

SHIPPING LIST		
QTY.	ITEM	ITEM NO.
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VESSEL SPECIFICATION		
ASME CODE SECTION VIII DIVISION I 1998 EDITION 1999 ADDENDA	HOLD POINTS	1. FIT-UP
		2. WELDING
		3. TESTING
		4.
		5.
		6.

DESIGN P.S.I.	VESSEL	JACKET	COIL
33/(-) 7	125	125	
M.A.W.P.	---	---	---
TEMP.	360° F.	360° F.	360° F.
CORR. ALLOW.	NONE	NONE	NONE
X-RAY	SPOT	NONE	NONE
JOINT. EFF.	85%	70%	70%
TEST P.S.I.G.	45 (VER.)	168	168
M.D.M.T.	---	---	---
P.W.H.T.	N/A	N/A	N/A

INSPECTION	CUST. SOFIX CORP.		
	A.F.I. OUR QUALITY CONTROL		
	A.S.M.E. NATIONAL BOARD A.I.		
VESSEL MATERIALS	HEADS	SA-240-304L	
	SHELL	SA-240-304L	
	PIPE	SA-312-TP304L	TYP.
	FLG'S.	SA-182-F304L	TYP.
	PADS	SA-240-304L	
	BOLTS	SA-193-B7	
	NUTS	SA-194-2H	
	SUPT'S	SA-36	SA-240-304L
	GSK'T		
	L.L.	SA-240-304L	N/A
	FTNGS	SA-403-WP304L	SA-403-WP304L
	INSUL.	(BY OTHERS)	

DRAWING STATUS	CERTIFIED	
	RELEASED FOR FABRICATION	
PROJECT ENGINEER	DATE	

NON-DESTRUCTIVE EXAMINATION	---

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

SURFACE FIN.	ALL WELDS-SMOOTH AS WELDED.	
	-PICKLE & PASSIVATE ALL STAINLESS STEEL	
	-CLEAN ALL C.S. SURFACES PER SSPC-SP 2 & APPLY	
	(1) COAT SHOP PRIMER (2 MILS. D.F.T.).	

VESSEL DATA	CONTENTS: --- SP. GR. = 1.55	
	CAPACITY: 5,154 GALLONS APPROX.	
	WT. EMPTY: 9,800 LBS. APPROX.	
	WT. WITH CONTENTS: 52,750 LBS. APPROX. w/WATER	

REMARKS	COVER ALL OPENINGS PRIOR TO SHIPMENT	
	FLG. BOLT HOLES TO STRADDLE TANK CENTERLINES UNLESS OTHERWISE NOTED.	

TOLERANCES	DRAWN BY: TERRY REYNOLDS	
	CHECKED BY: DAVID PARHAM	

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

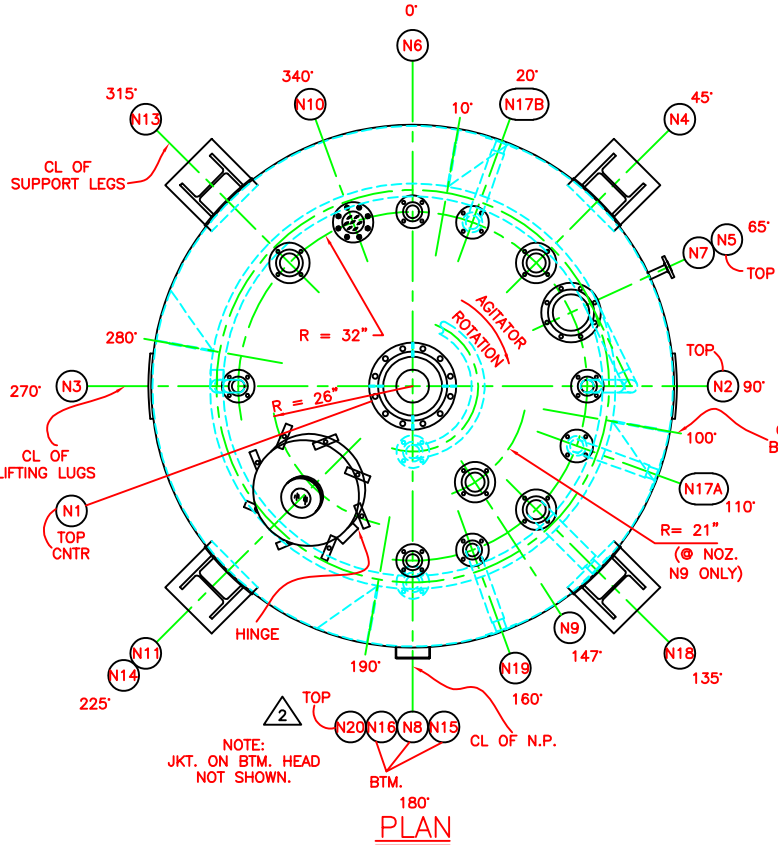
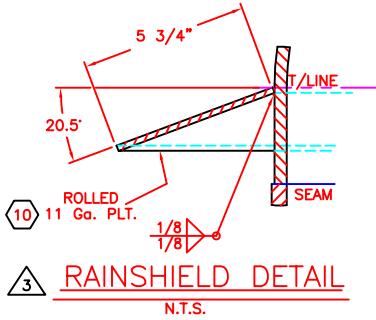
DESCRIPTION	P.O.NO.: P00-0248	
	EQUIP. No.: C 4100	
	PROJ. No.: ---	
	PLANT: CHATTANOOGA, TN	

REV.	ALLOY FABRICATORS, INC.	
	TRENTON, GA.	
	CUSTOMER	
	SOFIX CORP.	

REV.	DWG. TITLE	
	VERTICAL REACTOR VESSEL	
	DATE	
	4-11-00	

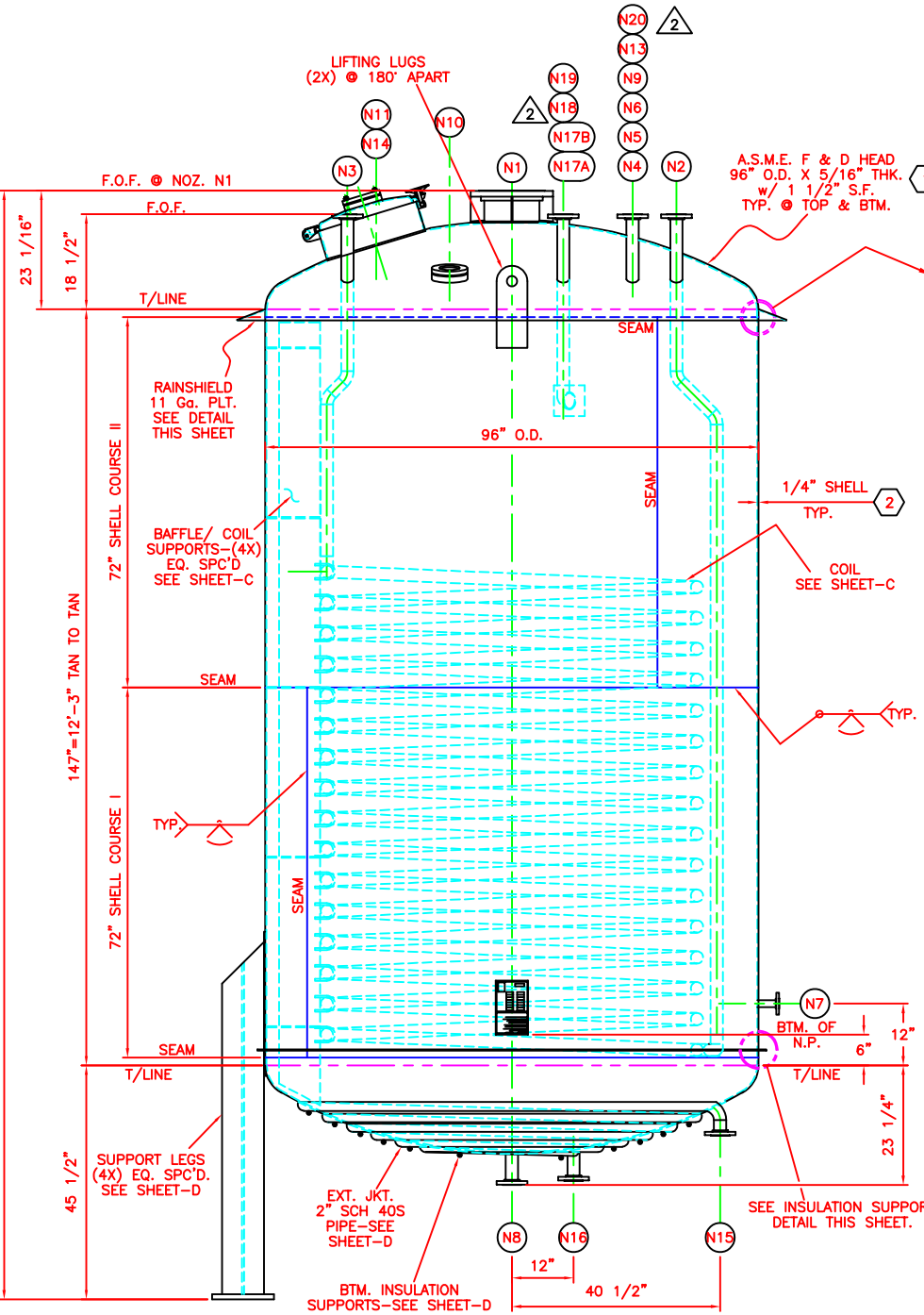
REV.	PLOT SCALE	
	1 = 24	
	DRAWING NO. 1 of 4	
	00-155-A	

REV.	ISSUE	
	3	

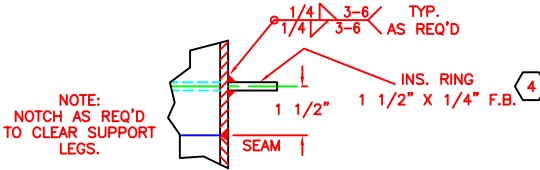


NO.	QTY.	SIZE	FLG. DESCRIPTION	MAT'L.	NOZZ. NECK	SERVICE	REMARKS
N20	1	2"	150# R.F.S.O. FLG.	SA-182-F304L	SCH 40S PIPE	SPARE	w/ BLIND
N19	1	2"	150# R.F.S.O. FLG.	SA-182-F304L	SCH 40S PIPE	TOLUENE IN	w/ DIP TUBE
N18	1	3"	150# R.F.S.O. FLG.	SA-182-F304L	SCH 40S PIPE	ALKALI IN	w/ DIP TUBE
N17	2	2"	150# R.F.S.O. FLG.	SA-182-F304L	SCH 40S PIPE	SPARE	w/ DIP TUBE & BLD.
N16	1	2"	150# R.F.S.O. FLG.	SA-182-F304L	SCH 40S PIPE	STEAM OUT	FROM EXT. JKT.
N15	1	2"	150# R.F.S.O. FLG.	SA-182-F304L	SCH 40S PIPE	STEAM IN	TO EXT. JKT.
N14	1	20"	HUBER	SA-240-304L	---	MANWAY	510 SWING-BOLT
N13	1	3"	150# R.F.S.O. FLG.	SA-182-F304L	SCH 40S PIPE	SAFETY VALVE	---
N11	1	4"	PAD FLG.	SA-240-304L	N/A	SIGHT GLASS	---
N10	1	4"	PAD FLG.	SA-240-304L	N/A	SIGHT GLASS	---
N9	1	3"	150# R.F.S.O. FLG.	SA-182-F304L	SCH 40S PIPE	LEVEL	---
N8	1	2"	150# R.F.S.O. FLG.	SA-182-F304L	SCH 40S PIPE	FLUID	PRODUCT OUT
N7	1	1 1/2"	150# R.F.S.O. FLG.	SA-182-F304L	SCH 40S PIPE	TEMP	---
N6	1	2"	150# R.F.S.O. FLG.	SA-182-F304L	SCH 40S PIPE	NITROGEN IN	---
N5	1	6"	150# R.F.S.O. FLG.	SA-182-F304L	SCH 40S PIPE	EX. HEADER	---
N4	1	3"	150# R.F.S.O. FLG.	SA-182-F304L	SCH 40S PIPE	EX. HEADER	---
N3	1	2"	150# R.F.S.O. FLG.	SA-182-F304L	SCH 40S PIPE	125# STEAM OUT	TO STEAM COIL
N2	1	2"	150# R.F.S.O. FLG.	SA-182-F304L	SCH 40S PIPE	125# STEAM IN	TO STEAM COIL
N1	1	10"	150# R.F.S.O. FLG.	SA-182-F304L	SCH 40S PIPE	AGITATOR	---

DATE	CHK'D BY	REV.	DESCRIPTION	REV.
8-4	T.R.	AS BUILT		3
6-22	T.R.	ADDED NOZ. N20/REV. NOZS. N17,N18 & N19		2
4-26	T.R.	REV. PER CUST. APP. ORIG. ISSUE TO SHOP		1

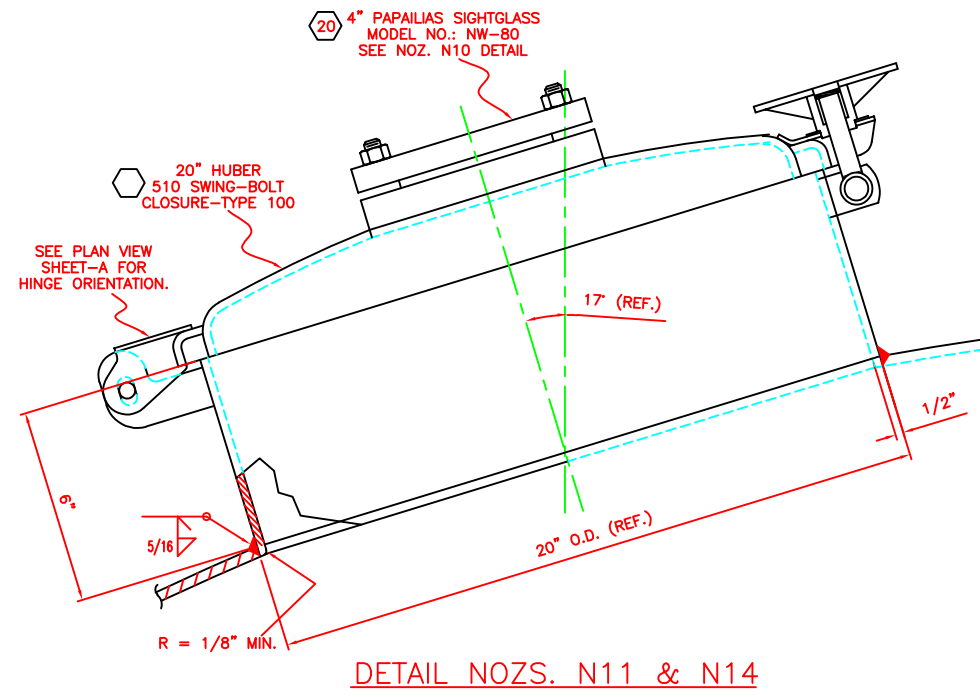
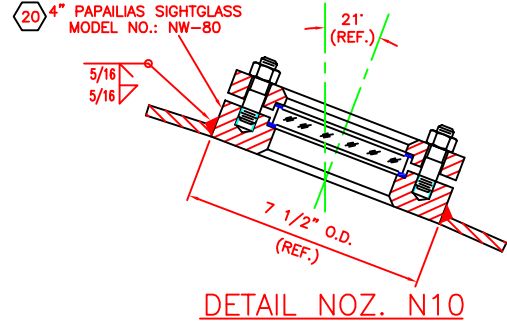
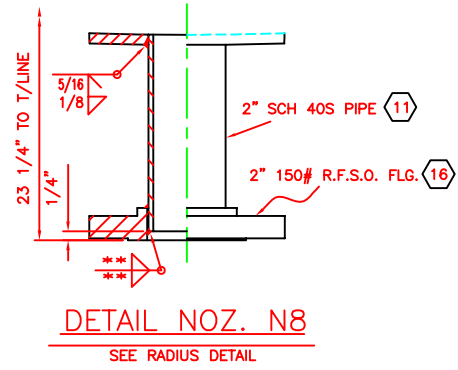
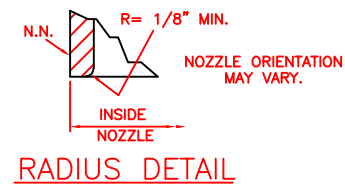
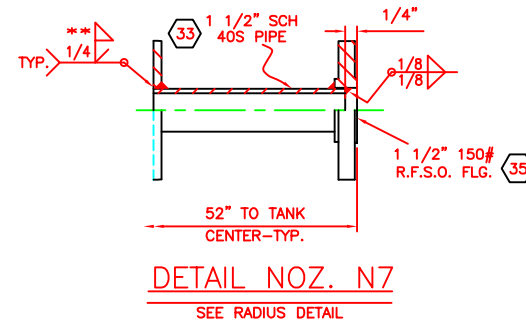
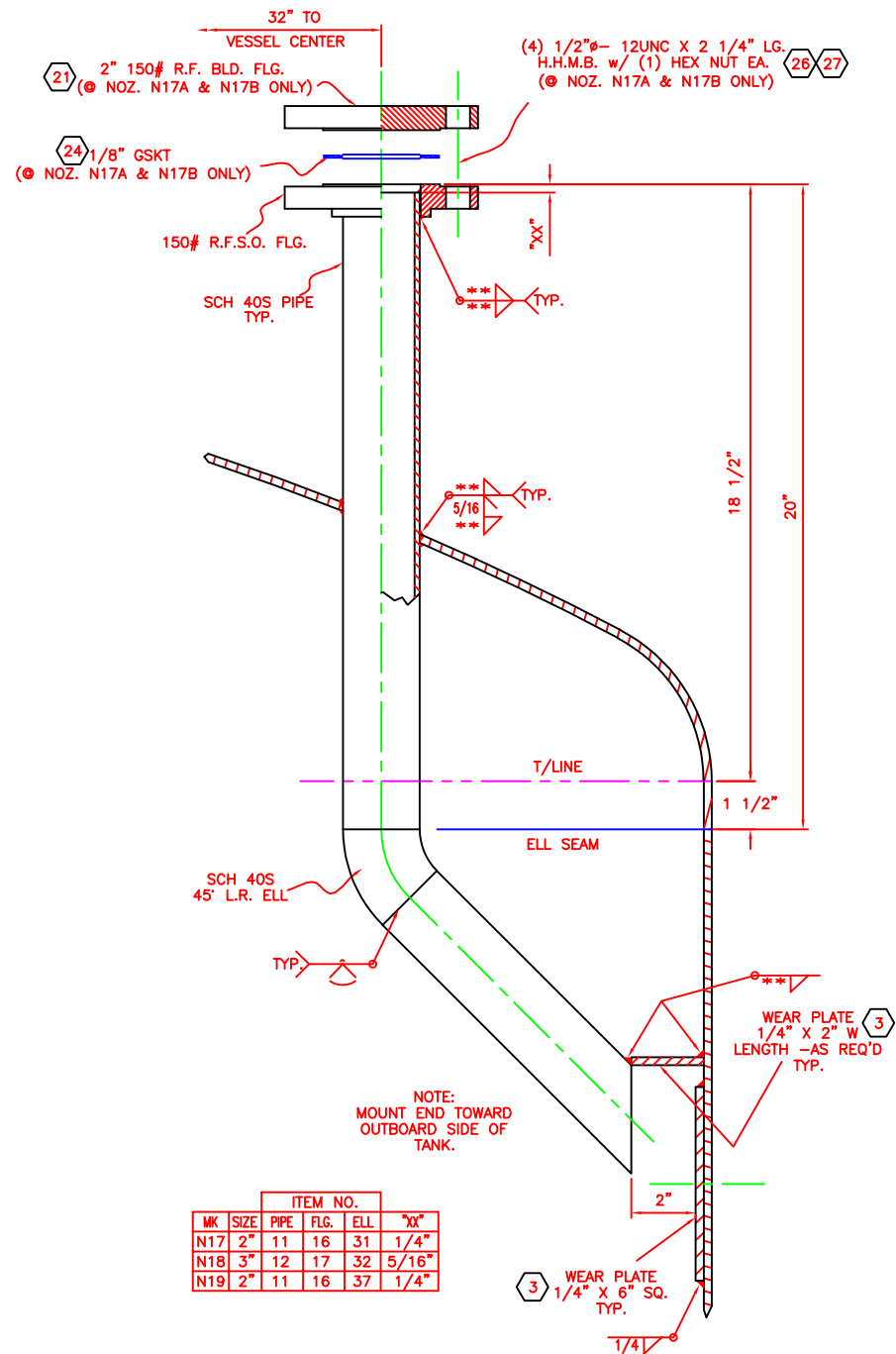
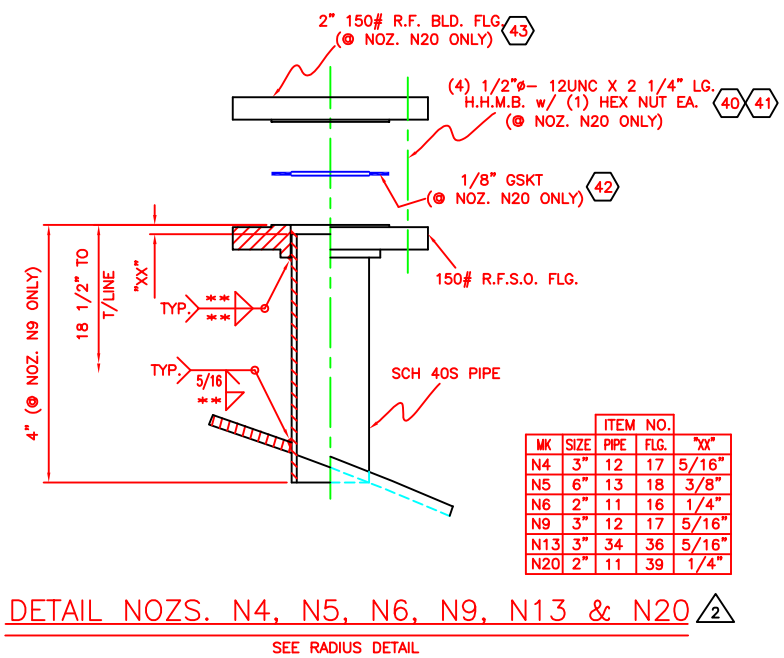
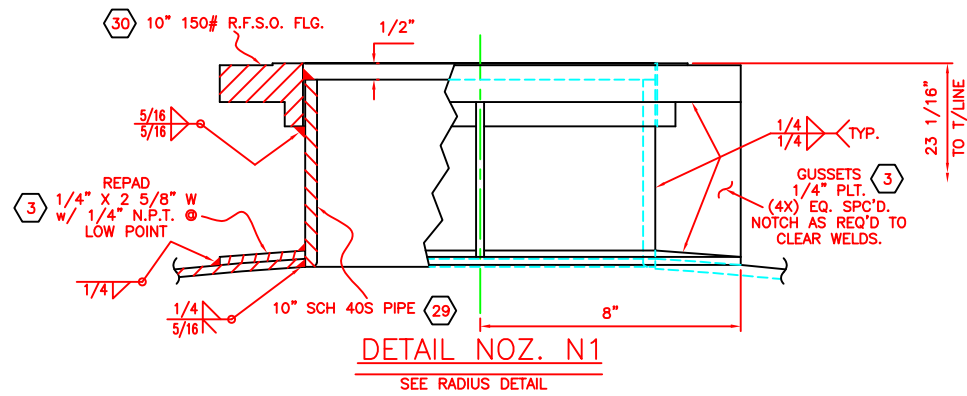


ELEVATION



INSULATION SUPPORT DETAIL

(1X)



** FILLET SIZE EQUAL TO THINNER OF PIPE WALL OR PLATE THICKNESS.

CERTIFIED
RELEASED FOR FABRICATION
DATE _____
PROJECT ENGINEER _____

DATE REC'D	DATE REC'D	DATE REC'D	CUST. DATA
8-4	8-22	4-28	
CHK'D BY:	CHK'D BY:	CHK'D BY:	
REV. BY:	REV. BY:	REV. BY:	
T.R.	T.R.	T.R.	
DATE	DESCRIPTION	REV.	
8-4	ADDED NOZ. N20/REV. NOZS. N17, N18 & N19	1	
8-22	REV. PER. CUST. APP. ORIG. ISSUE TO SHOP	2	
4-28		3	
P.O. NO.:	EQUIP. No.:	PROJ. No.:	
DRAWN BY:	CHECKED BY:		
ALLOY FABRICATORS, INC.			
TRENTON, GA.			
CUSTOMER			
SOFIX CORP.			
DWG. TITLE			
VERTICAL REACTOR VESSEL			
DATE	PLOT SCALE	DRAWING NO. 2 of 4	ISSUE
4-11-00	1 = 4	00-155-B	3



**** FILLET SIZE EQUAL TO THINNER OF PIPE WALL OR PLATE THICKNESS.**



DESIGN: JKT.: 125 P.S.I. @ 360° F.
TEST PRESSURE: JKT.: 168 P.S.I.G.
DESIGN: COIL: 125 P.S.I. @ 360° F.
TEST PRESSURE: COIL: 168 P.S.I.G.

[illegible]