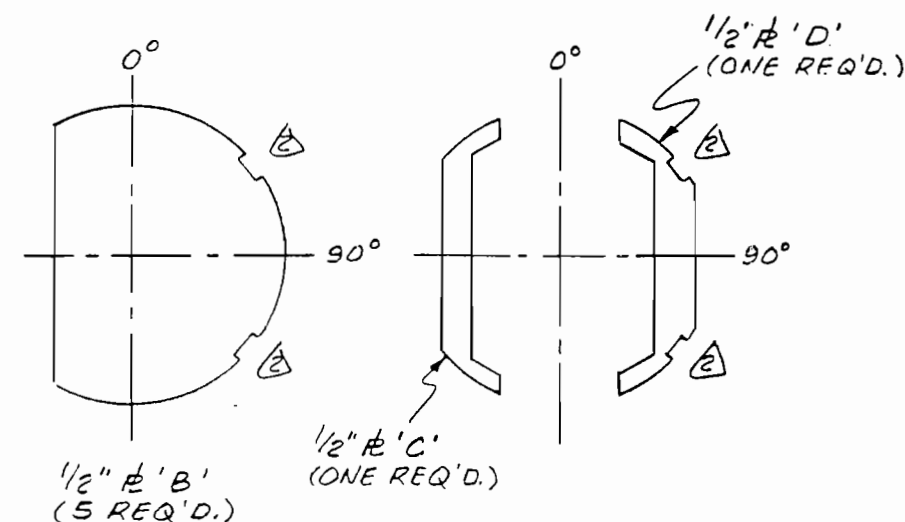
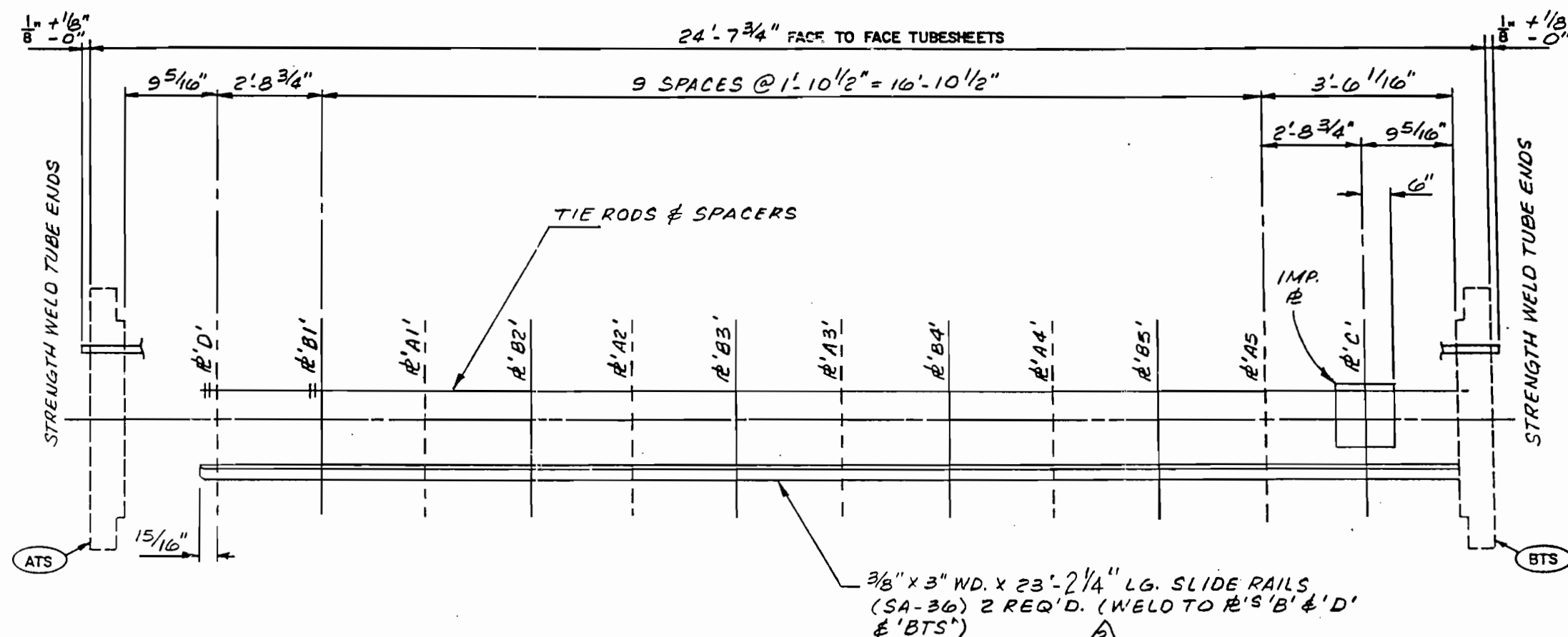
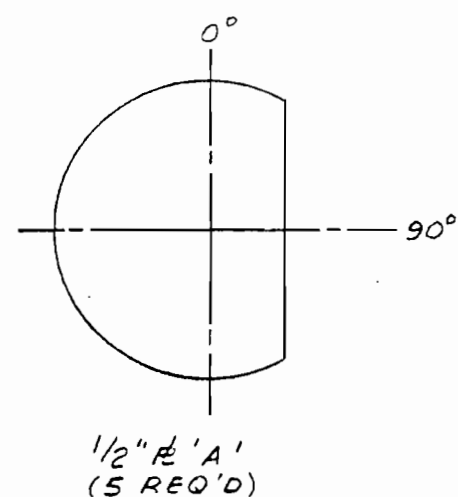




CROSS BAFFLE & SUPPORT DETAILS

MAT'L: SA-36

BAFFLES VIEWED FROM SHELL SIDE OF (BTS)

CERTIFIED
PRINT

MAY 17 1995
TEXAS METAL
FABRICATING CO.
A TRINITY INDUSTRIES CO.
HOUSTON, TEXAS

			2	3/4" ϕ	5'-4 5/16"
			8	↑	2'-8 1/4"
			16	↓	3'-8 1/2"
			36		1'-10"
			2	↓	3'-5 13/16"
			4	3/4" ϕ	9' 1/16"
NO.	SIZE	LENGTH	NO.	SIZE	LENGTH
MAT'L: C. STL.			TUBING MAT'L:		
16 NUTS REQ'D.			C. STL.		
TIE RODS & NUTS			SPACERS		

PHILLIPS SUMIKA POLYPROPYLENE COMPANY
PASADENA, TEXAS
M.W. KELLOGG P.O. NO. 6014-02D1-C210-01
ITEM NO. PS-2001-220000-41-5003
1ST REACTOR(R-102A)2ND GAS COOLER
MANUFACTURER'S SERIAL NO. 9458
WTT #41001026

24' - 7³/₄" FACE TO FACE TUBESHEETS

9 SPACES @ 1'-10 1/2" = 16'-10 1/2"

TIE RODS & SPACERS

— 3/8" x 3" WD. x 23'-2 1/4" LG. SLIDE RAILS
(SA-36) 2 REQ'D. (WELO TO E'S 'B' & 'D'
& 'BTS') A

1/2" ~~PL~~ 'A'
(5 REQ'D)

1/2" $\perp$ 'B'
(5 REQ'D.)

1/2" @ 'C'
(ONE REQ'D.)

1/2" R 'D'
(ONE REQ'D.)

VM RS
09/07/95

REVISIONS
1) REVERSED T.R.
TAPPING
D/LT/4-28-95
2) ADDED SLIDE
RAILS
D/LT/5-4-95

REFERENCE:
94062

NO. 94.58

SHEET 12

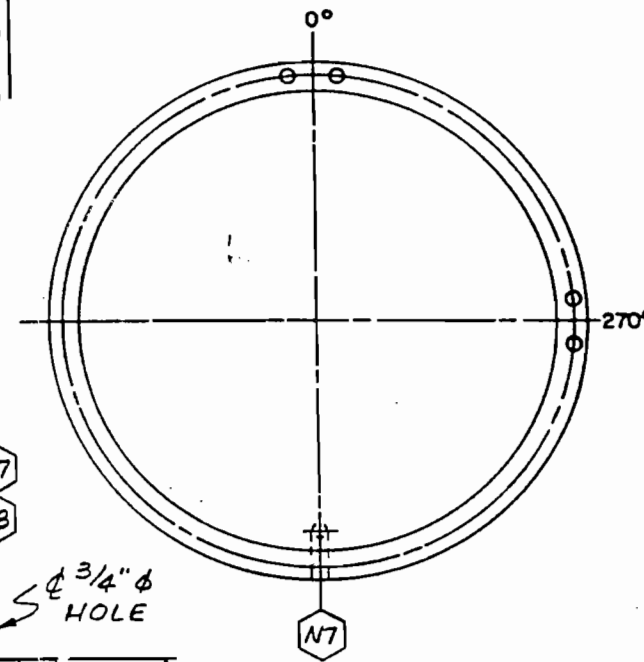
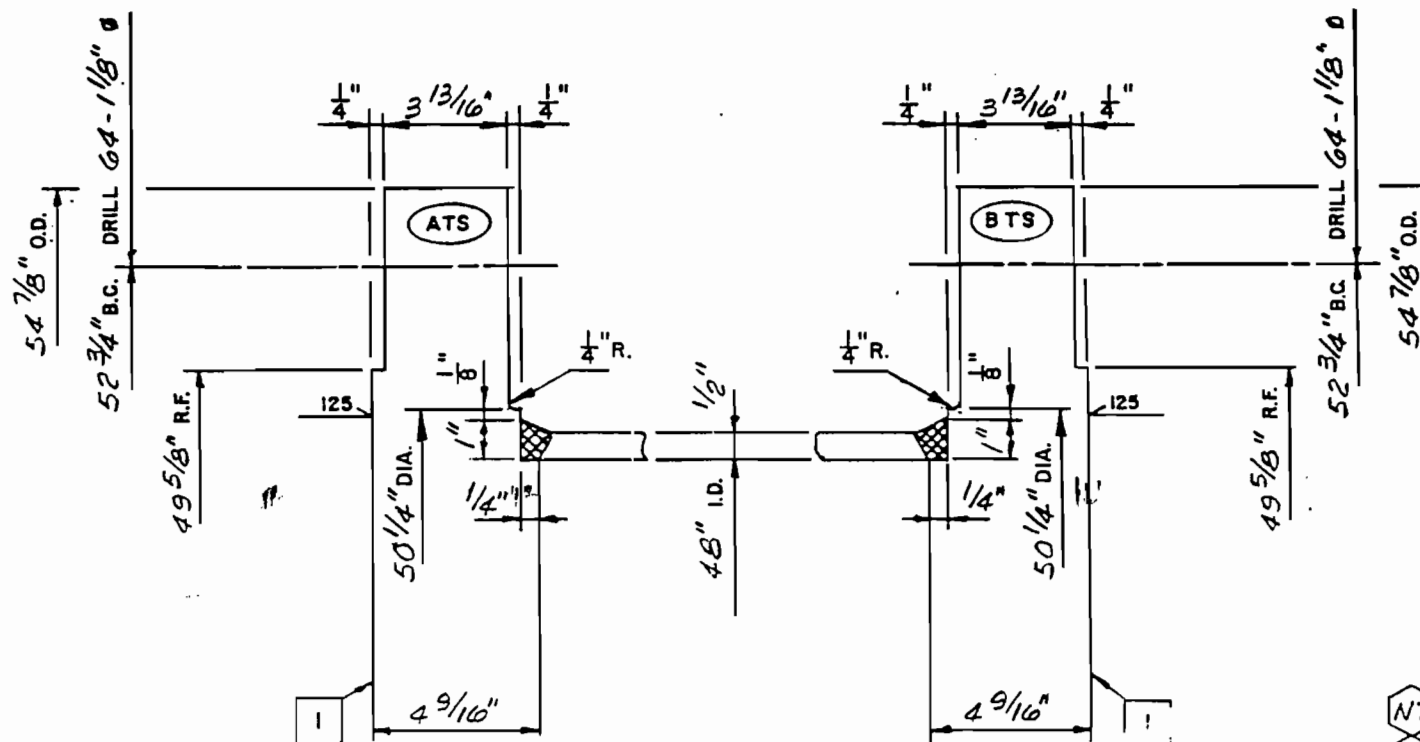
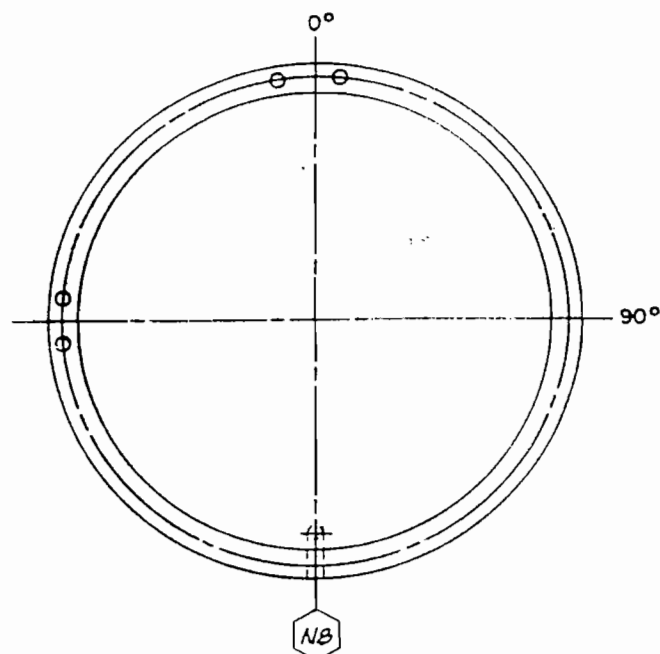
FABRICATION DETAIL - BUNDLE ASSEMBLY



MADE DLT	DATE 12/17/94	CHKD JMN	DATE 1-25-95	APVD JMN	DATE 1-25-95
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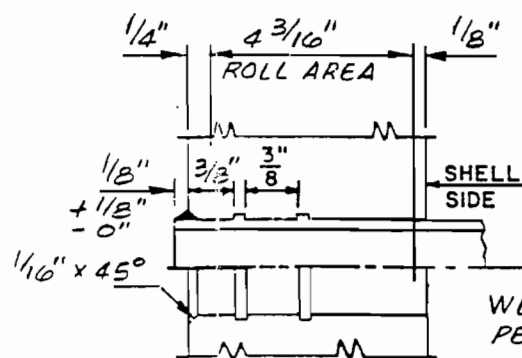
9 005

90005



TUBE-TUBESHEET WELD PROCEDURE:

- PREPARE THE JOINT.
 - CHAMFER TUBE HOLES 1/16" X 45 DEGREES.
 - CLEAN THE FACE OF THE TUBESHEET, ALL TUBE HOLES, AND ALL TUBES WITH ACETONE FOR A MINIMUM LENGTH OF 1 FOOT FROM EACH END.
 - SET TUBES TO PROJECT 1/8" (+1/8", -0") FROM THE FACE OF THE TUBESHEET.
- GIVE TUBES A LIGHT ROLLING TO OBTAIN METALLIC CONTACT PRIOR TO WELDING. DO NOT USE LUBRICANT FOR THIS STEP.
- GTAW WELD CARBON STL. JOINTS WITH AWS A5.18 ER 70S-2 FILLER METAL.
- LIQUID PENETRANT EXAMINE ALL WELDS AND THEN CLEAN THEM WITH ACETONE. REPAIR ANY DEFECTIVE WELDS AND RECHECK.
- WELD 2ND PASS, GTAW WITH AWS A5.18 ER 70S-2 FILLER METAL.
- REPEAT STEP NO. 4 FOR 2ND PASS.
- LEAK TEST: APPLY SOAP SUDS SOLUTION TO TUBE WELDS WHILE MAINTAINING 15 PSI AIR PRESSURE ON SHELL SIDE OF TUBESHEET.
- ROLL TUBES WITH OIL USING CONTROLLED METHOD (4 1/2 TO 5% TUBE WALL REDUCTION). DO NOT ROLL IN WELD AREA.
- REPEAT STEP NO. 7.
- FINAL LIQUID PENETRANT EXAMINE.
- HYDRO TEST AT FULL SHELL SIDE TEST PRESSURE.

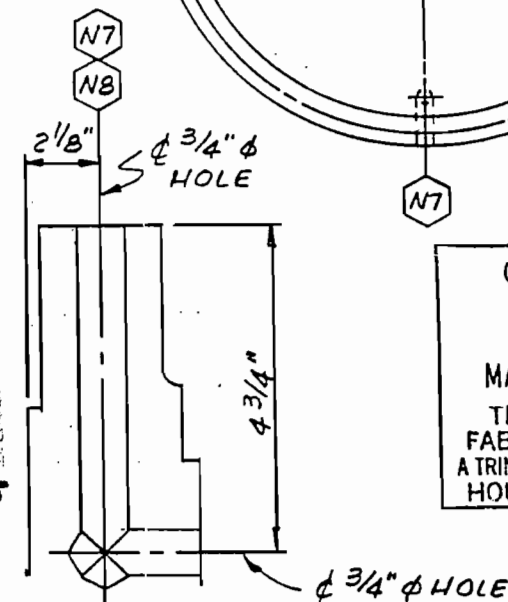


TUBE HOLE GROOVING DETAIL

1/8" WIDE X 1/64" DEEP GROOVES
 (+)0.003" (-)0.003" TUBE HOLE DIA
 DEBURR TUBE HOLES BOTH SIDES

REAM TO 1.261"

WELD TUBES TO TUBESHEET
 PER TMF PROC. SP-205C



CERTIFIED
 PRINT

MAY 17 1995
 TEXAS METAL
 FABRICATING CO.
 A TRINITY INDUSTRIES CO.
 HOUSTON, TEXAS

SA-266-2



FABRICATION DETAIL — TUBESHEETS

MADE	DATE	CHKD	DATE	APVD	DATE
DLT	12/17/94	JM	1-25-95	JM	1-25-95

REFERENCE
 94062
 NO. 945B
 SHEET 13

REVISIONS

PHILLIPS SUMIKA POLYPROPYLENE COMPANY
 PASADENA, TEXAS
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857