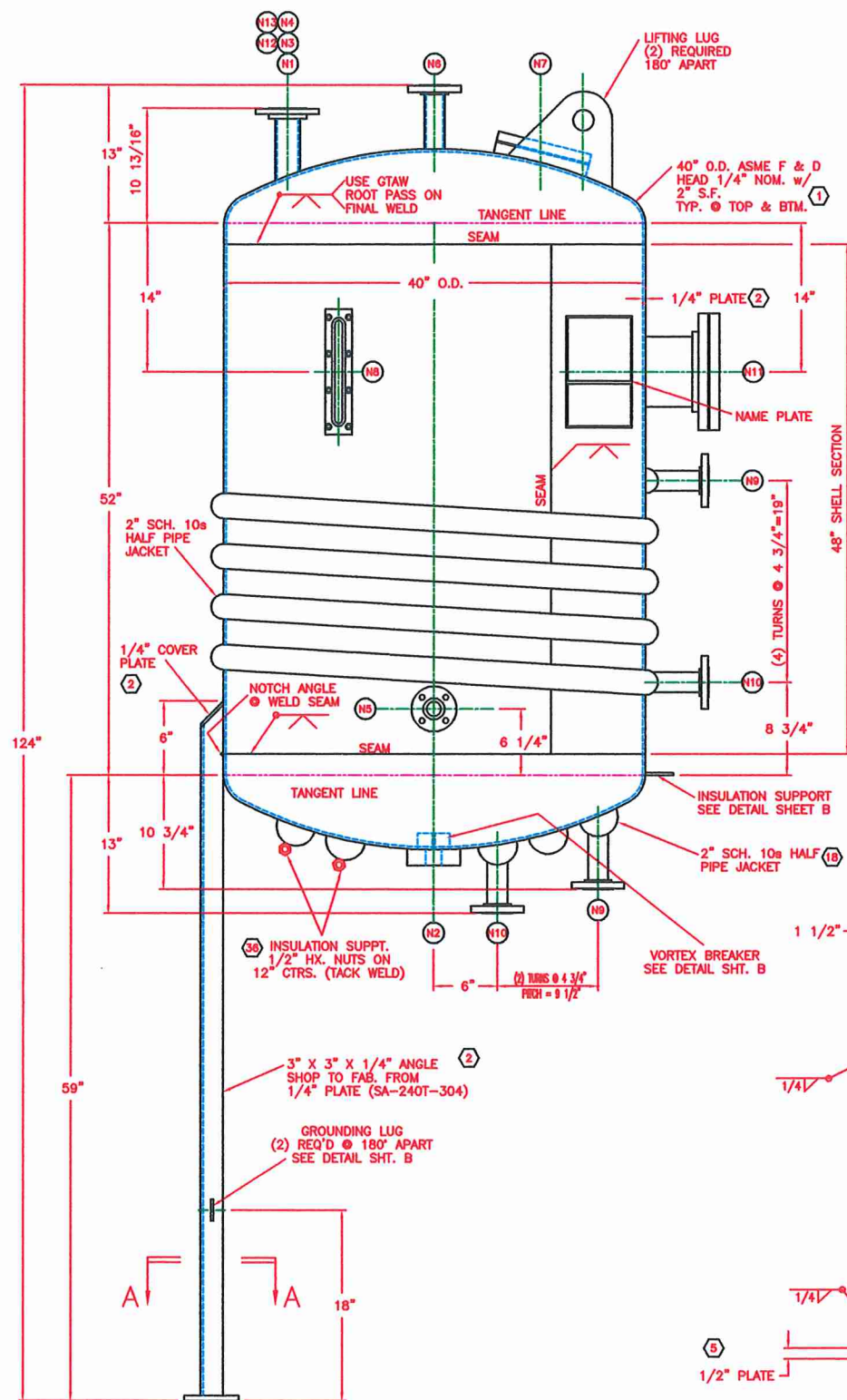
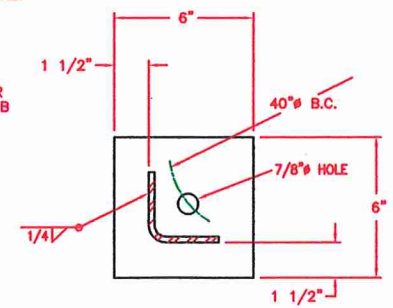
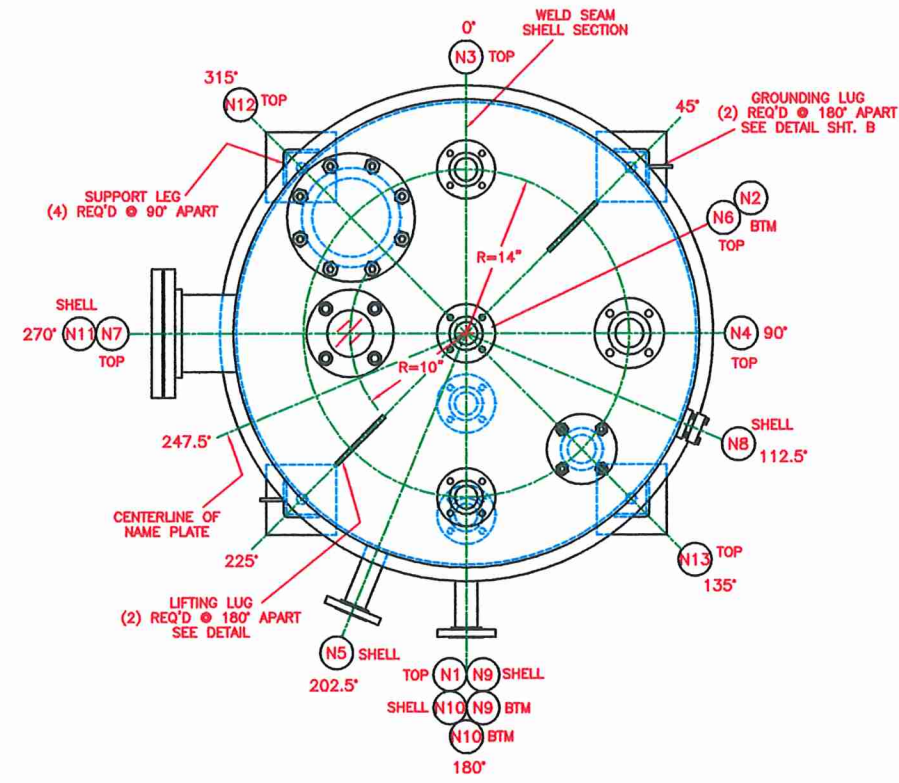




ELEVATION

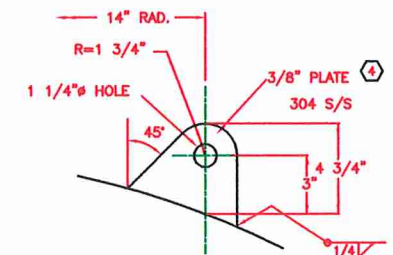


SECTION A-A
TYP (4) PLACES



PLAN

ALL FLANGE BOLT HOLES TO STRADDLE TANK CENTERLINES



DETAIL LIFTING LUG
(2) REQUIRED 180° APART

N13	1	2"	150# R.F.S.O.	SA-182F-304	SA-312TP-304	SPARE	w/BLIND FLG.
N12	1	6"	150# R.F.S.O.	SA-182F-304	SA-312TP-304	HANDHOLE	w/BLIND FLG.
N11	1	6"	150# R.F.S.O.	SA-182F-304	SA-312TP-304	HANDHOLE	w/BLIND FLG.
N10	2	1 1/2"	150# R.F.S.O.	SA-182F-304	SA-312TP-304	40SC OUTLET	-----
N9	2	1 1/2"	150# R.F.S.O.	SA-182F-304	SA-312TP-304	40S INLET	-----
N8	1	1 1/2"	J.G. PAPALIAS	304 S/S	-----	SIGHT GLASS	MODEL NO. RS300
N7	1	4"	J.G. PAPALIAS	304 S/S	-----	SIGHT GLASS	MODEL NO. NW80
N6	1	1 1/2"	150# R.F.S.O.	SA-182F-304	SA-312TP-304	VENT	-----
N5	1	1"	150# R.F.S.O.	SA-182F-304	SA-312TP-304	TG	-----
N4	1	2"	150# R.F.S.O.	SA-182F-304	SA-312TP-304	RELIEF VALVE	-----
N3	1	1 1/2"	150# R.F.S.O.	SA-182F-304	SA-312TP-304	30PA INLET	-----
N2	1	1 1/2"	PAD FLG.	-----	SA-479T-304	LIQUID OUT.	-----
N1	1	1 1/2"	150# R.F.S.O.	SA-182F-304	SA-312TP-304	LIQUID IN.	-----

NOZZLE SCHEDULE

DATE	CH'D BY	REV. BY	DESCRIPTION	REV.
1-13	T. GISS		AS BUILT	2
6-20	T. GISS		REV. PER CUST. APP. ORG. ISSUE TO SHOP	1

VESSEL SPECIFICATION

DESIGN CODE	ASME CODE SECTION VIII DIV. I 1989 EDITION 1989 ADDENDA	1. FIT-UP 2. WELDING 3. TESTING 4. 5. 6.
-------------	---	---

CODE STAMP: A.S.M.E. NATIONAL BOARD

DESIGN CONDITION	VESSEL	JACKET	COIL
P.S.I.G.	33	44	
TEMP.	335°F	335°F	
CORR. ALLOW.	NONE	NONE	
X-RAY	NONE	NONE	
JOINT. EFF.	70%	60%	
TEST P.S.I.G.	57	75	
M.D.M.T.	-20°F @ 33 PSIG	-20°F @ 44 PSIG	
P.W.H.T.	N/A	N/A	

CUST. SOFIX CORPORATION
A.F.I. OUR QUALITY CONTROL
A.S.M.E. NATIONAL BOARD A.I.

VESSEL MATERIALS	VESSEL	JACKET
HEADS	SA-240T-304	
SHELL	SA-240T-304	
PIPE	SA-312TP-304	SA-312TP-304
FLG'S.	SA-182F-304	SA-182F-304
PADS	-----	
BOLTS	SA-193-B7	
NUTS	SA-194-2H	
SUPT'S	SA-240T-304	
GSK'T	GARLOCK 6326 MILLED TYP OREQ.	

CERTIFIED
RELEASED FOR FABRICATION
DATE _____
PROJECT ENGINEER _____
ORIGINAL RELEASE DATE: 9-5-91

FULL PENETRATION AS NOTED AS PER A.F.I. WELD SPEC. NO. 1
1-1-A, 1-8-B, 8-8-A, 8-8-D, 8-8-AD

INTERNAL NOZZLE WELDS SHALL BE GROUND SMOOTH
ALL OTHER WELDS SMOOTH AS WELDED.

PICKLE & PASSIVATE ALL STAINLESS STEEL
SAND BLAST ALL C/S PER SSPC-SP6. PAINT ALL
C/S w/PORTER 7501 MAGNA PRIME (5.0 MILS D.F.T.)

CONTENTS: --- SP. GR. = 1.55
CAPACITY: 320 GALLONS APPROX.
WT. EMPTY: 1,585 LBS. APPROX.
WT. WITH CONTENTS: 4,255 LBS. APPROX. w/WATER
FLG. FACE FINISH: STANDARD AS PURCHASED

COVER ALL OPENINGS PRIOR TO SHIPMENT

DRAWN BY: ROSCOE PAGE
CHECKED BY: KEVIN MULLINS

OVERALL DIM.: ±1/4"
NOZ. PROJ. AND LOCATION: ±1/4"
SUPT. AND LUG LOCATION: ±1/4"
FLG. FACE LEVEL: ±1/2"
ORIENTATION: ±1/4"

P.O.NO.: 91-00006
EQUIP. No.: C 4011
PROJ. No.: 5262A
PLANT: CHATTANOOGA, TN

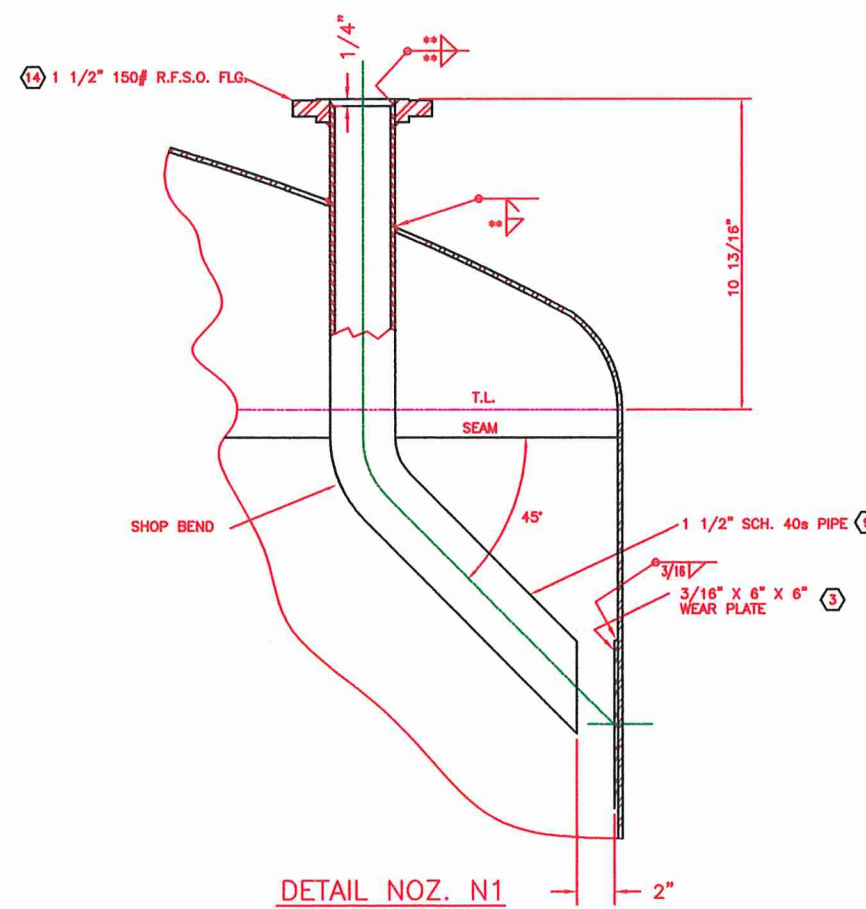
ALLOY FABRICATORS, INC.
TRENTON, GA.

CUSTOMER
SOFIX CORPORATION

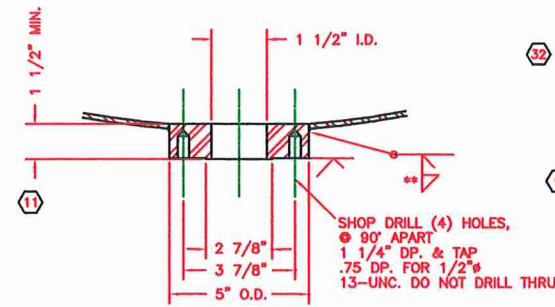
DWG. TITLE
INTERMEDIATE LAYER TANK

REV. DATE SCALE DRAWING NO. 1 of 2 ISSUE
4/17/91 NONE 1-136-A 2

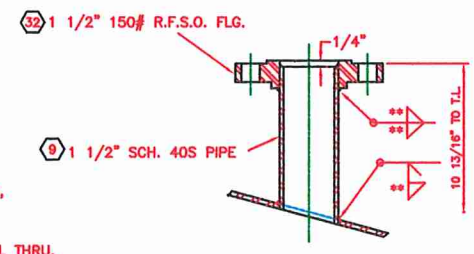
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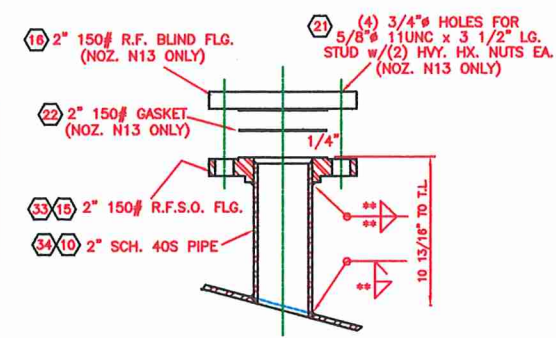
DETAIL NOZ. N1



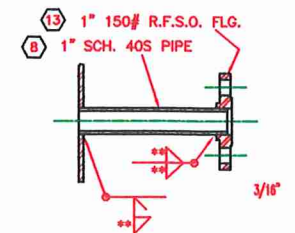
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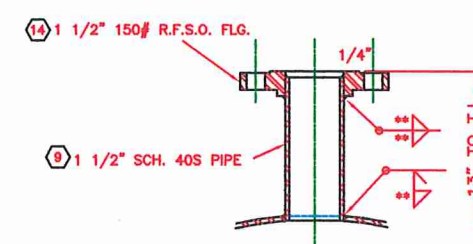
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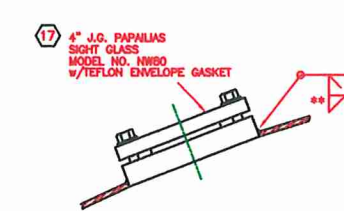
DETAIL NOZ. N4 & N13



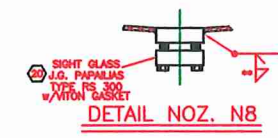
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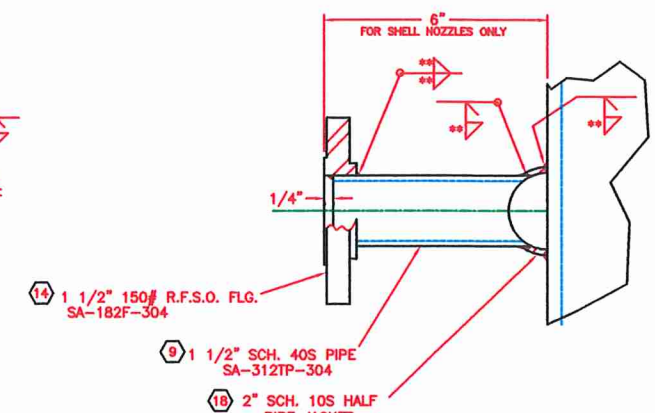
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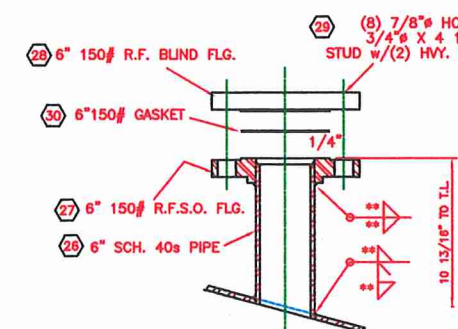
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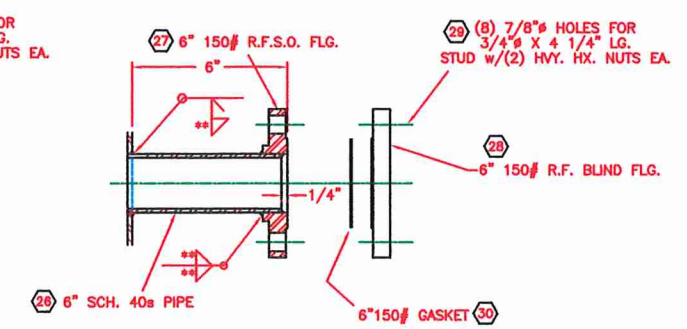
DETAIL NOZ. N8



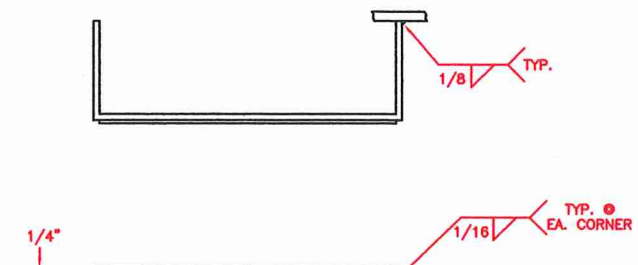
DETAIL NOZ. N9 & N10



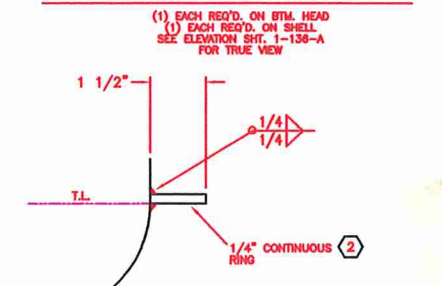
DETAIL NOZ. N12



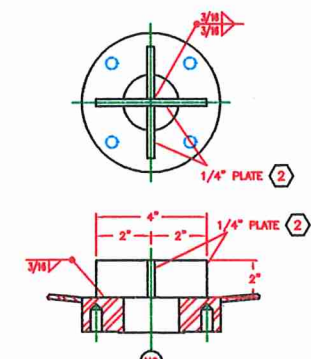
DETAIL NOZ. N11



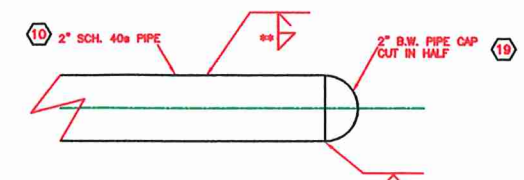
GROUNDING LUG DETAIL



INSULATION SUPPORT DETAIL



VORTEX BREAKER



DETAIL PIPE JACKET

NATIONAL BOARD NO. _____			
CERTIFIED BY ALLOY FABRICATORS, INC. TRENTON, GEORGIA			
SHELL M.A.W.P.	33 PSI AT	335 °F	
M.D.M.T.	-20 °F	33 PSI	
JACKET M.A.W.P.	44 PSI AT	335 °F	
M.D.M.T.	-20 °F	44 PSI	
COIL M.A.W.P.	PSI AT	°F	
M.D.M.T.	°F	PSI	
SERIAL NO.	YEAR BUILT		

NAME PLATE DETAIL

CERTIFIED
RELEASED FOR FABRICATION
DATE _____
PROJECT ENGINEER
ORIGINAL RELEASE DATE: 9-5-91

DATE	REV.	DESCRIPTION	DATE	REV.	DESCRIPTION
4/18/91	1	AS BUILT	4/18/91	1	AS BUILT
4/18/91	2	REV. PER. CUST. APP. ORG. ISSUE TO SHOP	4/18/91	2	REV. PER. CUST. APP. ORG. ISSUE TO SHOP

ALLOY FABRICATORS, INC.
TRENTON, GA.
CUSTOMER
SOFIX CORPORATION
DWG. TITLE
INTERMEDIATE LAYER TANK

DATE 4/18/91 SCALE NONE DRAWING NO. 2 of 2 ISSUE 1-136-B 2

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