

1. Manufactured and certified by Walker Stainless Equipment Company, Inc. 625 State Street, New Lisbon, WI 53950
(Name and address of Manufacturer)
2. Manufactured for APV HEAT TRANSFER TECHNOLOGIES, 395 Filmore Avenue, Tonawanda, NY 14150
(Name and address of Purchaser)
3. Location of installation FOLGERS COFFEE, 300 West FM Road, Sherman, TX 75091
(Name and address)
4. Type: Vertical Jacketed Vessel SPG-37272
(Horiz., vert., or sphere) (Tank, separator, jkt. vessel, heat exch., etc.) (Mfg's serial No.)
- SPG-37272-1-D, Rev. 2 4959 2003
(CRN) (Drawing No.) (Nat'l. Bd. No.) (Year built)
5. ASME Code, Section VIII, Div. 1 Edition 2001, Ad. 2002 None
(Edition and Addenda (date)) (Code Case No.) (Special Service per UG-120(d))
- Items 8 - 11 incl. to be completed for single wall vessels, jackets of jacketed vessels, shell of heat exchangers, or chamber of multi-chamber vessels.
6. Shell (a) No. of course(s): One (b) Overall length (ft & in.): 2'-7"

Course(s)			Material		Thickness		Long. Joint (Cat. A)			Circum. Joint (Cat. A, B, & C)			Heat Treatment	
No.	Diameter, in.	Length (ft & in.)	Spec./Grade or Type		Nom.	Corr.	Type	Full, Spot, None	Eff.	Type	Full, Spot, None	Eff.	Temp.	Time
1	40.27" ID	2'-7"	SA-240Tp.304		.059"	None	—	—	—	—	—	—	—	—
—	—	—	—		—	—	—	—	—	—	—	—	—	—
—	—	—	—		—	—	—	—	—	—	—	—	—	—

7. Heads: (a) SA-240Tp.304 (b) —
(Mat'l Spec. No., Grade or Type) (H.T.-Time & Temp.) (Mat'l Spec. No., Grade or Type) (H.T.-Time & Temp.)

Location (Top, Bottom, Ends)	Thickness		Radius		Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure		Category A		
	Min.	Corr.	Crown	Knuckle					Convex	Concave	Type	Full, Spot, None	Eff.
(a) Bottom	.07"	None	—	—	—	150°	—	—	—	X	—	—	—
(b) —	—	—	—	—	—	—	—	—	—	—	—	—	—

If removable, bolts used (describe other fastening) —

(Mat'l Spec. No., Grade, size, No.)

8. Type of jacket Type 1, Channel & Type 3, Dimple Jacket closure Ogee & Weld
(Describe as ogee & weld, bar, etc.)

If bar, give dimensions —

If bolted, describe or sketch.

9. MAWP 120 — psi at max. temp. 100 — °F Min. design metal temp. -20 °F at 120 psi.
(internal) (external) (internal) (external)

10. Impact test NO, CHARPY IMPACT TEST EXEMPT PER UHA-51(d), (e), & (f) at test temperature of — °F.
(Indicate yes or no and the component(s) impact tested)

11. Hydro., pneu., or comb. test press. Hydrostatic @ 250 psig Proof test UG-101(m): RT#W-47 & RT#W-48
Items 12 and 13 to be completed for tube sections.

12. Tubesheet:
[Stationary (Mat'l Spec. No.)] [Dia., in. (subject to press.)] (Nom. thk., in.) (Corr. Allow., in.) [Attachment (welded or bolted)]
[Floating (Mat'l Spec. No.)] (Dia., in.) (Nom. thk., in.) (Corr. Allow., in.) (Attachment)

13. Tubes:
(Mat'l Spec. No., Grade or Type) (O.D., in.) (Nom. thk., in. or gauge) (Number) [Type (Straight or U)]

Items 14 - 18 incl. to be completed for inner chambers of jacketed vessels or channels of heat exchangers.

14. Shell (a) No. of course(s): One (b) Overall length (ft & in.): 2'-7"

Course(s)			Material		Thickness		Long. Joint (Cat. A)			Circum. Joint (Cat. A, B, & C)			Heat Treatment	
No.	Diameter, in.	Length (ft & in.)	Spec./Grade or Type		Nom.	Corr.	Type	Full, Spot, None	Eff.	Type	Full, Spot, None	Eff.	Temp.	Time
1	40" ID	2'-7"	SA-240Tp.304		.135"	None	1	None	70%	—	—	—	—	—
—	—	—	—		—	—	—	—	—	—	—	—	—	—
—	—	—	—		—	—	—	—	—	—	—	—	—	—

15. Heads: (a) SA-240Tp.304 (b) —
(Mat'l Spec. No., Grade or Type) (H.T.-Time & Temp.) (Mat'l Spec. No., Grade or Type) (H.T.-Time & Temp.)

Location (Top, Bottom, Ends)	Thickness		Radius		Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure		Category A		
	Min.	Corr.	Crown	Knuckle					Convex	Concave	Type	Full, Spot, None	Eff.
(a) Bottom	0.107"	None	—	—	—	150°	—	—	Convex	—	1	None	70%
(b) —	—	—	—	—	—	—	—	—	—	—	—	—	—

If removable, bolts used (describe other fastening) —

(Mat'l Spec. No., Grade, size, No.)

Platform 01-02E01

FORM U-1 (Back)

pal at max. (

°F. Min. design n

temp. _____

°F at _____

psi.

(internal)

(external)

(internal)

(external)

Impact test NO. CHARPY IMPACT TEST EXEMPT PER UHA-51(d), (e), & (f) at test temperature of _____ °F.

(Indicate yes or no and the component(s) impact tested)

8. Hydro., pneu., or comb. test press. _____

Proof test _____

19. Nozzles, inspection, and safety valve openings:

Purpose (inlet, Outlet, Drain, etc.)	No.	Diameter or Size	Flange Type	Material		Nozzle Thickness		Reinforcement Material	How Attached		Location (Insp. Open)
				Nozzle	Flange	Nom.	Corr.		Nozzle	Flange	
Jkt. Inlet/Outlet	2	1 1/2"	150#LAPJNT	SA312Tp.304	SA182F 304	.145"	None	---	UW16.1(a)	2-4(3)	---
Jkt. Inlet/Outlet	2	1"	150#LAPJNT	SA312Tp.304	SA182F 304	.133"	None	---	UW16.1(a)	2-4(3)	---

20. Supports: Skirt No Lugs --- Legs 4 Others --- Attached Bottom --- Welded
(Yes or No) (No.) (No.) (Describe) (Where and how)21. Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report
(List the name of part, item number, mfg's. name and identifying number)None22. Remarks: 250 Gallon Crude Caffeine Crystallizer with Code jacket. --- Customer to supply and install proper safety valves. ---Item 11.) Proof test: BT#W-47 and BT#W-48 were tested and accepted by Inspector on April 4, 1996. ---Lap joint flanges are ANSI B16.5. --- Hydro-testing performed with vessel in vertical position. ---Formed channel headers are SA240Tp.304. --- Jacket: "For Noncorrosive Service". ---

CERTIFICATE OF SHOP COMPLIANCE

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME Code for Pressure Vessels, Section VIII, Division 1.

U Certificate of Authorization No. 5.842Expires 06/302006Date 06/18/2003Name Walker Stainless Equipment Company, Inc.

(Manufacturer)

Signed

Marshall M. Kuehl
(Representative)

CERTIFICATE OF SHOP INSPECTION

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of Wisconsin and employed by HSB CT of Hartford, Connecticut have inspected the pressure vessel described in this Manufacturer's Data Report on April 15, 2003, and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME Code, Section VIII, Division 1. By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.Date 6/18/03

Signed

R. Jamie Wertz
(Authorized Inspector)

Commissions

NB1202SA, WI 250982

(Nat'l Board Incl. endorsement, State, Province and No.)

CERTIFICATE OF FIELD ASSEMBLY COMPLIANCE

We certify that the statements on this report are correct and that the field assembly construction of all parts of this vessel conforms with the requirements of ASME Code, Section VIII, Division 1.

U Certificate of Authorization No. _____

Expires _____

Date _____

Name _____

(Assembler)

Signed _____

CERTIFICATE OF FIELD ASSEMBLY

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of _____ and employed by _____

have compared the statements in this Manufacturer's Data Report with the _____

_____ not included in _____

and belief, the Manufacturer has constructed and assembled this vessel

was inspected and subjected to a hydrostatic test of _____

expressed or implied, concerning the pressure vessel described in this

be liable in any manner for any personal injury or property damage or a

Date _____ Signed _____

(Authorized Inspector)

Post-it® Fax Note

To CHUCK MENTION

Co./Dept.

Phone #

Fax # 903 870 9405

7671

Date

From

Co.

Phone #

Fax #

of pages 2BUS DEASY

vessel

any warranty,

Inspector nor his employer shall

this inspection.

(Nat'l Board Incl. endorsement, State, Province and No.)