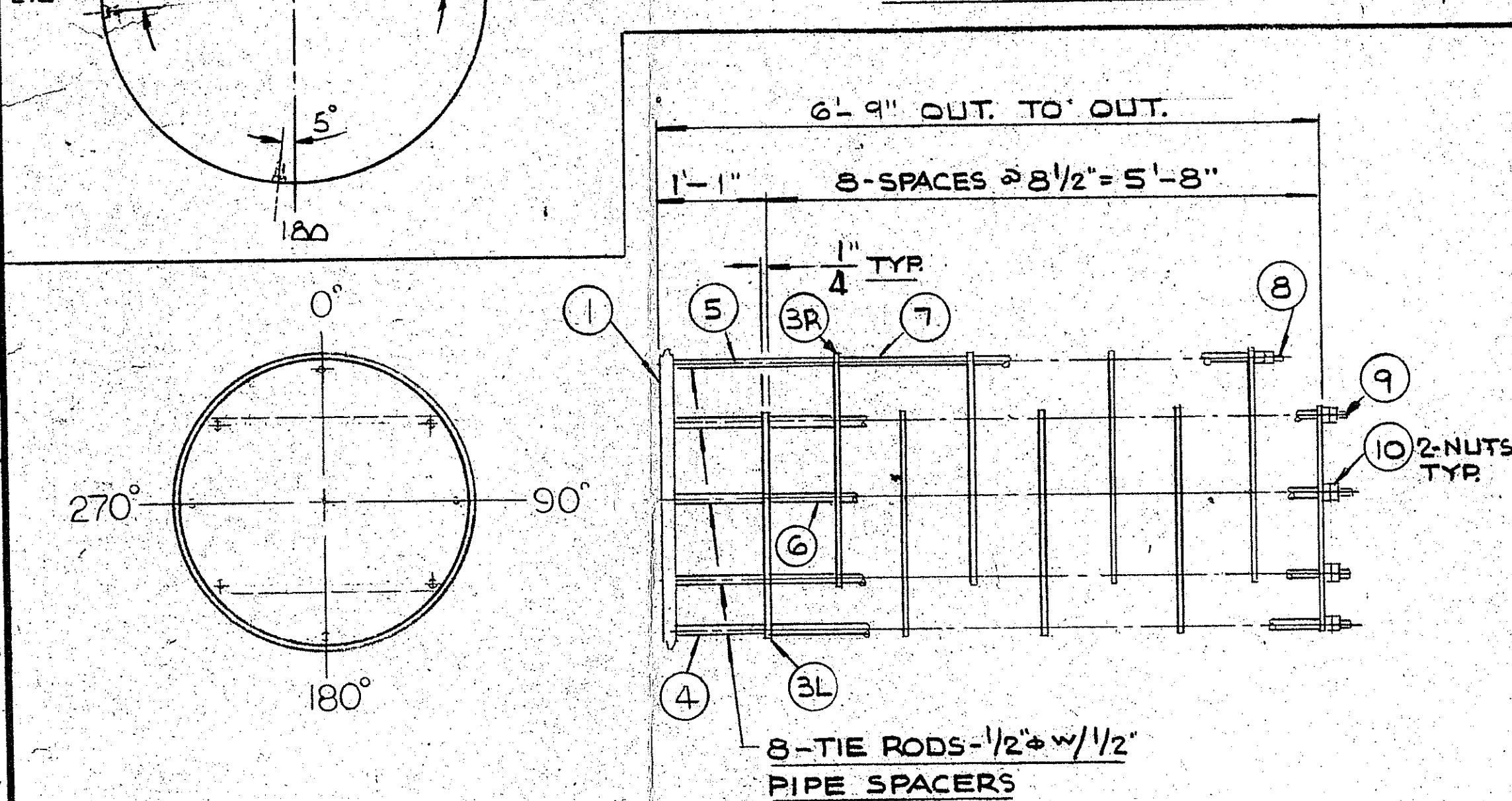


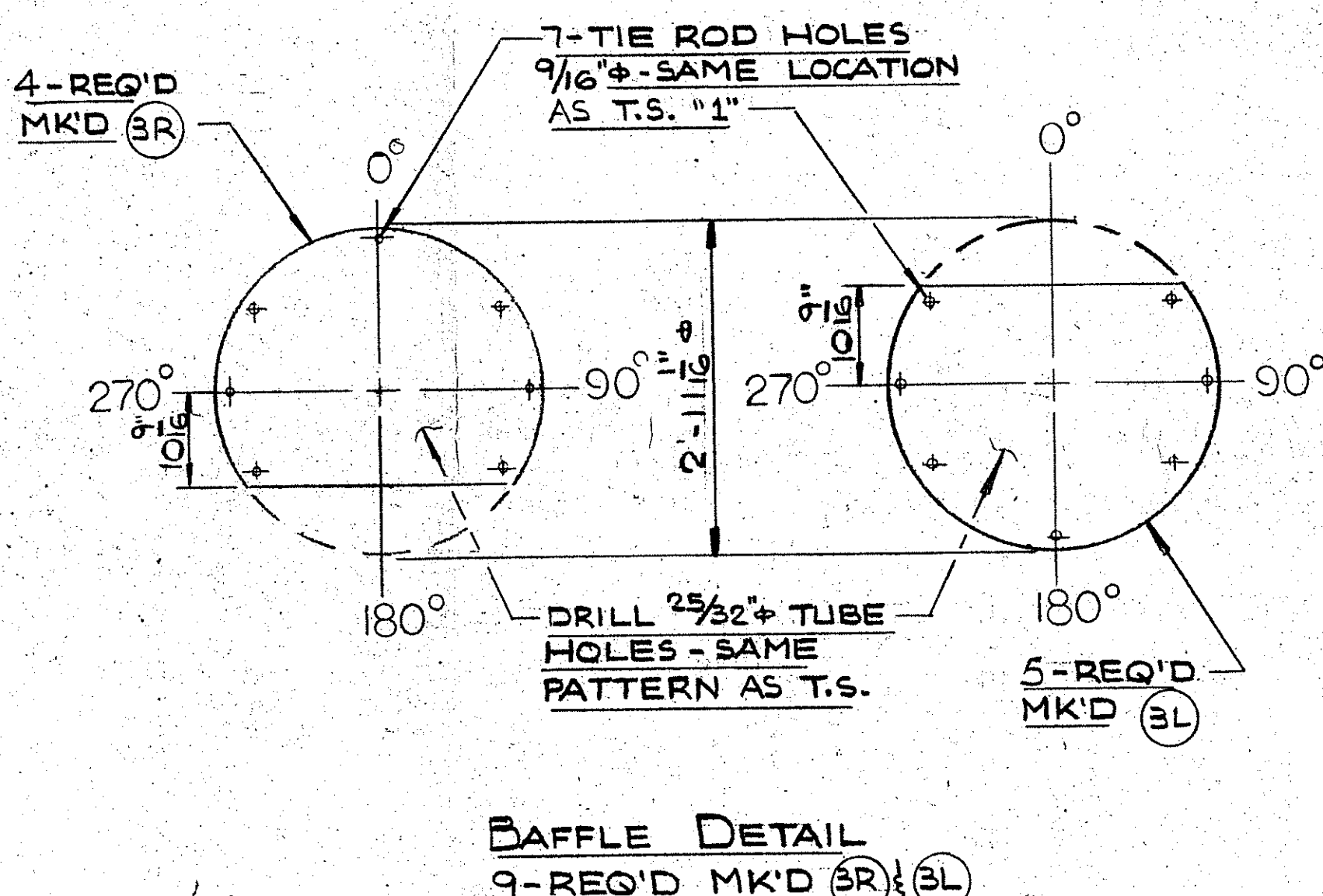
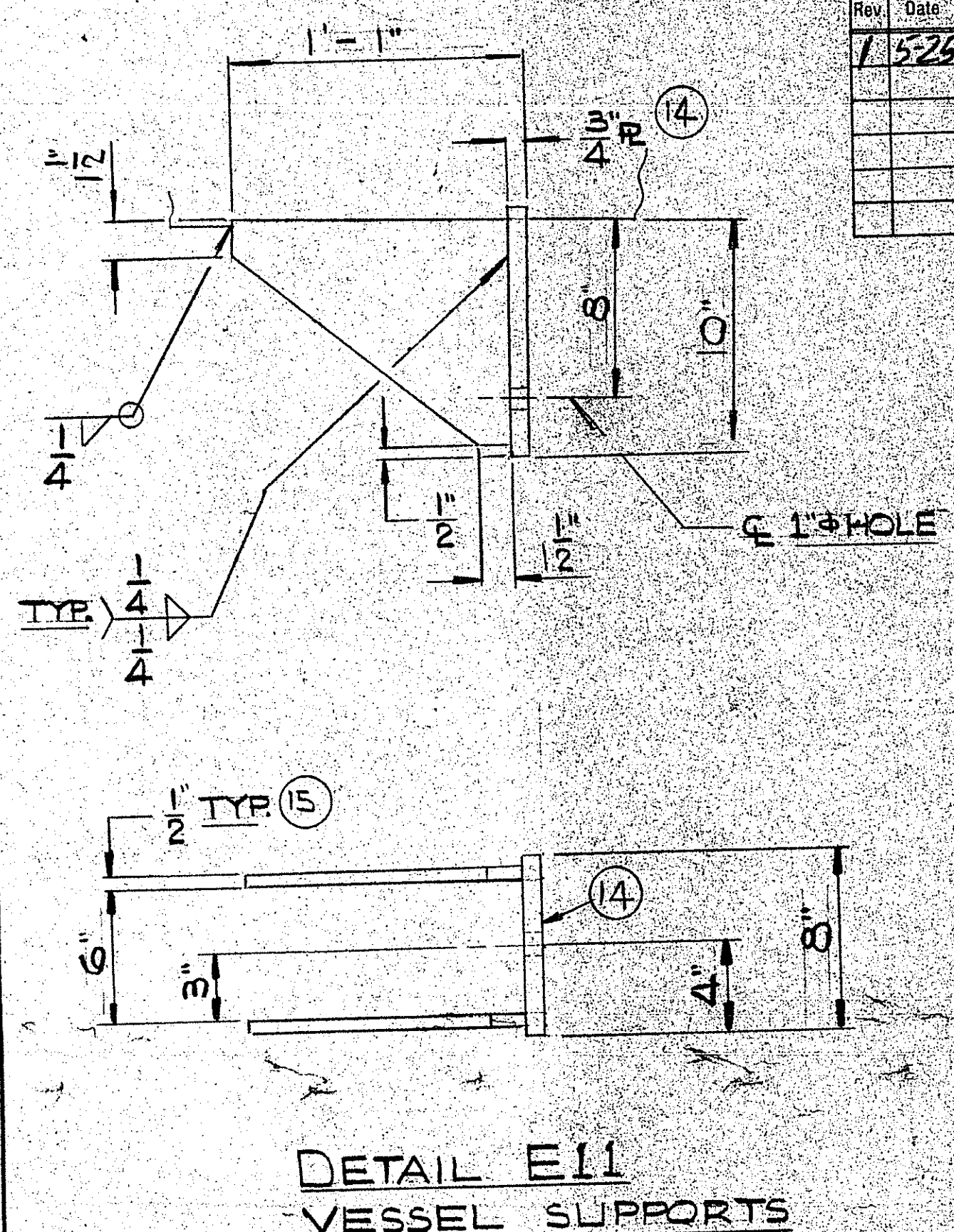
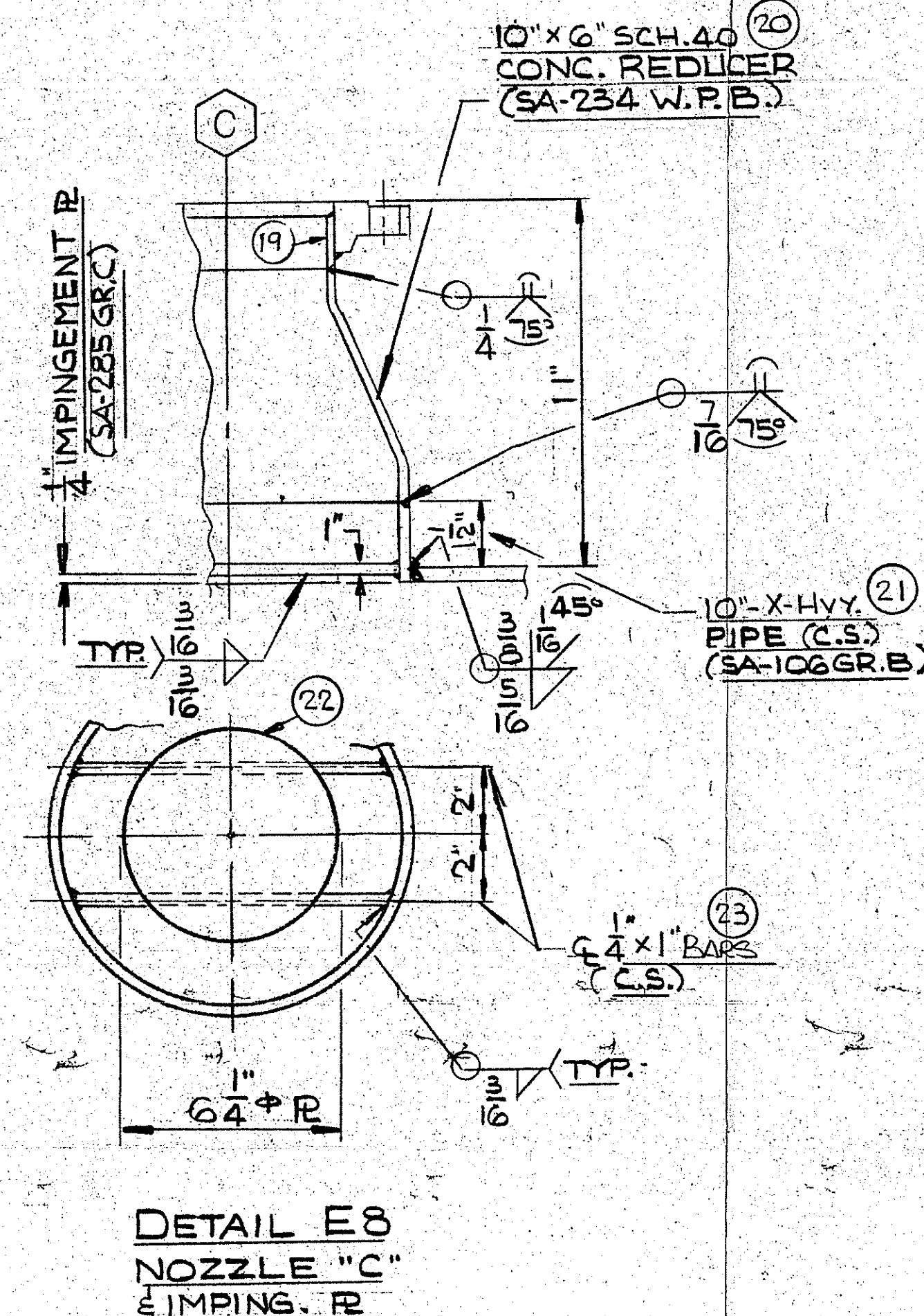
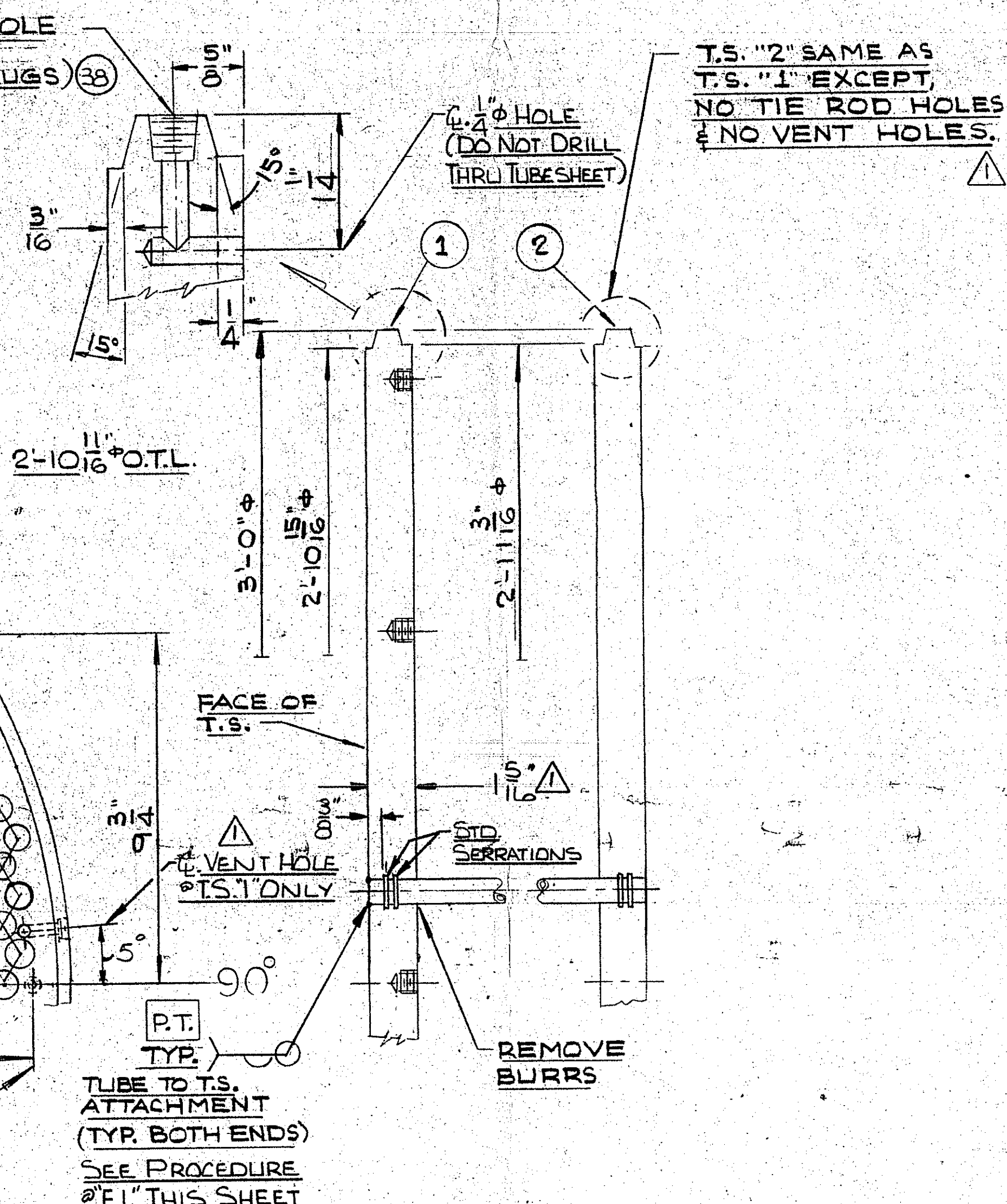
PROCEDURE FOR TUBE TO TUBESHEET ATTACHMENT

1. Weld tube to tubesheet as shown.
2. Air and soap suds test w/10 PSI air on shell side.
3. Roll tubes to within 1/8" of backside of tubesheet and to within 1/8" of tube to tubesheet weld at face of tubesheet.
4. Conduct hydro. test.
5. Examine tube attachment with liquid penetrant.



SPACER		SCHEDULE
Mk.	Nº REQ'D	LENGTH
(4)	7	11 ⁷ / ₁₆ Δ
(5)	1	1'-7 ⁵ / ₁₆ " Δ
(6)	48	8 ¹ / ₄ "
(7)	7	1'-4 ³ / ₄ "

TUBESHEET DETAIL
ONE EACH REQ'D MK'D (1) & (2)



BAFFLE DETAIL
9-REQ'D MK'D (3R) & (3L)

THIS PRINT CERTIFIED FOR CONSTRUCTION FOR HERCOFINA		CUST. ORDER NO. X-1670001	
MISSOURI BOILER & TANK CO. JOB NO. C-5044		DATE 5-30-84 BY JMS APP. B.B.	
6			
5			
4			
3			
2	CERTIFIED DWG.		BY B.B.
1	APPROX. TUBE SHEET TANK REV. N.B. OF TUBE SHEET VENT HOLE & ADD'D SPACES. LEAKTIGHTS		CHKD W.B.
NO.	DATE	REVISION	BY APP. C.N.
This drawing has been furnished by Missouri Boiler. The information, know-how, and all new or patentable features are the property of Missouri Boiler and must not be copied or reproduced without permission. The foregoing in no way applies to design and features which are our customers' property.			
MISSOURI BOILER AND TANK CO. DIVISION OF MORTER CORPORATION P. O. BOX 14704, ST. LOUIS, MISSOURI 63178			
MISC. DETAILS FOR E-4400-11R HERCOFINA WILMINGTON, N.C.			
DATE 3-27-84		JOB NO. C-5044	
DRAWN DF		REC. Q	
APP. DF		SHEET NO.	
CHKD. HA		APR. MD-C-5044	
		2	