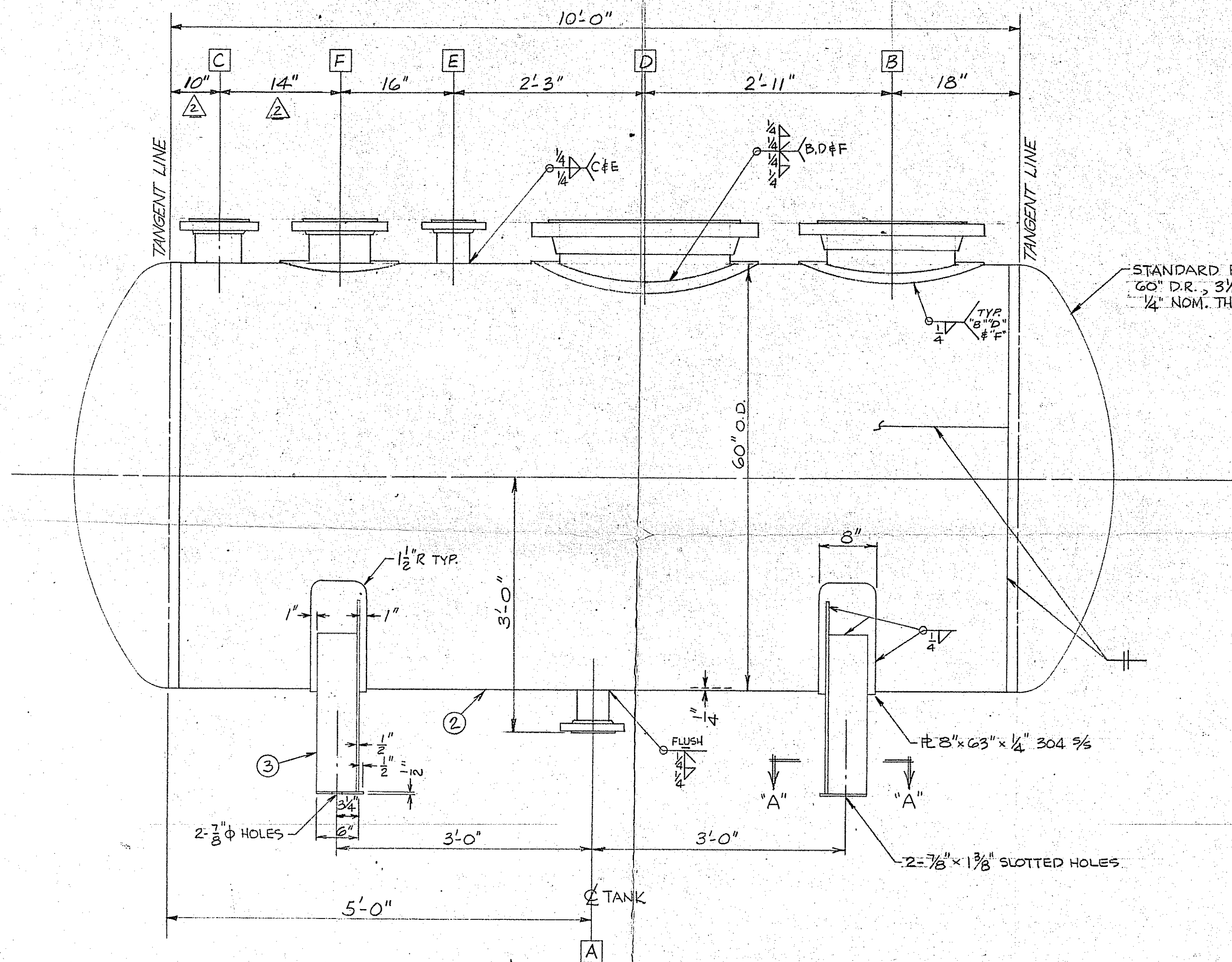
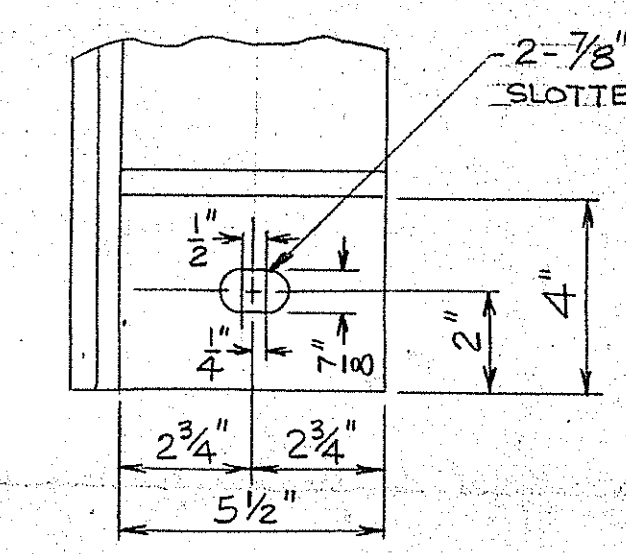
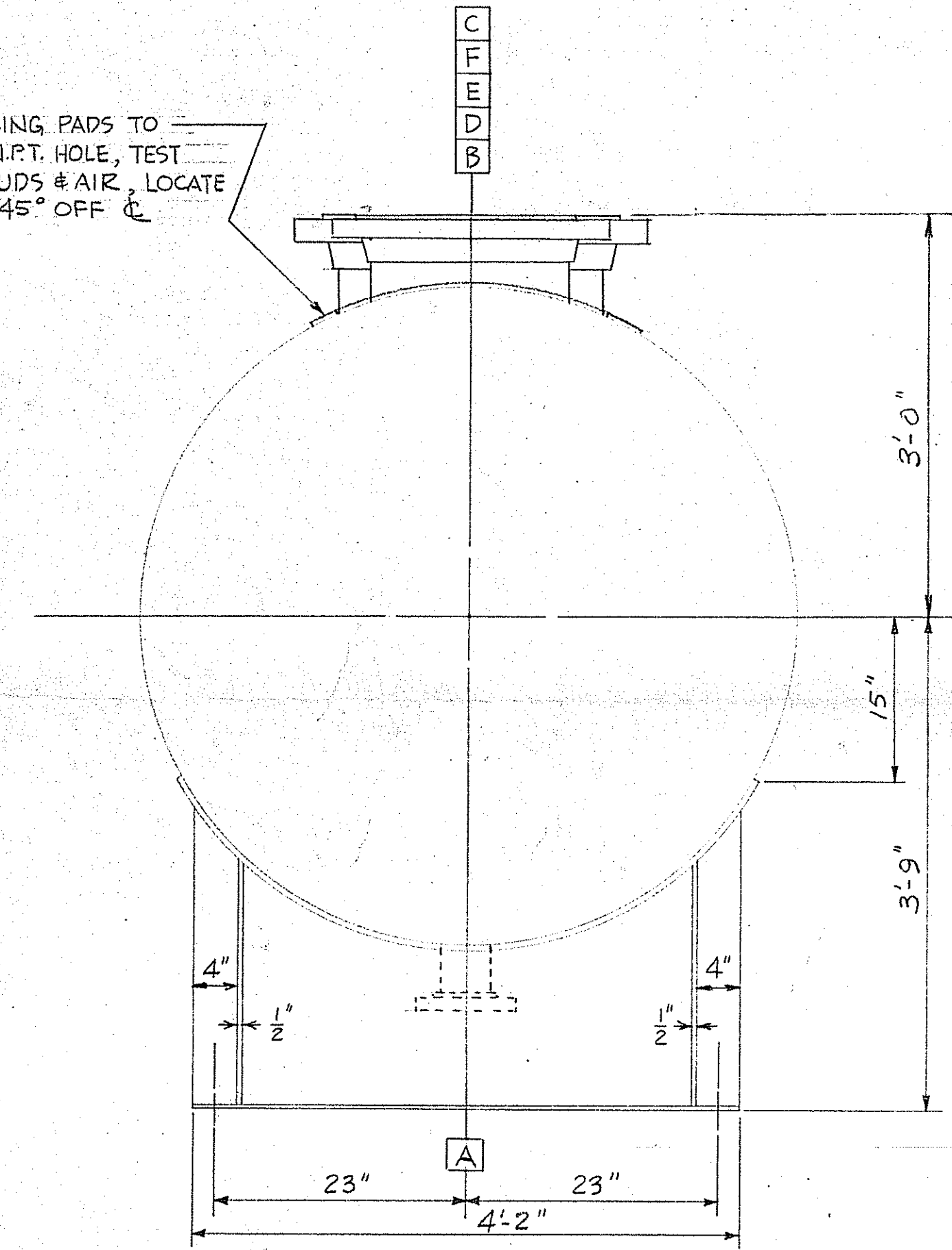


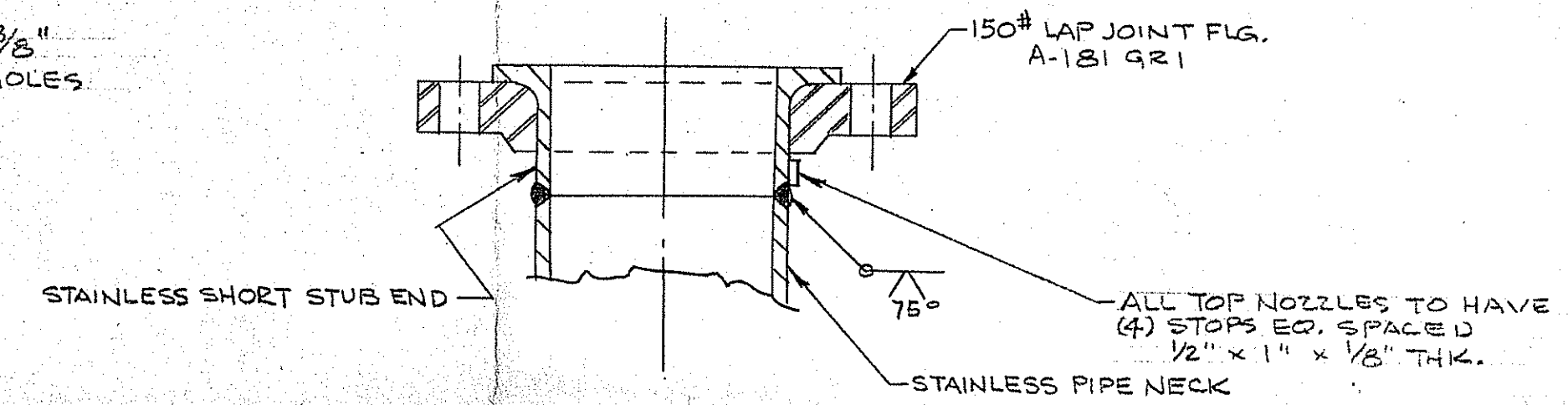


REINFORCING PADS TO HAVE 1/8" N.R.T. HOLE, TEST W/ SOAP SUDS & AIR, LOCATE AT LEAST 45° OFF

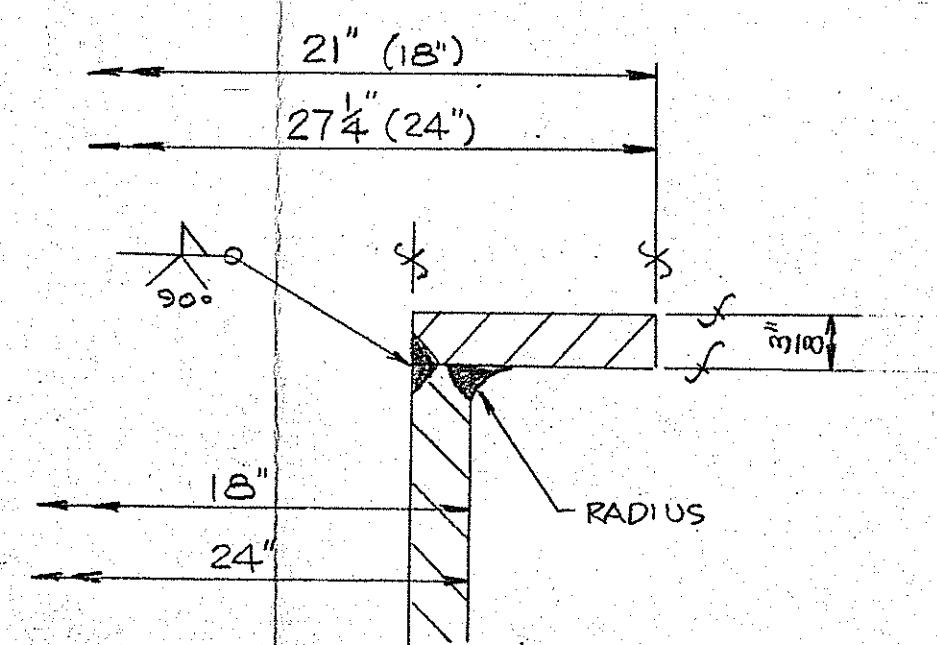
STANDARD F&D HEADS 60" D.R., 3 1/2" K.R., 1 1/2" S.F., 1/4" NOM. THK.



SECTION "A-A"



DETAIL "A" TYPICAL FLANGED NOZZ.



DETAIL "B" 18" x 24" FABRICATED L.J. STUB ENDS

NOZZLE SCHEDULE									
B/M MK	MARK	QUAN.	SIZE	RATING	TYPE	FACE	SCH.	SERVICE	REMARKS
4	A	1	4"	150#	L.J.	R.F.	40S	OUTLET	
5	B	1	18"				3/8" FL	C-518-4	26" O.D. x 1/4" PAD
6	C	1	6"				40S	INLET	
7	D	1	24"				3/8" FL	A-518-6	32" O.D. x 1/4" PAD
8	E	1	4"				40S	LEVEL	
9	F	1	8"	150#	L.J.	R.F.	40S	INLET	16 3/8" O.D. x 1/4" PAD

NOTES

1. VESSEL IS TO BE BUILT IN ACCORDANCE WITH HERCULES SPEC. 5C'S - 3T1 AND WELDED IN ACCORDANCE WITH SECT. IX OF THE 1965 ASME CODE, NO STAMP
2. DESIGN PRESSURE - 14 PSIG @ 200°F
3. OPERATING PRESSURE - ATMOSPHERIC @ 200°F
4. TEST PRESSURE - FULL OF WATER & HOLD FOR 2 HOURS
5. NO RADIOGRAPHY REQUIRED
6. JOINT EFFICIENCY - 70%
7. CORROSION ALLOWANCE - NONE
8. MATERIAL:
 - A. HEADS & SHELL - ASTM A-240 TYPE 304 STAINLESS STEEL, .04 MIN. CARBON
 - B. REINFORCING PADS - ASTM A-240 TYPE 304
 - C. NOZZLE NECKS - ASTM A-312 TYPE 304 & A-240 TYPE 304
 - D. STUB ENDS - ASTM A-403 TYPE 304
 - E. FLANGES - ASTM A-181 G21 FORGED STEEL
 - F. SUPPORTS - ASTM A-235 GR C F.Q. CARBON STEEL
 - G. BOLTING - NONE
 - H. GASKETS - NONE
 - J. FILLER METAL - TYPE 308 STAINLESS & TYPE 310 FOR STAINLESS TO CARBON
9. ALL CARBON STEEL PARTS ARE TO BE PAINTED ONE (1) SHOP COAT OF RED ZINC CHROMATE PRIMER, SHOTBLAST SURFACES TO BE PRIMED
10. VESSEL SHALL BE THOROUGHLY CLEANED INSIDE & OUT AND SHALL BE FREE FROM GREASE, MARKING, COMPOUNDS, WELD SPATTER, SCALE, SLAG, RUST, AND ANY OTHER FOREIGN MATTER, STAINLESS STEEL WIRE BRUSH & ACID WASH
11. CUSTOMER INSPECTION IS REQUIRED
12. MAXIMUM INSIDE PROJECTION OF NOZZLES IS TO BE 1/2"
13. ALL STUB END FACINGS TO HAVE A COMMERCIAL PHONOGRAPHIC SERRATED FINISH
14. VESSEL ITEM NUMBER IS TO BE PAINTED ON VESSEL IN 3" HIGH LETTERS WITH A CHLORIDE FREE PAINT
15. NAMEPLATE IS TO BE STAINLESS STEEL AND STAMPED WITH THE FOLLOWING INFORMATION:
 - 1. NAME OF MANUFACTURER
 - 2. DESIGN PRESSURE & TEMPERATURE
 - 3. MANUFACTURER'S SERIAL NO.
 - 4. YEAR BUILT
 - 5. NAME & ITEM NO. OF VESSEL
16. TWO (2) VESSELS REQUIRED
17. APPROXIMATE WEIGHT EACH - 3,827 LBS.

B.P.F. NO. 37635	DATE 6/2/67
SHEET 1	APPARATUS T-518
PROJECT & ACCOUNT 26001	NO. T-2518
ORDER NO. 335-026-01172	2004
PLANT HANOVER	2017
APPROVED	

HERCULES P.O. NO. 336-026-01172-03-000-FCD
HERCULES DWG. NO. 026-2004-52008-2WE REV. 3

REVISIONS				RICHMOND ENGINEERING CO., INC.			
MK.	DESCRIPTION	BY	DATE	RICHMOND VIRGINIA			
1	REVISED LOCATION OF NOZZLES C & F PER CUSTOMER	W.H.	5/24/67	SLURRY TANK SCRUBBER			
2	REVISED IN ACCORDANCE WITH CUSTOMER'S APPROVED AS NOTED	D.H.	6/1/67	ITEMS T-518 & T-2518 60" O.D. x 10'0" TAN-TAIL FOR: HERCULES POWDER COMPANY			
JOB NO. 166814.75				NO. SHEETS - 5			
DATE 4/12/67				SHEET NO. -			
DRAWN BY RMH				DRAWING NUMBER			
TRACED BY				APPROVED			
				D-67-160-2			