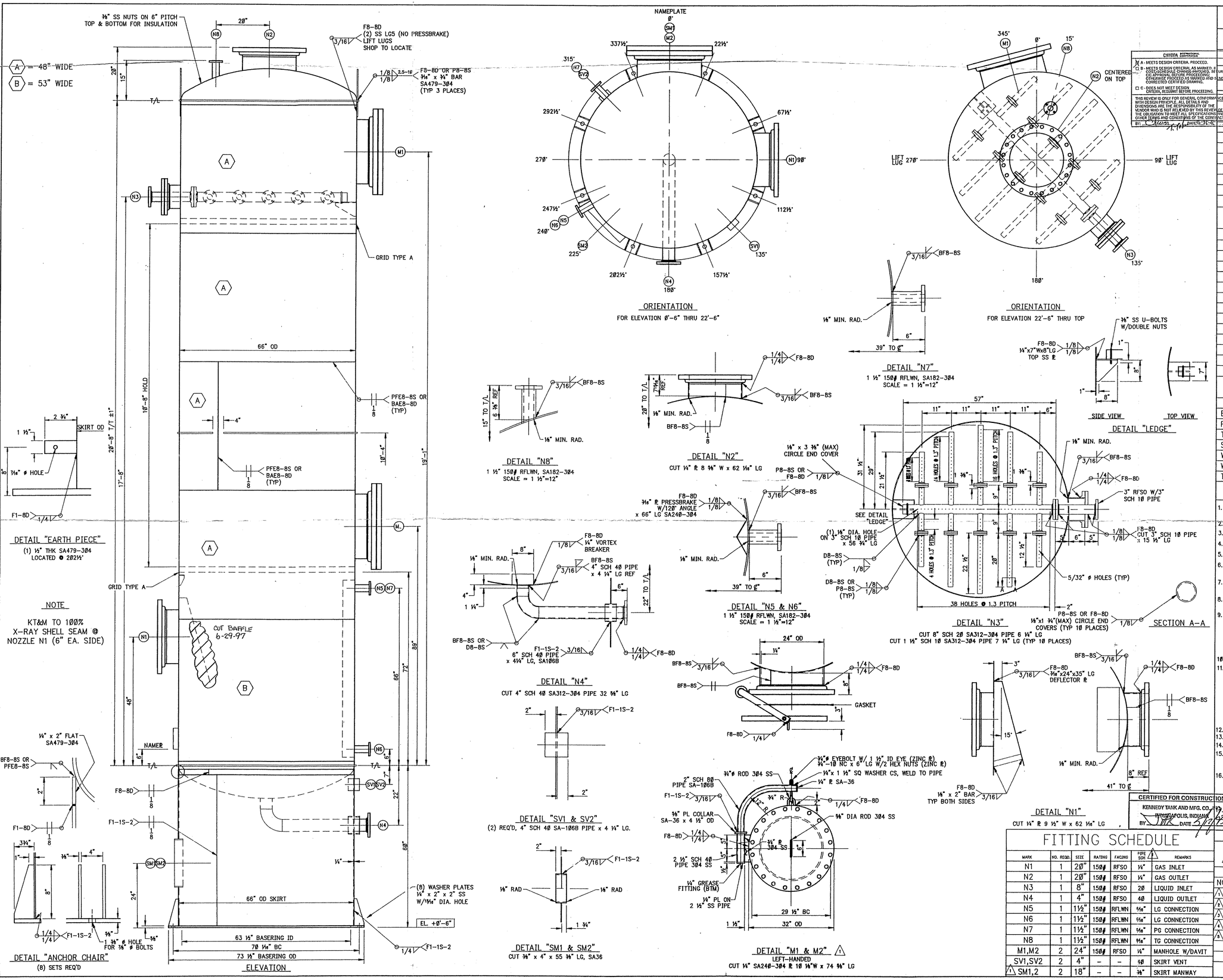

MATERIALS

HEADS: 3/16" x 66" OD ASME F&D RD=60", KR=4", SF=1 1/2"	SA240-304
SHELL: 3/16"	SA240-304
SKIRT: 1/4"	SA479-304 & 1/4" SA516-70
FLANGES:	SA182-304
WELD FITTINGS:	SA403-304
NOZZLE NECKS (PIPE):	SA312-304
NOZZLE NECKS (PLATE):	SA240-304
REPADS:	SA240-304
VESSEL SUPPORT:	A36
STRUCTURAL:	A36 & SA479-304
NUTS (EXT.): (SEE NOTE 17)	A325, (ZINC PLATED) SA194-2H
STUDS (EXT.): (SEE NOTE 17)	A325, (ZINC PLATED) SA193 B7
BOLTS (INT.): (SEE NOTE 17)	18-8 & SA193 B8
NUTS (INT.): (SEE NOTE 17)	18-8 & SA194-8
GASKETS: 1/8" GARLOCK 3700 (SEE NOTE 17)	

DESIGN CONDITIONS

SPEC. PRESS. PSIG.:	4.33
EXTERNAL PRESS. PSIG.:	NONE
AT SPEC. TEMP. (F):	100
OPERATING PRESS. PSIG:	ATMOSPHERIC
AT OPERATING TEMP. (F):	60° F
CORROSION ALLOW.:	NONE
LABEL: (NO STAMP)	BUILT PER ASME SEC. VIII, DIV. 1, 1992 ED. 93 ADD.
STRESS RELIEVE:	NONE
RADIOGRAPH:	RT-3 (SPOT)
JOINT EFF.:	85%
AIR TEST:	5 PSIG
CUSTOMER INSPECTION: (SEE NOTE 9)	YES
MTR COPIES: (SEE NOTE 4)	1 KT&M, 1 CUSTOMER
NAMEPLATE FACSIMILE:	YES

WEIGHTS & CAPACITIES

CAPACITY, GALS. (ESTIMATE)	
EACH HEAD:	100.8
PER FT. STRAIGHT SIDE:	175.7
TOTAL:	3,833
SP. GR. OF CONTENTS:	1.0
WT. OF CONTENTS:	31,967#
WT. OF VESSEL:	7,169#
TOTAL WT.:	39,136#

NOTES

1. BOLT HOLES TO STRADDLE SHOWN CENTERLINES, OR LINES PARALLEL TO 0°/180° & 90°/270° ℄.
2. ALL NOZZLES TO BE ORDERED WITH "A" RA 250-500 FINISH.
3. INSULATION CLIPS ARE REQUIRED. 1" INSULATION BY CUSTOMER.
4. MTR'S WILL ONLY BE RETAINED UNTIL COMPLETION OF JOB.
5. ALL INSIDE EDGES OF NOZZLES TO BE ROUNDED OFF TO A MINIMUM RADIUS OF 1/8".
6. TACK WELDS APPLIED TO THE PREPARED EDGES FOR WELDING SHALL BE REMOVED SO THAT THEY DO NOT MERGE INTO THE ACTUAL WELD.
7. ASME SPOT RADIOGRAPHY FOR CIRCUMFERENTIAL AND LONGITUDINAL JOINTS IS A MINIMUM REQUIREMENT.
8. SHOP TOLERANCES: DIMENSIONS ±1/8"
   NOZZLES ± 1/2 DEGREE
9. CUSTOMER TO BE NOTIFIED 5 DAYS IN ADVANCE FOR:
   1) IDENTIFICATION/MARKING OF MATERIAL 2) WELDING PREPARATION.
   3) FINAL DIMENSION INSPECTION 4) AIR TEST 5) FINAL INSPECTION WHICH INCLUDES: A) SURFACE FINISH B) CLEANING C) PAINTING AND COATING D) MARKING AND NAMEPLATE E) FLANGE PROTECTION F) PREPARATION FOR SHIPMENT
10. HYDROTEST WITH TEST GASKETS ONLY. INSTALL SERVICE GASKETS PRIOR TO SHIPMENT.
11. CLEAN ALL INTERIOR DISCOLORATION DUE TO WELDING BY APPLYING ARCAL COMPOUND 302.. AFTER CLEANING, RINSE THOROUGHLY WITH DISHWASHING LIQUID IN WATER. RINSE THE VESSEL AGAIN BEFORE DRYING WITH HOT AIR, OR ALL INTERNAL WELD DISCOLORATION ON STAINLESS STEEL COMPONENTS SHALL BE REMOVED BY ACID CLEANING PER ASTM A380 A.2 RECOMMENDATIONS. DESCALE WELDS USING 80 GRIT FLAPPER WHEEL. APPLY ACID PICKLING SOLUTION, RINSE, WASH SURFACE WITH ALKALINE DETERGENT SOLUTION TO REMOVE ALL SMUT. RINSE THOROUGHLY THEN DRY USING TOWELS OR HOT AIR.
12. SANDBLAST: CARBON STEEL ONLY. DO NOT BLAST STAINLESS STEEL.
13. LINING: NONE
14. PAINTING: CARBON STEEL ONLY WITH ONE COAT RED OXIDE PRIMER AT 2-3 MILS DFT.
15. FABRICATOR SHALL PROVIDE GASKETS, BOLTS, AND HEX NUTS FOR ALL MATING PARTS INCLUDING BLIND FLANGES WHERE NOTED. ALL OTHER FLANGES WILL BE SHIPPED WITH PROTECTIVE SHIELDS.
16. ASSEMBLE ENTIRE VESSEL WITH SERVICE GASKETS FOR SHIPMENT. ORIENTATION SHALL BE MARKED ON THE TOP, MIDDLE, AND BOTTOM PORTIONS OF THE SURFACES OF THE SHELL AT 0°, 90°, 180° AND 270° WITH BLACK PAINT. THE ORIENTATION MARKER AND CENTER LEVEL MARK WITH PAINT SHALL BE A MIN. OF 12" LONG AND MAX. 1/8" WIDTH.
17. SHIP LOOSE: 200% SPARE GASKETS, 10% SPARE BOLTING, LADDERS, PLATFORMS & ANCHOR CHAIR WASHERS.

RECEIVED
MAY 23 1995
C.T.C. ENGINEERING

FITTING SCHEDULE

MARK	NO. REQD.	SIZE	RATING	FACING	PIPE SCH.	△1	REMARKS
N1	1	20"	150#	RFSO	1/4"		GAS INLET
N2	1	20"	150#	RFSO	1/4"		GAS OUTLET
N3	1	8"	150#	RFSO	20		LIQUID INLET
N4	1	4"	150#	RFSO	40		LIQUID OUTLET
N5	1	1 1/2"	150#	RFLWN	5/16"		LG CONNECTION
N6	1	1 1/2"	150#	RFLWN	5/16"		LG CONNECTION
N7	1	1 1/2"	150#	RFLWN	5/16"		PG CONNECTION
N8	1	1 1/2"	150#	RFLWN	5/16"		TG CONNECTION
M1,M2	2	24"	150#	RFSO	1/4"		MANHOLE W/DAVIT
SV1,SV2	2	4"	–	–	40		SKIRT VENT
△1 SM1,2	2	18"	–	–	1/8"		SKIRT MANWAY

94201-010-017 5752-190-3

KENNEDY TANK & MANUFACTURING CO., INC.
833 EAST SUMNER AVENUE INDIANAPOLIS, INDIANA 46227

REVISIONS		
NO.	DATE	BY
△1	3/23/95	WAD
△2	5/3/95	WAD
△3		
△4		
△5		

DESCRIPTION: 66" OD x 27'-4" OAH WATER BATH SCRUBBER

FOR: *CHIYODA INTERNATIONAL CORP.* TW-102 TAG: 5752-190-3

CAD: W DARNELL	SCALE: 3/4"=12"	QUANTITY REQUIRED:	
APP'D BY: J KLEYLA	DATE: 1/16/95	ONE	
Q.C.: D PENCE	JOB NO.: 6085-A2	DRAWING NO.:	
	PLOT: 3/4"=12"	95-6085A2D1	
PURCHASE ORDER NO. 201010-M1-001		SHEET 1 OF 2	

#108716