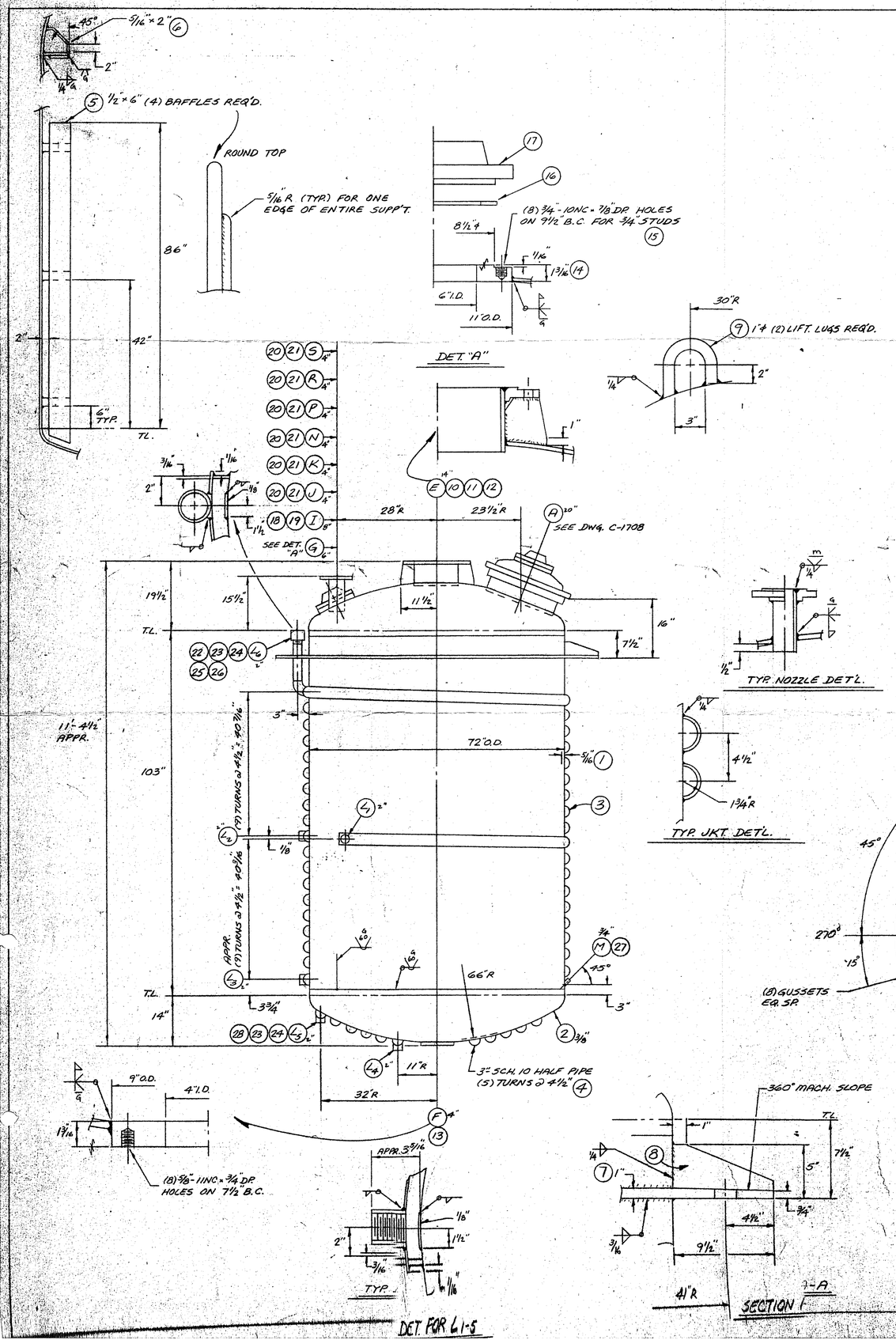

SCHEDULE OF CONNECTIONS						
MK.	NO.	SIZE	RATG.	TYPE	THK.	SERVICE
A	1	20"	90#	RING	1/4"	MANWAY w/ SIGHT GLASS
E	1	14"	150#	S.O.	3/8"	AGITATOR
F	1	4"	150#	PAD	13/16"	BTM. OUT.
G	1	6"	150#	PAD	1 3/16"	LIGHT CONN.
I	1	8"	150#	S.O.	3/8"	TO CONDENSER
J	1	4"	150#	S.O.	SCH.40	
K	1	4"	150#	S.O.	SCH.40	
L6	6	2"	3000#	C'PLG.	TH'D.	JACKET
M	1	3/4"	3000#	C'PLG.	TH'D.	THERMOWELL
N	1	4"	150#	S.O.	SCH.40	
P	1	4"	150#	S.O.	SCH.40	
R	1	4"	150#	S.O.	SCH.40	
S	1	4"	150#	S.O.	SCH.40	

BILL OF MATERIAL				
ITEM NO.:	NO. REQ'D.	CONN.	MAT'L.	DESCRIPTION
1.	1		SA-240 316L	SHELL 72" O.D. x 100" LG. x 5/16"
2.	2		SA-240 316L	ASME F+D HD. 72" O.D. x 1 1/2" S.F. x 3/8" w/ 66" R.
3.	1		SA-240 316L	3" HALF PIPE x 11 GA. THK.
4.	1		SA-312 316L	3" SCH. 10 HALF PIPE
5.	4		316L 1/2	BAFFLE 1/2" x 6"
6.	12		316L 1/2	BAFFLE SUPPORT 5/16" x 2"
7.	1		304 1/2	SUPP'T. RING 1" x 3/4" TK.
8.	8		304 1/2	GUSSET 1/2" TK.
9.	2		304 1/2	LIFT. LUG 1" ϕ
10.	1	E	SA-182 F304	14" - 150# ANSI S.O. FLG.
11.	1	E	SA-240 316L	NECK 14" O.D. x 3/8" TK.
12.	4	E	304 1/2	GUSSET 1/2" TK.
13.	1	F	316L 1/2	STUD PAD 1 1/4" TK.
14.	1	G	316L 1/2	STUD PAD 1 1/4" TK.
15.	8	G	304 1/2	3/4" - 10NC x 3 1/4" LG. STUD w/ NUT
16.	1	G	[illegible]	GASKET 1/8" x 8 3/4" O.D. x 6 3/8" I.D.
17.	1	G	316L 1/2	6" - 150# PRESS. PROD. MODEL B - FLG.
18.	1	I	SA-182 F316L	8" - 150# ANSI S.O. FLG.
19.	1	I	SA-240 316L	NECK 8 5/8" O.D. x 3/8" TK.
20.	6		SA-182 F304L	4" - 150# ANSI S.O. FLG.
21.	6		SA-312 316L	4" SCH. 40 PIPE
22.	1	L6	SA-182 F316L	2" 3000# TH'D. FULL C'PLG.
23.	6	L5	316L 1/2	WEAR PL. 1/8" x 3" x 3"
24.	6	L5	316L 1/2	END PL. 3/16" TK.
25.	1	L6	SA-312 316L	2" SCH. 40 PIPE T.O.E.
26.	1	L6	316L 1/2	2" SCH. 40 90° L.R. ELBOW
27.	1	M	SA-182 F316L	3/4" - 3000# C'PLG.
28.	5	L1-5	SA-182 F316L	2" 3000# TH'D. HALF C'PLG.

UKN PRS

GENERAL NOTES

1) VESSEL DESIGNED + FABRICATED PER 1983 ASME CODE SECT. VIII DIV. 1
2) CODE STAMP REQ'D.
3) NOZZLE BOLT HOLES TO STRADDLE MAIN VESSEL CTR. LINES, EXCEPT AGITATOR TO BE ON CTR.
4) PARTIAL X-RAY REQ'D. ON BOTH CIRCUM. SEAMS. AT LEAST ONE SHOT TAKEN AT JUNCTURE OF LONG. SEAM
5) INTERNAL SURFACES TO HAVE # 4 POLISH + BE PASSIVATED
6) INTERNAL WELDS GROUND SMOOTH + FLUSH
7) EXTERNAL WELDS WIRE BRUSHED
8) ALL WELDS TO BE FREE OF SLAG, POROSITY, UNDERCUTS ETC.
9) FOR SHIPPING, NOZZLES TO HAVE WOOD COVERS + C'PLGS. TO HAVE PLUGS
10) VESSEL TO BE TAGGED 5004-B419 ON TOP HEAD

CUST- AMERICAN HOECHST
PO. # 507612
ITEM # B419
EST. WTS.
EMPTY- 6200#
FULL H_2O - 23,600#
REF. DWG.
C-1708

U | RT4
W

NATIONAL BOARD NO. 1758
MFGRS. SERIAL NO. 2890
YEAR BUILT 1986

	FULL	VAC.	P.S.I. AT	°F.		
SHELL	90		390	°F.	SHELL THK.	.3125
JACKET	90		390	°F.	HEAD THK.	.3125
TUBES	—		—	°F.	JACKET THK.	.125
COILS	—		—	°F.	NO. UKT	.120

HYDRO TEST SHELL @ 137 P.S.I.G.
HYDRO TEST JACKET @ 137 P.S.I.G.

ALLOY FAB, INC. CERTIFIED

AHC NO. E005-307

REV.	DESCRIPTION	DATE	BY
C	MOVE L3 FROM 202 1/2° TO 220°	6-20-86	B.P.
B	REV. UKT. C'PLGS. + AGIT. SIZE	3-13-86	B.P.
A	PER CUST DWG.	3-4-86	B.P.

ALLOY FAB INC.
SOUTH PLAINFIELD, N.J.
(ONE) 72" O.D. 1500 GAL.
316L 1/2 H.P.C.J. CRYSTALLIZER

WORK ORDER NO.	DR. BY B.P.	DATE 2-21-86
2890	CH. BY RR	D-1711-C
	SCALE	

1142-13