



**Stove Body**  
 650 of Ø219mm dia Steam pipe (recycled)  
 Cut hole for exhaust  
 The cut-out becomes the door  
 Cut hole for ash cleaning door  
 Drill 1 x Ø17mm hole for secondary air  
 Drill 3 x Ø13mm holes for primary air

**Material:**  
 219 dia O.D. steam pipe

**Drawing No.**  
 KG3B-1.1-02

вертикальный огонь  
 Vertical Fire  
 Model 3B  
 Version 1.1  
 8 Oct 2016

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50x50x3 Angle iron 900mm long

**Secondary Air Preheater**

**Drawing No.**  
 KG3B-1.1-03

вертикальный огонь  
 Vertical Fire  
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Door with cut from the back

**Door**

**Drawing No.**  
 KG3B-1.1-04

вертикальный огонь  
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Length to suit the inside diameter of the pipe

**Grate Support**

**Drawing No.**  
 KG3B-1.1-05

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**Legs**

**Drawing No.**  
 KG3B-1.1-06

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**Legs assembled with base plate**

**Drawing No.**  
 KG3B-1.1-07

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- 1 Weld the Grate Support level with the lower opening
- 2 Check the fit of the Grate on the Grate Support
- 3 Weld on the Top Deck
- 4 Weld on the Bottom Plate
- 5 Weld on the door hinges, (align door bottom to the bottom plate)
- 6 Weld on the legs
- 7 Add Door handle to suit, see KG3B-1.1-14

**Assemble the stove body**

**Drawing No.**  
 KG3B-1.1-08

вертикальный огонь  
 Vertical Fire  
 Model 3B  
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**Material:**  
 219 dia O.D. steam pipe

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**Chimney Base**

**Drawing No.**  
 KG3B-1.1-09

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**Chimney Connectors**  
 Match the local chimneys

**Drawing No.**  
 KG3B-1.1-10

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**Drawing No.**  
 KG3B-1.1-01

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**Top Deck**

**Drawing No.**  
 KG3B-1.1-11

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**Bottom Plate**

**Drawing No.**  
 KG3B-1.1-12

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**Grate**

**Drawing No.**  
 KG3B-1.1-13

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**Handles**

**Drawing No.**  
 KG3B-1.1-14

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 Vertical Fire  
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