OVERHAULS GROUP
T 7 2005
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04 OCT 2002
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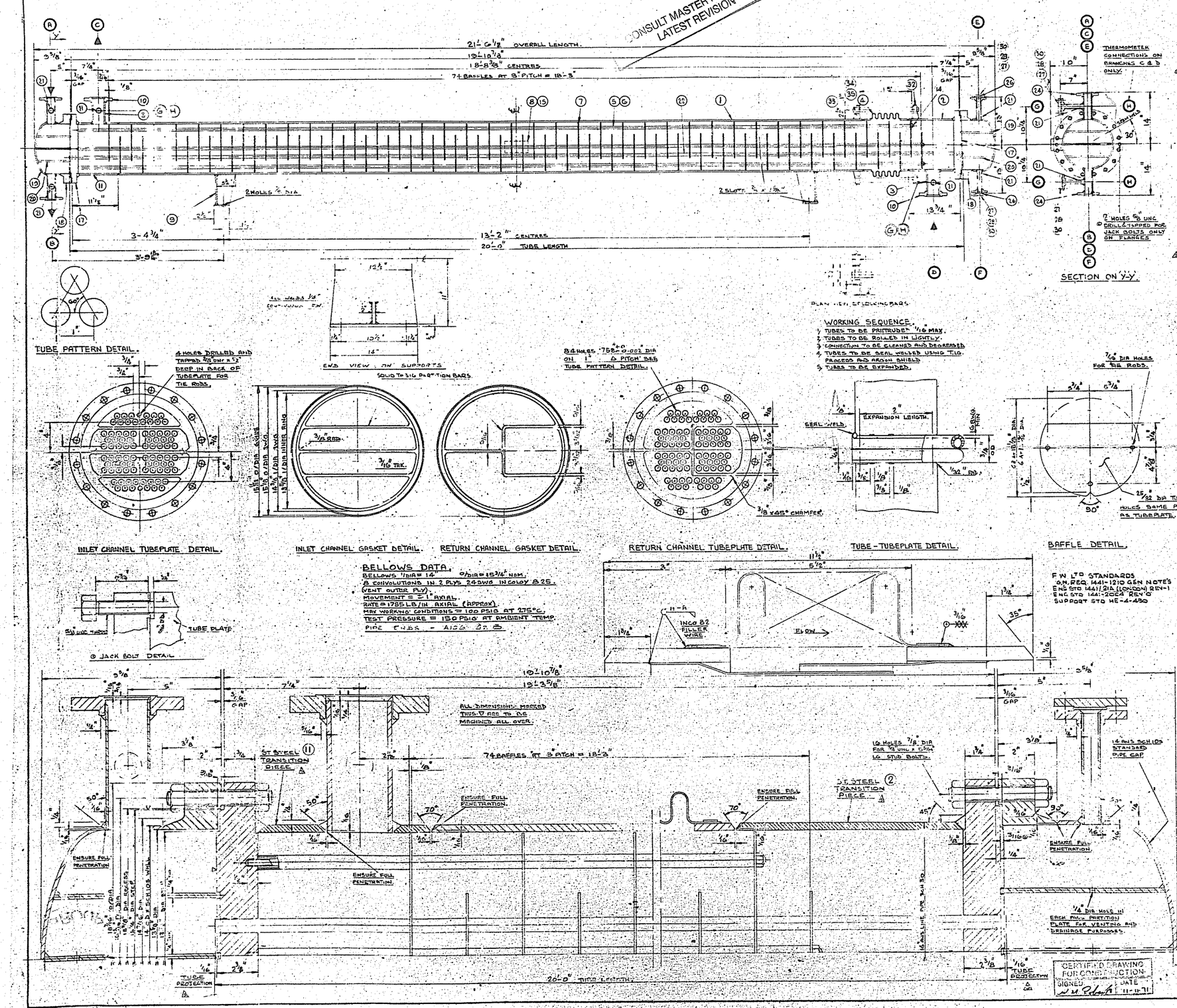

BILL OF MATERIAL

ITEM	QUAN	DESCRIPTION	SPEC.	MAT. REF.
1	1	SHELL 14" ANS UNS PIPE SCH 30 x 1/6 - 10 3/8" LG	A 106 GR B	2937
2	1	TRANSITION PIECE 14" OD x 3/8" THK x 11 7/8" LG	ST. STL. PLATE	
3	1	BRANCH BODY 3" ANS UNS PIPE x 3/16 WALL x 18" LG	SA 240 316L	2462
4	1	EXPANSION BELLOW 14" ANS (VOKES A-70)	INCOLOY 825	12912
5	4	SPACER TUBES 3/8" ANS UNS PIPE x 18 SWG x 19'-1/16	SA 213 321	12664
6	4	TIE RODS 3/8" DIA x 19'-3" LG	SA 276 321	1681
7	74	BAFFLES 12 5/8" DIA x 1/8" THK	SA 240 321	12466
8	1	NAMEPLATE SUPPORT MADE FROM 1/8" THK PLATE	BS 1501 151-208	S
9	2	SUPPORTS MADE FROM 1/2" THK PLATE	"	S
10	2	BRANCH FLANGES 3" ANS RF CLASS 150 SLIP-ON-TYPE	SA 182 316L	1342
11	1	TRANSITION PIECE 11" OD x 3/8" THK 9 1/2" LG PLATE	SA 240 316L	1466
12	32	3/4" UNC x 5 3/8" LG STUD BOLTS	BS 1700 EN 57	S
13	64	3/4" UNC HEX NUTS	BS 1700 EN 24	S
14	4	3/8" UNC HEX NUTS	BS 4379 321	S
15	1	NAMEPLATE		
16	4	JACK BOLTS 5/8" UNC 3" LG	BS 1700 EN 1A	S
17	2	TUBEPLATES 15 11/16" DIA x 7 3/8" THK FORGING	SA 181 316L	12334
18	2	MAIN FLANGES 18 1/2" OD x 13 1/8" ID x 2 1/2" THK	"	"
19	2	14" STD PIPE CAPS SCH 10S	SA 403 316L	1938
20		PASS PARTITION PLATES FROM 1/4" THK PLATE	SA 182 316L	1939
21	1	1/2" UNC HEX NUT	BS 1700 EN 1A	S
22	84	3/4" OD x 16 BWG TUBES x 20'-0" LG SEAMLESS	SA 213 SA 312 316L	12936
23	1	BRANCH BODY 2" ANS UNS PIPE SCH 10S x 16" LG	SA 182 316L	12941
24	2	BRANCH FLANGES 2" ANS RF CLASS 150 SLIP-ON-TYPE	SA 182 316L	12942
25	2	GASKETS AS DRAWN 3/16" THK SPIRAL WOUND FILLED	316	1935
26	8	BRANCH FLANGES 3/4" ANS RF CLASS 150 SLIP-ON-TYPE	SA 182 316L	1942
27	8	BLANK FLANGES 3/4" ASA RF CLASS 150	SA 182 316	14063
28	4	GASKETS 3/4" ASA CLASS 150 SPIRAL WOUND FILLED		14064
29	6	— 1 5/8" x 1 1/2" x 1 1/8" — CAF GRAPHITED BOTH SIDES		
30	37	3/4" UNC BOLTS 2" LG COMPLETE WITH NUTS - HEAVY SERIES	BS 1700 EN 1A	S
31		MACHINING AS REQUIRED		2944
NOTE 1)		ALL FLANGE BOLT HOLES TO STRADDLE CENTRE LINES.		
	2)	FLANGE FINISH: TUBE SIDE 125 RMS OR 6 MASTER		
	2a)	BELLOW LIFE EXPECTANCY - 12000 CYCLES		
	3)	TP316L STAINLESS STEEL - MAX CARBON CONTENT 0.030%		
	4)	FOR ALL WELDS IN TP316L STAINLESS STEEL USE WELD CONSUMABLES WITH 0.025% MAXIMUM CARBON CONTENT		
	5)	SHELL TO TUBEPLATE WELD TO HAVE DYE PENETRANT ROOT RUN CHECK.		
31A		RADIOGRAPHY AS REQD.		13466
32		1/4" THK STST PLATES TO SKETCH 6961/7	A 240 316L	14062
33		1/4" THK MI STEEL PLATE	BS 1501 151-26A	S
34	2	BOLT 1" UNC x 16" LG SCREWED BAR	BS 1700 EN 57	S
35	4	NUT 1" UNC HEX HD	BS 1700 EN 2H	S
36	1 set	SPARE GASKETS ITEM 25		14075

FOSTER WHEELER CONTRACT NUMBER 1-15-1440/1625.
FOSTER WHEELER LTD REQUISITION NUMBER 1441-1211-R REV.0
FOSTER WHEELER LTD. ORDER NUMBER 3018/1440.
ITEM NUMBER TO WHICH THE POINTS APPLY E511.
VENDORS SHOP ORDER NUMBER 696.
CLIENTS NAME I.C.I. FIBRES LTD.
PROJECT LOCATION WILTON TEESSIDE.

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ISSUE	DATE	MODIFICATION	BY
3	22-9-71	[illegible]	D
2	9-7-71	MODIFIED TO CUSTOMERS REQUIREMENTS	D

SCHEDULE OF BRANCHES

BRANCH	DESCRIPTION	SIZE	FLUID	SHELL SIDE	TUBE SIDE
A	ACETIC ACID & WATER INLET	2" ANS @ CLASS 150	DESIGN TEMP @	COOLING WATER 65°C/ 120°F	ACETIC ACID & WATER 125°C/ 257°F
B	" " OUTLET	"	DESIGN PRESSURE	7.5 KG/CM² 5 KT	8.5 KG/CM² 6.5 KT
C	WATER OUTLET	3" ANS CLASS 150	TEST PRESSURE @	"	12.4 KG/CM² 10.4 KT
D	" INLET	"	CORROSION ALLOWANCE	1/8"	1/16"
E	VENT	3/4" ANS @ CLASS 150	VOLUME		
F	DRAIN	"	EAT		
G	PRESSURE GAUGE	"	LAT		
H	THERMOMETER POCKET	"	PESIST TO AIR		
			X.R	SPOT	SPOT
			S.R	NIL	NIL

WT EMPTY:- 3000 LBS WT FULL:- 4200 LBS
FINISH:- INTERNAL:- CLEAN ALL UNMACHINED CARBON STEEL SURFACES
EXTERNAL:- ONE COAT RED OXIDE PRIMER.
DESIGN CODES:- ASME VIII-UG TEMA 'R' 1968 EDITIONS
INSPECTION BY:- FOSTER WHEELER LIMITED
CLIENT:- FOSTER WHEELER LIMITED CLIENT'S O No. 3018/1440
TITLE:-

DRYER SCRUBBER COOLER: 1-OFF.

ITEM Nº E511. I.C.I. DRG Nº F/X/A409870

HUNT HEAT EXCHANGERS LTD.,
GRIMSHAW LANE MIDDLETON
MANCHESTER ENGLAND

SCALE:- 1/10, 1/5, 1/2 & FULL SIZE JOB. No. 696
DATE:- 26-5-71 CHD:- [illegible]
DRN:- D GREGG A.P.D:- [illegible]
DRG. No. SX 13.17. SHEET 1 OF — SHEETS

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