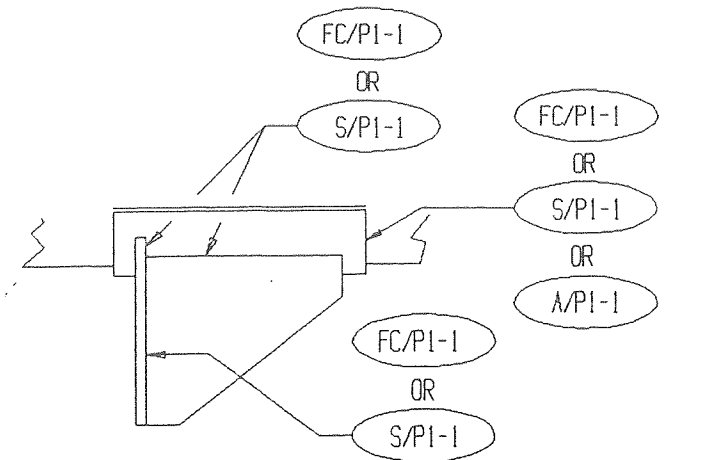
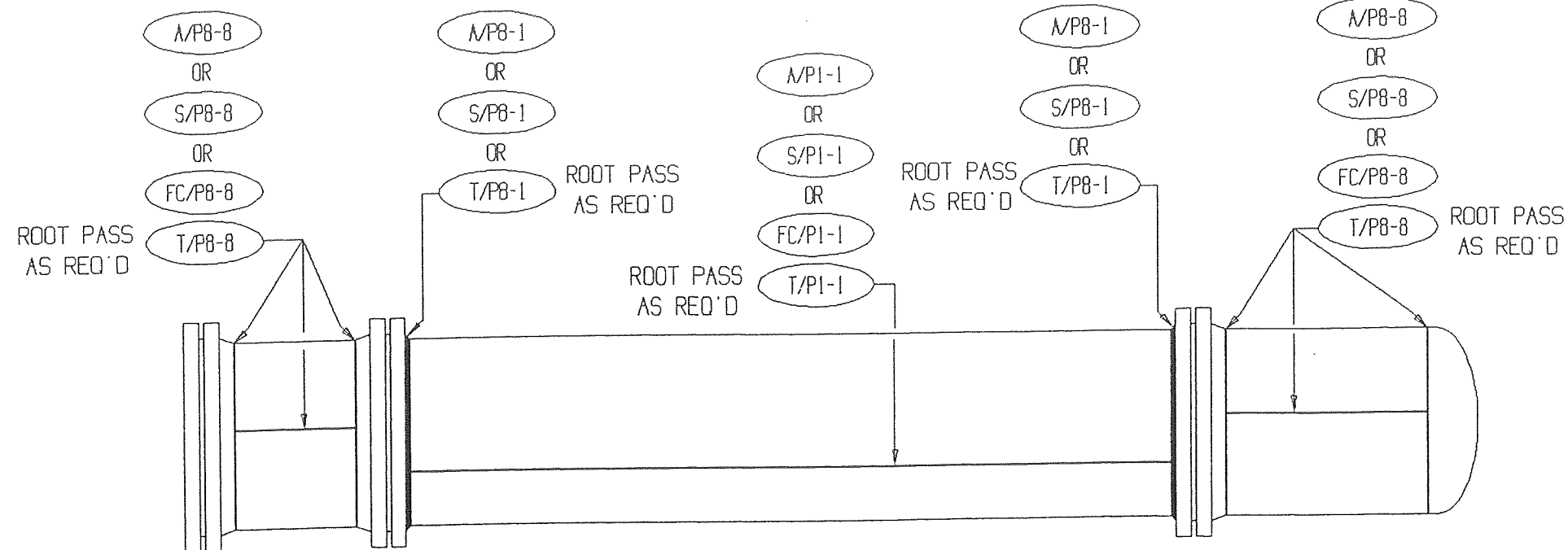
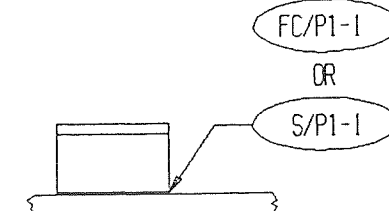
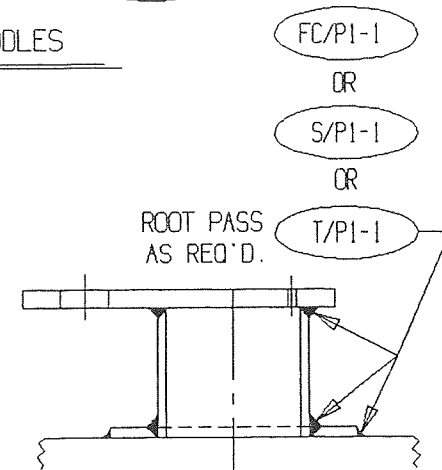




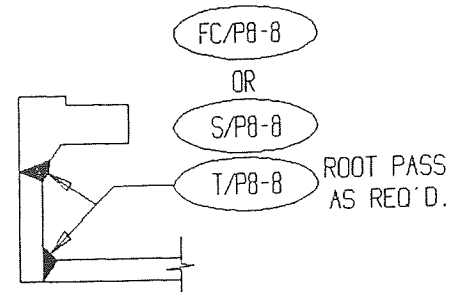
SUPPORT SADDLES



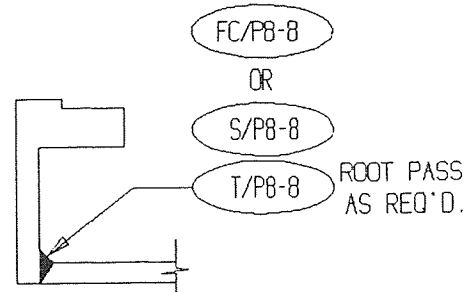
TYPICAL GUIDE & NAMEPLATE BRACKET



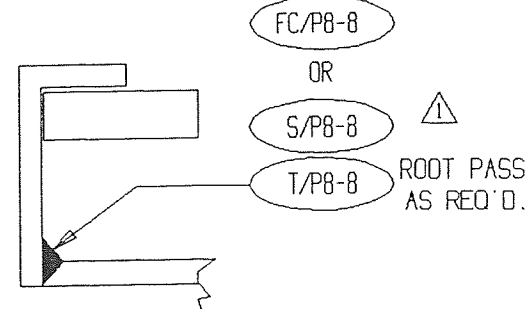
LIFTING TRUNNION



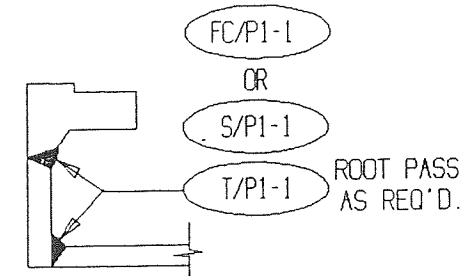
TYPICAL WELD NECK NOZZLE W/O PAD
TUBESIDE



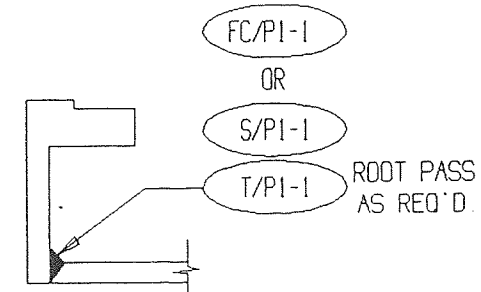
TYPICAL L.W.N. NOZZLE
TUBESIDE



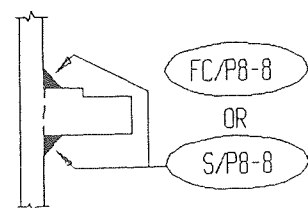
TYPICAL LAP JOINT NOZZLE
TUBESIDE



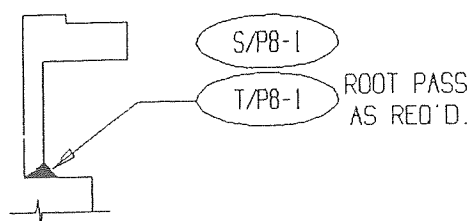
TYPICAL WELD NECK NOZZLE W/O PAD
SHELLSIDE



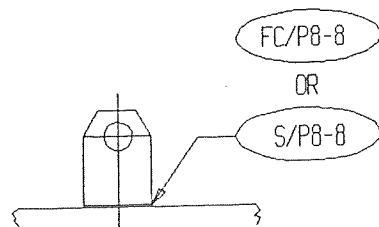
TYPICAL L.W.N. NOZZLE
SHELLSIDE



NOZZLE TO BLIND
TUBESIDE



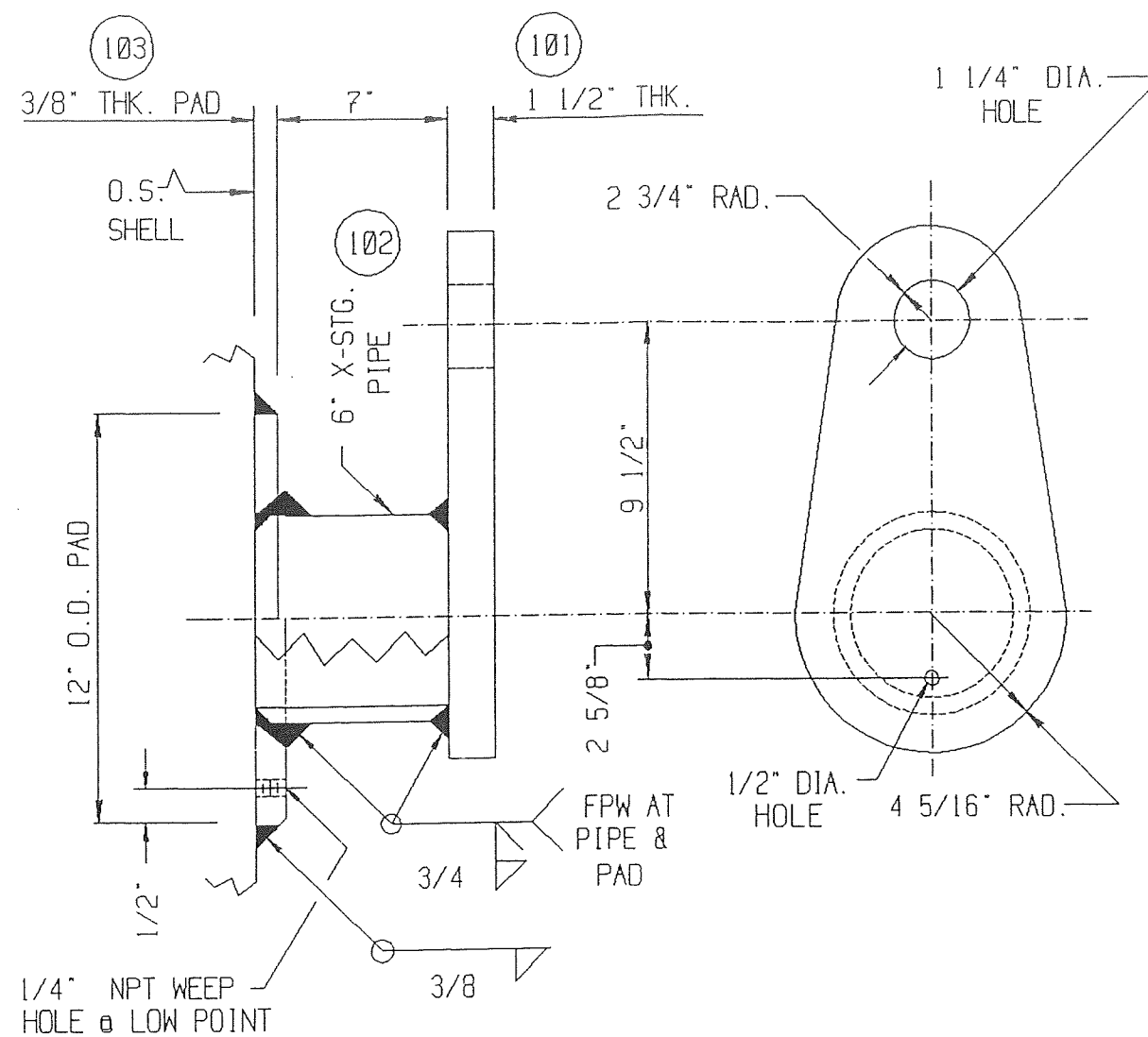
L.W.N. NOZZLE TO T'SHT



TYPICAL LIFT LUG

					CUSTOMER: DOW CHEMICAL COMPANY			
					OHMSTEDE JOB NO.: 938268			
					P.O. NO.: 63309586			
					ITEM NO.: E-565S			
					SERVICE: CONDENSER			
					VIN:			
1	RELEASE FOR FAB	TAN	BH	10-7-99	WELD MAP			
Ø	FOR CUSTOMER APPROVAL	TAN	BH	9-9-99	OHMSTEDE	DRAWING NO. 938268	SHEET NO. 2	REV. 1
NO.	REVISIONS	BY	CHK.	DATE CHK.				

					CUSTOMER: DOW CHEMICAL COMPANY			
					OHMSTEDE JOB NO.: 938268			
					P.O. NO.: 63309586			
					ITEM NO.: E-565S			
					SERVICE : CONDENSER			
					VIN:			
1	ADDED DAVIT DETAILS	TN	BH	10-28-99	SPRAY NOZZLE / DAVIT DETAILS			
0	RELEASE FOR FAB	TN	BH	10-7-99				
NO.	REVISIONS	BY	CHK.	DATE CHK.	OHMSTEDE	DRAWING NO. 938268	SHEET NO. 3A	REV 1



TRUNNION DETAILS

(2) REQ'D.

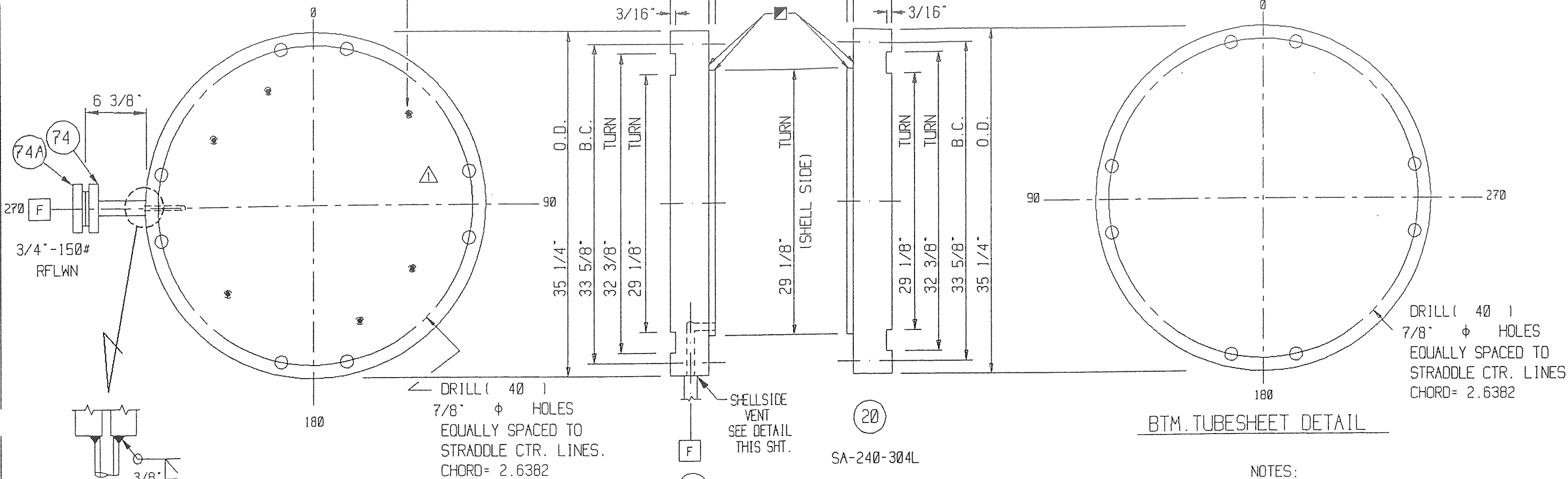
NOTE:

MT / PT EXAMINE TRUNNION
AND PAD ATTACHMENT WELDS.

					CUSTOMER: DOW CHEMICAL COMPANY			
					OHMSTEDE JOB NO.: 938268			
					P.O. NO.: 63309586			
					ITEM NO.: E-565S			
					SERVICE : CONDENSER			
					VIN:			
					TRUNNION DETAILS			
Ø	RELEASE FOR FAB	TN	BH	10-7-99	OHMSTEDE	DRAWING NO.	SHEET NO.	REV.
NO.	REVISIONS	BY	CHK.	DATE CHK.		938268	4A	Ø

DRILL & TAP 3/4" DEEP FOR 6 - 1/2" DIA. —
TIE RODS ON SHELL SIDE OF
19 TUBESHEET. DO NOT DRILL THRU
(SEE TUBE LAYOUT FOR LOCATIONS.)

SHOP NOTE!
SURFACES MARKED THUS 
TO BE P.T. EXAMINED
AFTER MACHINING.



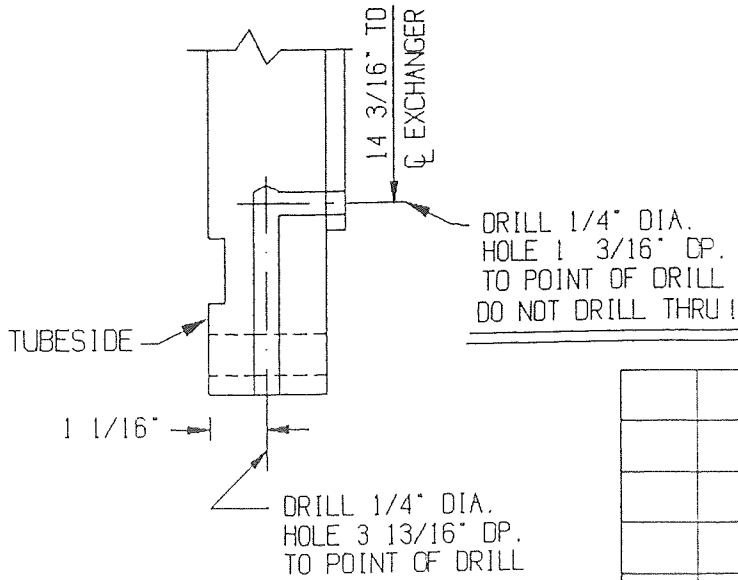
BTM. TUBESHEET DETAIL

NOTES:
1) MACHINE ALL GASKET SURFACES TO
125 - 250 AARH SERRATED FINISH
OF 40-55 GROOVES PER INCH.

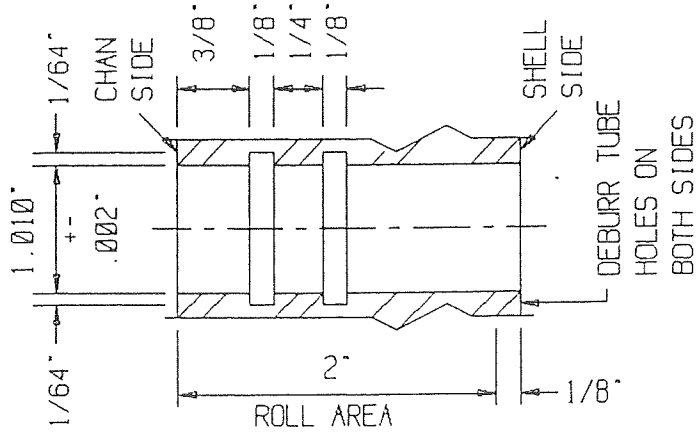
NOZ. "F" BOLTING

- (53) STUDS
- (54) NUTS

TOP TUBESHEET DETAIL

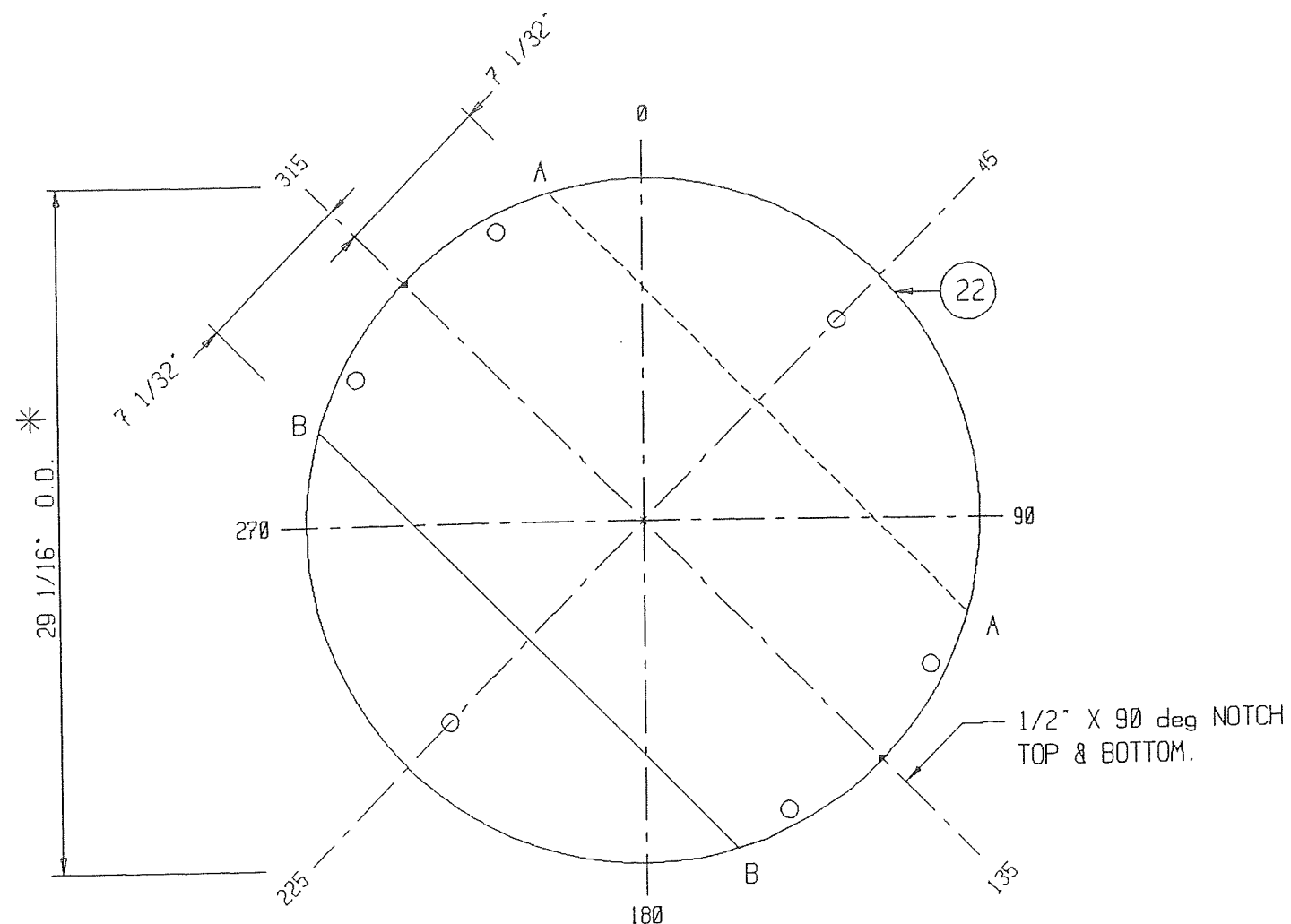


VENT DETAIL



TUBE HOLE GROOVING DETAIL

					CUSTOMER: DOW CHEMICAL COMPANY			
					OHMSTEDE JOB NO.: 938268			
					P.O. NO.: 63309586			
					ITEM NO.: E-565S			
					SERVICE : CONDENSER			
					VIN:			
1	REVISED AS NOTED	TN	BH	11-15-99	TUBESHEET DETAILS			
0	RELEASE FOR FAB	TN	BH	10-7-99				
NO.	REVISIONS	BY	CHK.	DATE CHK.				



VIEW ZZ OF BAFFLES

1/4" THK.

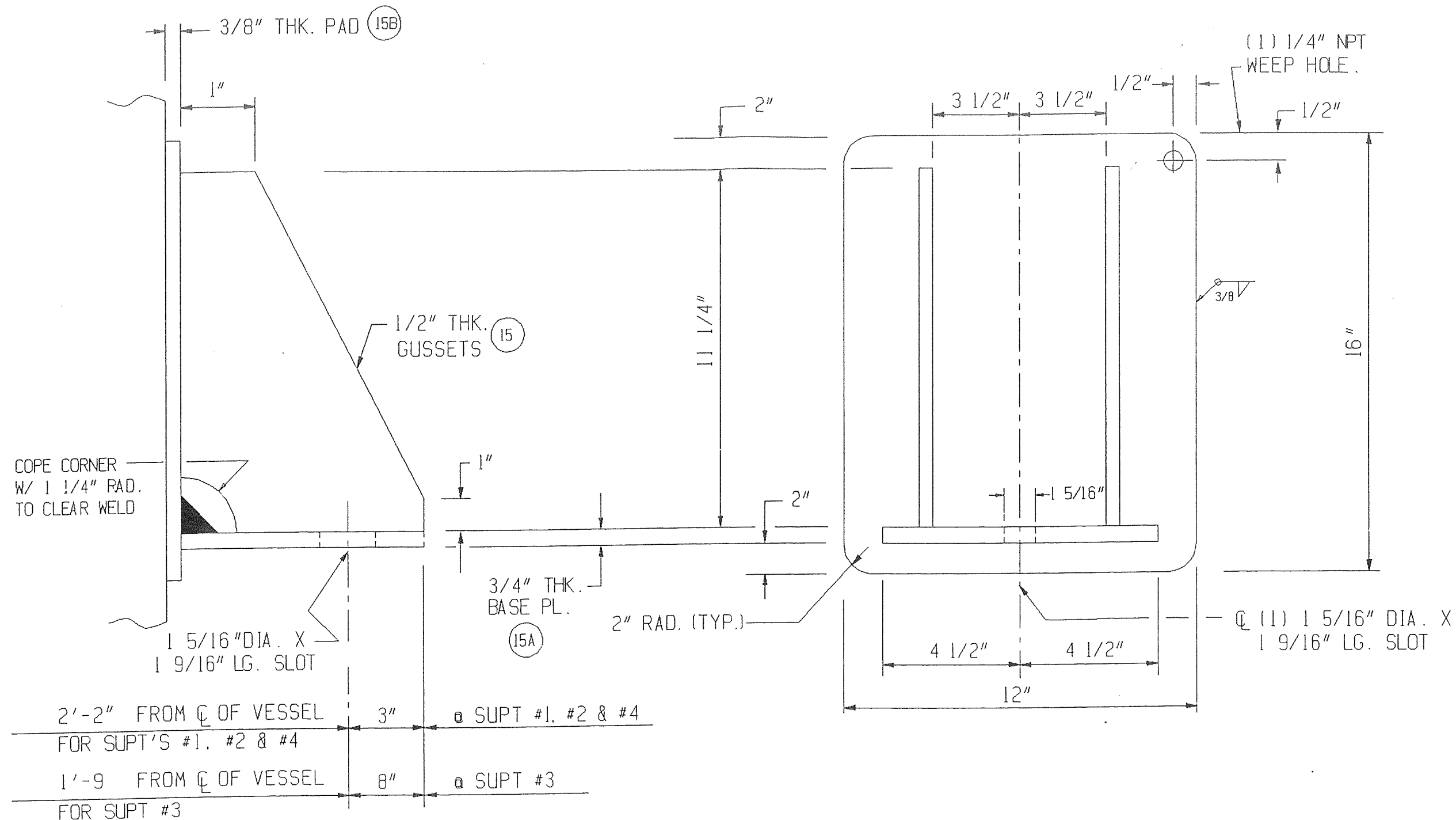
8 -REQ'D. CUTBB

7 -REQ'D. CUTAA

NOTES:

- 1) DRILL TUBE HOLES IN BAFFLES 1 1/32" DIA. & DEBURR.
- 2) DRILL TIE ROD HOLES 9/16" DIA.
SEE TUBE LAYOUT FOR LOCATION.
- 3) RADIUS ALL CORNERS ON BAFFLE CUTS.
- * 4) CHECK SHELL I.D. BEFORE MACHINING BAFFLE O.D.
- 5) MACHINE O.D. OF BAFFLES TO 250 AARH.

					CUSTOMER: DOW CHEMICAL COMPANY			
					OHMSTEDE JOB NO.: 938268			
					P.O. NO.: 63309586			
					ITEM NO.: E-565S			
					SERVICE : CONDENSER			
					VIN:			
					BAFFLE DETAILS			
Ø	RELEASE FOR FAB	TN	BH	10-7-99	OHMSTEDE	DRAWING NO. 938268	SHEET NO. 9	REV. Ø
NO.	REVISIONS	BY	CHK.	DATE CHK.				



SUPPORT LUG DETAILS

(4) REQUIRED

NOTE:

ALL WELDS 1/2" C.F.W. EXCEPT AS NOTED.
ALL MATERIAL: SA-516-70

					CUSTOMER: DOW CHEMICAL COMPANY			
					OHMSTEDE JOB NO.: 938268			
					P.O. NO.: 63309586			
					ITEM NO.: E-565S			
					SERVICE : CONDENSER			
					VIN:			
					SUPPORT DETAILS			
0	RELEASE FOR FAB	TN	BH	10-7-99	OHMSTEDE	DRAWING NO.	SHEET NO.	REV.
NO.	REVISIONS	BY	CHK.	DATE CHK.		938268	10	0

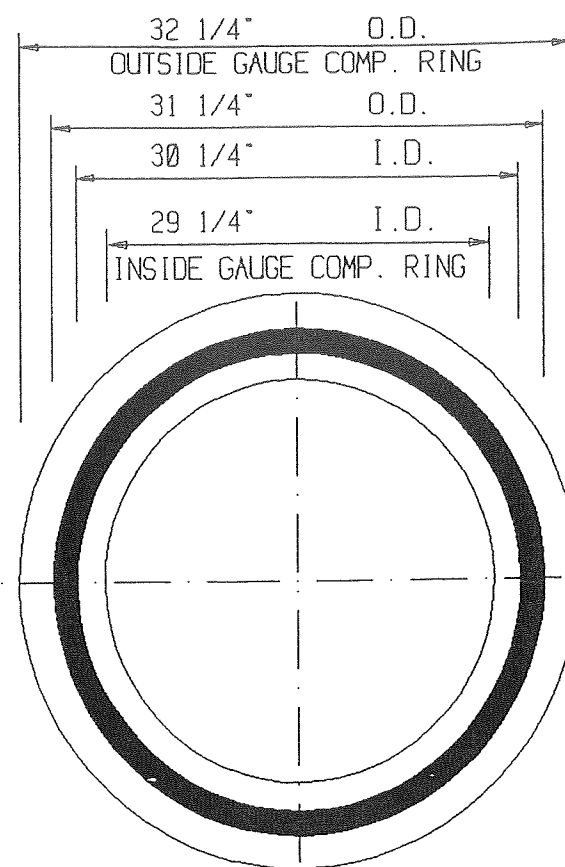
40 NOZZLE GASKETS:

NOZ."E" .175" THK. T-316 SS
SPIRAL WOUND FLEXITALLIC STYLE "CGI"
W/FLEXIBLE GRAPHITE FILLER
& T-316 SS INNER & OUTER COMP. RINGS
(FOR 2"-150#) ONE(1) REQ'D.

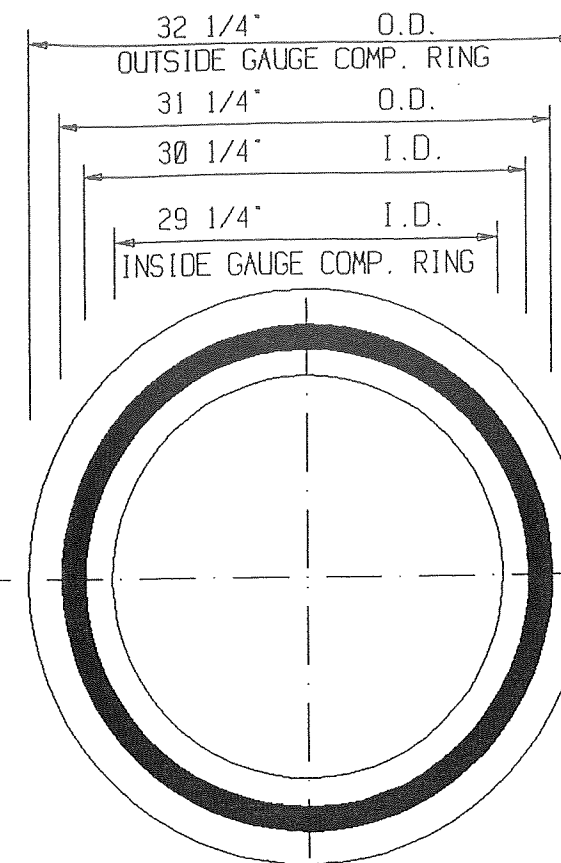
NOZ."F" .175" THK. T-316 SS
SPIRAL WOUND FLEXITALLIC STYLE "CGI"
W/FLEXIBLE GRAPHITE FILLER
& T-316 SS INNER & OUTER COMP. RINGS
(FOR 3/4"-150#) ONE(1) REQ'D.

NOZ."C" .175" THK. T-316 SS
SPIRAL WOUND FLEXITALLIC STYLE "CGI"
W/FLEXIBLE GRAPHITE FILLER
& T-316 SS INNER & OUTER COMP. RINGS
(FOR 3"-150#) ONE(1) REQ'D.

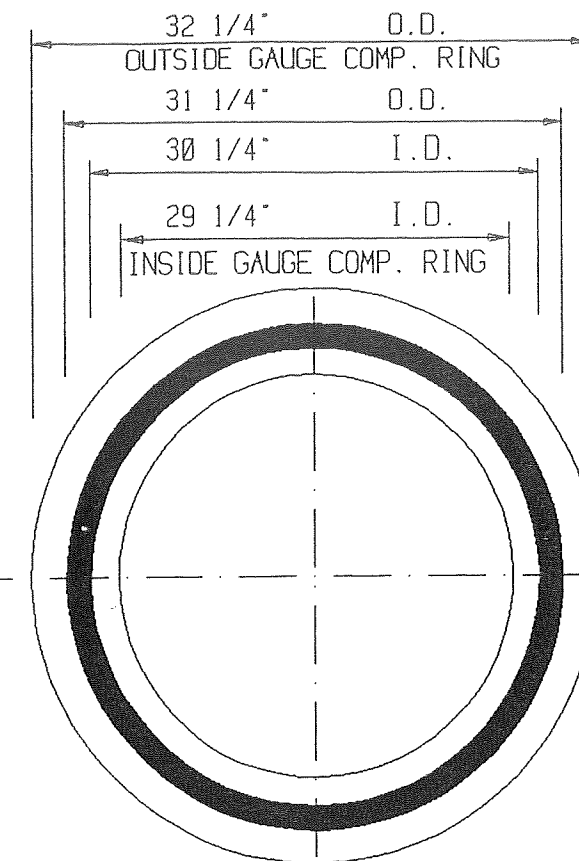
NOZ."G" .175" THK. T-316 SS
SPIRAL WOUND FLEXITALLIC STYLE "CGI"
W/FLEXIBLE GRAPHITE FILLER
& T-316 SS INNER & OUTER COMP. RINGS
(FOR 10"-150#) ONE(1) REQ'D.



40 (1)-REQUIRED
FRONT CHANNEL COVER GASKET
.175" THK. T-316 S.S. SPIRAL WOUND
FLEXITALLIC STYLE "CGI" W/FLEXIBLE
GRAPHITE FILLER & 1/8" THK. T316" INNER
& OUTER COMPRESSION RINGS.



40 (1)-REQUIRED
FRONT CHANNEL GASKET
.175" THK. T-316 S.S. SPIRAL WOUND
FLEXITALLIC STYLE "CGI" W/FLEXIBLE
GRAPHITE FILLER & 1/8" THK. T316" INNER
& OUTER COMPRESSION RINGS.

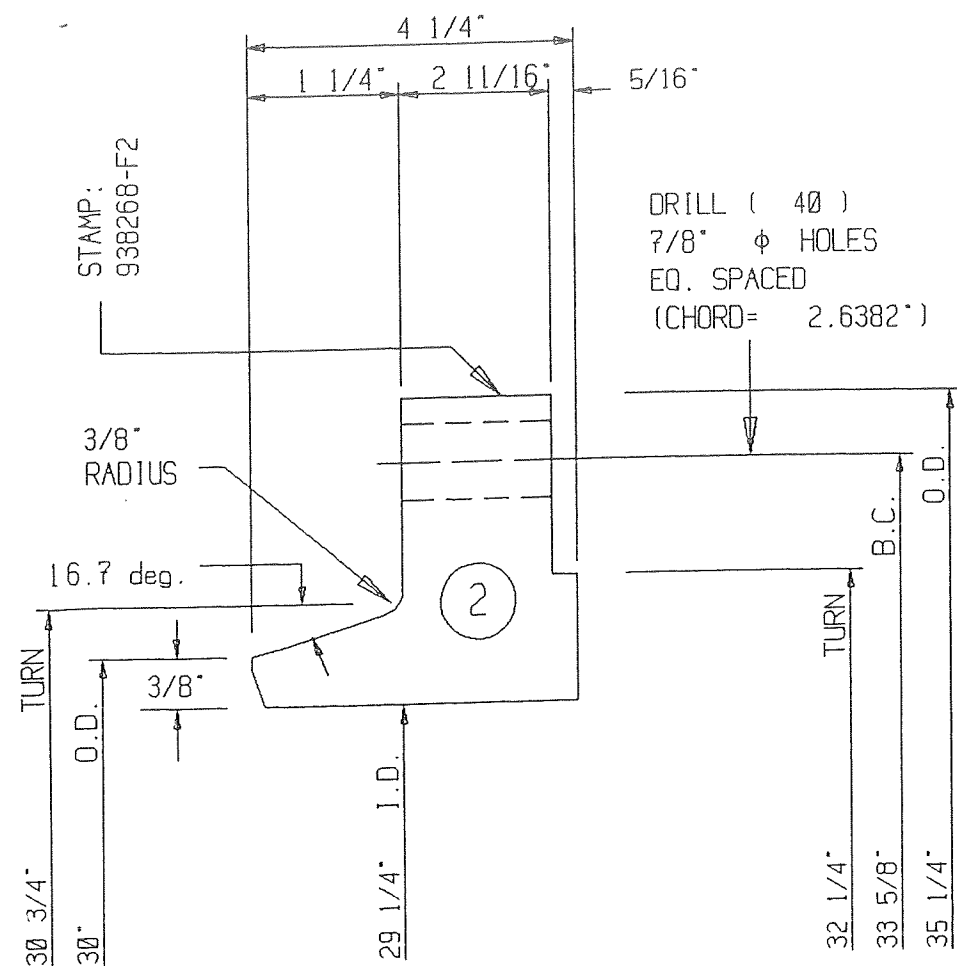


40 (1)-REQUIRED
REAR CHANNEL GASKET
.175" THK. T-316 S.S. SPIRAL WOUND
FLEXITALLIC STYLE "CGI" W/FLEXIBLE
GRAPHITE FILLER & 1/8" THK. T316" INNER
& OUTER COMPRESSION RINGS.

NOTES:

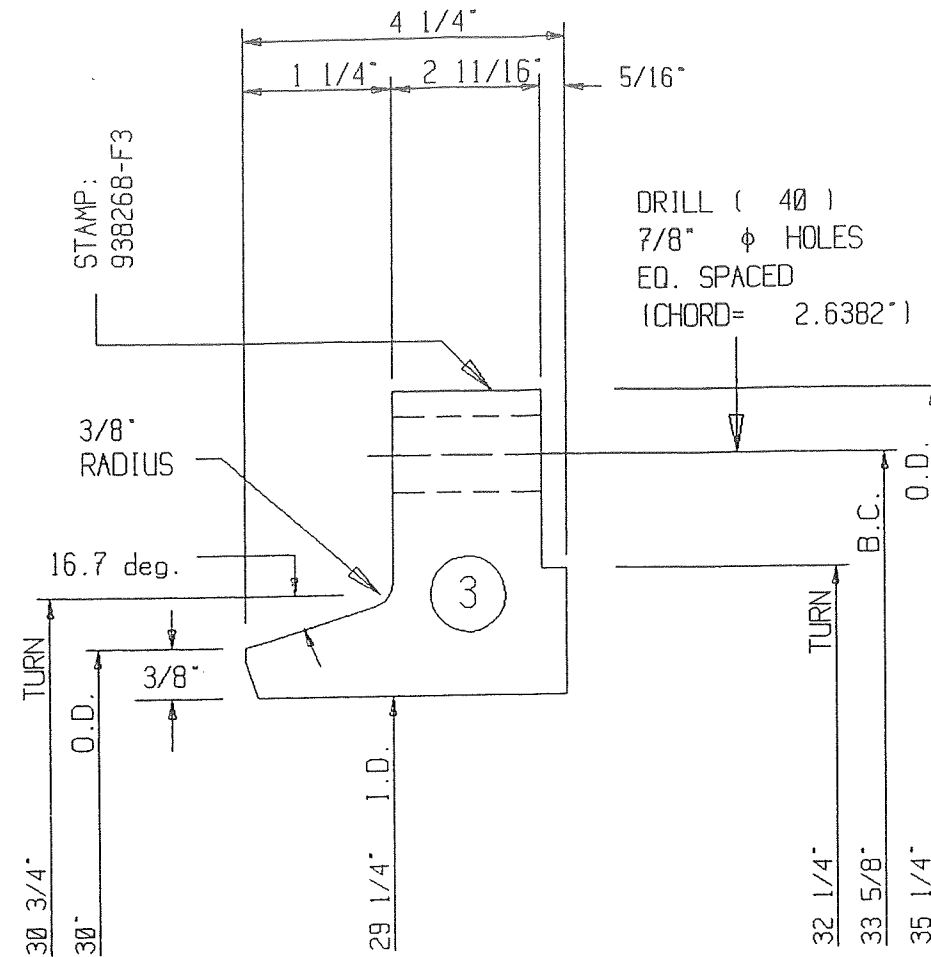
- 1) QUANTITIES SHOWN FOR ONE SET
(2)-SET(S) REQUIRED TOTAL.
- 2) ONE SET TO BE USED IN EXCHANGER AND
ONE SET TO BE BOXED, MARKED W' P.O.
NO. & ITEM NO. AND SHIPPED WITH UNIT.

					CUSTOMER: DOW CHEMICAL COMPANY			
					OHMSTEDE JOB NO.: 938268			
					P.O. NO.: 63309586			
					ITEM NO.: E-565S			
					SERVICE : CONDENSER			
					VIN:			
					GASKET DETAILS			
Ø	RELEASE FOR FAB	TN	BH	10-7-99	OHMSTEDE	DRAWING NO. 938268	SHEET NO. 12	REV. Ø
NO.	REVISIONS	BY	CHK.	DATE CHK.				



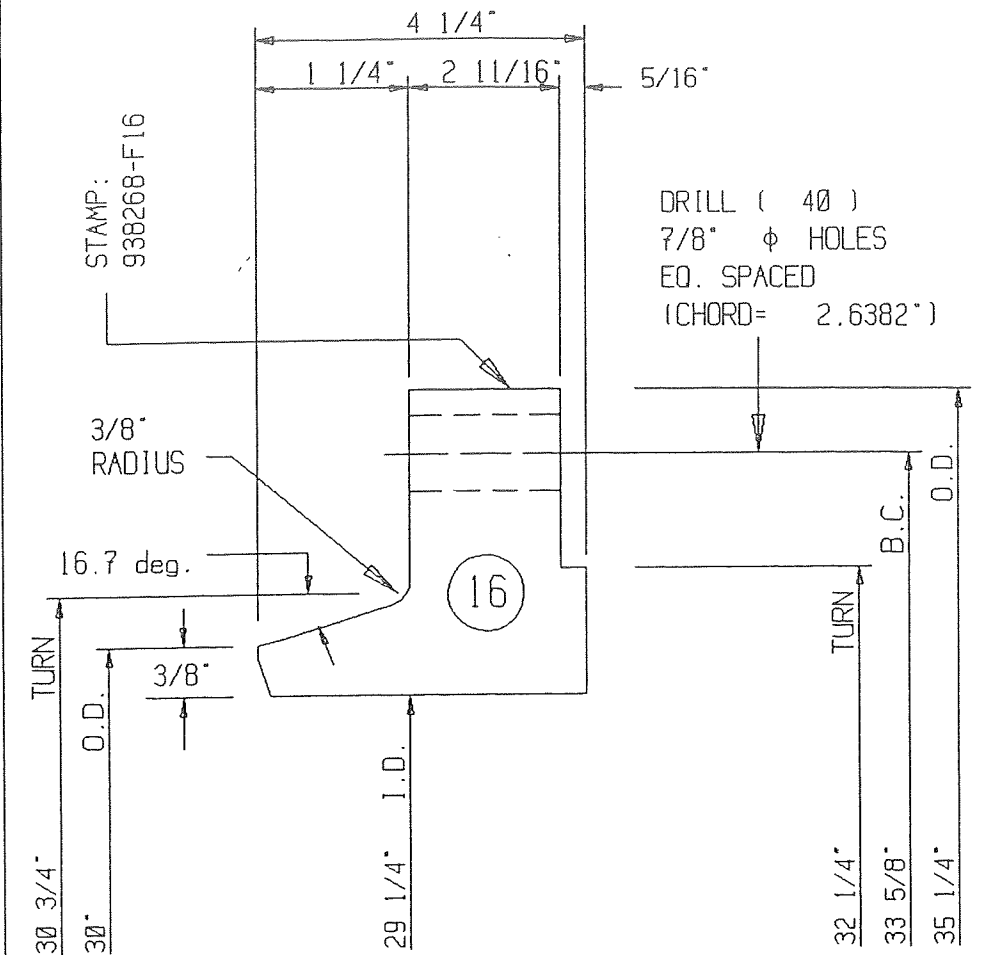
SA-336F316L

2 GIRTH FLANGE (ONE) REQ'D.



SA-336F316L

3 GIRTH FLANGE (ONE) REQ'D.



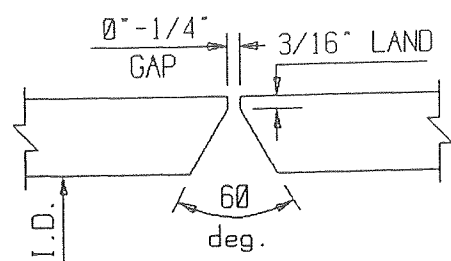
SA-336F316L

16 GIRTH FLANGE (ONE) REQ'D.

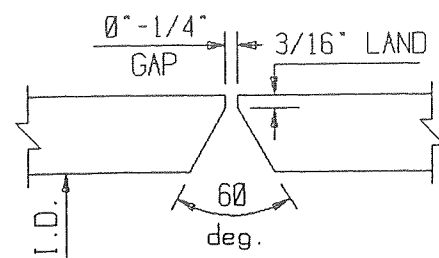
NOTES:

- 1) MACHINE ALL GASKET SURFACES TO 125-250 AARH W/ SERRATED FINISH OF 40 - 55 GROOVES PER INCH.
- 2) ALL BOLT HOLES TO STRADDLE NATURAL CENTER LINES.

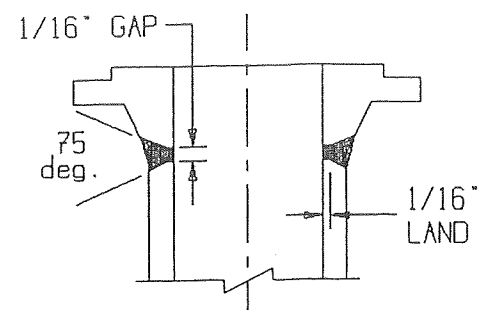
					CUSTOMER: DOW CHEMICAL COMPANY			
					OHMSTEDE JOB NO.: 938268			
					P.O. NO.: 63309586			
					ITEM NO.: E-565S			
					SERVICE: CONDENSER			
					VIN:			
					GIRTH FLANGE DETAILS			
Ø	RELEASE FOR FAB	TN	BH	10-7-99	OHMSTEDE	DRAWING NO.	SHEET NO.	REV.
NO.	REVISIONS	BY	CHK.	DATE CHK.		938268	13	Ø



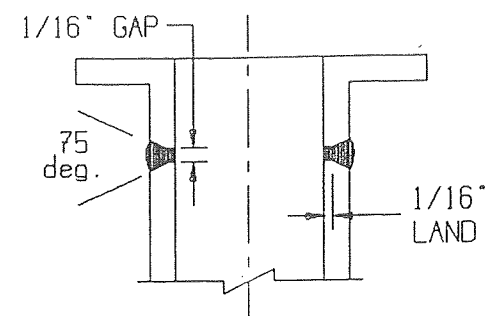
SHELL LONG. & GIRTH SEAMS



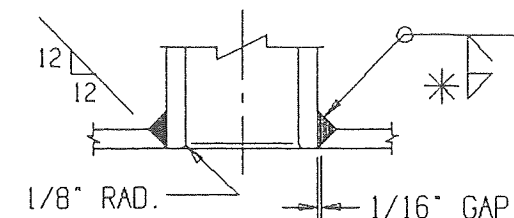
REAR CHAN LONG. & GIRTH SEAMS



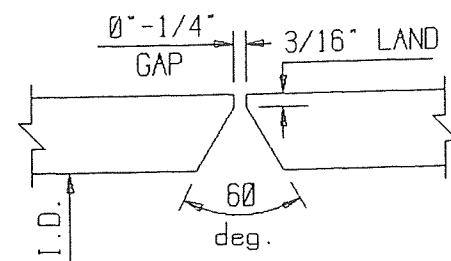
WELD-NECK FLANGE



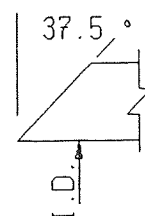
LAP JOINT STUB END TO PIPE



NOZZLE W/OUT PAD



FRONT CHAN LONG. & GIRTH SEAMS



SHELL BOTH ENDS TO TUBESHEETS

GENERAL NOTES

- 1) ALL WELDING TO BE IN ACCORDANCE W/ASME CODE (SECTION IX)
- * 2) ALL FILLET WELDS TO BE 3/8" UNLESS NOTED OTHERWISE.

					CUSTOMER: DOW CHEMICAL COMPANY			
					OHMSTEDE JOB NO.: 938268			
					P.O. NO.: 63309586			
					ITEM NO.: E-565S			
					SERVICE : CONDENSER			
					VIN:			
					WELD AND BEVEL DETAILS			
Ø	RELEASE FOR FAB	TN	BH	10-7-99	OHMSTEDE	DRAWING NO. 938268	SHEET NO. 14	REV. Ø
NO.	REVISIONS	BY	CHK.	DATE CHK.				

GENERAL NOTES

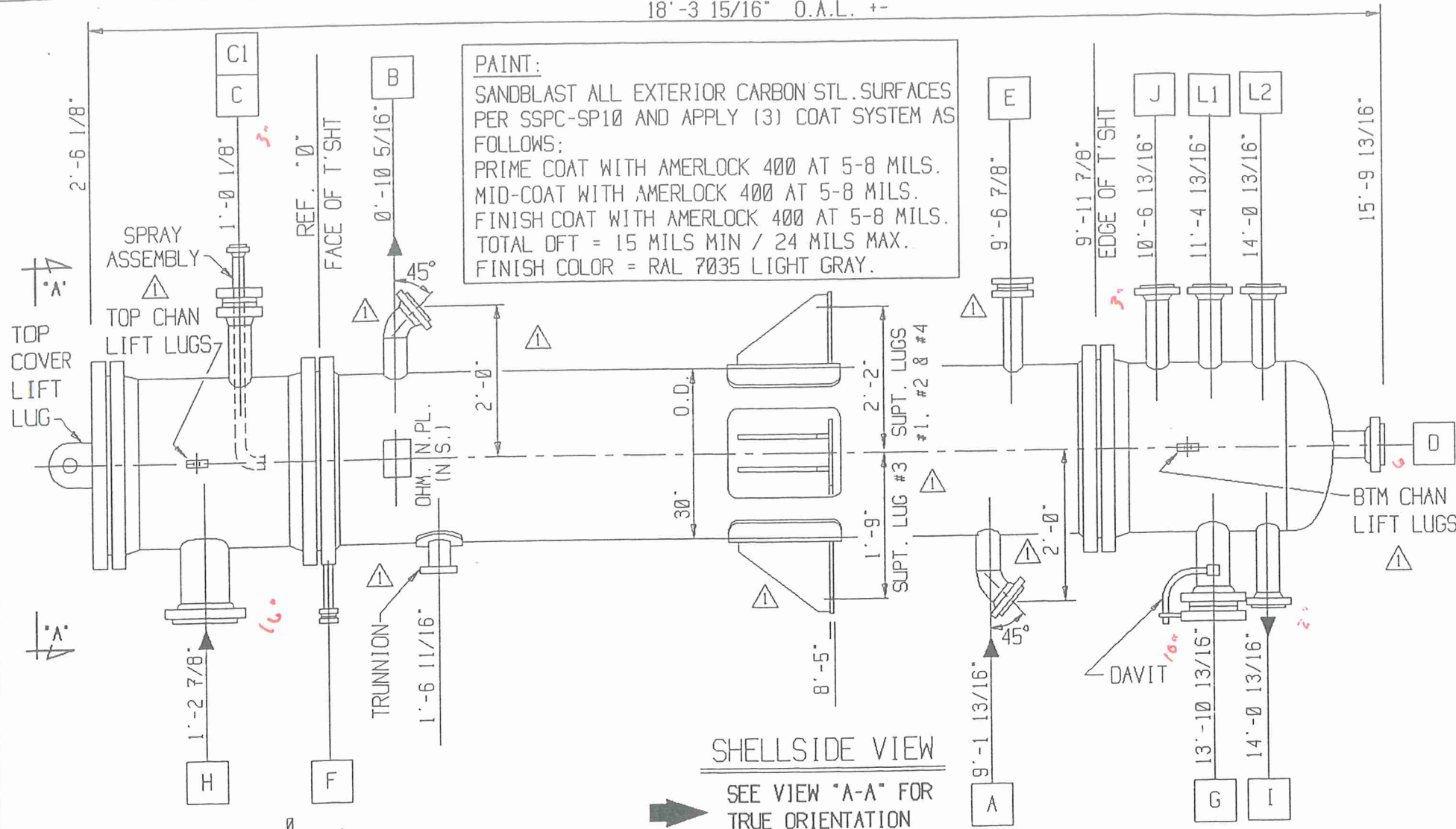
- 1. ALL BOLT HOLES SHALL STRADDLE NORMAL CENTERLINES EXCEPT AS NOTED.
- 2. ALL EXTERNAL BOLTING SHALL BE COATED FULL LENGTH WITH A METALLIC BASE WATERPROOF LUBRICANT SUCH AS MOLYKOTE P37.
- 3. ALL MACHINED SURFACES AND THREADED CONNECTIONS SHALL BE COATED WITH A READILY REMOVABLE RUST PREVENTATIVE.
- 4. THE INSIDE AND OUTSIDE OF THE EXCHANGER SHALL BE CLEAN AND FREE OF ALL SLAG, LOOSE SCALE, DIRT, GRIT, WELD SPLATTER, PIECES OF METAL, PAINT, OIL, AND OTHER FOREIGN MATTER BEFORE HYDROTESTING AND PAINTING. THE EXCHANGER SHALL BE THOROUGHLY DRIED INSIDE AND OUTSIDE AFTER HYDROTEST. SURFACE PREPARATION AND PAINTING MATERIALS SHALL BE KEPT OUT OF THE EXCHANGER.
- 5. ALL THREADED CONNECTIONS SHALL BE PLUGGED TO PREVENT DAMAGE. ALL FLANGED OPENINGS SHALL BE PROVIDED WITH SNAP-ON PLASTIC SHIPPING COVERS.
- 6. SUPPORT, TRUNNION AND GUIDE PADS SHALL BE TESTED WITH AIR OND BUBBLES AT 10 TO 15 PSIG. AFTER TESTING PADS, TEST HOLES SHALL BE PLUGGED WITH SILICONE GREASE FOR SHIPMENT. BUBBLE TESTING SHALL EMPLOY ONLY SOLUTIONS SPECIFICALLY MANUFACTURED FOR BUBBLE TESTING. SOAP OR DETERGENTS SHALL NOT BE USED.
- 7. THE EXCHANGER ITEM NO. AND THE OHMSTEDE SERIAL NO. SHALL BE DIE-STAMPED ON THE PERIPHERAL EDGE OF EACH BODY FLANGE AND TUBESHEET. THE EXCHANGER ITEM NO., THE PURCHASE ORDER NO., AND THE EXCHANGER SHIPPING WEIGHT SHALL BE STENCILED ON OPPOSITE SIDES OF THE SHELL AND EACH REMOVABLE SECTION IN A CONSPICUOUS LOCATION, IN LETTERS AT LEAST 3" HIGH.
- 8. ALL MATING BODY FLANGES AND TUBESHEETS SHALL BE MATCH MARKED FOR PERMANENT ASSEMBLY REFERENCE.
- 9. ALLOY SURFACES SHALL BE PROTECTED FROM COATINGS CONTAINING LEAD, ZINC OR SULPHUR.
- 10. TEST WATER SHALL NOT EXCEED 72 HOURS IN THE UNIT FROM START OF FILL TO DRAINING.
- 11. TEST WATER SHALL NOT EXCEED A CHLORIDE CONTENT OF 20 PPM. FURNISH CERTIFICATION AND LAB REPORT OF THE TEST WATER PRIOR TO THE TEST.

- 12. HYDROTEST PRESSURE SHALL BE HELD FOR A PERIOD OF FOUR HOURS. MINIMUM WATER TEMPERATURE FOR HYDROTEST SHALL BE 50 DEG. F. & MAX. 100 DEG. F. THE SHELL SIDE AND THE TUBE SIDE ARE TO BE HYDROTESTED SEPARATELY IN SUCH A MANNER THAT LEAKS AT THE TUBE JOINTS CAN BE DETECTED FROM AT LEAST ONE SIDE. USE POTABLE WATER FOR HYDROTEST. (SEE NOTE #11)
- 13. TEMPORARY ATTACHMENTS SUCH AS LUGS OR BRACES SHALL BE THE SAME MATERIAL AS THE PART TO WHICH THEY ARE WELDED.
- 14. HEATING OF NOZZLE NECKS TO ROTATE FLANGES IN ANY DIRECTION IS PROHIBITED.
- 15. BOLT HOLES IN STRUCTURAL MEMBERS SHALL BE DRILLED OR PUNCHED.
- 16. ANY WELDED ATTACHMENT SHALL BE SEAL WELDED ON ALL JOINTS WITH A 3/16" MINIMUM WELD FOR CARBON STEEL AND 1/8" MINIMUM WELD FOR ALLOYS.

					CUSTOMER: DOW CHEMICAL COMPANY			
					OHMSTEDE JOB NO.: 938268			
					P.O. NO.: 63309586			
					ITEM NO.: E-565S			
					SERVICE : CONDENSER			
					VIN:			
					GENERAL NOTES			
0	RELEASE FOR FAB	TN	BH	10-7-99	OHMSTEDE	DRAWING NO.	SHEET NO.	REV.
NO.	REVISIONS	BY	CHK.	DATE CHK.		938268	15	0

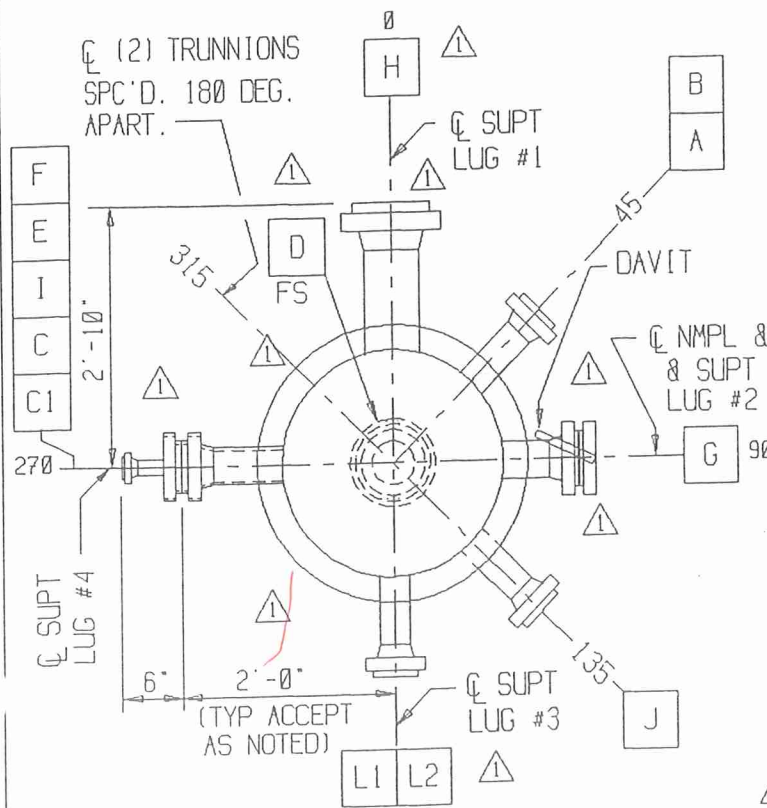
18'-3 15/16" O.A.L. +-
 2'-6 1/8"

PAINT:
 SANDBLAST ALL EXTERIOR CARBON STL. SURFACES
 PER SSPC-SP10 AND APPLY (3) COAT SYSTEM AS
 FOLLOWS:
 PRIME COAT WITH AMERLOCK 400 AT 5-8 MILS.
 MID-COAT WITH AMERLOCK 400 AT 5-8 MILS.
 FINISH COAT WITH AMERLOCK 400 AT 5-8 MILS.
 TOTAL DFT = 15 MILS MIN / 24 MILS MAX.
 FINISH COLOR = RAL 7035 LIGHT GRAY.



SHELLSIDE VIEW

SEE VIEW "A-A" FOR
 TRUE ORIENTATION



VIEW A-A

TRUE ORIENTATION

I	2"	150#RF WN	OUT
C1	3/4"	150#RF WN	SPRAY
D	6"	150#RF LJ	DRAIN
L2	3"	150#RF WN	LEVEL
L1	3"	150#RF WN	LEVEL
J	3"	150#RF WN	VAPOR OUT
G	10"	150#RF LJ W/ BLIND	SPARE
C	3"	150#RF WN W/ BLIND	SPRAY
H	16"	150#RF LJ	INLET
F	3/4"	150# RF LWN W/ BLIND	VENT
E	2"	150#RF LWN W/ BLIND	DRAIN
B	4"	150#RF WN	OUTLET
A	4"	150#RF WN	INLET
MK	SIZE-RATE	SERVICE	NO.

OHMSTEDE - LAKE CHARLES PLANT
 CERTIFIED "AS BUILT" DRAWING

Signed: *Kristina R. Kelly* Date: 12/20/99

SUPPORTS:

(1) 1 5/16" X 1 9/16" LG.
 SLOT EACH SUPPORT.

CERTIFIED BH

DATE 10/20/99

DESIGN DATA

DESIGN DATA	SHELL	TUBE
DESIGN PRESSURE P.S.I.G.	100	50
TEST PRESSURE P.S.I.G. (SHOP / FIELD)	428/368	131/87
DESIGN TEMPERATURE DEG. F. (MAX./MIN.)	250/ 14	400/ 32
CORROSION ALLOWANCE	.0625"	.0300"
NUMBER OF PASSES	1	1
RADIOGRAPHIC EXAMINATION	SPOT	SPOT
HEAT TREAT REQUIRED	NO	NO

ESTIMATED WEIGHTS, LBS.

DRY:	7600	BUNDLE:	3800	WET:	12600
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SPECIFICATIONS

ASME CODE SECT. VIII, DIV.1, 1998 ED. & ADD. (STAMP YES)

TEMA CLASS B

NATIONAL BOARD REGISTRATION REQUIRED

CUSTOMER SPECIFICATIONS: G9S-1000-01, G8S-4001-50, G8S-4001-60,
 G8S-4001-53, G9G-3005-04, G16S-0204-01, G9S-3000-01, G9S-1000-02,
 G16S-0201-01, G16S-0202-01, G9G-3000-02, G9G-5545-01

MATERIAL

CHANNEL:	SA-240-304L
SHELL:	SA-516-70
TUBESHEETS:	SA-240-304L
BAFFLES:	SA-36
TUBES:	SA-249TP304L
(428) 1" O.D.X .065" (AW)	X 10'-0" LG.
TUBE PITCH 1 1/4" Δ	SURFACE 1083 SQ.FT.

GENERAL NOTES

ALL BOLT HOLES TO STRADDLE NATURAL CENTER LINES.

TUBES ROLL ONLY.

BODY FLANGE GASKETS: .1750" THK. SPIRAL WND/FLXCB

MAXIMUM ALLOWABLE PRESSURES

SHELLSIDE :

MAWP (HOT & CORR.) = 245 PSIG LMTD BY NOZZ RATING
 MAP (NEW & COLD) = 285 PSIG LMTD BY NOZZ RATING
 SHOP HYDRO = 1 1/2 (285) = 428 PSIG
 FIELD HYDRO = 1 1/2 (245) = 368 PSIG

TUBESIDE :

MAWP (HOT & CORR.) = 58/FV PSIG LMTD BY CHANNEL COVER
 MAP (NEW & COLD) = 87 PSIG LMTD BY CHANNEL COVER
 SHOP HYDRO = 1 1/2 (87) = 131 PSIG
 FIELD HYDRO = 1 1/2 (58) = 87 PSIG

PAINT: SEE DETAIL THIS SHEET.

TYPE UNIT : A E M SIZE : 30-120

CUSTOMER: DOW CHEMICAL COMPANY
 OHMSTEDE JOB NO.: 938268
 P.O. NO.: 63309586
 ITEM NO.: E-5655
 SERVICE : CONDENSER
 VIN:

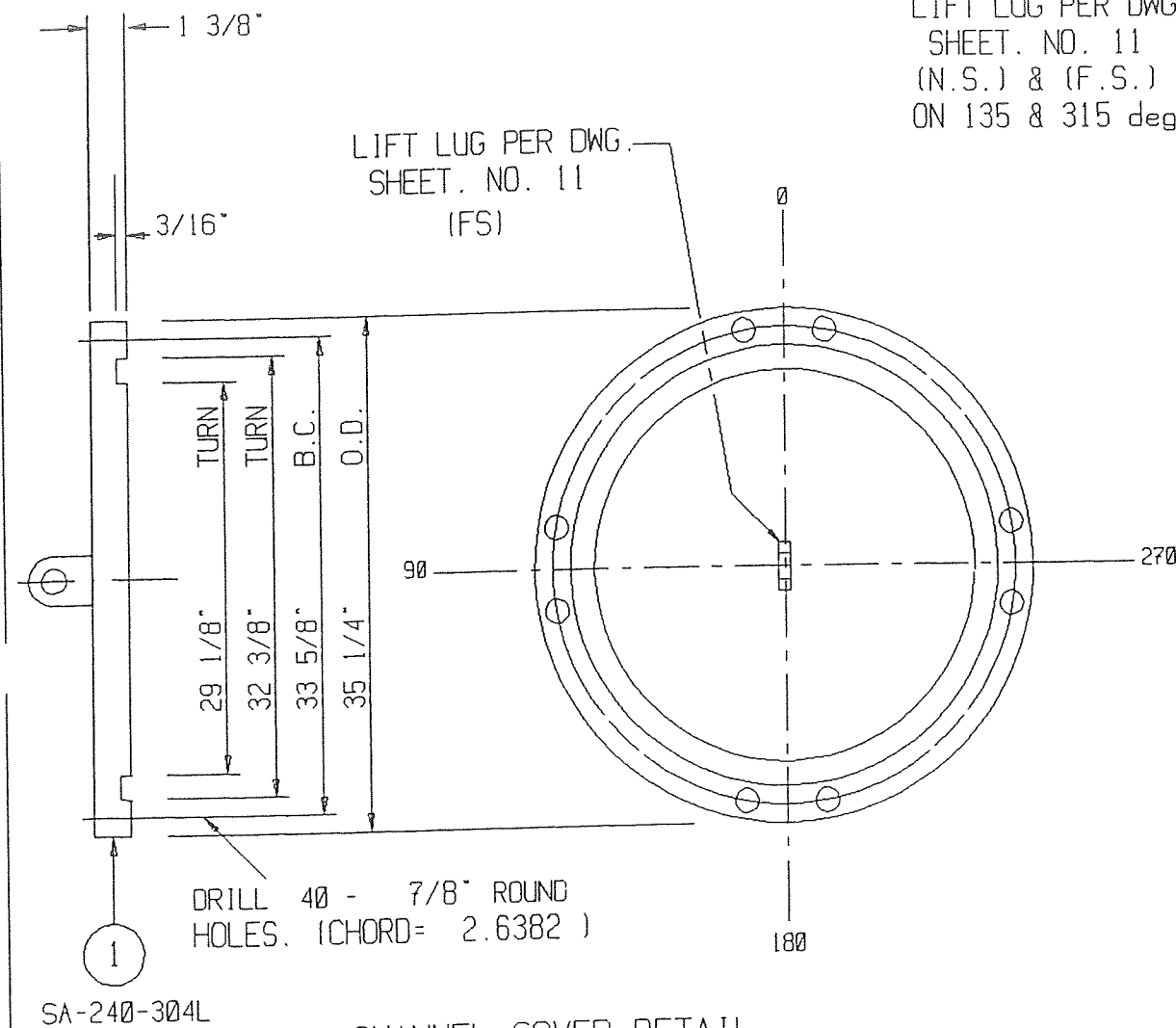
ASSEMBLY AND SPECIFICATIONS

OHMSTEDE

DRAWING NO.	SHEET NO.	REV.
938268	1	1

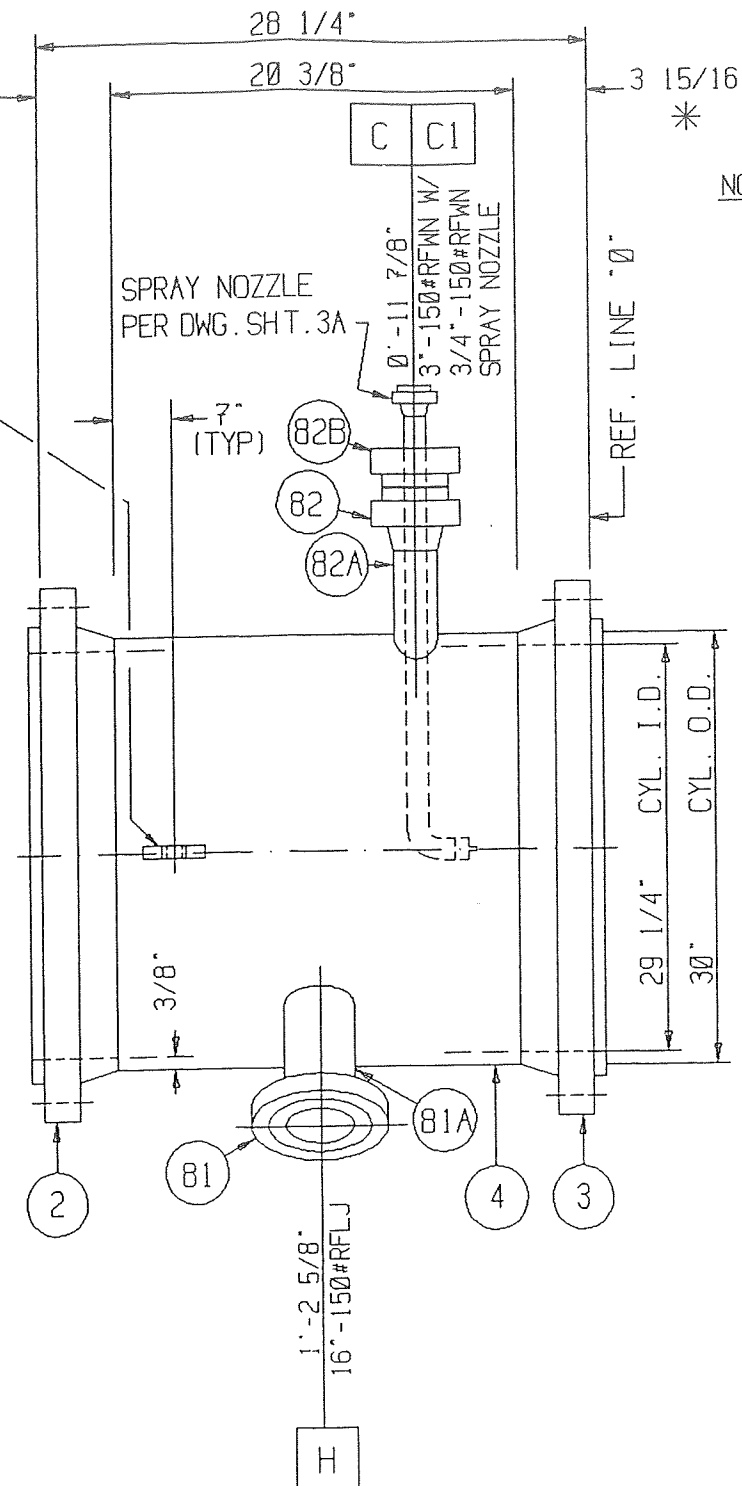
COVER NOTES:

- 1) MACHINE ALL COVER GASKET SURFACES TO 125 AARH - 250 AARH WITH SERATTED FINISH OF 40-55 GROOVES PER INCH.



CHANNEL-COVER DETAIL

LIFT LUG PER DWG. SHEET. NO. 11 (N.S.) & (F.S.) ON 135 & 315 deg

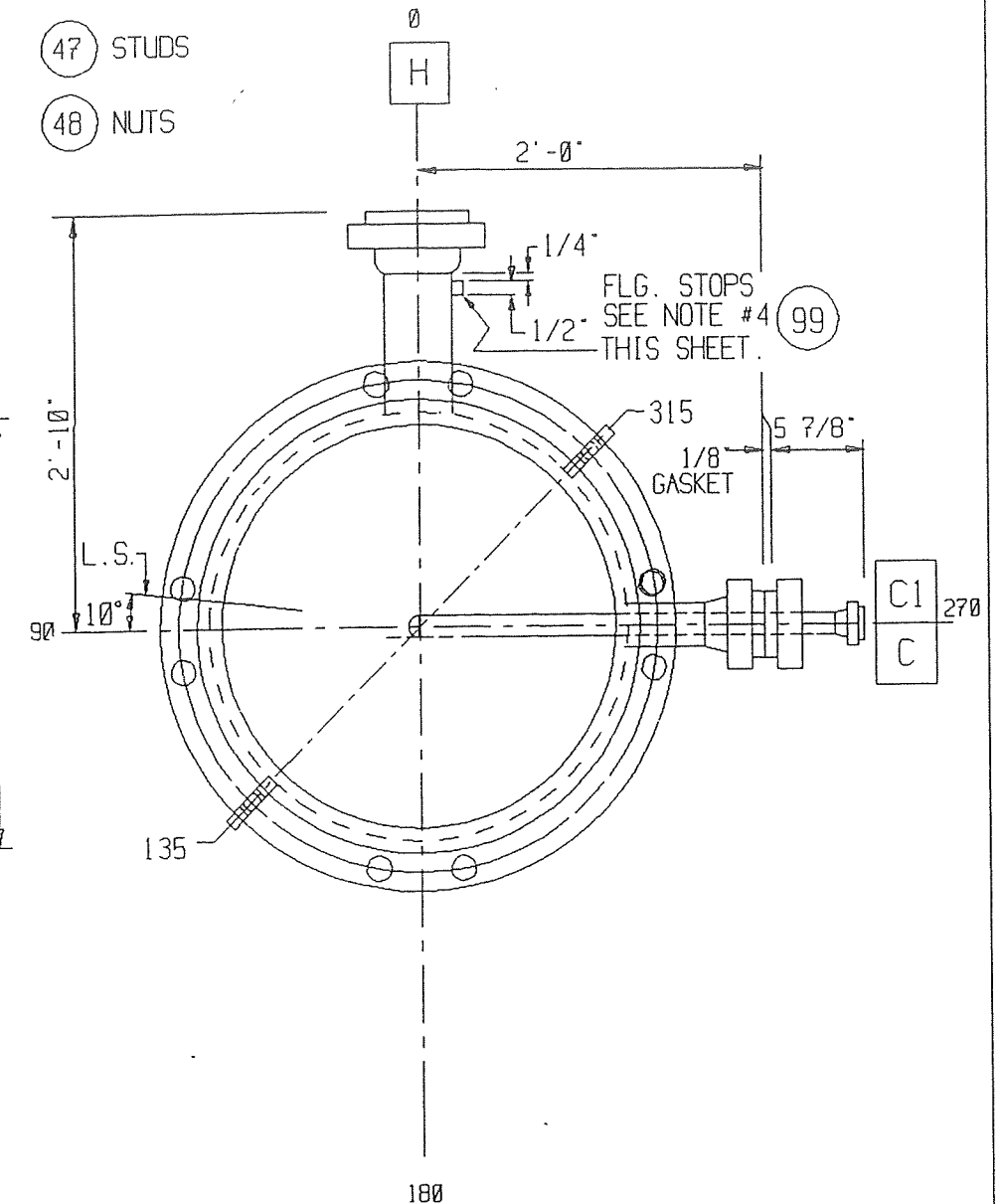


CHANNEL SIDE VIEW
SEE END VIEW FOR TRUE ORIENTATION

* MACHINE GASKET FACING AFTER ALL WELDING.
FOR FLANGE DETAILS SEE DWG. SHEET. NO. 13

NOZ. "C" BOLTING

- 47 STUDS
- 48 NUTS



CHANNEL END VIEW

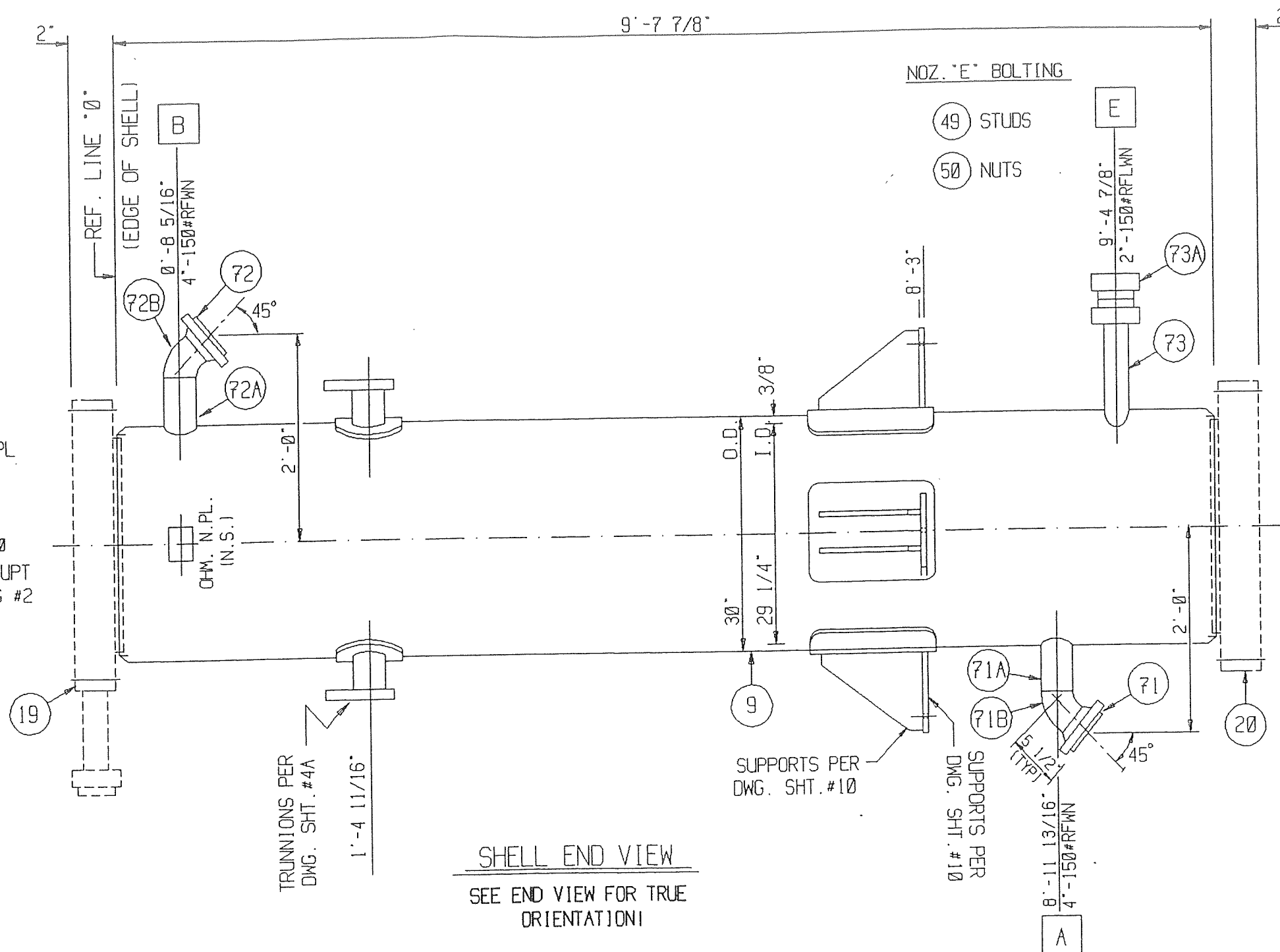
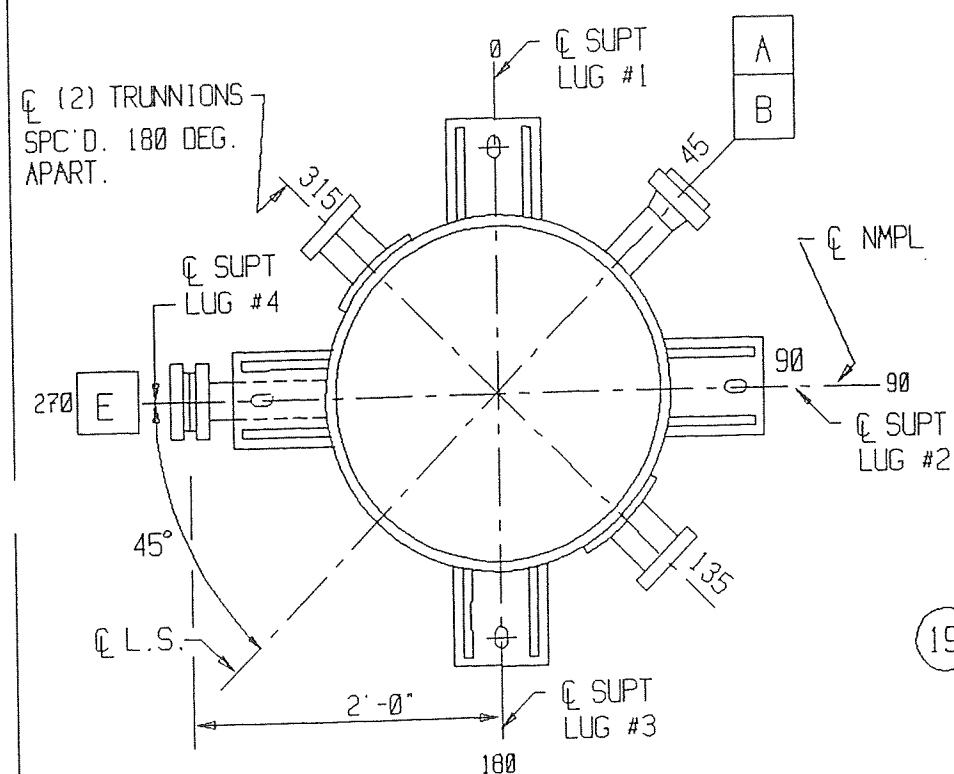
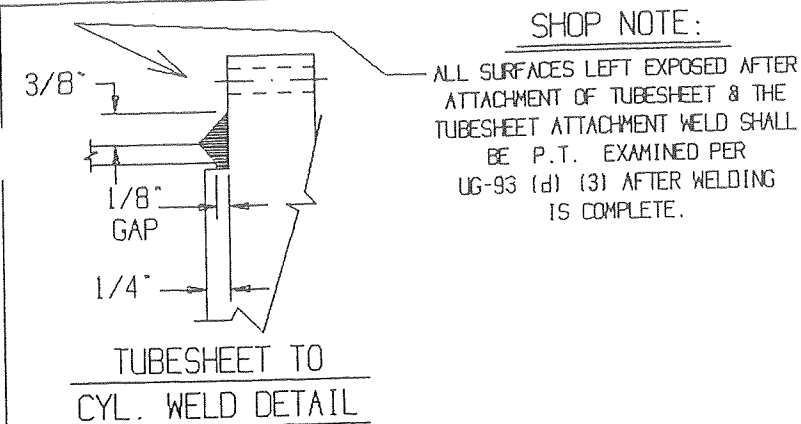
TRUE ORIENTATION

TOP CHANNEL WEIGHT: 1250 LBS.

NOTES:

- 1) ALL BOLT HOLES TO STRADDLE CENTER LINES.
- 2) FOR WELD & BEVEL DETAILS SEE DWG. SHEET. NO. 14
- 3) SPOT RADIOGRAPHY.
- 4) THREE (3) FLANGE STOPS 1/4" THK. X 1/2" X 1/2" TO BE WELDED TO NOZZLE "H" NECK APPROX. EQ. SPACED.

					CUSTOMER: DOW CHEMICAL COMPANY			
					OHMSTEDE JOB NO.: 938268			
					P.O. NO.: 63309586			
					ITEM NO.: E-565S			
					SERVICE : CONDENSER			
					VIN:			
					TOP CHANNEL DETAILS			
0	RELEASE FOR FAB	TN	BH	10-7-99	OHMSTEDE	DRAWING NO. 938268	SHEET NO. 3	REV. 0
NO.	REVISIONS	BY	CHK.	DATE CHK.				



NOTES:

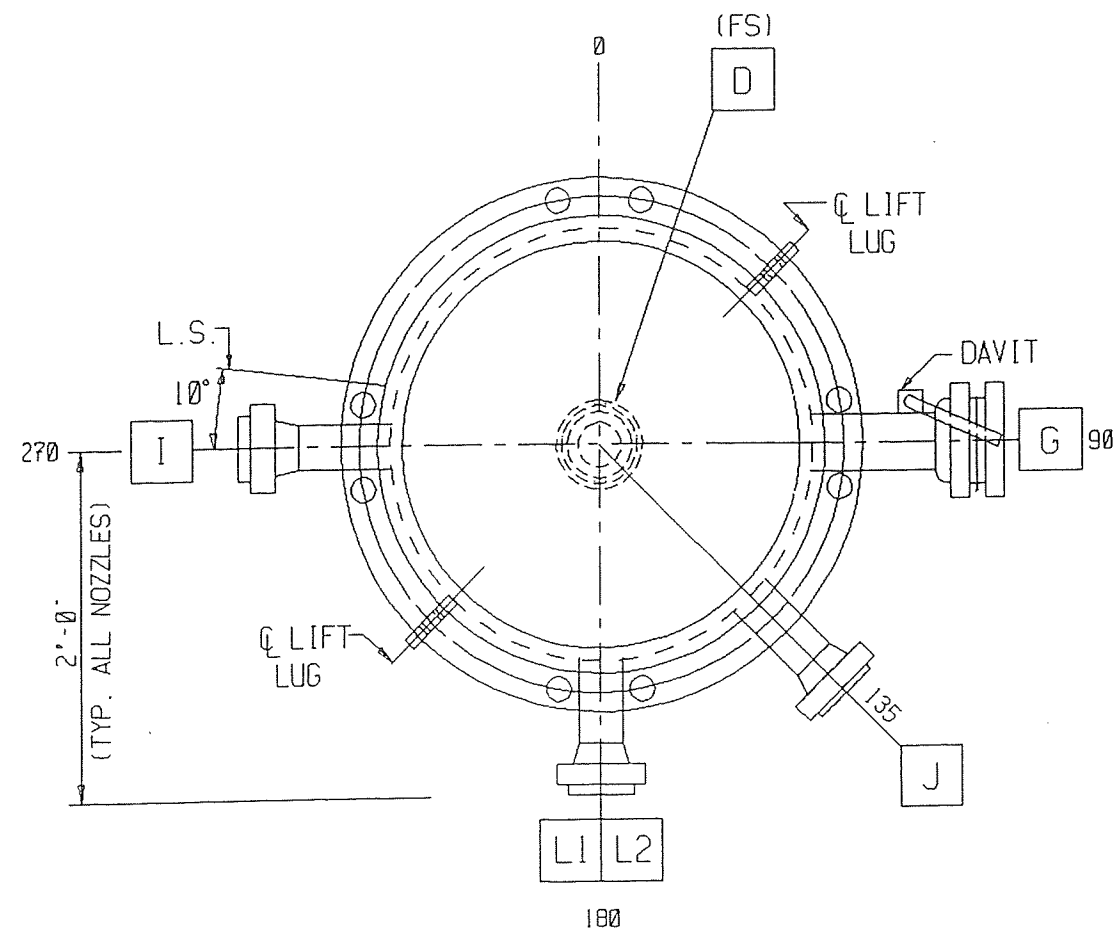
- 1) ALL BOLT HOLES TO STRADDLE CENTER LINES.
- 2) FOR WELD & BEVEL DETAILS SEE DWG. SHEET NO. 14
- 3) GRIND ALL INSIDE WELDS FLUSH.
- 4) SPOT RADIOGRAPHY.

SHELL WEIGHT: 1275 LBS.

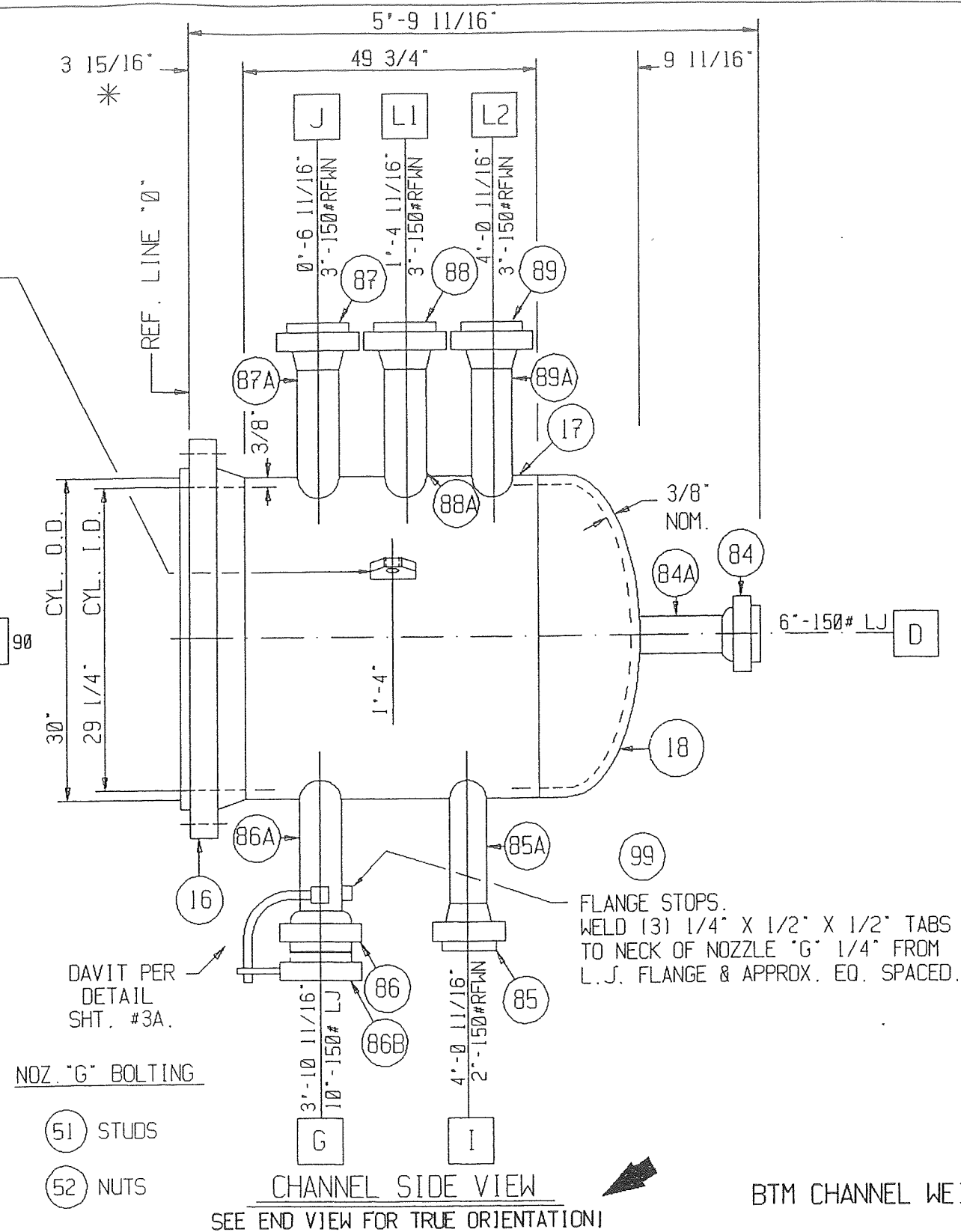
					CUSTOMER: DOW CHEMICAL COMPANY			
					OHMSTEDE JOB NO.: 938268			
					P.O. NO.: 63309586			
					ITEM NO.: E-565S			
					SERVICE: CONDENSER			
					VIN:			
					SHELL DETAILS			
Ø	RELEASE FOR FAB	TN	BH	10-7-99	OHMSTEDE	DRAWING NO. 938268	SHEET NO. 4	REV. Ø
NO.	REVISIONS	BY	CHK.	DATE CHK.				

* { MACHINE GASKET FACING AFTER ALL
WELDING.
FOR FLANGE DETAILS SEE DWG. SHEET. NO. 13

LIFT LUG PER DWG
SHEET. NO. 11
(N.S.) & (F.S.)
ON 30° & 210° deg. -



CHANNEL END VIEW
TRUE ORIENTATION!



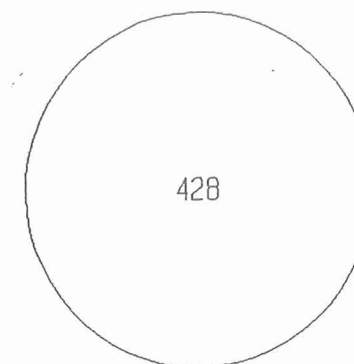
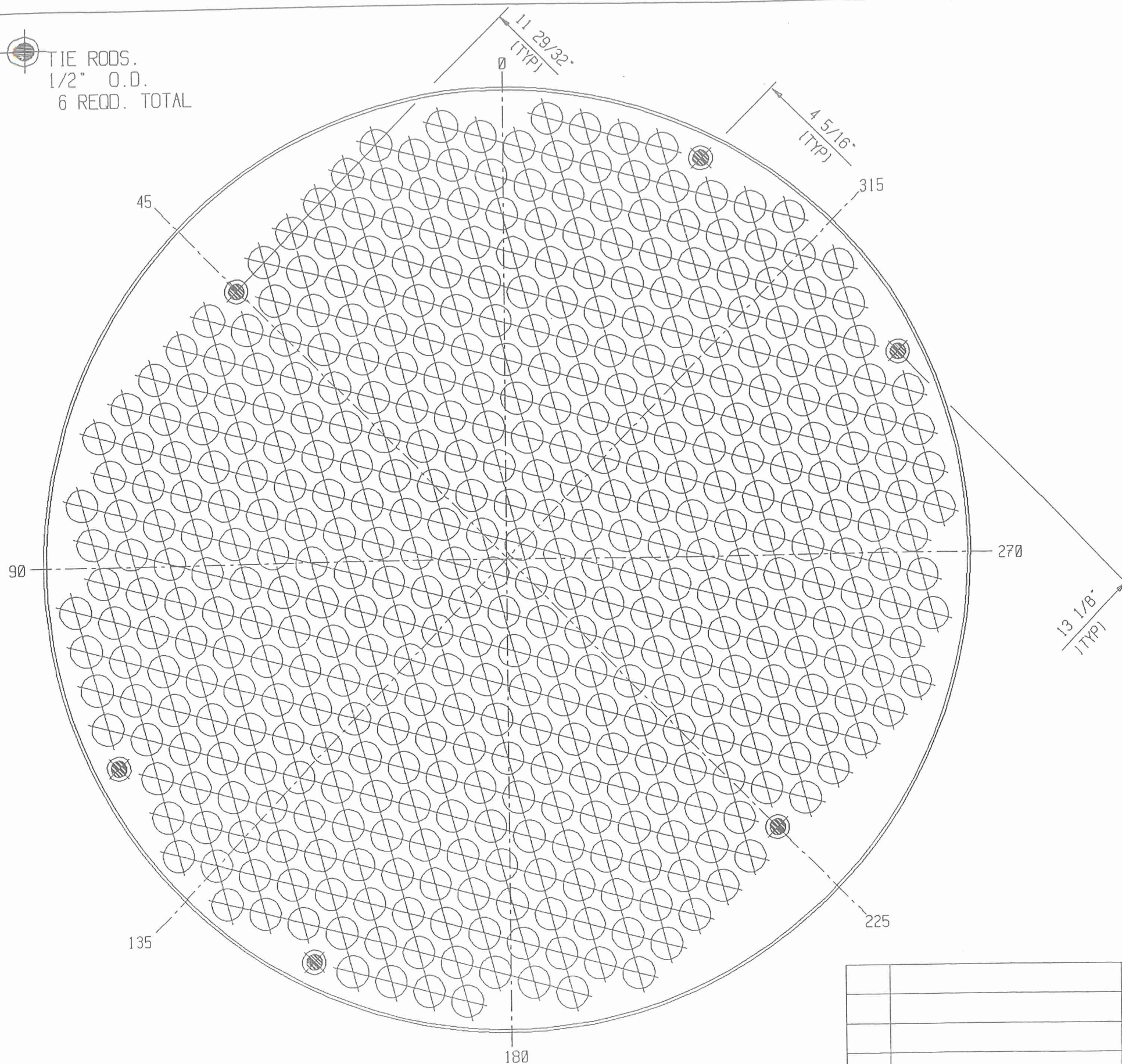
BTM CHANNEL WEIGHT: 1100 LBS.

NOTES:

- NOTES:
- 1) ALL BOLT HOLES TO STRADDLE CENTER LINES.
 - 2) FOR WELD & BEVEL DETAILS SEE DWG. SHEET. NO. 14
 - 3) SPOT RADIOGRAPHY.

					CUSTOMER: DOW CHEMICAL COMPANY				
					OHMSTEDE JOB NO.: 938268				
					P.O. NO.: 63309586				
					ITEM NO.: E-565S				
					SERVICE : CONDENSER				
					VIN:				
					BOTTOM CHANNEL DETAILS				
Ø	RELEASE FOR FAB	TN	BH	10-7-99	OHMSTEDE	DRAWING NO.	SHEET NO.	REV.	
NO.	REVISIONS	BY	CHK.	DATE CHK.		938268	5	Ø	

TIE RODS.
1/2" O.D.
6 REQD. TOTAL



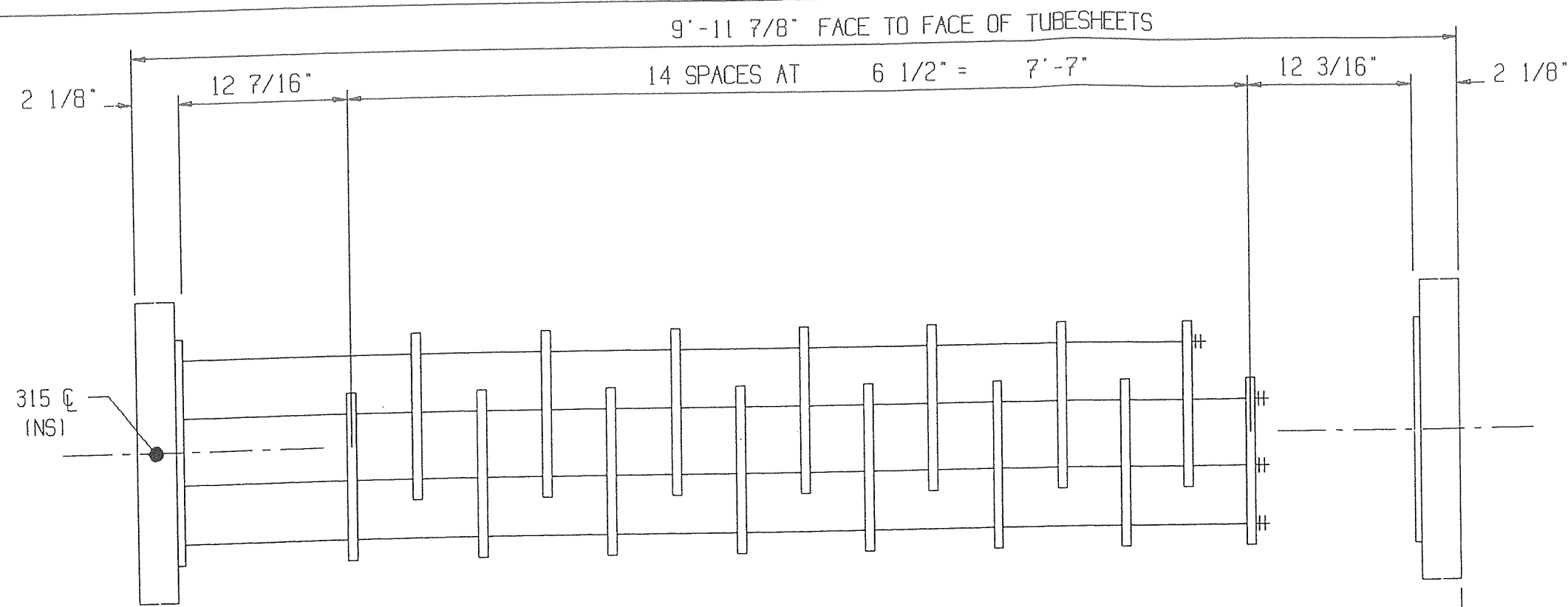
TUBE DISTRIBUTION

NOTES:

- 1) DRILL AND REAM TUBE HOLES IN TUBESHEETS TO 1.0100" $\pm$.002" DIA. FOR 428 - 1" O.D. TUBES.
- 2) TUBE PITCH = 1 1/4" 30° TRIANGLE.
- 3) NUMBER OF PASSES = 1
- 4) SEE DRAWING SHEET NO. 6 FOR TUBE HOLE GROOVING DETAILS.
- 5) BAFFLE O.D. = 29 1/16"
- 6) O.T.L. = 28 5/8"

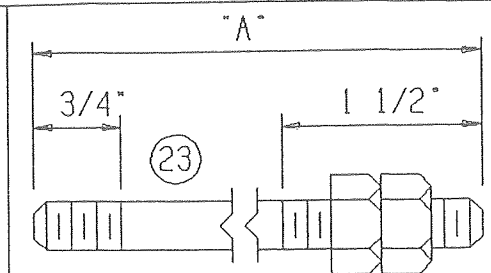
VIEW LOOKING AT SHELL SIDE OF NO. 19 TUBESHEET

					CUSTOMER: DOW CHEMICAL COMPANY			
					OHMSTEDE JOB NO.: 938268			
					P.O. NO.: 63309586			
					ITEM NO.: E-565S			
					SERVICE : CONDENSER			
					VIN:			
					TUBE LAYOUT			
Ø	RELEASE FOR FAB	TN	BH	10-7-99	OHMSTEDE	DRAWING NO. 938268	SHEET NO. 7	REV. Ø
NO.	REVISIONS	BY	CHK.	DATE CHK.				



VIEW "X-X"

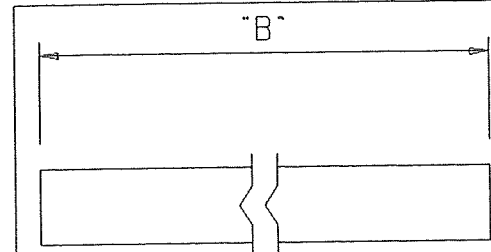
ELEVATION VIEW



MAT'L: C.STL.

1/2" O.D. TIE RODS

REQ'D.	"A"
5	8'-10"
1	8'-3 1/2"



MAT'L: SA-214

3/4" O.D. SPACER TUBING

REQ'D.	"B"
5	12 5/16"
1	18 13/16"
56	6 1/4"
13	12 3/4"

NOTES:

1) SEE DWG. SHEET NO. 9 FOR SECTION AND VIEW DETAILS.

Ø	RELEASE FOR FAB	TN	BH	10-7-99
NO.	REVISIONS	BY	CHK.	DATE CHK.

CUSTOMER: DOW CHEMICAL COMPANY
 OHMSTEDE JOB NO.: 938268
 P.O. NO.: 63309586
 ITEM NO.: E-565S
 SERVICE: CONDENSER
 VIN:

BUNDLE DETAILS

OHMSTEDE

DRAWING NO.	SHEET NO.	REV.
938268	8	Ø

