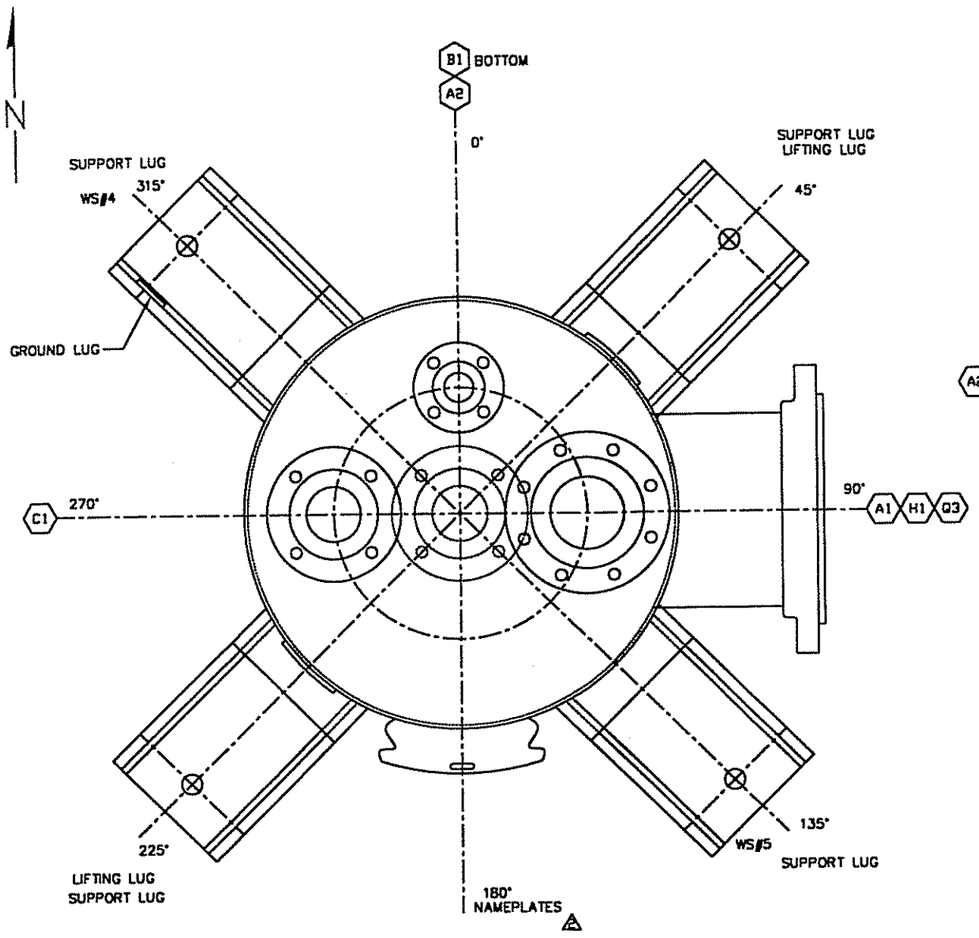
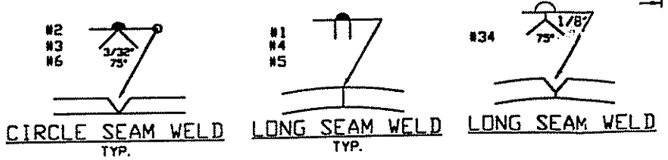


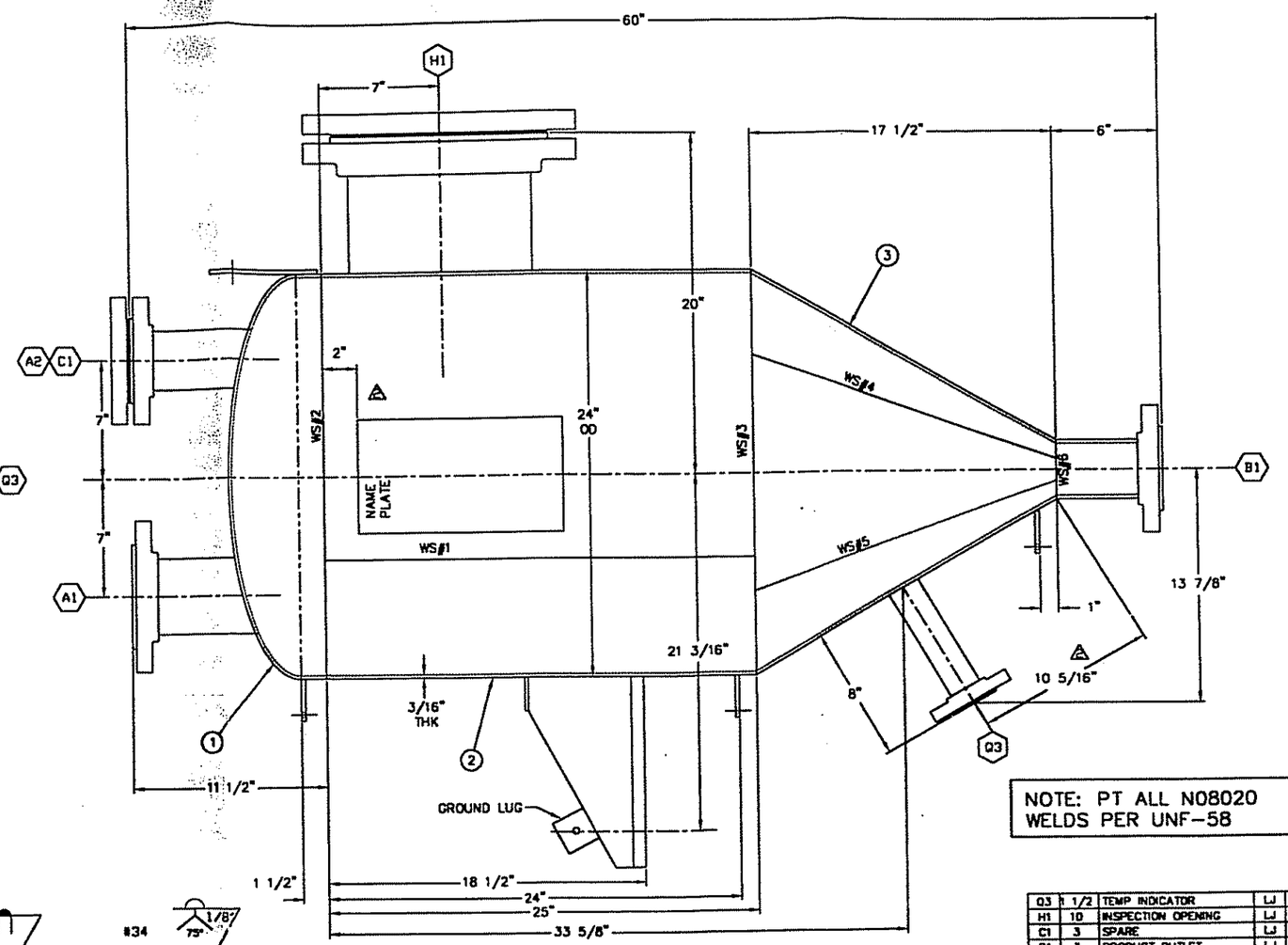
ORIENTATION VIEW



CIRCLE SEAM WELD TYP.

LONG SEAM WELD TYP.

LONG SEAM WELD



ELEVATION VIEW

NOTE: PT ALL NO8020 WELDS PER UNF-58

MARK	SIZE	DESCRIPTION	TYPE	CLASS
		NOZZLE		FLANGE
Q3	1 1/2	TEMP INDICATOR	LJ	150
H1	10	INSPECTION OPENING	LJ	150
C1	3	SPARE	LJ	150
B1	3	PRODUCT OUTLET	LJ	150
A2	1 1/2	PRODUCT RECYCLE	LJ	150
A1	4	PRODUCT INLET	LJ	150

NOZZLE SCHEDULE

MAJOR COMPONENT DESIGN DATA
VESSEL DESIGNED PER THE ASME CODE SECTION VIII DIVISION 1, LATEST ADDENDA, CODE STAMP: YES

DESIGN PRESSURE INTERNAL: 20 PSI @ 266 DEG F
DESIGN PRESSURE EXTERNAL: 15 PSI @ 266 DEG F
HYDRO TEST: 153 PSI @ 70 DEG F
MDMT: -20 DEG F PWHT: NONE
SPECIFIC GRAVITY: OPERATING 1.31
CORROSION ALLOWANCE: NONE
ESTIMATED CAPACITY: 62 US GALLONS
INSULATION SPRTS: YES

RADIOGRAPH:	LONG.	CIRC.
SHELL	SPOT 11B	SPOT 11B
HEAD	SMLS	SPOT 11A
NOZ. (PIPE)	SMLS	N/A
NOZ(PL)	FULL 11A	N/A

INTERIOR
SURFACE PREP: NONE
COATING: NONE

EXTERIOR
SURFACE PREP: SSPC SP-10 PROFILE 2 MILS
COATING: PRIMER WISCONSIN PLASITE 7104L 3-5 MILS DFT
COATING: FINISH WISCONSIN PLASITE 7156 5-7 MILS DFT COLOR LIGHT GRAY

WELD PROCEDURES	
MATERIAL	WPS *
NOZZLES CS-20 TO CS-20	CS20-1A
CS-20 TO CS-20	CS20-1A
CS-20 TO S.S.	CS20-3A
S.S. TO S.S.	STN-3A/STN-1A
–	–
–	–
–	–

* UNLESS NOTED OTHERWISE

GENERAL NOTES:
1. FLANGE BOLT HOLES SHALL STRADDLE 0 & 180 DEG. VESSEL CENTERLINES UNLESS NOTED.
2. WELDS SHALL BE NEAT IN APPEARANCE, FREE OF SLAG, UNDERCUTS AND OTHER DEFECTS.
3. REINFORCING PADS AND PAD SECTIONS SHALL HAVE 1/8 INCH NPT WEEP HOLE LOCATED AS LOW AS POSSIBLE IN THE PAD WHEN THE VESSEL IS IN OPERATING POSITION. PLUG WEEP HOLE WITH HEAVY GREASE.
4. VESSEL SHALL BE CLEANED OF SCALE, OIL, WELD SPATTER AND ALL OTHER FOREIGN MATTER BEFORE HYDROSTATIC TESTING.
5. COAT ALL NOZZLE GASKET SURFACES WITH PROTECTIVE LUBRICANT BEFORE BLANKING FOR SHIPMENT.
6. PROTECT ALL MACHINED SURFACES AND THREADED CONNECTIONS WITH WOOD OR PLASTIC PROTECTORS BEFORE SHIPMENT.

ESTIMATED EMPTY WEIGHT: 491 LBS
SHIPPING SIZE: 41 X 48 X 65 INCHES

U — W — RT-4

NB 1956
CERTIFIED BY GASPAR, INC.
CANTON, OHIO
SHELL SIDE
MAWP 116/-15 PSI AT 266/266 °F
MDMT -20 °F AT 116/-15 PSI
TUBE SIDE
MAWP XX PSI AT XX °F
MDMT XX °F AT XX PSI
33019 MFG. SERIAL NO. 2005 YEAR BUILT

CERTIFIED DIMENSIONAL PRINT
BY: Gaspar Inc. Michael R Smith
DATE: JANUARY 7, 2005

± 1/8"	FACE OF NOZZLE TO CENTERLINE OF EQUIPMENT.	–	–	–
± 1/8"	C.L. OF NOZZLE TO BASELINE OR DATUM REFERENCE.	–	–	–
1°	NOZ. FLNG FACE ALIGNMENT, C.L. TO EDGE, IN DEGREES RISE	2	MEH 01/19/05	AS BUILT
± 1/8"	PLAN LOCATION OF NOZ. OR SUPPORT LUGS FROM EQUIP. C.L. OR DATUM REF.	1	MEH 01/10/05	CHG'D MK-13 FROM PIPE TO PLATE & ADDED WELD SEAM
± 1/8"	FACE OF BOTTOM NOZZLE TO BASELINE OR DATUM REFERENCE.	NO.	BY DATE	

FABRICATION TOLERANCES (GENERAL)

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GASPAR JOB #: 33019 W
CUSTOMER: BAYER CROPSCIENCE
P.O. NO.: 260035497
NUMBER OF UNITS: 1
INQUIRY #: 23753
REFERENCE NUMBER: –

Gaspar, Inc.
CANTON, OHIO

DRAWING TITLE:
CONCENTRATED RHO POT
PROP NO 6395N 66881

DRAWN BY: MEH 12/21/04
CHECKED BY: –
DRAWING NUMBER: 33019
REVISION: 2
SHEET 1 OF 2