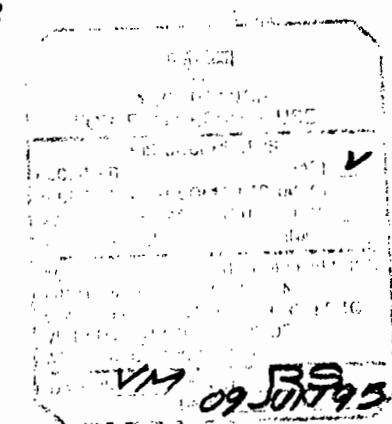
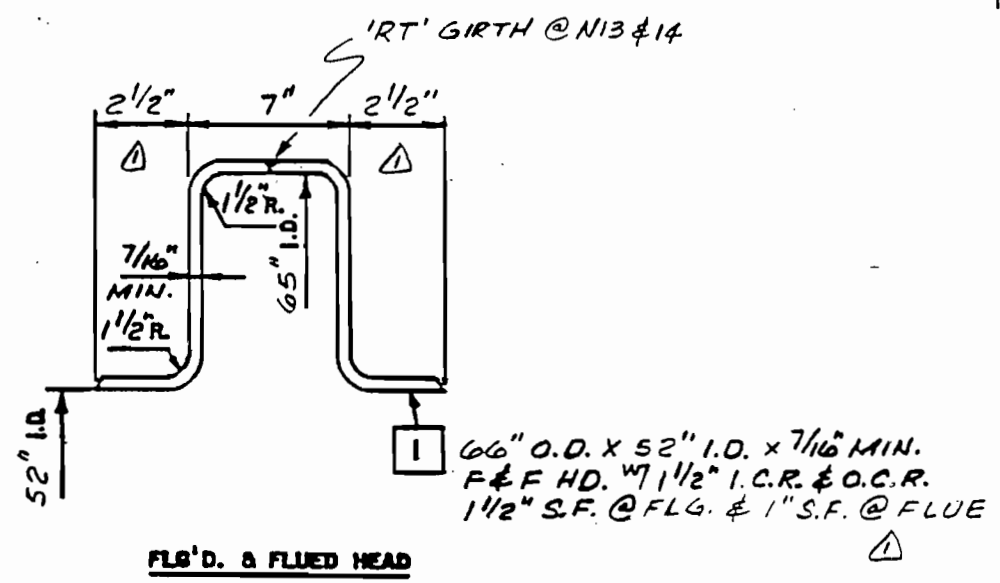
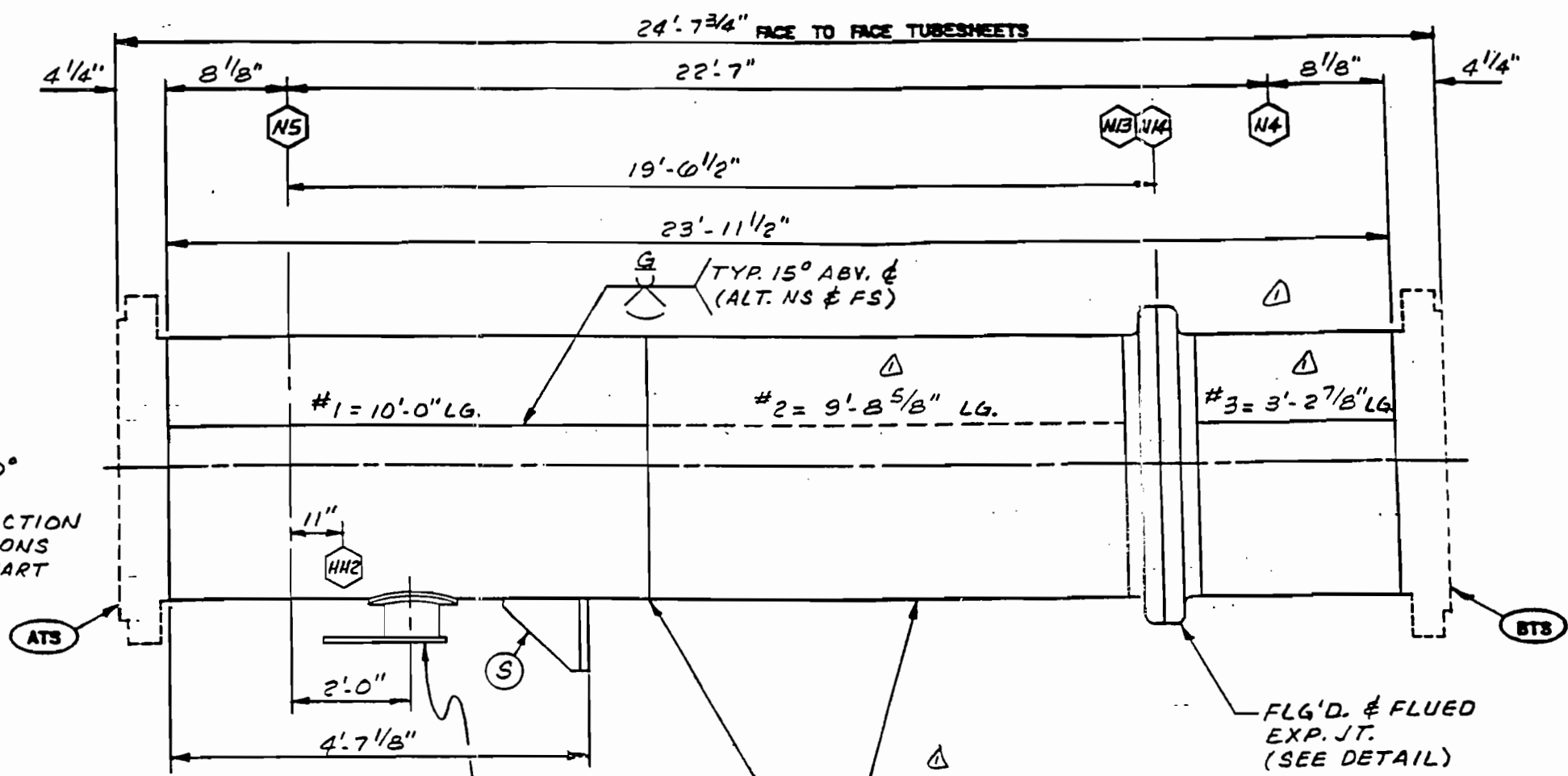
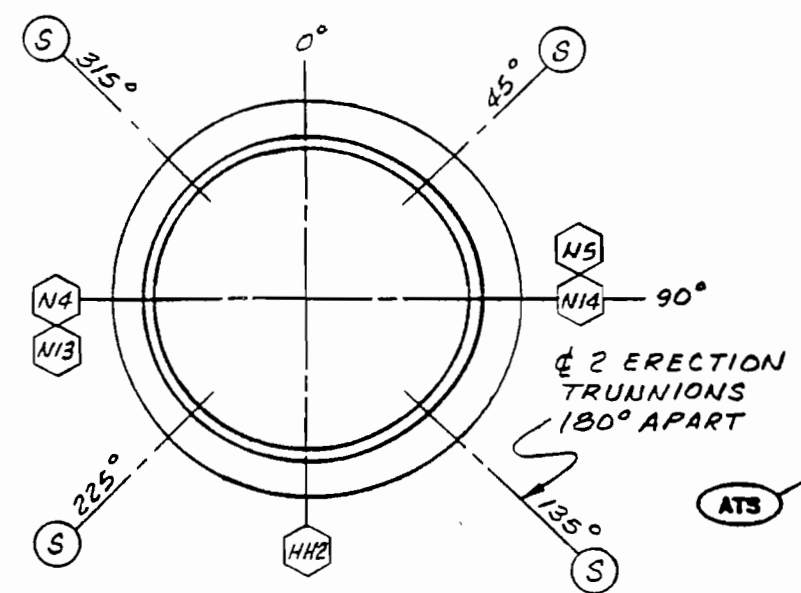


74



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

1 SA-516-70



FABRICATION DETAIL — SHELL

REFERENCE:
94062

NO. 94062

SHEET 8

REVISION:
1 DELETED IMP.
2 DIFF. & REV.
3 EXP. JT.
DLT/4.26.95

DATE	DATE	CHG	DATE	APVD	DATE
DLT	11/17/94	DM	12/5/95	DM	12/5/95

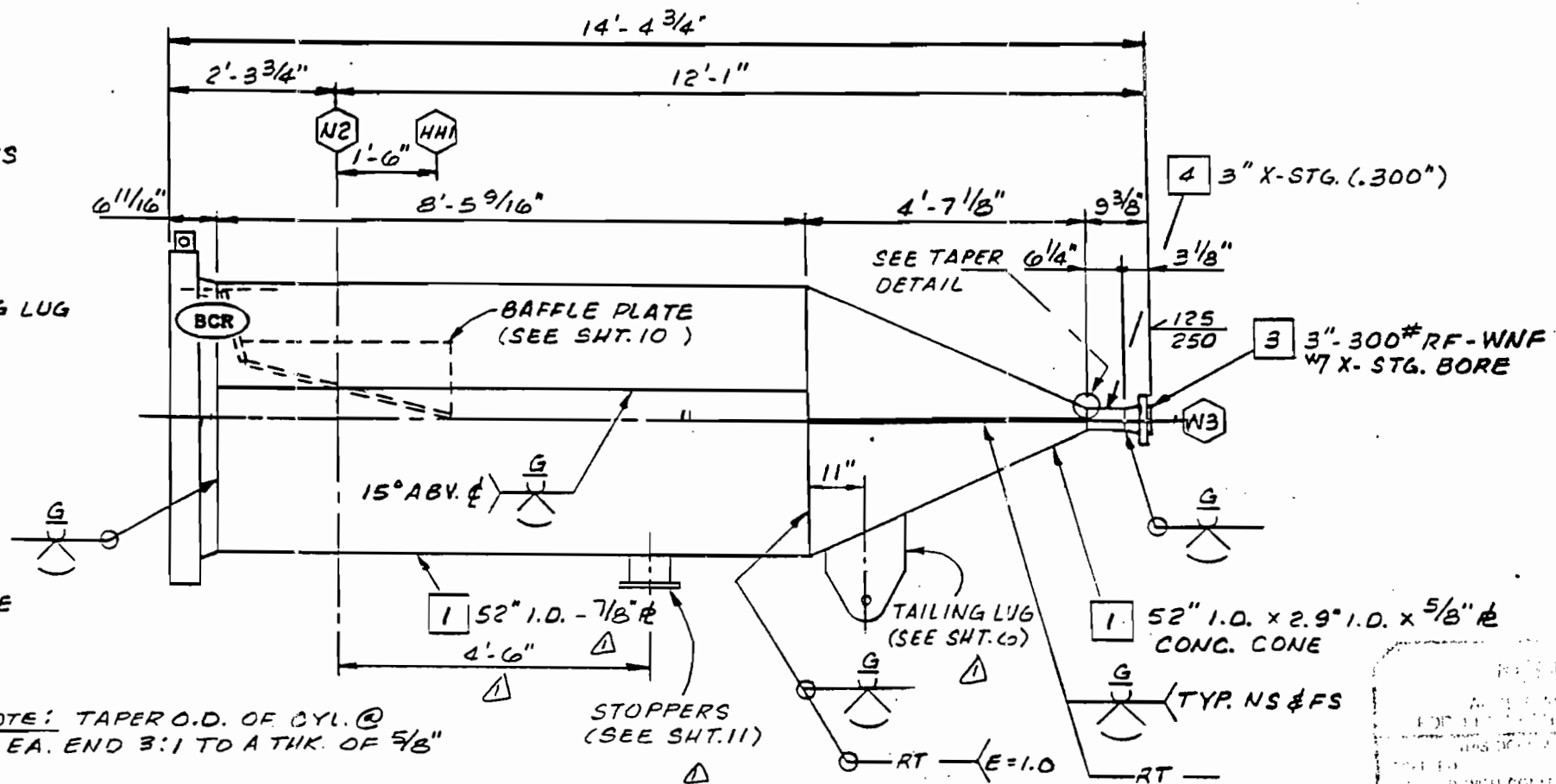
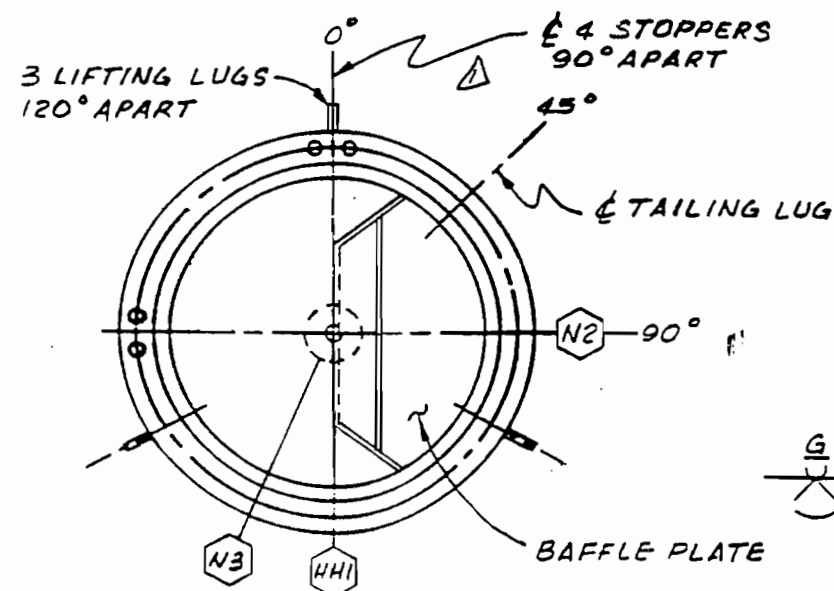
PHILLIPS SUMIKA POLYPROPYLENE COMPANY
PASADENA, TEXAS
M.W. KELLOGG P.O. NO. 6014-02D1-C210-01
ITEM NO. PS-2001-220000-41-5007
3RD REACTOR 2ND GAS COOLER
MANUFACTURER'S SERIAL NO. 9462
WTT #41001030

12-10-78

7007

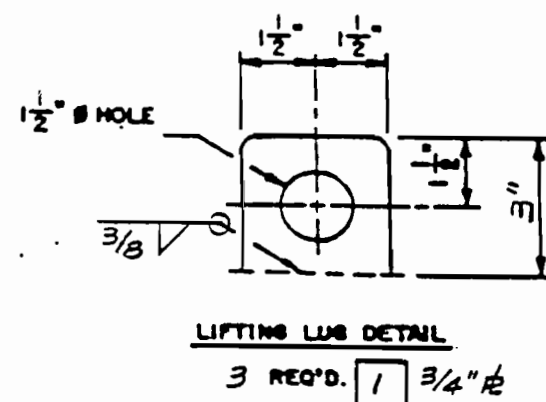
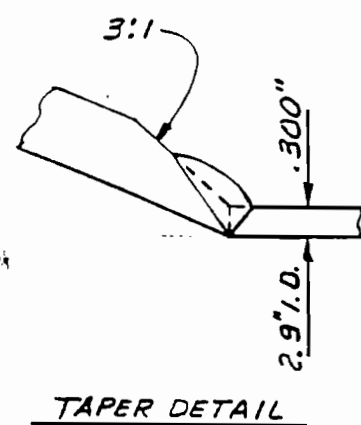
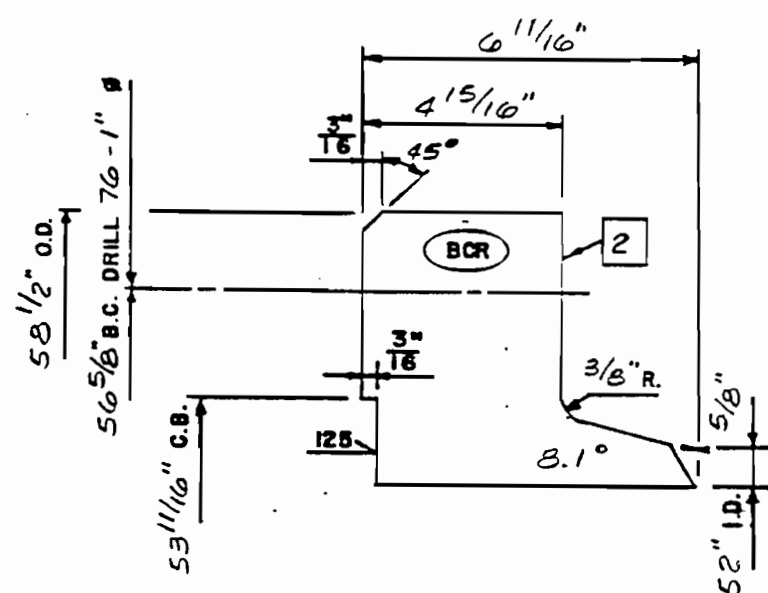
4

1



NOTE: TAPER O.D. OF CYL. @
EA. END 3:1 TO A THK. OF 5/8"

NOTE: SEE SHT. 20 FOR LOC. &
DETS. OF INSUL. SUPPT. RINGS



* CV = 15/12 FT. LBS. @ 30° F

- 4 SA-106-B
- 3 SA-105
- 2 SA-105 (N) *
- 1 SA-516-70

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MAY 17 1995

TEXAS METAL
FABRICATING CO.
A TRINITY INDUSTRIES CO.
HOUSTON, TEXAS

12-18-75

5065



FABRICATION DETAIL-"B" CHANNEL

MADE	DATE	CHKD	DATE	APVD	DATE
DLT	11/14/94	DM	12-25-95	DM	1-25-95

REFERENCE:
94062
NO. 9462

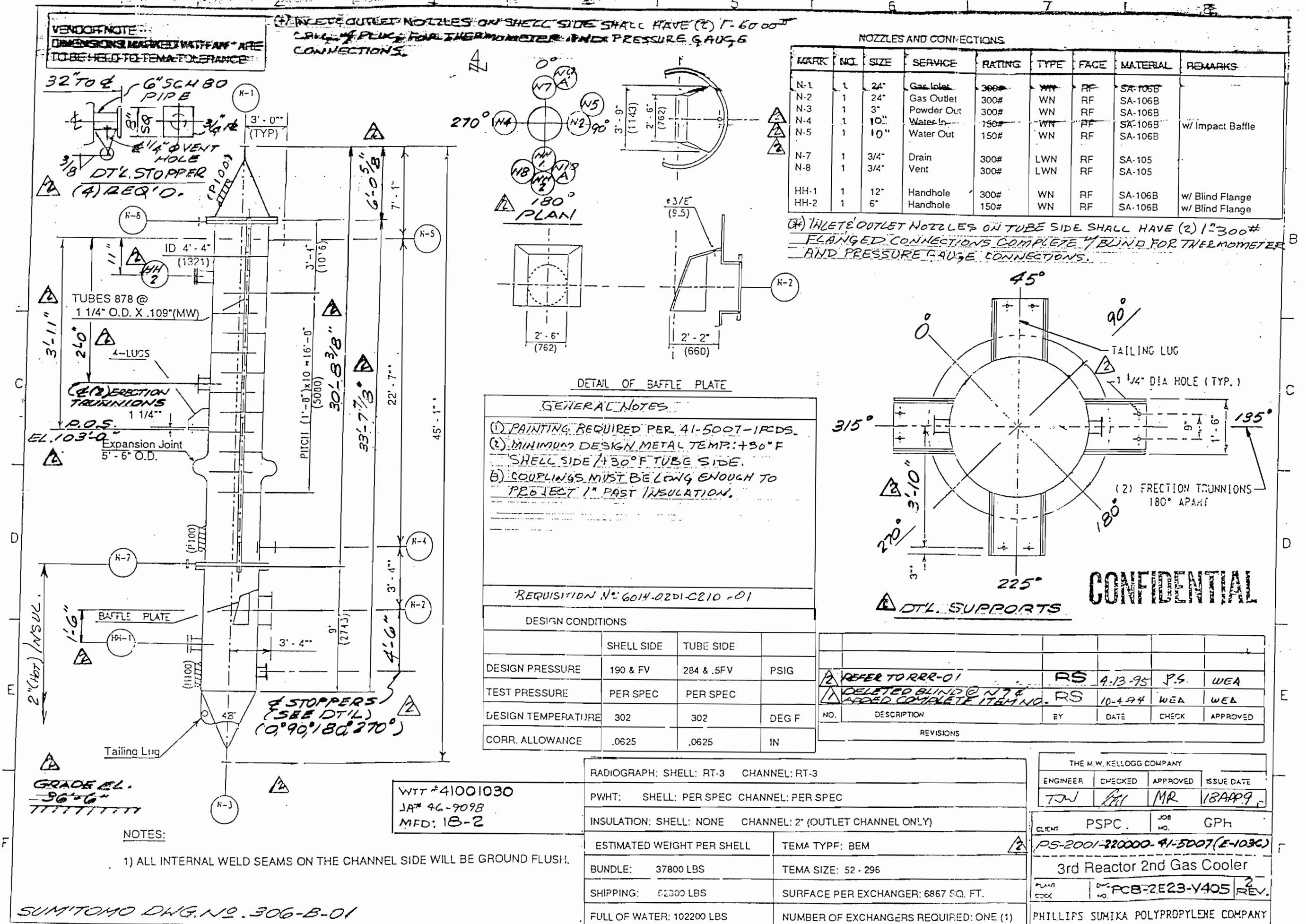
SHEET 9

REVISIONS
REV. PER CUST
APPROV.
DLT/4-26-95

PHILLIPS SUMIKA POLYPROPYLENE COMPANY
PASADENA, TEXAS
M.W. KELLOGG P.O. NO. 6014-02D1-C210-01
ITEM NO. PS-2001-220000-41-5007
3RD REACTOR 2ND GAS COOLER
MANUFACTURER'S SERIAL NO. 9462
WTT #41001030

8-531

APPROVED
BY ccw 3/10/93



* SLOTS TO BE MILLED
(DO NOT TORCH CUT)

* $\varnothing$ (2) $\frac{5}{8}$ " WIDE
SLOTS

$\varnothing$ DETECTOR

$\varnothing$ SOURCE & CLIPS "NSSC-1"

PLAN

* $\varnothing$ 2 $\frac{1}{2}$ " WIDE SLOT
FOR CONDUIT
FITTING

O.S.
CONE

* $\varnothing$ (2) $\frac{5}{8}$ " WIDE SLOTS

$\varnothing$ DETECTOR
(BY OTHERS)

$\varnothing$ SOURCE
(BY OTHERS)

ELEVATION

NUCLEAR SWITCH SOURCE CLIPS "NSSC-1" & NUCLEAR DETECTOR CLIPS "NSDC-1"

The M.W. Kellogg Company

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THE PRIOR WRITTEN CONSENT OF PSPC.

1	0	5-24-95	PS-8001-220000-41-5007	FABR RELEASE
ISSUE	REV	DATE	REQ./P.O.	ISSUED FOR
DRAWING ISSUE RECORD				

REV.	REVISION DESCRIPTION	DATE	BY	CHK.	APP.
	ENGINEER WEA				
	DRAWN RS				
	CHKD. EK				
	APPR. WEA				
	DATE 5-23-95				

PHILLIPS SUMIKA POLYPROPYLENE CO.

GAS PHASE POLYPROPYLENE PLANT

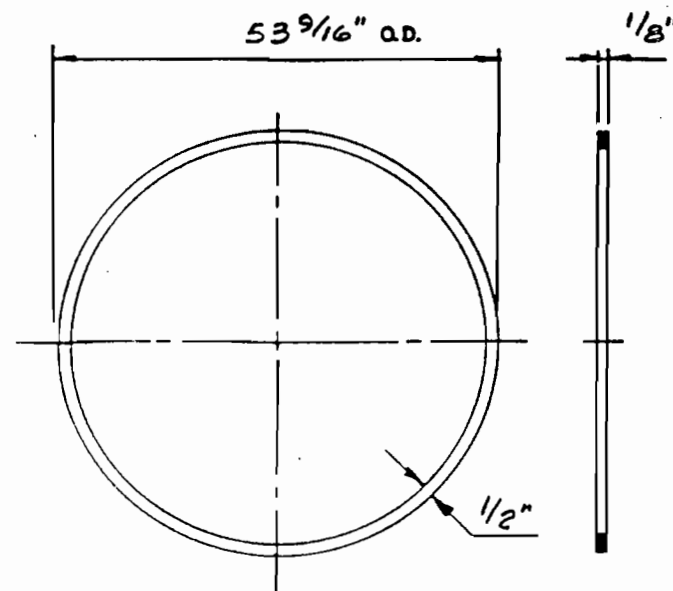
3RD REACTOR 2ND GAS COOLER-DETAILS

PS-8001-220000-41-5007

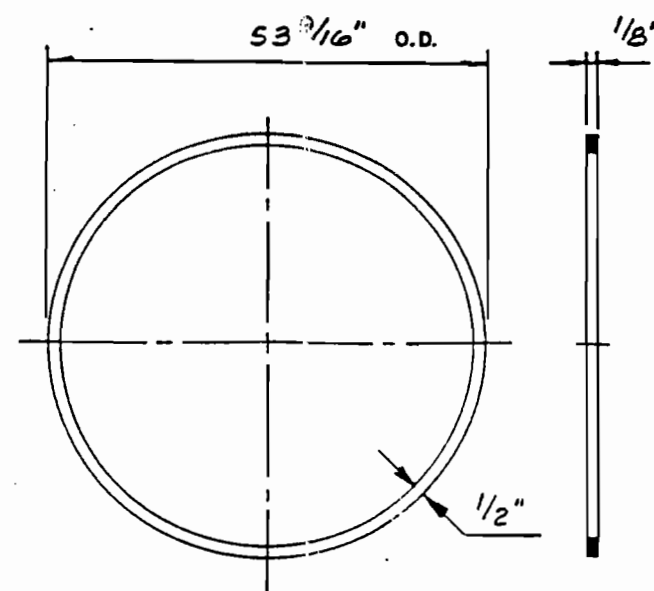
AFE UNIT

ITEM NUMBER

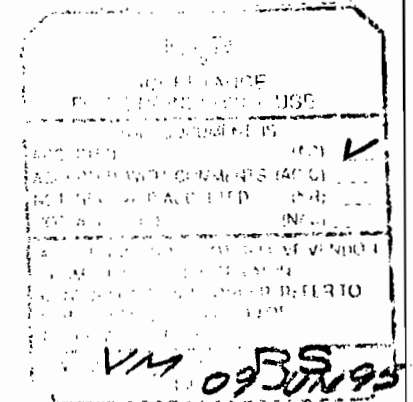
NONE	6014	H	PCB-2E23	V-415-0
SCALE:	JOB	AREA	DRAWING NUMBER	SHT. NO.
				REV.



ACR TO ATS
MAT'L. C. STL. DBL. JKT'D. NON-ASB.
(ANNEALED)



BTS TO BCR
MAT'L. C. STL. DBL. JKT'D. NON-ASB.
(ANNEALED)



BOLT SCHEDULE			
LOCATION	NO. REQ'D EACH ASSEMBLY	SIZE	LENGTH
ACR TO ATS	76	7/8" ϕ NC	10 5/8"
BTS TO BCR	76	7/8" ϕ NC	10 5/8"

MATERIAL: STUDS TO BE SA-193-B7 WITH TWO (2) AMERICAN STANDARD HEAVY DIM. HEX NUTS EACH SA-194-CL:2H

ONE SET(S) OF GASKETS REQ'D. EACH ASSEMBLY
2 SET(S) OF SPARE GASKETS REQ'D. EACH ASSEMBLY

	FABRICATION DETAIL- GASKETS DETAILS & BOLTING SCHEDULE						REVISIONS NO. 9462 SHEET 15
	REFERENCE 94062						
	NO. 9462						
MADE DLT	DATE 1/14/95	CHKD JM	DATE 1-25-95	APVD JM	DATE 1-25-95		

PHILLIPS SUMIKA POLYPROPYLENE COMPANY
PASADENA, TEXAS
M.W. KELLOGG P.O. NO. 6014-02D1-C210-01
ITEM NO. PS-2001-220000-41-5007
3RD REACTOR 2ND GAS COOLER
MANUFACTURER'S SERIAL NO. 9462
WTT #41001030

TUBE HOLE LAYOUT VIEWED FROM SHELL SIDE OF (BTS)

NO. OF TUBE HOLES: 878

TUBE PITCH: $1\frac{9}{16}"$

Q OF O.M.T.: $50\frac{1}{8}"$

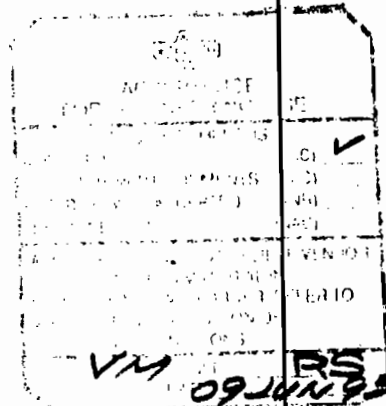
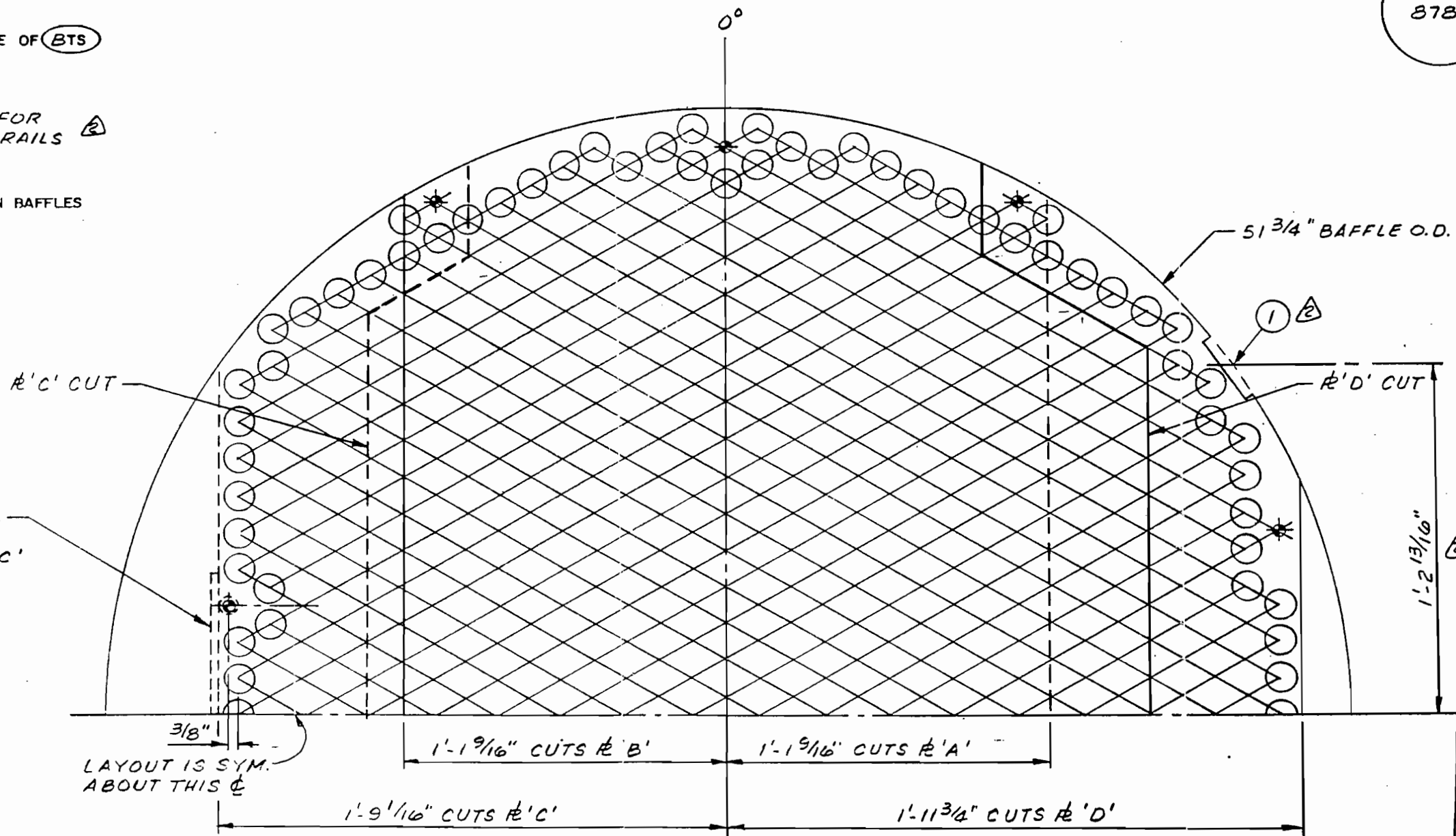
TAP $\frac{1}{2}"$ DEEP ON SHELL SIDE OF (BTS)
FOR $10-\frac{1}{2}"$ N.C. TIE RODS

① NOTCH R'S 'B' & 'D' FOR $\frac{3}{8}" \times 3"$ WD. SLIDE RAILS ②

$\frac{9}{16}"$ TIE ROD HOLES
 $1\frac{7}{16}" \pm 0.007"$ TUBE HOLES
-0.000" IN BAFFLES

TUBES: 878 - $1\frac{1}{4}"$ O.D. x .110" M.W. x 24'-8" LG.
SA-214

878



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

12.001



FABRICATION DETAIL — TUBE HOLE LAYOUT

MADE	DATE	CHKD	DATE	APVD	DATE
DLT	1/11/95	Jm	1-25-95	Jm	1-25-95

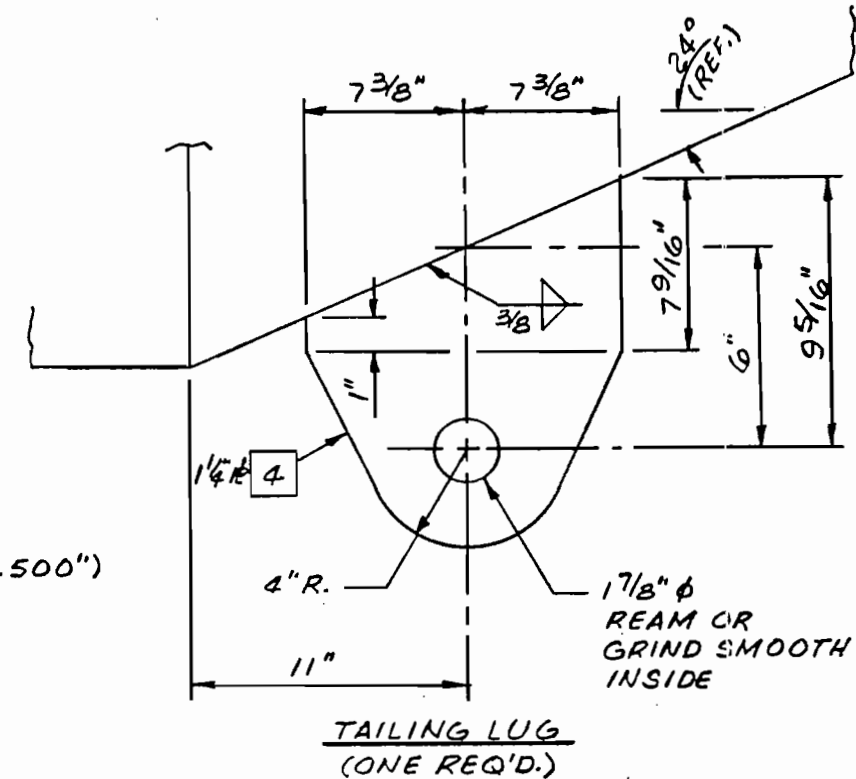
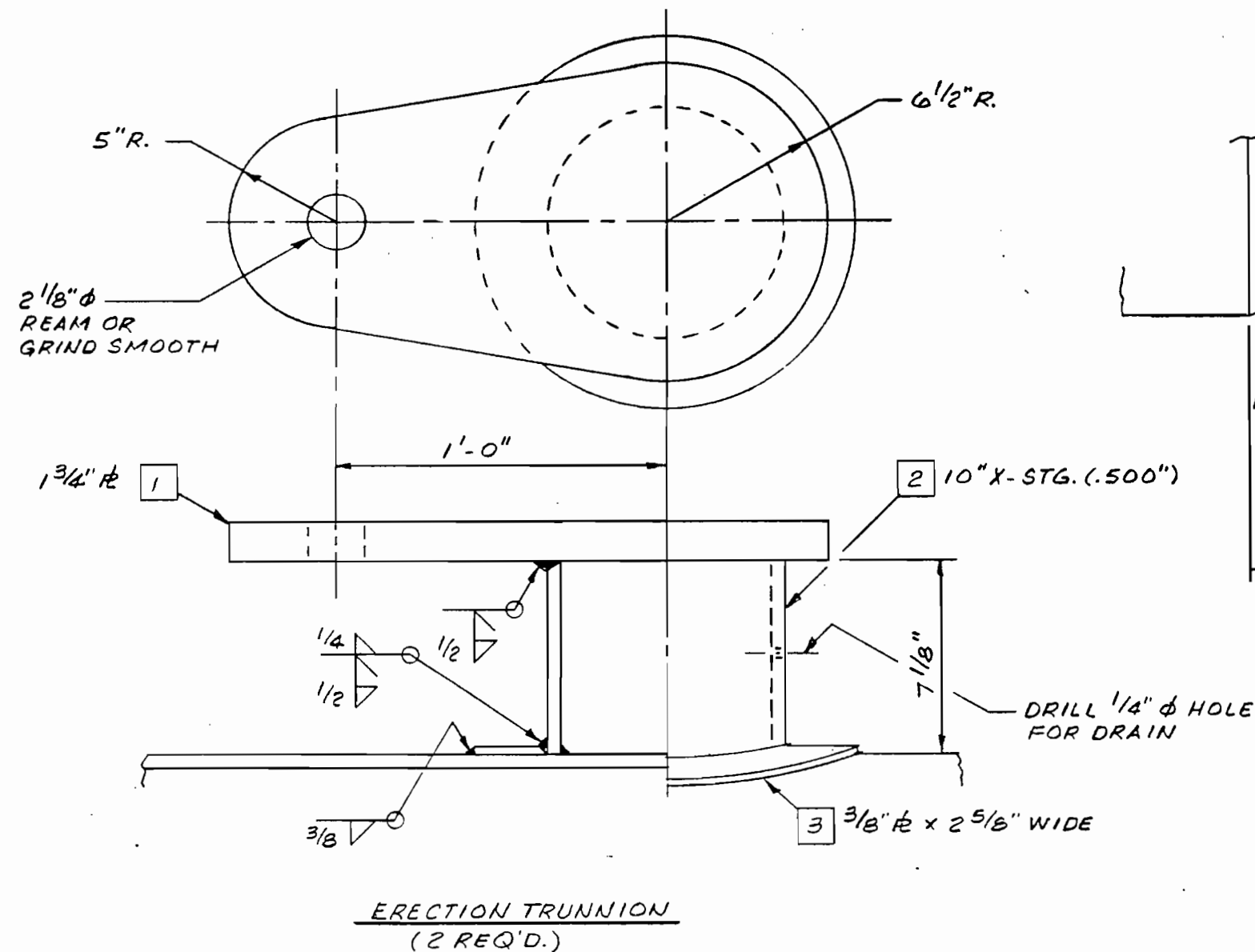
REFERENCE:
94062

NO. 94062

SHEET 14

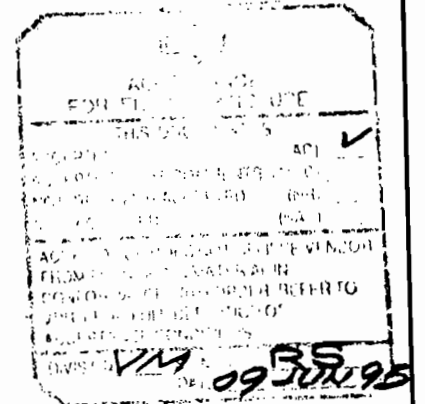
REVISIONS
A REVERSED TUBE
LAYOUT
DLT/4-26-95
B ADDED SLIDE
RAILS
DLT/5-8-95

PHILLIPS SUMIKA POLYPROPYLENE COMPANY
PASADENA, TEXAS
M.W. KELLOGG P.O. NO. 6014-02D1-C210-01
ITEM NO. PS-2001-220000-41-5007
3RD REACTOR 2ND GAS COOLER
MANUFACTURER'S SERIAL NO. 9462
WTT #41001030



ALL REINFORCING PADS AND WEAR PLATES SHALL HAVE ONE NPS 1/4 TAPPED HOLE FOR VENTING IN EACH SEGMENT. VENT HOLES IN REINFORCING PADS TO BE DRILLED AND TAPPED PRIOR TO INSTALLATION. EACH REINFORCING PAD AND WEAR PLATE OR EACH SEGMENT THEREOF SHALL BE TESTED AT 15 PSIG IN ACCORDANCE WITH ASME SECTION V, ARTICLE T-1031 AND T-1032 WITH DRY AIR. VENT HOLES SHALL BE PLUGGED WITH A HEAVY GREASE AFTER TESTING.

- 4 SA-516-70
- 3 SA-516-70
- 2 SA-106-B
- 1 SA-516-70(N)



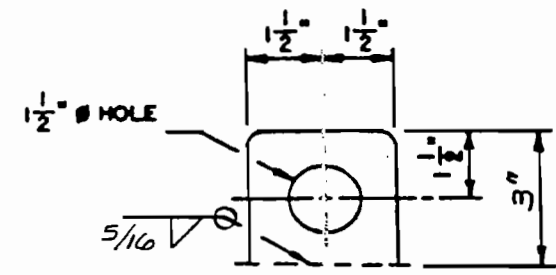
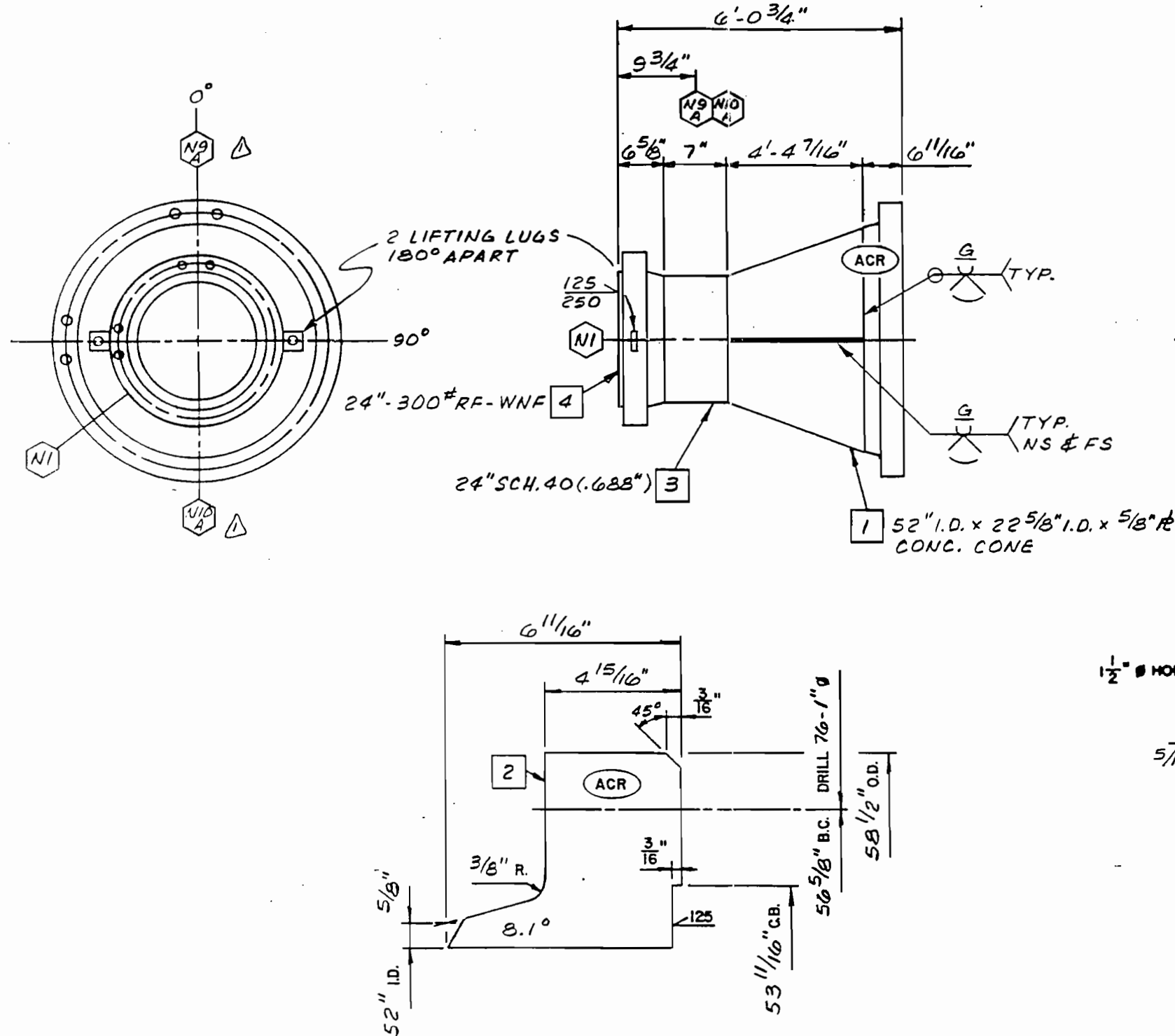
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TEXAS METAL
FABRICATING CO.
A TRINITY INDUSTRIES CO.
HOUSTON, TEXAS

	FABRICATION DETAIL - ERECTION TRUNNION & TAILING LUG						REVISIONS NO. 9462 SHEET 6
	REFERENCE						
	94062						
	NO. 9462						
MADE	DATE	CHKD	DATE	APVD	DATE		
DLT	1/9/95	Jm	1-25-95	Jm	1-25-95		

PHILLIPS SUMIKA POLYPROPYLENE COMPANY
PASADENA, TEXAS
M.W. KELLOGG P.O. NO. 6014-02D1-C210-01
ITEM NO. PS-2001-220000-41-5007
3RD REACTOR 2ND GAS COOLER
MANUFACTURER'S SERIAL NO. 9462
WTT #41001030

4
1



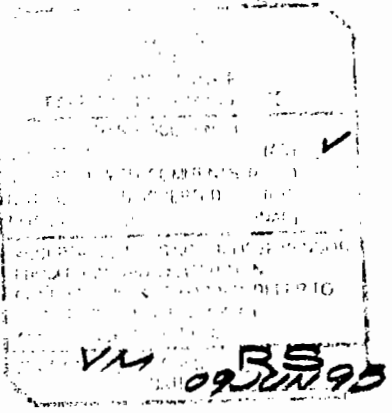
LIFTING LUG DETAIL
2 REQ'D. 1 3/4" R

2 SA-105 (N)

4 SA-105

1 SA-516-70

3 SA-106-B



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

12-10-75

5065

 HOUSTON	FABRICATION DETAIL-"A" CHANNEL					
						REFERENCE: 94062
						NO. 9462
	MADE DLT	DATE 11/14/94	CHKD Jm	DATE 1-25-95	APVD Jm	DATE 1-25-95

REFERENCE:
94062
NO. 9462

REVISIONS
REV. PER CUST.
APPV'L.
DLT/4-25-95

PHILLIPS SUMIKA POLYPROPYLENE COMPANY
PASADENA, TEXAS
M.W. KELLOGG P.O. NO. 6014-02D1-C210-01
ITEM NO. PS-2001-220000-41-5007
3RD REACTOR 2ND GAS COOLER
MANUFACTURER'S SERIAL NO. 9462
WTT #41001030

8551