

NOZZLE SCHEDULE			SERVICE
MARK	SCH	DESCRIPTION	
1	3/8	SPECIAL - SEE DETAIL 5	VAPOR LIQUID IN
2	3/8	150# L.J. FLG AND FAB. STUB END W/2" WIDE x 1/4" REINF. PAD - SEE DETAIL 2	VAPOR OUT
3	80S	150# L.J. # BL. FLG W/FAB. STUB END - DET. 2	SPARE
4	80S	150# L.J. FLG W/FAB. STUB END - DETAIL 2	SAFETY VALVE
5	3/8	DITTO W/13/4" WIDE x 1/8" REINF. PAD	LIQUID OUT
6	80S	150# L.J. FLG W/FAB. STUB END - DETAIL 2	BLOW DOWN
7		STUDDING PAD - SEE DETAIL 6	SIGHT GLASS
8		DITTO	LEVEL
9		DITTO	HIGH LEVEL
10	3/8	SPECIAL - SEE DETAIL 7 AND DWG A-45	MANHOLE
11		STUDDING PAD - SEE DETAIL 6	PRESSURE
12		DITTO	TEMPERATURE

DESIGN DATA

1. DESIGN PRESSURE AND TEMPERATURE - 75 PSIG AT 350° F.
2. CORROSION ALLOWANCE - 1/4".

CONSTRUCTION NOTES

1. VESSEL TO BE DESIGNED AND CONSTRUCTED PER 1974 ASME SECTION VIII, DIV. 1, AND SO STAMPED.
2. MATERIAL
 - SH, HDS - SA240TP316L
 - NOZ NKS - SA312TP316L AND SA240TP316L
 - FLG - SA240TP316L
 - FLG - SA181GR1 AND SA515GR70 GALV.
 - SA182F316L
 - HDS COVER - SA515 GR70 GALV.
 - GS - SA36
 - FLG - SA240TP316L AND SA479TP316L
 - FLG SUPITS - C/S
 - SKETS - JM61 - FOR TEST
 - FLEXITALLIC TP CG 316L TFE FILLED - FOR COMP CONN
 - 1/3 B7 CAD PLTD
 - SA194 2H CAD PLTD

TO BE WELDED WITH TYPE 316MC S/S FILLER

1. VESSEL TO BE WELDED TO STRADDLE 0°-180° & OR ITS PARALLEL.
2. PARTIAL X RAY REQ'D.
3. VESSEL TO BE THOROUGHLY CLEANED INSIDE AND OUTSIDE AND SHALL BE FREE FROM GREASE, ALL MARKING COMPOUNDS, WELD SPATTER, SLAG, AND ANY FOREIGN MATTER.
4. SURFACE FINISH - 125AA.
5. TEST - 120 PSIG HYDRO. HOLD FOR 2 HOURS.
6. VESSEL TO BE CLEARLY IDENTIFIED BY PAINTING OR STENCILING THE HERCULES VESSEL NO. AT LEAST 3" HIGH IN A CONSPICUOUS LOCATION WITH A CHLORIDE-FREE PAINT.
7. ON COMPLETED CONN, SHIP TEST GASKETS IN PLACE AND SHIP ONE SET NEW GASKETS SEPARATELY.
8. CAPACITY - 2334 GALS.
9. WEIGHTS - EMPTY = 8089 LBS.
10. FULL OF WATER = 27,538 LBS.
11. ONE VESSEL REQ'D.

#104195

VENDOR	DATE
PRINT FILE	48108 8/16/76
EQUIPMENT	NOS. S-6920-11
SHEET	1
PROJECT & ACCOUNT NOS.	26113
PURCHASE ORDER NO.	336-026-1130011
PLANT	MANOVER
REVIEWED - DRAFTING DESIGN	
APPROVED - ENGINEER	Will M. [Signature]

REFERENCE

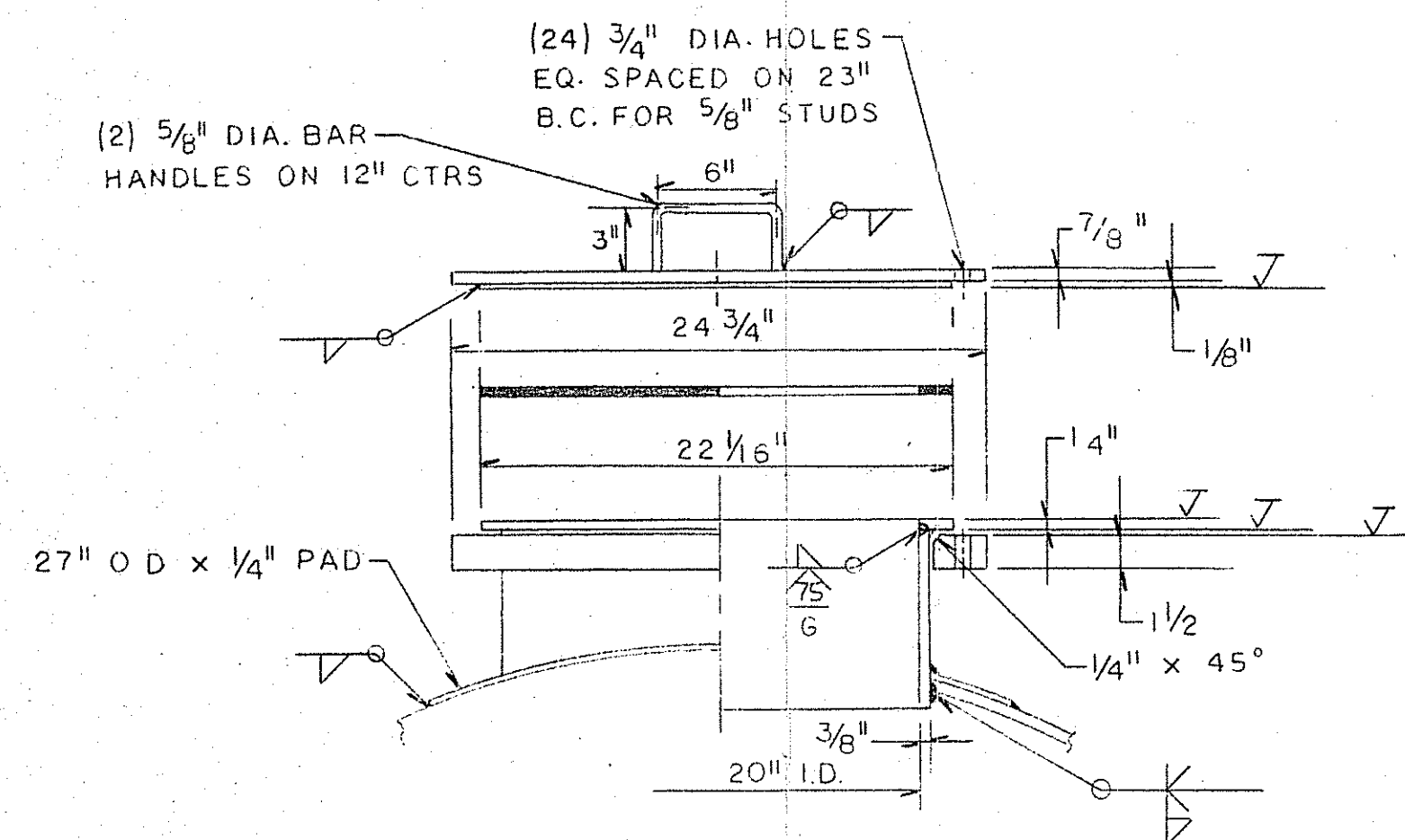
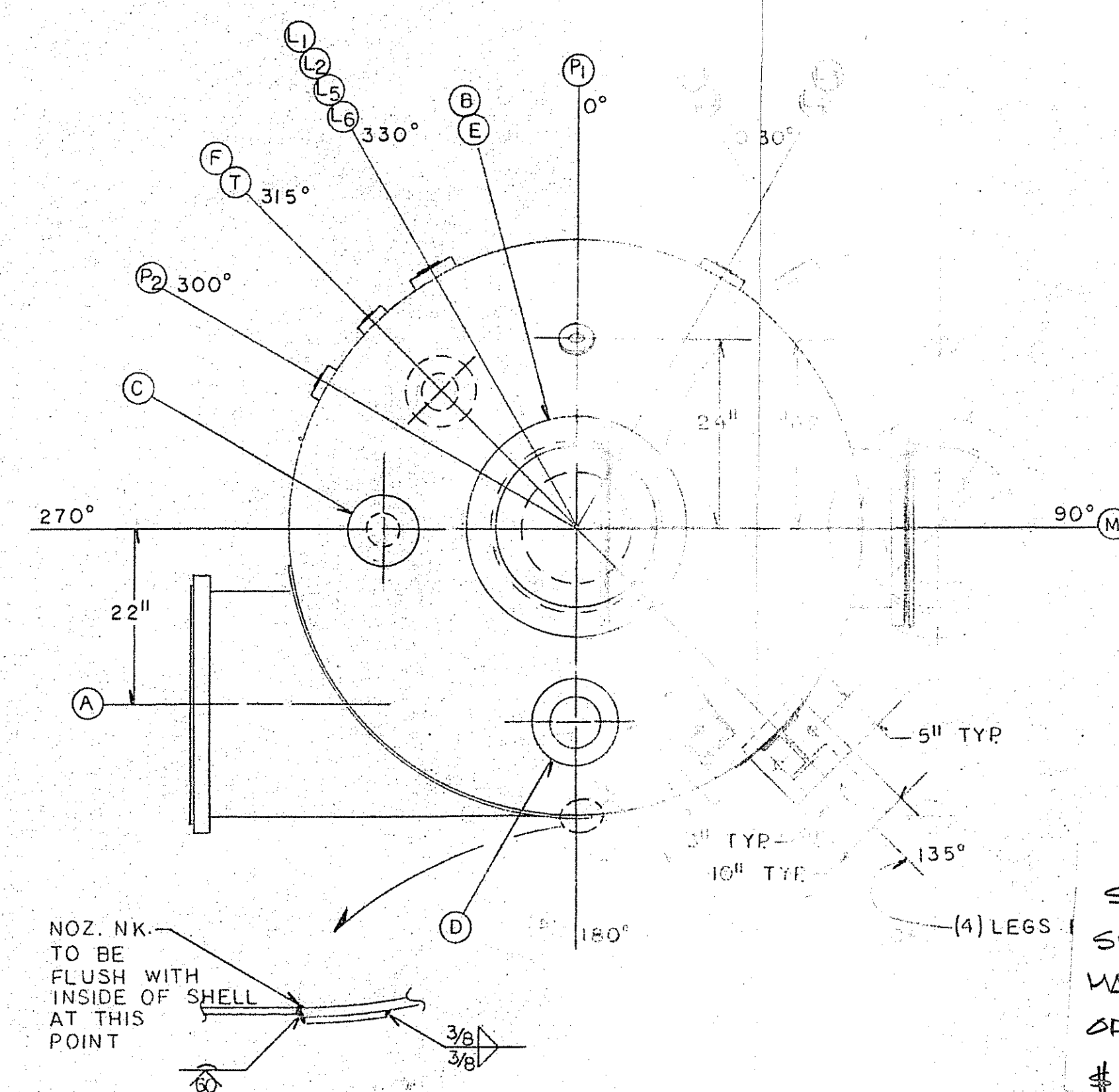
HERCULES P.O. NO. 336-026-1130011-TES
DWG. NO. 026-8577-52001-4WN REV. 0
VESSEL NO. S-6920-11

INDUSTRIAL ALLOY FABRICATORS, INC.
RICHMOND, VIRGINIA 23222

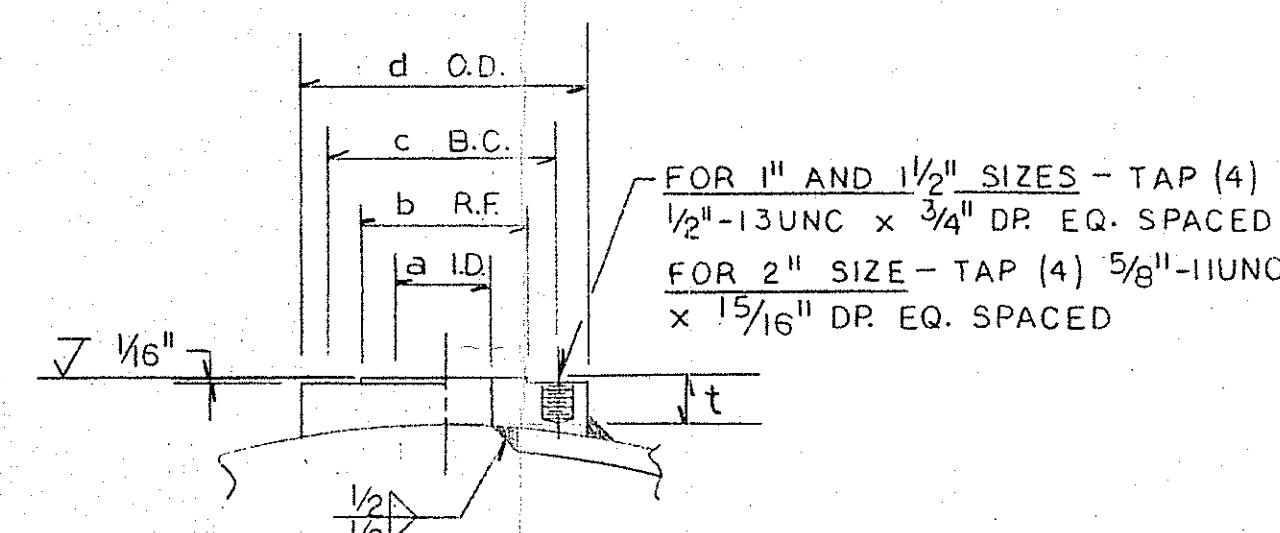
#2 THERMAL OXIDIZER VAPORIZER
SEPARATOR

HERCULES INCORPORATED

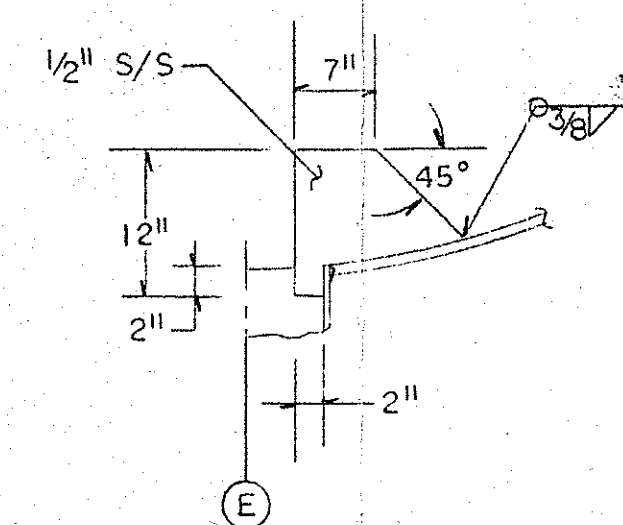
MARK	REVISION DESCRIPTION	BY	DATE	SCALE	3/4" = 1'-0"	DATE	15 JULY 76	D-1572A
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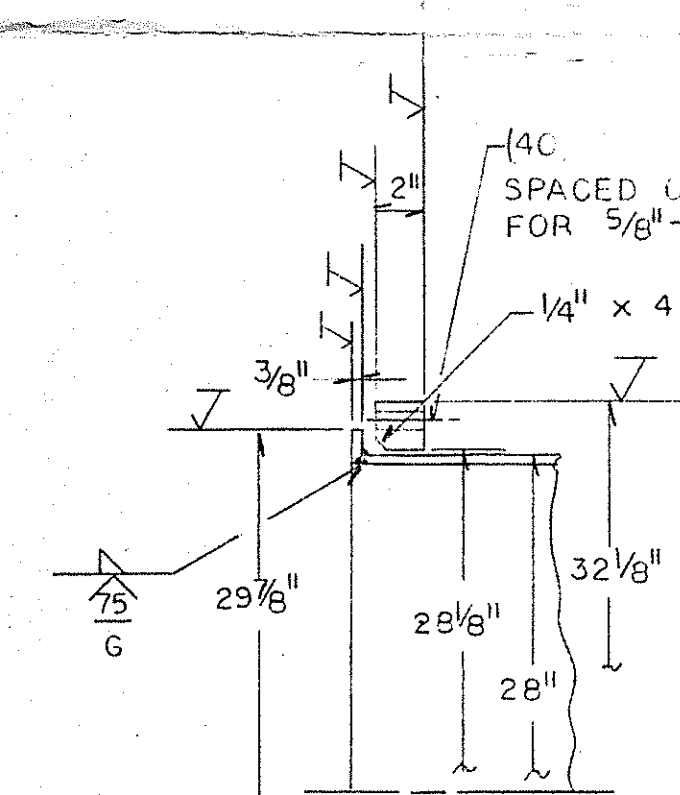
DETAIL 7



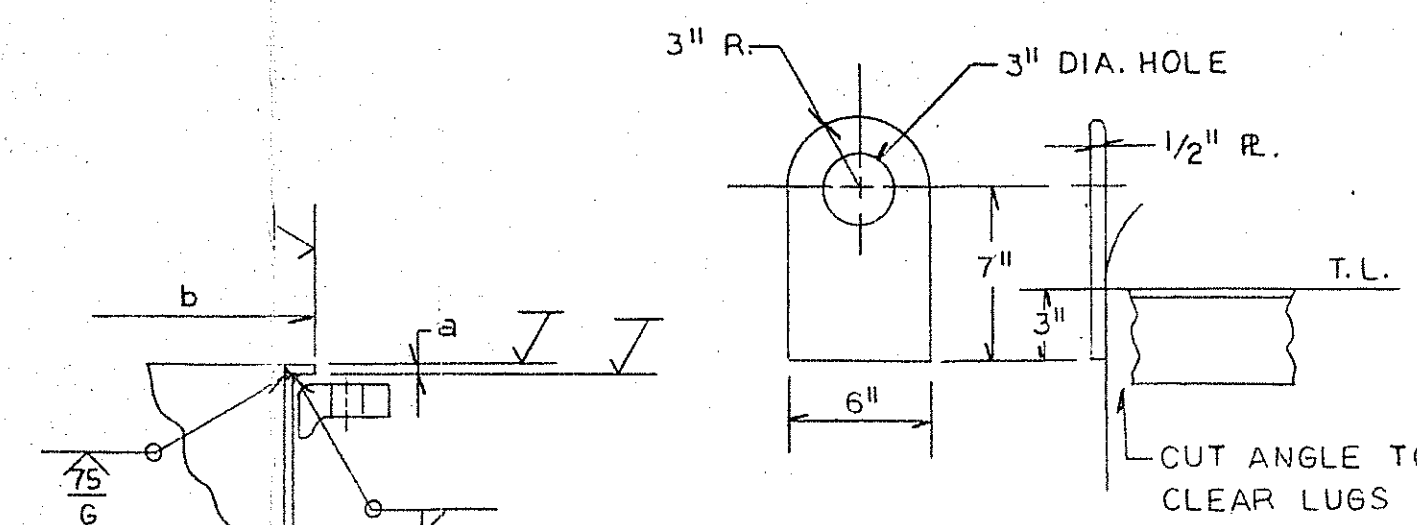
DETAIL 6



DETAIL 4



DETAIL 5



DETAIL 3
LOCATE AT 0°, 120°, 240°

SIZE	a	b
4	.337	6 3/16
6	.432	8 1/2
14	.375	16 1/4
20	.375	23

DETAIL 2

