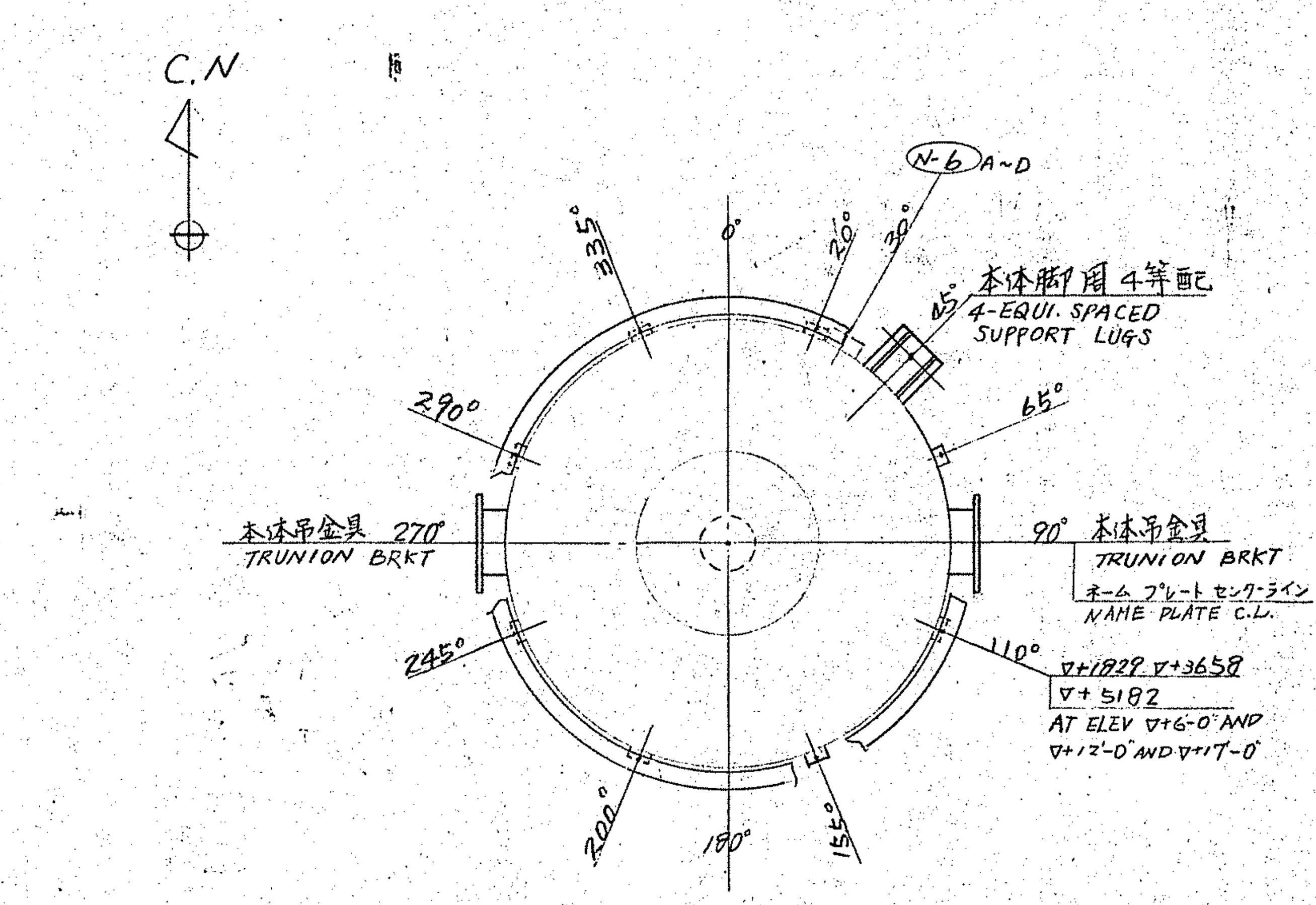
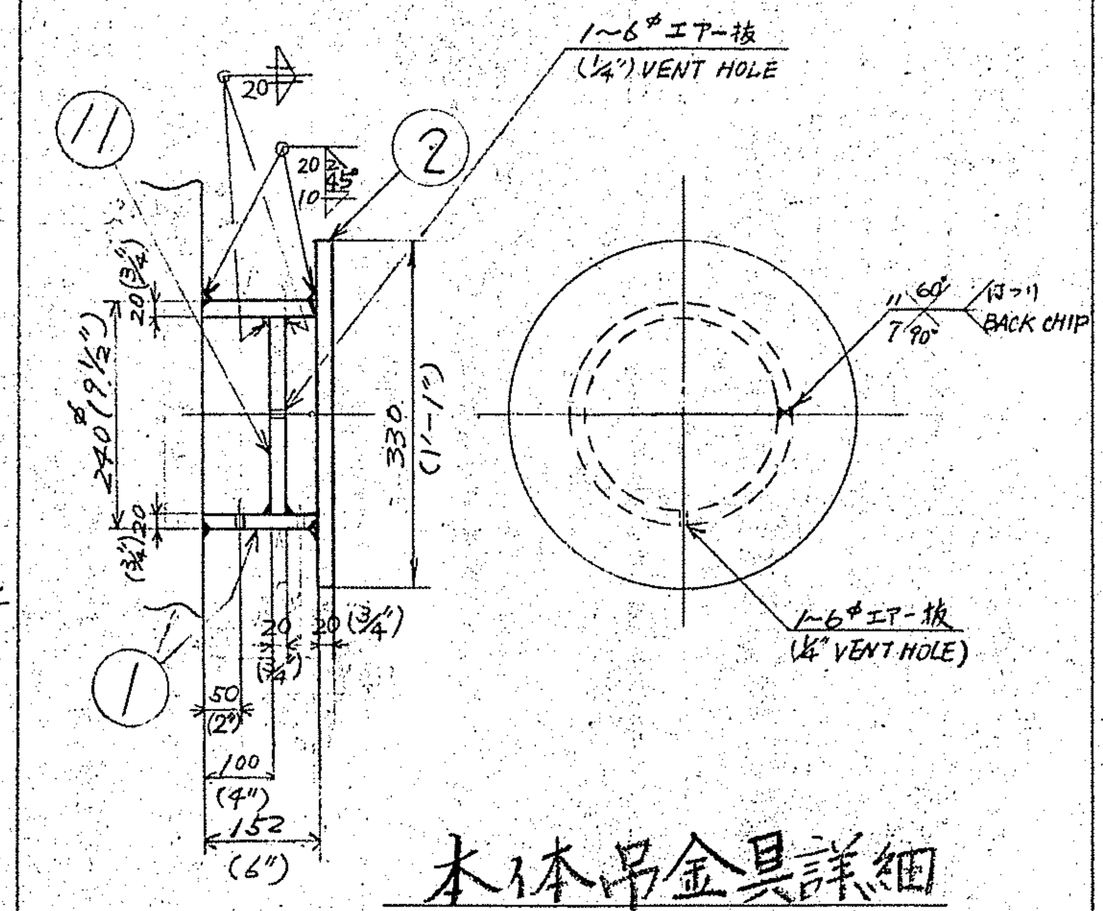
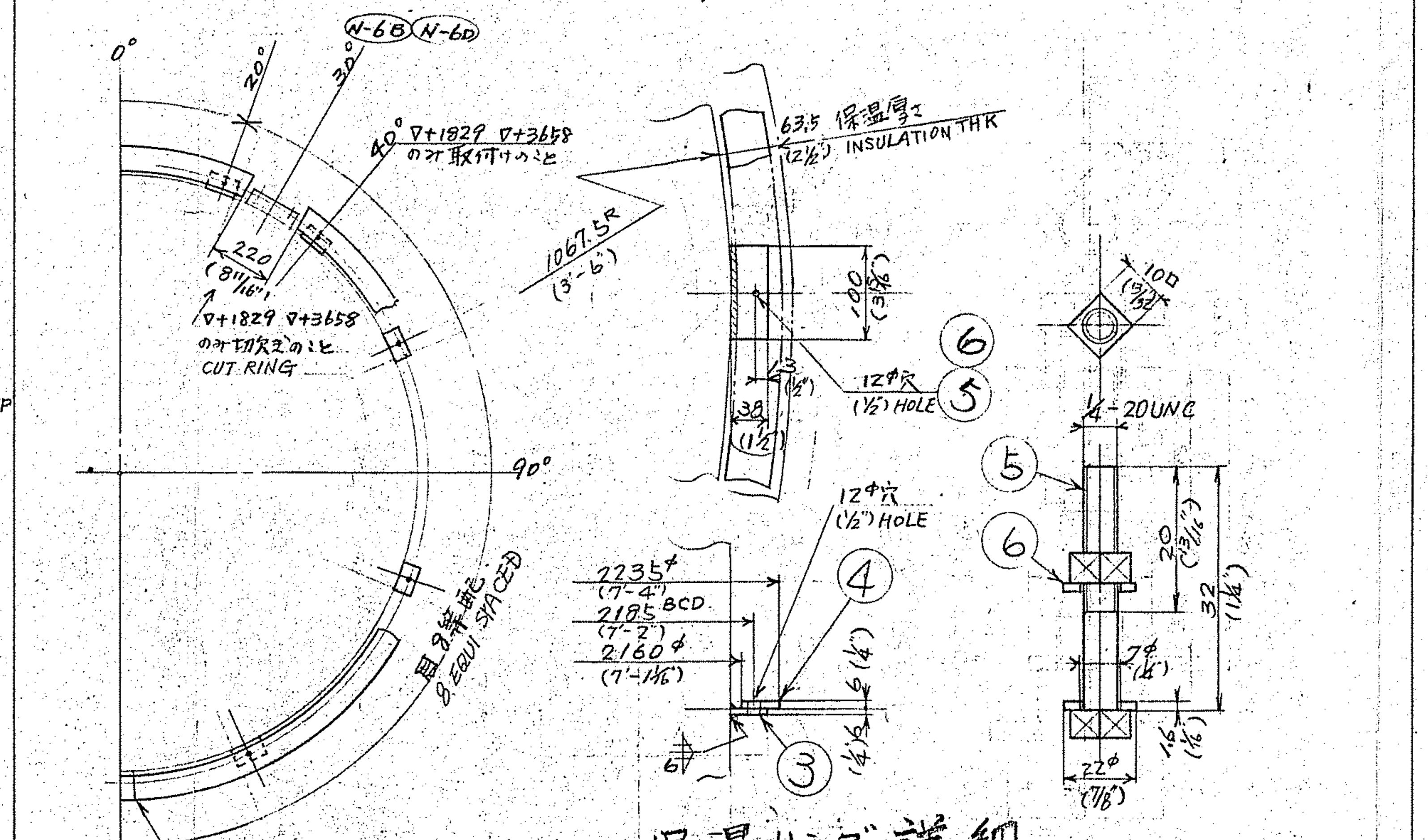
5,000





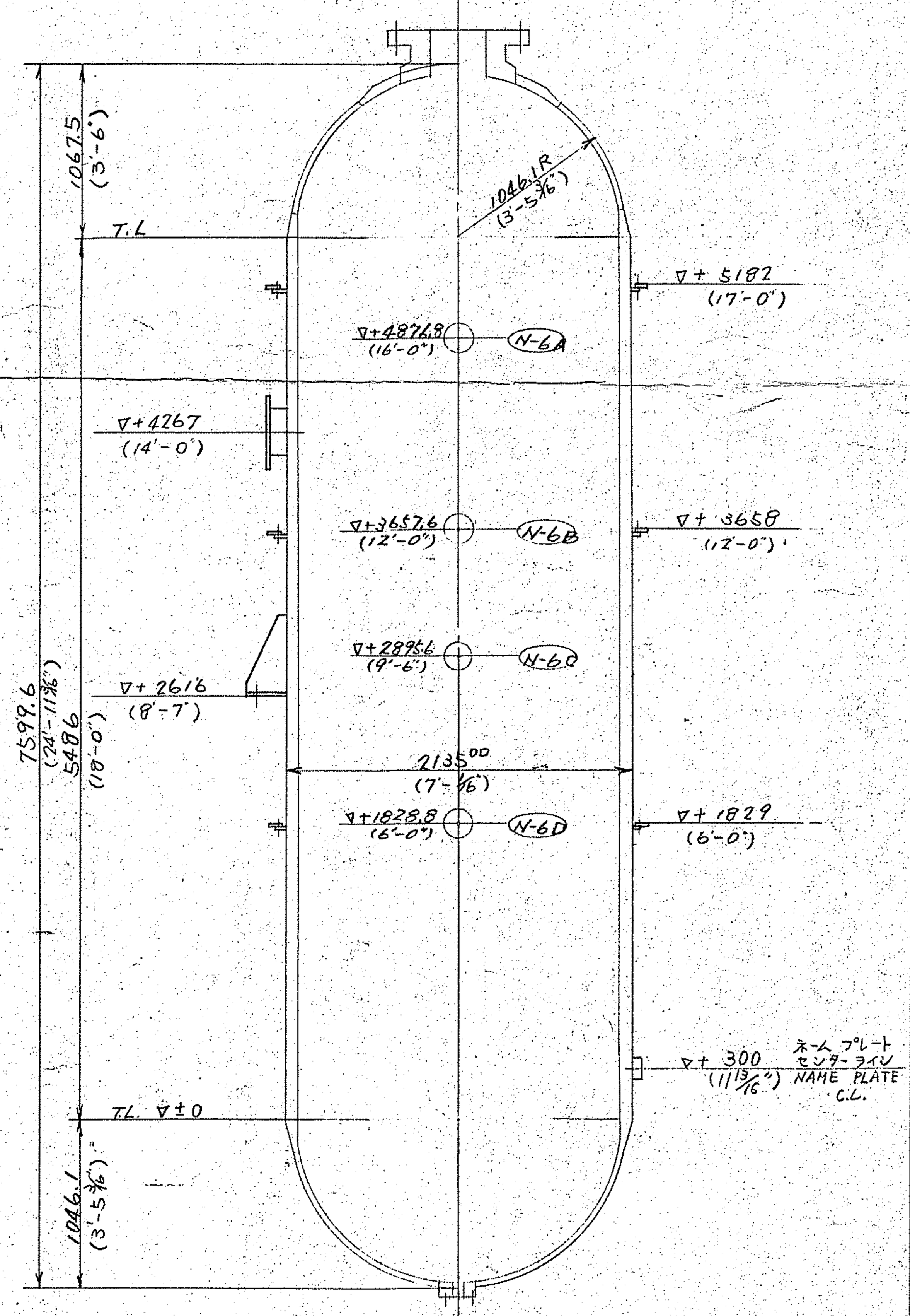
本体吊金具詳細
DETAIL OF TRUNION



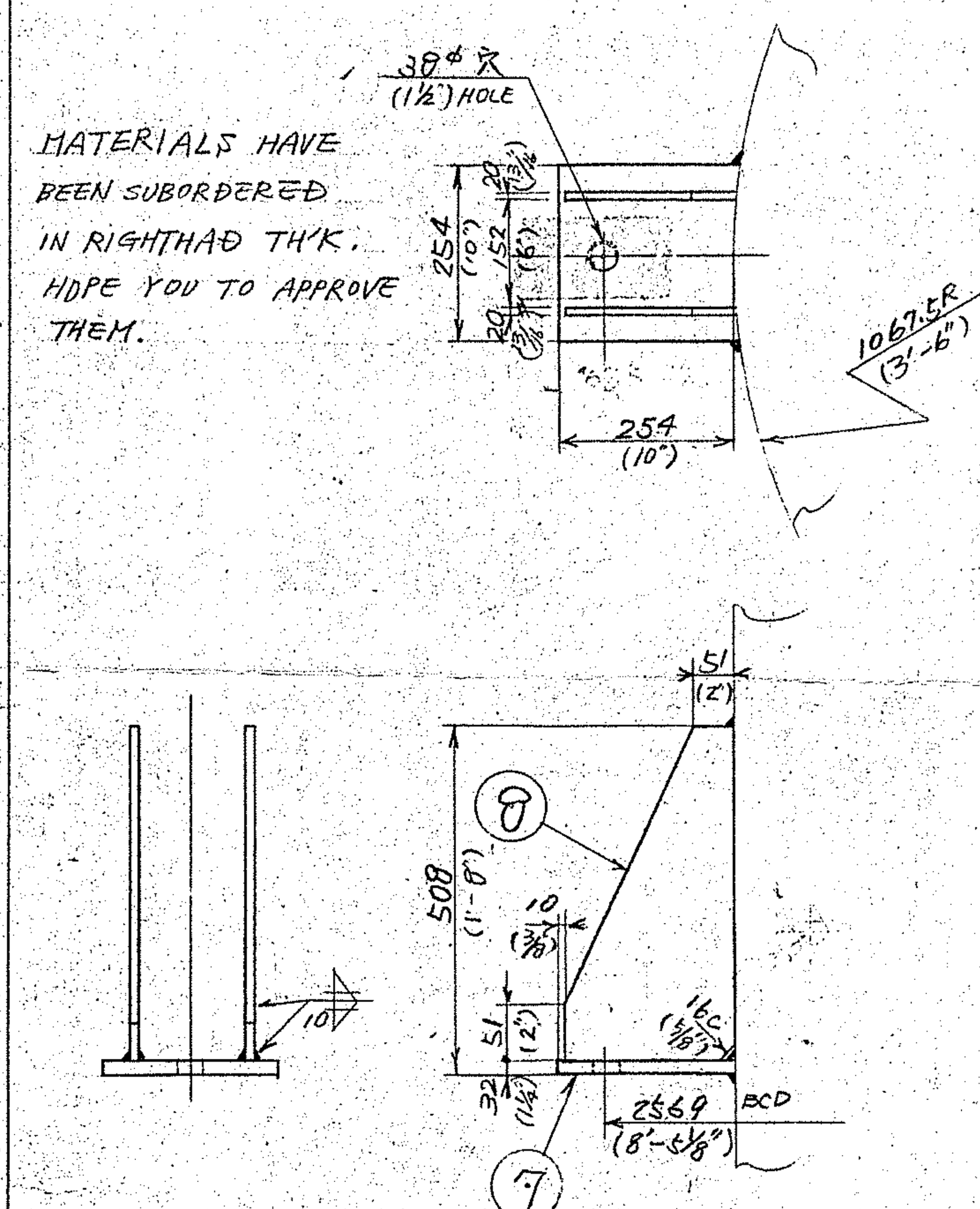
保温リング詳細
INSULATION RING DETAIL

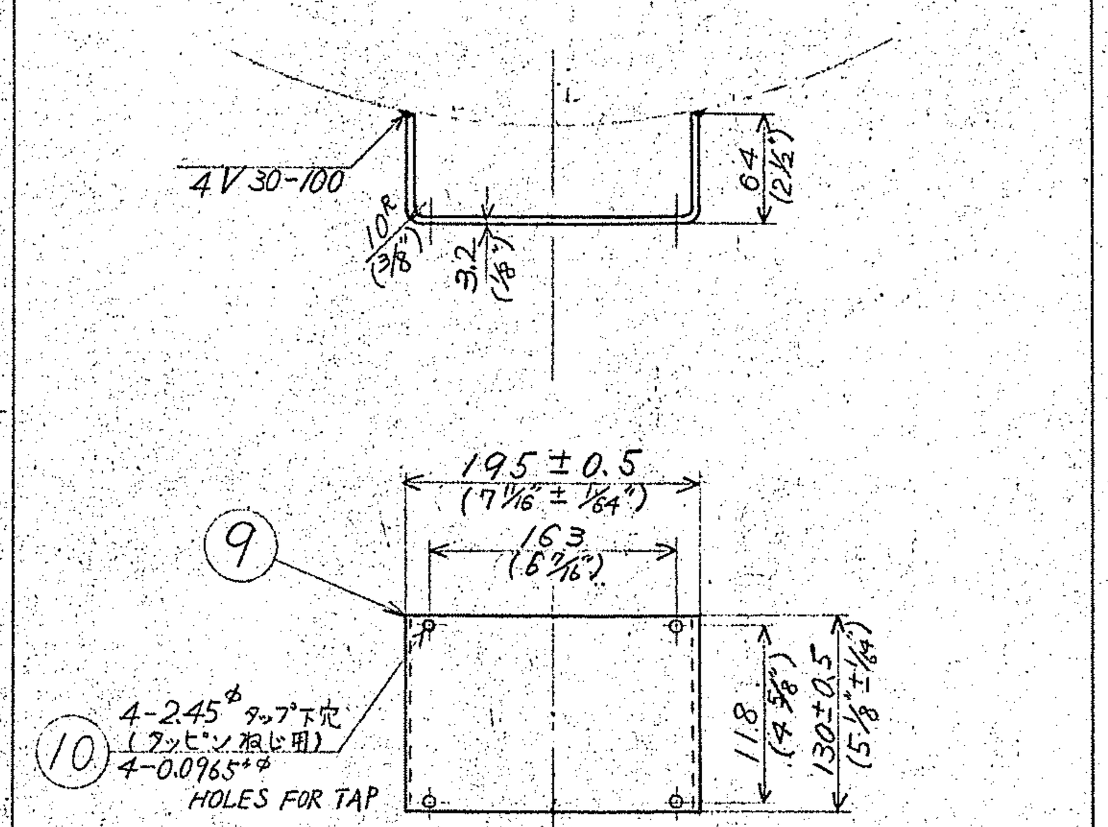
NOTES

1. REFERENCE DWG 参照図面
SHELL (1/2) - - - - - - - CK 29709



MATERIALS HAVE BEEN SUBORDERED IN RIGHTHAD TH'K. HOPE YOU TO APPROVE THEM.





ネームプレート取付座詳細
DETAIL OF NAME PLATE SUPPORT

PART NO.	NAME		MATERIAL JIS		QTY FOR / SET REG	SPARE	TOTAL	REMARKS
11	支エ板	PLATE	SB42-SR		2			
10	タッピンネジ M3×8ℓ	TAPPING SCREW	SWRM3		4			⑦
9	ネーム プレート 取付座	NAME PLATE SUPPORT	SB42		1			
8	リブ	RIBS	SB42-SR		8			
7	脚	LUGS	SB42-SR		4			
6	ざがね	WASHERS	SS41		52			④
5	四角頭ボルト及ナット	SQUARE BOLT & NUTS	SS41		26 SETS			④
4	保温リング	RINGS	SS41		3 SETS			
3	ラグ	LUGS	SS41		26			
2	エンドプレート	PLATES	SB42-SR		2			
1	本体吊金具	TRUNIONS	SB42-SR		2			

1 SET TO BE MANUFACTURED

SCALE 1/30, 1/20, 1/5

CUSTOMER,S APPROVAL

NOTE

FINAL

FW CONTRACT NO 1-15-1442
FW REQ NO 1442-1131-A
FW ORDER NO 1026/1440

TITLE

F-1215

DISSOLVER
EXTERNAL

I.C.I FIBRES LTD/PROTEST P45/WILTON TEESSIDE

ISSUE

DESIGN DEPARTMENT DEC 27 1971 TAMANO WORKS

CHEMICAL PLANT DIVISION
MITSUI SHIPBUILDING & ENGINEERING CO., LTD.

DRAWN OHSHITA	JUN 29 1971	JOB CLASSIF NO D13004	JOB NO. TC 3368
CHKD [illegible] Nakamura	July 6 1971		WORKS 玉
CHKD			DWG NO. CK 29714
APPD [illegible]	July 6 1971		REV ①

化設 ③

第三角法
THIRD ANGLE PROJECTION

フランジ類の穴割りは特記の外中心線に対し振り分けとする
ALL BOLT HOLES SHALL STRADDLE CENTER LINE UNLESS OTHERWISE NOTED

⓪	JUN 29 1971	ISSUED FOR APPROVAL	
①	July 20 1971	ANCHOR BOLT CIRCLE DIA. AND DIMENSION OF TRUNION BRKT CHANGED	

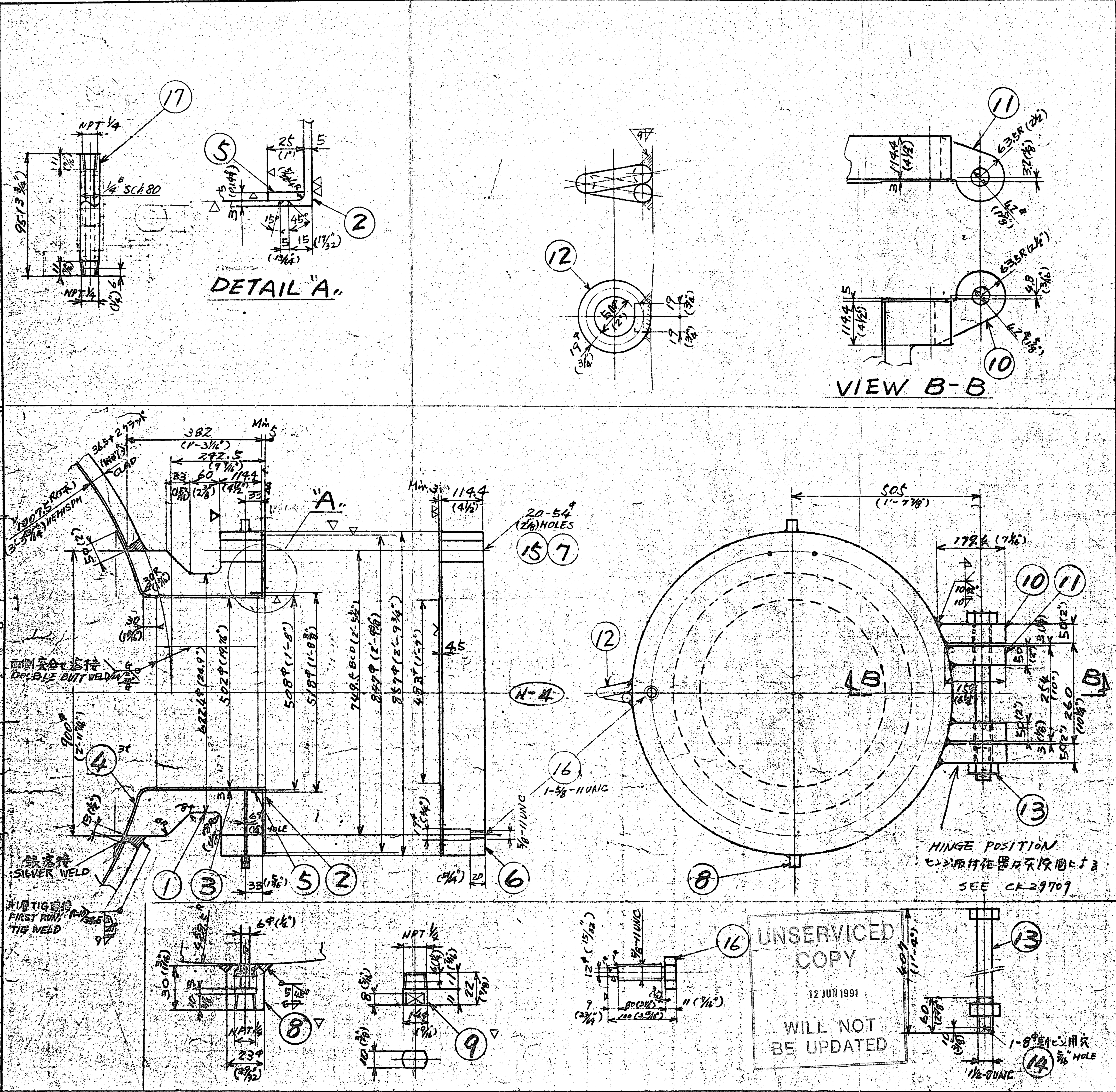
FINAL

承認 再承
参考 提出
完成 準備
見積 材手
検討 返図

変更急送

配布先

I.C.I. DRG NO F/X/B/417764



NOTES:

1. REFERENCE DWG 参照図面

SHELL (1/2) - - - - - - CK 29709

2. Fe AND H CONTENT IN TP28 (EQUIV. IMI 115) TO BE AS FOLLOWS.

$Fe \leq 0.050\%$ $H \leq 60PPM$

3. COUPLING WELDS FOR ALL TELL-TALE HOLES TO BE DYE PENETRANT CHECKED BEFORE AND AFTER HEAT TREATMENT.
ハーフカップリング溶接部は熱処理(SR)の前后2回カラーチェックの事
又. EXTENSION PIPEは現地で取付けの為別途発送のこと.
4. ALL NOZZLE LINERS TO BE GR FLUSH.
全てのノズルライナーは面一にグラインダー掛けの事.
5. GASKET SURFACES SHLL BE MACHINED TO 125CLA FINISH.
ガスケット面は125CLA.

PART NO.	NAME		JIS MATERIAL	MATERIAL	REG QTY FOR / SET	SPARE	TOTAL	REMARKS
17	エクステンション パイプ	EXTENSION PIPE	STS38		2			
16	起動ボルト	STARTING BOLT	SS41		1			④
15	全ネジ B.N 2-8UN x 355	FULL THREADED BOLT & NUTS		B A193-B7 N A194-2H	20 SETS			④ ヘビーナット
14	割ピン 8φx65ℓ	SPLIT PIN	SWRM3		1			④
13	B.N	BOLT & NUT	SS41		1 SET			④
12	吊輪	RING	SS41		1			
11	ヒンジ	HINGES	SS41		2			
10	ヒンジ	HINGES	SS41		2			
9	プラグ NPT 1/4	PLUGS		A105 Gr II	2			④
8	ハーフカップリング NPT 1/4	HALF COUPLINGS		A105 Gr II	2			④
7	ガスケット 680φ/520φx1.6t	GASKET		V# 1500	1			④ C.A.F
6	盲フランジ	BLIND		A105 Gr II +TP28 CLAD	1			
5	リング	RING	TP28		1			
4	ライニング	LINING	TP28		1			
3	ライニング	LINING	TP28		1			
2	ライニング	LINING	TP28		1			
1	(N-4) ノズル	NOZZLE		A105 Gr II	1			

1 SET TO BE MANUFACTURED — SCALE 1/8

CUSTOMER.S APPROVAL — NOTE

FINAL

FW CONTRACT NO 1-15-1441
FW REQ. NO 1441-1123-A
FW ORDER NO 1026/1440

TITLE (F-1215) DISSOLVER MAN HOLE

I.C.I FIBRES LTD/PROJECT P&S/WILTON TEESSIDE

CHEMICAL PLANT DIVISION
MITSUI SHIPBUILDING & ENGINEERING CO., LTD.

DRAWN	K. Nabe	MAR 8 1971
CHKD	M. Nakamura	APR. 14 1971
CHKD		
APPD	M. Sakamoto	April 14 1971

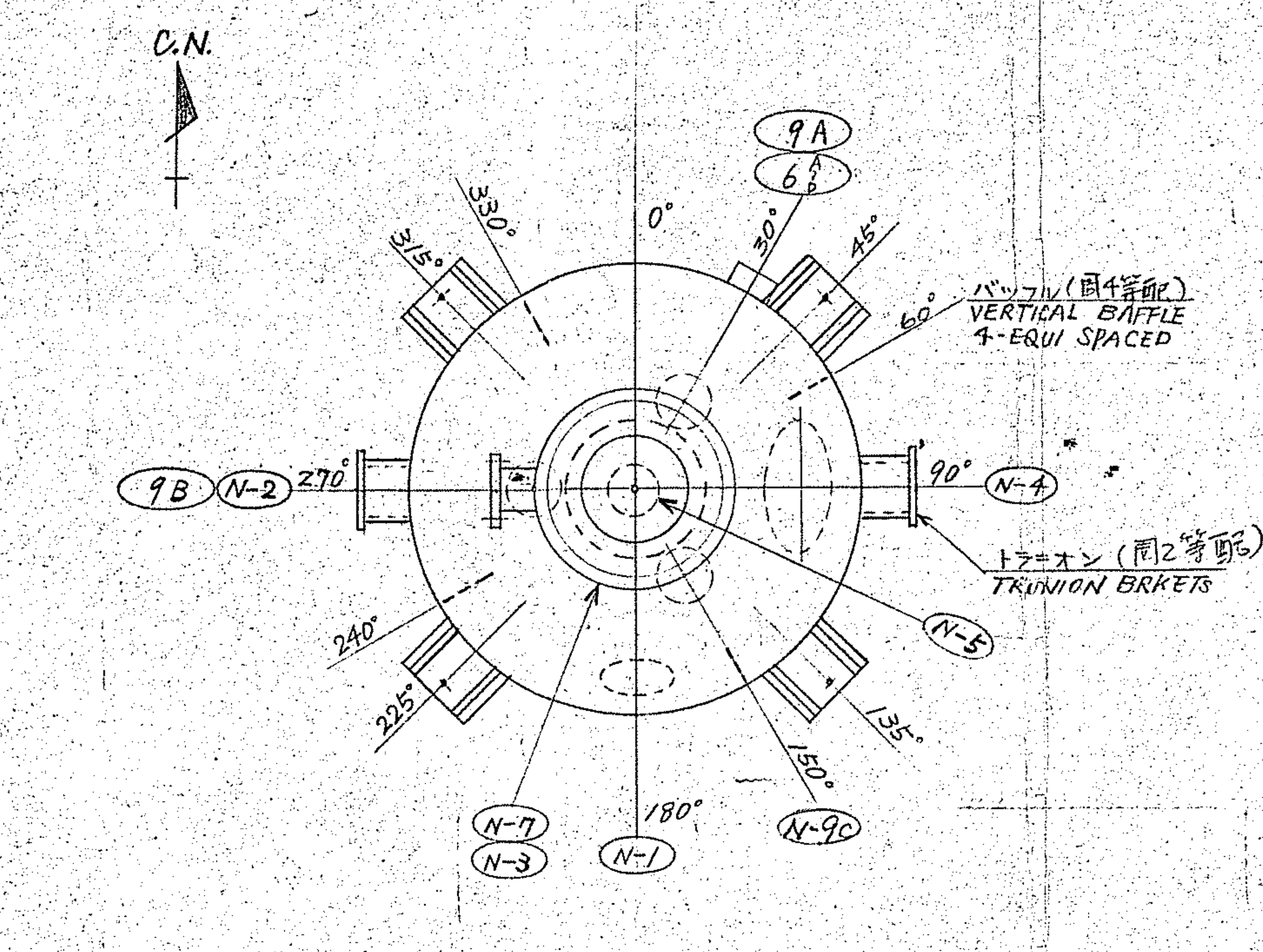
JOB CLASSIF NO. D13004 — JOB NO. TC 3368 — WORKS 玉 — DWG NO. CK 29711 — REV ④

REV	DATE	DESCRIPTION
0	MAR 9 1971	ISSUED FOR APPROVAL
1	June 24 1971	FL'G THK. TO BE CORRECTED
2	July 16 1971	EXTENSION PIPE TO BE CHANGED & MIN. TH'K ADDED
3	July 28 1971	NOTES. HINGE POSITION
4	August 9 1971	N-4 WELD BEVEL CHANGED
5	Aug. 23 1971	NOZZLE PROJECTION CHANGED (MISS FABRICATION)

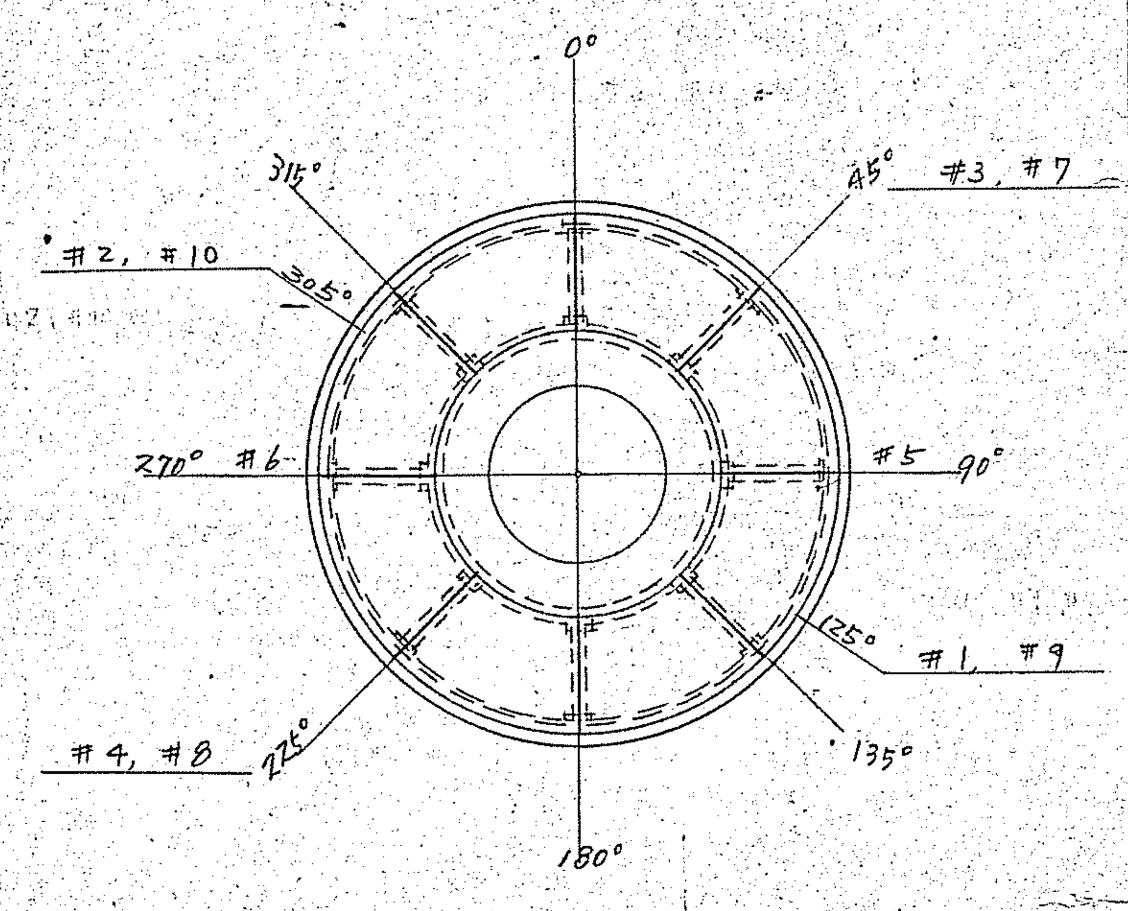
第三角法 THIRD ANGLE PROJECTION

フランジ類の穴割りは特記の外中心線に対し振り分けとする
ALL BOLT HOLES SHALL STRADDLE CENTER LINE UNLESS OTHERWISE NOTED.

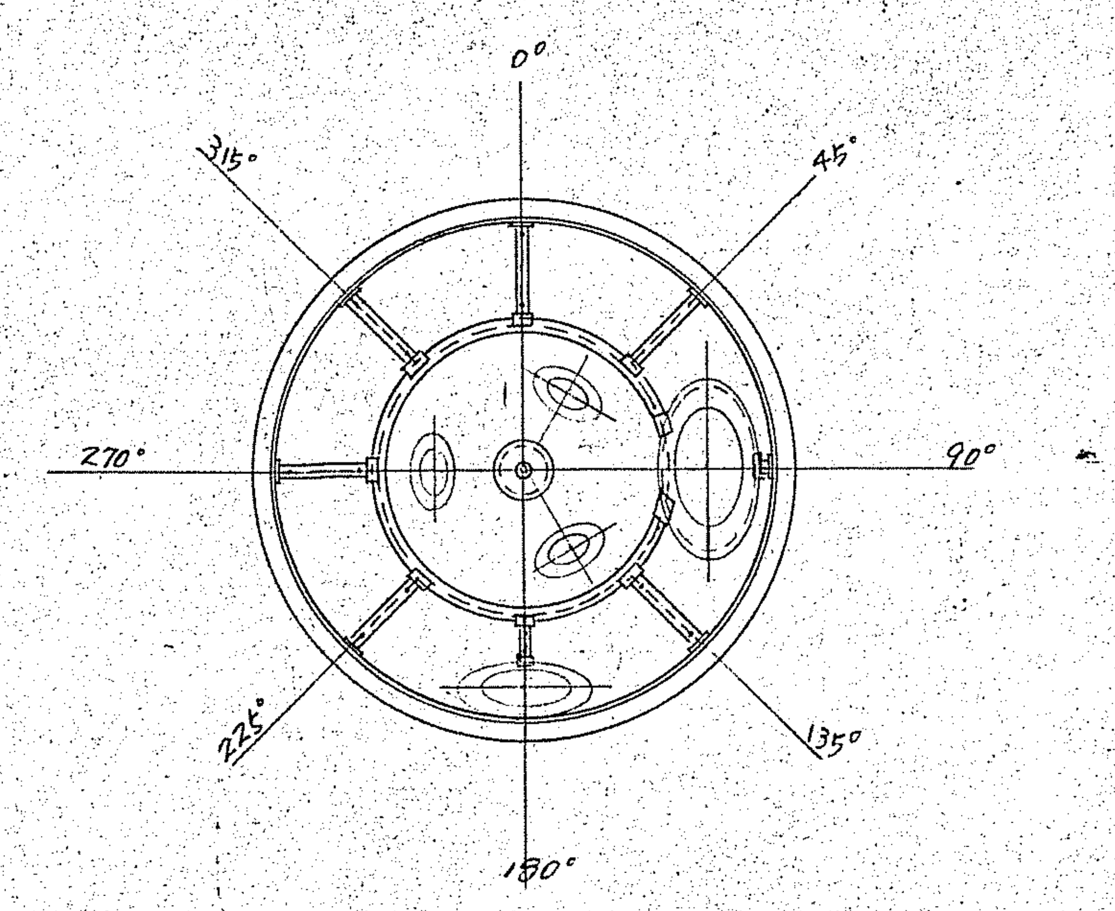
I.C.I DRG. No F1X1B-417782



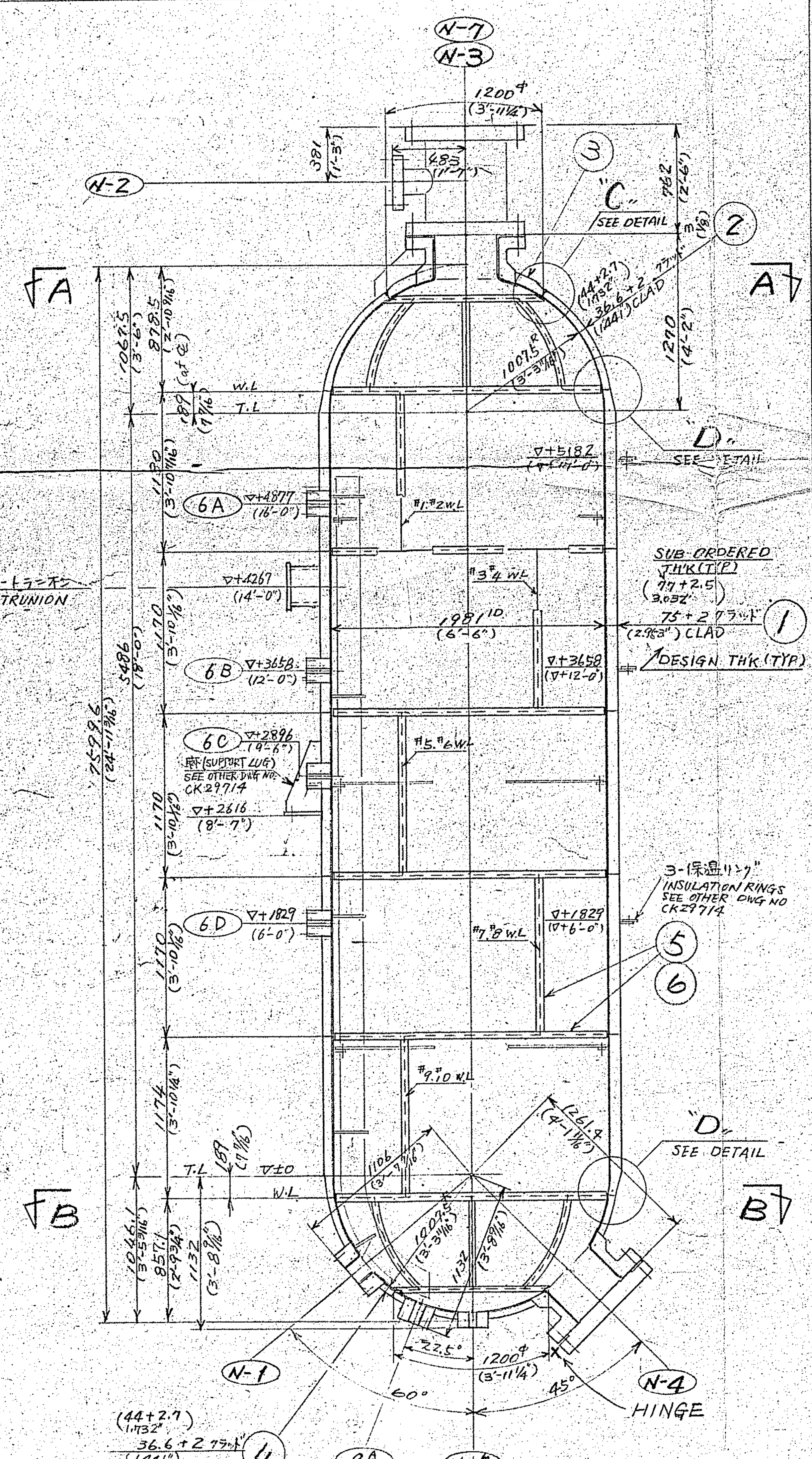
NOZZLE ORIENTATION

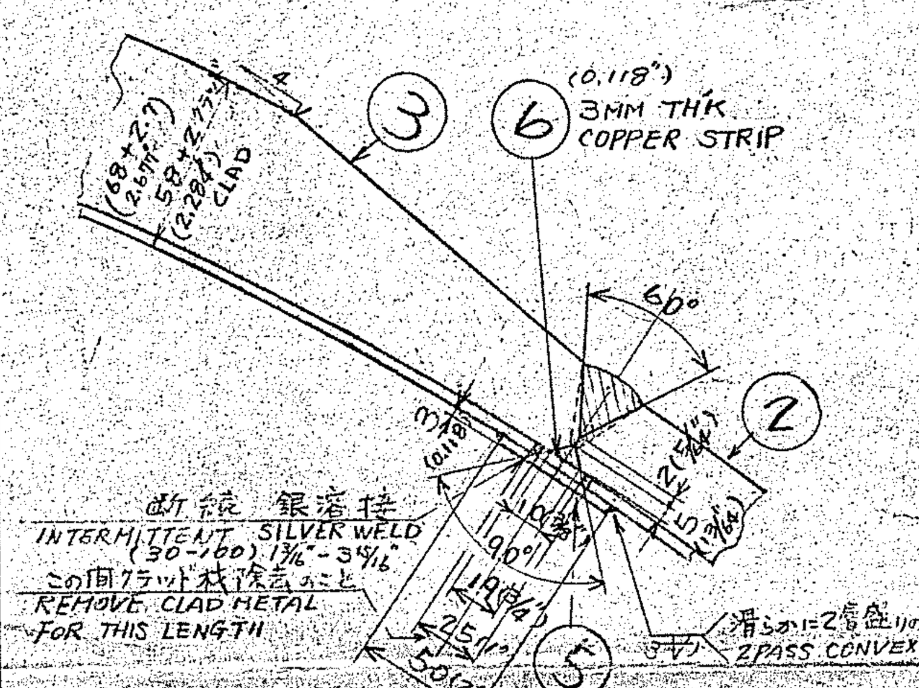


VIEW A - A

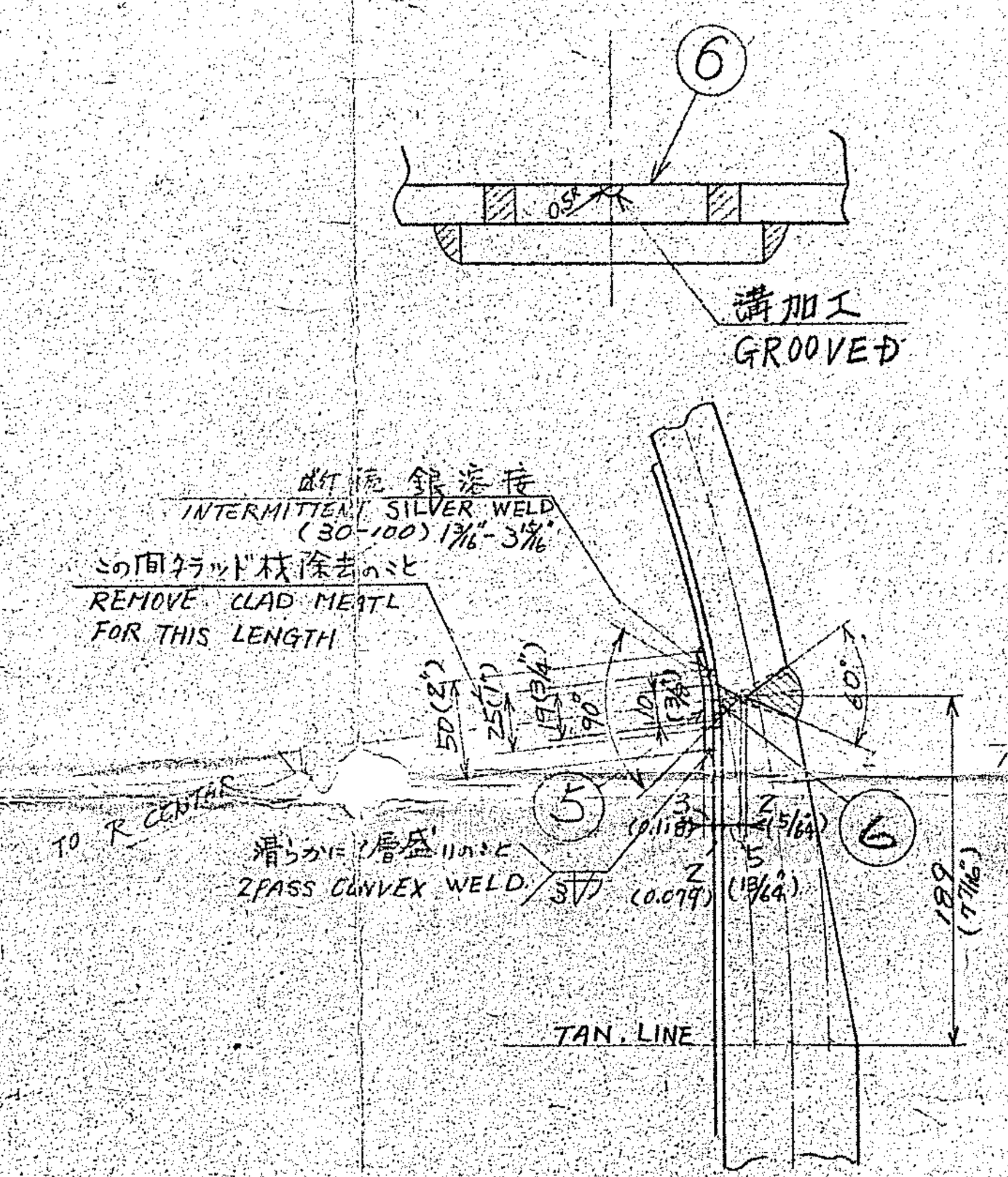


VIEW B - B

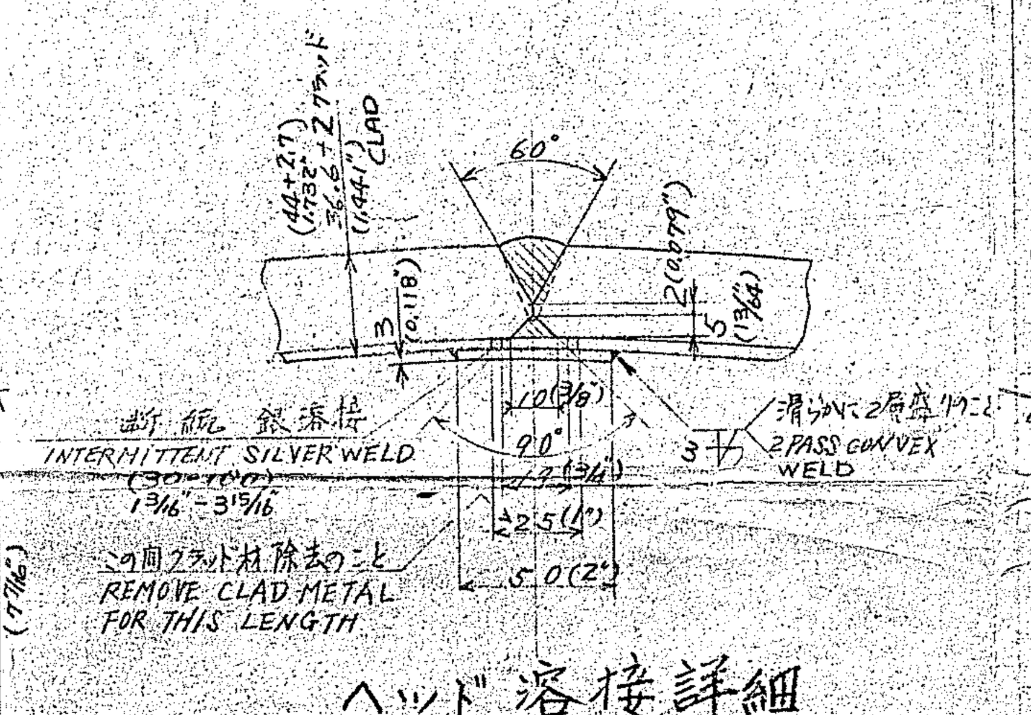




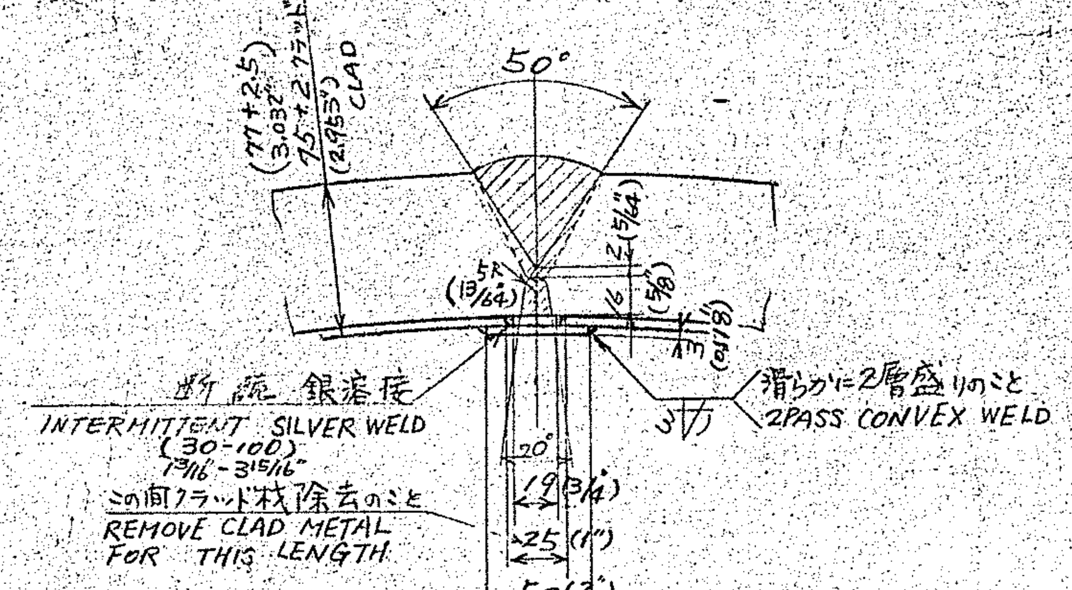
DETAIL "C"



DETAIL "D"



ヘッド溶接詳細
DETAIL OF WELD SEAM FOR HEAD



シエル周及び長手溶接詳細
DETAIL OF CIRCUM & LONG. WELD SEAM FOR SHELL

NOTES

1. THE FOLLOWING INFORMATION TO BE CLEARLY PRINTED ON SIDE OF FINISHED VESSEL.
見やすい所に下記記入の事

HEAT TREATED VESSEL
NO WELDING PERMITTED

2. VESSEL ITEM NUMBERS SHALL BE STENCILED IN AT LEAST TWO CONSPICUOUS LOCATIONS ON THE VESSELS.
機器番号を見やすい所に少なくとも2ヶ所ステンシルの事

NOTES

1. REFERENCE DWGS 参照図面

NOZZLE — CK29710 INTERNAL — CK29713
MANHOLE & MANHOLE DAVIT — CK29711 EXTERNAL — CK29714
NAME PLATE — CK29712 SHELL (2/2) — CK29715

2. TWO THICKNESSES ARE SHOWN ON THIS DRAWING. ONE IS SUBORDERED THICKNESS AND THE OTHER DESIGN THICKNESS.
板の厚さは( )内が手配板厚,( )のないのが設計板厚である.

3. Fe AND H CONTENT IN TP28 TO BE AS FOLLOWS
Fe ≦ 0.050% H ≦ 60 ppm

4. REFERENCE SPECIFICATIONS

(1) SPECIFICATION FOR Ti. CLAD VESSELS	1441-1102A
(2) DESIGN & CONSTRUCTION REQUIREMENTS	1441-10A1
(3) HEAT TREATMENT PROCEDURE	FT-7141
(4) CLEAN ROOM CONSTRUCTION	FT-7143
(5) FORMING PROCEDURE FOR HEADS	FT-7142
(6) TESTING PROCEDURE FOR BOND STRENGTH OF CLAD PLATE	71P-5

5. GENERAL NOTES

(1) MANWAY TO BE PROVIDED WITH DAVIT. M.Hはダビット付.
(2) 1-C.A.F. GASKET FOR TRANSIT SUPPLIED FOR EACH BLANKED CONNECTION (SERVICE GASKET NOT BY VESSEL FABRICATOR).
(3) GASKETS MAY BE C.A.F. FOR HYDROSTATIC TESTING. テストガスケットはアスベストシート
(4) THREADING TO BE U.N.C. WITH 8 THREADS/INCH FOR 1" DIA & OVER UNLESS OTHERWISE NOTED. 指定なき限り 1"以上 8山/in, U.N.C
(5) ALL PAD TYPE NOZZLES TO BE SUPPLIED WITH STUD BOLTS.
パッド タイプ ノズルは スタッドボルト付.
(6) WELDING PROCEDURES REQUIRED FOR ALL ALLOY MATERIALS & THE WELDING OF DISSIMILAR METALS.
アロイ及び異種金属のEWは W.P. 提出の事
(7) ALL ELEVATIONS TAKEN FROM BOTTOM TAN. LINE.
(8) ALL INTERNALS TO BE REMOVABLE THROUGH MAN WAY OR NOZZLES.
内部品は全て M.H 又はノズルより取出可能な事
(9) ALL INTERNAL PIPES TO BE REMOVABLE THROUGH NOZZLES. MITRE BENDS ARE NOT TO BE USED. 内挿管はノズルより取出可能

6. INSPECTION REQUIREMENTS

PROCEDURE OF FABRICATION, INSPECTION AND TESTING SHALL BE IN ACCORDANCE WITH FOLLOWING SPECIFICATIONS.
1) 1441-1102A SPECIFICATION FOR TITANIUM CLAD VESSELS.
2) 1441-10A1 DESIGN AND CONSTRUCTION REQUIREMENTS FOR PRESSURE VESSELS.
3) 1441-1100A GENERAL NOTES FOR PRESSURE VESSELS.
製作, 検査要領は上記到来仕様書による.

DESIGN DATA

NO. REQUIRED		1 SET
CODE		ASME SECT VIII DIV.1 (1968)
TYPE		
HEATING SURFACE		—
CAPACITY OR DUTY	NOMINAL	
	ACTUAL	
DESIGN PRESS.		88.07 kg/cm² (1252.6 PSI)
DESIGN TEMP.		307.2°C
OPERATING PRESS		73.82 kg/cm² (1050 PSI)
OPERATING TEMP		279.4°C
STRESS RELIEF		YES
RADIOGRAPH		FULL (100%)
CORROSION ALLOW		2 mm Ti
JOINT EFFICIENCY		100%
WELDER'S QUALIF		ASME IX
INSULATION		HOT 2½" THK (BY OTHERS)
PAINTING	SHOP	PRIMER 1
	~~FIELD~~	
PACKING		
TEST PRESS.	VACUUM	
	PNEUM.	
	HYDRO.	132.2 kg/cm² (1880 PSI)
TOLERANCE F.W. STD		1441-10B11.6
~~SHAPE OF BEVEL~~		~~A B C D~~
WEIGHT	EMPTY	31,500 kg (69,400 lb)
	FULL OF WATER	56,600 kg (125,000 lb)

NOZZLE LIST

MARK No	NOMIN SIZE	NO	FLANGE RATING	FLANGE TYPE	FLANGE FACE	I.DIA CONN	SERVICE	NOZZLE PROJECTION ℄ OF SHELL TO FLG FACE
N-9A,C	3"	3	ANSI 900Lb	PAD	F.F.	3" I.D.S	STEADY BEARING	SEE DWG
N-8		~~DELETED~~						
N-7	16"	1	ANSI 900Lb	L.W.N	F.F.	16" I.D.S	AGITATOR CONN	SEE DWG
N-6A,D	1½"	4	ANSI 900Lb	PAD	F.F.	1½" I.D.S	T.I	1103 (3'-7 7/16")
N-5	3"	1	ANSI 900Lb	PAD	F.F.	3" I.D.S	DRAIN	SEE DWG
N-4	20"	1	ANSI 900Lb	L.W.N	F.F.	20" I.D.S	MANWAY	SEE DWG
N-3	16"	1	ANSI 900Lb	L.W.N	F.F.	16" I.D.S	SPOOL PAD	SEE DWG
N-2	6"	1	ANSI 900Lb	L.W.N	F.F.	I.D.S 5.761	SOLUTION OUTLET	SEE DWG
N-1	6"	1	ANSI 900Lb	PAD	F.F.	6" I.D.S	FEED INLET	SEE DWG

PART NO.	NAME		MATERIAL	JIS	QTY FOR / SET REQ	SPARE	TOTAL	REMARKS
6	当板	STRIP	DCP1-0		95M			COPPER
5	当板	STRIP	TP28		95M			TP28 EQUIV. 1111 115
4	ヘッド	BOTTOM HEAD	A516-70 +TP28 CLAD		1 SET			〃
3	ヘッド	TOP HEAD	A516-70 +TP28 CLAD		1			〃
2	ヘッド	TOP HEAD	A516-70 +TP28 CLAD		1 SET			〃
1	シエル	SHELL	A516-70 +TP28 CLAD		1 SET			TP28 EQUIV. 1111 115

1 SET TO BE MANUFACTURED — SCALE 1/30

CUSTOMER'S APPROVAL — NOTE

FINAL

FW CONTRACT NO 1-15-1442
FW REQ NO 1442-1131-A
FW ORDER NO 1026/1440

TITLE: F-1215 DISSOLVER SHELL (1/2)

I.C.I FIBRES LTD/PROJECT P45/WILTON TEESSIDE

ISSUE: DESIGN DEPARTMENT DEC 27 1971 TAMANO WORKS

CHEMICAL PLANT DIVISION
MITSUI SHIPBUILDING & ENGINEERING CO., LTD.

DRAWN		MAR. 1 1971	JOB CLASSIF NO D13 004
CHKD	[illegible]	Mar 10 '71	JOB NO. TC 3368
CHKD			DWG NO. CK 29709
APPD	[illegible]	MAR. 10 1971	REV. 3

第三角法 THIRD ANGLE PROJECTION

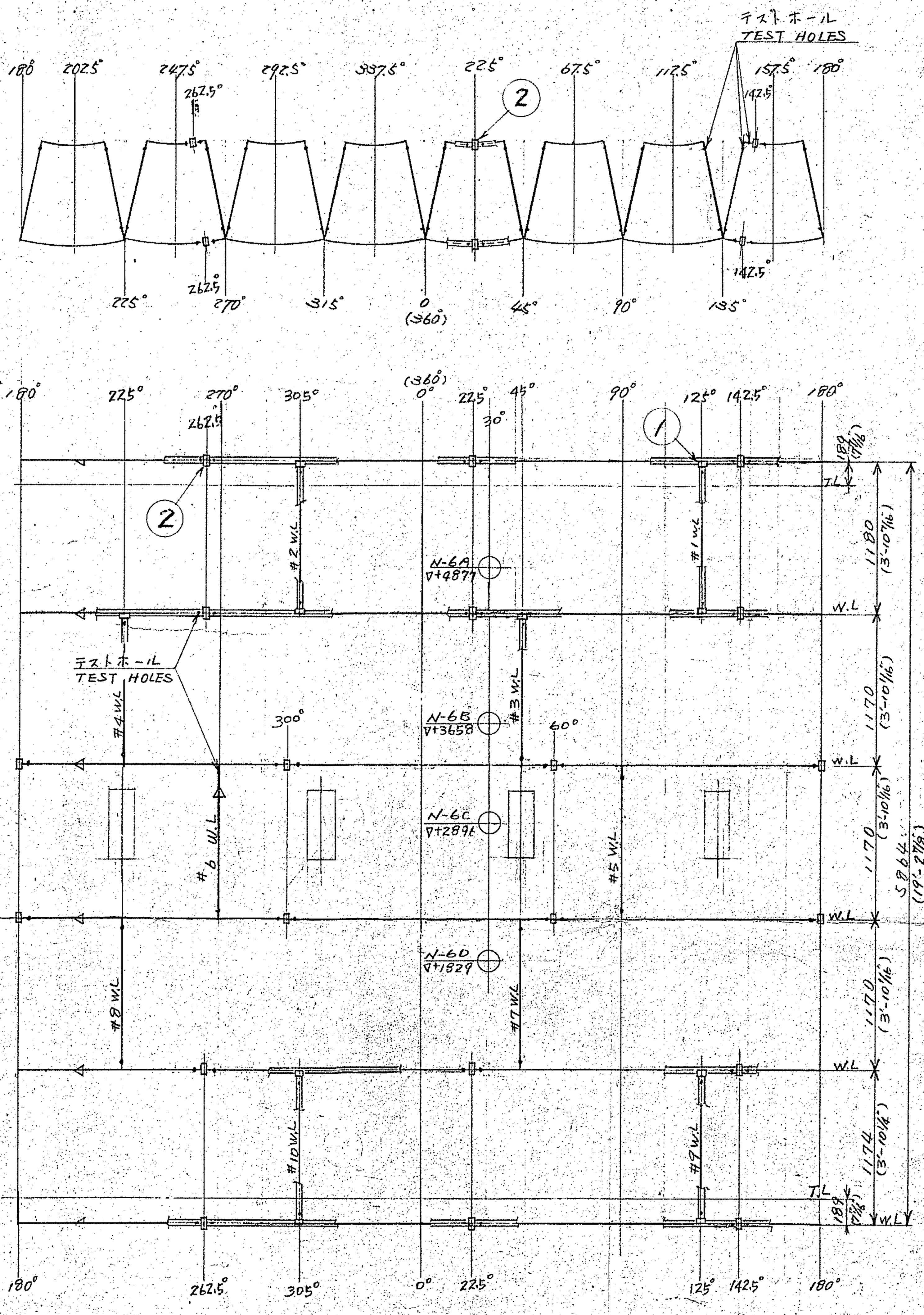
フランジ類の穴割りは特記の外中心線に対し振り分けとする
ALL BOLT HOLES SHALL STRADDLE CENTER LINE UNLESS OTHERWISE NOTED

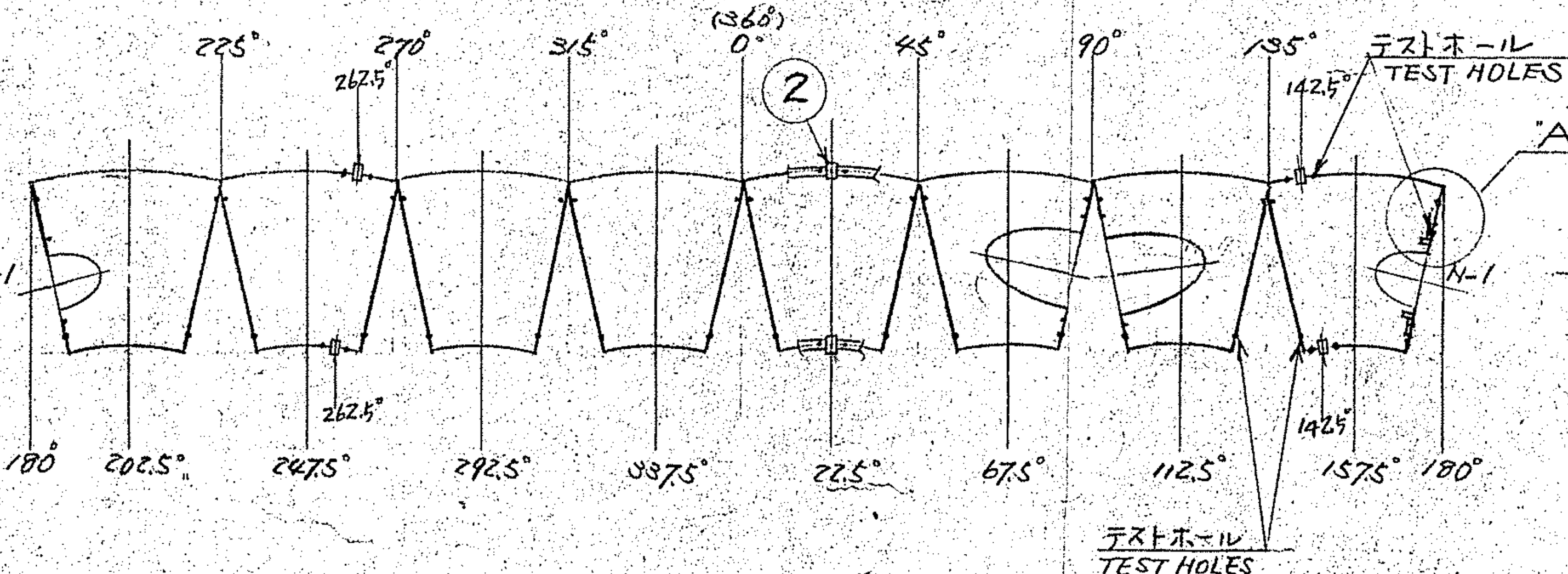
REV	DATE	DESCRIPTION
0	MAR 1 1971	ISSUED FOR APPROVAL
1	APR. 13 1971	FEET & INCH DIMENSIONS AND NOTES ARE ADDED.
2	July 6 1971	NOZZLE ORIENTATION TO BE FINALIZED
3	July 29 1971	NOZZLE LIST CORRECTED HINGE POSITION ADDED

FINAL

I.C.I DRG No F/X/B-409633

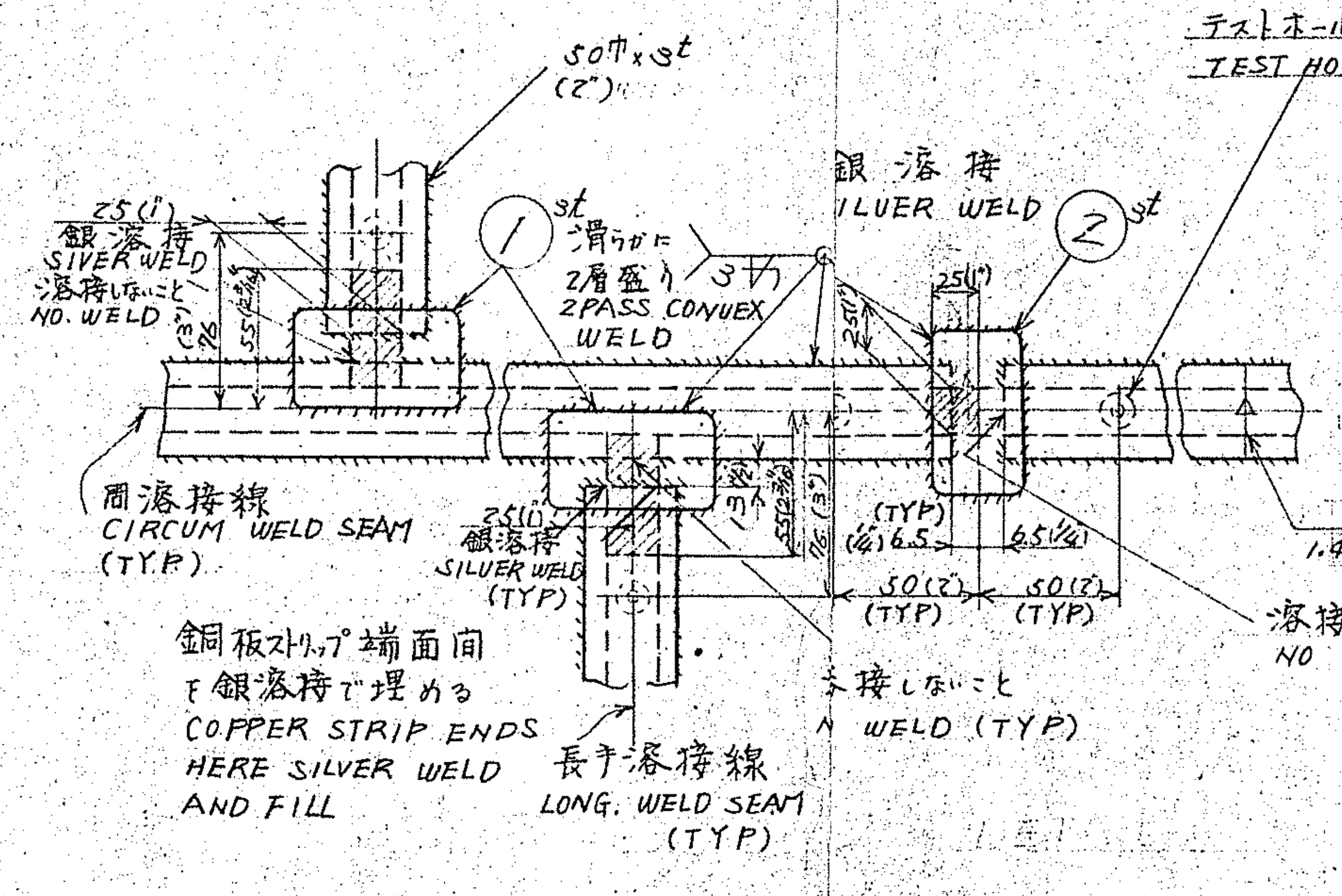
6,000

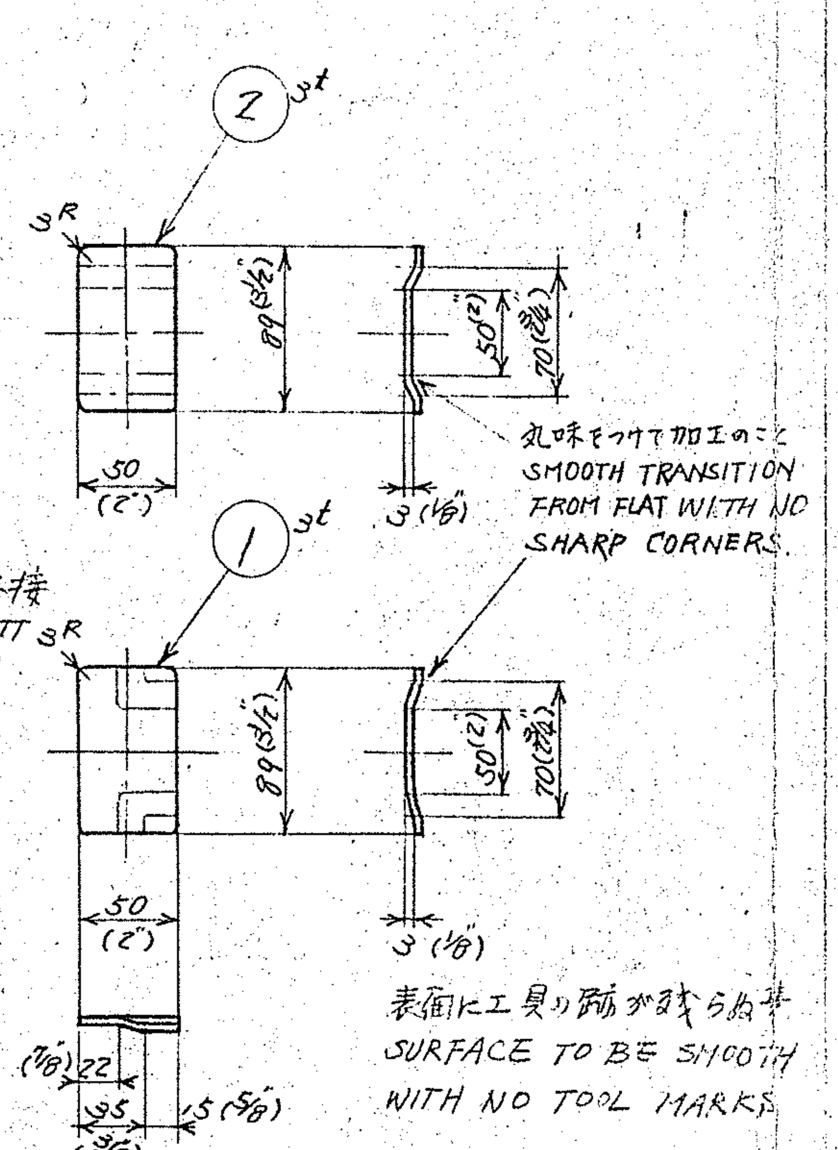


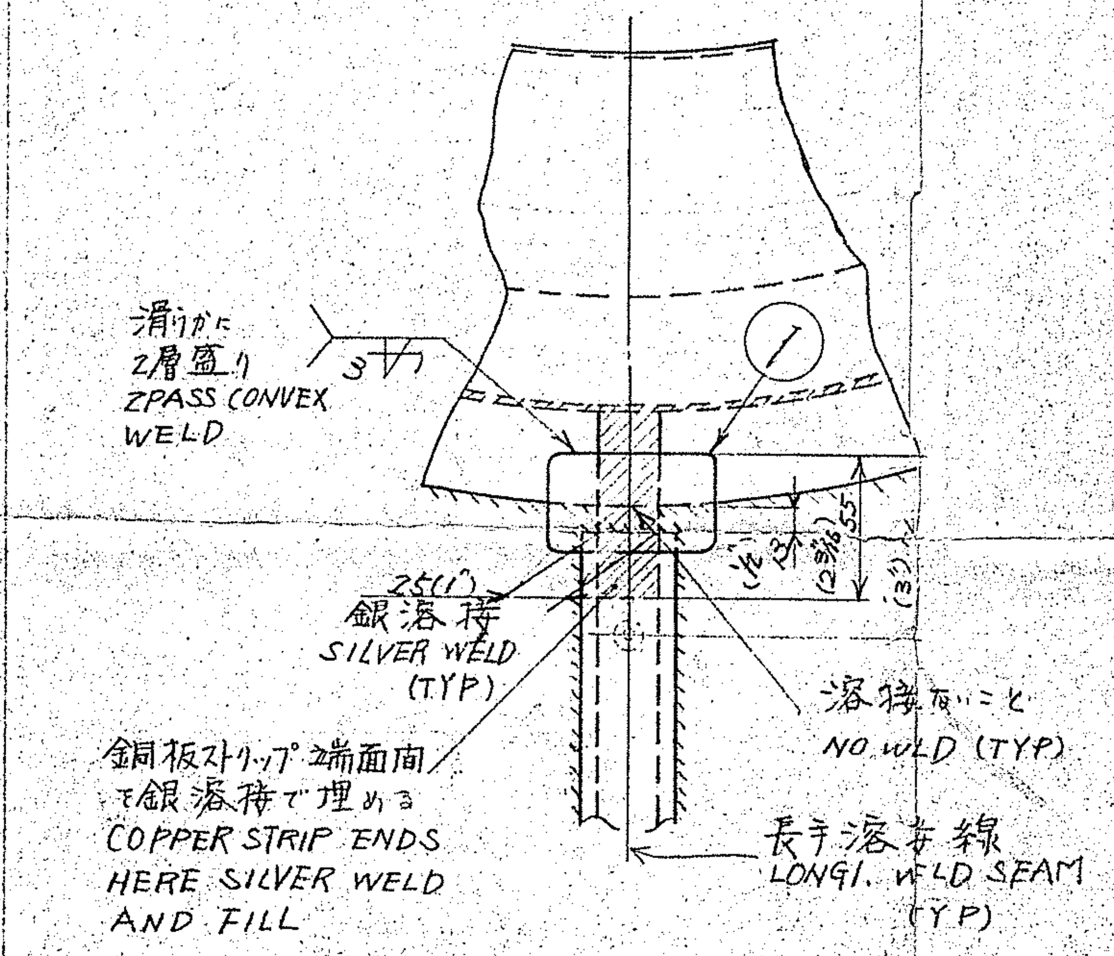


周溶接は3ヶ所縁切りとする

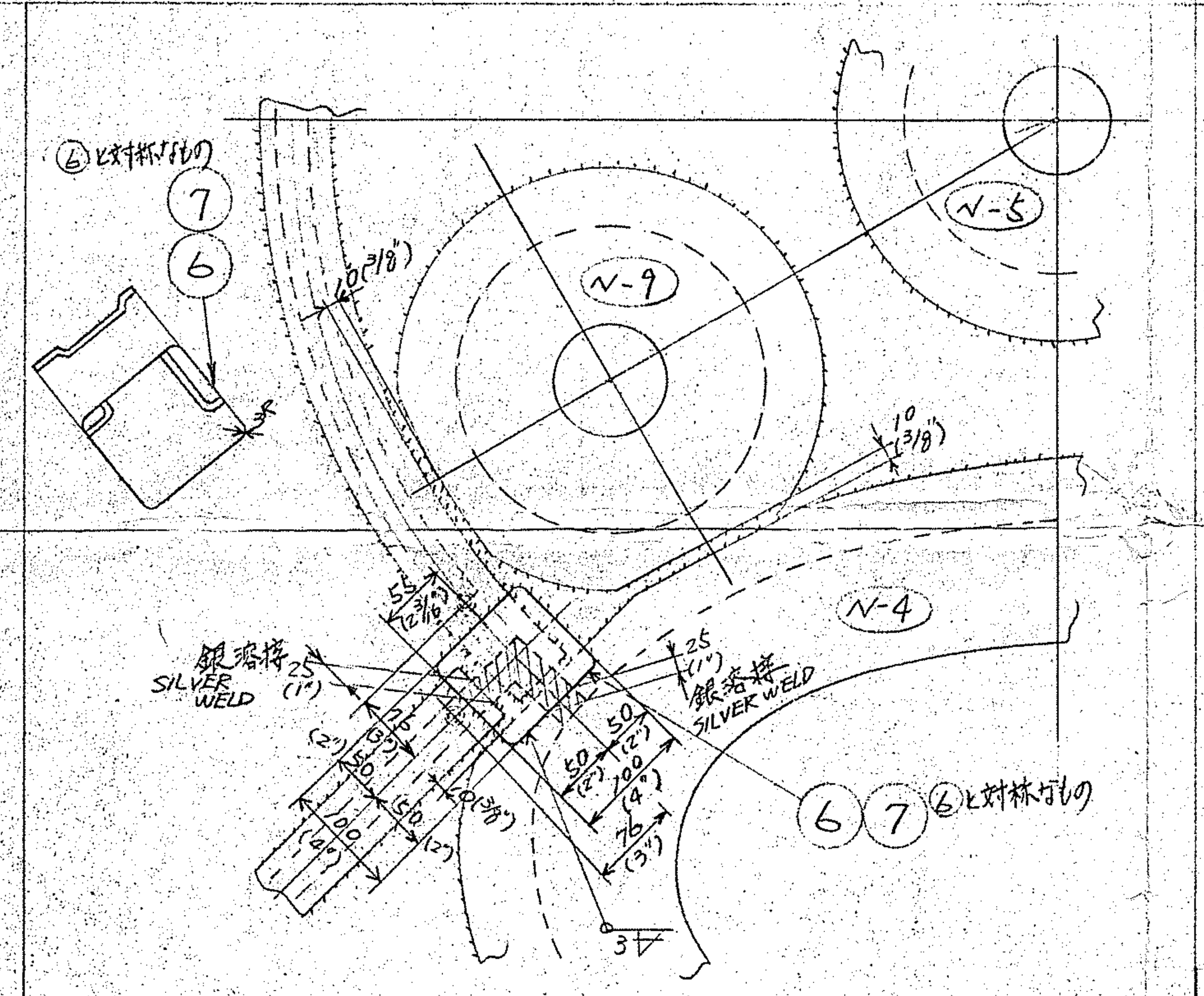
THREE ISOLATED VOIDS SHALL BE PROVIDED ON EACH SHELL CIRCUMFERENTIAL JOINT.

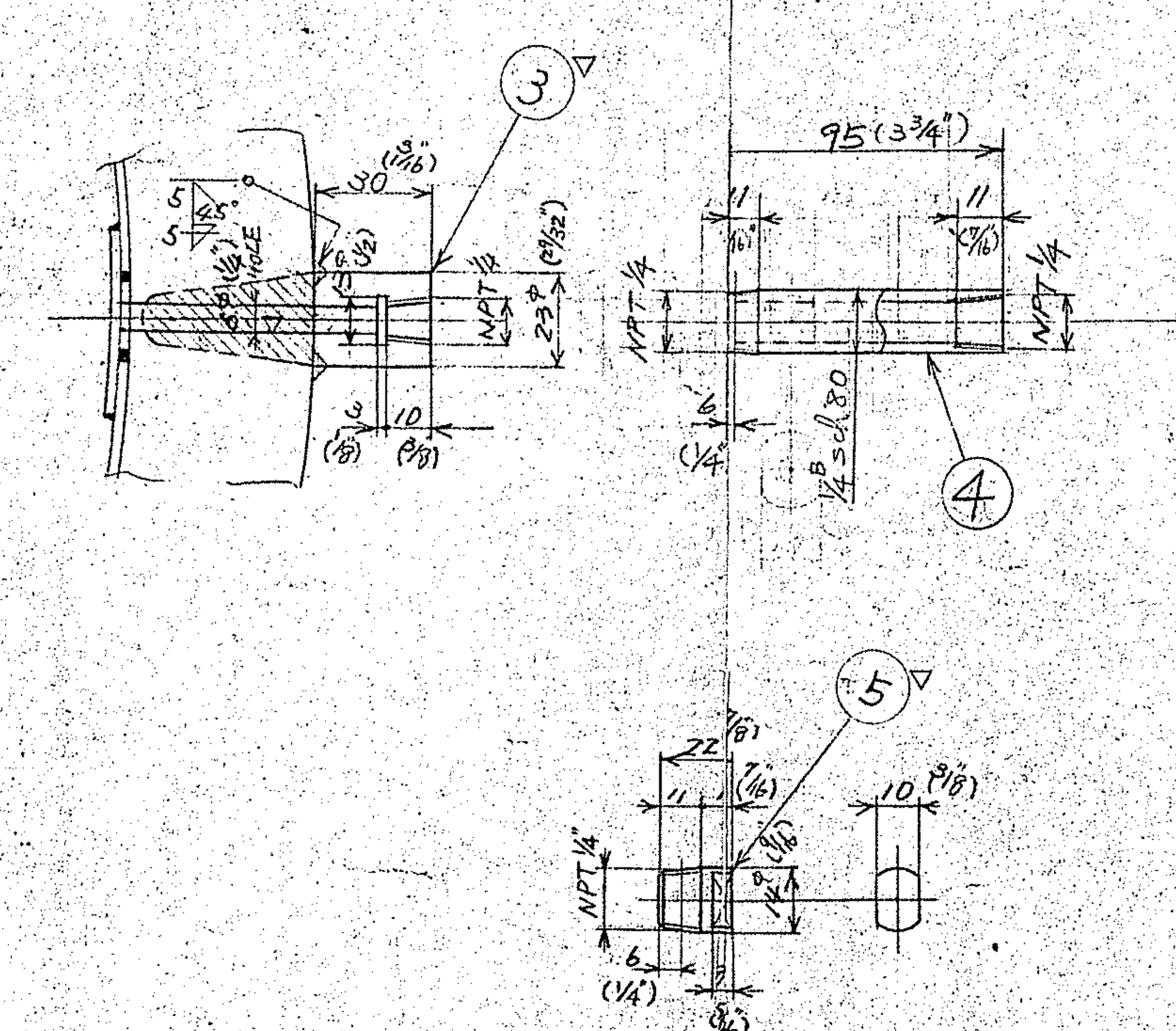






DETAIL "A"





NOTES

1. REFERENCE DWGS 参照図面
SHELL ---------------- CK 29709

2. Fe AND H CONTENT IN TP28 (EQIV. IMI 115) TO BE AS FOLLOWS.
$Fe \leq 0.050\%$ $H \leq 60$ ppm.

3. COUPLING WELDS FOR ALL TELL-TALE HOLES TO BE DYE PENETRANT CHECKED BEFORE AND AFTER HEAT TREATMENT.
ハーフカップリングの溶接部は熱処理(SR)の前後2回カラーチェックの事.

4. EXTENSION PIPES TO BE SHIPPED SEPARATELY.
エクステンション パイプは別途発送の事.

PART NO.	NAME		JIS MATERIAL		QTY FOR / SET REG	SPARE	TOTAL	REMARKS
7	カバー	COVER PLATE	TP28		1			
6	カバー	COVER PLATE	TP28		1			
5	プラグ	PLUGS		A105 Gr II	112			④
4	エクステンション・パイプ	EXTENSION PIPES	STS38		112			
3	ハーフカップリング NPT 1/4	HALF COUPLING		A105 Gr II	112			④
2	カバー	COVER PLATES	TP28		24			CK30400 先行図にて手配済
1	カバー	COVER PLATES	TP28		54			CK30400 先行図にて手配済

1 SET TO BE MANUFACTURED SCALE 1/30

CUSTOMER,S APPROVAL NOTE

FINAL

FW CONTRACT NO 1-15-1442
FW REQ. NO 1442-1131-A
FW ORDER NO 1026/1440

TITLE
F-1215 DISSOLVER
SHELL (UNFOLDING OF SHELL & HEAD) 2/2

I.C.I FIBRES LTD/PROJECT P45/WILTON TEESSIDE

ISSUE DESIGN DEPARTMENT DEC 2 1971 TAMANO WORKS

CHEMICAL PLANT DIVISION
MITSUI SHIPBUILDING & ENGINEERING CO., LTD.

DRAWN	JUNE 14 1971	JOB CLASSIF NO D13004	JOB NO. TC 3368	WORKS 玉
CHKD M. Nakamura	July 6 1971		DWG NO. CK29715	REV ③
CHKD				
APPD Misakamoto	July 6 1971			

第三角法 THIRD ANGLE PROJECTION

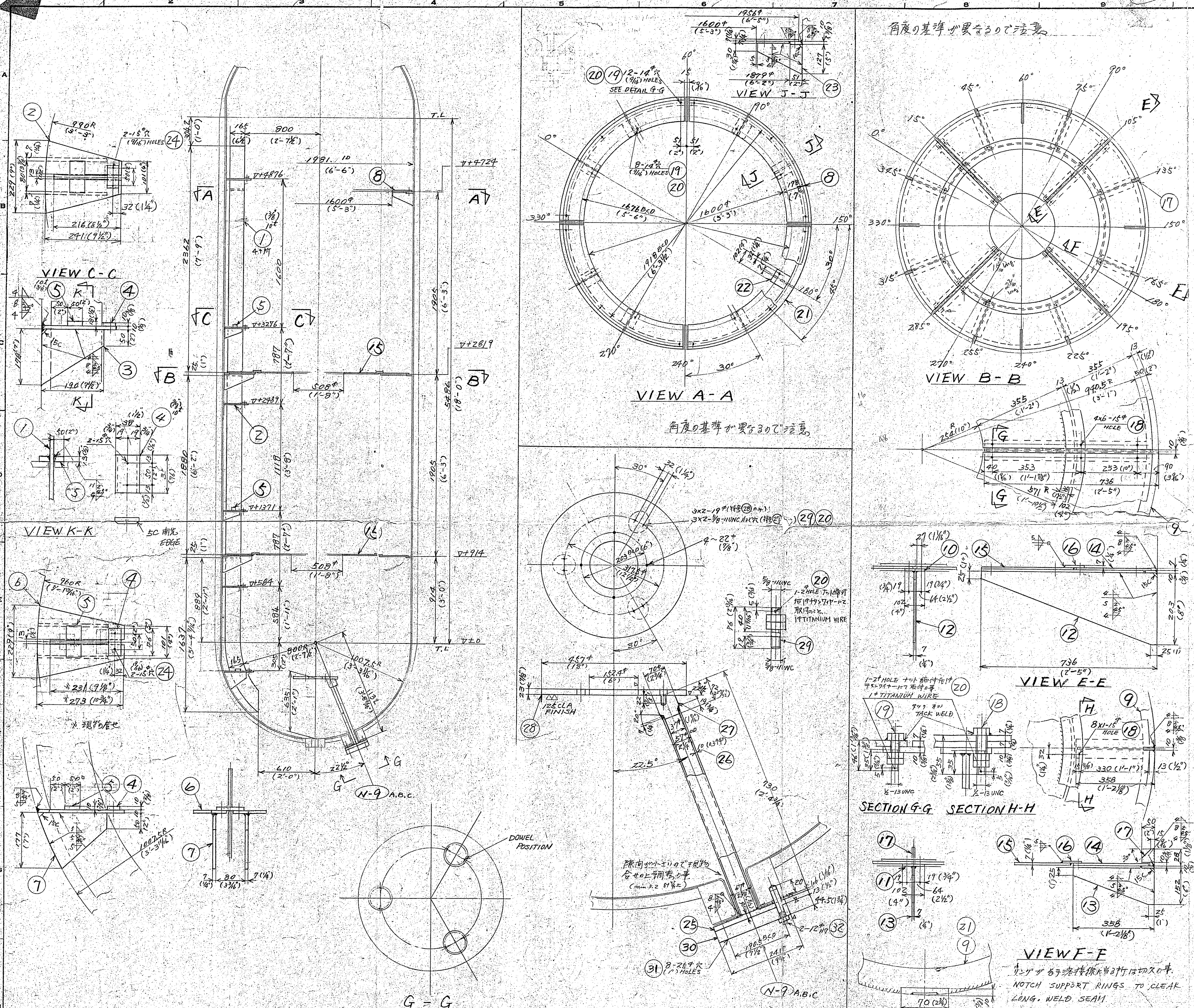
フランジ類の穴割りは特記の外中心線に対し振り分けとする
ALL BOLT HOLES SHALL STRADDLE CENTER LINE UNLESS OTHERWISE NOTED

REV	DATE	DESCRIPTION
⓪	JUNE 14 1971	ISSUED FOR APPROVAL
①	July 29 1971	DETAIL OF COVER STRAP CORRECTED
②	Aug. 4 1971	METHOD OF SILVER WELD CHANGED
③	Oct. 22 1971	DETAIL OF COVER PLATE ON THE INTERSECTION OF M.H. AND BOTTOM CROWN PLATE WELD SEAM ADDED

FINAL

61085. 化設. A1. 1 50. 2000. 45.5. M

ICI DRG No F/X/B-417760 F1215



NOTES

1. REFERENCE DWGS 参照図面
   SHELL ---- CK 29709
   NOZZLE ---- CK 29710
2. Fe AND H CONTENT IN TP49 TB49 (BOTH EQUIV. IMI 130) AND TW28 (EQUIV. IMI 115) TO BE AS FOLLOWS.
   Fe ≦ 0.050%. H ≦ 60ppm
3. ALL BAFFLE SECTIONS TO CLEARLY PASS THROUGH A 20" I.D. MANWAY.
   バッフルは M.H より搬入可能の事.
4. BAFFLE SUPPORT BRK'TS TO BE NOTCHED TO CLEAR VERTICAL WELD SEAMS.
   バッフル サポートは縦継溶接に当る所は切欠の事.

PART NO.	NAME		JIS MATERIAL		REG QTY FOR / SET	SPARE	TOTAL	REMARKS
32	ノックB.N U3/8 ×106ℓ	DOWELS	SS41		6			D0404 ネジのみ3/8-16UNC
31	ガスケット 165φ/80φ×1.6t	GASKETS		V#1500	3			(4) C.A.F
30	盲フランジ	BLIND FLANGES		A105 Gr II	3			
29	スタッドB & ダブルナット	STUD BOLTS & DOUBLE NUTS	TB49		6 SETS			(4)
28	座	PLATE		Ti-6A-4V	1			IMI 318
27	支柱	STANCHIONS		Ti-6A-4V	3			IMI 318
26	支柱	STANCHIONS		Ti-6A-4V	3			IMI 318
25	フランジ	FLANGES	TP49		3			
24	頭付ボルト・ナット 1/2-13UNC. 35X20	MACH. BOLT & DOUBLE NUTS	TB49		48 SETS			(4)
23	リブ	RIBS	TP49		8			
22	サポート	SUPPORTS	TP49		8			
~~21~~	~~サポートリング~~	~~SUPPORT RINGS~~	~~TP49~~		~~4~~			
20	1φチタンワイヤー	TITANIUM WIRE	TW28		5M			(4)
19	頭付ボルト& ダブルナット	MACH. BOLT & DOUBLE NUTS	TB49		52 SETS			(4)
18	頭付ボルト& ダブルナット	MACH. BOLT & DOUBLE NUTS	TB49		32 SETS			(4)
17	押え板	STOPPERS	TP49		16			
16	継ぎ板	PLATES	TP49		8			
15	バッフル	DOUGHNUT BAFFLES	TP49		8			
14	バッフル	DOUGHNUT BAFFLES	TP49		8			
13	リブ	RIBS	TP49		16			
12	リブ	RIBS	TP49		8			
11	サポート	SUPPORTS	TP49		16			
10	サポート	SUPPORTS	TP49		8			
9	サポートリング	SUPPORT RING	TP49		8			
8	バッフル	DOUGHNUT BAFFLES	TP49		4			
7	リブ	RIBS	TP49		8			
6	ブラケット	BRACKETS	TP49		4			
5	ストッパー	STOPPERS	TP49		24			
4	ストッパー	STOPPERS	TP49		24			
3	リブ	RIBS	TP49		16			
2	ブラケット	BRACKETS	TP49		20			
1	バッフル板	BAFFLES	TP49		4 SETS			

/ SET TO BE MANUFACTURED   SCALE 1/20 1/5 1/6

CUSTOMER,S APPROVAL   NOTE

FINAL

FW CONTRACT NO 1-15-1442
FW REQ. NO 1442-1131-A
FW ORDER NO 1026/1440

TITLE: (F-1215) DISSOLVER INTERNALS
I.C.I FIBRES LTD/PROJECT P45/WILTON TEESSIDE

ISSUE DATE: DESIGN DEPARTMENT DEC 27 1971 TAMANO WORKS

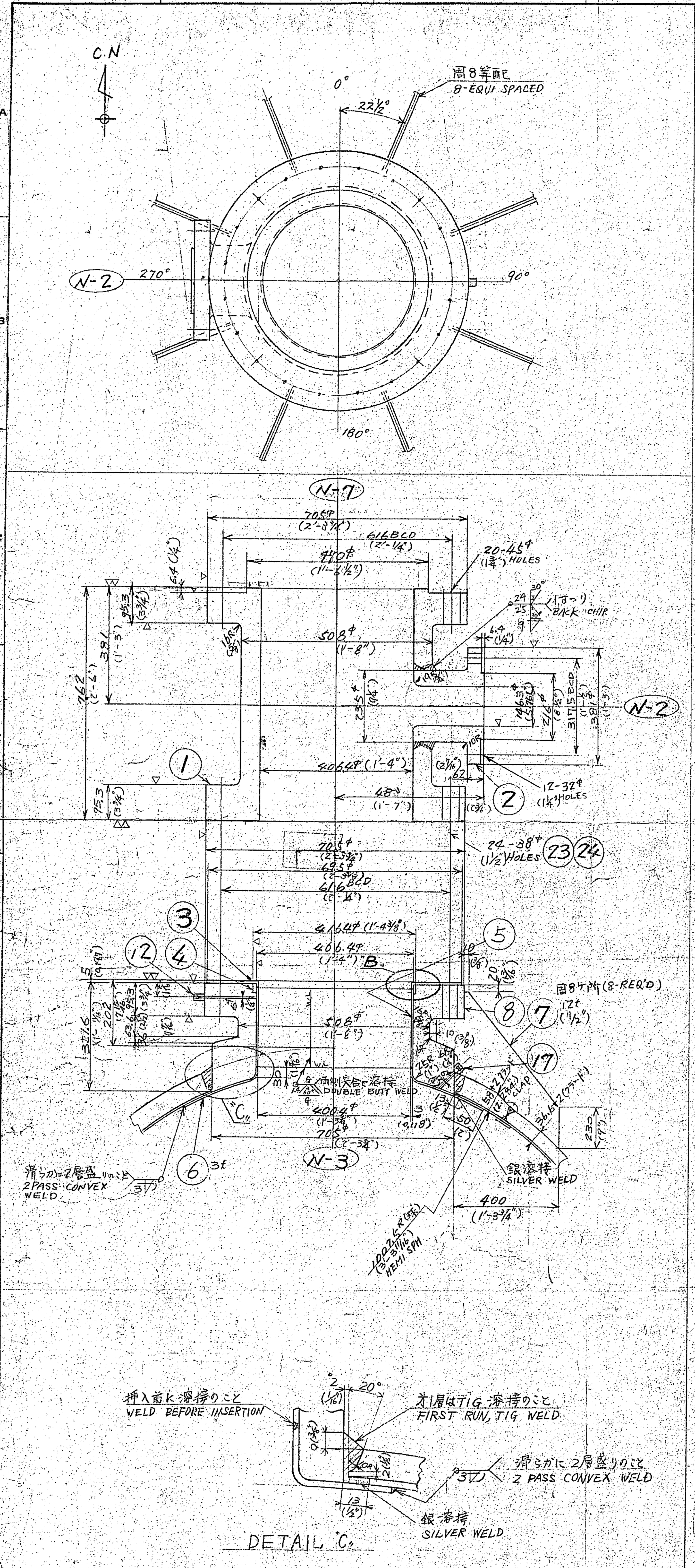
CHEMICAL PLANT DIVISION
MITSUI SHIPBUILDING & ENGINEERING CO., LTD.

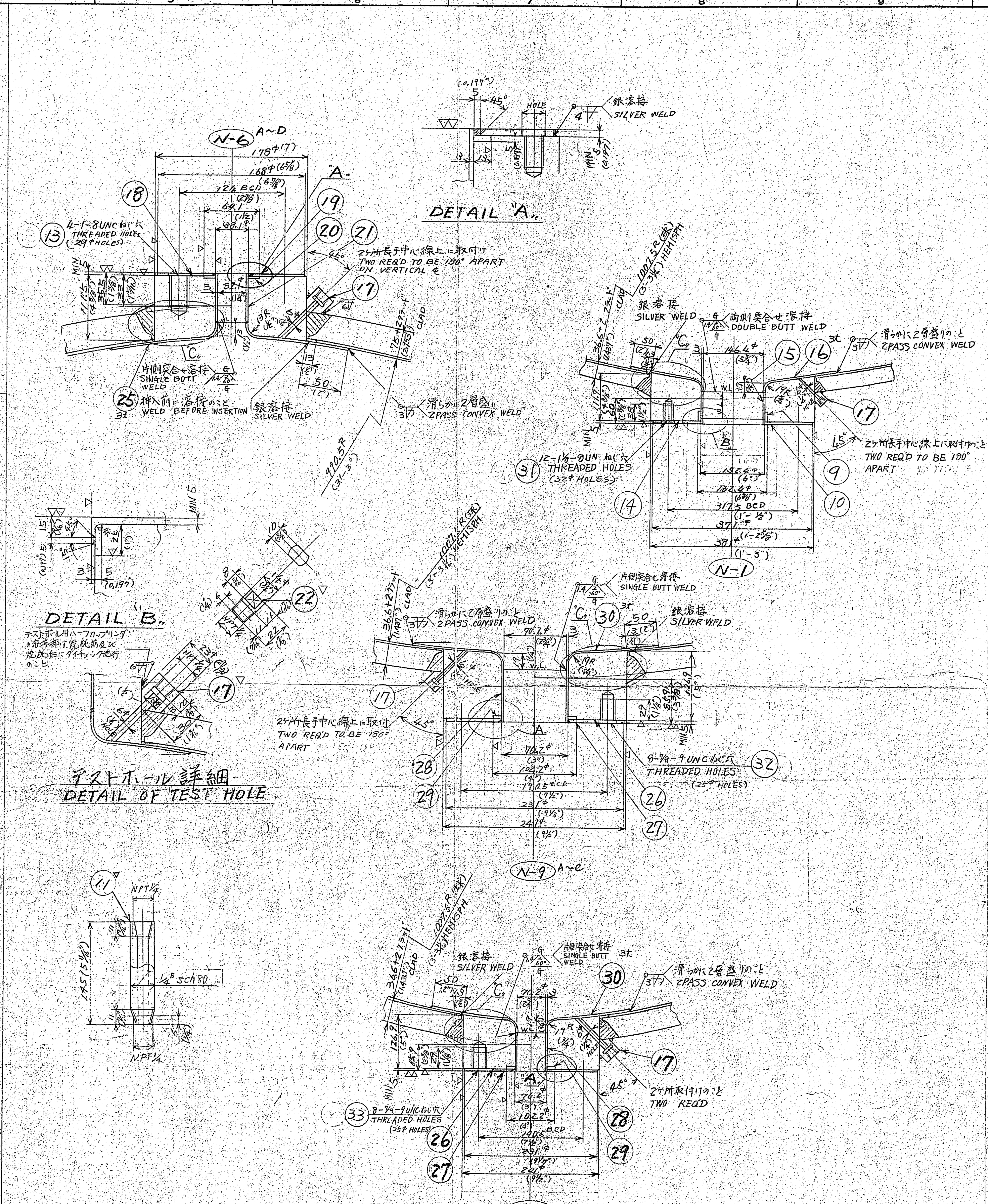
DRAWN	CHKD	CHKD	APPD	JOB CLASSIF NO	JOB NO.	DWG NO.	WORKS	REV
K. Hara APR 2 1971	M. Nakamura July 3 1971		M. Sakamoto July 5 1971	D 13004	TC 3368	CK 29713	玉	6

第三角法 THIRD ANGLE PROJECTION
フランジ類の穴割りは特記の外中心線に対し振り分けとする
ALL BOLT HOLES SHALL STRADDLE CENTER LINE UNLESS OTHERWISE NOTED

REV	DATE	DESCRIPTION
0	APRIL 2 1971	ISSUED FOR APPROVAL
1	June 25 1971	DOUGHNUT BAFFLES TO BE CHANGED. TRIPOD BEARING TO BE DECIDED
2	July 27 1971	VIEW 'B-B', SECTION 'G-G', 'H-H' CHANGED. STOPPER (4) HAD EDGE PREPARED.
3	Aug. 21 1971	(26), (27), (28) MATERIAL CHANGED BECAUSE OF ERROR IN WRITING
4	Aug. 23 1971	ANGLE OF LEG ASSEMBLY CHANGED, AND DETAIL OF NOTCHED RING ADDED.
5	Sept. 2 1971	LOCATION OF BOLT HOLE CHANGED BECAUSE OF ERROR IN WRITING
6	Dec. 3 1971	MACHINING AND DOWELS ARE ADDED.

ICI DRG NO E/X/B-417763





NOTES

1. REFERENCE DWG. 参照図面
   SHELL------ CK.29709
2. Fe AND H CONTENT IN TP28 (EQUIV. IMI 115) TO BE AS FOLLOWS.
   Fe ≦ 0.050% H ≦ 60 PPM
3. ALL GASKET SURFACES SHALL BE MACHINED TO 125 CLA FINISH.
   全てのガスケット面の仕上は125 CLAとする。
4. ALL WELDING OF PREFABRICATED NOZZLE LINERS, CYLINDRICAL SLEEVE AND FLUED RING SHALL BE DOUBLE BUTT WELDS MADE PRIOR TO INSERTION IN THE CONNECTION EXCEPT THOSE OF SMALL SIZE NOZZLES.
   AFTER FORMING AND WELDING. ALL NOZZLE LINER WELDS SHALL UNDERGO THE FOLLOWING INSPECTION AND TREATMENT.
   1) LIQUID PENETRANT EXAMINATION
   2) ALL BUTT WELDS (Tc) SHALL BE 100% RADIOGRAPHED.
   3) AFTER CHECK AND REMOVAL OF ALL SURFACE IRON, ALL LINER ASSEMBLIES SHALL BE STRESS-RELIEVED AT 580°C FOR ONE HOUR IN A ELECTRIC FURNACE. STRESS-RELIEVED PIECES SHALL BE SAND-BLASTED OR GRIT-CLOTH BUFFED TO REMOVE OXIDE PENETRATION.
   プレハブのノズルライナーは両側突合せ溶接とする。成形溶接後 次の検査 熱処理施行
   1) 浸透探傷検査
   2) 突合せ溶接部の全線X線検査
   3) 表面の鉄分チェック除去後 全てのライナーは電気炉にて580°Cで1時間応力除去、その後サンドブラスト又はグリットクロスバフ仕上げをし酸化物を除去する。

PART NO.	NAME		JIS MATERIAL		REG	SPARE	TOTAL	REMARKS
33	スタッド B.N 7/8-9UNC 115X27X45	STUDS & NUTS		B A193-B7 N A194-2H	8 SETS			④ヘビーナット
32	スタッド B.N 7/8-9UNC 130X27X50	STUDS & NUTS		B A193-B7 N A194-2H	24 SETS			④ヘビーナット
31	スタッド B.N 1⅛-8UN 145X35X55	STUDS & NUTS		B A193-B7 N A194-2H	12 SETS			④ヘビーナット
30	ライニング	LININGS	TP28		4			
29	リング	RINGS	TP28		4			
28	ライニング	LININGS	TP28		4			
27	ライニング	LININGS	TP28		4			
26	(N-5)(N-9)ノズル	NOZZLES		A105GrII	4			
25	ライニング	LININGS	TP28		4			
24	ガスケット 470φ/424φx1.6t	GASKET		V#1500	1			④ C.A.F.
23	全ネジ B.N 1⅜-8UN x295	BOLT & NUTS		B A193-B7 N A194-2H	24 SETS			④ヘビーナット
22	プラグ NPT¼	PLUGS		A105GrII	20			④
21	ライニング	LININGS	TP28		4			
20	リング	RINGS	TP28		4			
19	ライニング	LININGS	TP28		4			
18	(N-6)A~Dノズル	NOZZLES		A105GrII	4			
17	ハーフカップリング NPT¼	HALF COUPLING		A105GrII	19			④
16	ライニング	LINING	TP28		1			
15	ライニング	LINING	TP28		1			
14	(N-1)ノズル	NOZZLE		A105GrII	1			
13	スタッド B.N 1-8UNC 115x30x45	STUDS & NUTS		B A193Gr.B7 N A194Gr.2H	16 SETS			④ヘビーナット
12	ハーフカップリング NPT¼	HALF COUPLING		A105GrII	1			
11	エクステンションパイプ	EXTENSION PIPE	STS38		20			
10	ライニング	LINING	TP28		1			
9	リング	RING	TP28		1			
8	(N-3)ノズル	NOZZLE		A105GrII	1			
7	リブ	RIBS	SS41		8			
6	ライニング	LINING	TP28		1			
5	ライニング	LINING	TP28		1			
4	リング	RING	TP28		1			
3	ライニング	LINING	TP28		1			
2	(N-2)ノズル	NOZZLE		A182-F321	1			
1	(N-7)ノズル	NOZZLE		A182-F321	1			

QTY FOR 1 SET

1 SET TO BE MANUFACTURED

SCALE 1/10 1/6 1/4

CUSTOMER,S APPROVAL

NOTE

FINAL

FW CONTRACT NO 1-15-1442
FW REQ NO 1442-1131-A
FW ORDER NO 1026/1440

NOTES 5. HALF COUPLING WELDS FOR ALL TELL-TALE HOLES TO BE DYE PENETRANT CHECKED BEFORE AND AFTER HEAT TREATMENT
ハーフカップリングの溶接部は熱処理(SR)の前后2回カラーチェックの事。

6. ALL NOZZLE LINERS TO BE GROUND FLUSH
全てのノズルライナーは面一にグラインダー掛けの事。

7. EXTENSION PIPE TO BE SHIPPED SEPARATELY.
エクステンションパイプは別途発送の事。

TITLE

F-1215 DISSOLVER NOZZLE

I.C.I FIBRES LTD/PROJECT P45/WILTON TEESSIDE

ISSUE DATE

DESIGN DEPARTMENT DEC 27 1971 TAMANO WORKS

CHEMICAL PLANT DIVISION
MITSUI SHIPBUILDING & ENGINEERING CO., LTD.

DRAWN	K. [illegible]	MAR 8, 1971	JOB CLASSIF. NO D13004	JOB NO. TC 3368	WORKS 玉
CHKD	M. Nakamura	APR 15 1971		DWG. NO. CK-29710	REV ⑤
CHKD					
APPD					

REV	DATE	DESCRIPTION
⓪	MAR 8 1971	ISSUED FOR APPROVAL
①	June 22 1971	NOZZLE SIZES TO BE FINALIZED
②	July 16 1971	EXTENSION PIPE & N-3 NOZZLE DRAWING TO BE CHANGED
③	July 29 1971	SPOOL FLANGE & RIBS ⑦ CHANGED GASKET FACING MIN THK ADDED.
④	August 9 1971	N-1, N-3, N-5, N-6A~D & N-9A~C WELD BEVEL CHANGED (FABRICATION SECTION REQUEST)
⑤	August 20 1971	MISS FABRICATION OF N-3

第三角法 THIRD ANGLE PROJECTION

フランジ類の穴割りは特記の外中心線に対し振り分けとする
ALL BOLT HOLES SHALL STRADDLE CENTER LINE UNLESS OTHERWISE NOTED

I.C.I. DRG. No. F/X/B-417761