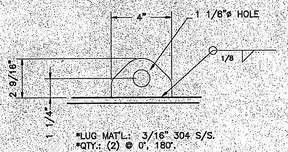
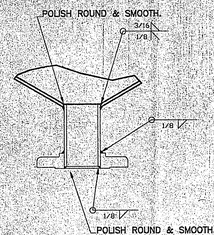


*LUG MAT'L.: 3/16" 304 S/S.
*QTY.: (2) @ 0°, 180°.

DETAIL ~ LIFTING LUGS
SCALE: 3"=1'-0"

DETAIL, "A"
SCALE: 3"=1'-0"



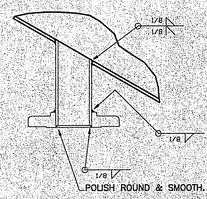
DETAIL~NOZZLE "J"
SCALE: 3"=1'-0"

NOZZLE SCHEDULE

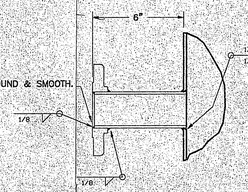
MK	SIZE	No. REQ'D.	RATING	FLANGE & FACING	FLANGE MATERIAL	NECK SCHEDULE	NECK MATERIAL	REPAD MATERIAL	REPAD SIZE	DETAIL DRAWING	ORIENTATION h	ORIENTATION ø	ORIENTATION r	ORIENTATION proj.	ORIENTATION e	SERVICE	REMARKS
A	18"	1	N/A	FLAT FACE	3/4" 316L S/S	N/A	N/A	---	---	529-01-19	TOP	270°	1'-2"	---	---	MANWAY	SEE NOZZLE NOTE 1.
B	2"	1	150#	RFSO	316L S/S	40	316L S/S	---	---	529-01-19	TOP	180°	1'-6"	4"	---	MISC.	
C	2"	1	150#	RFSO	316L S/S	40	316L S/S	---	---	529-01-19	TOP	135°	1'-6"	4"	---	MISC.	
D	3"	1	150#	RFSO	316L S/S	40	316L S/S	---	---	529-01-19	TOP	90°	1'-6"	4"	---	VENT	
E	2"	1	150#	RFSO	316L S/S	40	316L S/S	---	---	529-01-19	TOP	45°	1'-6"	4"	---	MISC.	
F	2"	1	150#	RFSO	316L S/S	40	316L S/S	---	---	529-01-19	TOP	0°	1'-6"	4"	---	MISC.	
G	2"	1	150#	RFSO	316L S/S	40	316L S/S	---	---	529-01-19	2'-6"	300°	---	6"	---	LEVEL	
H	2"	1	150#	RFSO	316L S/S	40	316L S/S	---	---	529-01-19	-1'-5 3/8"	300°	---	---	---	LEVEL	
J	2"	1	150#	RFSO	316L S/S	40	316L S/S	---	---	529-01-19	-2'-6 3/8"	---	0"	---	---	OUTLET	
K	1"	1	3000#	H.CPLG.	316L S/S	---	---	---	---	529-01-19	TOP	0°	2'-3"	---	---	MISC.	

NOZZLE NOTES:

1. NOZZLE "A"= INCLUDES 3/8" COVER PLATE WITH SIGHT GLASS. SEE DETAIL.



DETAIL~NOZZLE "H"
SCALE: 3"=1'-0"



DETAIL~NOZZLE "G"
SCALE: 3"=1'-0"

DESIGN CONDITIONS

CODE	INDUSTRIAL AIR STANDARDS
VESSEL	MAWP = ATM.@ 212(F)
	MDMT = 20 °F
	PRODUCT S.G. = 1.20
	WIND LOAD = N/A
	SEISMIC LOAD = N/A
	INT. CORROSION ALLOW. = N/A
	EXT. CORROSION ALLOW. = N/A
JACKET	MAWP = N/A
	MDMT = N/A
	INT. CORROSION ALLOW = N/A
	EXT. CORROSION ALLOW = N/A
COIL	MAWP = N/A
	MDMT = N/A
	INT. CORROSION ALLOW = N/A
	EXT. CORROSION ALLOW = N/A
NDE	HEADS = NONE
	CYLINDER = NONE
JOINT EFF.	VESSEL: HEADS = 0.70 / VESSEL: CYLINDER = 0.70
	JACKET = N/A
IMPACT TESTING	NONE

MATERIAL TYPE

TOP HEAD	3/8" HRAP, A240-316L S/S, FLAT @ 5'-6 7/8" I.D.
BOTTOM HEAD	3/16" HRAP, A240-316LS/S, CONICAL @ 5'-6" I.D. x 2 3/8"" I.D. x 1'-6 3/8" DP.
CYLINDERS	3/16" HRAP, A240-316LS/S, 5'-6" I.D. x 3'-0" LG. WRAPPER CUT @ 17'-3 3/4" LG.
STRUCTURAL	304 S/S
GASKETING	GORE-TEX, WITH 304 S/S
INSUL. INT.	N/A
INSULATION	N/A
BOLTING	316 S/S HEX HD., UNC.

WELDING SPECIFICATIONS

VESSEL SHELL	WPS's 8-1-1, 8-2-1, ER316L
VESSEL NOZZLES	WPS's 8-1-1, 8-2-1, ER316L
STRUCTURAL	WPS's 8-1-1, 8-2-1, ER316L
ATTACHMENTS	
JACKET	WPS's 8-1-1, 8-2-1, ER316L
COIL	N/A

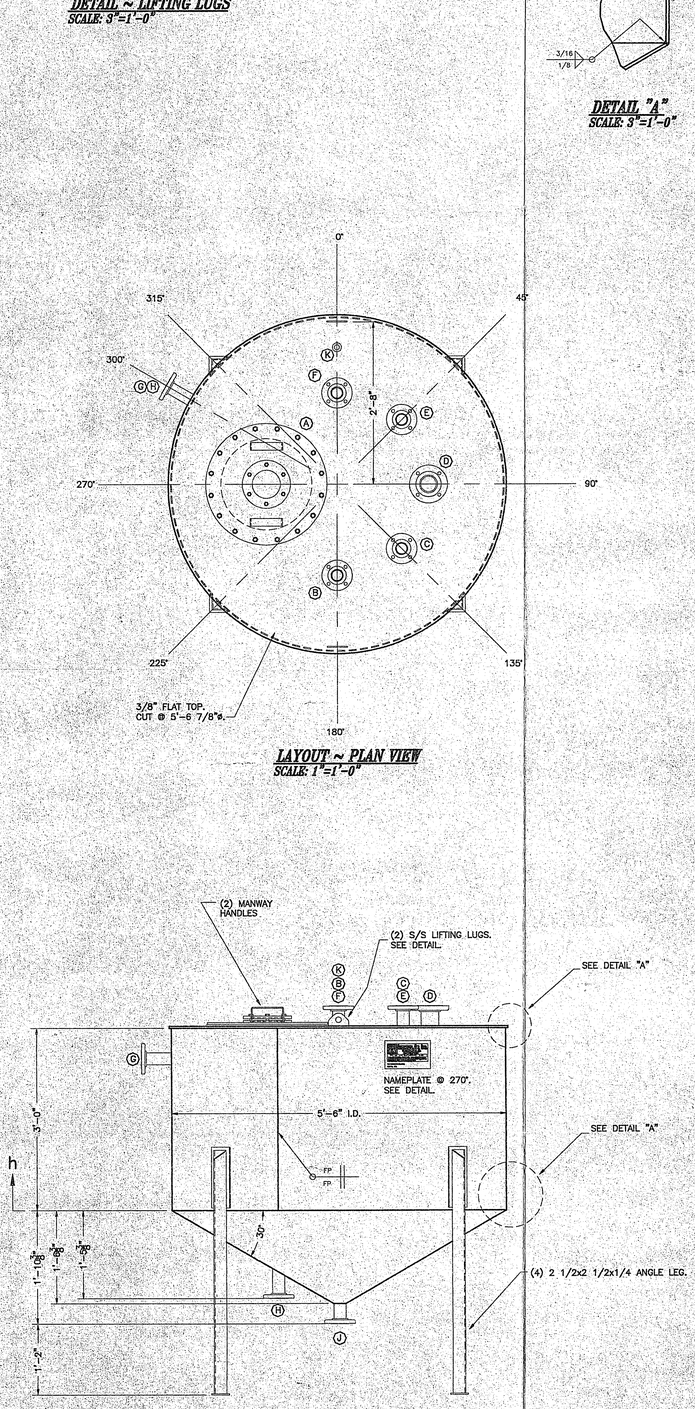
TESTING

	Air/psi	Hydro/psi	Dye	X-Ray
VESSEL	2.5			NONE
COIL	N/A			N/A
JACKET	N/A			N/A
REPAD	N/A			N/A

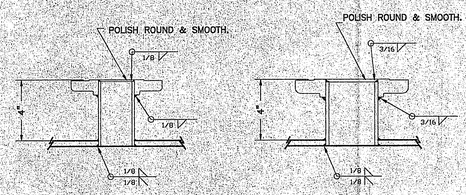
CLEAN-UP, FINISH, & PAINT

INTERIOR	WELDS : GRIND FLUSH AND POLISH WITH 120 GRIT WHEEL.
	BODY: DETERGENT CLEAN TO REMOVE ALL OIL AND SCALE, AND RINSE. POLISH TO A #4 (120 GRIT) FINISH.
EXTERIOR	WELDS : GRIND SMOOTH (NOT FLUSH) & BUFF CLEAN.
	BODY: DETERGENT CLEAN TO REMOVE ALL OIL AND SCALE, AND RINSE.
	CARBON STEEL: N/A.
EMPTY WT.	1,376 LBS.
OPER. WT.	6,565 (LBS.) @ SG = 1.0

LAYOUT ~ PLAN VIEW
SCALE: 1"=1'-0"

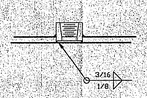


ELEVATION VIEW
SCALE: 1"=1'-0"

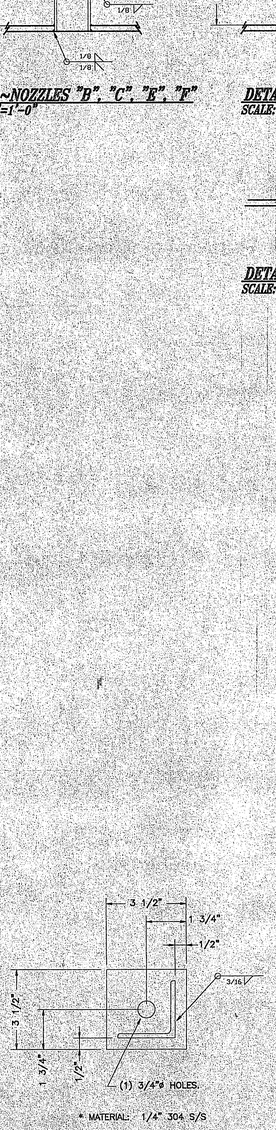


DETAIL~NOZZLES "B", "C", "E", "F"
SCALE: 3"=1'-0"

DETAIL~NOZZLE "D"
SCALE: 3"=1'-0"

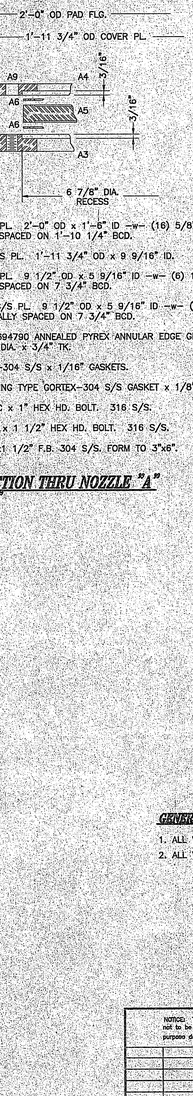


DETAIL~NOZZLE "K"
SCALE: 3"=1'-0"



* MATERIAL: 1/4" 304 S/S

DETAIL ~ SUPPORT BASE PLATES
SCALE: 3"=1'-0"



*A1 (PAD)= 3/4" 316L S/S PL. 2'-0" OD x 1'-5" ID -w- (16) 5/8" UNC HOLES EQUALLY SPACED ON 1'-10 1/4" BCD.

*A2 (COVER)= 3/8" 316L S/S PL. 1'-11 3/4" OD x 9 9/16" ID.

*A3 (PAD)= 3/4" 316L S/S PL. 9 1/2" OD x 5 9/16" ID -w- (6) 1/2" UNC HOLES EQUALLY SPACED ON 7 3/4" BCD.

*A4 (RETAINER)= 1/2" 304 S/S PL. 9 1/2" OD x 5 9/16" ID -w- (6) 9/16" DIA. HOLES EQUALLY SPACED ON 7 3/4" BCD.

*A5 (SIGHT GLASS)= EEP # 694790 ANNEALED PYREX ANNULAR EDGE GLASS. 6 3/4" DIA. x 3/4" TK.

*A6 (GASKETS)= (2) GORTEX-304 S/S x 1/16" GASKETS.

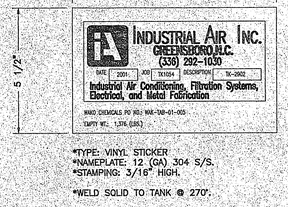
*A7 (GASKETS)= 18" 150# RING TYPE GORTEX-304 S/S GASKET x 1/8".

*A8 (BOLTS)= (16) 5/8" UNC x 1" HEX HD. BOLT. 316 S/S.

*A9 (BOLTS)= (6) 1/2" UNC x 1 1/2" HEX HD. BOLT. 316 S/S.

*A10 (HANDLES)= (2) 3/16"x1 1/2" F.B. 304 S/S. FORM TO 3"x6".

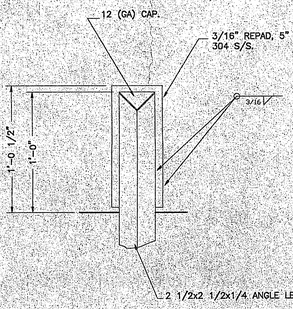
DETAIL~SECTION THRU NOZZLE "A"
SCALE: 3"=1'-0"



*TYPE: VINYL STICKER
*NAMEPLATE: 12 (GA) 304 S/S.
*STAMPING: 3/16" HIGH.

*WELD SOLID TO TANK @ 270°.

DETAIL ~ NAMEPLATE
SCALE: 3/8"=1"



DETAIL ~ LEG ATTACHMENT
SCALE: 2"=1'-0"

GENERAL NOTES:

1. ALL WETTED MATERIALS TO BE TYPE 316L S/S. UNWETTED MATERIAL MAY BE TYPE 304 S/S.
2. ALL WELDING TO BE BY INDUSTRIAL AIR CERTIFIED ASME SECTION IX QUALIFIED WELDERS.

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EMORY WILSON
GREENSBORO, NC
WAKO CHEMICALS USA, INC. / RICHMOND, VA
HOPPER # TK-2902 ~ SHOP FAB.

REV. NO.	DATE	REVISION	BY

DRAWN: MSG JTC DATE: 04/18/2001 PROJECT: TK-1054
CHECKED: MSG SCALE: 1"=1'-0" DWG. 529-01-19