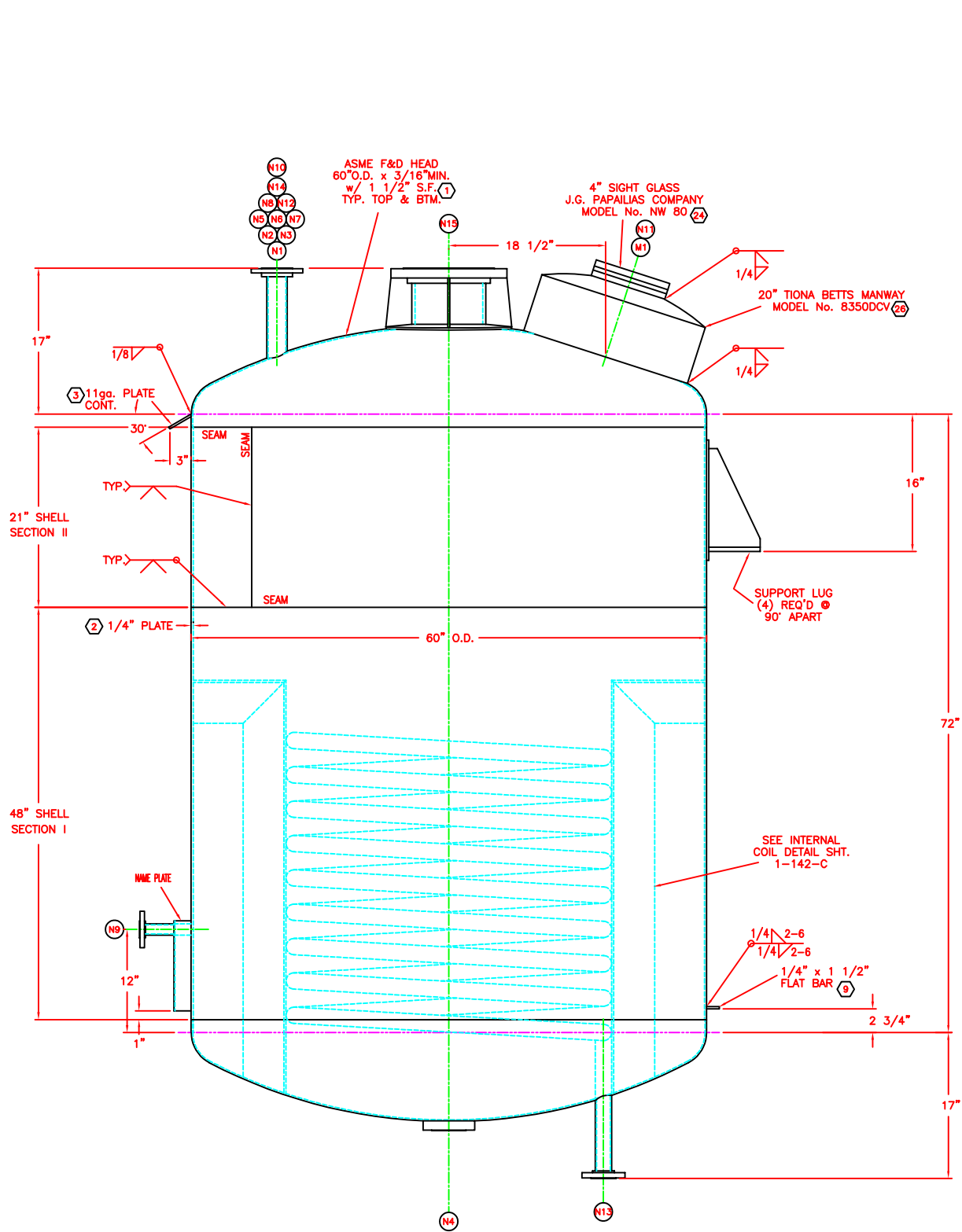
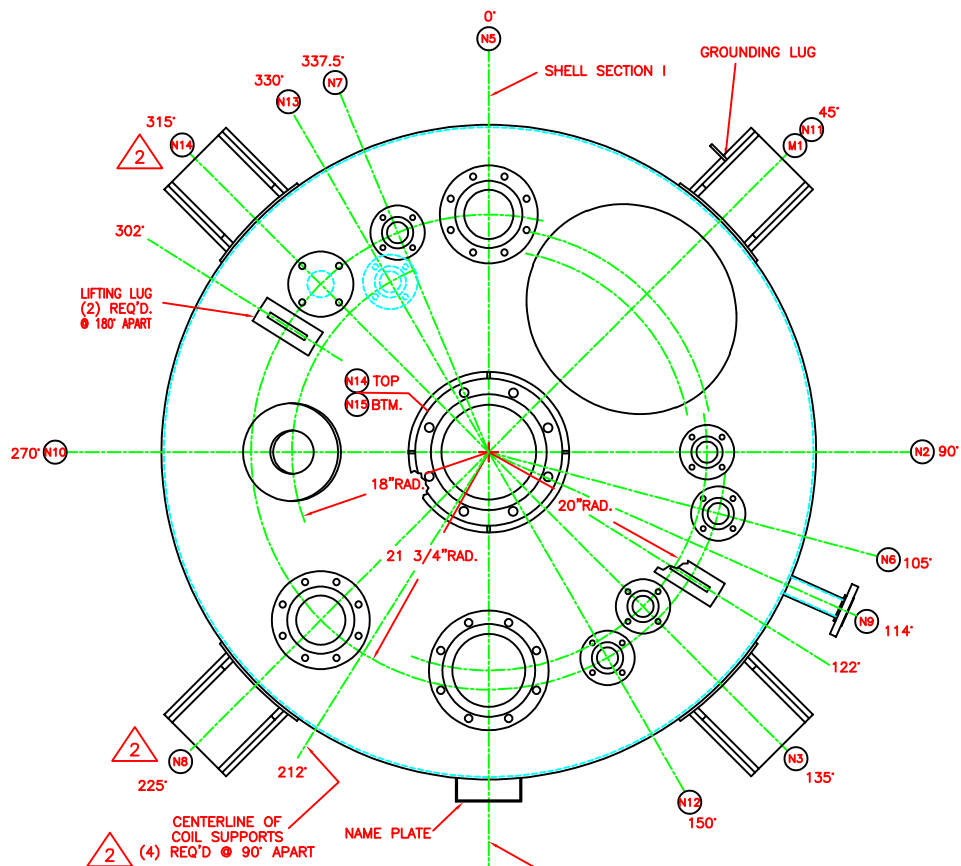




ELEVATION



PLAN

ALL BOLT HOLES
TO STRADDLE NORMAL
VESSEL CENTERLINES

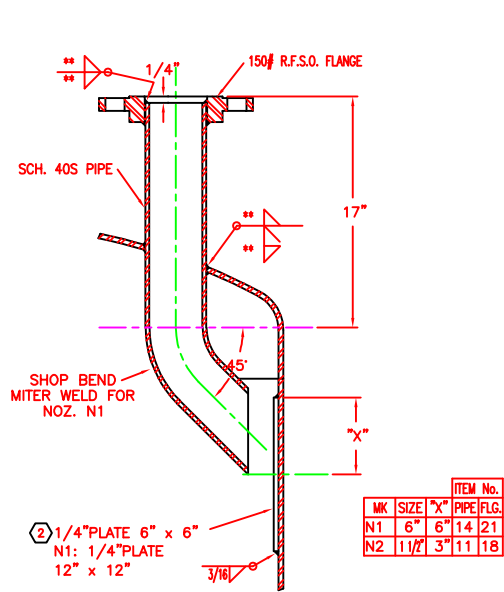
DATE	CHK'D BY	REV. BY	DESCRIPTION	REV.
5-24	T. GISS		CHANGE SIZE & OREN. @ NOZ. N8 & N14, LOCATE PIPE SUPS.	2
4-30	K.W.M.		REV. PER CUST. APP. ORIG. ISSUE TO SHOP	1

MK.	NO.	REQ'D	SIZE	DESCRIPTION	SCH.	40S PIPE	SERVICE	REMARKS
M1	1	20"		TIONA BETTS COMPANY	T-304	----	MANWAY	
N15	1	10"		150# R.F.S.O. FLANGE	SA-182-F304	3/8" PLATE	AGITATOR	
N14	1	2"		150# R.F.S.O. FLANGE	SA-182-F304	SCH. 40S PIPE	SPARE	w/ BLIND FLANGE
N13	1	1 1/2"		150# R.F.S.O. FLANGE	SA-182-F304	SCH. 40S PIPE	NOZ. OUTLET/MS INLET	
N12	1	1 1/2"		150# R.F.S.O. FLANGE	SA-182-F304	SCH. 40S PIPE	MS INLET/NOZ. OUTLET	
N11	1	4"		J.G. PAPALIAS COMPANY	T-304	----	SIGHT GLASS	MODEL NW80
N10	1	4"		J.G. PAPALIAS COMPANY	T-304	----	LIGHT GLASS	MODEL SL100/NW80
N9	1	1"		150# R.F.S.O. FLANGE	SA-182-F304	SCH. 40S PIPE	TI	
N8	1	6"		150# R.F.S.O. FLANGE	SA-182-F304	SCH. 40S PIPE	SAFETY VALVE	
N7	1	1 1/2"		150# R.F.S.O. FLANGE	SA-182-F304	SCH. 40S PIPE	VENT	
N6	1	1 1/2"		150# R.F.S.O. FLANGE	SA-182-F304	SCH. 40S PIPE	30PA INLET	
N5	1	4"		150# R.F.S.O. FLANGE	SA-182-F304	SCH. 40S PIPE	VAPOR OUTLET	
N4	1	2"		PLATE FLANGE	SA-240-304	----	LIQUID OUTLET	
N3	1	1 1/2"		150# R.F.S.O. FLANGE	SA-182-F304	SCH. 40S PIPE	RW INLET	
N2	1	1 1/2"		150# R.F.S.O. FLANGE	SA-182-F304	SCH. 40S PIPE	LIQUID INLET	
N1	1	6"		150# R.F.S.O. FLANGE	SA-182-F304	SCH. 40S PIPE	LIQUID INLET	
				MAT'L.			NOZZ. NECK	

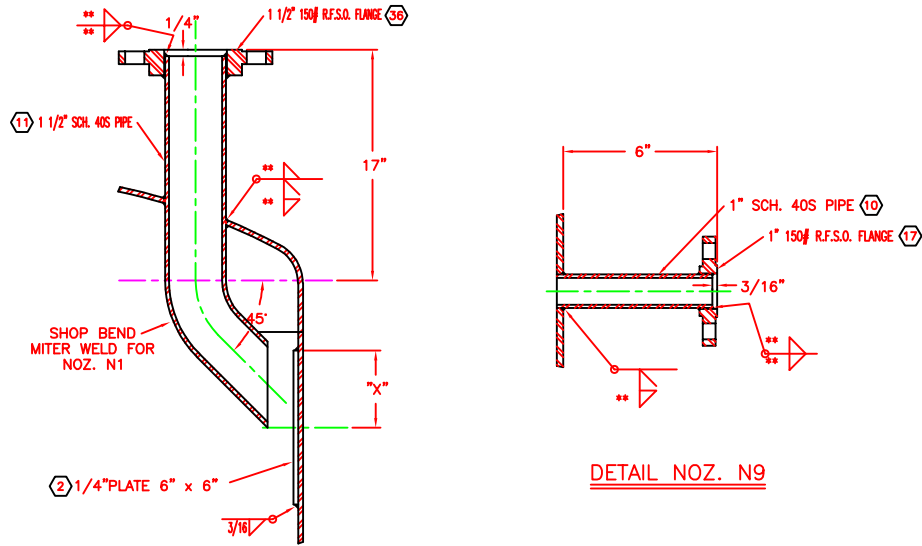
NOZZLE SCHEDULE

VESSEL SPECIFICATION

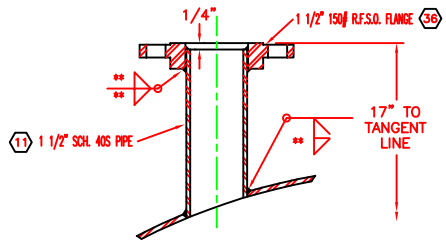
DESIGN CODE	ASME CODE SECTION VIII		HOLD POINTS	1. FIT-UP
	DIV. I 1989 EDITION			2. WELDING
	1989 ADDENDA			3. TESTING
				4.
				5.
				6.
CODE STAMP: A.S.M.E. NATIONAL BOARD				
DESIGN CONDITION	VESSEL		JACKET	COIL
	P.S.I.G.	33		85
	TEMP.	335°F		335°F
	CORR. ALLOW.	NONE		NONE
	X-RAY	NONE		NONE
	JOINT. EFF.	70%		70"
	TEST P.S.I.G.	57		146
INSPECTION	M.D.M.T.	-20°F @ 33 PSI		-20°F @ 85 PSI
	P.W.H.T.	N/R		N/R
	CUST. SOFIX CORPORATION			
VESSEL MATERIALS	A.F.I. OUR QUALITY CONTROL			
	A.S.M.E. NATIONAL BOARD A.I.			
	VESSEL		COIL	
	HEADS	SA-240-304		
	SHELL	SA-240-304		
	PIPE	SA-312-TP304	SA-312-TP304	
	FLG'S.	SA-182-F304		
	PADS	SA-240-304		
	BOLTS	SA-193-B7	T-304	
	NUTS	SA-194-2H	T-304	
DRAWING STATUS	SUPT'S	SA-36	SA-240-304	
	GSK'T	GARLOCK 6326 UNLESS NOTED		
WELDING	RELEASED FOR FABRICATION			
	DATE			
	PROJECT ENGINEER			
	ORIGINAL RELEASE DATE: 5-10-91			
SURFACE FIN.	FULL PENETRATION AS NOTED AS PER A.F.I. WELD SPEC. NO.:			
	1-8-B, 1-1-AD, 1-8-AD, 1-8-B, 1-8-C, 8-8-B			
	8-8-C & 8-8-AD			
	INTERNAL NOZZLE WELDS SHALL BE GROUND SMOOTH			
	ALL OTHER WELDS SMOOTH AS WELDED.			
	PICKLE & PASSIVATE ALL STAINLESS STEEL			
	SANDBLAST ALL CARBON STEEL PER SSPC-SP6			
	PAINT ALL CARBON STEEL WITH PORTER 7501 MAGNA			
VESSEL DATA	PRIME (5.0 MILS D.F.T.), FINISH WITH PORTER			
	8731 HYTHANE ULTRA COLOR: "SOFIX BLUE"			
	(4.0 MILS. D.F.T.)			
	CONTENTS: -- SP. GR. = 1.0			
	CAPACITY: 1,013 GALLONS APPROX.			
	WT. EMPTY: 3,290 LBS. APPROX.			
	WT. WITH CONTENTS: 11,740 LBS. APPROX. w/ WATER			
	FLG. FACE FINISH: STANDARD AS PURCHASED			
REMARKS	COVER ALL OPENINGS PRIOR TO SHIPMENT			
	DRAWN BY: KEVIN W. MULLINS			
	CHECKED BY:			
TOLERANCES	OVERALL DIM.: ±1/4"			
	NOZ. PROJ. AND LOCATION: ±1/4"			
	SUPT. AND LUG LOCATION: ±1/4"			
	FLG. FACE LEVEL: ±1/2"			
	ORIENTATION: ±1/4"			
CUST. DATA	P.O.NO.: 91-00006			
	EQUIP. No.: C5113			
	PROJ. No.: 5262A			
	PLANT: CHATTANOOGA, TENNESSEE			
DESCRIPTION	ALLOY FABRICATORS, INC.			
	TRENTON, GA.			
	CUSTOMER			
	SOFIX CORPORATION			
REV.	DWG. TITLE			
	RESIDUE TANK			
	DATE	SCALE	DRAWING NO. 1 of 3	ISSUE
	1-24-91	NONE	1-142-A	2



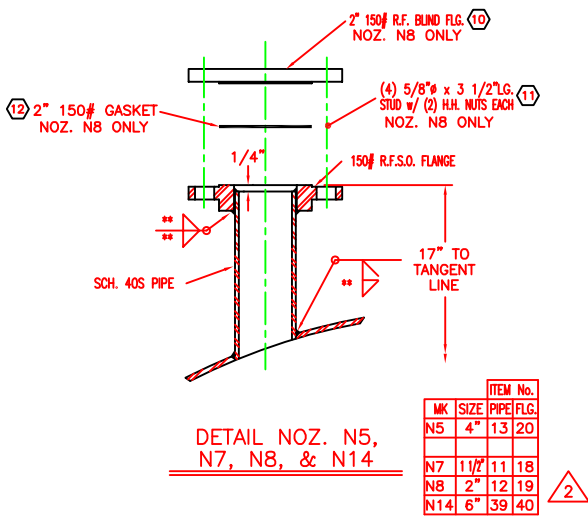
DETAIL NOZ. N1 & N2



DETAIL NOZ. N3

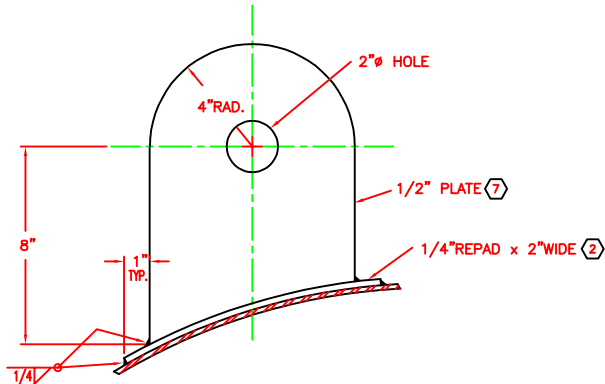
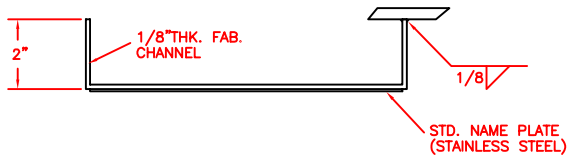


DETAIL NOZ. N6

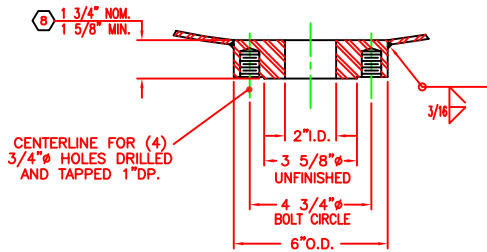


DETAIL NOZ. N5, N7, N8, & N14

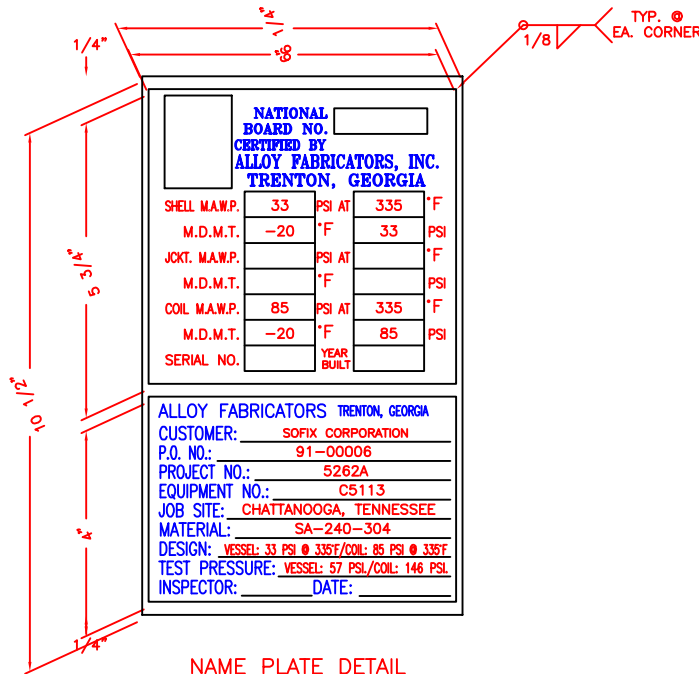
ITEM No.			
MK	SIZE	PIPE	FLG.
N5	4"	13	20
N7	1 1/2"	11	18
N8	2"	12	19
N14	6"	39	40



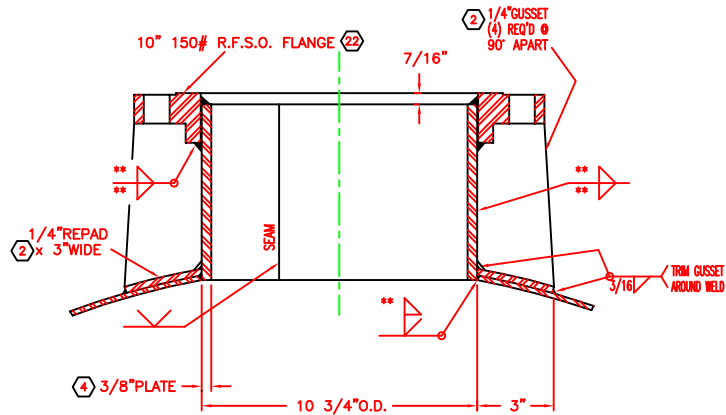
DETAIL LIFTING LUG



DETAIL NOZ. N4



NAME PLATE DETAIL

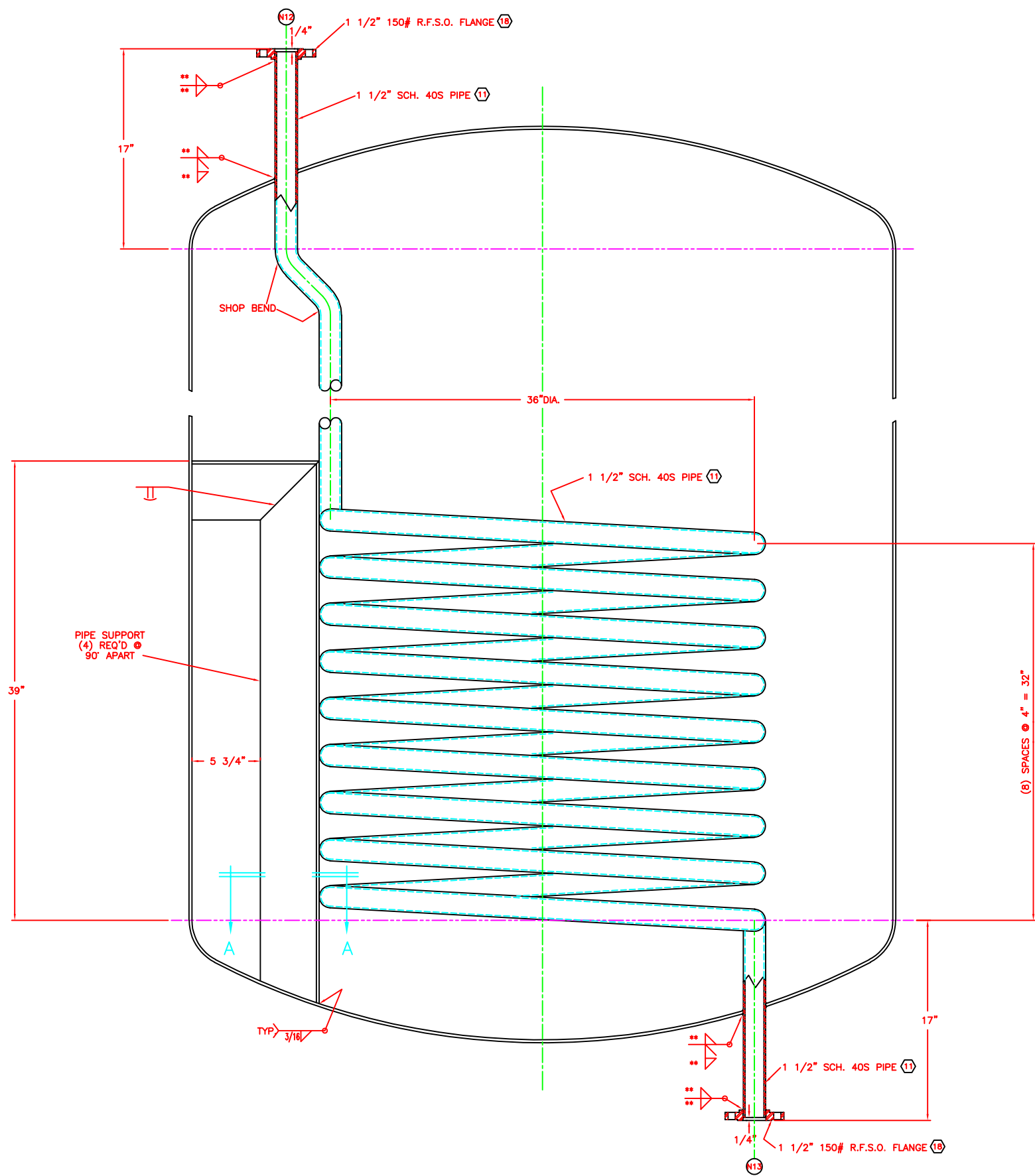


DETAIL NOZ. N15

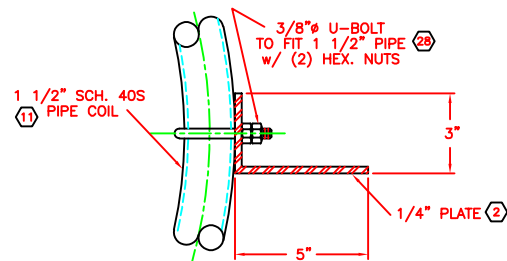
** FILLET SIZE EQUAL TO THINNER OF PIPE WALL OR SHELL THICKNESS

CERTIFIED
RELEASED FOR FABRICATION
DATE _____
PROJECT ENGINEER
ORIGINAL RELEASE DATE: 5-10-91

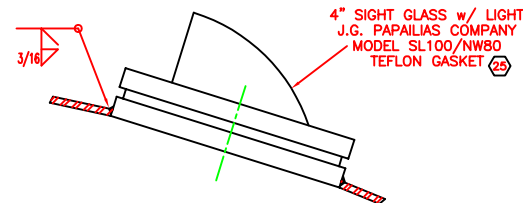
DATE RECD.		DATE RECD.		DATE RECD.		CUST. DATA	REV.	DESCRIPTION	REV.
6-14		6-24		4-30					
CH'D BY:		CH'D BY:		CH'D BY:					
REV. 91:		REV. 91:		REV. 91:					
T. GASS		T. GASS		K.W.M.					
AS BUILT		CHANGE N8 TO 6"		REV. PER. CUST. APP.		REV.		DESCRIPTION	
				ORIG. ISSUE TO SHOP					
1-20		3		5-20		2		1	
P.O.NO.: 91-00006									
EQUIP. No.: C5113									
PROJ. No.: 5262A									
DRAWN BY: KEVIN W. MULLINS									
CHECKED BY:									
ALLOY FABRICATORS, INC.									
TRENTON, GA.									
CUSTOMER									
SOFIX CORPORATION									
DWG. TITLE									
RESIDUE TANK									
DRAWING NO. 2 of 3									
ISSUE									
2-8-91									
NONE									
1-142-B									
3									



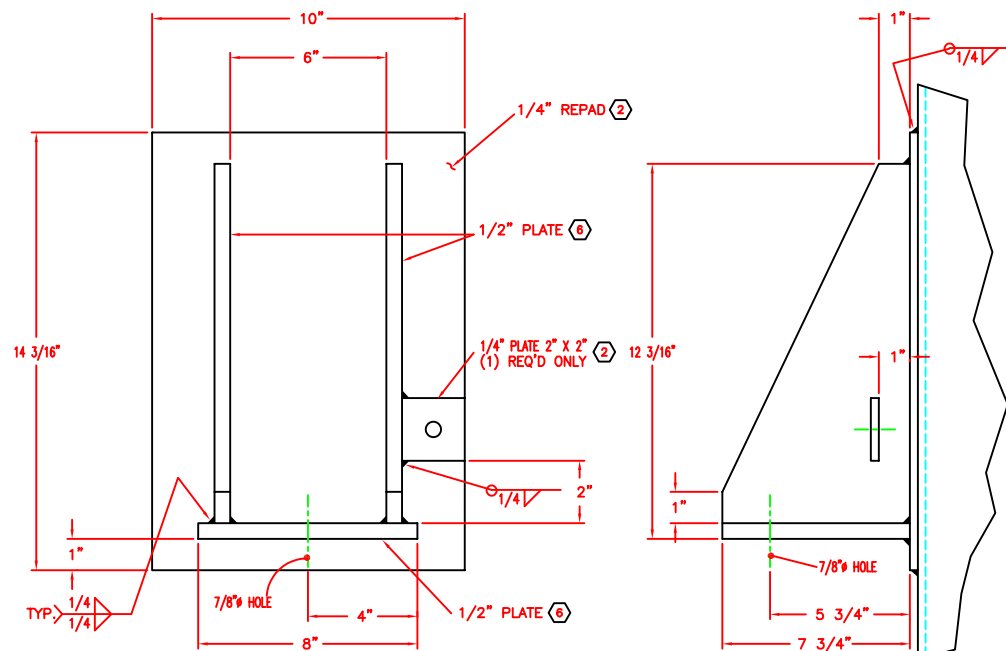
INTERNAL COIL DETAIL



SECTION A-A



DETAIL NOZ. N10



SUPPORT LUG & GROUNDING LUG DETAIL

(4) REQ'D @ 90° APART
(2) GROUNDING LUGS REQ'D, LOCATE (1) @ 45°, & (1) @ 225°

DRAWING STATUS		CERTIFIED	
		RELEASED FOR FABRICATION	
		DATE _____	
		PROJECT ENGINEER _____	
		ORIGINAL RELEASE DATE: 5-10-91	
DATE REQ'D 8-14 CHK'D BY T. GOS	DATE REQ'D 1-30 CHK'D BY K.W.M.	P.O. NO.: 91-00006	
		EQUIP. No.: C5113	
REV. BY T. GOS	REV. BY K.W.M.	PROJ. No.: 5262A	
		DRAWN BY: KEVIN W. MULLINS	
AS BUILT	REV. PER. CUST. APP. ORG. ISSUE TO SHOP	CHECKED BY:	
		ALLOY FABRICATORS, INC.	
1-20	2	TRENTON, GA.	
		CUSTOMER	
1-20	2	SOFIX CORPORATION	
		DWG. TITLE	
1-20	2	RESIDUE TANK	
		DATE	
1-20	2	SCALE	
		NONE	
1-20	2	DRAWING NO. 3 of 3	
		1-142-C	
1-20	2	ISSUE	
		2	