

FORM U-2A MANUFACTURER'S PARTIAL DATA REPORT (ALTERNATIVE FORM)
A Part of a Pressure Vessel Fabricated by One Manufacturer for Another Manufacturer
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

1. Manufactured and certified by Industrial Process Equipment Corporation RD#2 Donahue Rd, Latrobe PA, 15650
(Name and address of Manufacturer)
2. Manufactured for Roche Vitamins, 233 Roche Dr. Belvidere, NJ 07823
(Name and address of Purchaser)
3. Location of installation Unknown
(Name and address)
4. Type: Head 809-2702
(Description of vessel part (shell, two-piece head, tube bundle)) (Bolt's serial No.)
(Part's Ed. No.) C-3745 Rev.0 Industrial Process Equipment Corporation (ICN) 1998
(Drawing No.) (Drawing prepared by) (Year built)
5. ASME Code, Section VIII, Div. 1 1995 97 Addenda
(Edition and Addenda listed) (Code Case No.) (Special Service per UG-130(a))
6. Shell (a) No. of course(s): One (b) Overall length (ft & in.): 0'-11.875"

Course(s)			Material	Thickness		Long. Joint (Cat. A)			Circum. Joint (Cat. A, B, & C)			Heat Treatment	
No.	Diameter, in.	Length, ft & in.	Spec./Grade or Type	Non.	Cor.	Type	Full, Spot, None	ER.	Type	Full, Spot, None	ER.	Temp.	Time
1	20	0-11.875"	SA240-304	.1875	0	1	None	70	1	None	70	None	-
-	-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-	-

7. Heads: (a) SA240-304 (b) -
(Part's Spec. No., Grade or Type) (Part's Spec. No., Grade or Type)

	Location (Top, Bottom, Ends)	Thickness		Radius		Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure		Category A		
		Min.	Cor.	Crown	Knuckle					Concave	Convex	Type	Full, Spot, None	Eff.
(a)	End	.1875	0	20	1.125	-	-	-	-	-	Concave	-	-	-
(b)	-	-	-	-	-	-	-	-	-	-	-	-	-	-

If removable, bolts used (describe other fastening)

8. MAWP 85 psi at max. temp. 325 °F
(Internal) (Internal) (Internal) (Internal) (Part's Spec. No., Grade, Size, No.)
9. Impact test No, UHA51(d)(e)(f) Exempt, UG20(f) Exempt
(Indicate yes or no and the complementary impact tested)

10. Hydro., pneum., or comb. test press. -

11. Yes, inspection, and safety valve openings: (See Remarks) Proof test -

Purpose (Inlet, Outlet, Drain, etc.)	No.	Diameter or Size	Flange Type	Material		Nozzle Thickness		Reinforcement Material	How Attached		Location (Shop, Open.)
				Nozzle	Flange	Non.	Cor.		Nozzle	Flange	
Inlet	1	6	150#/SO	*	**	.134	0	None	(c)	(k)	Channel
Drain	1	2	150#/SO	*	**	.109	0	None	(c)	(k)	Channel
-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-

12. Supports: Skirt No Lugs 0 Legs 0 Others - Attached -
(Yes or no) (Size) (Size) (Describe) (Where and how)

13. Remarks: Item 19: *SA312-304, ** SA182-304
Roche Vitamins PO# BBRW42112
Design function performed by Industrial Process Equipment Corporation

CERTIFICATE OF SHOP/FIELD COMPLIANCE

We certify that the statements made in this report are correct and that all details of material, construction, and workmanship of this pressure vessel part conform to the ASME Code for Pressure Vessels, Section VIII, Division 1.

U Certificate of Authorization No. 26,227 Expires March 12, 20 01

Date 10-9-98 Name Industrial Process Equipment Corporation Signed Christopher J. Kanyan
(Manufacturer) (Representative)

CERTIFICATE OF SHOP/FIELD INSPECTION

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of Pennsylvania and employed by Allendale Mutual Insurance Company of Norwood, MA have inspected the pressure vessel part described in this Manufacturer's Data Report on 10-15, 19 98, and state that, to the best of my knowledge and belief, the manufacturer has constructed this pressure vessel part in accordance with ASME Code, Section VIII, Division 1. By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel part described in this Manufacturer's Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.

Date 10-19-98 Signed [Signature] Factory Mutual Engrg. Assn. PA-2646
(Authorized Inspector) (Commissions) (Part's Board Incl. endorsement, State, Province and No.)

FORM U-1 MANUFACTURERS' DATA REPORT FOR PRESSURE VESSELS
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

HEX-3587

1. Manufactured by Weldon, Inc., Clark, New Jersey
(Name and address of manufacturer)
2. Manufactured for Hoffmann La Roche, Inc., Nutley, New Jersey
(Name and address of purchaser)
3. Location of Installation Belvidere, New Jersey
(Name and address)
4. Type Horizontal Vessel No. 80-1746 (CRN) C-1667
(Horizontal, or vert. tank) (Mfg's Serial No.) (Drawing)
2436 Year Built 1977
(Nat'l Id. No.)
6. The chemical and physical properties of all parts meet the requirements of material specifications of the ASME BOILER AND PRESSURE VESSEL CODE. The design, construction, and workmanship conform to ASME Rules, Section VIII, Division 1 1974 and Addenda to 6-30-76 and Code Case no. _____
(Year) (Date)
Special service per UG-120(d) _____
Manufacturers' Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report: _____
(Name of part, item number, mfg's name and identifying stamp)

Items 6-11 incl. to be completed for single wall vessels, jackets of jacketed vessels, or shells of heat exchangers
6. Shell: Material SA240-304 Nominal Thickness 1/4 in. Corrosion Allowance 0 in.
(Spec. No., Grade) (Date)
Diam. 3 ft 4 in. Length 13 ft 6-1/2 in.

CERTIFICATE OF COMPLIANCE

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME Code for Pressure Vessels, Section VIII, Division 1.
Date 3-28-77 Signed Weldon, Inc. by [Signature]
(Manufacturer) (Representative)
"U" Certificate of Authorization No. 11,621 expires August 10, 1978

CERTIFICATE OF SHOP INSPECTION

Vessel made by Weldon, Inc. at Clark, New Jersey
I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of ND and employed by Lumbermen Mutual Casualty Co. of Chicago, Illinois have inspected the pressure vessel described in this Manufacturers' Data Report on 4-1 1977, and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME Code, Section VIII, Division 1.

By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in the Manufacturers' Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.

Date 4-6-77 Commissions 1193870
Signed [Signature] (Inspector) (Nat'l Board, State, Province and No.)

CERTIFICATE OF COMPLIANCE FOR FIELD WORK

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME Code for Pressure Vessels, Section VIII, Division 1.
Date _____ Signed _____ (Manufacturer) by _____ (Representative)
"U" Certificate of Authorization No. _____ expires _____, 19____

CERTIFICATE OF FIELD ASSEMBLY INSPECTION

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of _____ and employed by _____ of _____ have compared the statements in this Manufacturers' Data Report with the described pressure vessel and state that parts referred to as data items _____, not included in the certificate of shop inspection, have been inspected by me and that, to the best of my knowledge and belief, the Manufacturer has constructed and assembled this pressure vessel in accordance with ASME Code, Section VIII, Division 1.

The described vessel was inspected and subjected to a hydrostatic test of _____ psi.

By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturers' Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.

Date _____ Commissions _____ (Nat'l Board, State, Province and No.)
Signed _____ (Authorized Inspector)

This form (E00108) may be obtained from the Order Dept., ASME, 345 E. 47th St., New York, N.Y. 10017

(7/76)

33-5854

MANUFACTURER'S REPORT OF WELDED REPAIRS OR ALTERATIONS

HEX-3587

1	REPAIRED BY (Name and address of Manufacturer or Repair Concern)	
2	REPAIRED FOR (Name and plant address of owner)	
3	OBJECT AND TYPE (Boiler, pressure vessel, P.T., W.T., fabricated, etc.)	
4	IDENTIFICATION NUMBER (Owner's, State's, etc.)	YEAR BUILT
5	DESCRIPTION OF REPAIR (Use separate sheet or sketch if necessary)	
6	REPAIRS MADE IN ACCORDANCE WITH	
7	REPAIR PLANS APPROVED BY (Name of Owner representative)	
8	WELDING PROCEDURE QUALIFICATION AND WELDER QUALIFICATION IN ACCORDANCE WITH ASME CODE	
9	REPAIRS COMPLETED (Date)	

We certify the above statements to be correct and that the repairs when completed satisfactorily withstood the hydrostatic test without evidence of leakage or other signs of distress.

Date 7/22/1982 Signed Weldon, Inc. By Anthony Baurale
(Manufacturer or Repair Concern) (Representative)

CERTIFICATE OF WELDED REPAIR INSPECTION

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State of New Jersey have inspected during repair the object described above and state that to the best of my knowledge and belief the statements made and certified to above by the representative of Weldon, Inc. are correct.

By signing this certificate neither the Inspector nor N.J. Department of Labor & Industry makes any warranty, expressed or implied, concerning the object described in this report. Furthermore neither the Inspector nor N.J. Dept. of Labor & Industry shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection, except such liability as may be provided in a policy of insurance which N.J. Dept. of Labor & Industry Company may issue upon said object and then only in accordance with the terms of said policy.

Date 7/22/1982 Signed Vincent J. Palocano Commissions NB7135
(Inspector) (State or Nat'l Board No.)

PRINTED IN U.S.A.