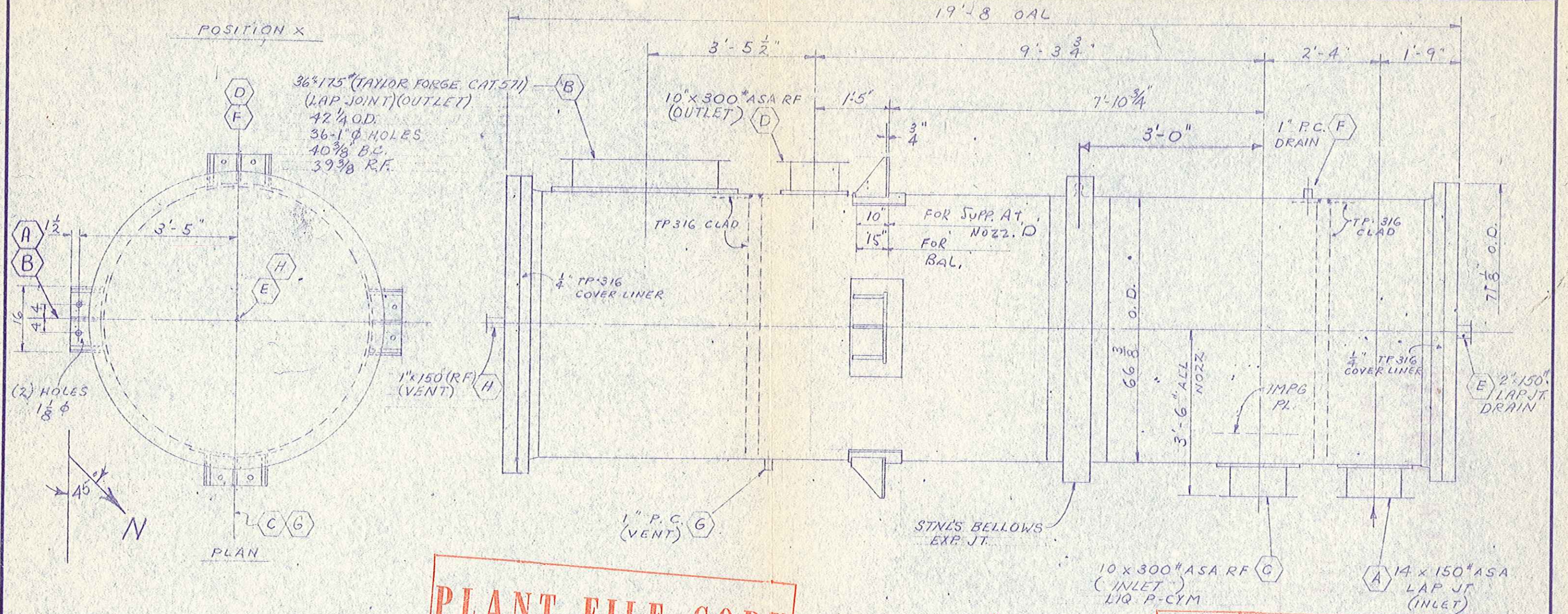


#104032 #104127 E 204-2

STRUTHERS WELLS CORPORATION HEAT EXCHANGER CONSTRUCTION SHEET				ORDER NUMBER 66-4-6218	
PURCHASER Hercules Inc. Wilmington, Del.				PURCHASERS ORDER 336-026-01090-11	
EQUIPMENT Main Prestill Reboiler INSTALLATION Wilmington, N.C.				-000-ECD Items E-204-2 &	
NO. REQ'D. 2 SIZE 65 ID x 12'-0" T.L. CODE SIZE 66-12NX11-10V				MADE Marc	CHECKED DAC
SHELL SIDE 200# HAMMER TEST 300# MAX. TEMP. 600° F. CORR. 1/16 on STL				REVISIONS	
TUBE SIDE 150# HAMMER TEST 225# MAX. TEMP. 500° F. CORR. ALL				1	
FLUID SHELL SIDE P-Cymene FLUID TUBE SIDE Organics				2	
NO. TUBES 1348 - 1 1/4 O.D. .065 AVG. THK. WALL Welded Stnls. TP 316 SA-249				3	
MANUF. CODE ASME Sect. 8 TEMA C INSPECTION Hart. & Cust. STAMP Natl. Bd.				4	
PART	DRAWING NO.	MATERIAL	SPEC.	REMARKS	
SETTING PLAN	B1				
SHELL	D1	Fbx Stl.	SA-285-C	FLGS.	
SHELL NOZZLES	SW3A2	Smis. Stl. Fgd. Stl.	SA-106-B SA-181-2	SIZE 10" x 300# ASA WNF	
SHELL COVER				FLGS.	
CHANNEL	D1	Stnls. TP 316 Clad Fbx 285-C	SA-240-Clad Backing	FLGS. Fgd. Stl. 105-2 w/tp 316 overlay	
CHAN. NOZZLES	SW3A8 D1	Stnls. Stl. Fgd. Stl.	TP 316 SA-240 SA-181-1	Lap Jt. SIZE 14", 36 x 150# ASA	
CHANNEL COVER	D1	Fbx Stl.	SA-212-B w/stnls.	TP 316 Liner	
FLOATING COVER				PART NO.	
TUBE SHEETS	D1 & D2	Stnls. TP 316 Clad Fbx 212-B	SA-240-Clad Backing		
TUBE LAYOUT	C1			1-9/16 Tri. Pitch	
TUBE GROOVING	D1			Dbl. & Welded	
CROSS BAFFLES	D2	Stl.	NO. 8 THK. 3/8 CUT C. Line	DRILL REAM 1-9/32	
SUPPORT PLATES			NO. THK. CUT	PITCH DRILL REAM	
Imp. BAFFLE	D2	Steel			
HOOK RING					
Expansion Jt.	D1	Stnls.	Bellows Type		
TIE RODS	D2	HRS		10-1/2 Dia.	
SPACERS	D2	STEEL		3/4 O.D.	
GASKETS	D1	Flexitallic	TP 316 w/asb. Filler		
BOLTS	D1	Alloy Stl.	SA-193-B7		
NUTS	D1	Carb. Stl.	SA-194-2H		
SHELL SUPPORTS	D1	Steel			
NAME PLATE & ATTACHMENT	A-14400 B-6360				
WELDING	D2				
FLANGING			HEAT TREAT: NONE		
WELDING	ASME 1965				
WELD FINISH	Normal, grind where nec.				
X-RAY	Spot shell & Chan.		SHIP. INST. Ship intact, protect openings		
SURFACE FINISH	Normal, clean up I.S. & O.S. of all mill scale, rust, etc.		SPECIAL INST. Paint equipment No. in 2" high letters on side of units		
& paint O.S. (1) coat alum. on stl. only E-204-2 and E-2204-2					

#14700
1-Coat Support Logs Only of Devote Chem-Zinc
Film Thk. Dry to Be 3 to 5 MILS



NOZZLE BOLT HOLES TO STR & COUPS ARE 3000" SCREWED

WT. EMPTY 58,000# Est.
WT. FLOODED 85,000#

PLANT FILE COPY
DO NOT REMOVE FROM FILES

#104032
#104127

DRAWING CERTIFIED FOR FABRICATION

Ch. Decker
Chief Draftsman 2-9-67

PLANT FILE COPY
DO NOT REMOVE FROM FILES

	SHELL SIDE	TUBE SIDE
DESIGN PRESS.	200#	150#
TEST PRESS.	300#	225#
DESIGN TEMP.	600°F	500°F
CORR. ALLOW.	1/16 (STL)	-

HERCULES INCORPORATED
CUST. ORD. 336-026-01090 11 000 FCD
ITEM NO. E-204-2 & E-2204-2

2 UNITS
SERVICE: MAIN PRESTILL REBOILER
S.W. ORD NO. 66-4-6218

B.P.F. NO. 37230 DATE 3/7/67
SHEET 1 APPARATUS NO. E-204-2
PROJECT & ACCOUNT 26001 2001 2014

ORDER NO. 336-026-01090

PLANT Wilmington
APPROVED *H. G. Schuber*

REV. A	CKD:	REV. A	CKD:
CHANGED PER CUST. APPROVAL OF 12-27-66 BOSKO 1-18-67			
SETTING PLAN OF HEAT EXCH. 66" O.D. x 12'-0" T.L.			
DRAWN: <i>K. N. D.</i>	1/12	66-4-6218 B1	
CHECKED: <i>DAC</i>	1-6		
APPROVED: <i>D</i>	2-1-67		
SCALE: 1/12	DATE		

STRUTHERS WELLS CORPORATION • WARREN, PE