAPLATE IRHS	1.0000 EA		SED-IRHS	400	***Backflush***
120	E011417	TRIVET 1/3 PHU	30.0000 EA		SED-IRHS	400	***Backflush***
150	1030-2440	PAN BASE INNER 3W PHU2	5.0000 EA		SED-IRHS	400	***Backflush***
160	1030-2462	ANGLE SUPPORT 3W GL FRM PHU2	20.0000 EA		SED-IRHS	400	***Backflush***
170	1030-2464	BOX,WIRE PP PHU2	10.0000 EA		SED-IRHS	400	***Backflush***
320	156624	CORD,POWER 15AMP 250V W/TERM. 6 FT	5.0000 EA		SED-IRHS	400	***Backflush***
380	175515	STRAIN RELIEF,POWER CORD INCLUDES NUT	5.0000 EA		SED-IRHS	400	***Backflush***
400	502916	LABEL,CAUTION HOT	30.0000 EA		SED-IRHS	400	***Backflush***
410	516008	INSUL,FIBERGLASS 1"x24"x87'x2 LYERS/RL,2 RL/PKG(696 SFT	15.3470 SF		SED-IRHS	400	***Backflush***
470	155749	TRANSFORMER,20VA 208/240VAC-12VAC	5.0000 EA		SED-IRHS	30	***Backflush***
480	166007	HEATER, IRHS 3 WIDE 450W - 208V	10.0000 EA		SED-IRHS	30	***Backflush***
490	166017	EMITTER 340W-208V	30.0000 EA		SED-IRHS	30	***Backflush***
500	1030-2623	PANEL TOP 2X3 W/ FRY CUP DISPENSERS ON BOTH SIDES	5.0000 EA		SED-IRHS	30	***Backflush***
510	156666	CABLE,FLAT MODULAR RJ12-6 26" LONG (4 X 2 WARMER)	5.0000 EA		SED-IRHS	10	***Backflush***
520	156667	CABLE,FLAT MODULAR RJ45-8 24" LONG (4 X 2 WARMER)	5.0000 EA		SED-IRHS	10	***Backflush***
530	222252	WARMER COMM. ADAPTER BOARD – W/LI	5.0000 EA		SED-IRHS	10	***Backflush***
540	223470	NUT, 4-40 NYLON LOCKNUT	0.0005 PC		SED-IRHS	10	***Backflush***
550	155850	SPACER,NYLON #6 X 5/16"	15.0000 EA		SED-IRHS	10	***Backflush***
560	222253	HARNESS – IRHS ICC/RENAU COMM. ADAPTER	5.0000 EA		SED-IRHS	10	***Backflush***
570	156616	COUPLER,STRAIGHT 6X6 RJ12 BLACK	5.0000 EA		SED-IRHS	10	***Backflush***
580	213191	RIVET, POP ADS-32-BS SS	0.0005 PC		SED-IRHS	10	***Backflush***
590	1030-2574	PLATE MTG CNTRL PANEL ICC SINGLE PHU2	5.0000 EA		SED-IRHS	10	***Backflush***
600	156195	ADAPTER,USB HOST	5.0000 EA		SED-IRHS	20	***Backflush***

Job Traveler

Job: 0177522 **Asm:** 0 **Drop Location:** IR **Usage:** 0 **Priority:** NORMAL
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610	155625	NUT,INSERT 8-32 OPEN END TRIVALENT PLATING	0.0005 PC	SED-IRHS	20	***Backflush***
620	229945	INST, IRHS	5.0000 PC	SED-IRHS	20	***Backflush***
630	156218	USB,FLASH DRIVE 64M W/ DUKE LOGO	5.0000 EA	SED-IRHS	20	***Backflush***
640	229550	ENVELOPE, 9X12 CLEAR LOCK AND PRESS 2 MIL	5.0000 PC	SED-IRHS	20	***Backflush***
650	219026	POUCH,KANBAN CARD	0.0005 PC	SED-IRHS	20	***Backflush***
660	279500	SCREW,8-32X1/2"TR PH SS	0.0005 PC	SED-IRHS	20	***Backflush***
670	168378	SCREW,8-32X3/8"PN PH SS	1.0000 EA	SED-IRHS	20	***Backflush***
680	168106	RIVET,1/8"SS .039-.118GRIP R. V#97550A105	1.0000 EA	SED-IRHS	20	***Backflush***
690	158369	NUTSERT,HEX 8-32, TRIVALENT PLATING	0.0005 PC	SED-IRHS	20	***Backflush***
700	156248	SPACER,USB HOST ADAPTER 24 X 20 18GA ALZ = 104	5.0000 EA	SED-IRHS	20	***Backflush***
710	157916	SWITCH,VERTICAL RENAU DAYPART ASSEMBLY	5.0000 EA	SED-IRHS	20	***Backflush***
720	1030-2527	ANGLE,MOUNTING	15.0000 EA	SED-IRHS	20	***Backflush***
730	1030-2422	PLATE SHIM POWER SWITCH PHU2	5.0000 EA	SED-IRHS	20	***Backflush***
740	213281	RIVET,3/16" ALUM POP	0.0005 PC	SED-IRHS	20	***Backflush***
750	157886	SWITCH,NON-LIT 20A DPST HI-TEMP, IO STYLE 7	5.0000 EA	SED-IRHS	20	***Backflush***
760	0280050	SCREW,8-32X1-1/4FL PH SS	0.0005 PC	SED-IRHS	20	***Backflush***
770	215450	NAMEPLATE DUKE SHIELD	5.0000 PC	SED-IRHS	20	***Backflush***
780	214814	LABEL,ELECTRICAL CAUTION	0.0005 PC	SED-RS	20	***Issued Complete***
790	229947	LABEL, WARNING ELECTRIC SHOCK	0.0005 PC	SED-IRHS	20	***Issued Complete***
800	1030-2429	HEAT SINK 3W PHU2	5.0000 EA	SED-OP	140	***Backflush***
810	1030-2431	LINER TOP IR 3W PHU2	5.0000 EA	SED-IRHS	100	***Backflush***
820	1030-2417	OFFSET,EXTRUSION	10.0000 EA	SED-IRHS	100	***Backflush***
830	166013	HEAT SINK ANODIZED 3 WIDE	5.0000 EA	SED-IRHS	100	***Backflush***
840	166052	RENAU TERMINATED HEAT COMMON WIRE	5.0000 EA	SED-IRHS	100	***Backflush***
850	158312	THERMOSTAT,HI-LIMIT 300 DEG FOR HSHU W/FLANGE	5.0000 EA	SED-IRHS	100	***Backflush***
860	155890	STUD, PEM 10-32 X 1/2 S/S	1.0000 EA	SED-IRHS	100	***Backflush***

Job Traveler

Job: 0177522 **Asm:** 0 **Drop Location:** IR **Usage:** 0 **Priority:** NORMAL
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Part: IRHS23-2082T2RS **Drawing #:** **Rev:** 1

870	155986	NUT,KEPS 10-32 HEX ZP	1.0000 EA	SED-IRHS	100	***Backflush***
880	513032	SCREW,8-18X1/2"PN PH SS-T	0.0005 PC	SED-IRHS	100	***Backflush***
890	512120	TERMINAL,MULTIPLIER	5.0000 EA	SED-IRHS	100	***Backflush***
900	213335	BUSHING,HEYCO SB-625-8 OR #MP6258 SNAP IN	0.0005 PC	SED-IRHS	100	***Backflush***
910	155680	NUT,KEPS 8-32 HEX ZP	0.0005 PC	SED-IRHS	100	***Backflush***
920	155851	STUD,PEM 8-32 X 1/2 S/S (FHS-832-8 OR EQUAL)	0.0005 PC	SED-ST	100	***Issued Complete***
930	516008	INSUL,FIBERGLASS 1"x24"x87'x2 LYERS/RL,2 RL/PKG(696 SFT	12.6563 SF	SED-IRHS	100	***Backflush***
940	153168	INSUL,10LB 1/8"X 970-J OR KAOWOOL 900 PAPER	13.1770 SF	SED-IRHS	100	***Backflush***
950	153167	INSUL,4LB 1"THICK (50 SF/CTN) 1"X24"X25'	4.8610 SF	SED-IRHS	100	***Backflush***
960	213055	WASHER,AN960-C10L,18-8 SS	0.0005 PC	SED-IRHS	100	***Backflush***
970	1030-2530	LINER,LOWER 3 WIDE	5.0000 EA	SED-IRHS	100	***Backflush***
980	216490	SEALANT,RTV 1000 GRAY	0.0005 PC	SED-IRHS	100	***Backflush***
990	158289	COMPOUND,SILICONE HEAT SINK THERMAL 6-8OZ TUBES	0.0005 LB	SED-IRHS	100	***Backflush***
1000	1030-2354	BOX, IR INNER SPL PHU2	10.0000 EA	SED-IRHS	70	***Backflush***
1010	1030-2355	REFLECTOR,IR SPL PHU2	10.0000 EA	SED-IRHS	70	***Backflush***
1020	166015	SOCKET, EMITTER STRIPPED	10.0000 EA	SED-IRHS	70	***Backflush***
1030	213192	RIVET, #54D SS POP RIVET	0.0010 PC	SED-IRHS	70	***Backflush***
1040	153167	INSUL,4LB 1"THICK (50 SF/CTN) 1"X24"X25'	4.8610 SF	SED-IRHS	70	***Backflush***
1050	166024	HARNESS, SOCKET 25"	10.0000 EA	SED-IRHS	70	***Backflush***
1060	1030-2354	BOX, IR INNER SPL PHU2	5.0000 EA	SED-IRHS	80	***Backflush***
1070	1030-2355	REFLECTOR,IR SPL PHU2	5.0000 EA	SED-IRHS	80	***Backflush***
1080	166015	SOCKET, EMITTER STRIPPED	5.0000 EA	SED-IRHS	80	***Backflush***
1090	213192	RIVET, #54D SS POP RIVET	0.0005 PC	SED-IRHS	80	***Backflush***
1100	153167	INSUL,4LB 1"THICK (50 SF/CTN) 1"X24"X25'	2.4305 SF	SED-IRHS	80	***Backflush***
1110	166025	HARNESS, SOCKET 39"	5.0000 EA	SED-IRHS	80	***Backflush***
1120	1030-2444	PLATE FACE SS TD 3W PHU2	10.0000 EA	SED-IRHS	90	***Backflush***
1130	155851	STUD,PEM 8-32 X 1/2 S/S (FHS-832-8 OR EQUAL)	0.0010 PC	SED-ST	90	***Issued Complete***

Job Traveler

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1140	1030-2429	HEAT SINK 3W PHU2	5.0000 EA	SED-OP	220	***Backflush***
1150	1030-2431	LINER TOP IR 3W PHU2	5.0000 EA	SED-IRHS	180	***Backflush***
1160	1030-2417	OFFSET,EXTRUSION	10.0000 EA	SED-IRHS	180	***Backflush***
1170	166013	HEAT SINK ANODIZED 3 WIDE	5.0000 EA	SED-IRHS	180	***Backflush***
1180	166052	RENAU TERMINATED HEAT COMMON WIRE	5.0000 EA	SED-IRHS	180	***Backflush***
1190	158312	THERMOSTAT,HI-LIMIT 300 DEG FOR HSHU W/FLANGE	5.0000 EA	SED-IRHS	180	***Backflush***
1200	155890	STUD, PEM 10-32 X 1/2 S/S	1.0000 EA	SED-IRHS	180	***Backflush***
1210	155986	NUT,KEPS 10-32 HEX ZP	1.0000 EA	SED-IRHS	180	***Backflush***
1220	513032	SCREW,8-18X1/2"PN PH SS-T	0.0005 PC	SED-IRHS	180	***Backflush***
1230	512120	TERMINAL,MULTIPLIER	5.0000 EA	SED-IRHS	180	***Backflush***
1240	213335	BUSHING,HEYCO SB-625-8 OR #MP6258 SNAP IN	0.0005 PC	SED-IRHS	180	***Backflush***
1250	155680	NUT,KEPS 8-32 HEX ZP	0.0005 PC	SED-IRHS	180	***Backflush***
1260	155851	STUD,PEM 8-32 X 1/2 S/S (FHS-832-8 OR EQUAL)	0.0005 PC	SED-ST	180	***Issued Complete***
1270	516008	INSUL,FIBERGLASS 1"x24"x87'x2 LYERS/RL,2 RL/PKG(696 SFT	12.6563 SF	SED-IRHS	180	***Backflush***
1280	213055	WASHER,AN960-C10L,18-8 SS	0.0005 PC	SED-IRHS	180	***Backflush***
1290	1030-2530	LINER,LOWER 3 WIDE	5.0000 EA	SED-IRHS	180	***Backflush***
1300	216490	SEALANT,RTV 1000 GRAY	0.0005 PC	SED-IRHS	180	***Backflush***
1310	158289	COMPOUND,SILICONE HEAT SINK THERMAL 6-8OZ TUBES	0.0005 LB	SED-IRHS	180	***Backflush***
1320	1030-2354	BOX, IR INNER SPL PHU2	10.0000 EA	SED-IRHS	150	***Backflush***
1330	1030-2355	REFLECTOR,IR SPL PHU2	10.0000 EA	SED-IRHS	150	***Backflush***
1340	166015	SOCKET, EMITTER STRIPPED	10.0000 EA	SED-IRHS	150	***Backflush***
1350	213192	RIVET, #54D SS POP RIVET	0.0010 PC	SED-IRHS	150	***Backflush***
1360	153167	INSUL,4LB 1"THICK (50 SF/CTN) 1"X24"X25'	4.8610 SF	SED-IRHS	150	***Backflush***
1370	166024	HARNESS, SOCKET 25"	10.0000 EA	SED-IRHS	150	***Backflush***
1380	1030-2354	BOX, IR INNER SPL PHU2	5.0000 EA	SED-IRHS	160	***Backflush***
1390	1030-2355	REFLECTOR,IR SPL PHU2	5.0000 EA	SED-IRHS	160	***Backflush***
1400	166015	SOCKET, EMITTER STRIPPED	5.0000 EA	SED-IRHS	160	***Backflush***
1410	213192	RIVET, #54D SS POP RIVET	0.0005 PC	SED-IRHS	160	***Backflush***
1420	153167	INSUL,4LB 1"THICK (50 SF/CTN) 1"X24"X25'	2.4305 SF	SED-IRHS	160	***Backflush***

Job Traveler

Job: 0177522 **Asm:** 0 **Drop Location:** IR **Container Type:** **Usage:** 0 **Priority:** NORMAL **Job Code:**

Part: IRHS23-2082T2RS **Drawing #:** **Rev:** 1

1430	166025	HARNESS, SOCKET 39"	5.0000 EA	SED-IRHS	160	***Backflush***
1440	1030-2433	PLATE FACE SS 3W PHU2	10.0000 EA	SED-IRHS	170	***Backflush***
1450	155851	STUD,PEM 8-32 X 1/2 S/S (FHS-832-8 OR EQUAL)	0.0010 PC	SED-ST	170	***Issued Complete***
1460	1030-9612	PLATE MTG CONTROL 2H PHU2	5.0000 EA	SED-IRHS	230	***Backflush***
1470	166080	RENAU HCM-34	5.0000 EA	SED-IRHS	230	***Backflush***
1480	120103	FUSE, MOD CTRL TSC	10.0000 EA	SED-IRHS	230	***Backflush***
1490	158337	BOARD,RTD, CE AND ROHS COMPLIANT	5.0000 EA	SED-IRHS	230	***Backflush***
1500	120102	HOLDER,FUSE MOD CTRL TSC 354802-GY	5.0000 EA	SED-IRHS	230	***Backflush***
354802-GY Fuse Block						
1510	156278	MOUNT,HARNESS	15.0000 EA	SED-IRHS	230	***Backflush***
1520	512169	TIE,WRAP 4" NYLON 6/6, HEAT STABILIZED TO 220 DEG. F	0.0005 PC	SED-IRHS	230	***Backflush***
1530	157971	TIE,WRAP 5.7"X.14	1.0000 EA	SED-IRHS	230	***Backflush***
1540	223470	NUT, 4-40 NYLON LOCKNUT	0.0005 PC	SED-IRHS	230	***Backflush***
1550	223410	STANDOFF, ALUM 4-40 X7/8"	20.0000 PC	SED-IRHS	230	***Backflush***
1560	502786	STUDQWERTYPEM 4-40X3/4" SS FHS-440-12	1.0000 EA	SED-IRHS	230	***Backflush***
1570	223151	SPACER, 3/16ID X 3/8 ALUM	0.0005 PC	SED-IRHS	230	***Backflush***
1580	158289	COMPOUND,SILICONE HEAT SINK THERMAL 6-8OZ TUBES	0.0005 LB	SED-IRHS	230	***Backflush***
1590	166051	HARNESS, MAIN AC	5.0000 EA	SED-IRHS	230	***Backflush***
1600	167614	SENSOR,CURRENT	5.0000 EA	SED-IRHS	230	***Backflush***
1610	166081	RENAU SPM-202	20.0000 EA	SED-IRHS	230	***Backflush***
1620	212106	CONNECTOR WAGO 5 CONDUCTOR 222-415	15.0000 PC	SED-IRHS	230	***Backflush***
1630	166038	HARNESS, HEATER RELAYS 2X3 & 2X2	5.0000 EA	SED-IRHS	230	***Backflush***
1640	166040	HARNESS, EMITTER RELAYS 2X3	5.0000 EA	SED-IRHS	230	***Backflush***
1650	166039	HARNESS, RTD/PCB 2X3	5.0000 EA	SED-IRHS	230	***Backflush***
1660	166037	HARNESS, POWER HEATER RELAYS 2X3 & 2X2	5.0000 EA	SED-IRHS	230	***Backflush***
1670	223230	SCREW, 6-32 X3/8 PPHTCS TYPE F S/S	1.0000 EA	SED-IRHS	230	***Backflush***
1680	512901	SCREW,6-32X1/4"PN PH BO-TAP TITE THRD RLG BLACK OXIDE	1.0000 EA	SED-IRHS	230	***Backflush***

Job Traveler

Job: 0177522 **Asm:** 0 **Drop Location:** IR **Usage:** 0 **Priority:** NORMAL
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1690	166048	HARNESS, POWER EMITTER RELAYS 3X4	5.0000 EA	SED-IRHS	230	***Backflush***
1700	166050	HARNESS, DUAL FUSE 208/240	5.0000 EA	SED-IRHS	230	***Backflush***
1710	218932	TERMINAL, AMP .250 TAB 16-14 AWG BLUE	10.0000 EA	SED-IRHS	230	***Backflush***
1720	156951	SPACER,5/16ODX3/8LG ALUM.	20.0000 EA	SED-IRHS	230	***Backflush***
1730	154458	NUT,8-32 HEX CAPS SS C.T. WARMER	0.0005 PC	SED-IRHS	230	***Backflush***
1740	212122	TERMINAL,FEMALE DISCONNECT NYLON FULLY INSULATED 22-18 AWG .250X.032	5.0000 EA	SED-IRHS	230	***Backflush***
1750	166082	RENAU SPS-204 (UP/DOWN)	30.0000 EA	SED-IRHS	270	***Backflush***
1760	156855	SPACER RENAU KEYPAD NO AUDIT	30.0000 EA	SED-IRHS	270	***Backflush***
1770	156747	SPACER,RETAINING	1.0000 EA	SED-IRHS	270	***Backflush***
1780	0280000SED	SCREW,8-32X1"TR PH SS MACHINE	0.0010 PC	SED-IRHS	270	***Backflush***
1790	166664	Harness, timer bar IRHS-23 RH	10.0000 EA	SED-IRHS	270	***Backflush***
1800	279500	SCREW,8-32X1/2"TR PH SS	0.0010 PC	SED-IRHS	270	***Backflush***
1810	227830	GLUE, 1/2/" SUPER HIGH TACK DOTS	0.0010 PC	SED-IRHS	270	***Backflush***
1820	1030-2459	CHANNEL BACK MENU BAR 3W PHU2	10.0000 EA	SED-IRHS	250	***Backflush***
1830	223403	STANDOFF, PEM 8-32 X .687 BSOS-832-22	10.0000 EA	SED-IRHS	250	***Backflush***
1840	1030-2460	CHANNEL FRT MENU BAR 3W PHU2	10.0000 EA	SED-IRHS	260	***Backflush***
1850	1030-2463	PLATE,MTG MENU BAR	10.0000 EA	SED-IRHS	260	***Backflush***
1860	166023	GASKET, IR STRIP SIDES	20.0000 EA	SED-IRHS	310	***Backflush***
1870	166021	GASKET, IR STRIP F/R 3 WIDE	20.0000 EA	SED-IRHS	310	***Backflush***
1880	166019	GLASS, IRHS	30.0000 EA	SED-IRHS	310	***Backflush***
1890	216577	SEALANT,999 RTV CLEAR 10 OZ. TUBE.	0.0010 PC	SED-IRHS	310	***Backflush***
1900	1030-2434	FRAME,GLASS 3W PHU2	10.0000 EA	SED-IRHS	300	***Backflush***
1910	1030-2539	CHANNEL,COVER PAN PHU2	20.0000 EA	SED-IRHS	300	***Backflush***
1920	1030-2436	GUIDE,PAN PHU2	20.0000 EA	SED-IRHS	290	***Backflush***
1930	1030-2539	CHANNEL,COVER PAN PHU2	40.0000 EA	SED-IRHS	290	***Backflush***
1940	1030-2497	PANEL BASE 3W PG PHU2	5.0000 EA	SED-IRHS	320	***Backflush***
1950	217125	PAINT, PDR TEXTURED BLACK #ET442N2	1.4305 LB	SED-PN	330	***Backflush***
1960	1030-2488	PANEL,CNTRL 2H RH PG DUAL MENU BARS	5.0000 EA	SED-IRHS	340	***Backflush***
1970	155890	STUD, PEM 10-32 X 1/2 S/S	1.0000 EA	SED-IRHS	340	***Backflush***
1980	217125	PAINT, PDR TEXTURED BLACK #ET442N2	0.9850 LB	SED-PN	350	***Backflush***

Job Traveler

Job: 0177522 **Asm:** 0 **Drop Location:** IR **Usage:** 0 **Priority:** NORMAL
Container Type: **Job Code:**

Part: IRHS23-2082T2RS **Drawing #:** **Rev:** 1

1990	115355	STUD,PEM 8-32x3/4" FHS-832-12	1.0000 EA	SED-IRHS	340	***Backflush***
2000	1030-2489	PANEL LEFT SIDE 2H PG PHU2	5.0000 EA	SED-IRHS	360	***Backflush***
2010	217125	PAINT, PDR TEXTURED BLACK #ET442N2	0.6490 LB	SED-PN	370	***Backflush***
2020	1030-2491	COVER,CONTROL SIDE 2H PG PHU2	5.0000 EA	SED-IRHS	380	***Backflush***
2030	217125	PAINT, PDR TEXTURED BLACK #ET442N2	0.5960 LB	SED-PN	390	***Backflush***

OPERATIONS:

Seq	No.	Oper.	Description	Oper. Qty	Res.
10	2411		IRHS Assembly	5.00	1.00
INSTALL AND CONNECT ICC COMPONENTS					
20	2411		IRHS Assembly	5.00	1.00
30	2411		IRHS Assembly	5.00	1.00
FINAL ASSEMBLY					
40	2410		IRHS Weld/Polish	5.00	1.00
WELD AND POISH CORNERS ON BASE AND TOP					
50	2410		IRHS Weld/Polish	5.00	1.00
POLISH FRONT EDGE OF TOP TO MATCH EXPEDITE COUNTER					
60	2410		IRHS Weld/Polish	5.00	1.00
WELD & POLISH CORNERS MENU BAR BOX					
70	2411		IRHS Assembly	10.00	1.00
80	2411		IRHS Assembly	5.00	1.00
90	2411		IRHS Assembly	10.00	1.00
PEM PER DRAWING					
100	2411		IRHS Assembly	5.00	1.00
110	2410		IRHS Weld/Polish	5.00	1.00
WELD FACE PLATE CORNERS					
120	2411		IRHS Assembly	5.00	1.00
APPLY HEATING ELEMENT					
130	2411		IRHS Assembly	5.00	1.00
PEM STUD HEAT SINKS					
140	2413		OUTSIDE PROCESSING SUPPLI	5.00	1.00
150	2411		IRHS Assembly	10.00	1.00
160	2411		IRHS Assembly	5.00	1.00
170	2411		IRHS Assembly	10.00	1.00
PEM PER DRAWING					

Job Traveler

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OPERATIONS:

Seq No.	Oper.	Description	Oper. Qty	Res.	
180	2411	IRHS Assembly	5.00	1.00	
190	2410	IRHS Weld/Polish	5.00	1.00	
		WELD FACE PLATE CORNERS			
200	2411	IRHS Assembly	5.00	1.00	
		APPLY HEATING ELEMENT			
210	2411	IRHS Assembly	5.00	1.00	
		PEM STUD HEAT SINKS			
220	2413	OUTSIDE PROCESSING SUPPLI	5.00	1.00	
230	2411	IRHS Assembly	5.00	1.00	
240	2411	IRHS Assembly	5.00	1.00	
		INSTALL PEM STUDS			
250	2411	IRHS Assembly	10.00	1.00	
		PEM STANDOFF PER DRAWING			
260	2410	IRHS Weld/Polish	10.00	1.00	
270	2411	IRHS Assembly	10.00	1.00	
280	2229	BK Broiler Laser Weld	10.00	1.00	
		LASER WELD - USE FIXTURE			*BK Broiler Laser Weld*
290	2410	IRHS Weld/Polish	20.00	1.00	
		TIG & POLISH TABS *SPOT WELD PARTS TOGETHER*			
300	2410	IRHS Weld/Polish	10.00	1.00	
		WELD CHNL PANS IN PLACE			
310	2411	IRHS Assembly	10.00	1.00	
320	2410	IRHS Weld/Polish	5.00	1.00	
		WELD AND POLISH CORNERS			
330	2224	Manual Paint	5.00	1.00	
		TEXTURED BLACK - 217125			*Manual Paint*
340	2411	IRHS Assembly	5.00	1.00	
		PEM STUD PART			
350	2224	Manual Paint	5.00	1.00	
		COLOR - SEE DRAWING-TEXTURED BLACK-217125			*Manual Paint*
360	2411	IRHS Assembly	5.00	1.00	
370	2224	Manual Paint	5.00	1.00	
		TEXTURED BLACK - 217125			*Manual Paint*

Job Traveler

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OPERATIONS:

Seq No.	Oper.	Description	Oper. Qty	Res.	
380	2411	IRHS Assembly	5.00	1.00	
390	2224	Manual Paint	5.00	1.00	
		TEXTURED BLACK - 217125			*Manual Paint*
400	2411	IRHS Assembly	5.00	1.00	
		PERFORMANCE TEST UNIT			
410	2412	IRHS Pack/Inspect	5.00	1.00	
420	SDPP3	Sedalia Production Prep 3 Day	5.00	1.00	
430	2999	Transfer to Inventory	5.00	1.00	
					Transfer to Inventory