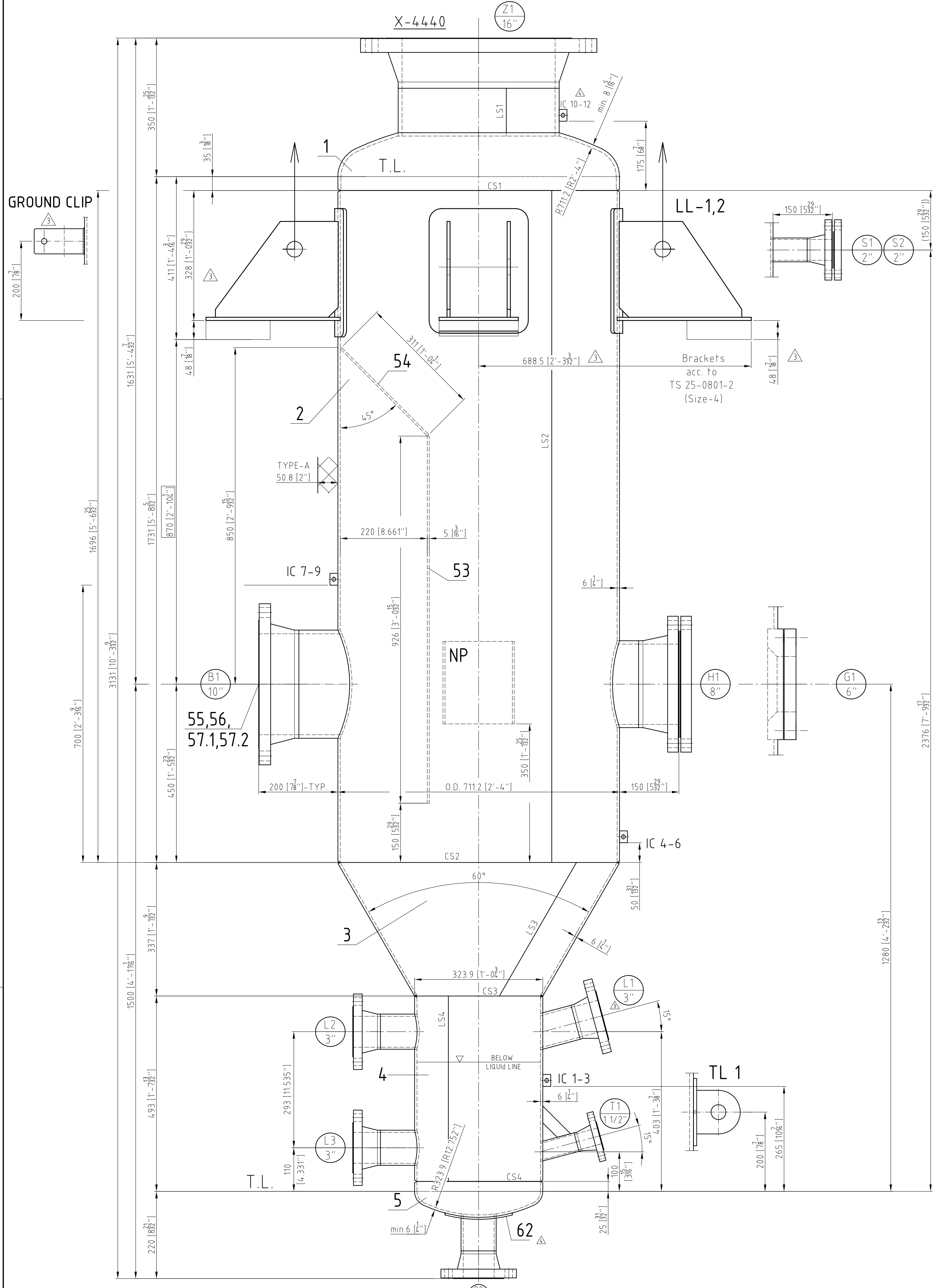
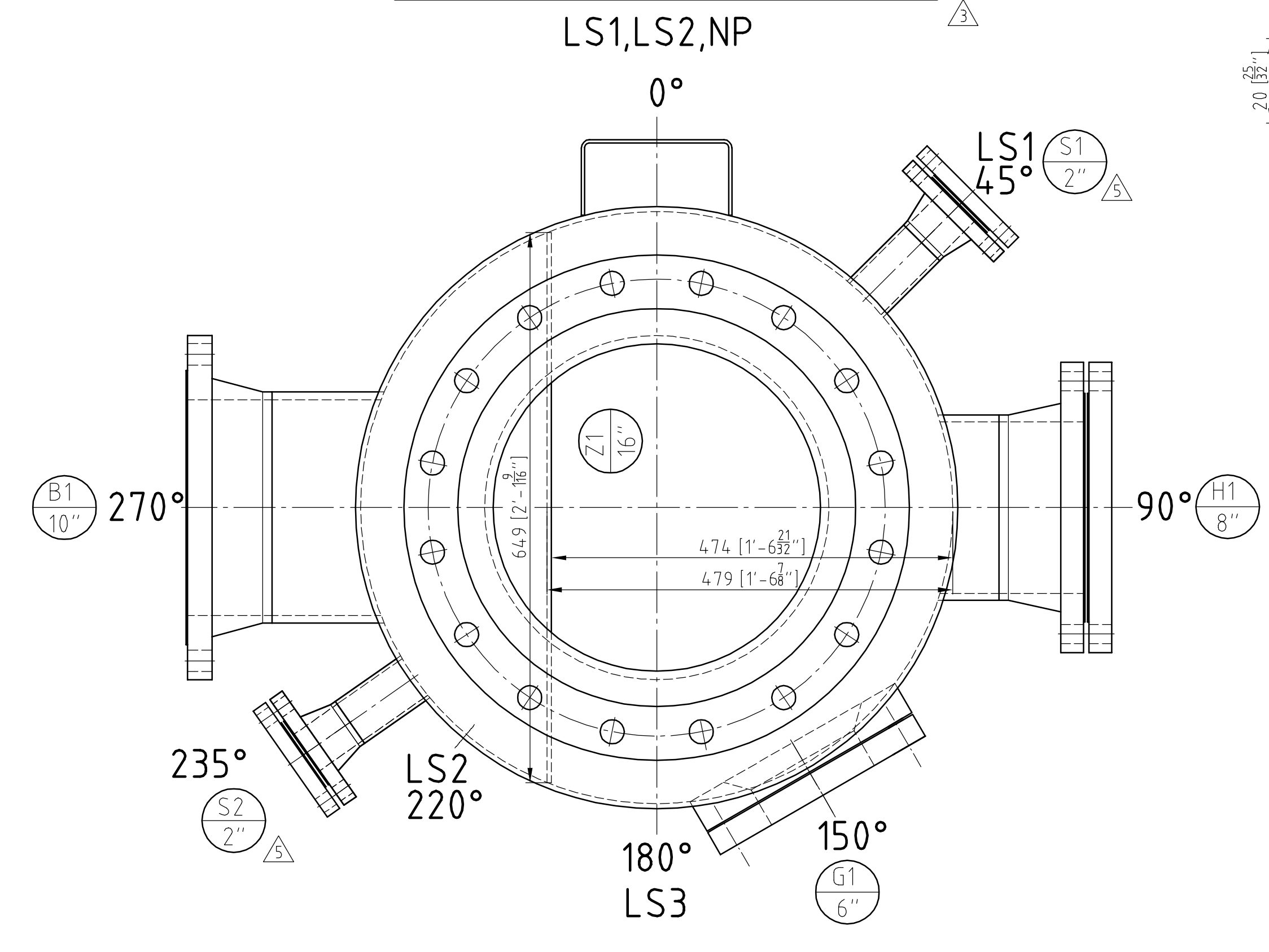


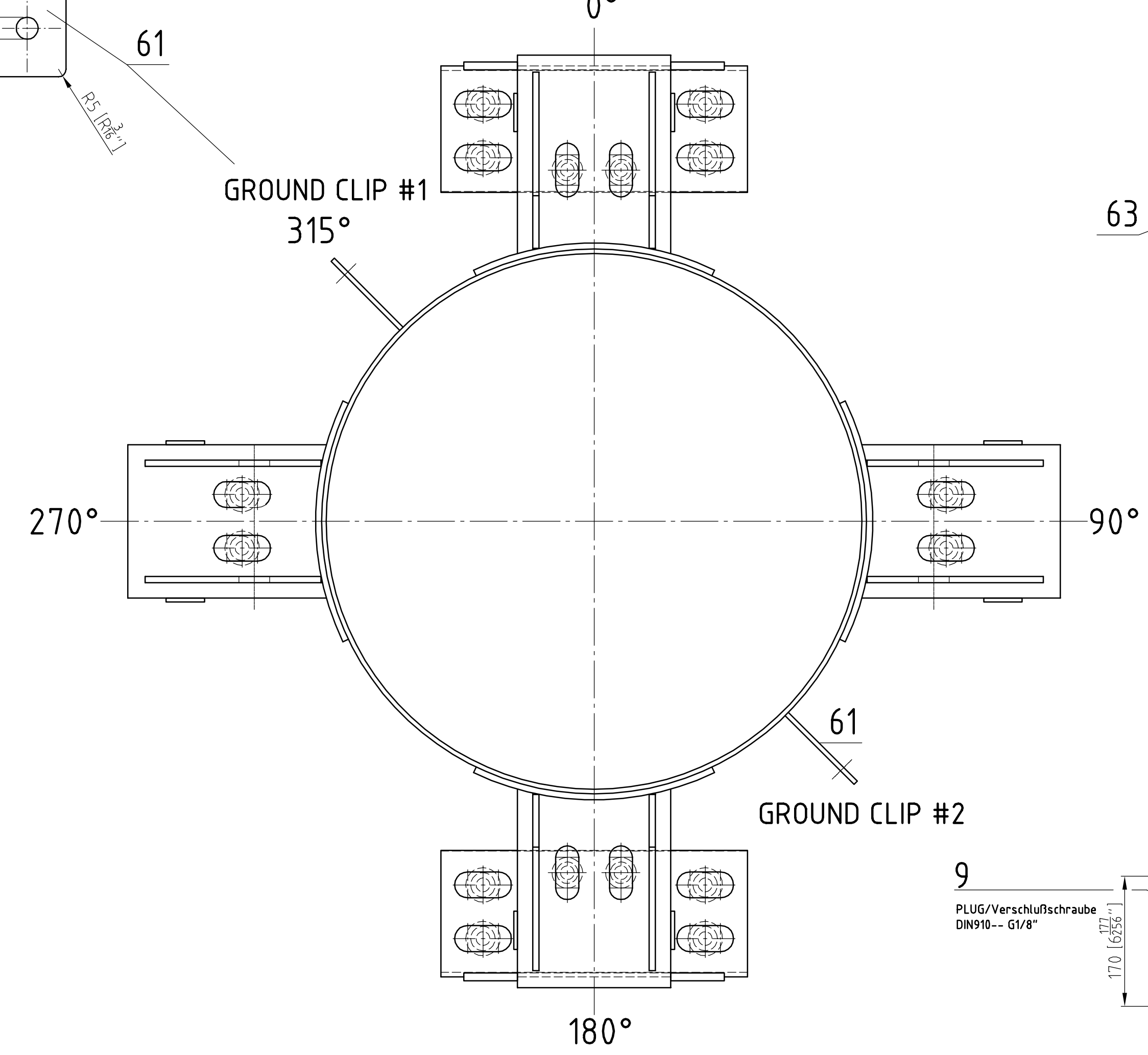
LAYOUT V-4430



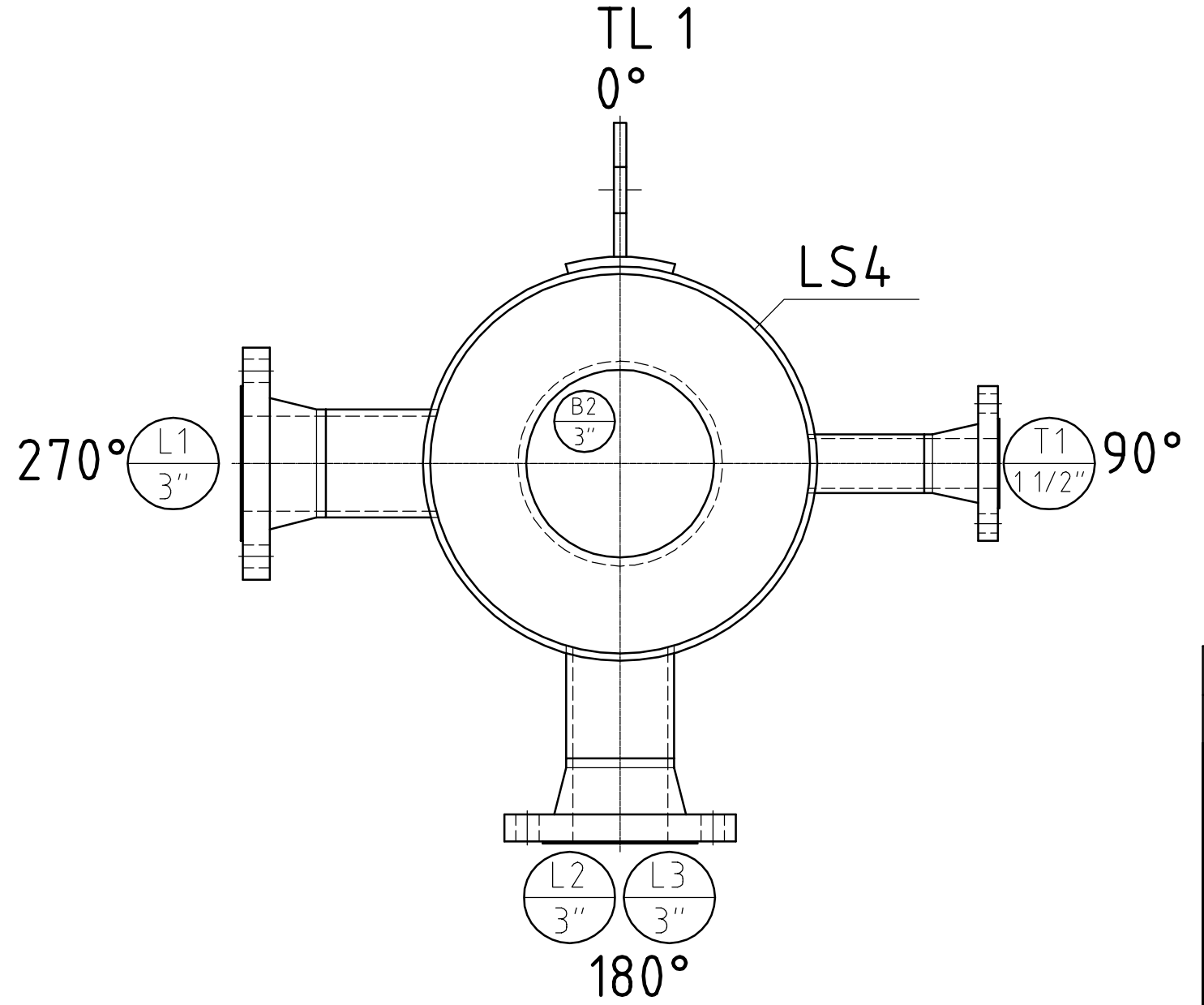
NOZZLE ORIENTATION



ORIENTATION BRACKETS



NOZZLE ORIENTATION



INSULATION CONNECTION IC 1-12

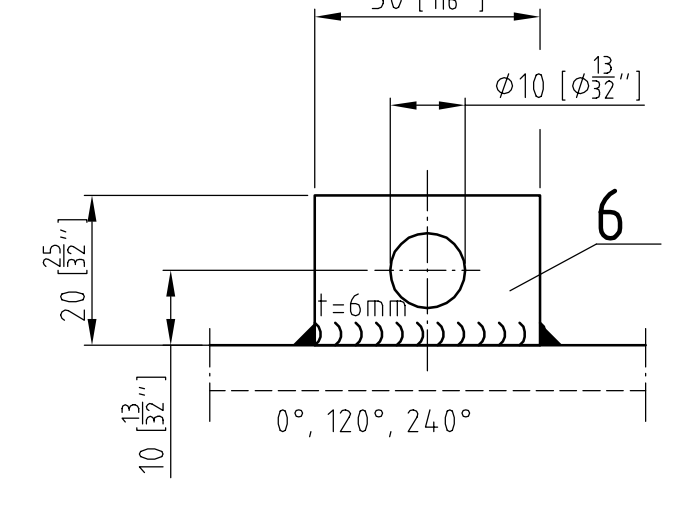


TABLE OF NOZZLES/Stutzen				TABLE OF NOZZLES/Stutzen				D.O.		NOZZLE PROJ.		FUNCTION	
DESIGN	SIZE	RATING	FLANGE	TUBE	MATERIAL	SCHED.	THK.	MATERIAL	INCH	mm	Shutzelement	NOZZLE PROJ.	FUNCTION
B1	10"	150#	WN	RF	SA192-F304L	40S	9.27mm	SA312-TP316L	10.75	273	-	-	VAPOR OUTLET
B2	3"	150#	WN	RF	SA192-F304L	40S	5.49mm	SA760-S31803	3.50	88.9	-	-	PRODUCT OUTLET
G1	6"	150#	PAD	WN	RF	SA192-F304L	40S	7.11mm	SA312-TP316L	6.425	168.3	-	SI-GT GLASS
L1-L3	3"	150#	WN	RF	SA192-F304L	40S	5.49mm	SA312-TP316L	3.50	88.9	-	-	LEVEL CONTROL
H1	8"	150#	WN	RF	SA192-F304L	40S	8.18mm	SA312-TP316L	8.425	213.3	-	-	HAND HOLE
S1-S2	2"	150#	WN	RF	SA192-F304L	40S	3.91mm	SA312-TP316L	2.375	60.3	-	-	SPARE (BLIND)
T1	1.5"	150#	WN	RF	SA192-F304L	40S	3.68mm	SA312-TP316L	1.90	48.3	-	-	TEMPERATURE CONTROL
Z1	16"	150#	WN	RF	SA192-F304L	40S	9.53mm	SA312-TP316L	16.00	406.4	-	-	CONNECTION X-4440

Flange B16.5 (2009)
Y1 - ASME Sect VIII Div I UG-80, UG-81, UW-9 (c) UW-33, UW-35, DIN EN ISO 19320-B
TS 25-0108

NOTES/Bemerkungen
 BOLT HOLES TO STRADDLE CENTER LINES/Flanschbohrungen: TOLERANCES TOP/Anstrichen nach Y18
 TEST HOLES: mit Bohrer/Bohrergrößenverhältnis=0.95, CLOSED AFTER PRESSURE TEST (PLUGS G 1/8")
 SPARE PARTS/Reserveerteile: BOLTS AND NUTS/Schrauben und Muttern: GASKETS/O-Rings: 2 SET/Satz, GLASSES/Glasauger: - SET/Satz
 OUTSIDE BOLT THREADS SHALL BE PROTECTED WITH ALUMINUM ANODIZED COATING/Mit Aluminium beschichten
 FLANGE FACINGS SHALL BE PROTECTED WITH ANTI-CORROSION COATING WITH COVER PLATE/WOOD/PLASTIC
 OPEN NOZZLES TO BE CLOSED WITH PROTECTIVE COUPLERS/Werkschlösschen mit COVER PLATE/WOOD/PLASTIC
 INSULATION/Isolierung: * NOT SUPPLIED BY MONTZ

TECHNICAL REQUIREMENTS:
 -EVONIK SPECIFICATION 20.230.013
 -EVONIK SPECIFICATION 20.230.030
 -EVONIK SPECIFICATION 20.230.036
 -TS25-0101-1

REFERENCE DRAWINGS/Zugehörige Zeichnungen
 T-300 / LAYOUT DWG NO./Z.Nr: 214-0451-18-001 DWG NO./Z.Nr:
 NOZZLE DETAIL 1 DWG NO./Z.Nr: 214-0451-18-002 DWG NO./Z.Nr:
 NOZZLE DETAIL 2 DWG NO./Z.Nr: 214-0451-18-003 DWG NO./Z.Nr:
 DWG NO./Z.Nr:
 DWG NO./Z.Nr:

SURFACE TREATMENT/Oberflächenbehandlung
 SS-PARTS/Edelstahlteile: PICKLED AND PASSIVATED/Gebleicht und passiviert. ACC. TO TS-0205 INCLUDE EVONIK REQUIREMENTS FOR DRYING (prior to shipment)
 WEIGHTS/Gewichte: HOLD/PRELIMINARY

NET WEIGHT/Nettogewicht:	APPROX. 650 kg	GROSS WEIGHT/Gesamtwicht:	APPROX. 650 kg
WEIGHT OF INTERNALS:	APPROX. - kg	VESEL TEST WEIGHT:	APPROX. 1550 kg
WEIGHT OF PACKING:	APPROX. - kg	VESEL OPERATING WEIGHT:	APPROX. 1100 kg

TESTING AND INSPECTING/Prüfungen				Pressure Test Water max. chloride content: 50ppm	
HEAD / SHELL	CERTIF.	ULTRASONIC EXAMINATION/Überschallprüfung		CERTIF.	
LONGITUDINAL JOINTS/Längsnähte	SPOT X1	DYE PENETRANT EXAMINATION/Färbeprüfung		X	
CIRCUMFERENTIAL JOINTS/Querschnähte	SPOT X1	MAGNETIC PARTICLE EXAMINATION/Magnetpulverprüfung		-	
WELD CROSSING/Stechnähte	100% X1	LEAK-TEST/Dichtheitprüfung		X	

xx JOINT EFFICIENCY:

HEAD / SHELL	0.85	-FOR LOADING SEE CALCULATION
SHELL	0.85	-THE MINIMUM THICKNESS SHOWN ARE CALCULATED THICKNESS
Nozzle	0.85	

RT4

DESIGN DATA / Berechnungsdaten

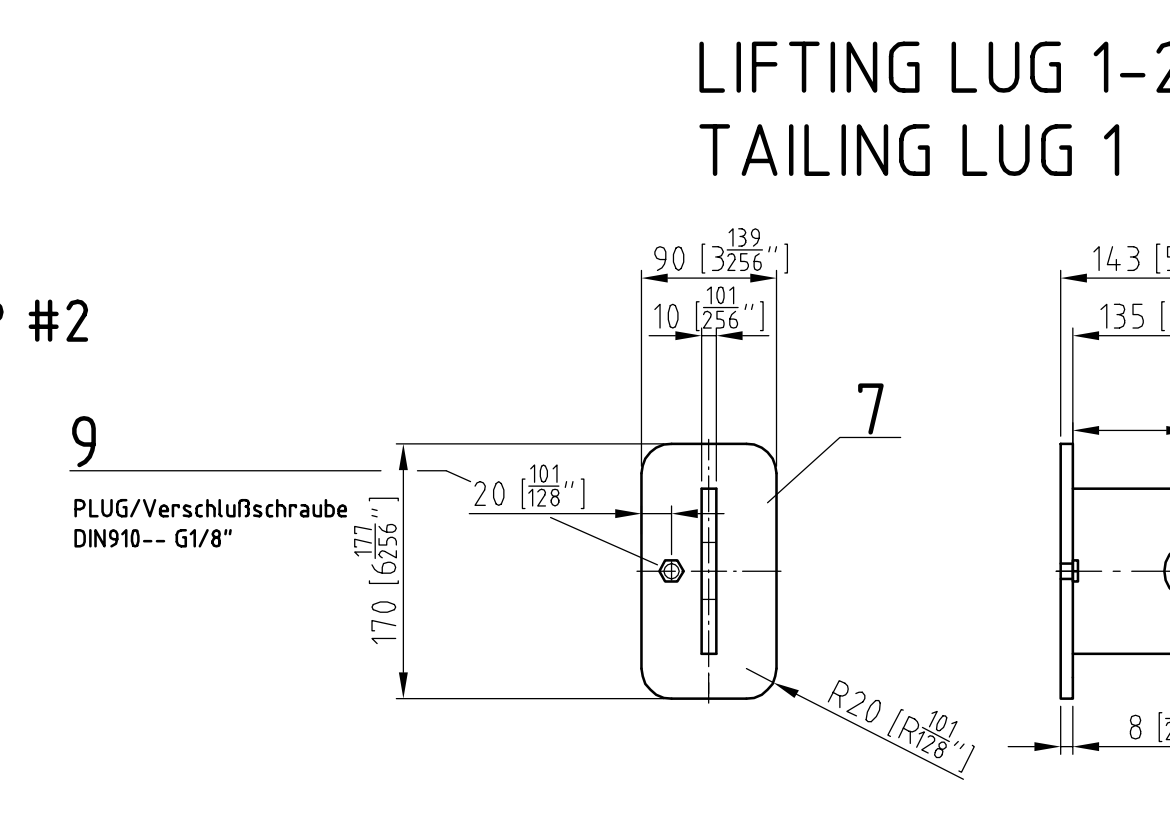
CONSTRUCTION CODE: ASME SEC VIII DIV I ED 2013

SHELL SIDE	
DESIGN TEMPERATURE	250/-29°C
DESIGN PRESSURE	3.1/-1 bar
Max. Allowable Working Pressure	3.1/-1 bar at 250°C
Min. Design Metal Temperature	-29°C at 3.1 bar
TEST PRESSURE y)	
field test pr. / shop test pressure	V=6.1/Hi=6.4 bar
y) Shop test pressure in horizontal position and field test pressure in vertical position	
CAPACITY	900L (0.900m³)
JOINT EFFICIENCY	0.85
CORROSION ALLOWANCE	No
SEISMIC LOADING	Acc. to IBC 2009 ---THEODORE ALABAMA
WIND SPEED	Acc. to IBC 2009 --- EXPOSURE CATEGORY C --- S3 (SUPPORT LOCATIONS ABOVE GRADE)
OPERATING PRESSURE	0.18 bar
OPERATING TEMPERATURE (°C)	103°C
PROCESS FLUID	ACA
DENSITY (kg/m³)	≈ 1000 kg/m³

DESIGN CHECK / Entwurfsprüfung		DESIGN CODE/Berechnungsvorschrift	
TÜV NORD SYSTEMS	ASME CODE Sect VIII Div I Ed 2013	TÜV NORD SYSTEMS	ASME CODE Sect VIII Div I Ed 2013
INSPECTION AUTHORITY/Abnahmegesellschaft	INSPECTION CODE/Abnahmevorschrift	TÜV NORD SYSTEMS	INSPECTION CODE/Abnahmevorschrift
TÜV NORD SYSTEMS	ASME CODE Sect VIII Div I Ed 2013	TÜV NORD SYSTEMS	ASME CODE Sect VIII Div I Ed 2013

MATERIALS / Material	
SHELL SIDE	
SHELL	SA 240 - 316L
BONNET	SA 240 - 316L
TUBESHEET	n.a.
TUBES seam (widl)	n.a.
BAFFLE	SA 240 - 316L
TIE RODS	
NOZZLE	SA 312 - TP 316L
FLANGE	SA 182 - F 316L
STUDS A NUTS	SA-193 B7 a SA194 2H mechanically galvanized acc. to ASTM B695, class 50

-NON LETHAL SERVICE
 -VESSEL USE FOR NON CORROSION SERVICE
 -NOZZLE WITHOUT NOZZLE LOADS INCREASE 10% INTERNAL PRESSURE
 -IMPACT TEST AS PER PARA UHA 51(d) NOT REQUIRED
 -OUTDOOR LOCATION
 -HEAT TREATMENT-NONE PER PARA UHA-4.4(a)(1)
 -MATERIAL, DIMENSIONS AND PCS SEE SEPARATE PARTS LIST:
 NO. 214-0451-18-101
 -FOR WELD INSTRUCTIONS SEE WELDPAN 214-0451-18-201
 -INSPECTION AND TESTPLAN (ITPI) 214-0451-18-301
 -VESSEL NOT SUBJECT TO RAPID FLUCTUATION IN PRESSURE
 -ERECTION PLACE: THEODORE ALABAMA
 -CODE CASES: NO
 -NATIONAL BOARD REGISTRATION: YES / CRN: NO
 -NAMEPLATE: SEE DRAW. 214-0451-18-004



Stutzenlasten / Nozzle loads		Forces (N)							Momente (Nm)		
Item	Nozzle	V1	V1	V2	MC	MC	MC	M1	M2	M3	
X-4440	A2	2300	3100	2300	500	400	800				
X-4440	A1	3500	4100	3000	1400	900	1800				
V-4430	B2	3500	4100	3000	1400	900	1800				

-FREILIEGENDE INNENKANTEN MÜSSEN GEFAST ODER GERUNDET SEIN!
 -EXPOSED INSIDE EDGES SHALL BE CHAMFERED OR ROUNDED.

EDGE PREPARATION FOR WELDING			
CS1,CS4,LS1-LS4	NI1-NI7	NS1-NS6	GENERAL FILLET WELD
2a	3a	4a	5a

SEALING SURFACE	
FINISH	Ra 3.2 (Rz 12.5) 125 AARR

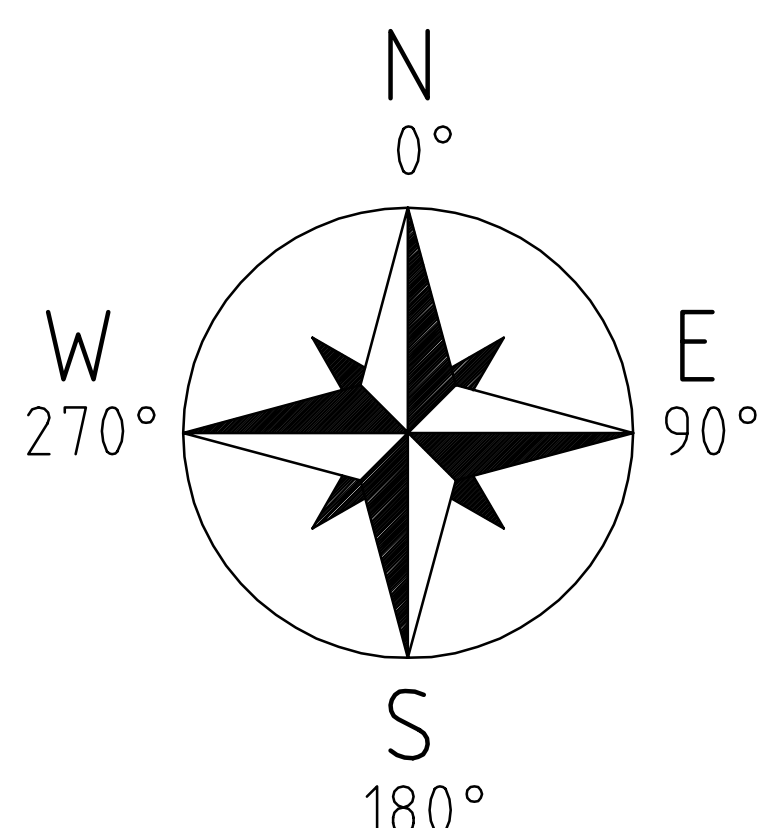
REVISION			
REV.	DATE	BY	CHECKED
1	10.11.15	J. Montz	G. Schmitt

DATE/Quellen			
DATE/Quellen	NAME/Name	WE RESERVE ALL RIGHTS FOR THIS DRAWING AND ALL CONTENTS THEREOF. NO PART MAY BE REPRODUCED, COPIED, OR BEING ACCESSIBLE TO THIRD PERSONS WITHOUT THE WRITTEN PERMISSION OF THE DRAWING OR THIRD PERSONS.	

SCALE/Vergrößerung	
SCALE/Vergrößerung	1:5

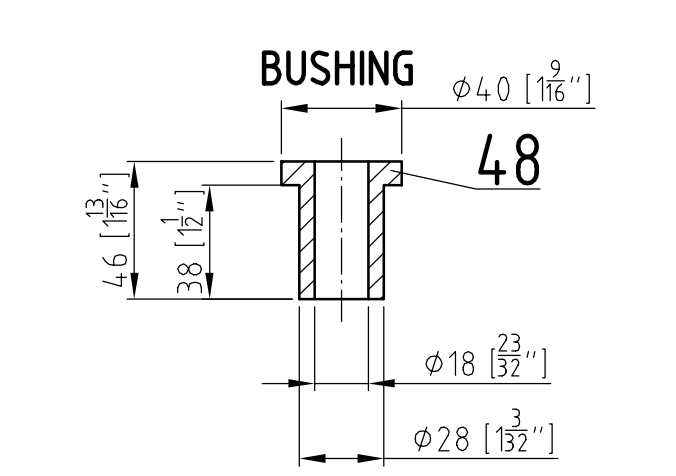
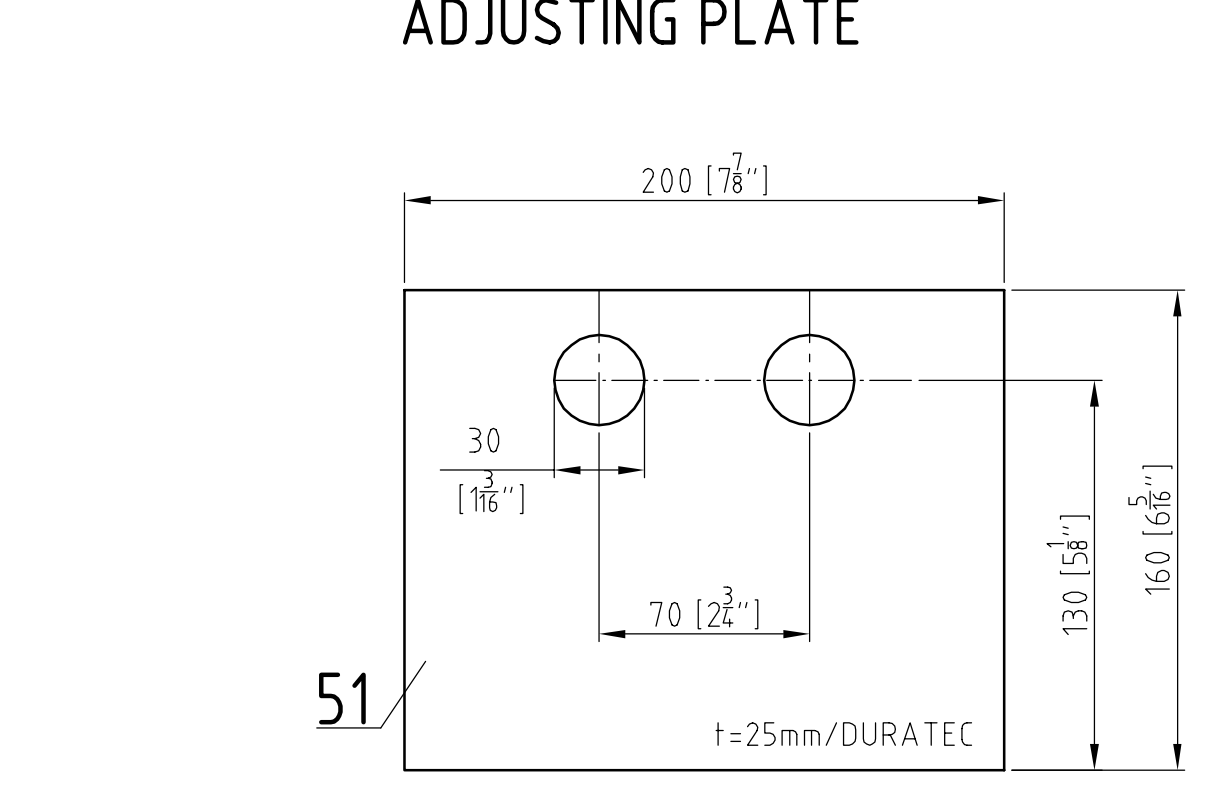
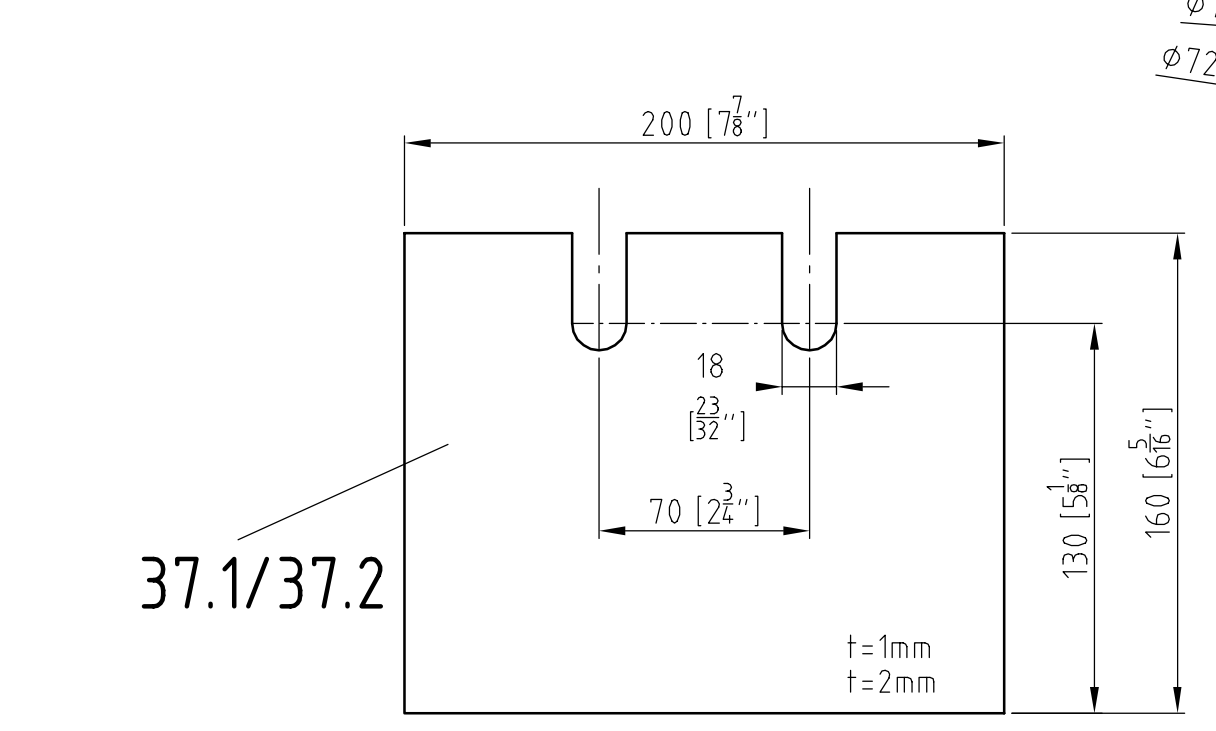
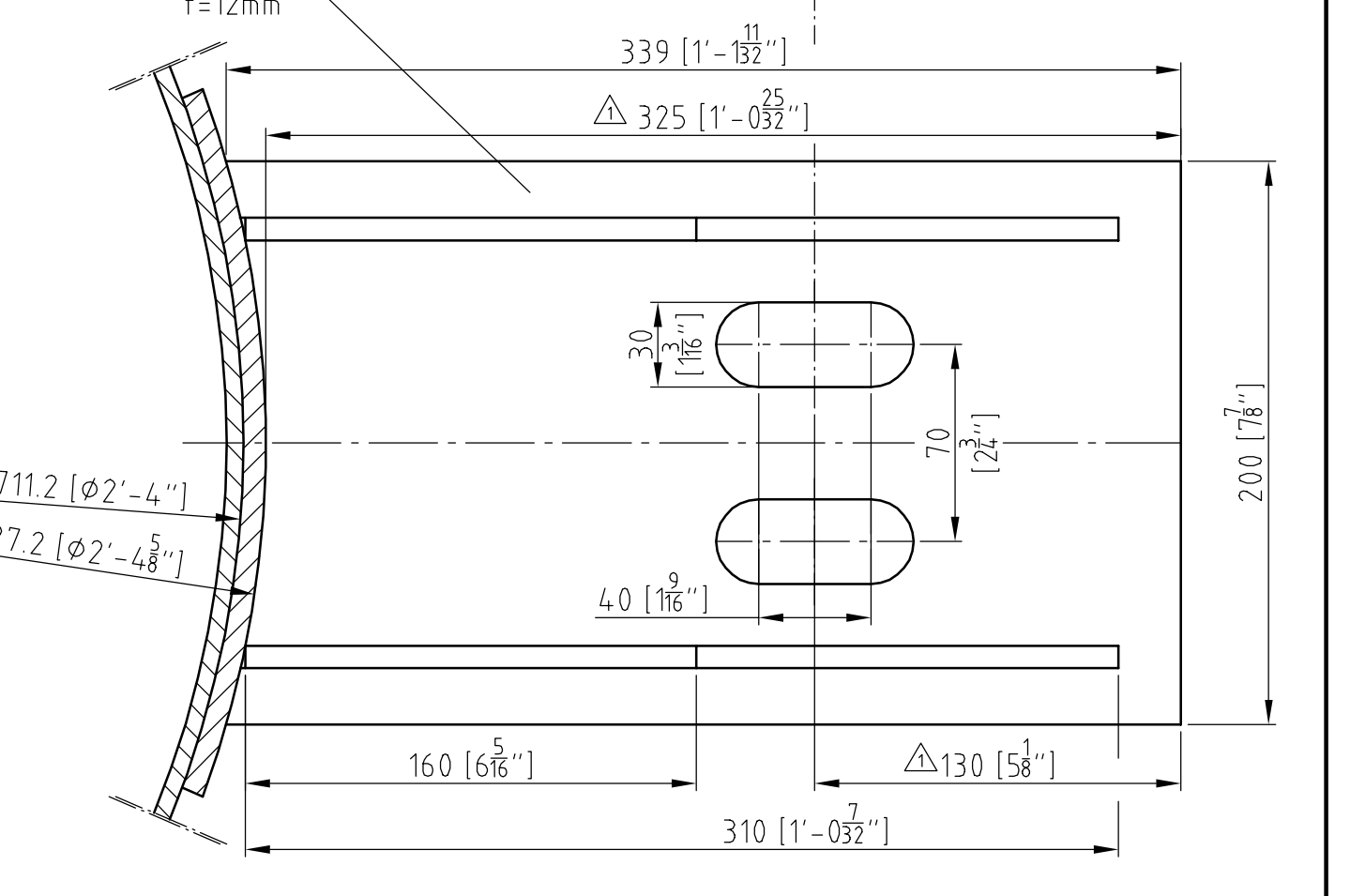
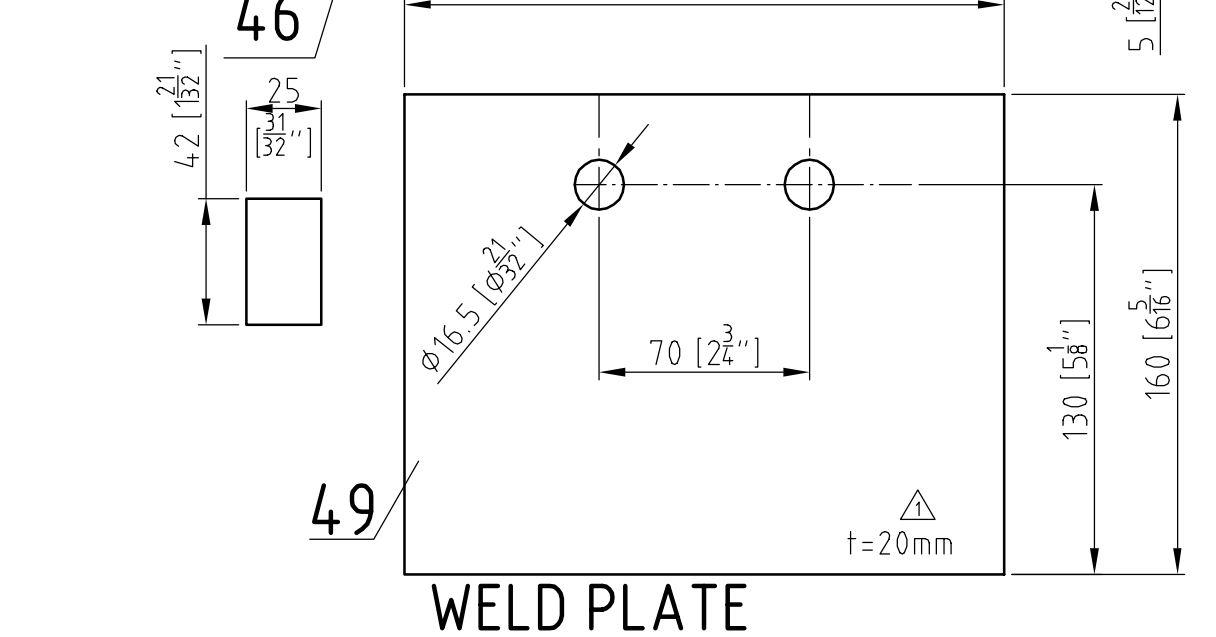
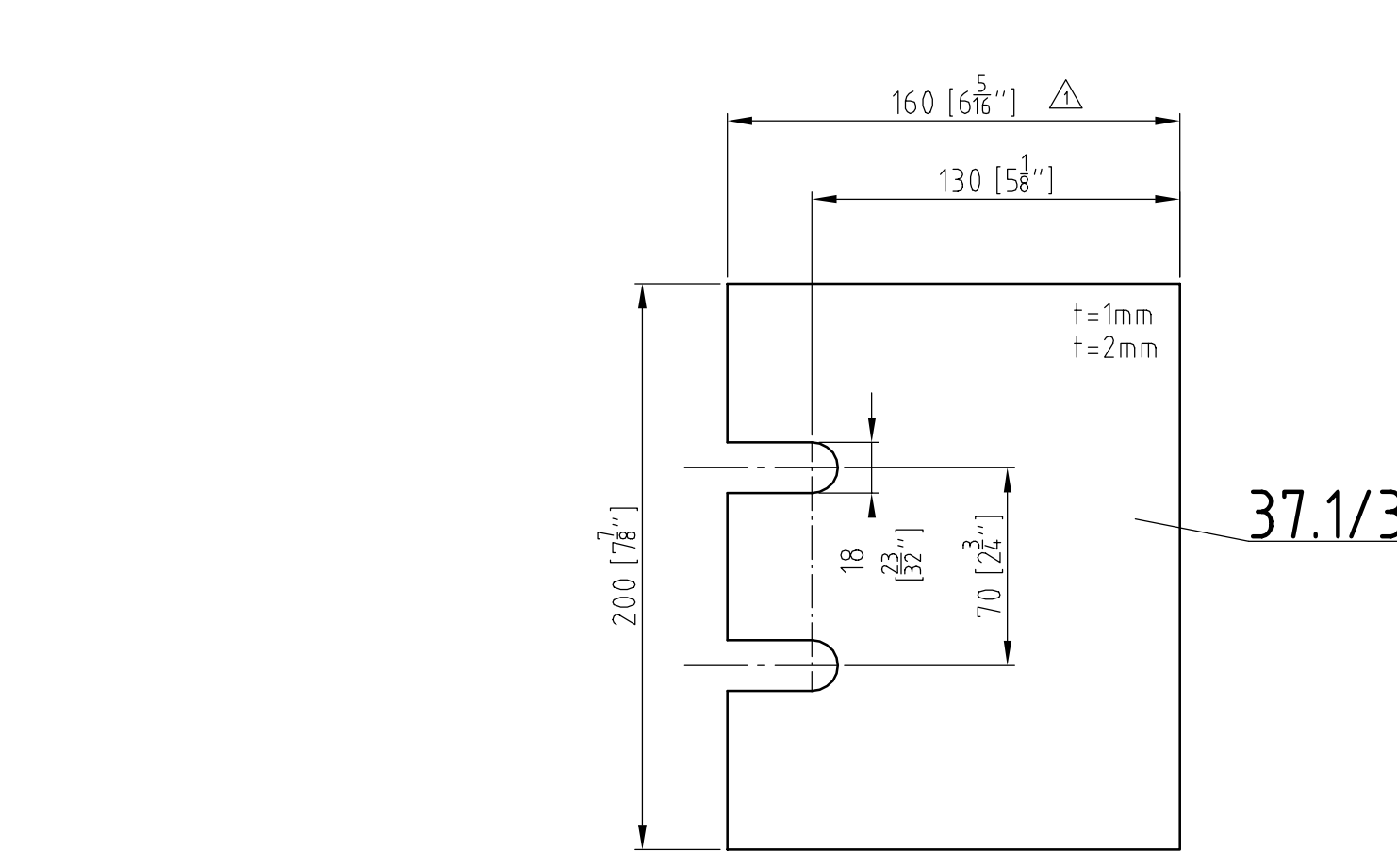
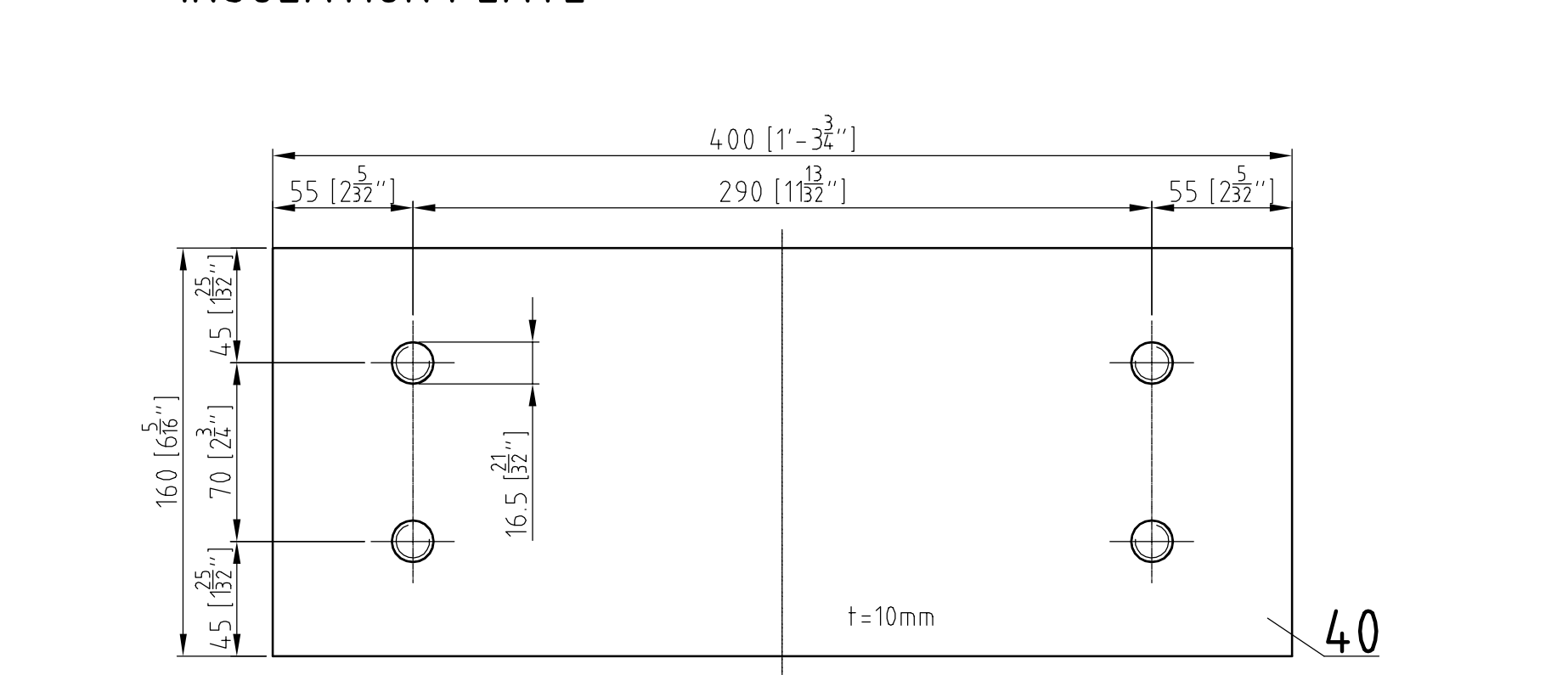
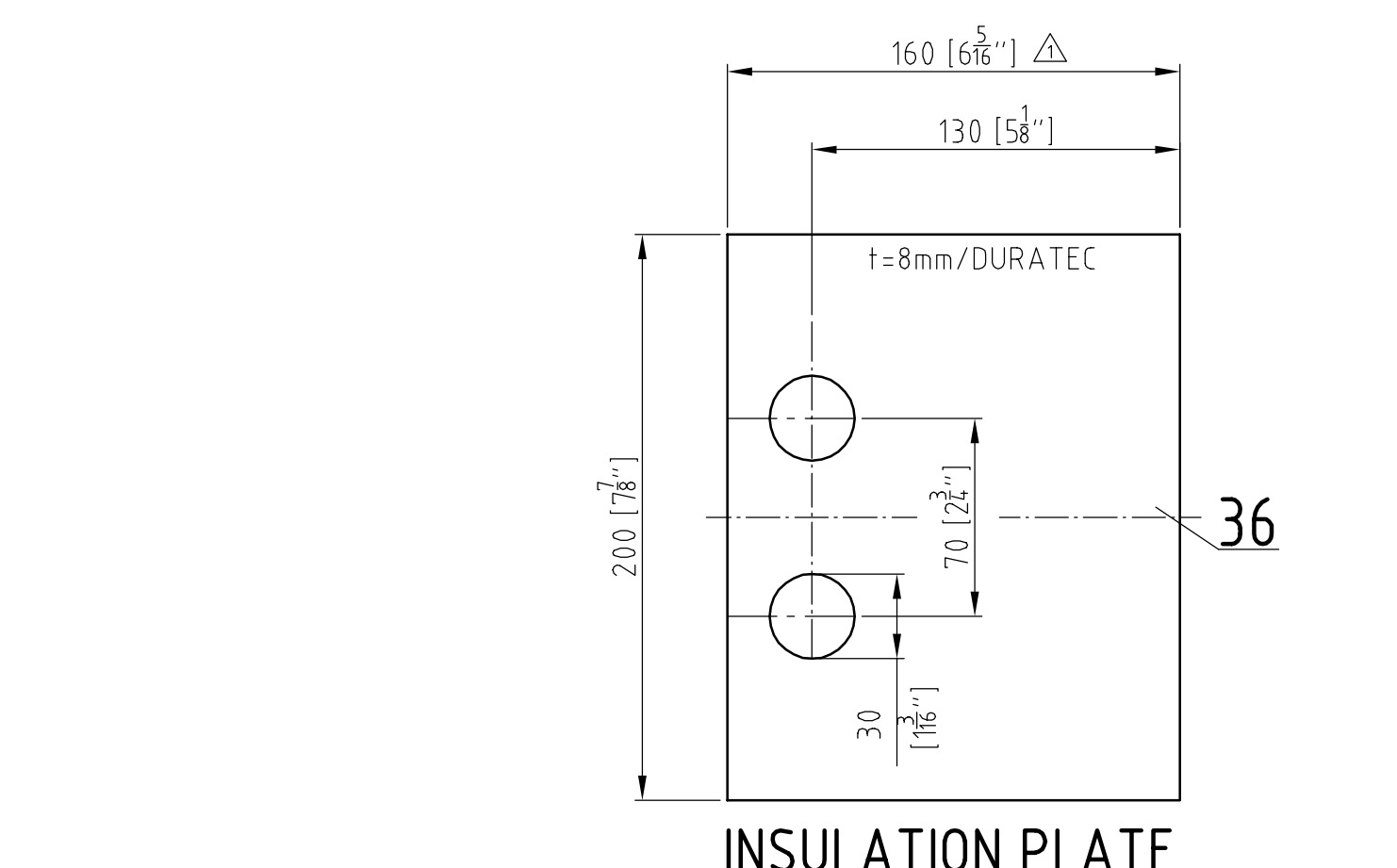
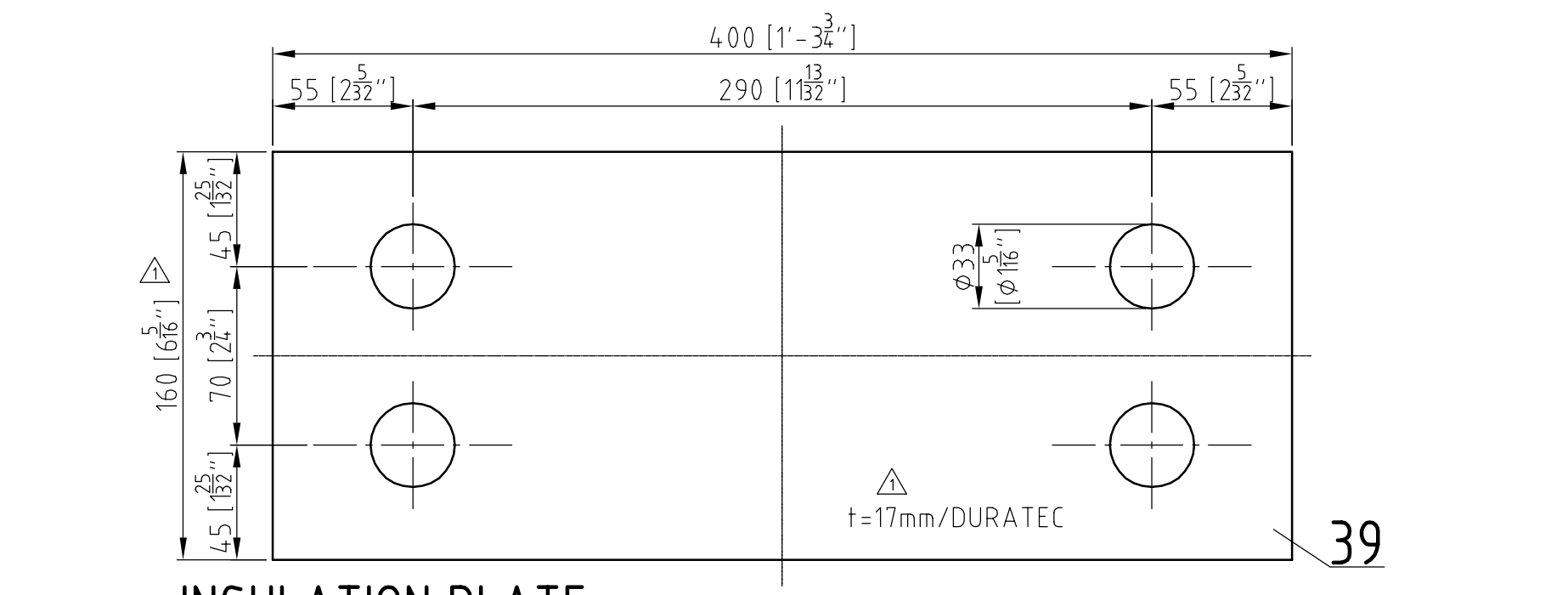
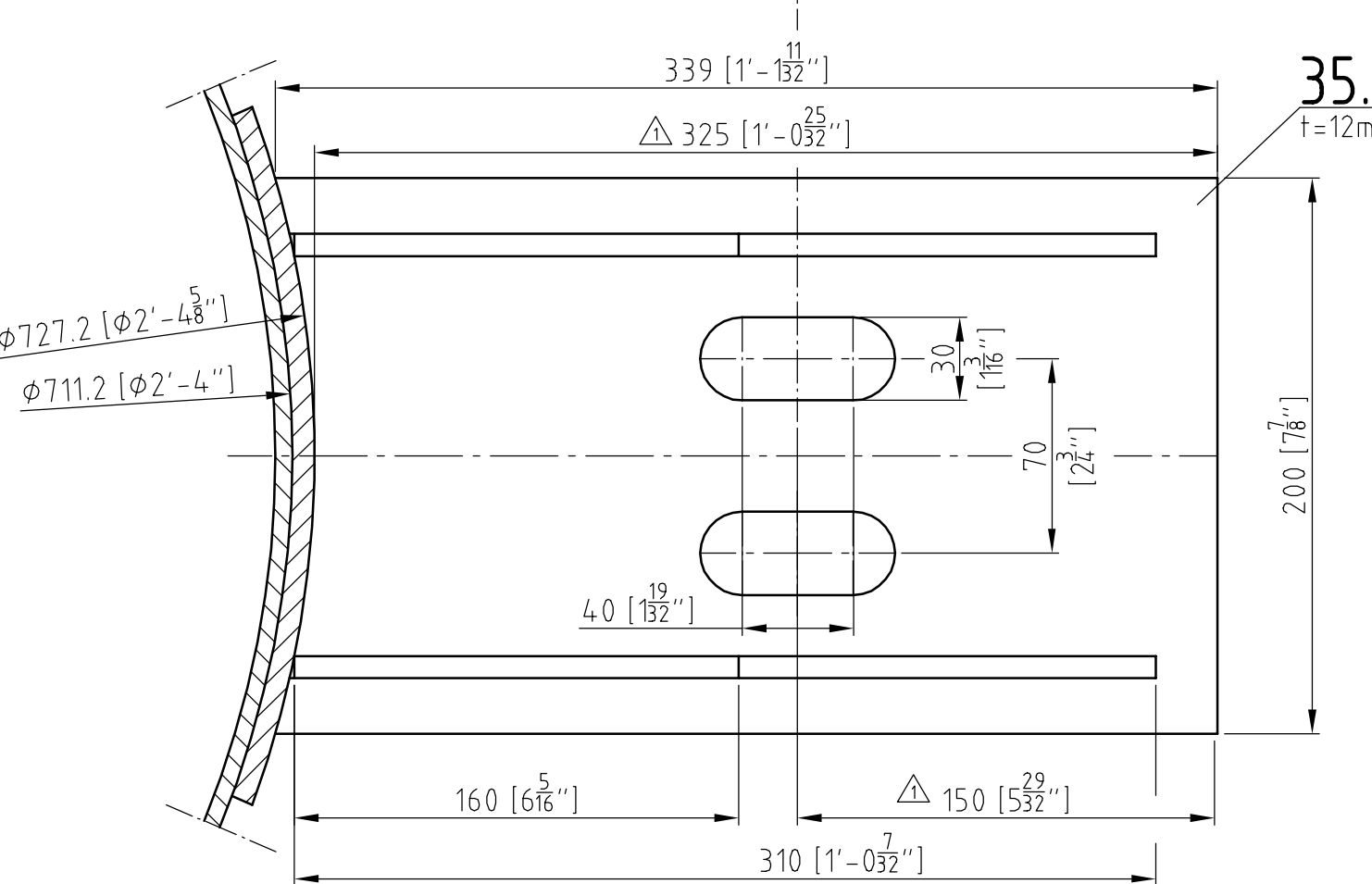
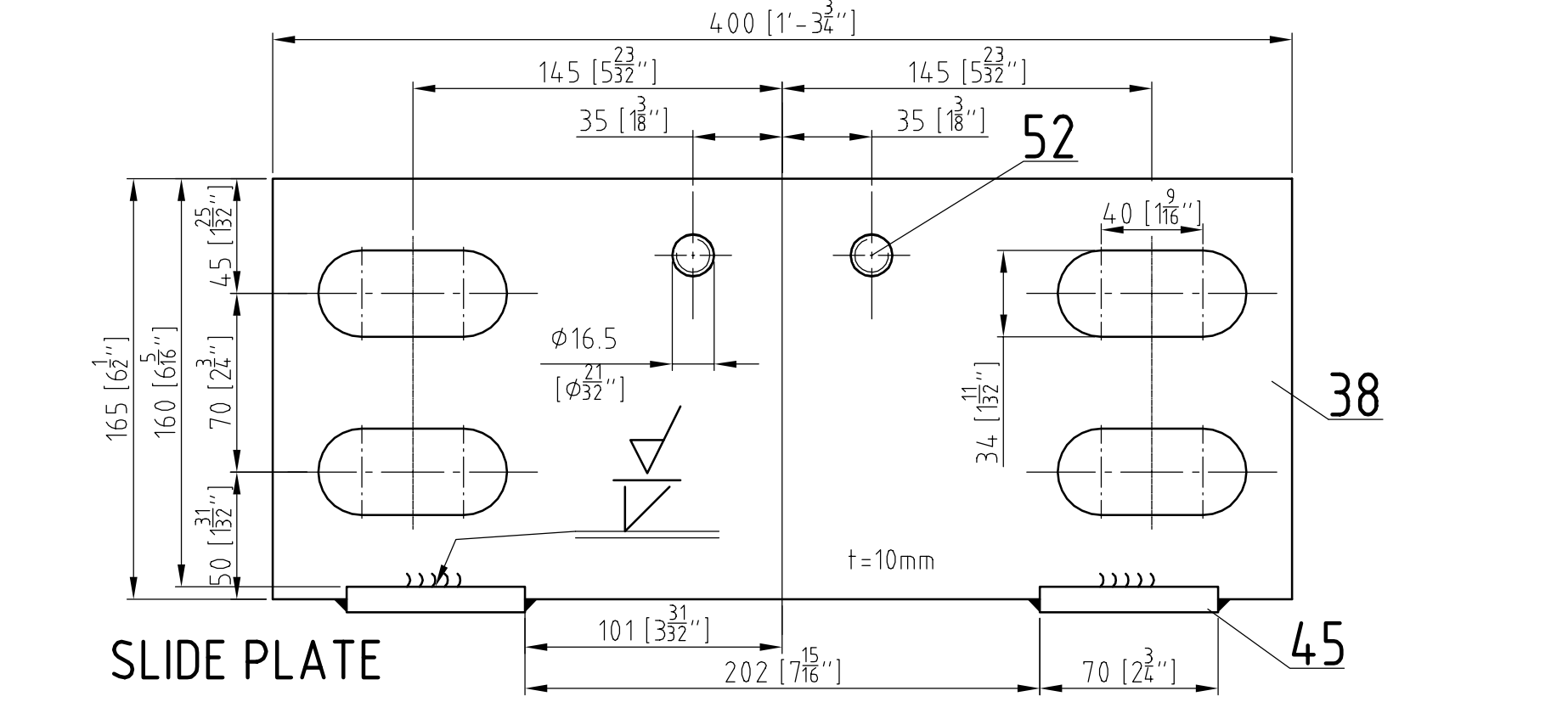
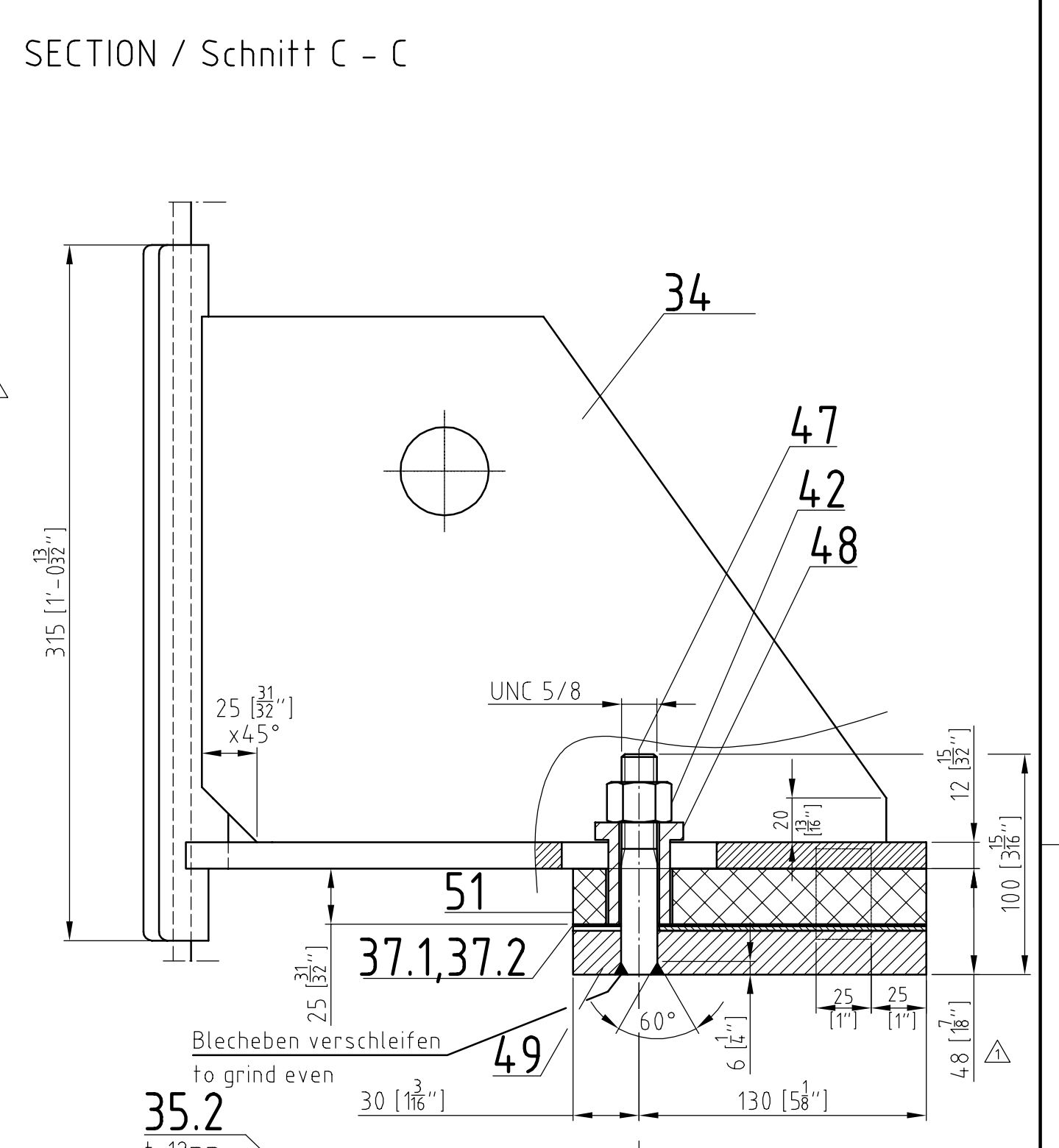
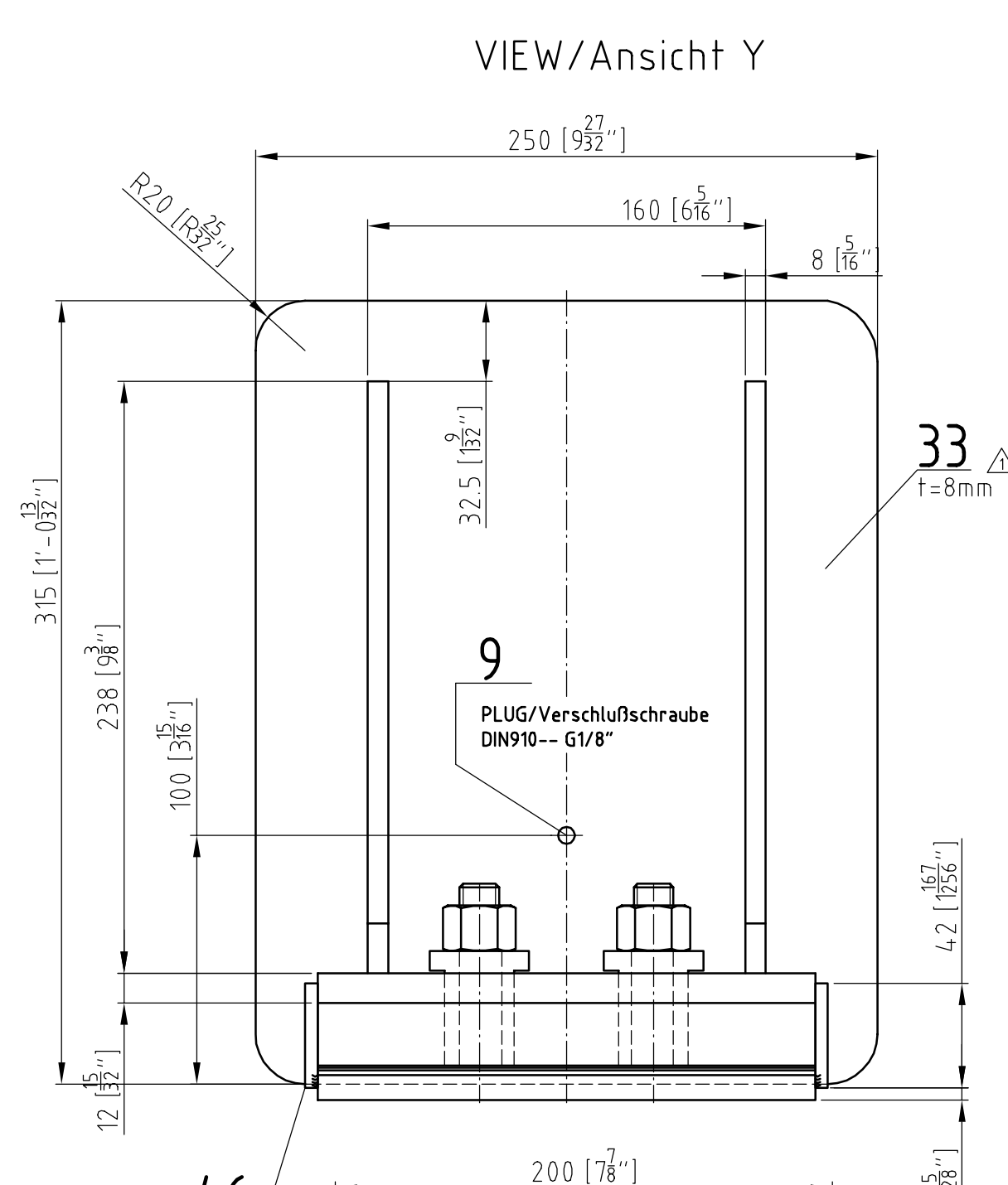
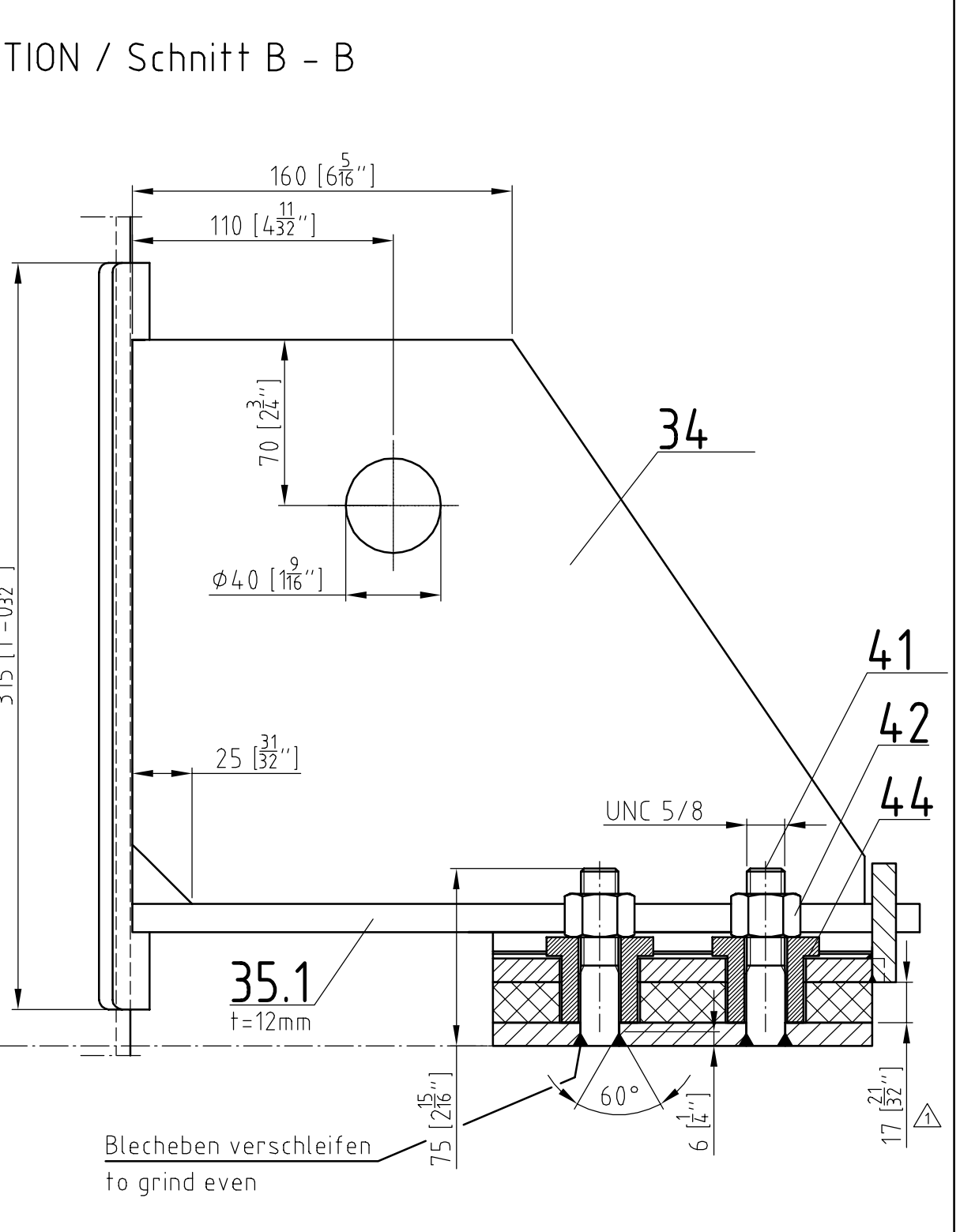
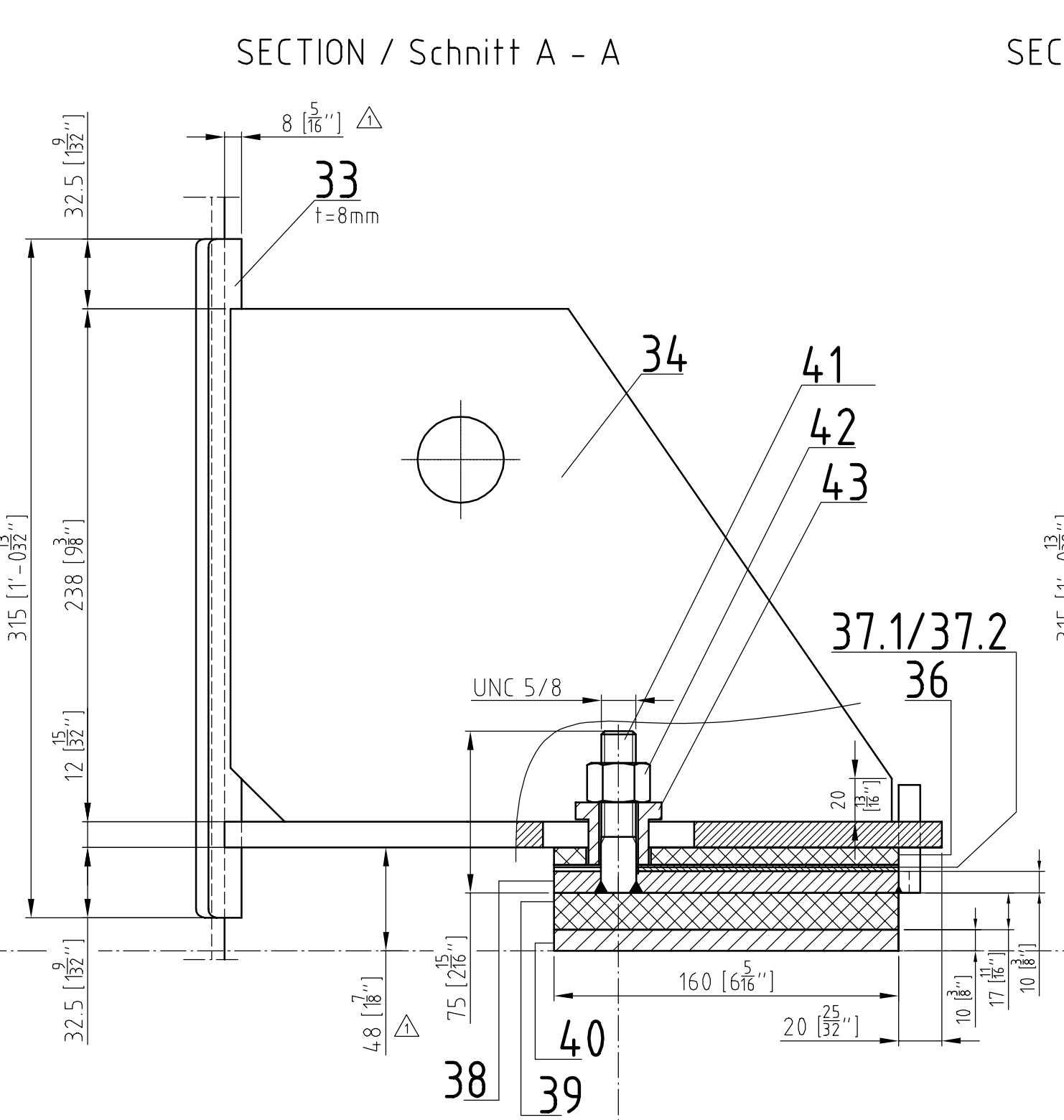
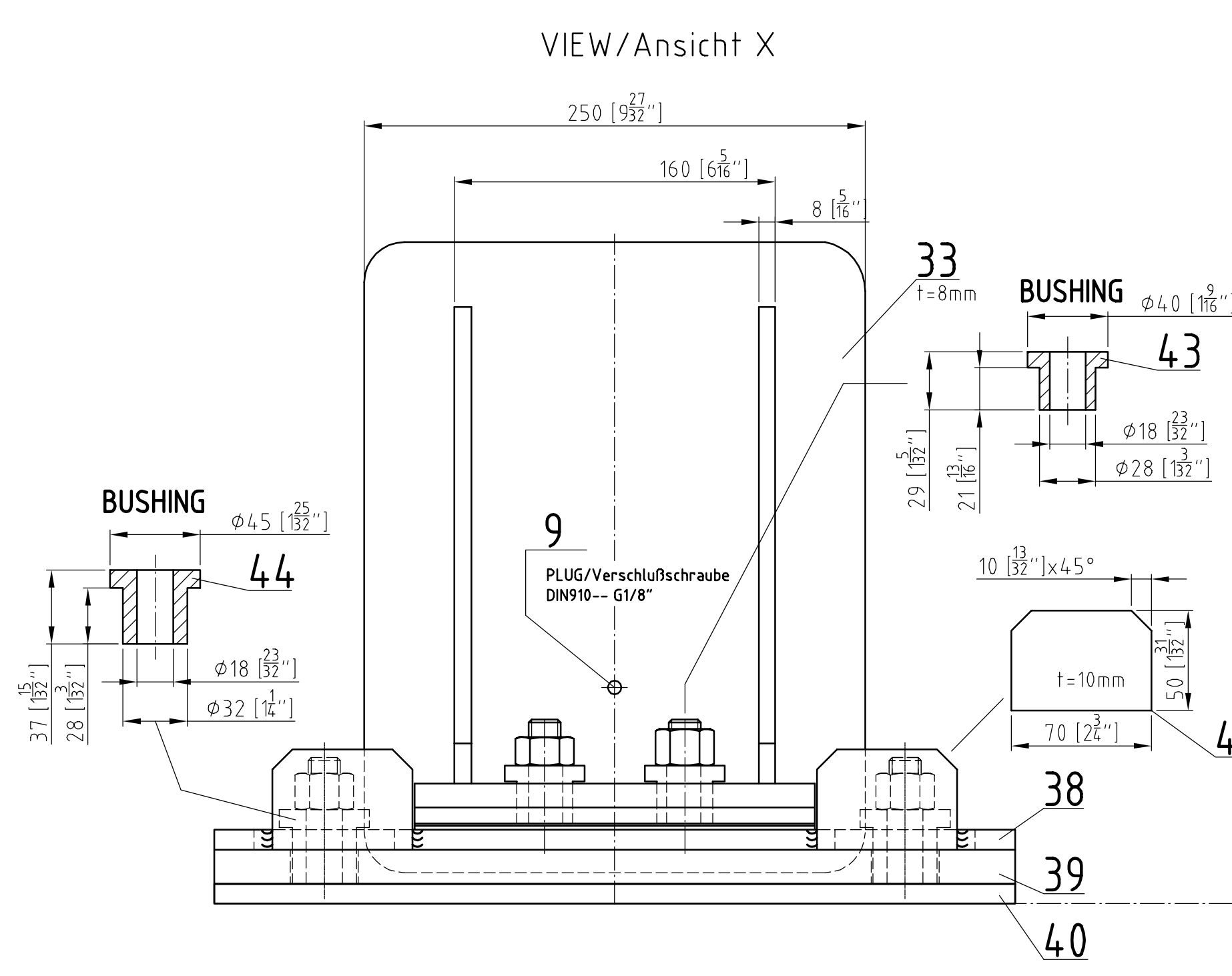
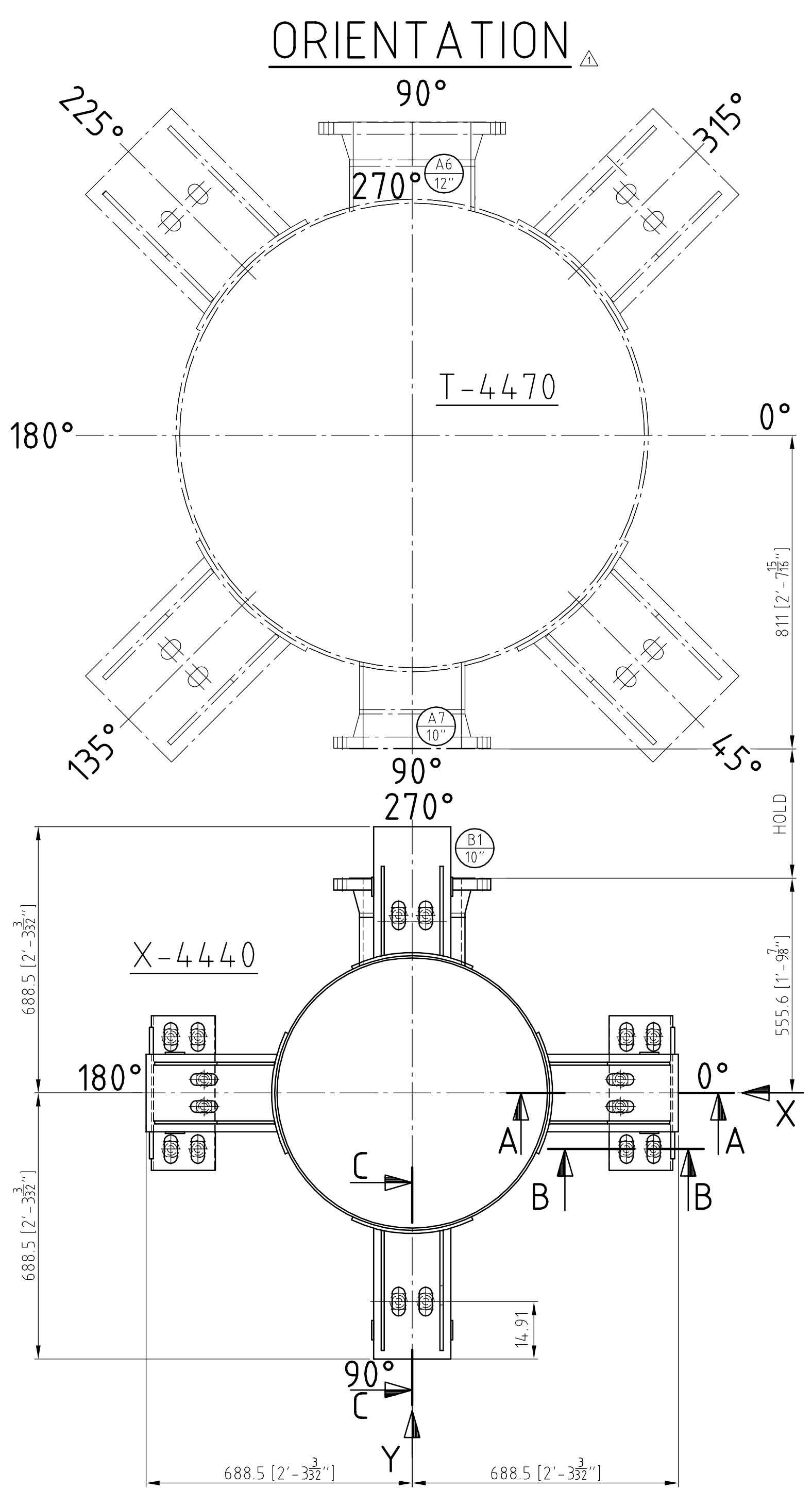
DESIGNATION/Bezeichnung	
DESIGNATION/Bezeichnung	ACA RESIDUE BOTTOMS SEPARATOR V-4430 / LAYOUT

DWG NO./Zeichnung Nr.	
DWG NO./Zeichnung Nr.	214-0451-18-001



SUPPORTS AT 0°/180°
IN DEPENDENCE ON EVONIK TS 25-0801-2

SUPPORTS AT 90°/270°
BASED ON TS 25-0801-2 / SIZE-4



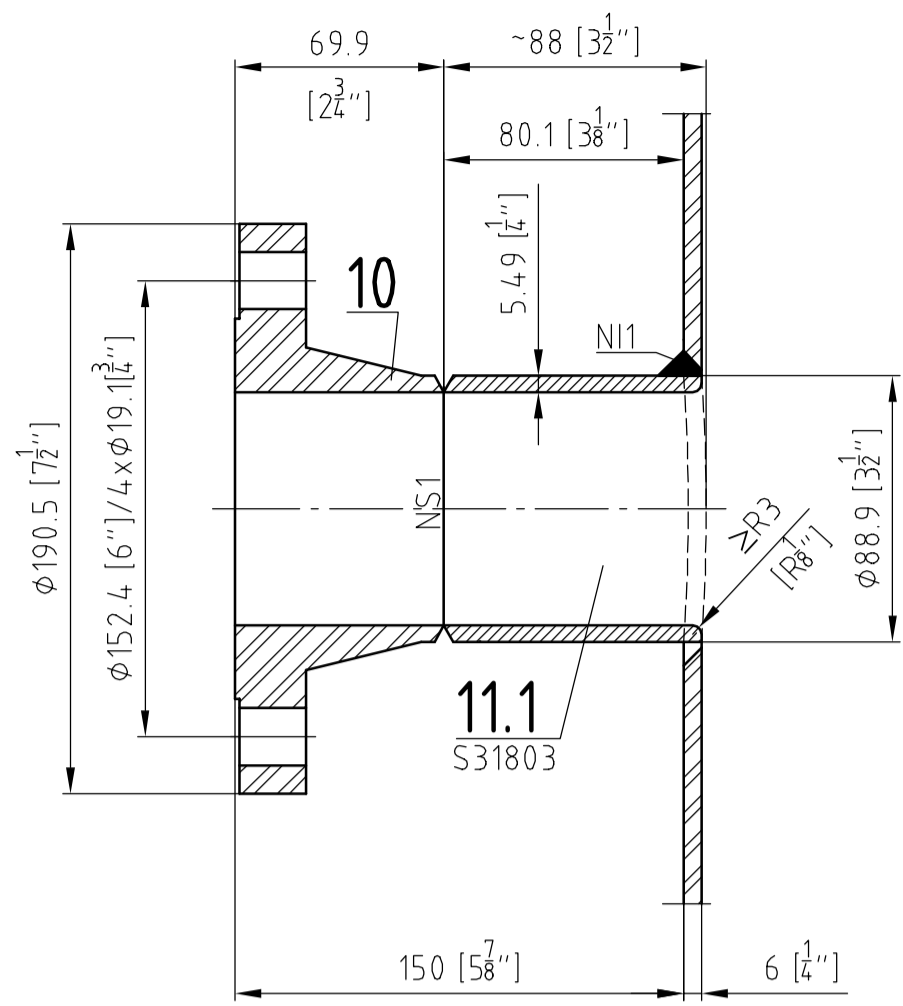
SEALING SURFACE
Ra 3.2 (Rz 12.5)
125 AARH

DATA/WELDING DETAILS SEE DRAWING 214-0451-18-001
PARTS LIST 214-0451-18-101 PARTS LIST

REVISION	DATE	NAME	CHECKED	DATE	NAME	MPER'S ORDER NO./MPER'S SERIAL NO.	YEAR BUILT
01	15.09.15	Gesche				214-0451-18	2015
02	03.08.15	Gesche					
DATE/ Datum	NAME/ Name	WE RESERVE US ALL RIGHTS FOR THIS OWN THIS ONE MAY NOT BE COPIED, NOR BEING ACCESSIBLE TO THIRD PERSONS, NOR PROVIDED IN ANOTHER WAY BY RECEIVER OR THIRD PERSONS.					
DRAWN	03.03.15	Gesche					
DATE/ Datum	NAME/ Name	WE RESERVE US ALL RIGHTS FOR THIS OWN THIS ONE MAY NOT BE COPIED, NOR BEING ACCESSIBLE TO THIRD PERSONS, NOR PROVIDED IN ANOTHER WAY BY RECEIVER OR THIRD PERSONS.					
SCALE/ Maßstab	1:5	DESIGNATION/ Benennung	214-0451-18-002				
		ACA RESIDUE BOTTOMS SEPARATOR V-4430 / DETAIL II					

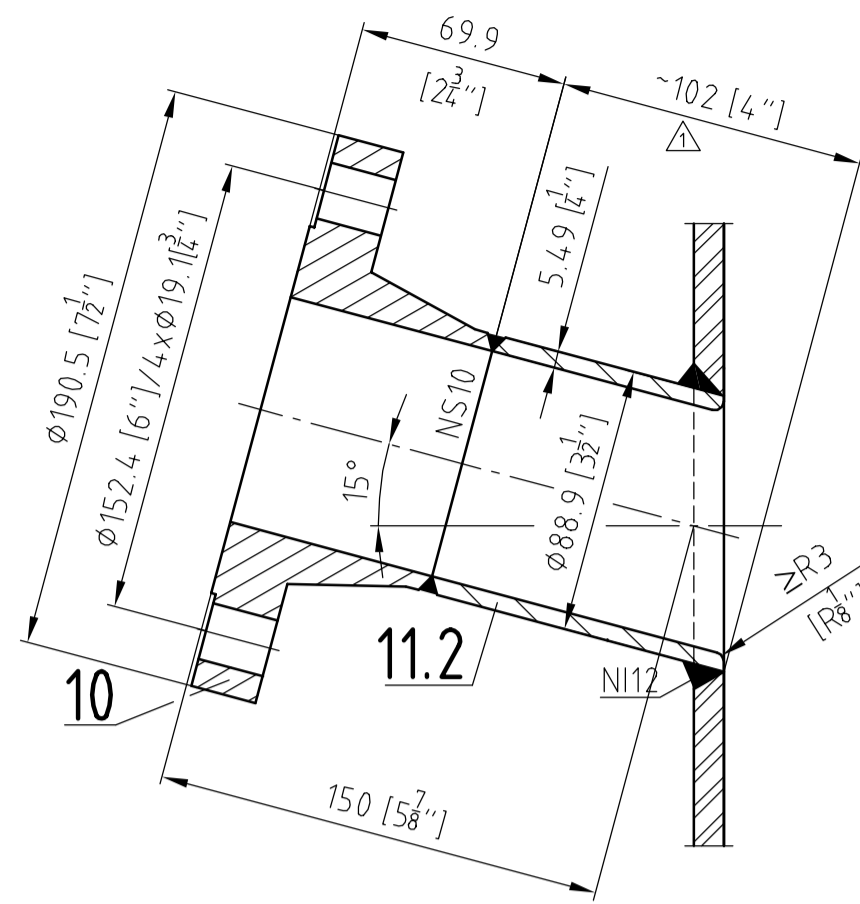
NOZZLE L2-L3

ANSI B16.5 - 3" - 150lb/sq.in. - RF



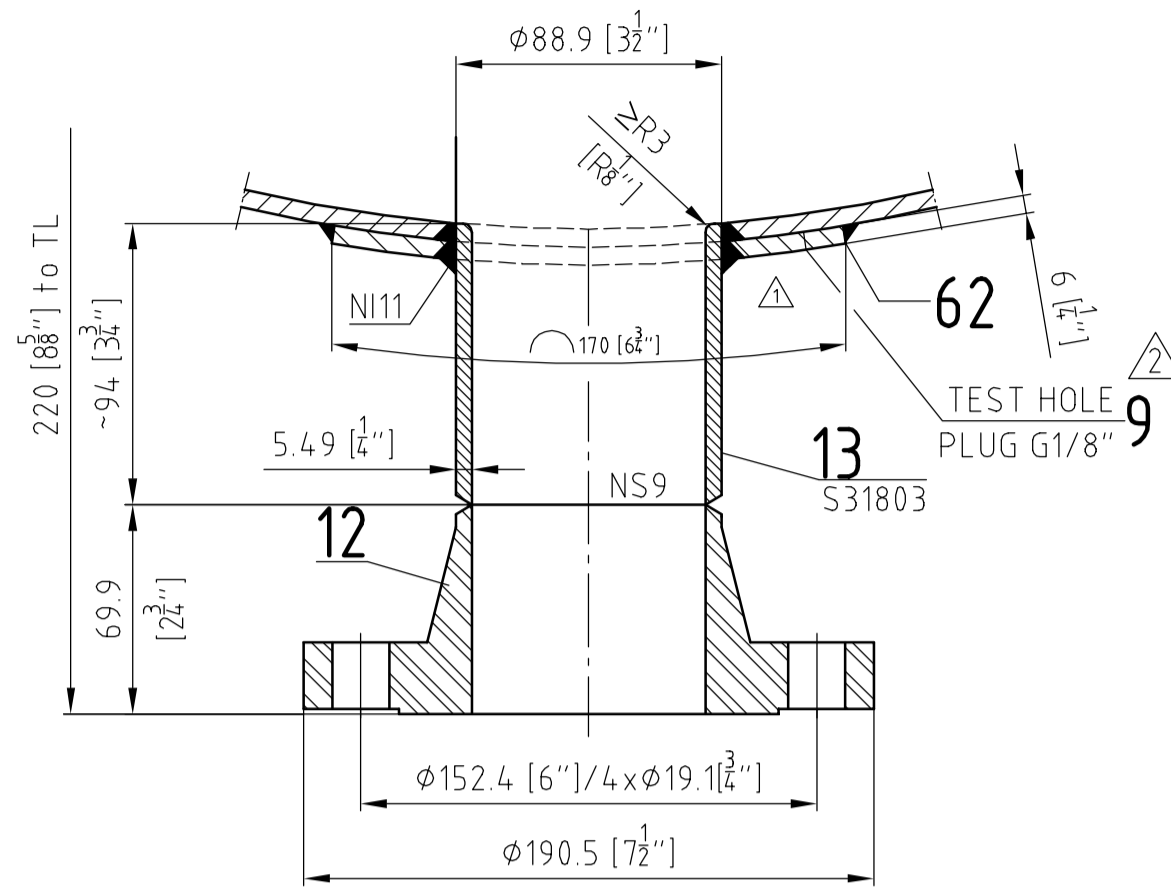
NOZZLE L1

ANSI B16.5 - 3" - 150lb/sq.in. - RF



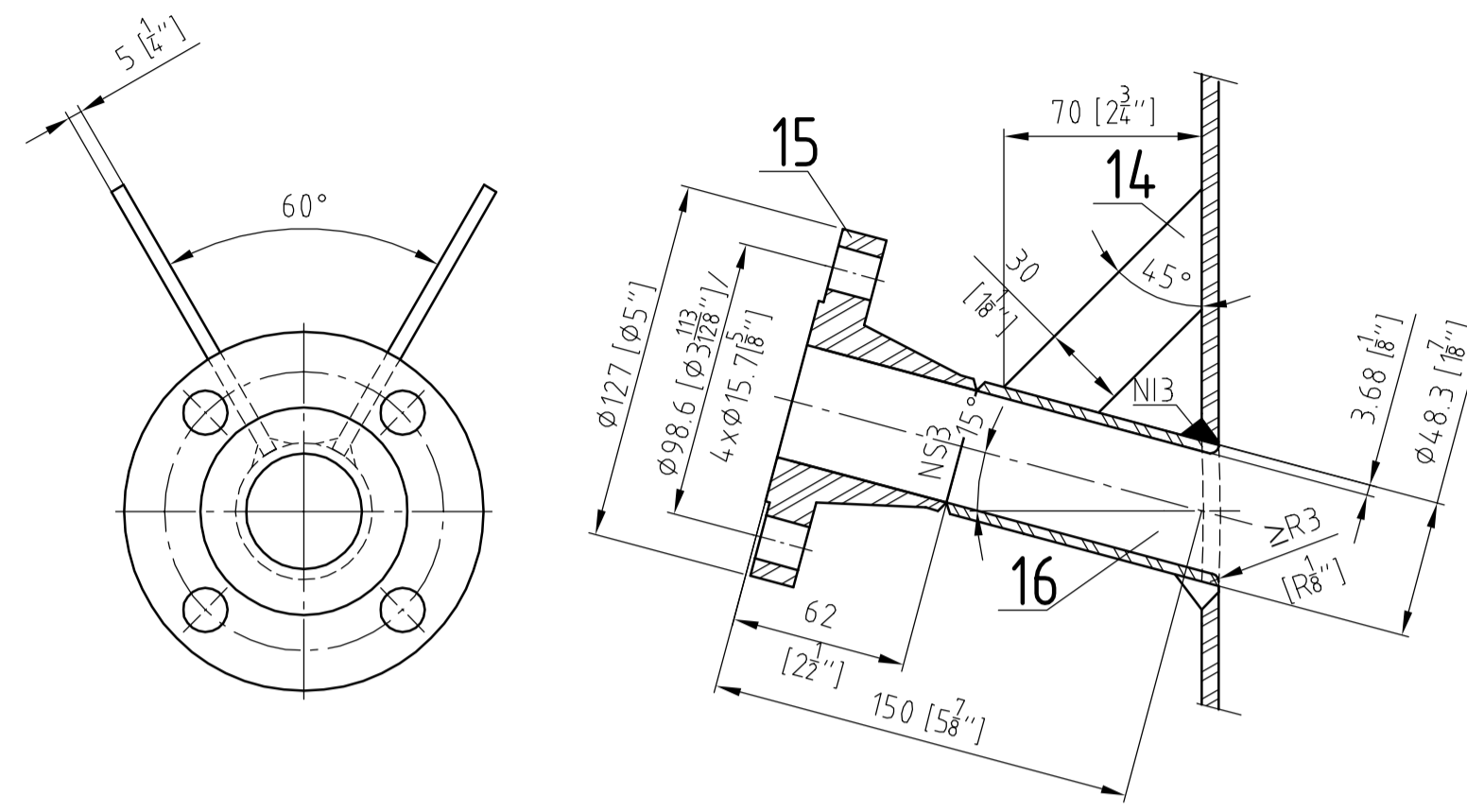
NOZZLE B2

ANSI B16.5 - 3" - 150lb/sq.in. - RF



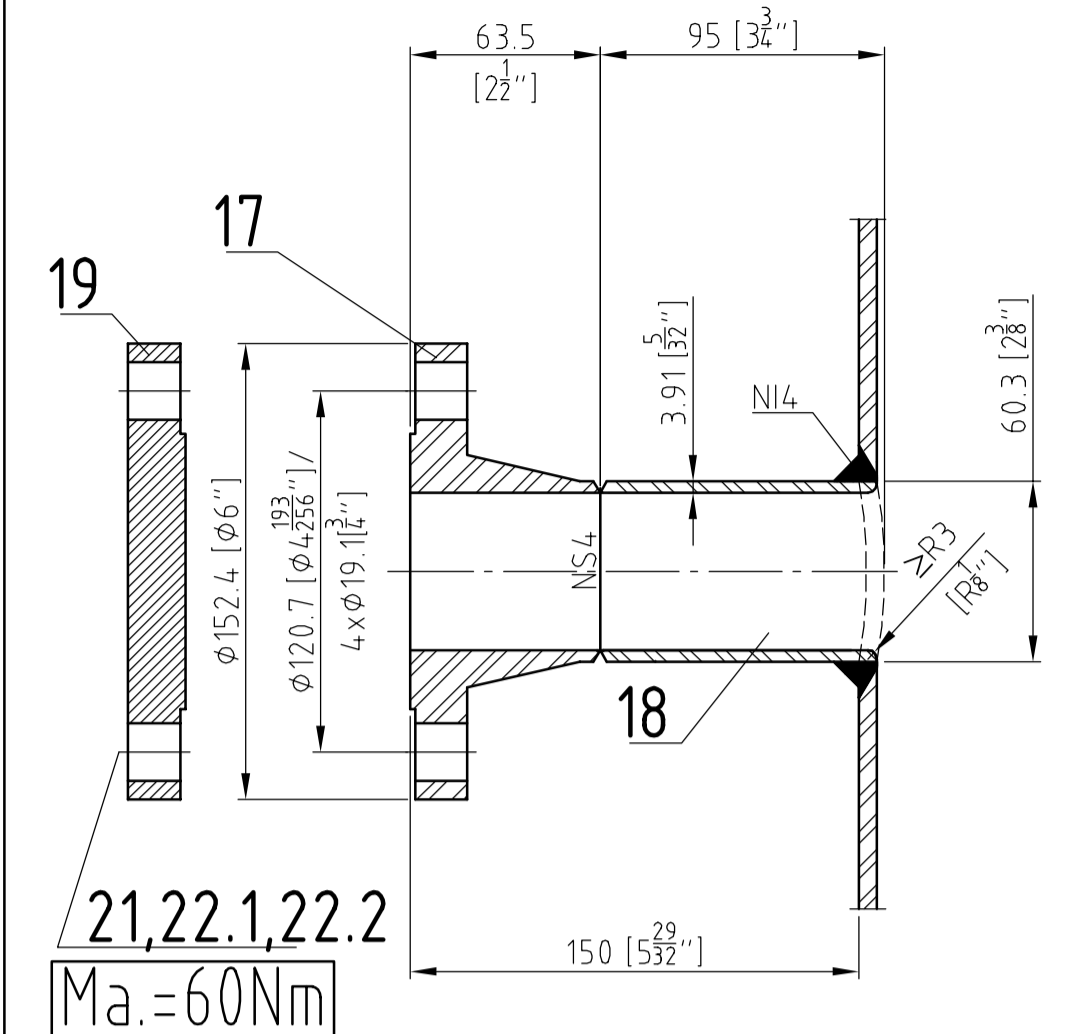
NOZZLE T1

ANSI B16.5 - 1/2" - 150lb/sq.in. - RF



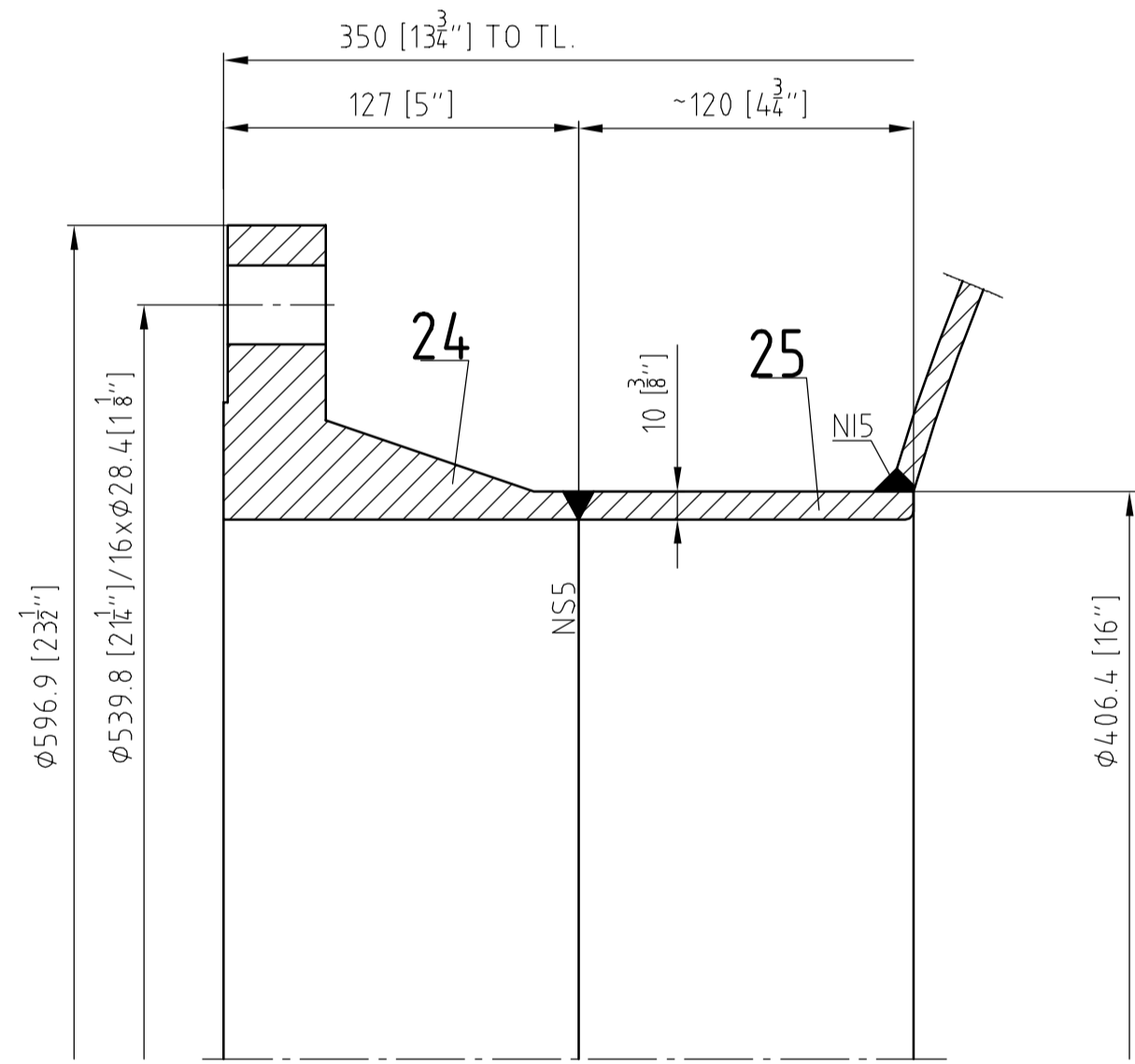
NOZZLE S1-S2

ANSI B16.5 - 2" - 150lb/sq.in. - RF



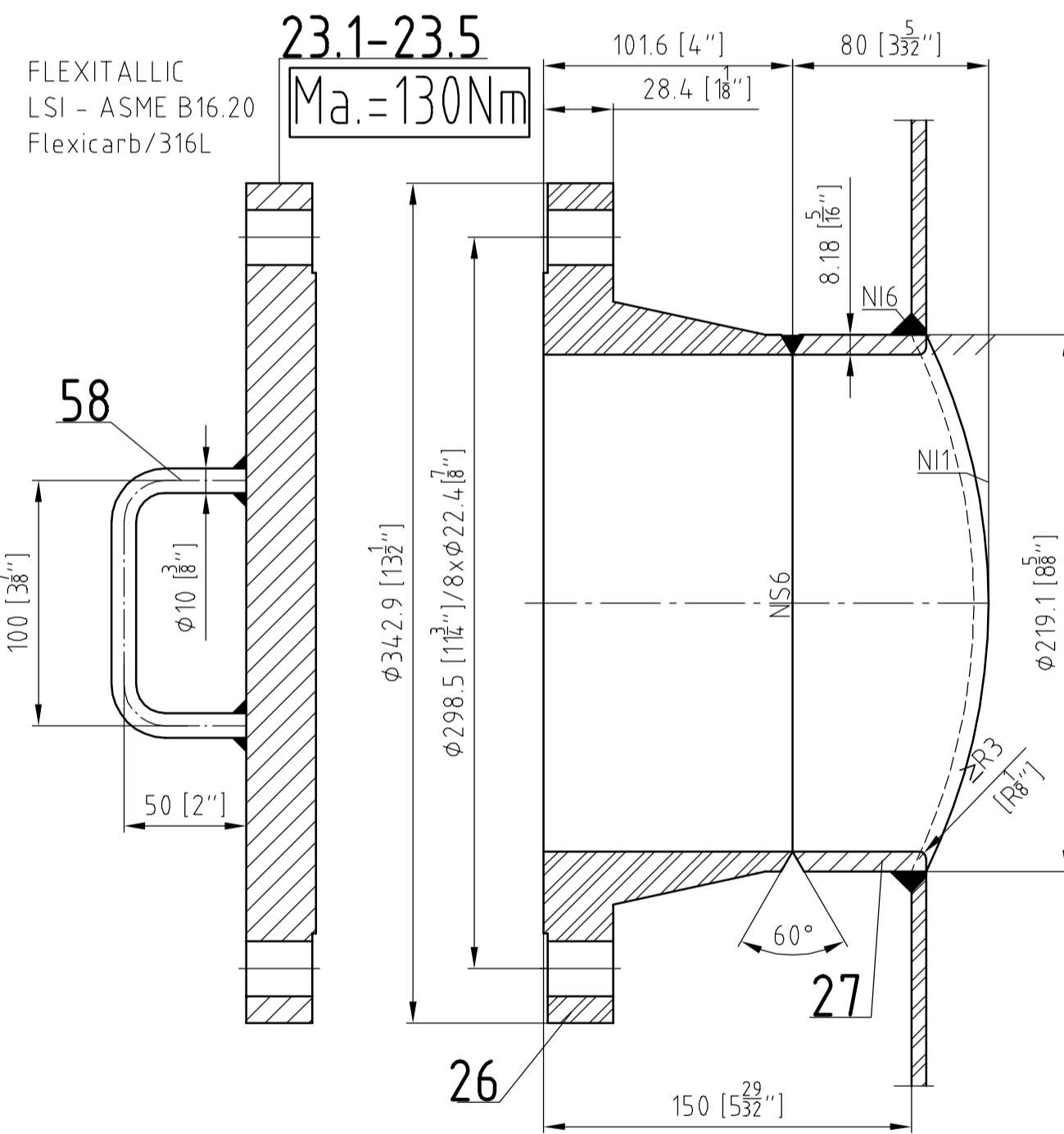
NOZZLE Z1

ANSI B16.5 - 16" - 150lb/sq.in. - RF



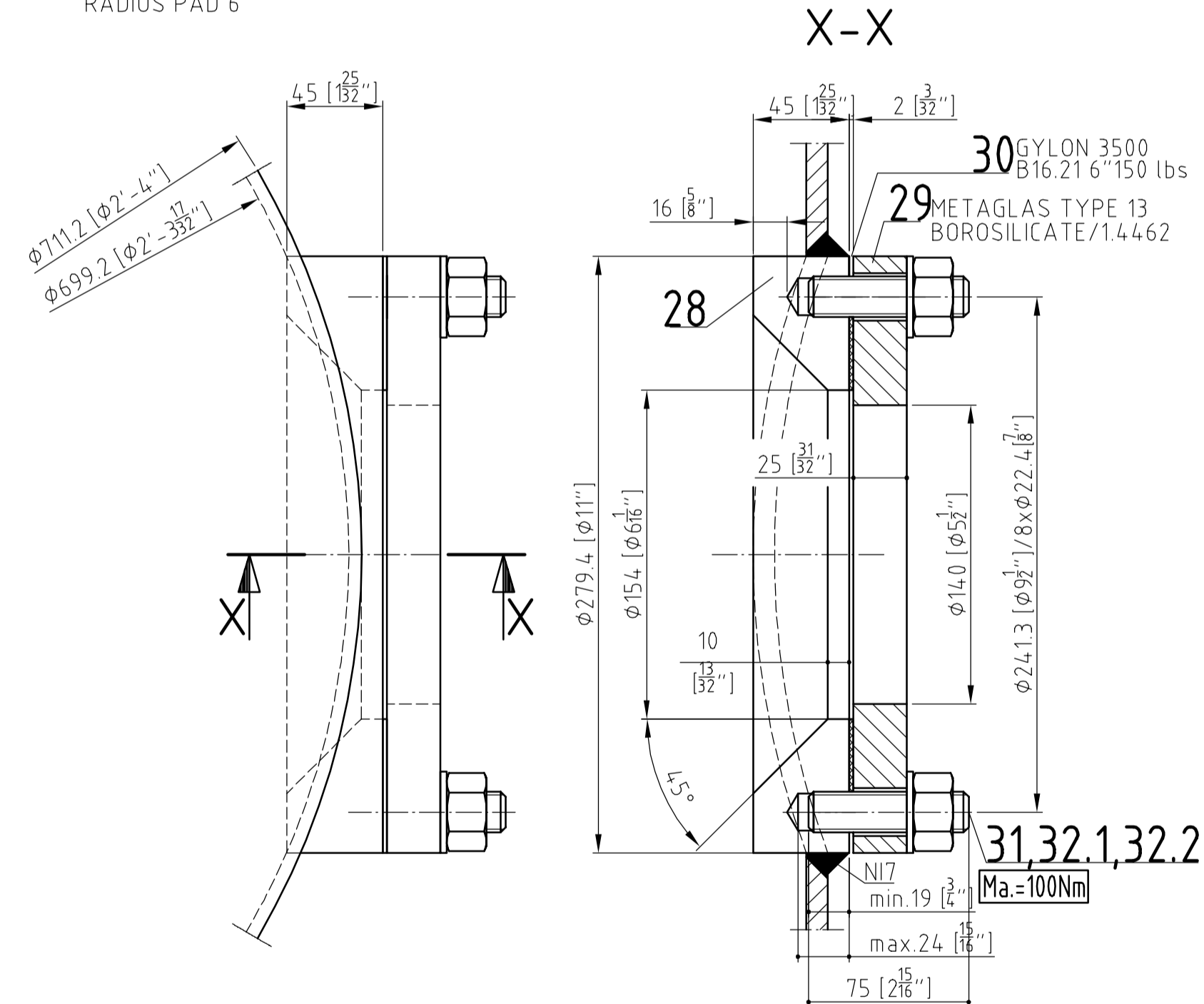
HANDHOLE H1

ANSI B16.5 - 8" - 150lb/sq.in. - RF



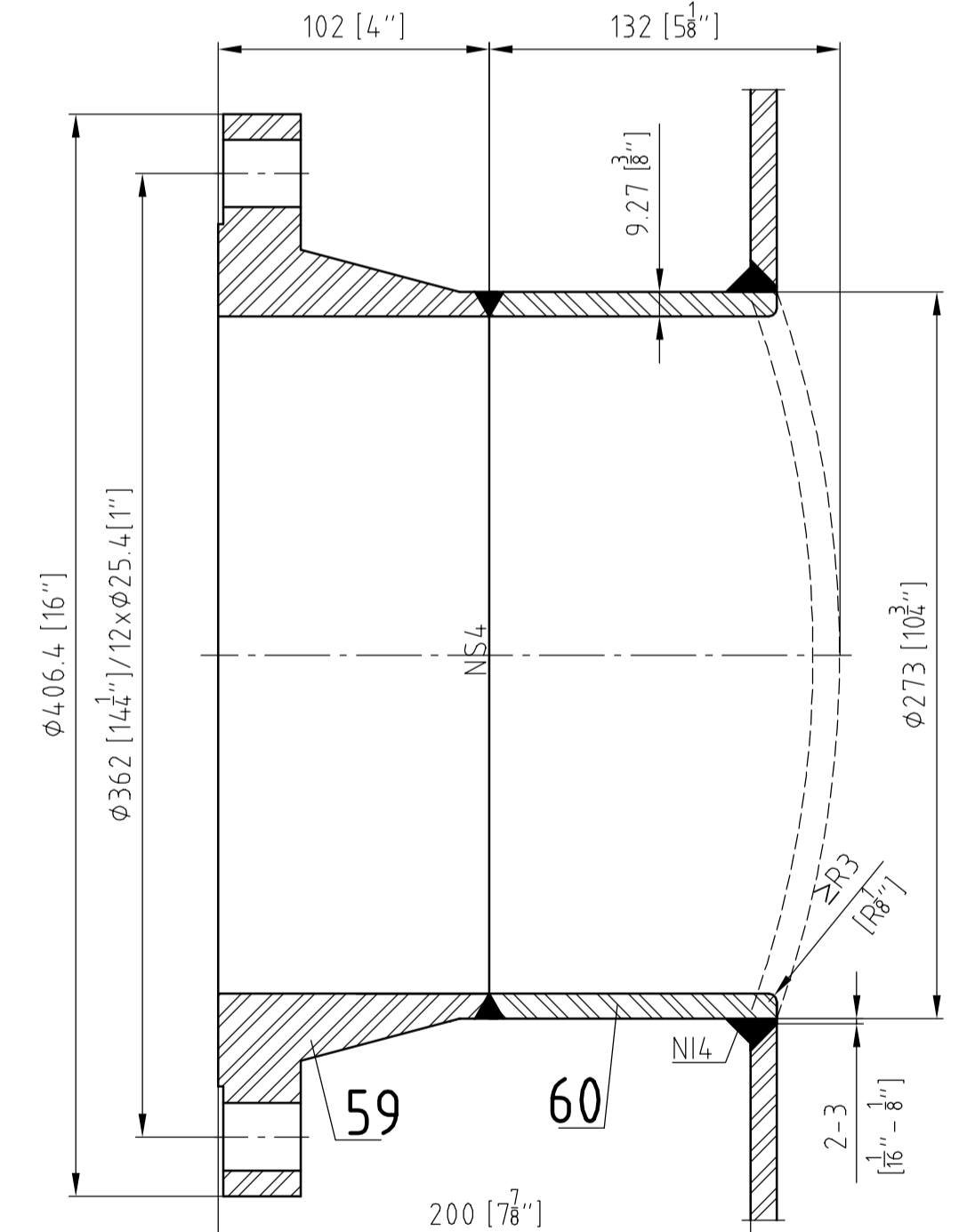
SIGHT GLASS G1

RADIUS PAD 6"



NOZZLE B1

ANSI B16.5 - 10" - 150lb/sq.in. - RF



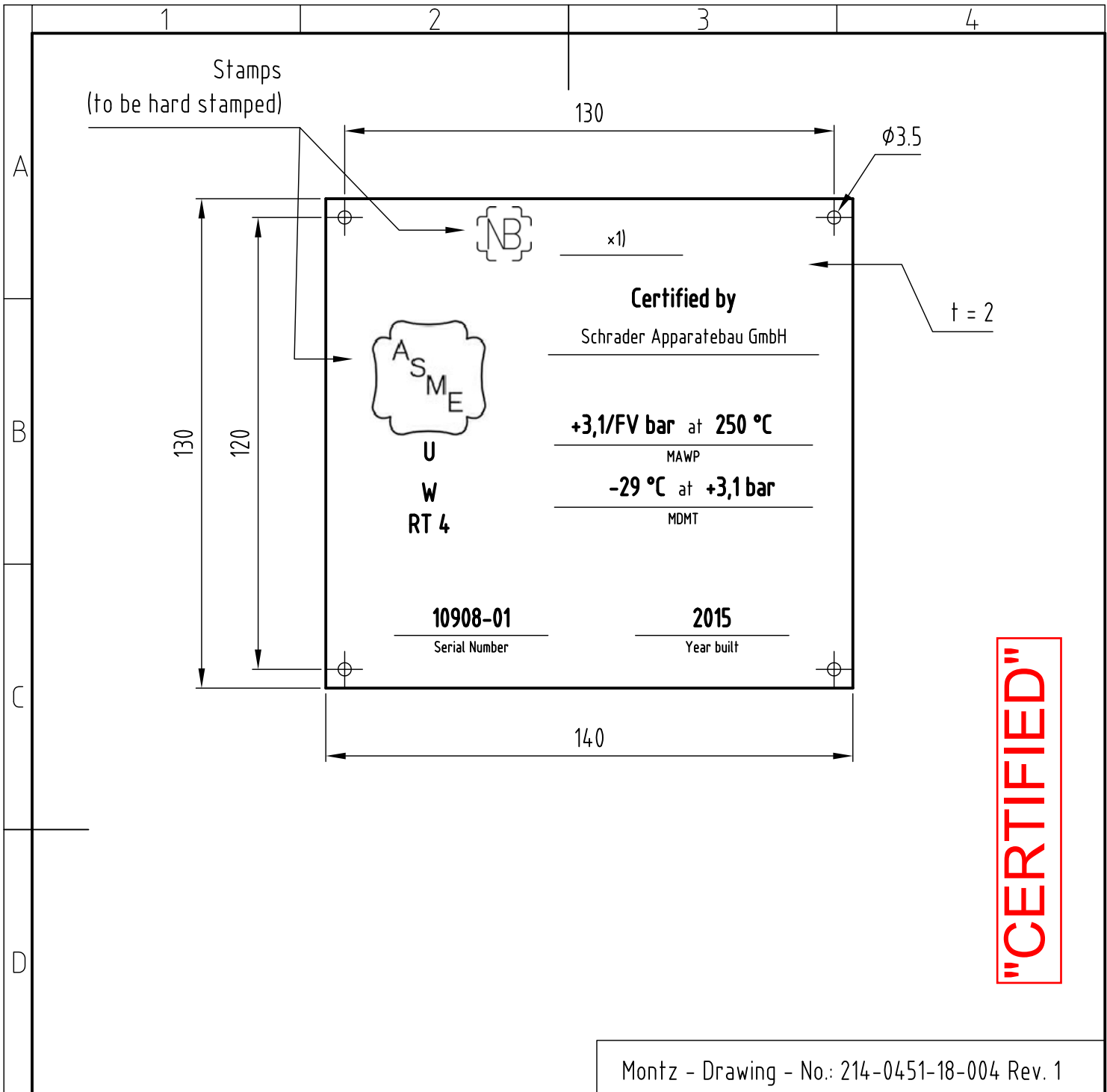
SEALING SURFACE

Ra 3,2 (Rz 12,5)
125 AARH

DATA/WELDING DETAILS SEE DRAWING 214-0451-18-001
PARTS LIST 214-0451-18-101 PARTS LIST

TEST HOLE		13.11.15	Giesen	214-0451-18		2015
Remarks EVONIK		03.08.15	Giesen			
REV.	REVISION	DATE	Name	CHECKED	DATE	NAME
Änderung	Datum	Datum	Name	Geprüft	Datum	Name
DATE/Datum			NAME/Name			WE RESERVE US ALL RIGHTS FOR THIS DWG. THIS DWG MAY NEVER BE COPIED NOR BEING ACCESSIBLE TO THIRD PERSONS. NOR MISUSED IN ANOTHER WAY BY RECEIVER OR THIRD PERSONS.
DRAWN	30.03.15	Giesen				
Gepr.	31.03.15	Maier				
Norm						
WELD CHECKED		Schweißnachgepr.				
SCALE/Maßstab	1:5	DESIGNATION/Benennung	ACA RESIDUE BOTTOMS SEPARATOR V-4.430 / DETAIL I	DWG NO./Zeichnung Nr.	214-0451-18-003	
			JULIUS MONTZ GmbH		APPARATEBAU ENGINEERING VERFAHRENTECHNIK D-40723 Hilden	
			MONTZ intern. Vermerk			

MONTZ & WERKZEUGE US PATENT #6,178,073 & #7,287,747 - MONTZ-PAK-UP-DWG US PATENT #6,235,445 - MONTZ-FLANNOCK US-PATENT #5,834,435 - MONTZ-PARTIALLY FLOORED PACKING US-PATENT #7,052,000



Montz - Drawing - No.: 214-0451-18-004 Rev. 1

Change radiographic examination (RT3 to RT 4)			19.11.2015			Haertel			
Art der Aenderung / kind of revision			Datum			Name			
Aenderungen / revisions									
CAD Zeichng. darf nicht manuell geaendert werden			Schutzvermerk n. DIN ISO 16016 beachten protection mark acc. to DIN ISO 16016						
Auftrag Order		A15 / 10908			 Schleebergstr. 12 • D-59320 Ennigerloh Tel.: +49 (0) 2524 266 0 • Fax: +49 (0) 2524 266 50 E Mail: info@schrader.de • Internet: www.schrader.de				
Zchnng. Drawng.		10908-01099		Revision 1					
Ers. fuer				Maßstab scale 1:1.5					
ers. durch				Benennung/Denomination Name Plate Material : SA240 - 304L				Blatt sheet 1	
		Datum/date						Name	
gez./drwd.		05.10.2015		Haertel		1			
gepr./appr.		05.10.2015		Poppenborg		A4			
Project :									