

**MAJOR COMPONENT DESIGN DATA**

VESSEL DESIGNED PER THE 2013 EDITION OF THE ASME CODE SECTION VIII DIVISION 1, N/A ADDENDA.  
 CODE STAMP: IS REQ'D SERIAL NO: 5612-12 NATIONAL BOARD NO: 3094  
 DESIGN PRESSURE INTERNAL: 75 PSI @ 300 DEG F  
 DESIGN PRESSURE EXTERNAL: 15 PSI @ 300 DEG F  
 HYDRO TEST (SHOP): 98 PSI  
 MAWP: 75 PSI @ 300 DEG F  
 MAP: 75 PSI @ 70 DEG F  
 MDMT: -20 DEG F PWHT: NOT REQ'D  
 CORROSION ALLOWANCE: 0"  
 RADIOGRAPH: HEAD/SHELL: SPOT UW-11(o)(5)(b)  
 SHELL CIRC: SPOT UW-11(o)(5)(b)  
 SHELL LONG: FULL UW-11(a)  
 ESTIMATED WEIGHT: FABRICATION: 7,260 LBS (BARE VESSEL WT)  
 EMPTY: 10,251 LBS  
 TEST: 26,072 LBS  
 OPERATING: 13,803 LBS  
 INSULATION: 2" FIREPROOFING: NONE INSPECTION BY: ONECIS

**MATERIAL SPECIFICATIONS**

SHELL SA-240-316 FLANGES SA-182-F316 125-250 AARH  
 HEADS SA-240-316 SUPPORTS SA-240-316  
 CPLGS. SA-182-F316 INTERNALS SEE DETAILS  
 STUDS SA-193-B8 REINF. PADS SA-240-316  
 NUTS SA-194-B8 NOZZLE NECKS SA-182-F316/SA-312-TP316  
 GASKETS 1/8" FLEXITALLIC "CG", 316SS WOUND, FLEX GRAPHITE FILLED, C.S. OUTER RING.

**WELDING PROCEDURES**

WPS No.	COMMENT

**COATING REQUIREMENTS**

STAINLESS - NO COATING REQUIRED

**GENERAL NOTES**

- 1) ALL FLANGE FACES SHALL BE CLEANED AND COVERED FOR SHIPMENT
- 2) APPLY A SUITABLE RUST PREVENTATIVE TO GASKET SURFACES.
- 3) ALL WEEP HOLES SHALL BE PLUGGED WITH STIFF GREASE.
- 4) VESSEL SHALL BE DRY, THOROUGHLY CLEANED INSIDE AND OUTSIDE, AND FREE OF ALL DIRT, EXCESS OIL, AND LOOSE FOREIGN MATERIALS.
- 5) ALL FLANGE BOLT HOLES SHALL STRADDLE VESSEL CENTERLINES UNLESS OTHERWISE SHOWN OR NOTED.
- 6) FOR INTERNALS BY SULZER - SEE SULZER DWGS #9011151-02.

**NDE REQUIREMENTS**

MAGNETIC PARTICLE TESTING TEMPORARY ATTACHMENTS.  
 LIQUID PENETRANT TESTING N/A  
 ULTRASONIC EXAMINATION N/A  
 RADIOGRAPHIC EXAMINATION RT-2  
 PMI ALL STAINLESS MATERIAL

FILE NAME: 5612-12  
 PLOT DATE: 11/6/15  
 PLOT TIME: 3:00  
 BY: MLR

**PPI Professional Projects, Inc.**  
 P.O. BOX 618 (18115 TELGE RD.) CYPRESS, TEXAS 77429

TITLE 36" OD x 36'-0" S/S  
 ITEM: T-1120, AMINE STILL COLUMN  
**ELEVATION, PLAN, & GENERAL NOTES**

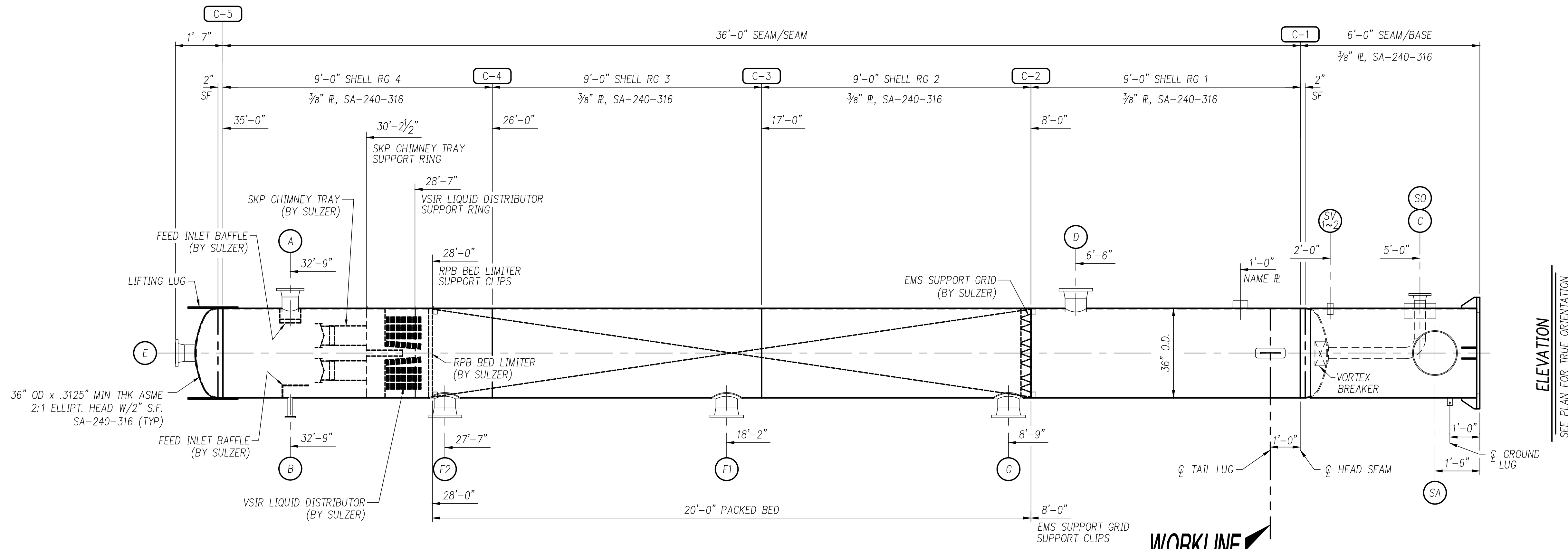
CUSTOMER INFRA TECHNOLOGY, LLC  
 HOUSTON, TEXAS

CUSTOMER P.O. NO. 13 PPI NO. 5612

DRAWN MLR DATE 11/6/15 CHECKED MUD DATE 11/6/15

DRAWING NO. SHEET NUMBER REVISION NO.

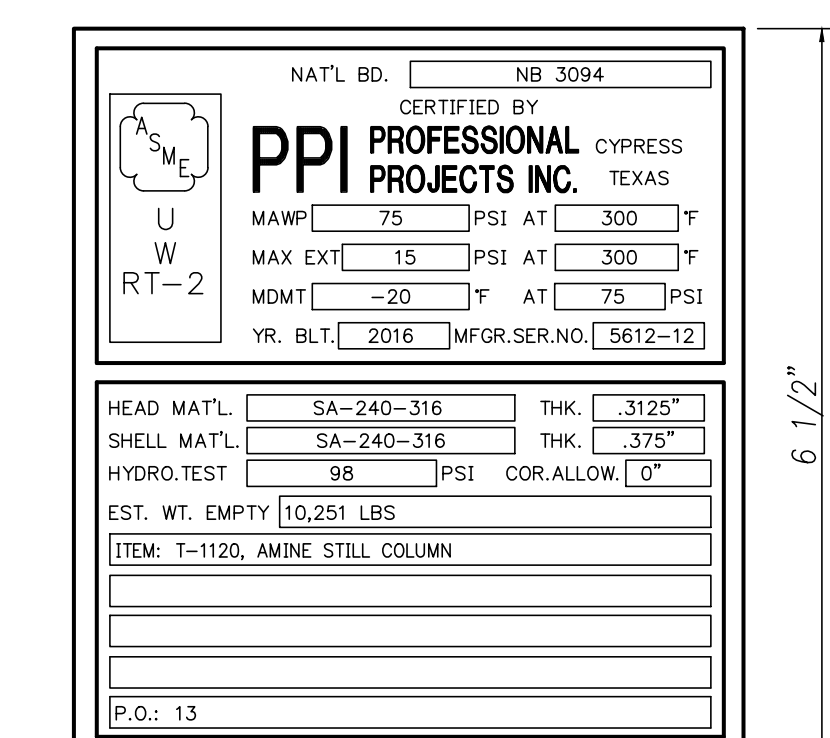
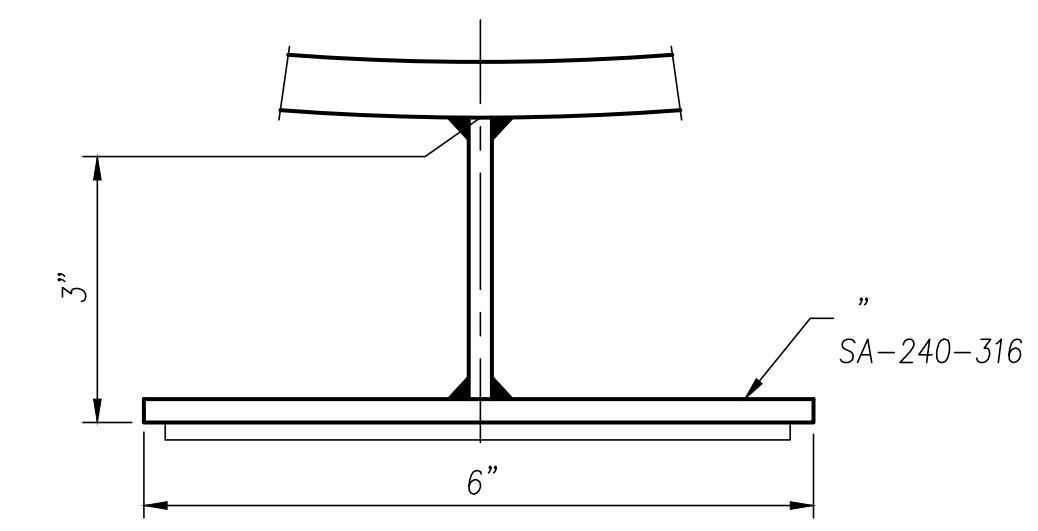
S/O 5612-12 1 4



ELEVATION  
SEE PLAN FOR TRUE ORIENTATION

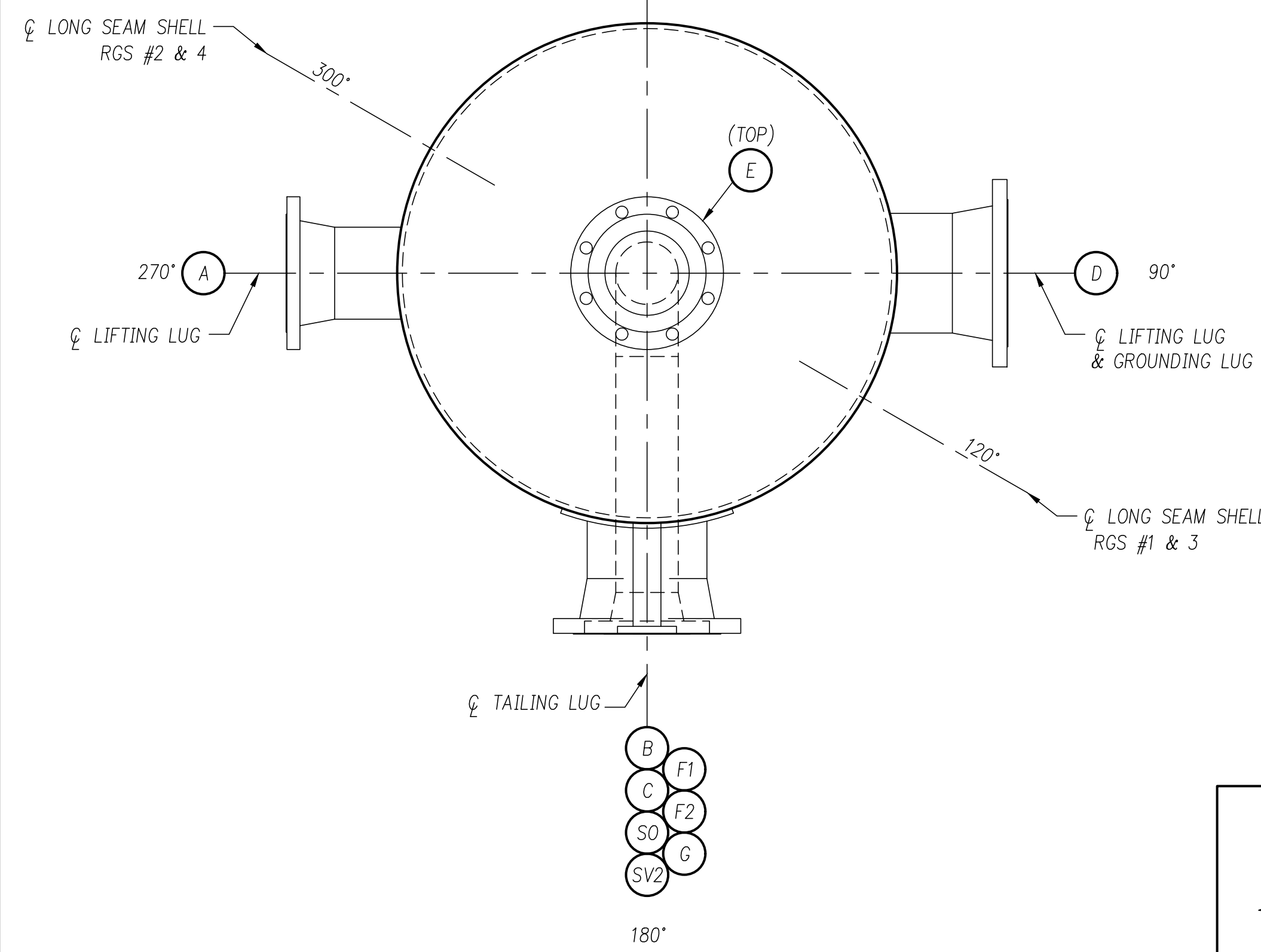
**WORKLINE**

CENTER PUNCH OUTSIDE FOR PERMANENT REFERENCE... ALL TAIL DIMENSIONS ARE TO THIS LINE.

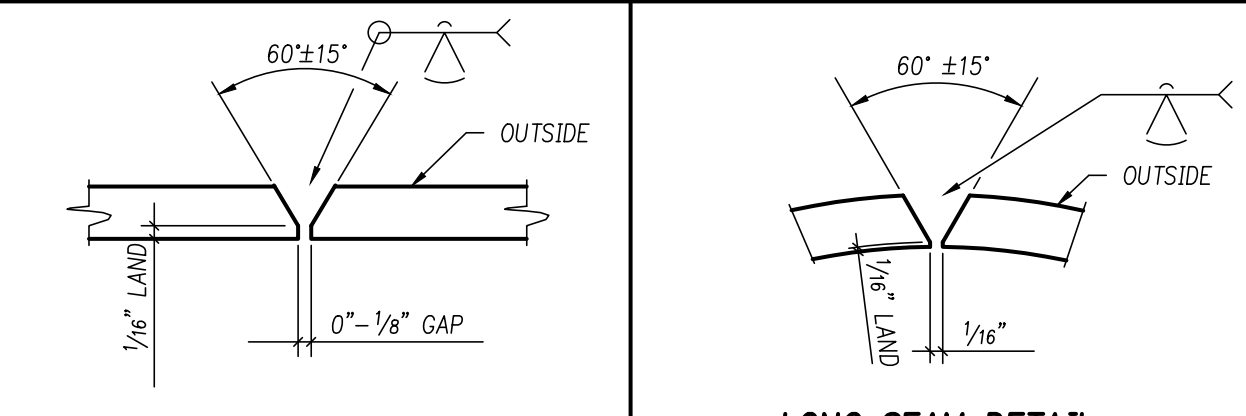


**NAME PLATE FACSIMILE & BRACKET DETAILS**

ONE (1) REQUIRED



**PLAN**

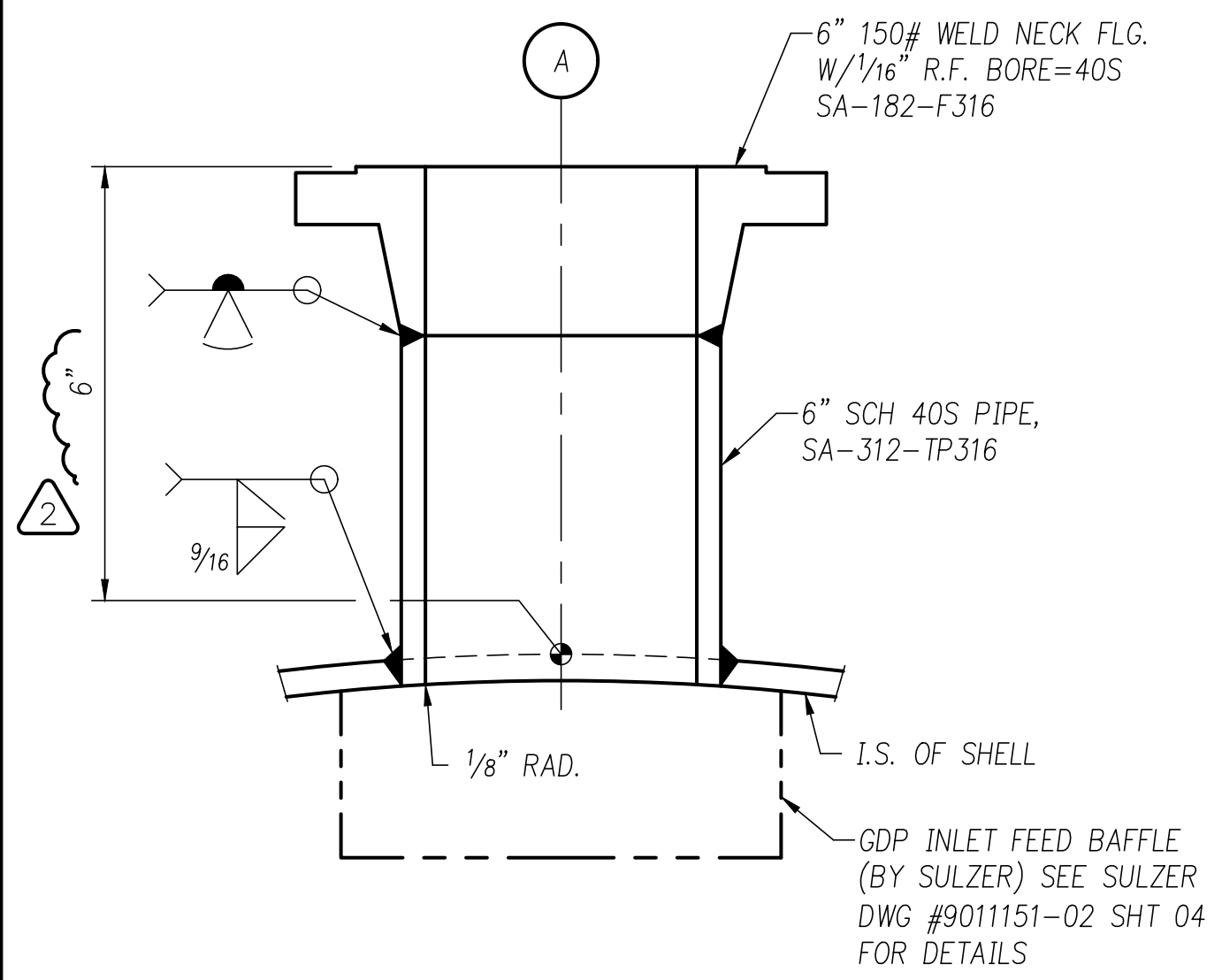


**TYPICAL ROUND SEAM DETAIL**      **LONG SEAM DETAIL**

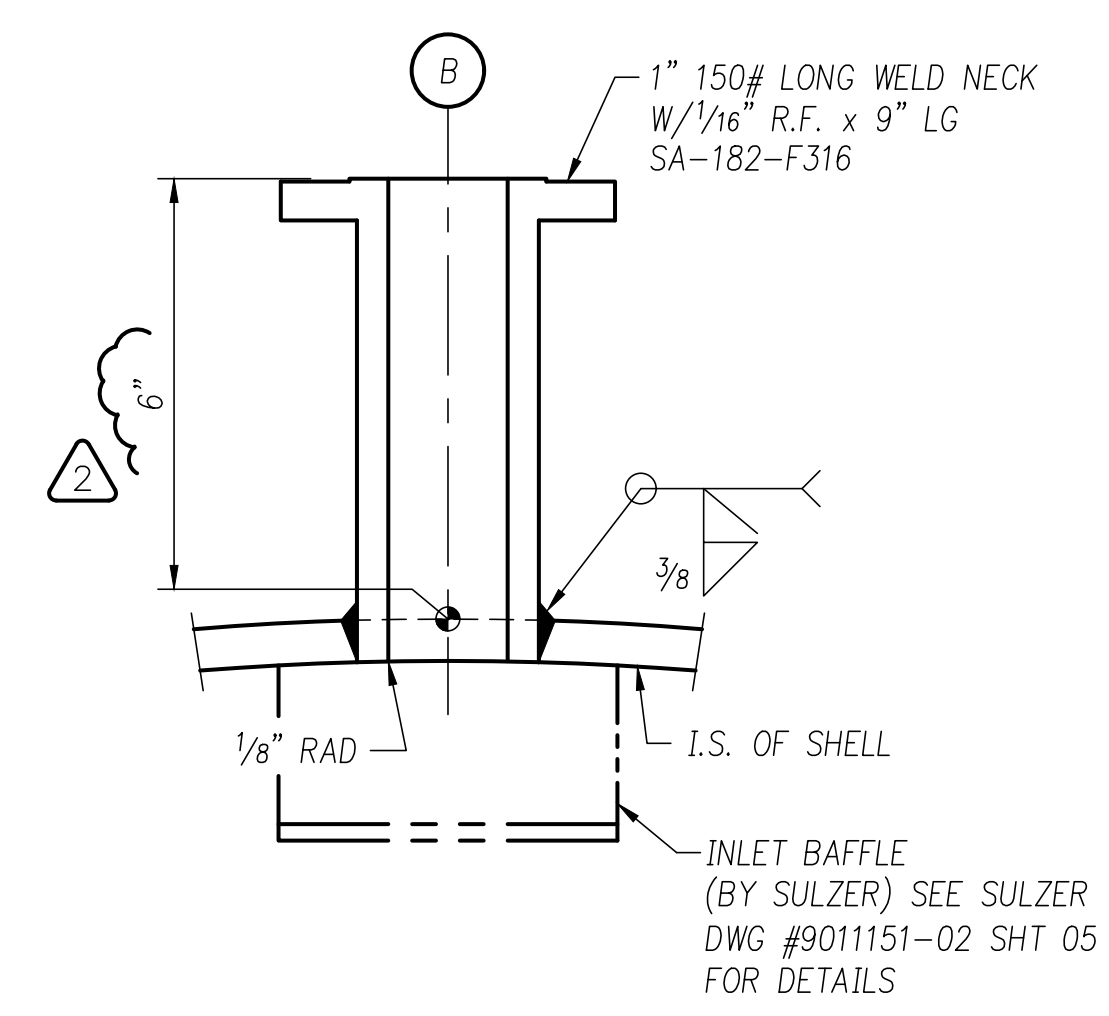
MARK	SIZE	CLASS	TYPE	IDENTIFIER
SV1~2	2"			SKIRT VENT
SO	8"			SKIRT SLEEVE
SA	18"			SKIRT ACCESS
G	8"	150#	WN	DUMP
F2	8"	150#	WN	FILL
F1	8"	150#	WN	FILL
E	6"	150#	WN	REFLUX VAPOR OUTLET
D	8"	150#	WN	REFLUX VAPOR INLET
C	4"	150#	WN	LEAN AMINE OUTLET
B	1"	150#	LWN	RICH AMINE INLET
A	6"	150#	WN	RICH AMINE INLET

**NOZZLE SCHEDULE**

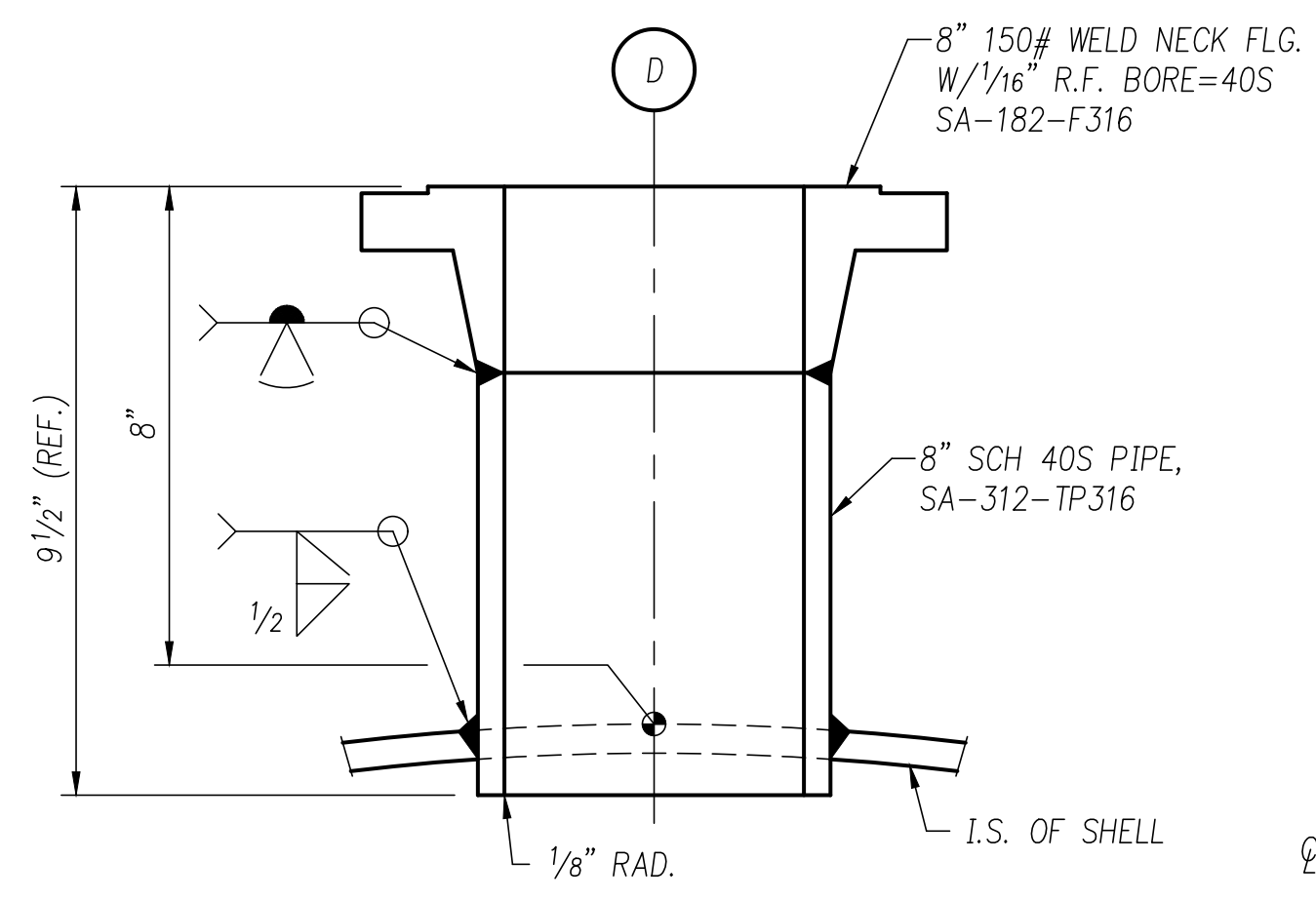
NO.	REVISION	BY	DATE
4	REVISED AS BUILT	MLR	8/22/16
3	REVISED AS NOTED	MLR	2/2/16
2	REVISED ELEVATIONS AS NOTED	MLR	1/11/16
1	REVISED PER CUSTOMER APPROVAL	MLR	12/7/15
0	ISSUED FOR CUSTOMER APPROVAL	MLR	11/6/15



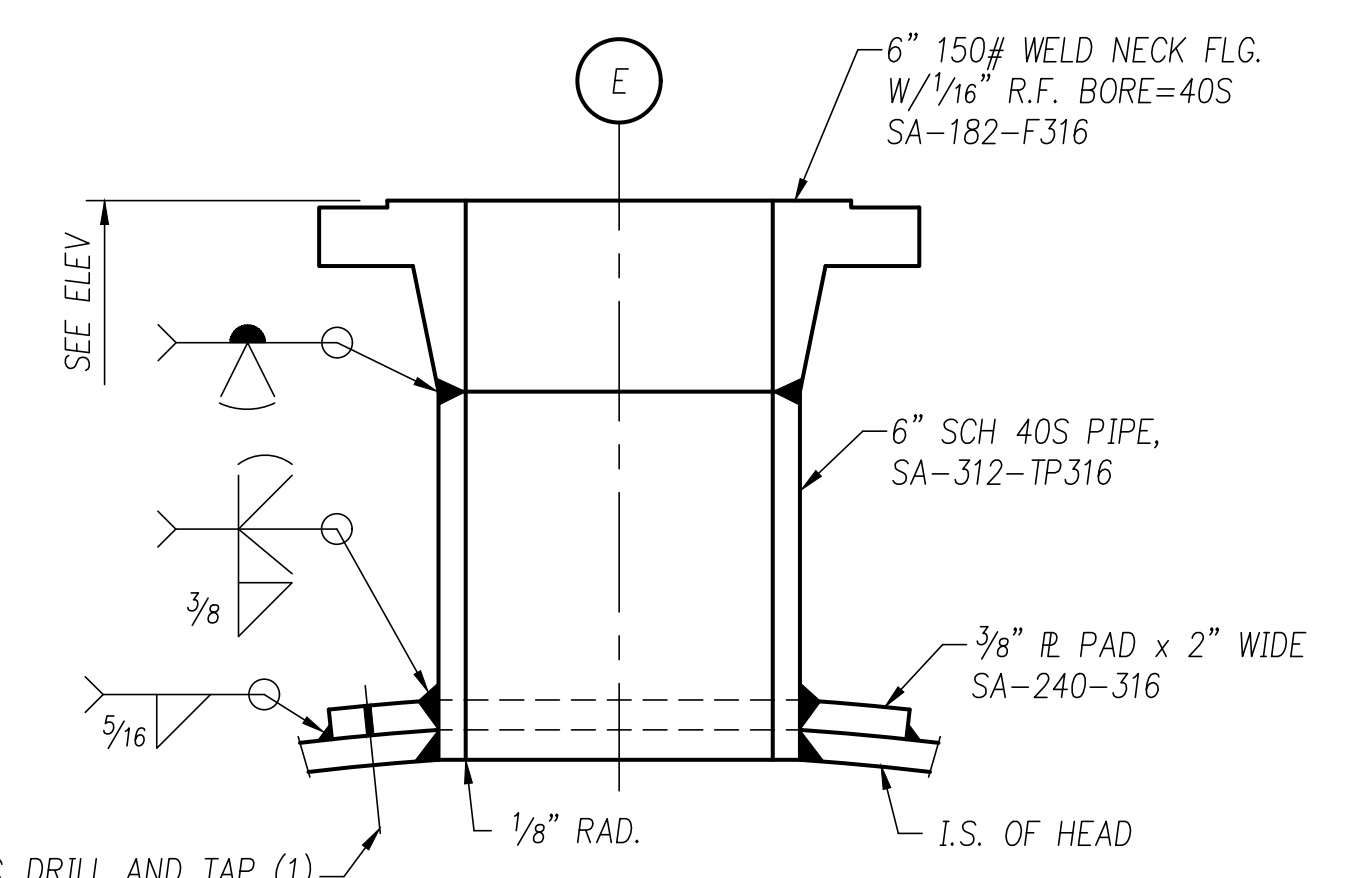
**DETAIL OF 6" 150# NOZZLE MK "A"**  
ONE (1) REQ'D



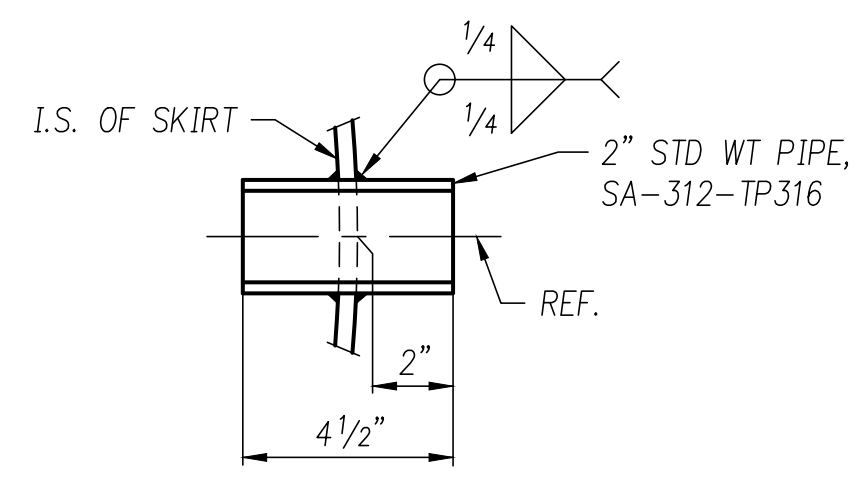
**DETAIL OF 1" 150# NOZZLE MK "B"**  
ONE (1) REQ'D



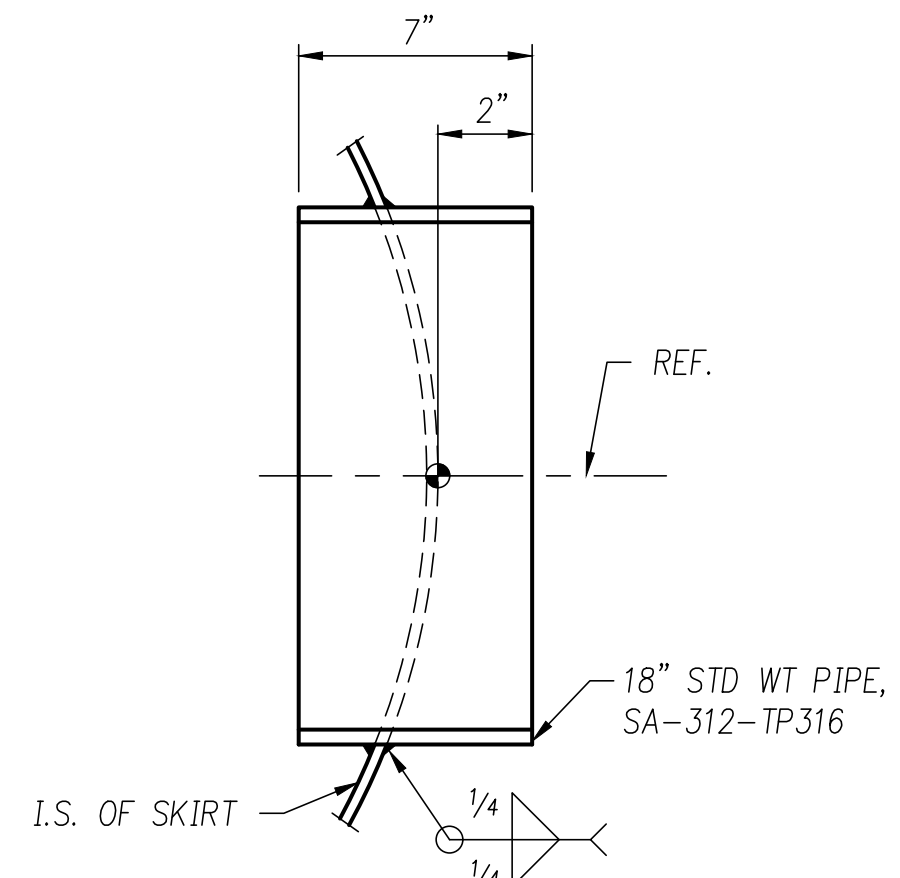
**DETAIL OF 8" 150# NOZZLE MK "D"**  
ONE (1) REQ'D



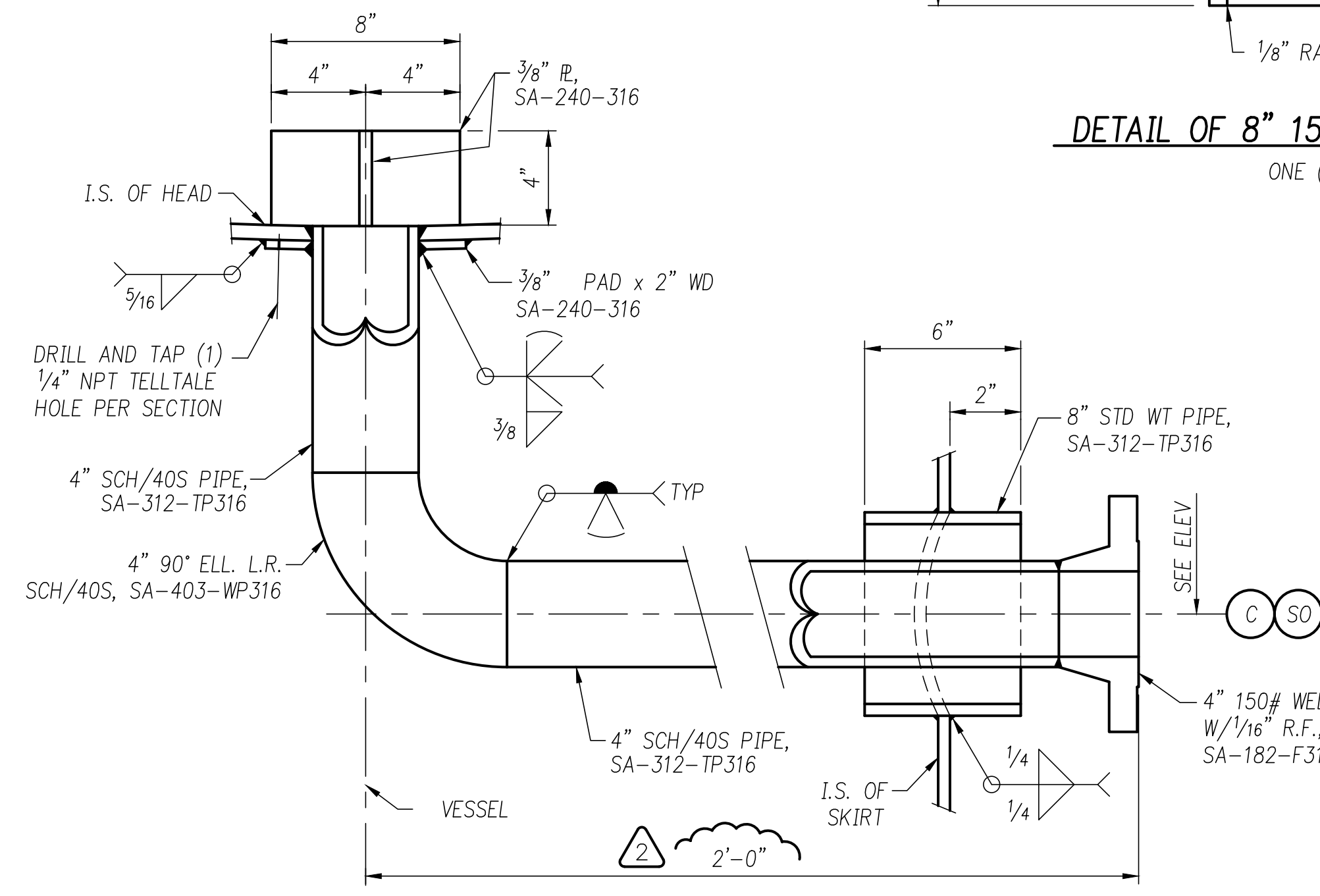
**DETAIL OF 6" 150# NOZZLE MK "E"**  
ONE (1) REQ'D



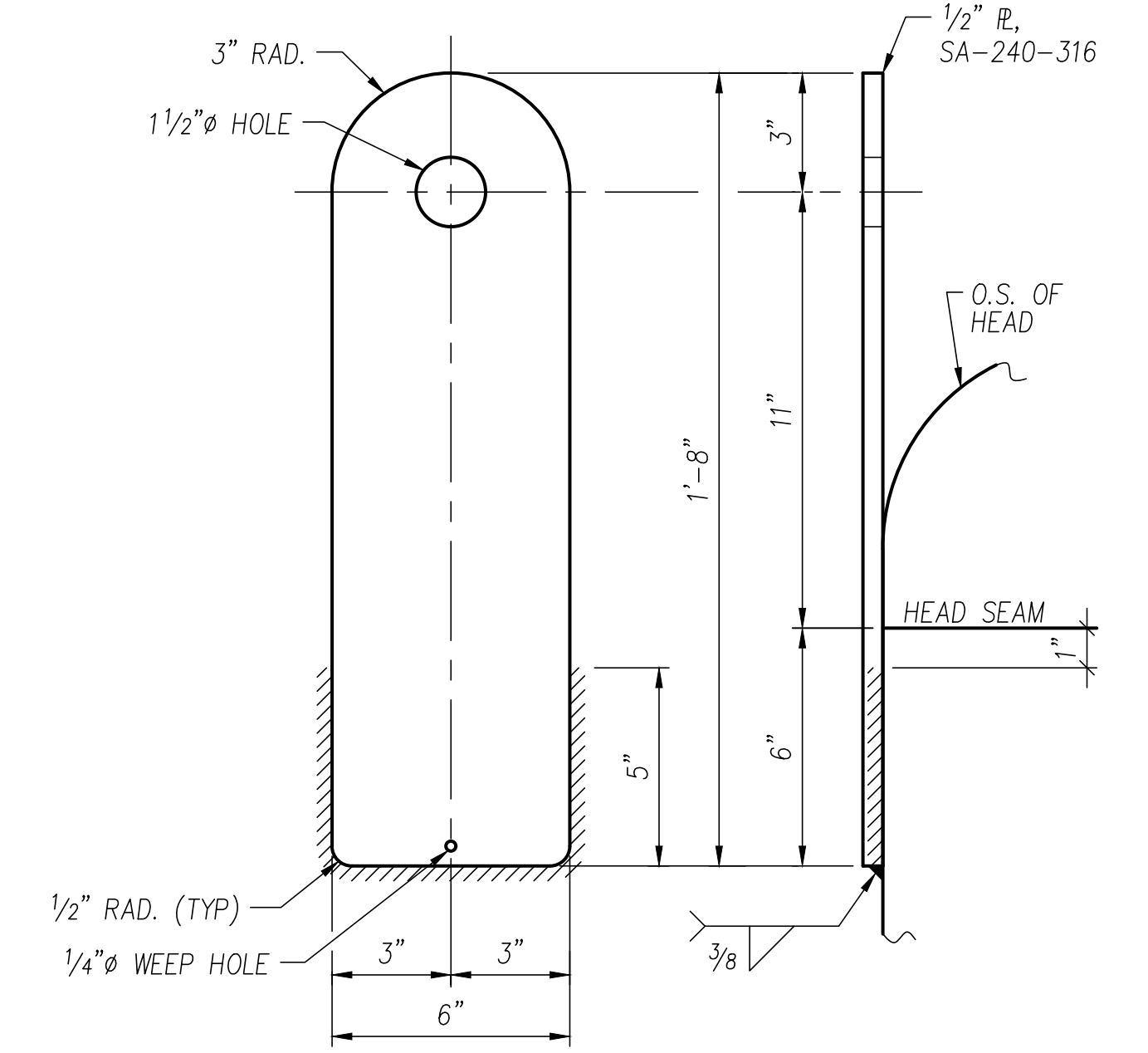
**DETAIL OF 2" SKIRT VENT**  
TWO (2) REQ'D MK "SV1~SV2"



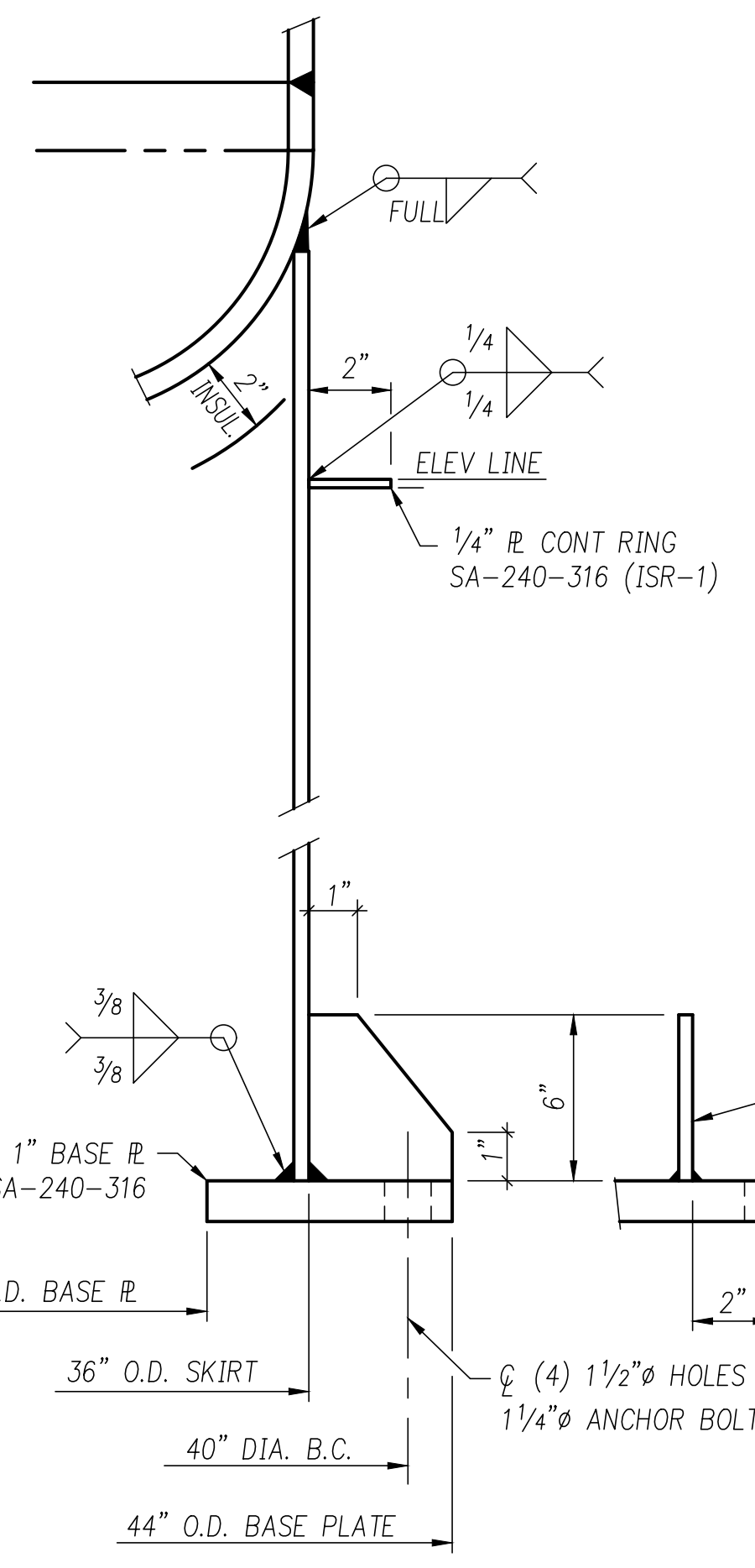
**DETAIL OF 18" SKIRT ACCESS**  
ONE (1) REQ'D MK "SA"



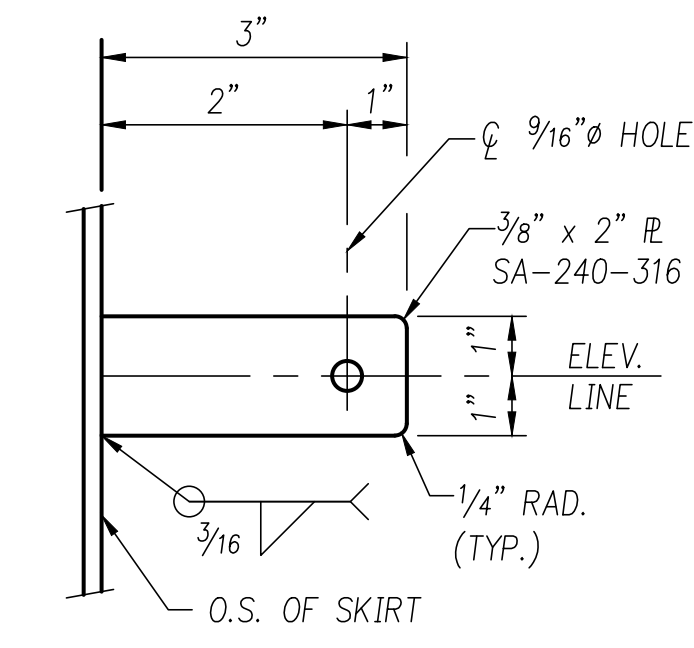
**DETAIL OF 4" 150# NOZZLE MK "C"**  
**W/SLEEVE MK "SO" & VORTEX BREAKER**  
ONE (1) REQ'D



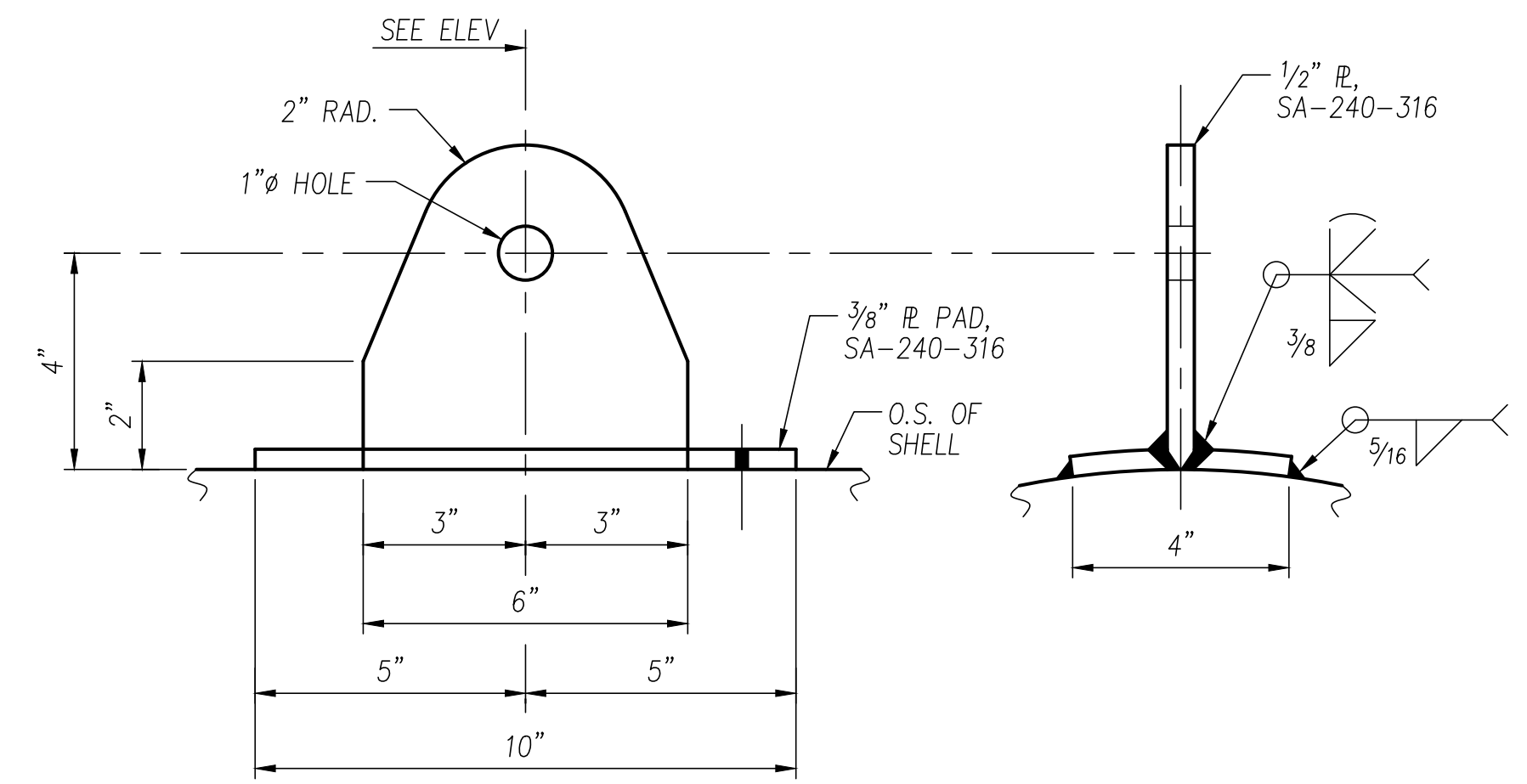
**DETAIL OF LIFTING LUG**  
TWO (2) REQ'D



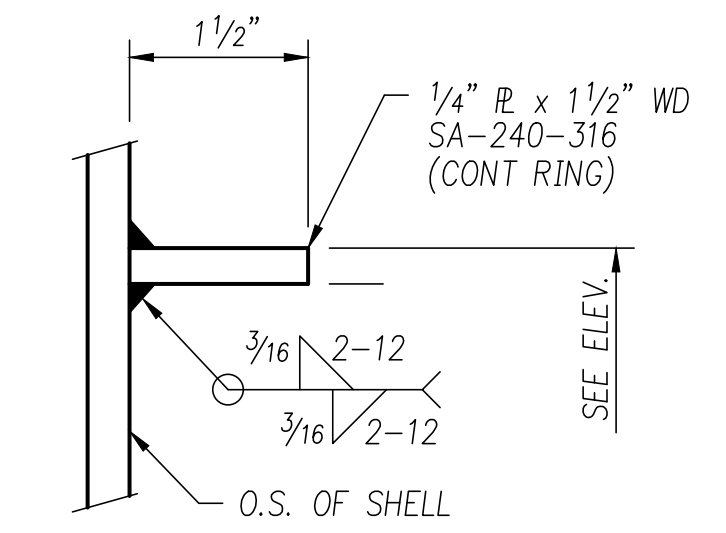
**BASEPLATE DETAIL**



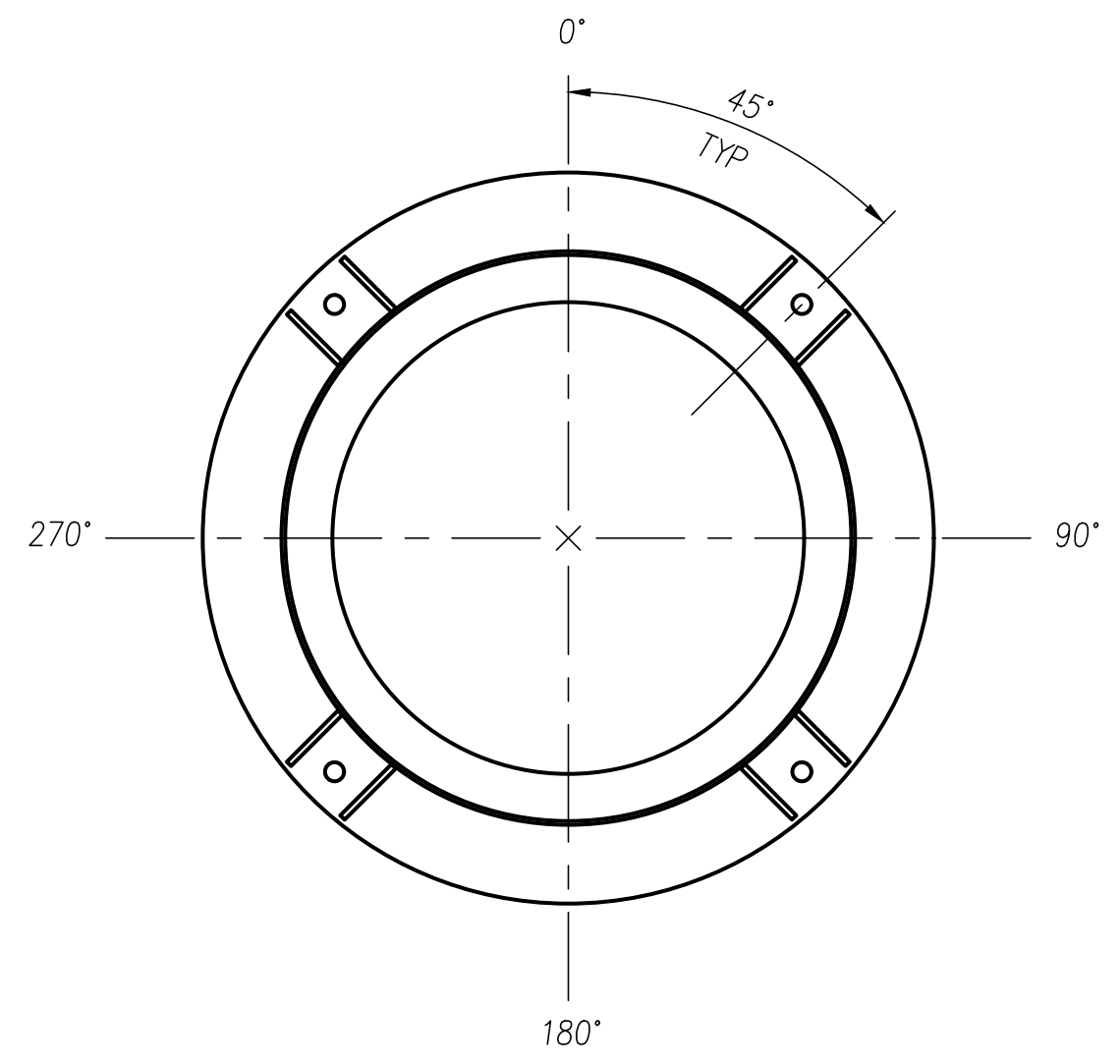
**GROUNDING LUG DETAIL**  
ONE (1) REQ'D



**DETAIL OF TAILING LUG**  
ONE (1) REQ'D



**INSULATION SUPPORT RING**  
ONE (1) EA. REQ'D MK "ISR-2 ~ ISR-5"  
FOUR (4) REQ'D



**ANCHOR BOLT PLAN**

NO.	REVISION	BY	DATE
2	REVISED PROJECTIONS AS NOTED	MLR	1/11/16
1	REVISED PER CUSTOMER APPROVAL	MLR	12/7/15
0	ISSUED FOR CUSTOMER APPROVAL	MLR	11/9/15

**PPI Professional Projects, Inc.**  
P.O. BOX 618 (18115 TELGE RD.) CYPRESS, TEXAS 77429

TITLE: 36" OD x 36'-0" S/S  
ITEM: T-1120, AMINE STILL COLUMN  
**DETAILS**

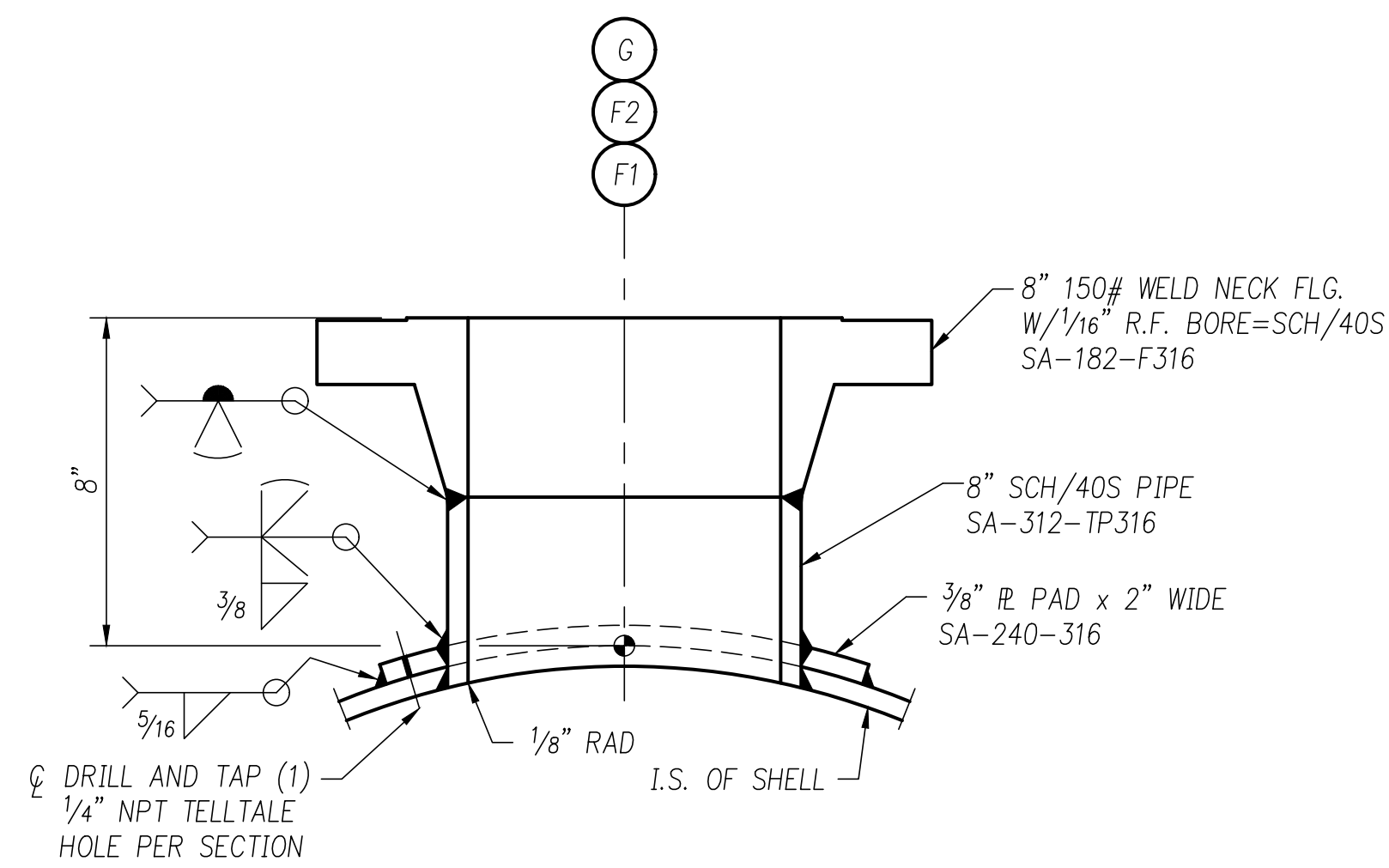
CUSTOMER: INFRA TECHNOLOGY LLC  
HOUSTON, TEXAS

CUSTOMER P.O. NO. 13 PPI NO. 5612

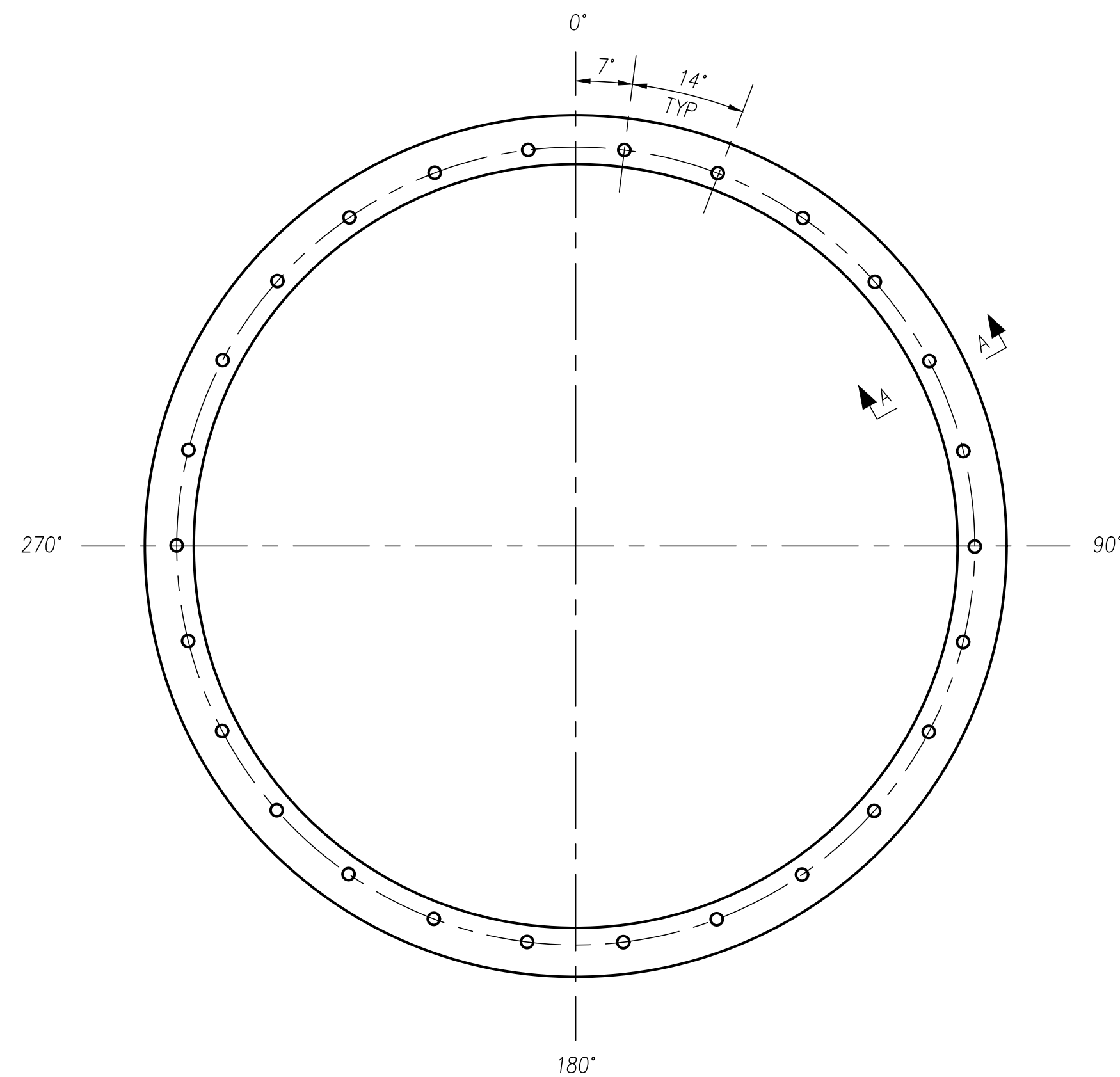
DRAWN: MLR DATE: 11/6/15 CHECKED: MUD DATE: 11/6/15

DRAWING NO. SHEET NUMBER REVISION NO.  
S/O 5612-12 2 2

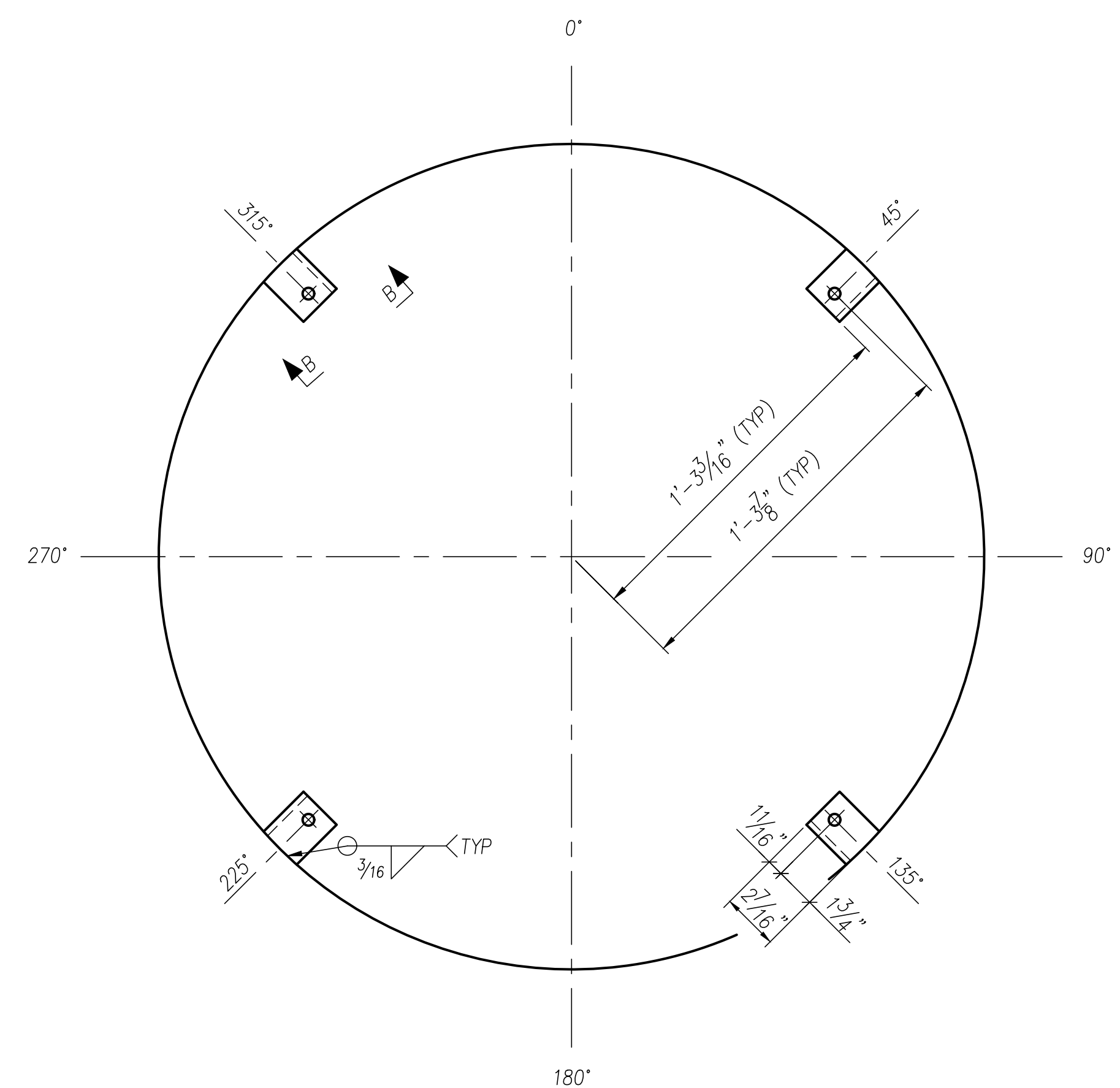
FILE NAME: 5612-12  
PLOT DATE: 11/6/15  
PLOT TIME: 10:00  
BY: MLR



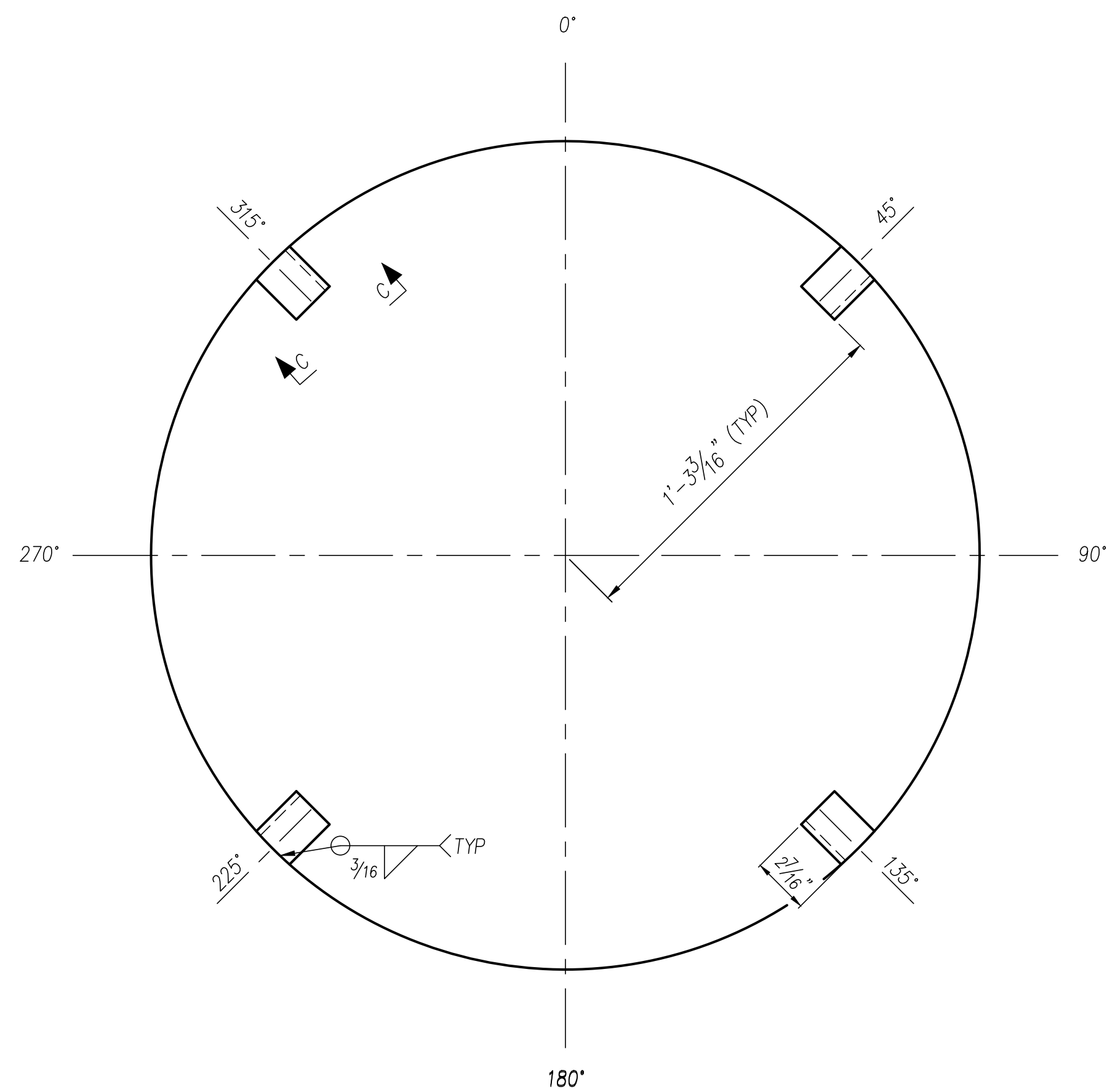
**DETAIL OF 8" 150# NOZZLES MK "F1, F2, & G"**  
THREE (3) REQ'D



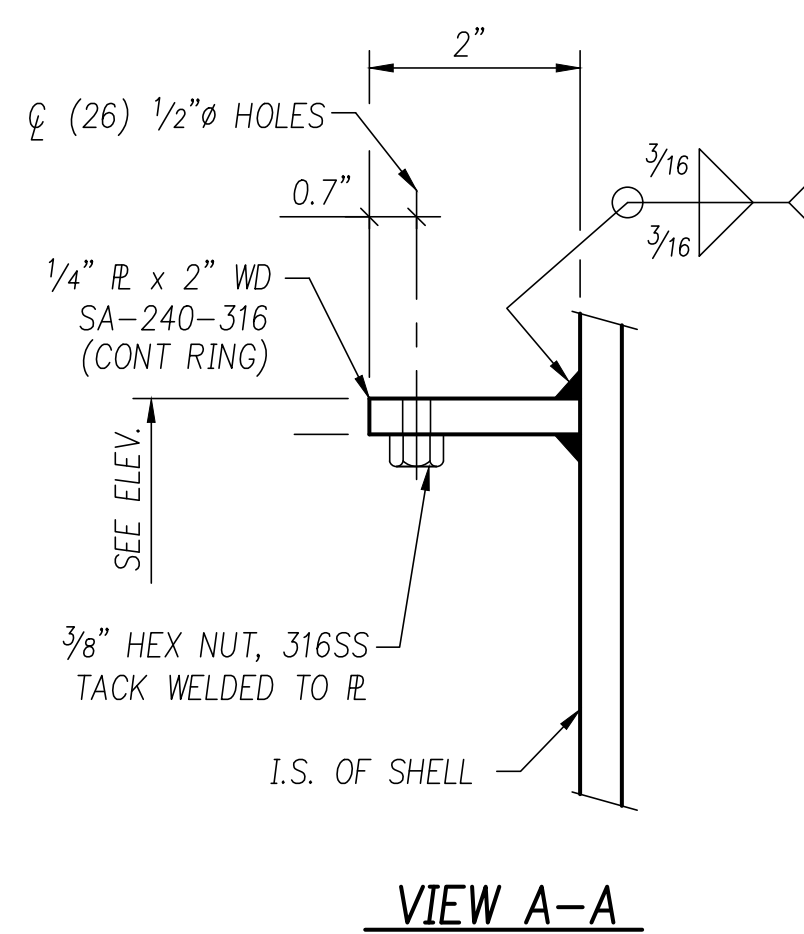
**PLAN OF SKP CHIMNEY TRAY SUPPORT RING**  
**PLAN OF VSIR LIQUID DISTRIBUTOR SUPPORT RING**  
TWO (2) TOTAL REQ'D



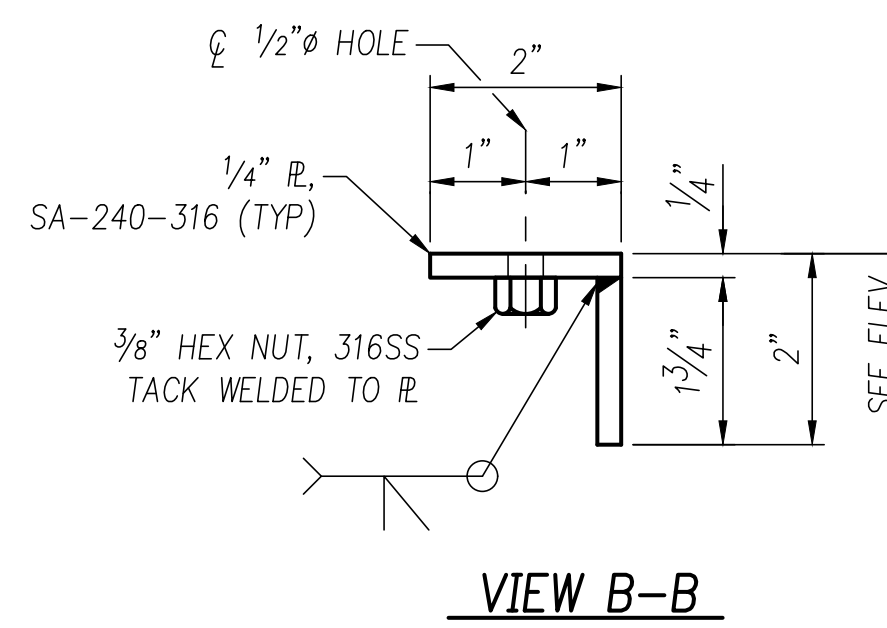
**PLAN OF RPB BED LIMITER SUPPORT CLIPS**



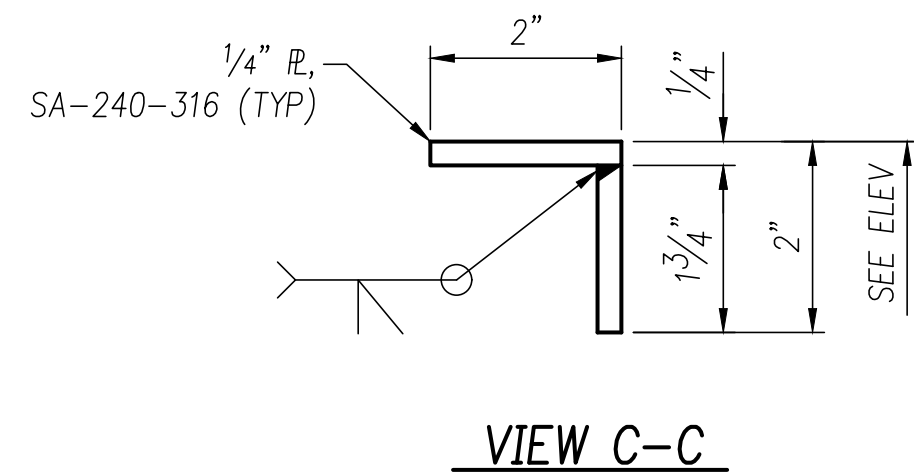
**PLAN OF EMS GRID SUPPORT CLIPS**



**VIEW A-A**



**VIEW B-B**



**VIEW C-C**

FILE NAME: 5612-12  
PLOT DATE: 12/7/15  
PLOT TIME: 10:00  
BY: MLR

**PPI Professional Projects, Inc.**  
P.O. BOX 618 (18115 TELGE RD.) CYPRESS, TEXAS 77429

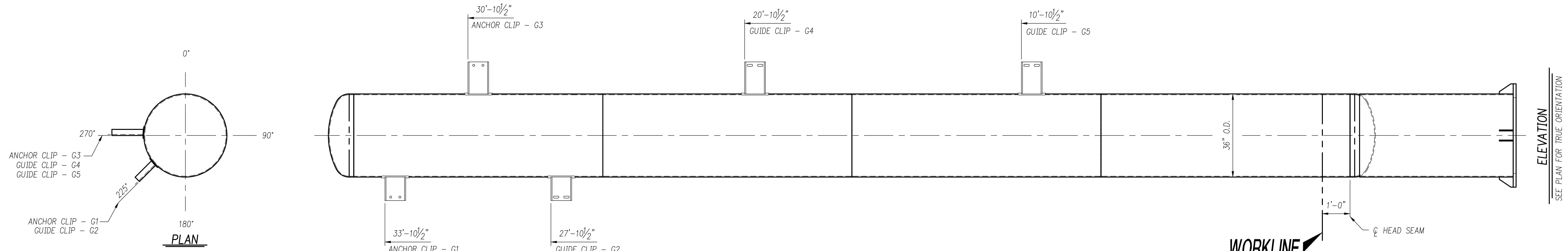
TITLE  
36" OD x 36'-0" S/S  
ITEM: T-1120, AMINE STILL COLUMN  
**DETAILS**

CUSTOMER  
INFRA TECHNOLOGY LLC  
HOUSTON, TEXAS

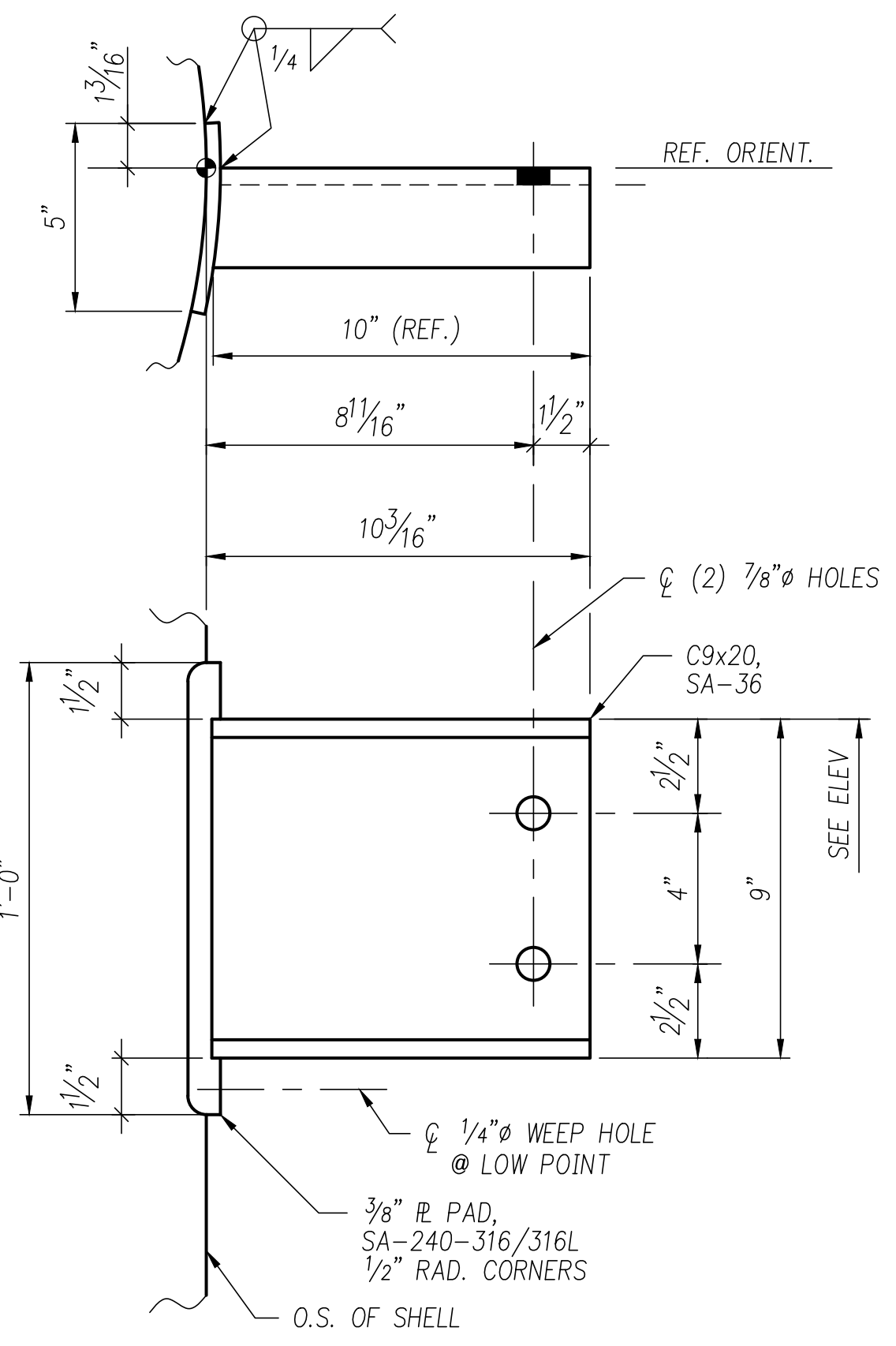
CUSTOMER P.O. NO. 13 PPI NO. 5612  
DRAWN MLR DATE 12/7/15 CHECKED MUD DATE 12/7/15

NO.	REVISION	BY	DATE
0	ISSUED FOR CUSTOMER APPROVAL	MLR	12/7/15

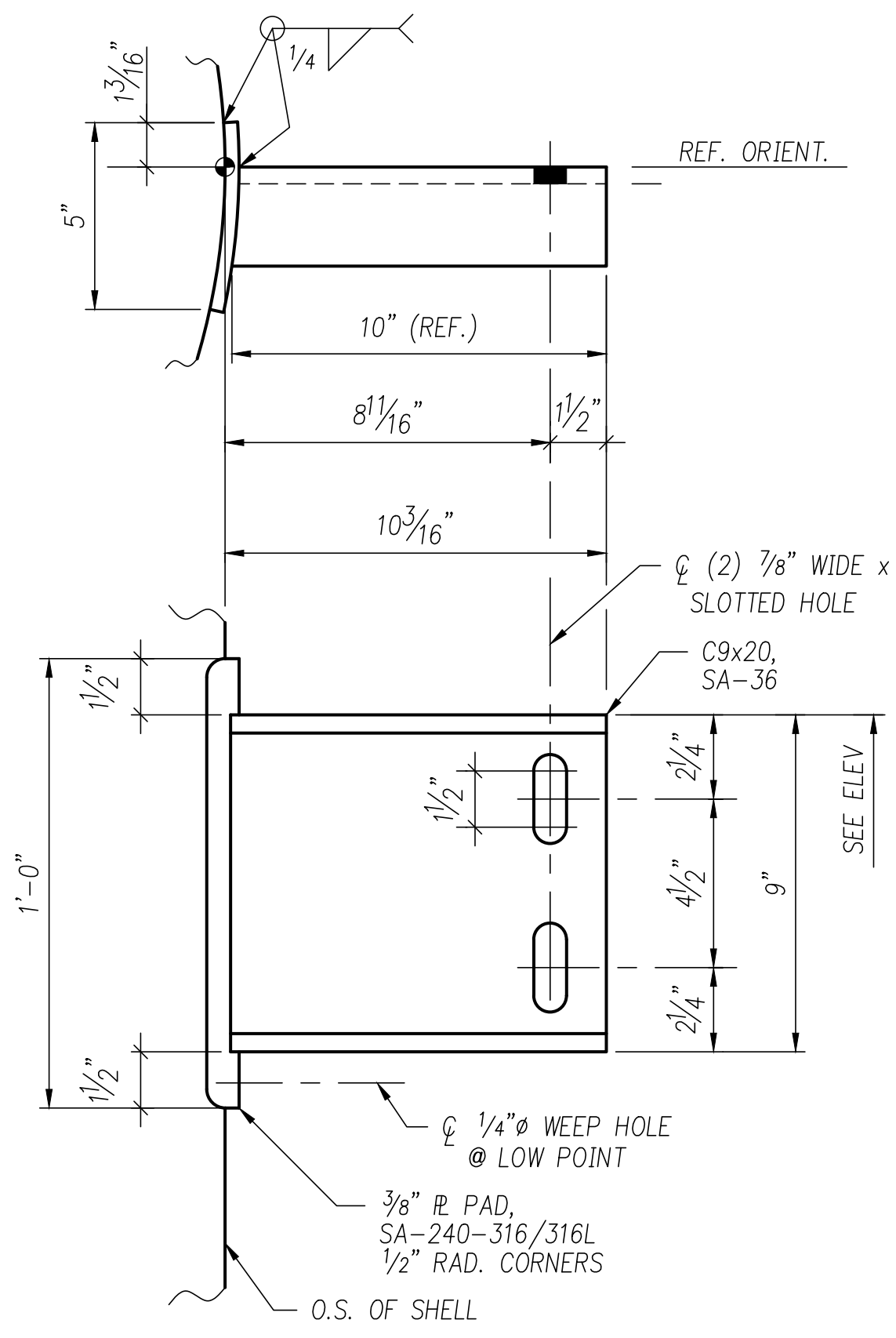
DRAWING NO. SHEET NUMBER REVISION NO.  
**S/O 5612-12** 3 0



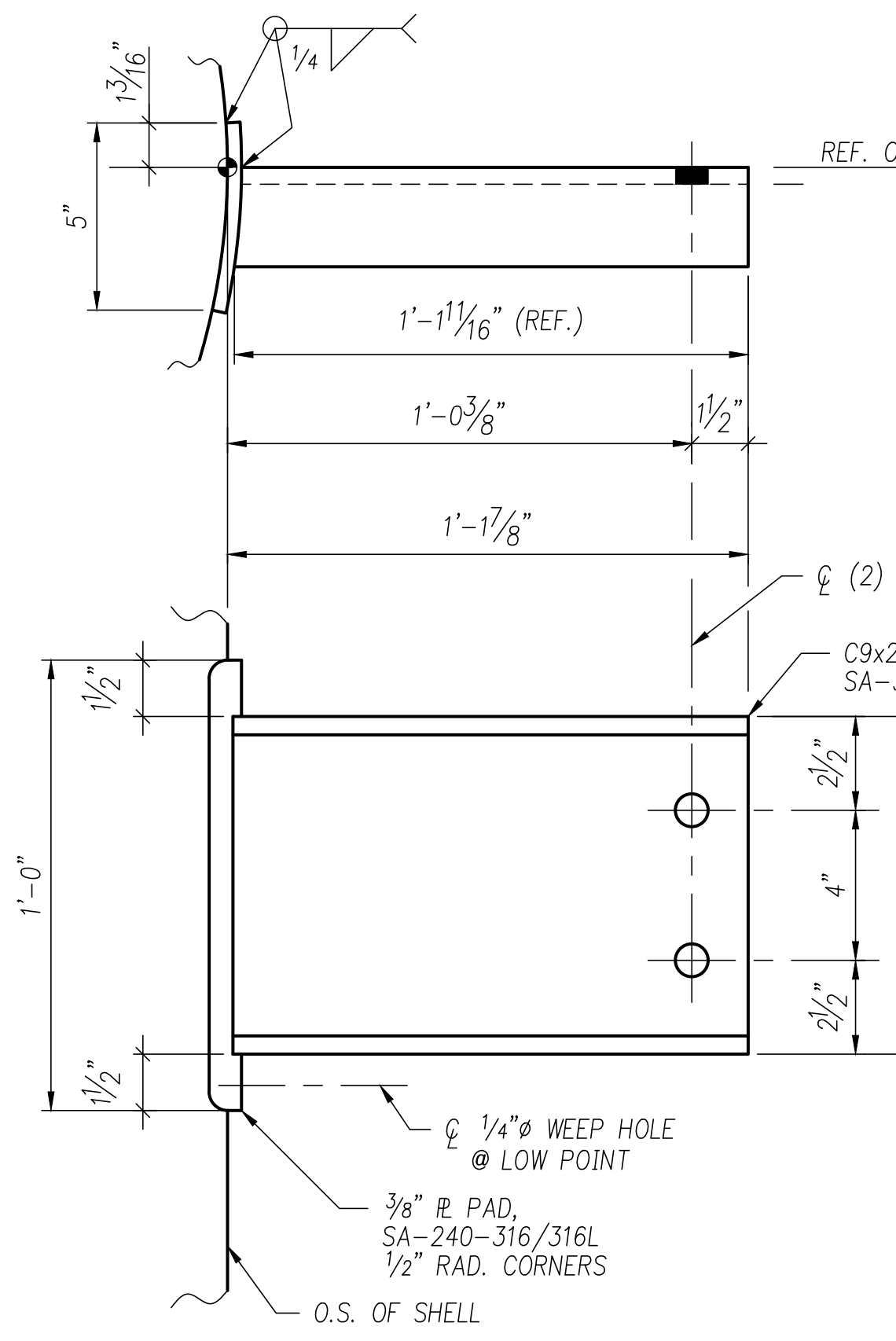
WORKLINE  
ALL TAIL DIMENSIONS ARE TO THIS LINE



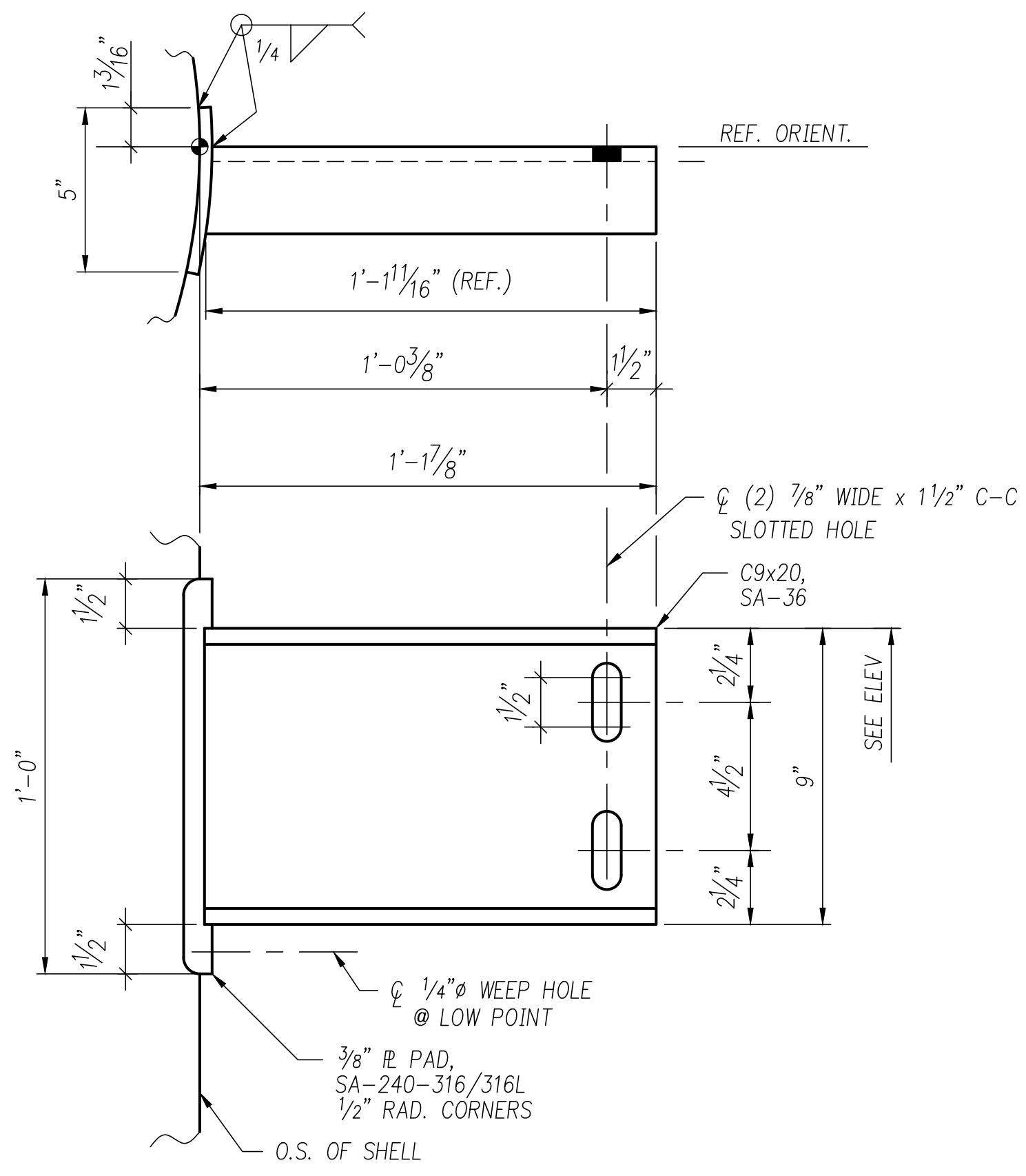
DETAIL OF ANCHOR CLIP MK "G1"  
ONE (1) REQ'D



DETAIL OF GUIDE CLIP MK "G2"  
ONE (1) REQ'D



DETAIL OF ANCHOR CLIP MK "G3"  
ONE (1) REQ'D



DETAIL OF GUIDE CLIPS MK "G4 & G5"  
TWO (2) REQ'D

**CLIP COATING REQUIREMENTS**  
ALL C.S. CLIP SURFACES PER MRKH-SP-PI-0003 3.2.3:  
1.) SURFACE PREP: SSPC-SP10  
2.) PRIMER: EPOXY PHENOLIC, THERMALINE 450, 4.0-6.0 MILS D.F.T.

FILE NAME: 5612-12  
PLOT DATE: 3/17/16  
PLOT TIME: 10:00  
BY: MLR

**PPI Professional Projects, Inc.**  
P.O. BOX 618 (18115 TELGE RD.) CYPRESS, TEXAS 77429

TITLE: 36" OD x 36'-0" S/S  
ITEM: T-1120, AMINE STILL COLUMN  
**PIPE GUIDE & SUPPORT DETAILS**

CUSTOMER: INFRA TECHNOLOGY LLC  
HOUSTON, TEXAS

CUSTOMER P.O. NO. 13	PPI NO. 5612
DRAWN: MLR	CHECKED: MUD
DATE: 3/17/16	DATE: 3/17/16
DRAWING NO. S/O 5612-12	SHEET NUMBER 4
REVISION NO. 2	REVISION NO. 2

NO.	REVISION	BY	DATE
2	ADDED CLIP COATING REQUIREMENTS	MLR	4/7/16
1	REVISED PER CUSTOMER APPROVAL	MLR	3/29/16
0	ISSUED FOR CUSTOMER APPROVAL	MLR	3/17/16