

RIBBON REPLACEMENT INSTRUCTIONS  
HIGH CAPACITY BURNERS

To install a new ribbon assembly in an Ensign High Capacity Burner, this procedure should be followed.

1. Remove flanges from both ends of the burner.
2. Loosen hex head bolts on the side of the burner, two per section.
3. Drive up ribbon assembly on open end of burner until 2" or 3" of ribbon is above casting. Put a piece of flat cold rolled steel 6" or 8" long x 3/4" or so wide (1/8" thick) under ribbon assembly (at right angle), and drive or push it along the top of the burner, forcing the ribbon up as you move along. Pry ribbon out at end of burner. Opening the casting slightly with a slightly tapered wedge aids in removal of the ribbon assembly.
4. Using a file, or some sort of abrasive material, remove any build-up of foreign material from sides of slot. Blow entire casting out well.
5. The new ribbon assembly which is welded at one end should be started from the open end from which the flange has been removed. Before starting to install ribbon, drive a wedge in the slot approximately 6" from the end in order to open up the slot just enough to insert the ribbon with ease. Then start the ribbon in the slot with the weld just flush with the end of the casting. Drive ribbon in slightly along the casting, continuing to use the wedge as you go along. When the ribbon has been installed the entire length of the burner, then trim ribbon to fit flush with the flange. Drive the entire assembly down about half way, then start at the end and drive down level with the top of the casting. Then tighten all hex head bolts on side of casting just snug. Take a piece of 1/8" flat stock, 5" or 6" long and slightly narrower than the width of the slot (1/2" to 1-3/8"), and starting at one end, drive the ribbon assembly down until the piece of flat stock is flush with the top of the burner casting. Continue along the length of the burner until the entire assembly is recessed the 1/8" dimension or depth.
6. **Blow out the assembly well** with a high pressure air stream, then tighten all hex head bolts until they feel firm. Extreme pressure may pull the lug out of the inside or crack the casting. 12 to 15 PSI is enough.
7. Reinstall end flanges and burner is ready for use.
8. If the main ports in the assembly start to run slightly off, this can be corrected by inserting four #55 drill blanks or .052" Dia. wire across the assembly all in the same line. Then continue to drive ribbon down and repeat if necessary. Care should be taken when removing the blanks. Using a wedge to open the casting slightly as the ribbon is being installed facilitates the installation and helps to keep the main ports aligned.