

GASKETS ARE CORRUGATED STRIP TP 316 L STAINLESS STEEL
SPIRALLY WOUND WITH REPROCESSED FLUON FILLER.
GASKET TO BE 0.125" ± 0.005" TH. WITH 0.125" ± 0.01" TH.
SOFT IRON OUTER COMPRESSION AND CENTRING RING AND
MIN ID INSIDE COMPRESSION RING J17 TYPE 913 (SPECIAL)
OR EQUAL
INNER COMPRESSION RING FROM STAINLESS STEEL TP 316 L

FOSTER WHEELER CONTRACT N°	1-15-1440 / 1459
" " REQUISITION N°	1442-1211-C REV 5
" " ORDER N°	3009 / 1440
ITEM N°	E 1514
VENDORS SHOP ORDER N°	
CLIENTS NAME	ICI FIBRES LTD
PROJECT LOCATION	WILTON TEASSIDE

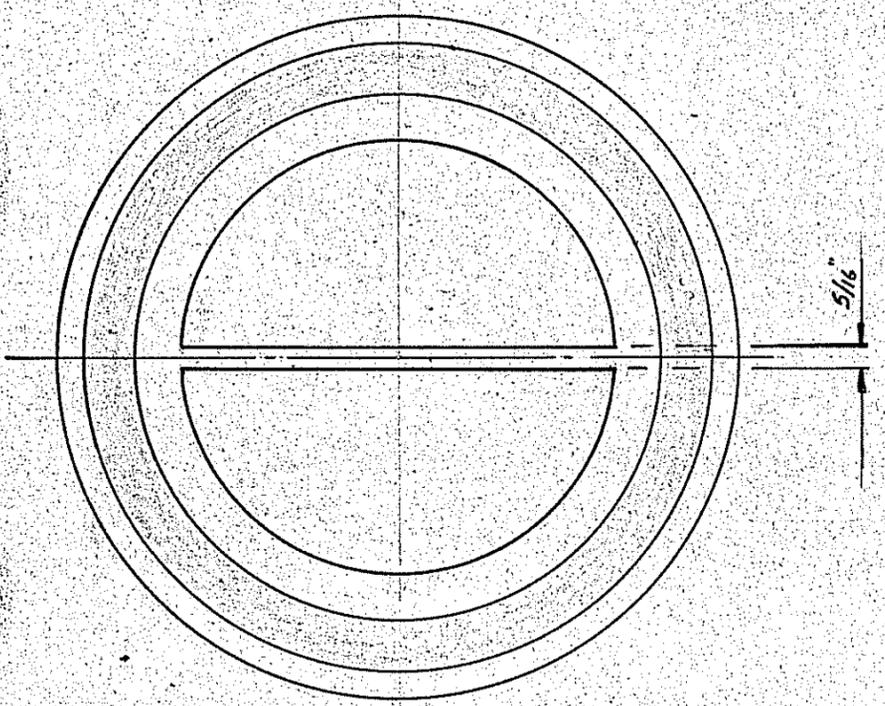
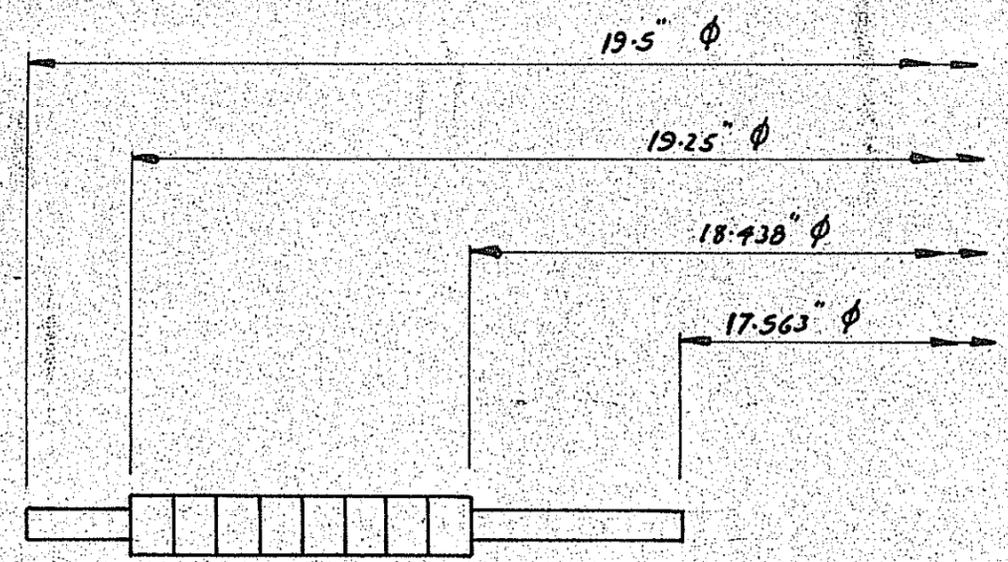
1-Off as drawn.

ICI N° FX/C 417824

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MOD.	REVISION	SIG.	DATE	DRAWN	GREENFIELD	GEA AIREXCHANGERS (NI) LTD	C. NO. 280/99549
				CH'K'D		TITLE	DRG. NO. 1857 0005 21
				APP		<u>GASKET.</u>	ISSUE
				DATE	4. 6. 71		
				SCALE			

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GASKETS ARE CORRUGATED STRIP TP 316 L STAINLESS STEEL
SPIRALLY WOUND WITH REPROCESSED FLUON FILLER.
GASKET TO BE 0.175" ± 0.005" TH. WITH 0.125" ± 0.01" ER.
SOFT IRON OUTER COMPRESSION AND CENTRING RING AND
MIN ID INSIDE COMPRESSION RING J17 TYPE 913 (SPECIAL)
OR EQUAL
INNER COMPRESSION RING FROM STAINLESS STEEL TP 316 L

FOSTER WHEELER CONTRACT N°	1-15-1440 / 1459
" " REQUISITION N°	1442-1211-C REV 5.
" " ORDER N°	3009 / 1440
ITEM N°	E 1514
VENDORS SHOP ORDER N°	
CLIENTS NAME	ICI FIBRES LTD.
PROJECT LOCATION	WILTON TEESIDE

1- Off as drawn.

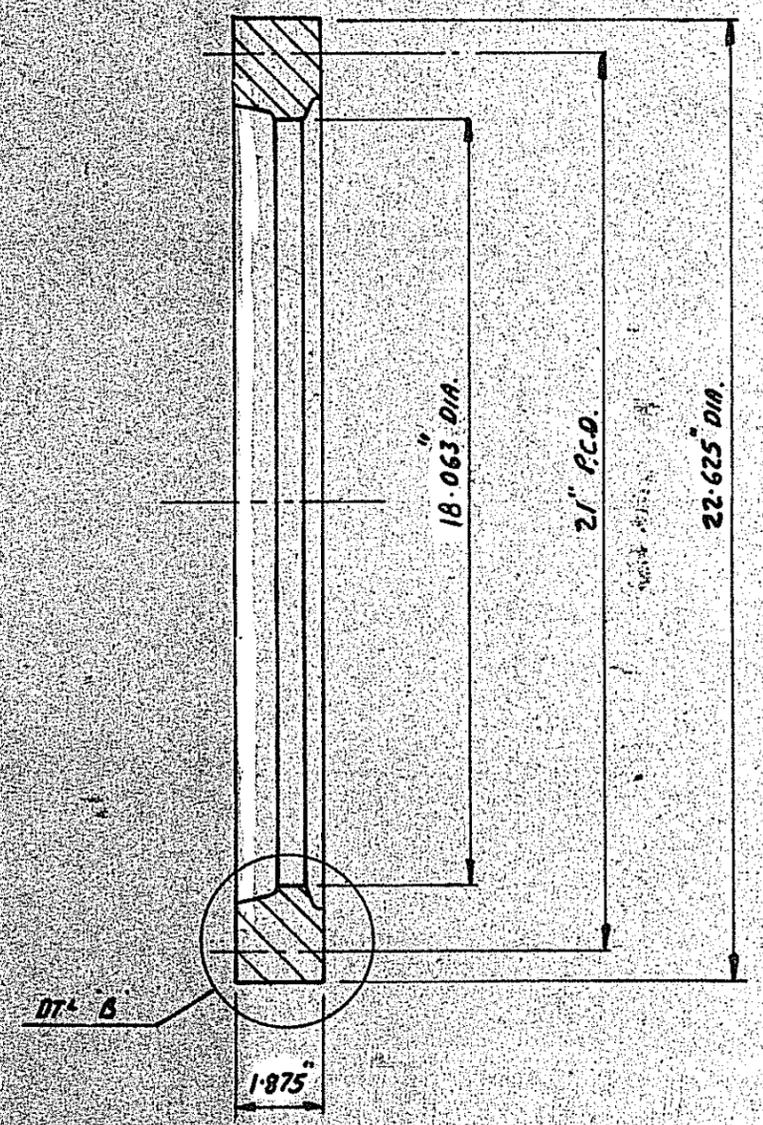
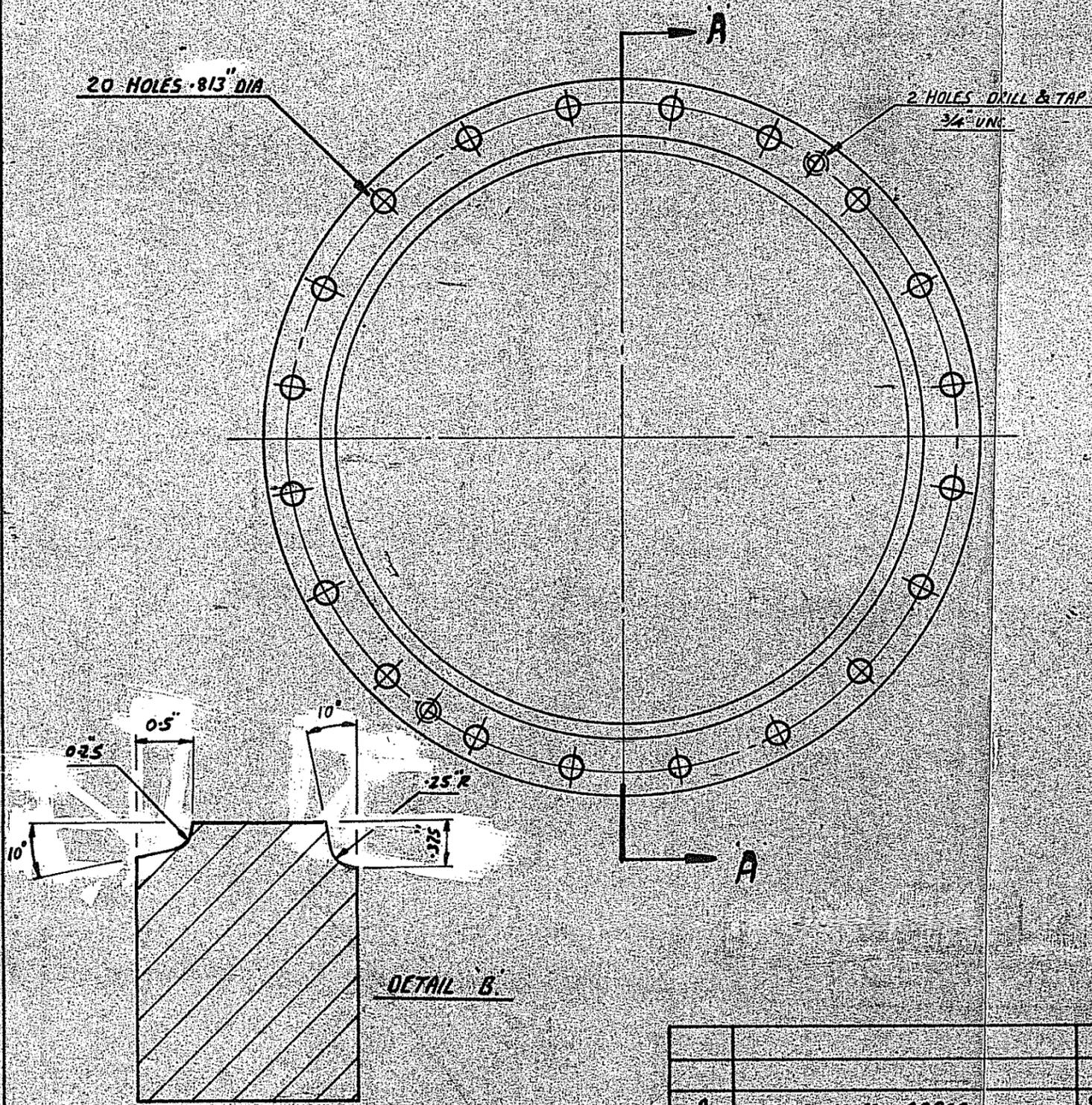
ICI N° FX/C 417825

					DRAWN	G. GREENFIELD	GEA AIREXCHANGERS (NI) LTD	C. NO. 280/99549
					CHK'D	[Signature]		DRG. NO. 1857 0003 21
					APP	[Signature]	TITLE	
					DATE	1. 6. 71.	GASKET.	ISSUE
MOD.	REVISION	SIG.	DATE	SCALE				

E1514

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FOSTER WHEELER CONTRACT N°	1-15-1990/1959
" " REGULATION N°	1992-1211-C
" " ORDER N°	3009/1990
ITEM N°	E 1514
VENDORS SHOP ORDER N°	
CLIENTS NAME	I.C.I. FIBRES LTD.
PROJECT LOCATION	WILTON TEESSIDE



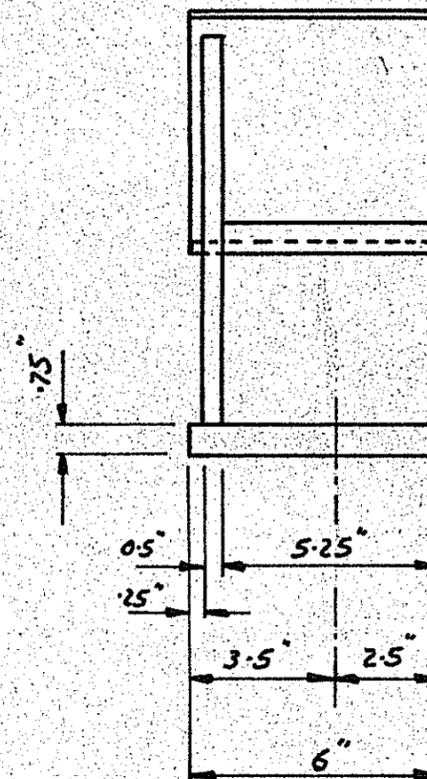
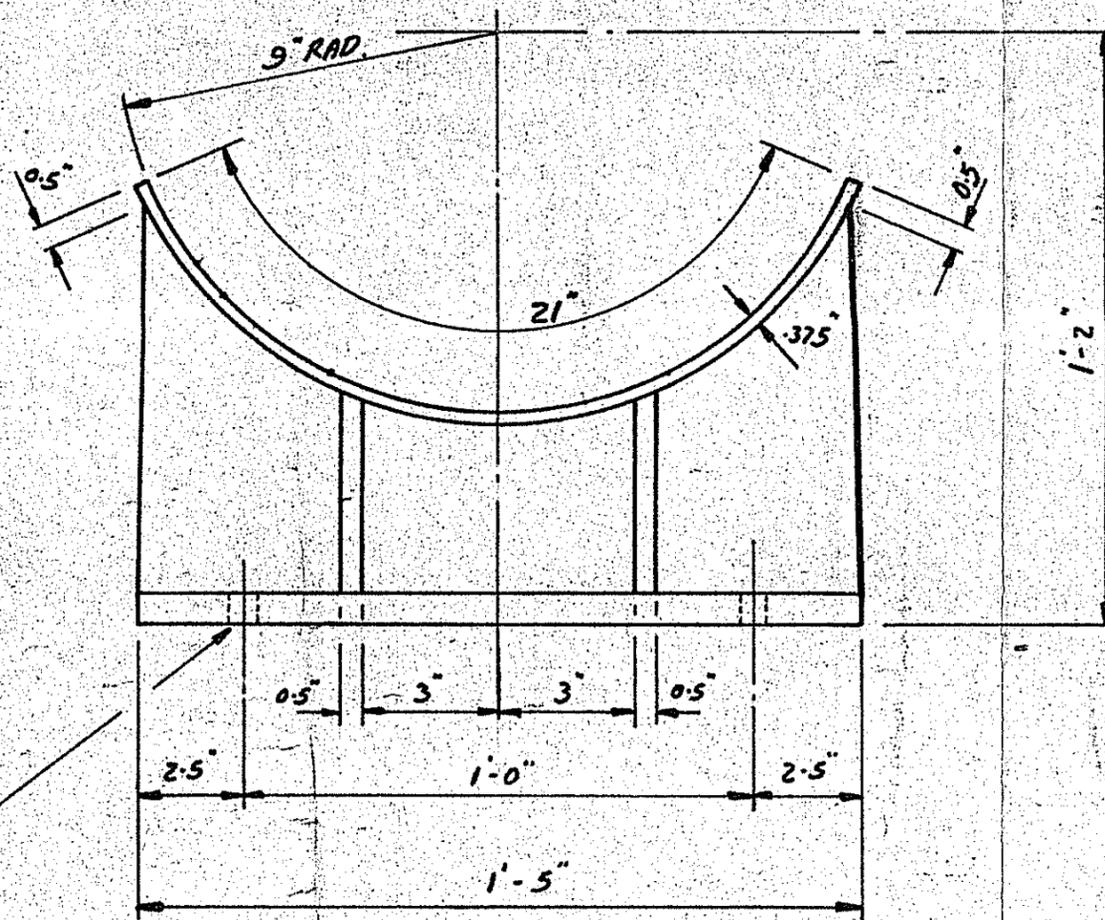
SECTION AA' 2- Off as drawn.

ICI N° FIX/C 417827

DRAWN	G. GARDNER	GEA AIREXCHANGERS (NI) LTD	C NO. 280 / 99549
CHK'D		TITLE	DRG. NO. 18 59 0009 21
APP.		CHANNEL FLANGE	ISSUE A
DATE	20.10.71		
SIG.			
MOD.			
REVISION			
SCALE	3"-1"		

OZALID 12202

E1514



Holes in Baseplate

Fixed Support 2 - 1" DIA HOLES

Floating Support 2 Slots 1" x 1.25"

All welds 1/4 continuous fillet welds

A 1/4" DIA WEAP HOLE TO BE PROVIDED IN SADDLE PLATE

1 OFF WITH 2 - 1" DIA HOLES IN BASE

1 OFF WITH 2 - 1" x 1.25" SLOTS IN BASE

CERTIFIED FINAL

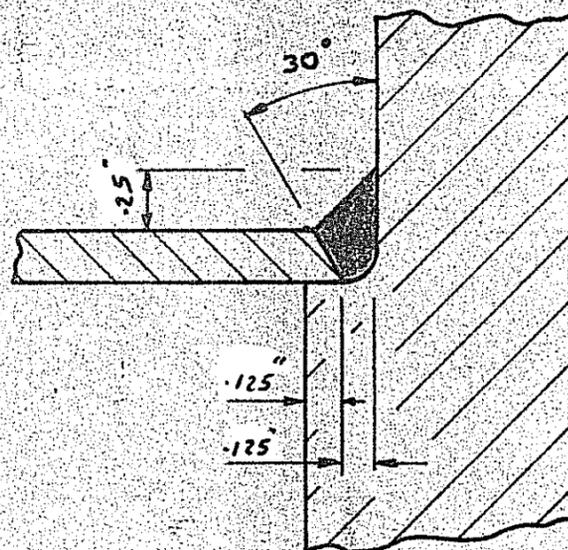
Clients Name	ICI Fibres LTD
Project Location	Wilton Teeside
FOSTER WHEELER CONTRACT N°	1-15-1440/1459
REQUISITION N°	1442-1211-C REV 5
ORDER N°	3009/1440
ITEM N°	E 1514
VENDORS SHOP ORDER N°	
ICI N° FXIC 417826	

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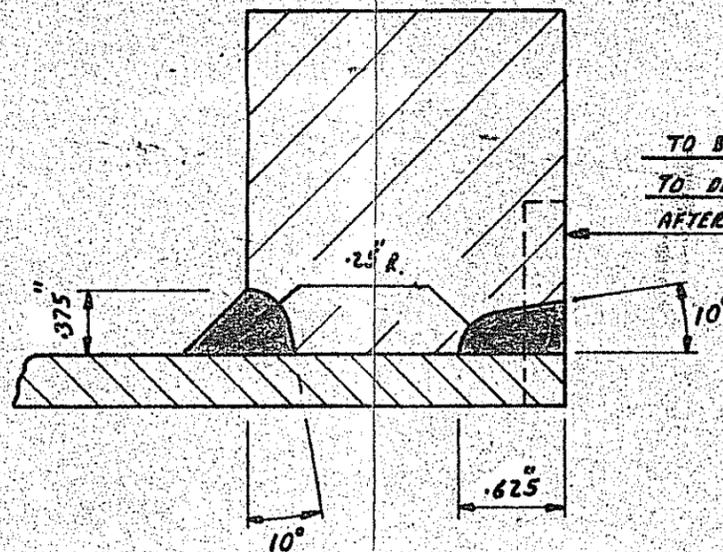
MOD.	REVISION	SIG.	DATE	DRAWN	CH'K'D	APP.	DATE	SCALE	GEA AIREXCHANGERS (NI) LTD	C. NO. 280/99549
				G. GREENFIELD			17. 8. 71	3"-1"	TITLE	DRG. NO. 18.59 002 21
									SADDLE DETAILS.	ISSUE

E 1514

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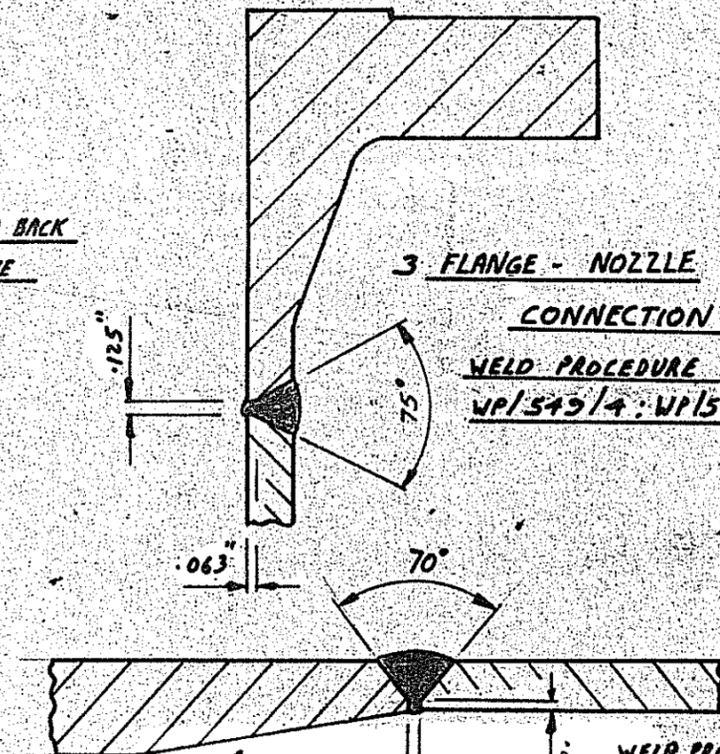


1 TUBESHEET - SHELL CONNECTION
WELD PROCEDURE NO WP/549/3



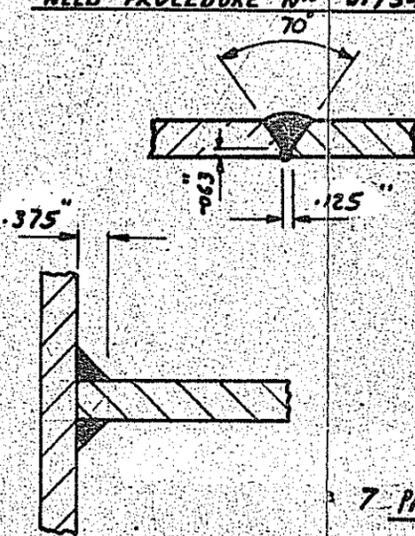
2 RING FLANGE - SHELL CONNECTION
WELD PROCEDURE NO WP/549/7

TO BE MACHINED BACK
TO DOTTED LINE
AFTER WELDING

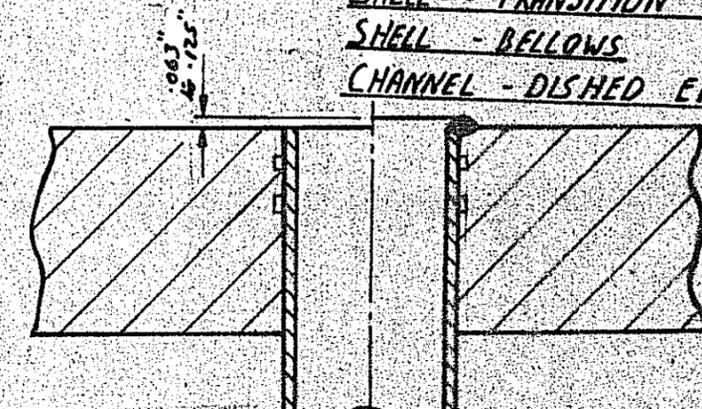


3 FLANGE - NOZZLE CONNECTION
WELD PROCEDURE NO WP/549/4 : WP/549/9

6 LONGITUDINAL AND CIRCUMFERENTIAL SEAMS
WELD PROCEDURE NO WP/549/1



4 CONNECTIONS FOR SHELL - TRANSITION PIECE SHELL - BELLOWS CHANNEL - DISHED ENDS.
WELD PROCEDURE NO WP/549/2 WP/549/6 WP/549/1



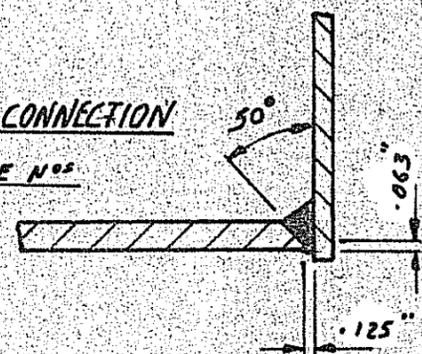
TUBE TO BE LIGHTLY EXPANDED PRIOR TO WELDING

8 TUBE - TUBEPLATE CONNECTION
WELD PROCEDURE NO WP/549/1

7 PARTITION PLATE CONNECTION
WELD PROCEDURE NO WP/549/10

5 NOZZLE CONNECTION

WELD PROCEDURE NOS
WP/549/8
WP/549/5

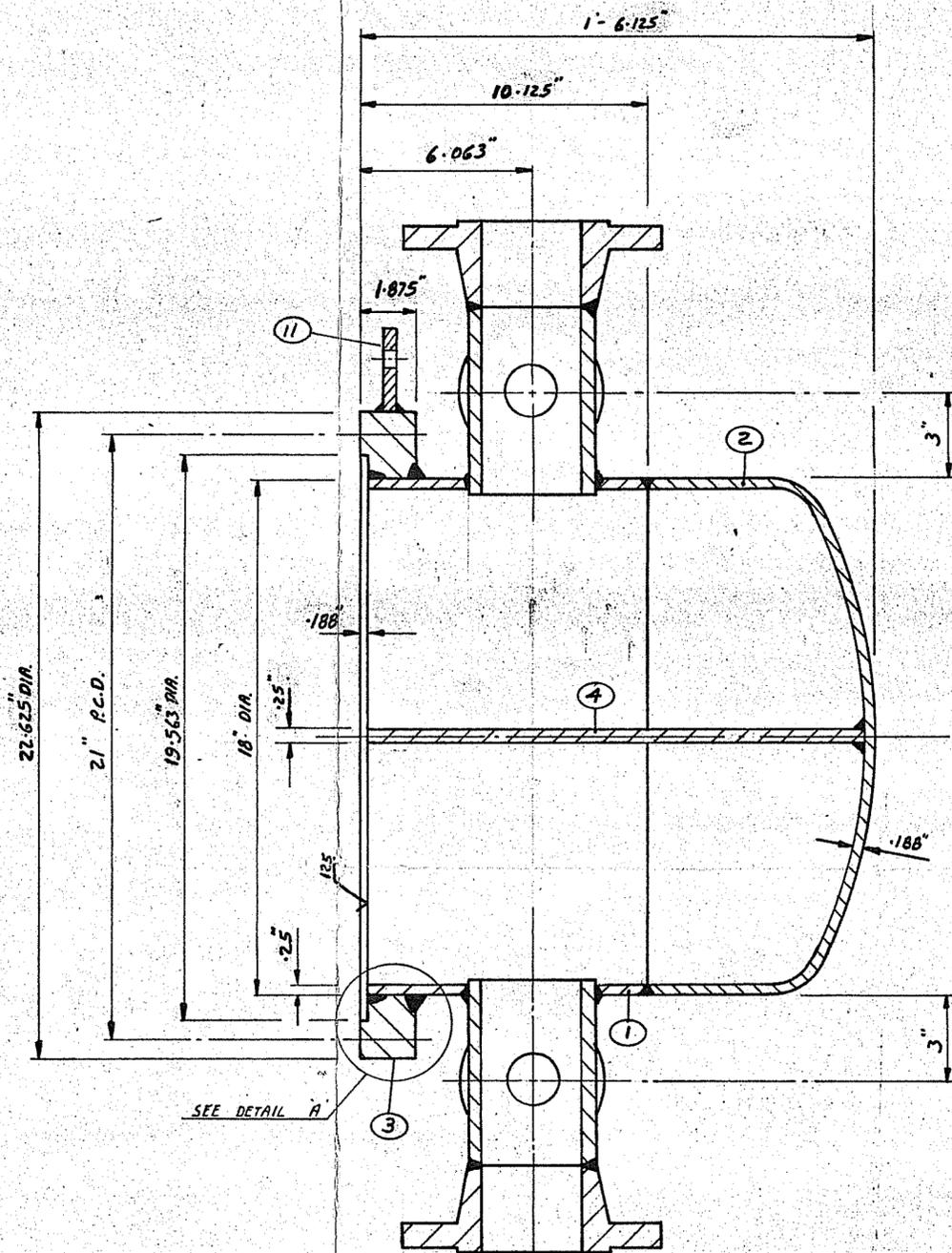
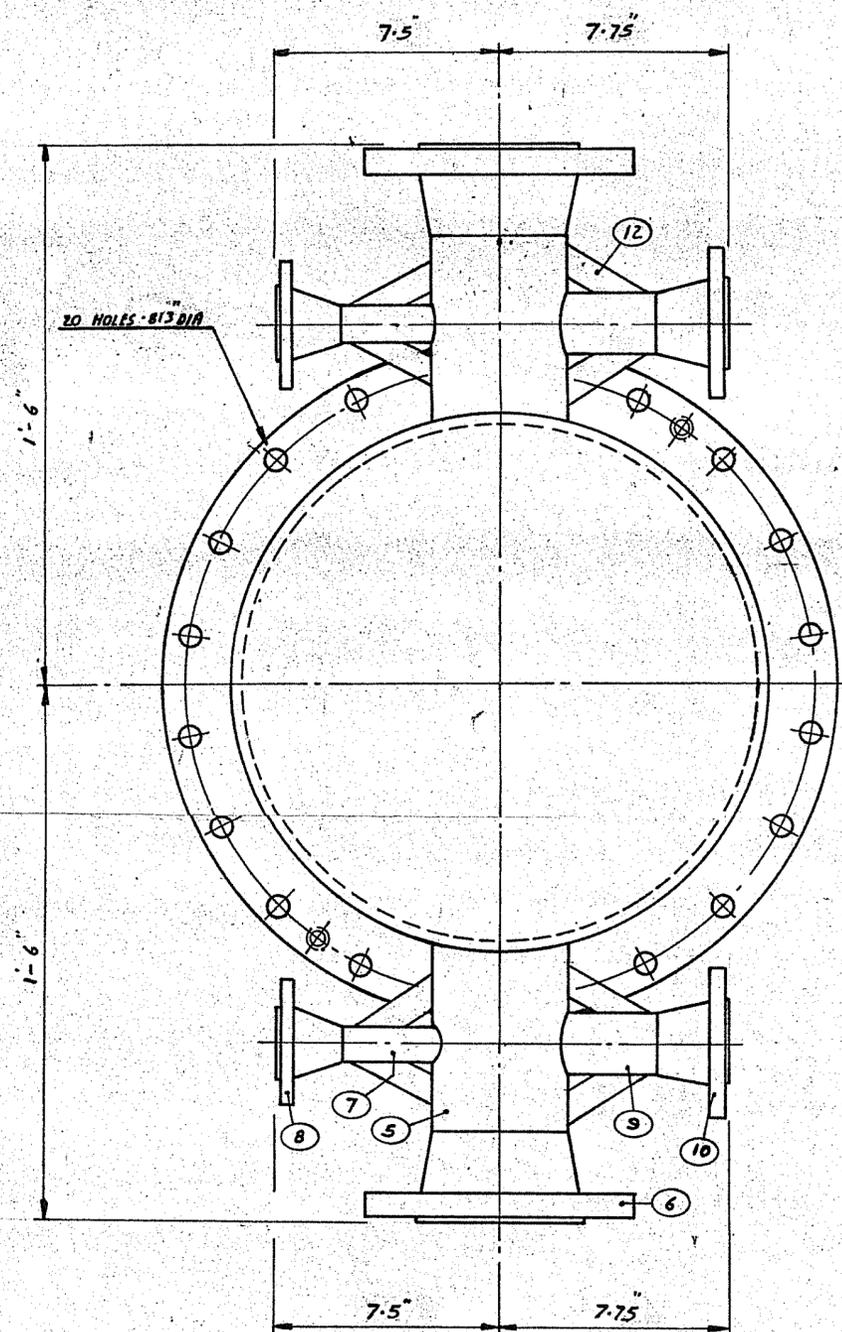


FOSTER WHEELER CONTRACT NO	1-15-1440/1459
REQUISITION NO	1442-1211-C REV 5
ORDER NO	3009/1440
ITEM NO	E 1514
VENDORS SHOP ORDER NO	
CLIENTS NAME	ICI FIBRES LTD.
PROJECT LOCATION	WILTON TEESIDE

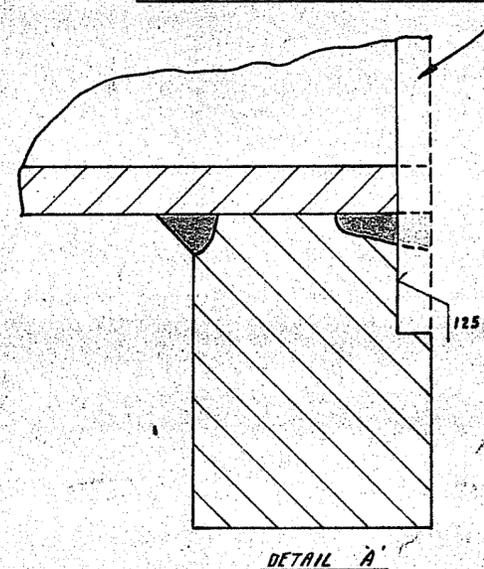
MOD.	REVISION	SIG.	DATE	SCALE	DRAWN G. GREGG/AFIELD	CH'K'D	APP	DATE 1. 6. 71.	GEA AIREXCHANGERS (NI) LTD	C NO. 280/99549
									TITLE	DRG NO 1859 0011 21
									WELD DETAILS	ISSUE

ICI NO FIXIC 417823

E 1514



NOTE :- FLANGE TO BE WELDED TO CYLINDER
AND THEN FACING TO BE MACHINED.



SEE DETAIL A

CERTIFIED FINAL

Clients Name	ICI Fibres LTD
Project Location	Wilton Teesside
FOSTER WHEELER CONTRACT N°	1-15-1440/1459
" " REQUISITION N°	1442-1211-C REV 5
" " ORDER N°	3009/1440
ITEM N°	E 1514
VENDORS SHOP ORDER N°	

ICI N° F/X/B 417816

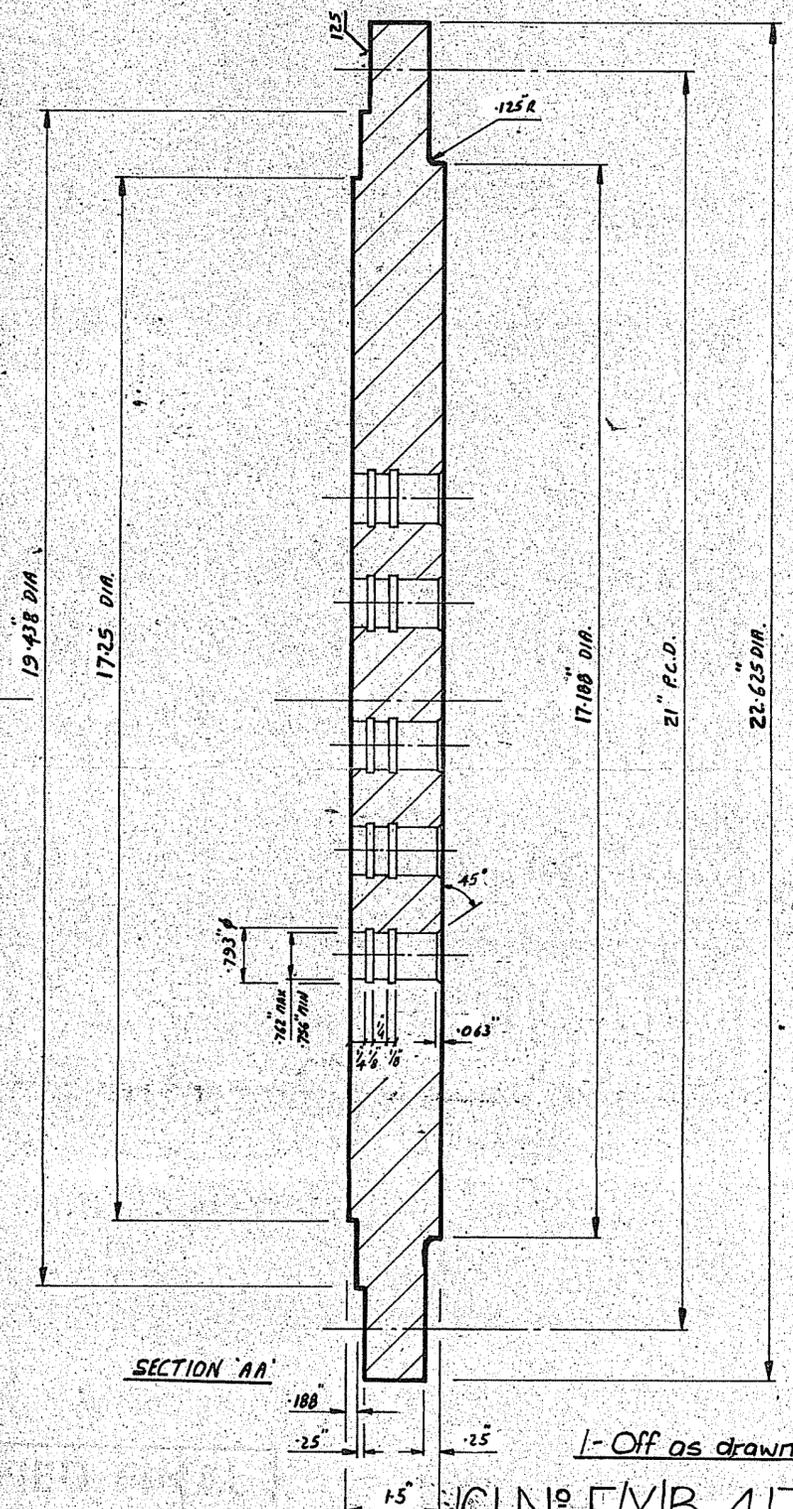
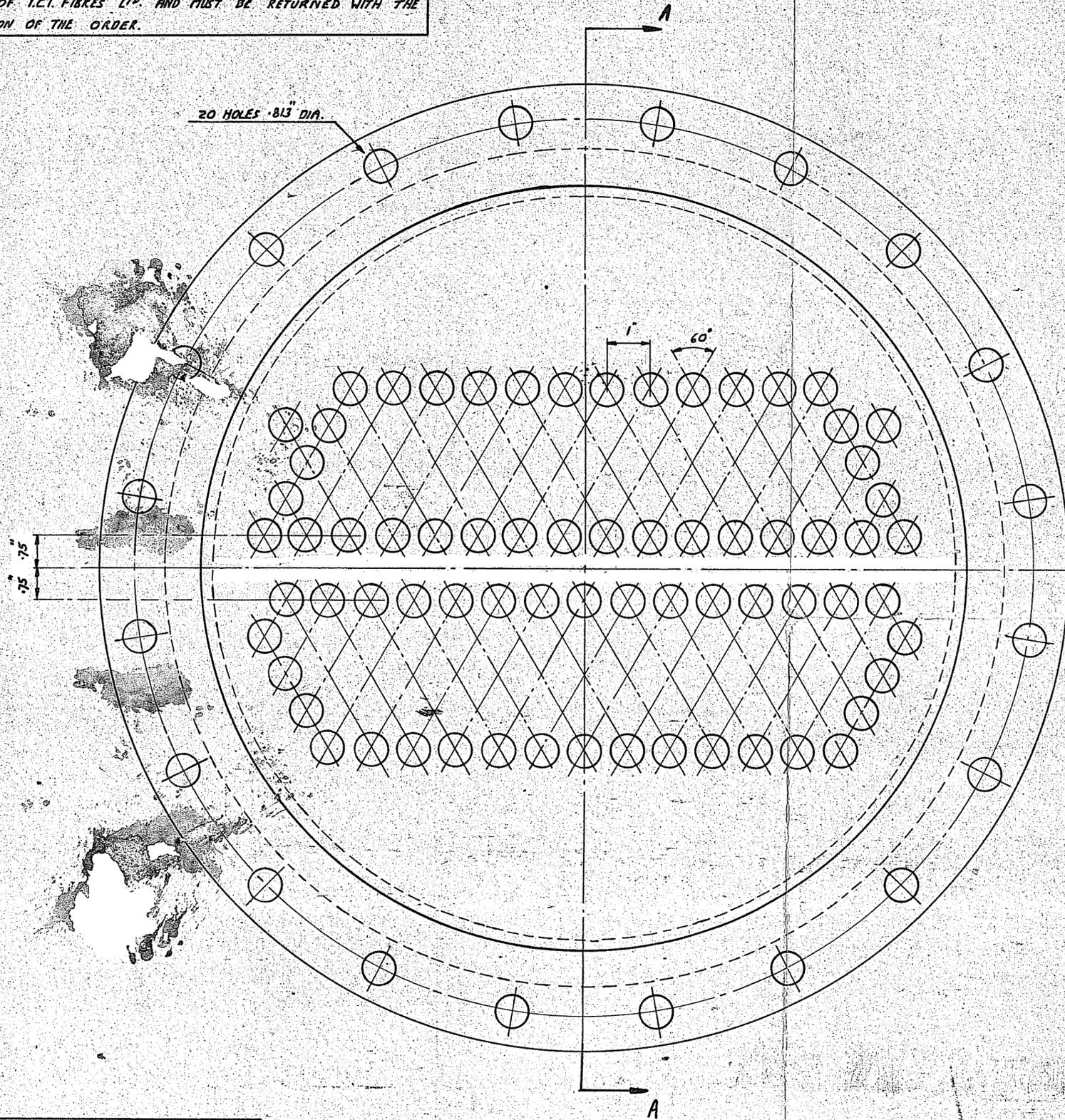
1-OFF AS DRAWN

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MOD.	REVISION	SIG.	DATE	DRAWN	G. GREENFIELD	GEA AIREXCHANGERS (NI) LTD.	C NO. 280/199549
A	NOZZLE STIFFENERS & LIFTING LUG ADDED		21. 10. 71.	CH'K'D			DRG NO. 1059.0007 21 GEA
				APP.		FIRST CHANNEL DETAILS	ISSUE A
				DATE	7. 7. 71		
				SCALE	3"-1"		

E1514

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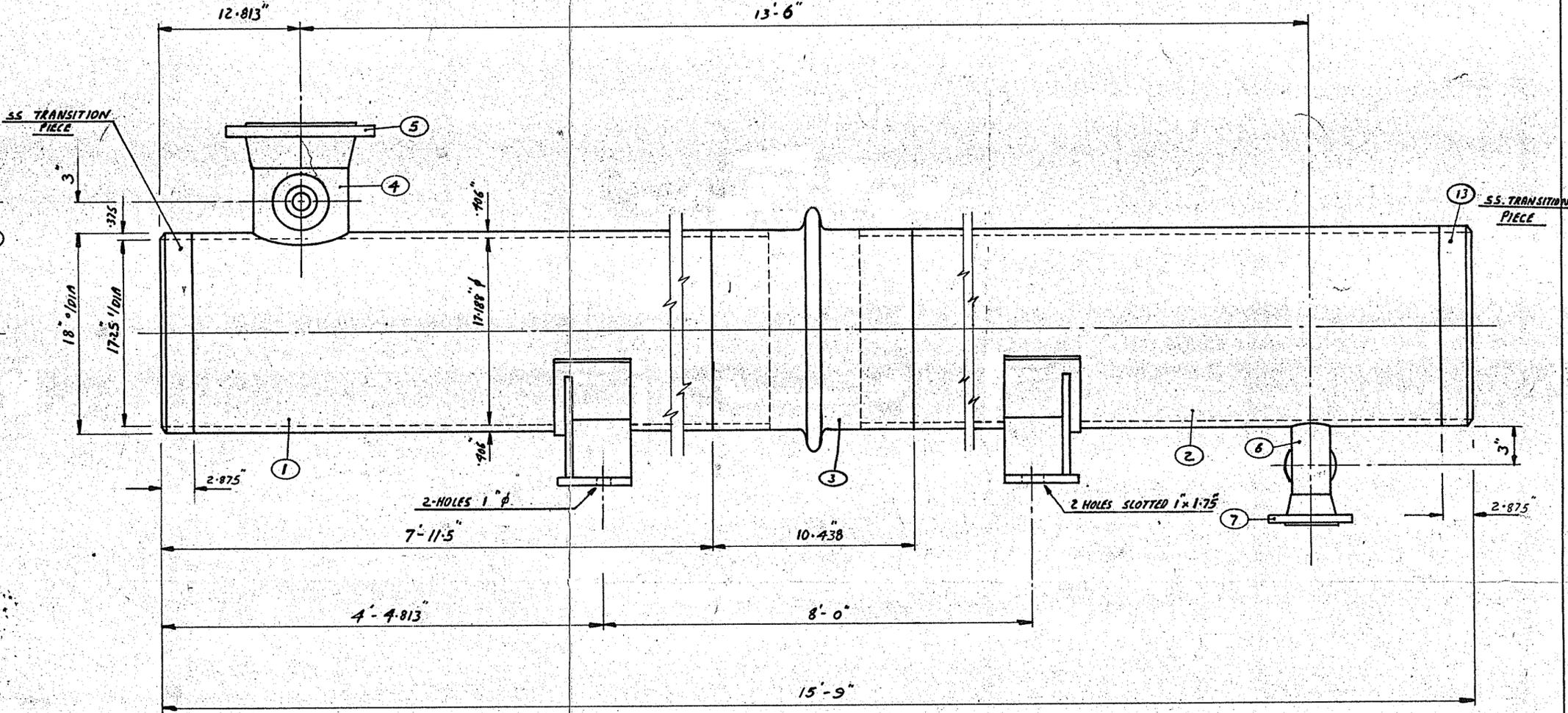
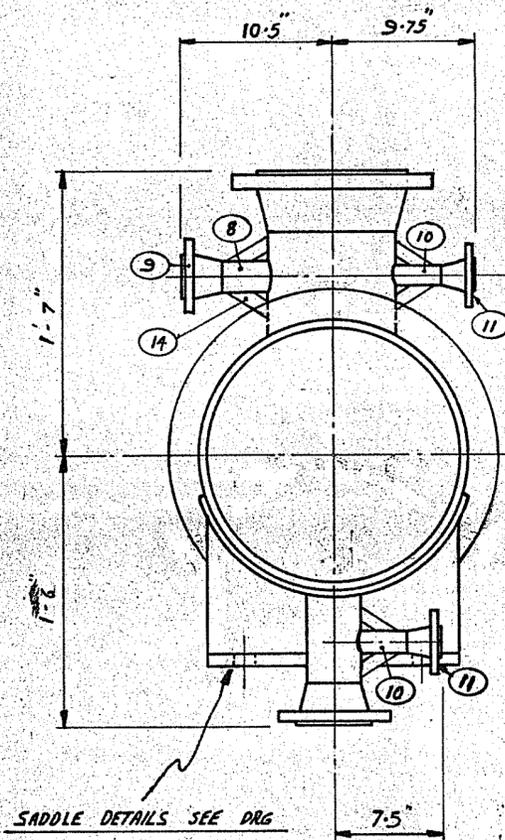


FOSTER WHEELER CONTRACT N°	1-15-1990 / 1459
REQUISITION N°	1492-1211-C REV 5
ORDER N°	3009 / 1440
ITEM N°	E 1514
VENDORS SHOP ORDER N°	
CLIENTS NAME	ICI FIBRES LTD.
PLANT LOCATION	WILTON TEESIDE

MOD.	REVISION	SIG.	DATE	DRAWN	G. GREENFIELD.	GEA AIREXCHANGERS (NI) LTD.	C NO.	280 / 99549
				CH'K'D			DRG. NO.	18.12.0006.21 GEA
				APP.			ISSUE	
				DATE	2. 7. 71	SECOND TUBESHEET		
				SCALE	1/2 FULL SIZE			

ICI N° FX/B 4178

E 1514



CERTIFIED FINAL

Clients Name	ICI Fibres LTD.
Project Location	Wilton Teesside
FOSTER WHEELER CONTRACT N°	1-15-1440 / 1459
" " REQUISITION N°	1442-1211-C REV 5
" " ORDER N°	3009 / 1440
ITEM N°	E 1514
VENDORS SHOP ORDER N°	
ICI N° F/X/C 417822	

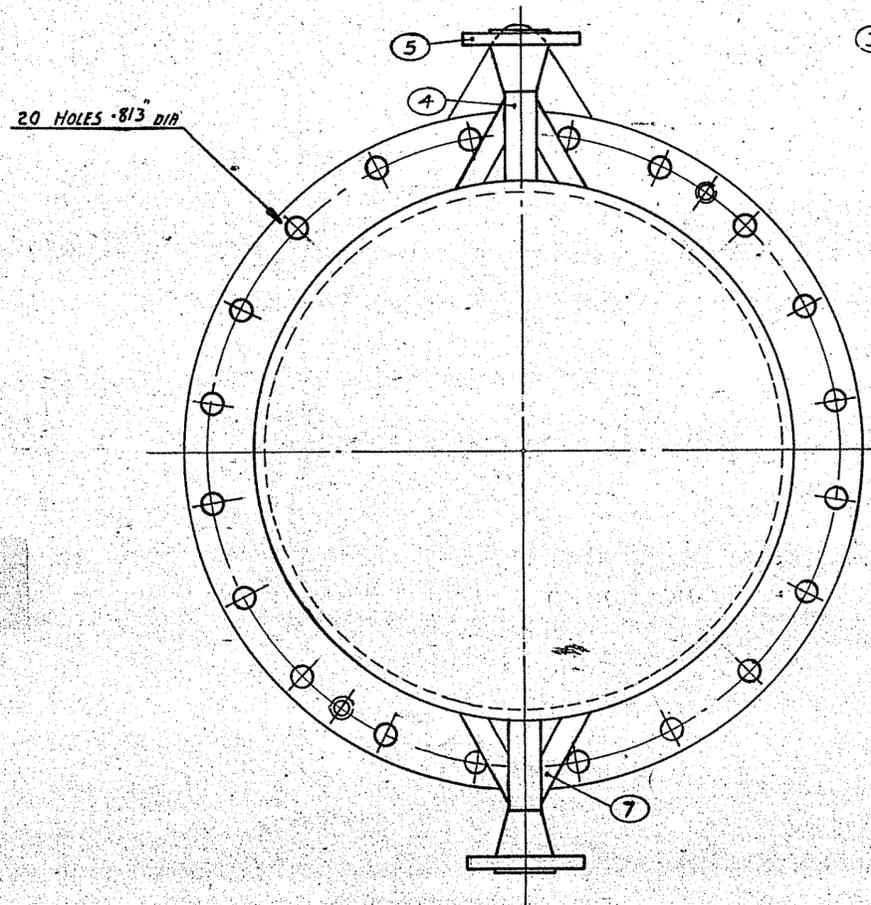
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MOD.	REVISION	SIG.	DATE	DRAWN	G. GREENFIELD.
B	NOZZLE STIFFENERS ADDED	B	21. 10. 71	CH'K'D.	
A	Details A & B removed	A.V.	3. 9. 71	APP.	
				DATE	6. 7. 71.
				SCALE	1 1/2" - 1'

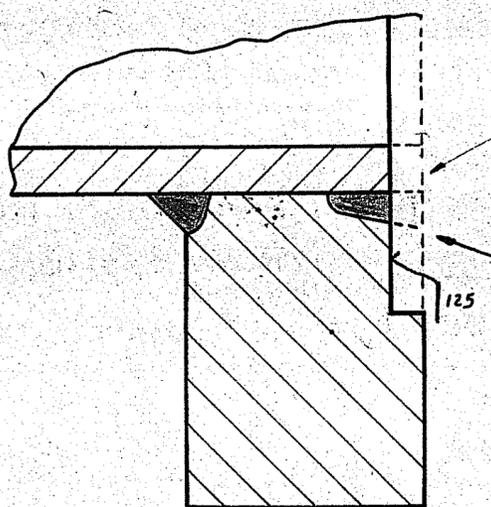
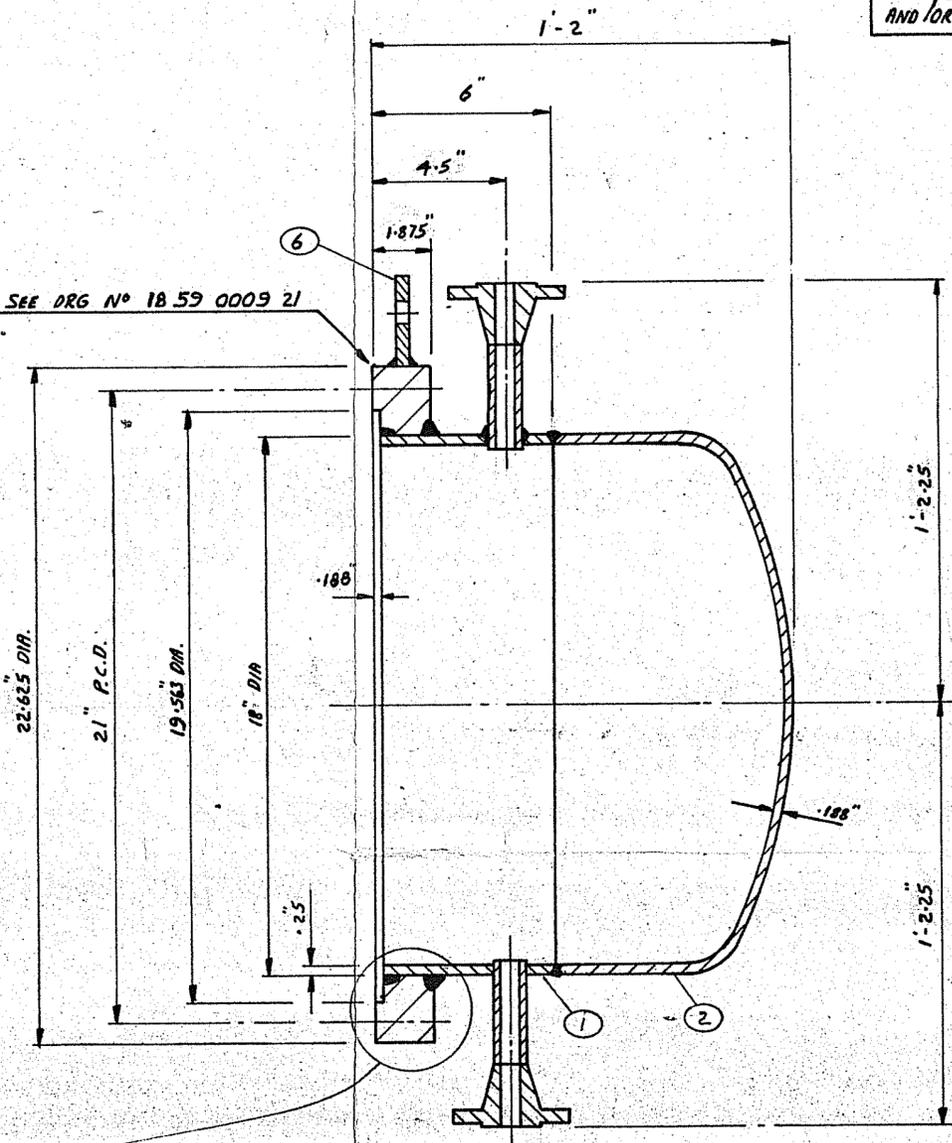
GEA AIREXCHANGERS (NI) LTD.	C NO. 280 / 99549.
<u>SHELL DETAILS.</u>	DRG NO. 18 52 0002 21 GEA
ISSUE	A B

E 1514

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③ SEE DRG NO 18.59 0009 21



NOTE :- FLANGE TO BE WELDED TO CYLINDER AND THEN FACING TO BE MACHINED.

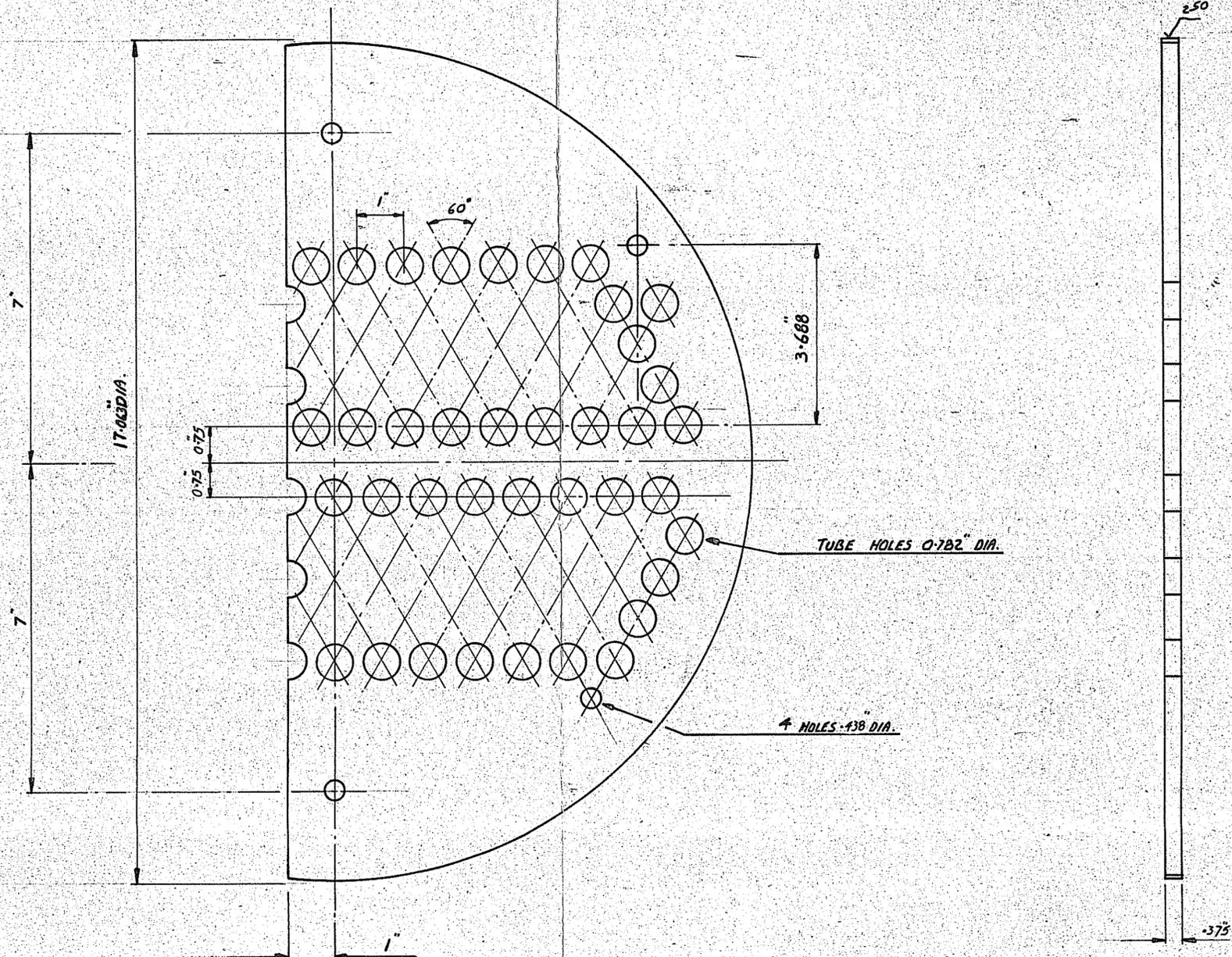
CERTIFIED FINAL

Clients Name	ICI Fibres LTD
Project Location	Wilton Teesside
FOSTER WHEELER CONTRACT N°	1-15-1440/1459
" " REQUISITION N°	1442-1211-C REV 5
" " ORDER N°	3009/1440
ITEM N°	E 1514
VENDORS SHOP ORDER N°	
ICI N° F/X/B 417817	

1-OFF AS DRAWN.

				DRAWN	G. GREENFIELD.	GEA AIREXCHANGERS (NI) LTD.	C NO. 280/99549.
				CH'K'D	<i>[Signature]</i>		DRG NO. 18.59 0008 21 66A
				APP.	<i>[Signature]</i>		
A	LIFTING LUG; NOZZLE STIFFENERS ADDED.	<i>[Signature]</i>	20. 10. 71	DATE	7. 7. 71.	SECOND CHANNEL DETAILS	ISSUE
MOD.	REVISION	SIG.	DATE	SCALE	3"-1'		A

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TUBE HOLES 0.782" DIA.

4 HOLES .438 DIA.

6-Off as drawn.

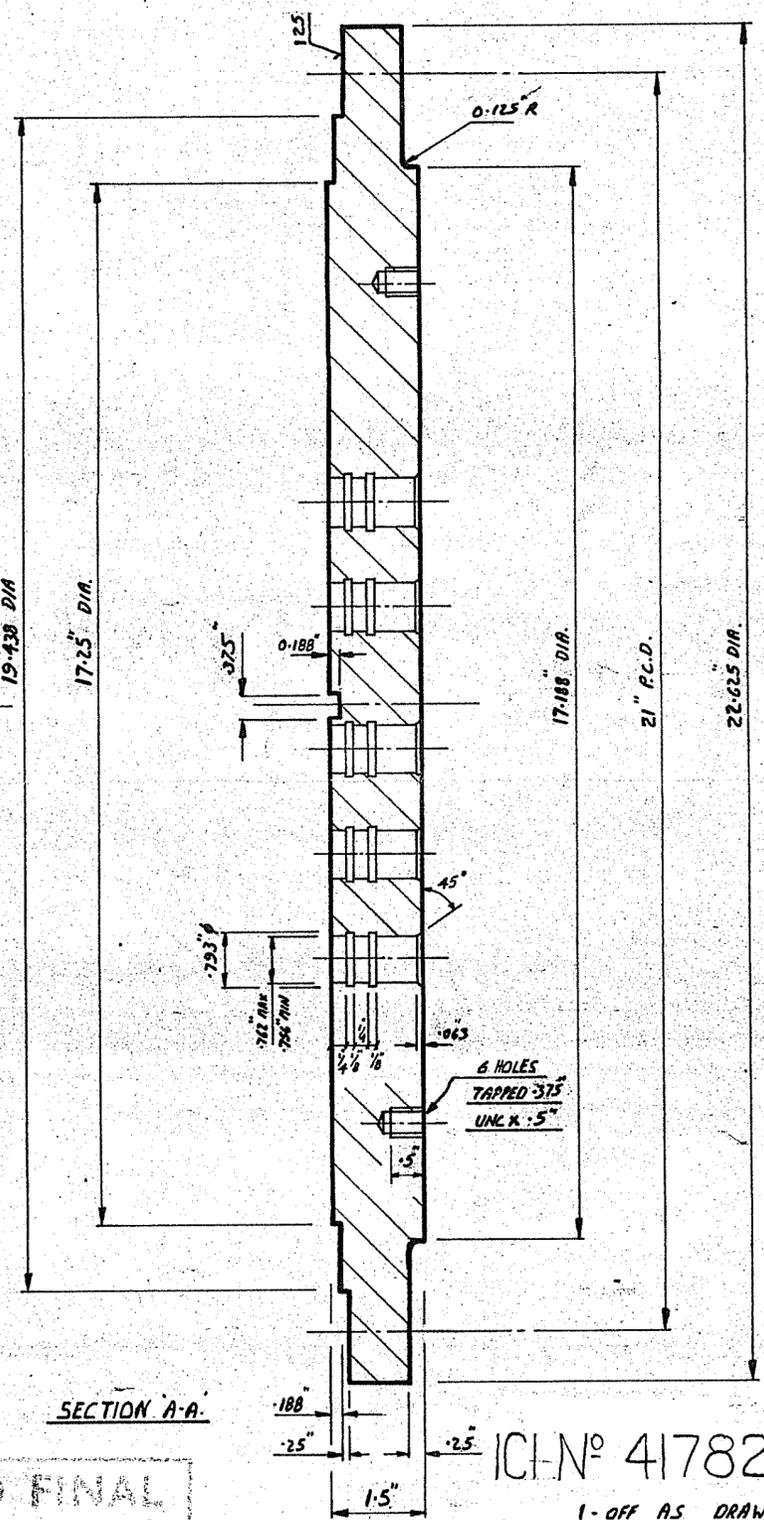
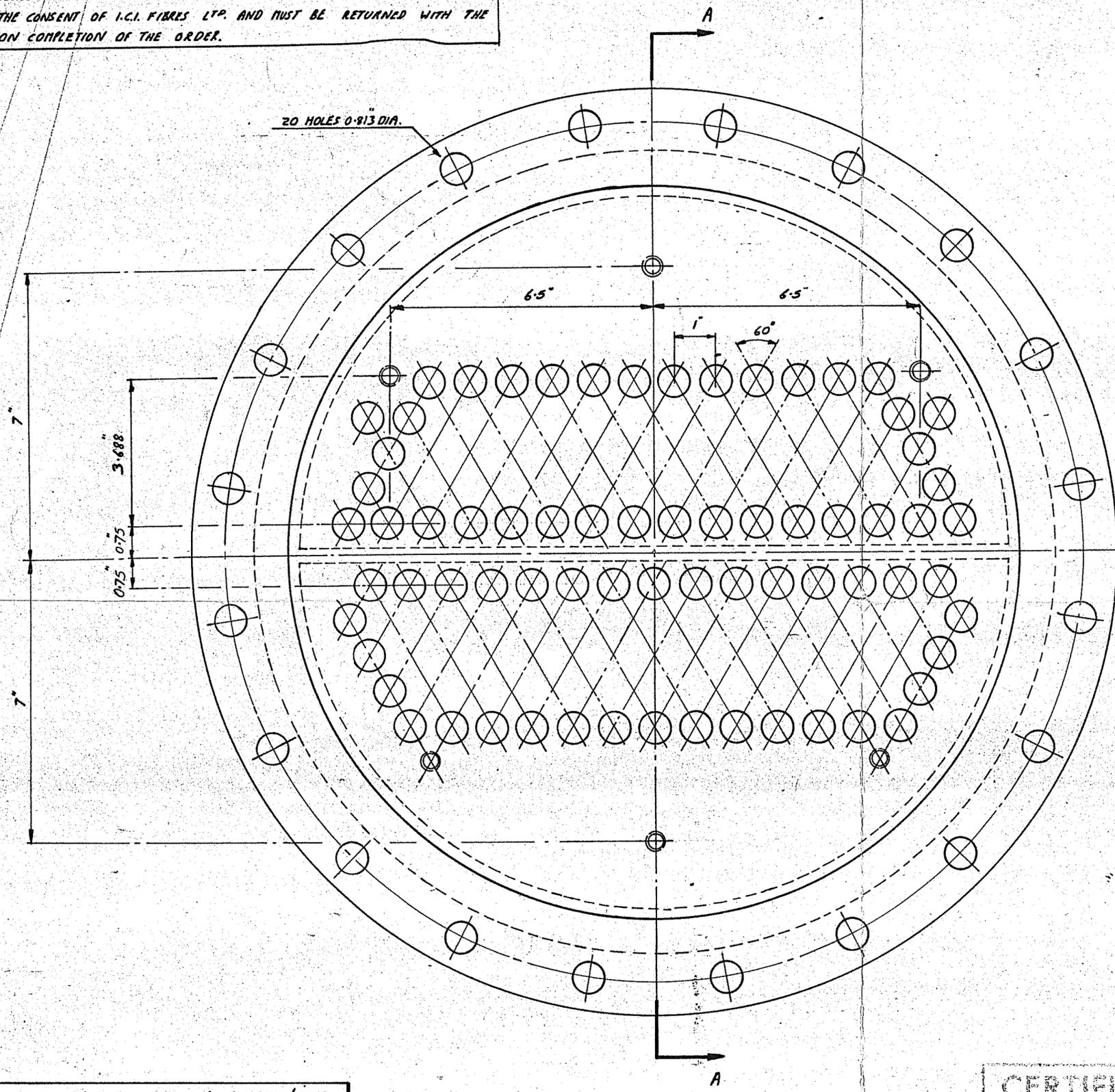
FOSTER WHEELER CONTRACT N°	1-15-1440 / 1459
" " REQUISITION N°	1442-1211-C REV 5
" " ORDER N°	3009 / 1440
ITEM N°	E 1514
VENDORS SHOP ORDER N°	
CLIENTS NAME	ICI FIBRES LTD.
PROJECT LOCATION	WILTON TEESIDE

ICIN° F/X/B 417820

MOD.	REVISION	SIG.	DATE	DRAWN	G. GREENFIELD	GEA AIREXCHANGERS (NI) LTD.	C NO.	280 / 99549
				CH'K'D			DRG NO.	18 19 0008 21 - GEA.
				APP.	SEB		ISSUE	
				DATE	2. 7. 71	BAFFLE PLATE.		
				SCALE	1/2 FULL SIZE			

E1514

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CERTIFIED FINAL

ICI-N° 417821 F/X/B

1-OFF AS DRAWN.

FOSTER WHEELER CONTRACT N°	1-15-1990/1459
REVISION N°	1492-1211-C REV 5
ORDER N°	3009/1440
ITEM N°	E 1514
VENDORS SHOP ORDER N°	
CLIENTS NAME	ICI FIBRES LTD.
PROJECT LOCATION	WILTON TEESIDE

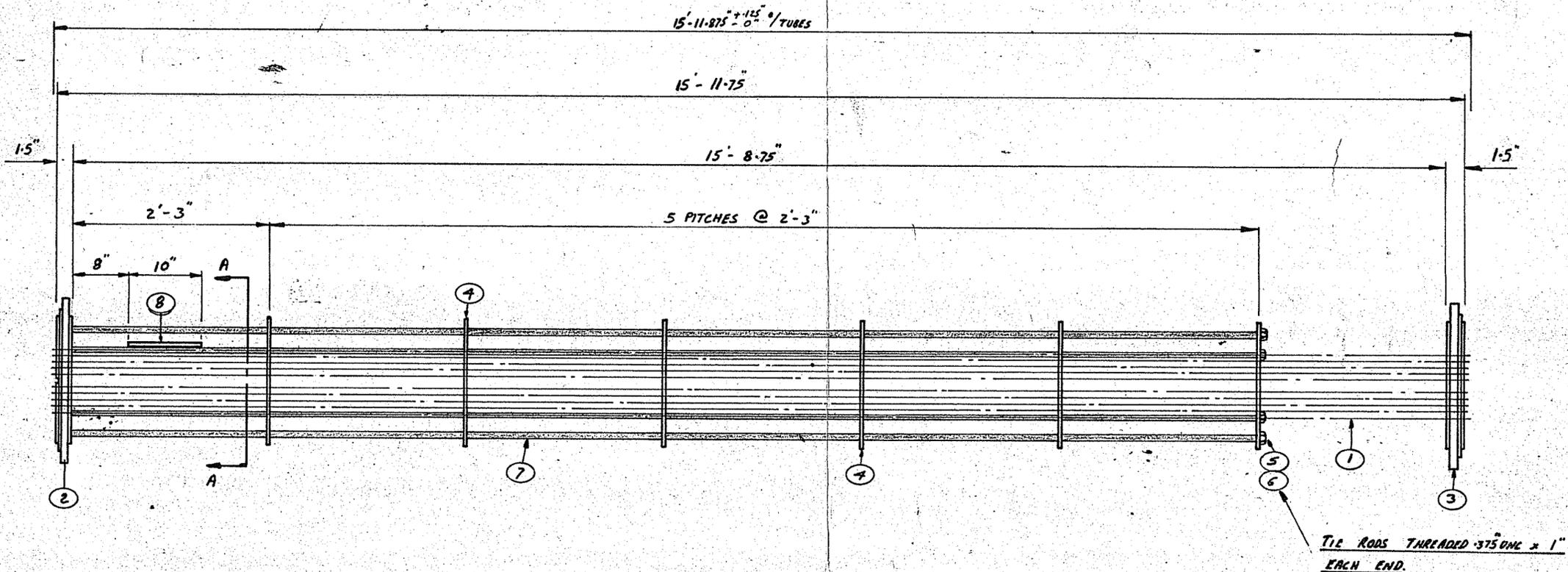
MOD.	REVISION	SIG.	DATE	SCALE	1/2 FULL SIZE

GEA AIREXCHANGERS (NI) LTD.
FIRST TUBESHEET

C NO.	280/99549
DRG NO.	18.12.0005.21 GEA
ISSUE	

E1514

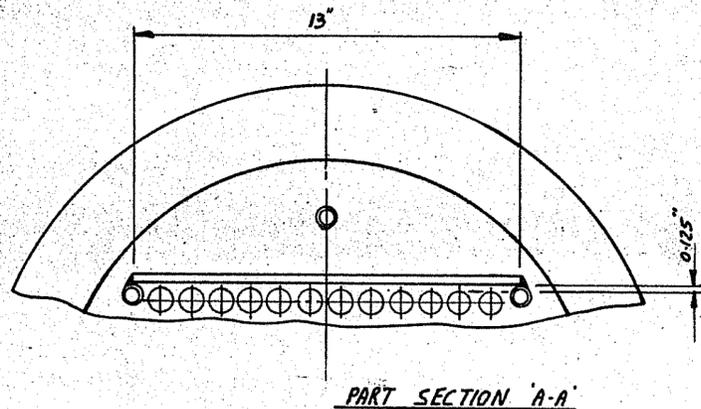
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NOTE :-

1. IMPINGEMENT PLATE (ITEM 8) TO BE WELDED TO SIZER TUBE PRIOR TO TUBING BUNDLE
2. TUBE WELDING TO BE DONE WHEN TUBEPLATES ARE WELDED INTO SHELLS
3. ENDS OF TUBES TO BE CLEANED INSIDE AND OUT FOR A LENGTH OF 2 3/4" AT EACH END. USING A DEGREASING SOLVENT.
4. TUBEPLATES TO BE DEBURRED AND CLEANED ALL OVER USING A DEGREASING SOLVENT.
5. OUTSIDE SURFACE OF TUBE TO BE CLEANED BACK TO BRIGHT METAL USING GLASS PAPER FOR 3/4" EACH END.
6. TUBES TO BE LIGHTLY EXPANDED INTO TUBESHEET PRIOR TO WELDING.
7. WELDS TO BE CONCENTRIC WITH TUBE HOLES AND HAVE A UNIFORM CONTOUR.
8. EACH TUBE WELD TO BE LEAK DETECTED BEFORE HYDROSTATIC TEST AND BEFORE FINAL EXPANSION. THE TEST TO BE PERFORMED USING HALIDE GAS AT 50 PSIG.
9. TUBES TO BE FULLY EXPANDED AFTER LEAK TEST.

CERTIFIED FINAL

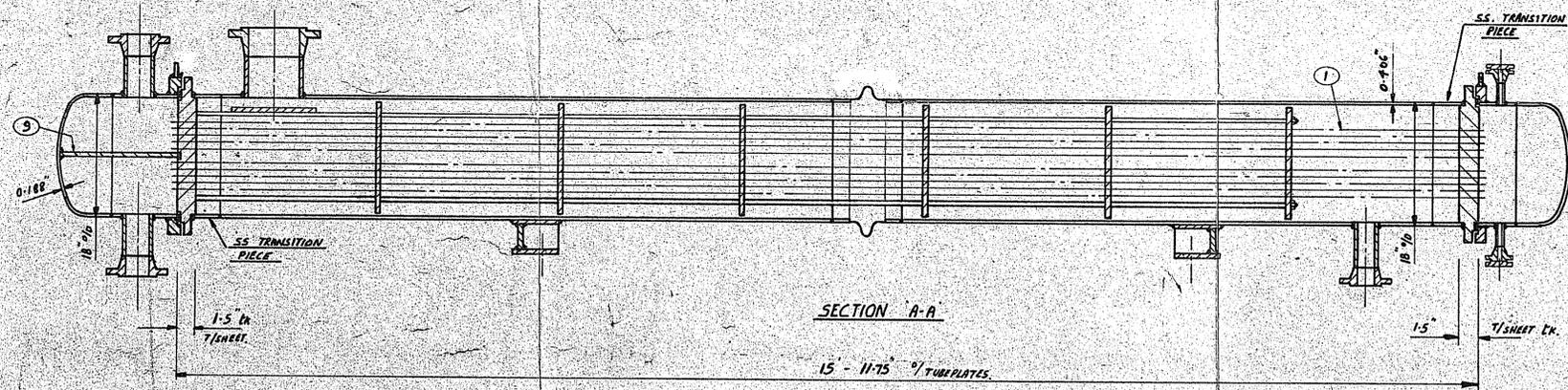
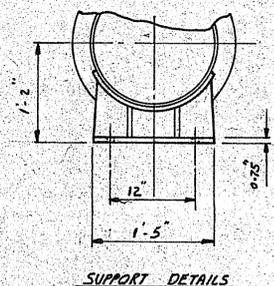
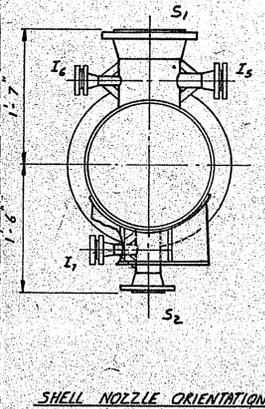
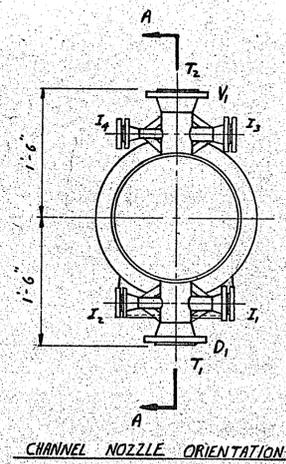
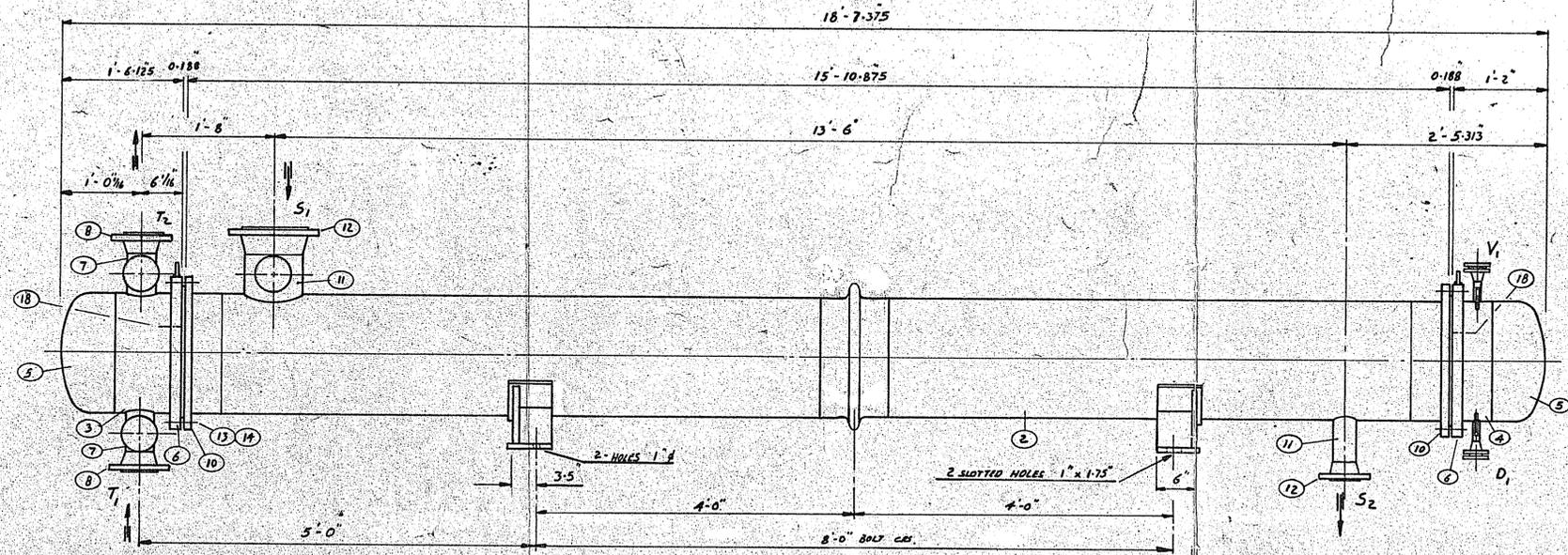


Client's Name	ICI Fibres LTD
Project Location	Wilton Teesside
FOSTER WHEELER CONTRACT N°	1-15-1440/1459
" " REQUISITION N°	1442-1211-C REV 5
" " ORDER N°	3009/1440
ITEM N°	E 1514
VENDORS SHOP ORDER N°	
ICI N° FX/B 417819	

DRAWN	G. GREENFIELD.	GEA AIREXCHANGERS (NI) LTD.	C NO.	280/99549.	
CHK'D			DRG NO.	18.10.0002.21 GEA	
APP.			TUBE BUNDLE.	ISSUE	
DATE	5. 7. 71.				
SCALE	1" = 1'				
MOD.	REVISION	SIG.	DATE		

E 1514

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MATERIALS OF PRESSURE PARTS.		
1.	SEAMLESS TUBE	A213 304L WITH MATERIAL TEST CERT.
2.	MAIN SHELL	A106 B
3, 4.	CHANNEL SHELL	A312 304L
5.	CHANNEL DISHED END	A403 304L
6.	CHANNEL RING FLANGE	A182 304L
7.	CHANNEL NOZZLES	A312 304L
8.	CHANNEL NOZZLE FLANGES	A182 304L
9.	PARTITION PLATE	A240 304L
10.	TUBEPLATE	A240 304L
11.	SHELL NOZZLES	A106 A
12.	SHELL NOZZLE FLANGES	A181 - 1
13.	STUDBOLT	A193 - B7
14.	NUT	A194 - 2H
15.	GASKET	SARAL WOUND TP316 + FLUON
16.	BELLOWS	INCOLOY 825
17.	SS. TRANSITION PIECE	A240 304L

WELDING	
WELDING METHOD	
WELDING FACTOR	0.85
WELDING ELECTRODE	
WELD PREPARATION	ASME VIII
NON-DESTRUCTIVE TEST	SPOT-RADIOGRAPH DYE PENETRANT CHECK AS SHOWN
PREHEATING	NONE
POST HEATING	NONE

OPERATING DATA		SHELL SIDE	TUBE SIDE
DESIGN TEMPERATURE	304°F 154°C	250°F 121°C	
DESIGN PRESSURE	75 PSI 5.17 BAR G	150 PSI 10.34 BAR G	
TEST PRESSURE	113 PSI 7.78 BAR G	228 PSI 15.72 BAR G	
ASSEMBLED WEIGHT		4250 LB	
ASSEMBLED WEIGHT FLOODED		3950 LB	
CORROSION ALLOWANCE	0.125	0.063	

INSPECTION	
DRAWING EXAMINATION BY	FOSTER WHEELER LTD.
CONSTRUCTION CONTROL BY	
PRESSURE TEST BY	
INSPECTION ACC. TO	ASME VIII & TEMA 'R' (1968 EDITIONS)
DESIGN ACC. TO	

- NOTE :-
- CARE TO BE TAKEN DURING ASSEMBLY TO ENSURE THAT THE IMPINGEMENT RATE IS IN LINE WITH THE INLET NOZZLE.
 - CLEANING
 - PRIOR TO WELDING
 - ENDS OF TUBES TO BE CLEANED INSIDE AND OUT FOR AT LEAST A LENGTH OF 2 1/4" USING A DEGREASING SOLVENT.
 - TUBEPLATE TO BE DEBURKED AND CLEANED ALL OVER USING A DEGREASING SOLVENT.
 - OUTSIDE SURFACE OF TUBE TO BE CLEANED BACK TO BRIGHT METAL USING GLASS PAPER FOR 24" EACH END.
 - FINAL CLEANING
 - ALL SURFACES TO BE STEAM CLEANED.
 - TUBES TO BE LIGHTLY EXPANDED TO TUBESHEET PRIOR TO WELDING.
 - TUBE WELDS TO BE CONCENTRIC WITH TUBE HOLE AND HAVE A UNIFORM CONTOUR.
 - EACH TUBE WELD TO BE LEAK DETECTED BEFORE HYDRAULIC TEST AND BEFORE FINAL EXPANSION. THE TEST TO BE PERFORMED USING HALIDE GAS AT 50 PSIG.
 - TUBES TO BE FULLY EXPANDED AFTER LEAK TEST.
 - SHELL TO TUBESHEET WELD - DYE PENETRANT CHECK ROOT RUNS.
 - MAX. PERMISSIBLE CARBON CONTENT FOR 304L S.S. IS 0.030%.
 - FOR ALL WELDS IN TP304L S.S. USE WELDING CONSUMABLES WITH 0.025% MAX. CARBON.

CONNECTION NO.	SIZE	RATING	TYPE	FACING	SCHEDULE	SERVICE
T1	4" NB	150# ASB	WN	R.F.	80	TUBESIDE INLET
T2	4" NB	150# ASB	"	"	80	" OUTLET
S1	8" NB	150# ASB	"	"	80	SHELLSIDE INLET
S2	3" NB	"	"	"	80	" OUTLET
V1	0.75" NB	"	"	"	160	CHANNEL VENT
D1	0.75" NB	"	"	"	"	CHANNEL DRAIN
I1	1.5" NB	"	"	"	"	INSTRUMENT CONNECTION
I2	1" NB	"	"	"	"	"
I3	1.5" NB	"	"	"	"	"
I4	1" NB	"	"	"	"	"
I5	1.5" NB	"	"	"	"	"
I6	1" NB	"	"	"	"	"
I5	1" NB	"	"	"	"	"

Nº	REFERENCE DRAWING	DRG. Nº
1; 10	TUBE BUNDLE	18.10.0002.21
10	FIRST TUBESHEET	18.12.0005.21
10	SECOND TUBESHEET	18.12.0006.21
17	BAFFLE PLATE	18.19.0008.21
2; 16	SHELL DETAILS	18.52.0002.21
3; 5; 6	FIRST CHANNEL DETAILS	18.59.0007.21
4; 5; 6	SECOND CHANNEL DETAILS	18.59.0008.21
6	CHANNEL FLANGE	18.59.0009.21
	WELD DETAILS	18.59.000

MATERIAL FOR NON-PRESSURE PARTS:		REVISION		SIG		DATE	
BAFFLE PLATE	18" Ø STAINLESS STEEL						
TIE ROD	18.8.76	D	STIFFENERS ADDED TO NOZZLES ALSO LIFTING LUGS & WELLS 8 & 9.	SS	21.10.77.		
SPACER	18.8.76	C	LOCKING BARS REMOVED FROM BELLOWS.	SS	3.9.77.		
IMPINGEMENT PLATE	18.8.76	B	LOCKING BARS ADDED TO BELLOWS.	SS	18.8.77.		
SUPPORTS	A283 C	A	DRG. ALTERED TO CORRY WITH F.W. REQUISITION REV. 4.	SS	29.7.77.		
NOZZLE STIFFENERS	BS 4360						
LIFTING LUGS	BS 4360						

CERTIFIED FINAL

1 - OFF AS DRAWN.

DRAWN	G. GREENFIELD.	GEA AIREXCHANGERS (NI) LTD	C. NO.	280 / 99549
CH'K'D		TITLE	DRG NO	18.50.0003.21
APP		G. A SHELL & TUBE	ICINº	FXB 417750
DATE	21.6.77.	TYPE	ISSUE	A X / D
SCALE	1'-1'			61514