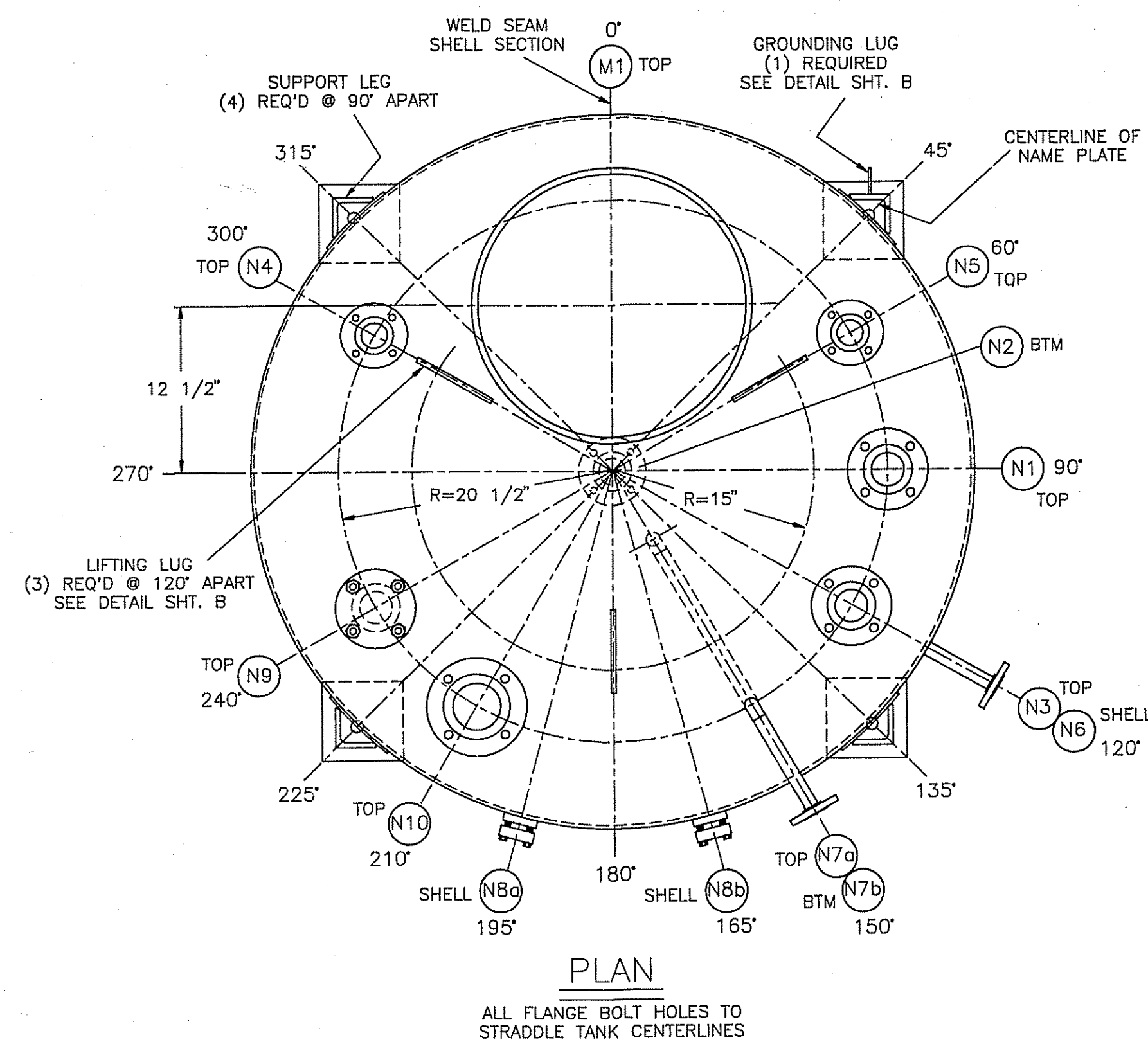
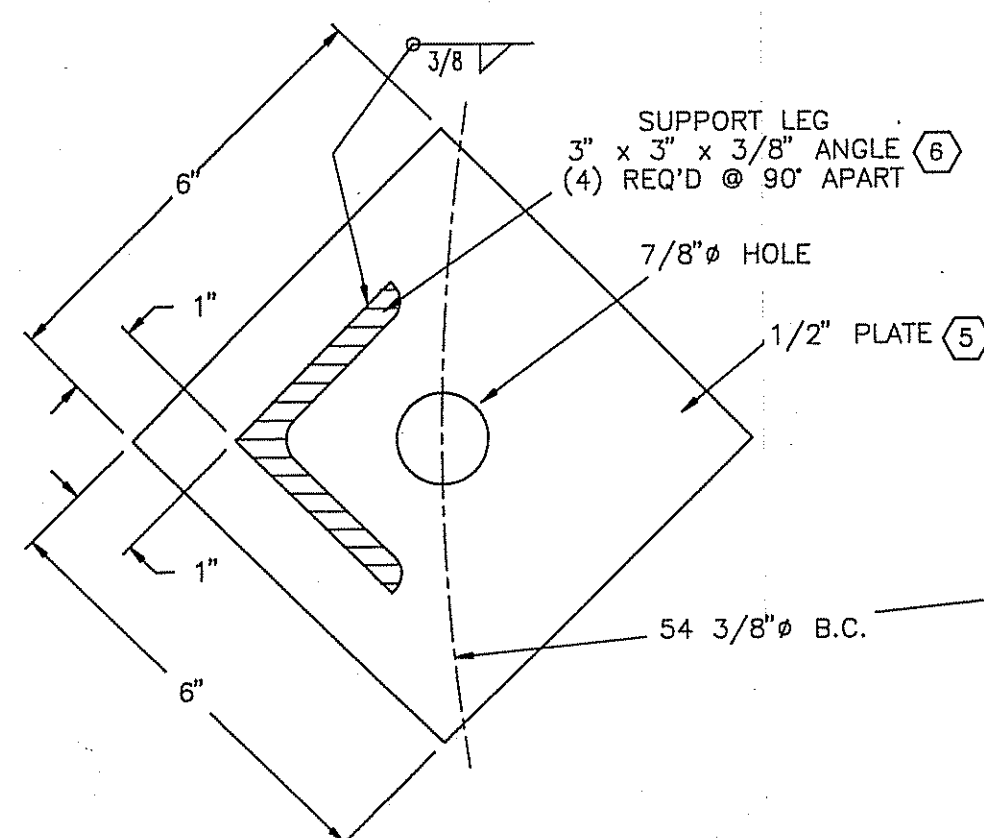
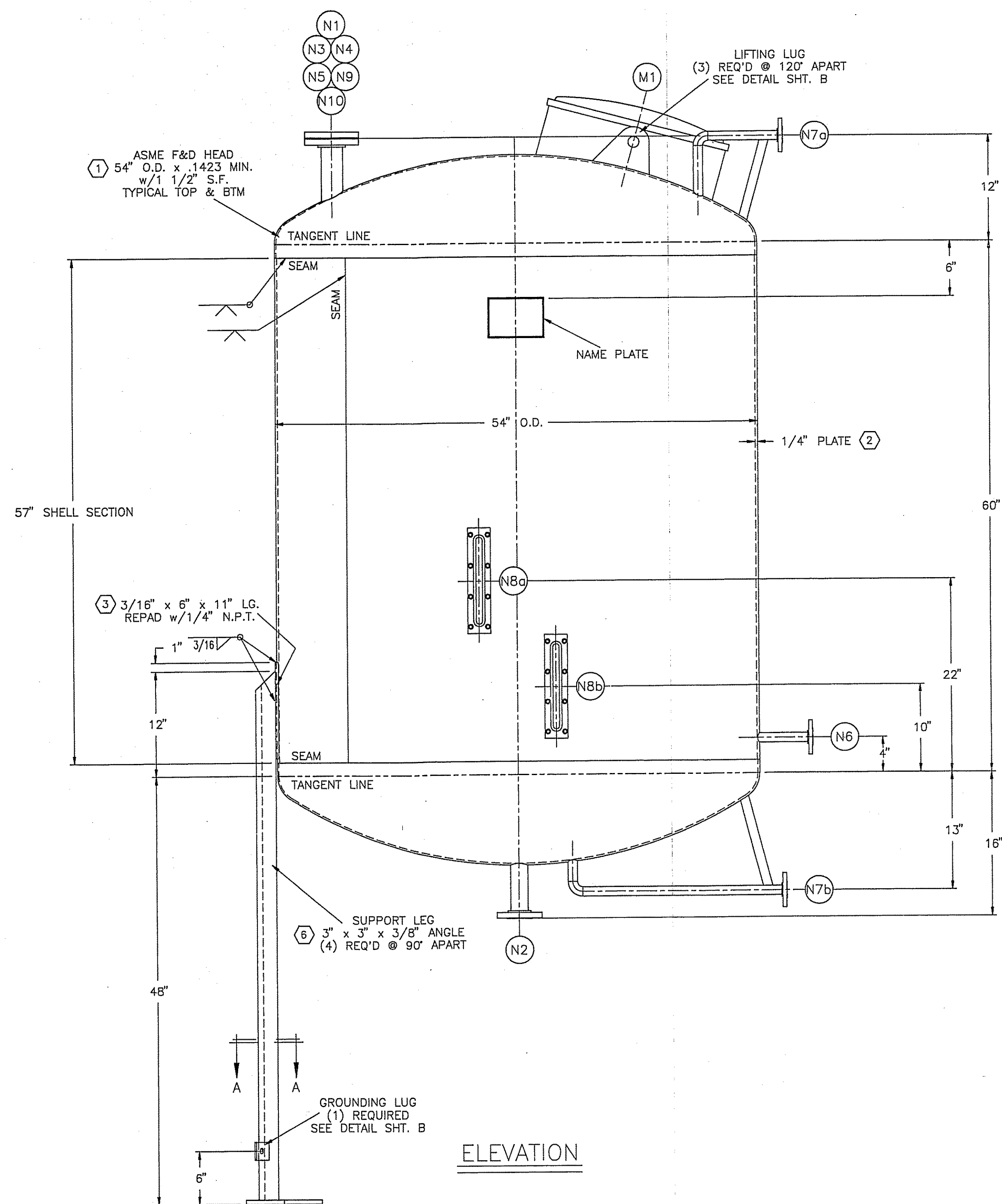




MK.	NO.	REQ'D	SIZE	DESCRIPTION	MAT'L.	NOZZ. NECK	SERVICE	REMARKS
M1	1	20"	TIONA BETTS	T-304	-----	MANWAY	MODEL 8306-CCV	
N10	1	3"	150# R.F.S.O.	SA-182F-304	SCH. 40S PIPE	SAFETY VALVE	-----	
N9	1	2"	150# R.F.S.O.	SA-182F-304	SCH. 40S PIPE	SPARE	w/BLIND FLANGE	
N8	2	1 1/2"	J.G. PAPAILIAS	T-304	-----	SIGHT GLASS	TYPE RS300	
N7	2	3/4"	150# R.F.S.O.	SA-182F-304	SCH. 40S PIPE	LG	-----	
N6	1	3/4"	150# R.F.S.O.	SA-182F-304	SCH. 40S PIPE	SAMPLING	-----	
N5	1	1 1/2"	150# R.F.S.O.	SA-182F-304	SCH. 40S PIPE	VENT	-----	
N4	1	1 1/2"	150# R.F.S.O.	SA-182F-304	SCH. 40S PIPE	VENT	-----	
N3	1	2"	150# R.F.S.O.	SA-182F-304	SCH. 40S PIPE	VAPOR OUTLET	-----	
N2	1	1 1/2"	150# R.F.S.O.	SA-182F-304	SCH. 40S PIPE	LIQUID OUTLET	-----	
N1	1	2"	150# R.F.S.O.	SA-182F-304	SCH. 40S PIPE	LIQUID INLET	-----	

DATE	CHK'D	REV.	BY:	DESCRIPTION	REV.
6-07	K.M.	L.CASS		REV. PER CUST. APP.	
				ORIG. ISSUE TO SHOP	

NOZZLE SCHEDULE

VESSEL SPECIFICATION

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

CODE STAMP: NOT REQUIRED

DESIGN CONDITION	VESSEL	JACKET	COIL
P.S.I.G.	15 & F.V.		
TEMP.	295'		
CORR. ALLOW.	NONE		
X-RAY	NONE		
JOINT. EFF.	70%		
TEST P.S.I.G.	26		
M.D.M.T.	-20F @ 15 PSIG		
P.W.H.T.	N/A		

CUST. SOFIX CORPORATION
A.F.I. OUR QUALITY CONTROL

VESSEL MATERIALS	VESSEL	JACKET
HEADS	SA-240T-304	
SHELL	SA-240T-304	
PIPE	SA-312TP-304	
FLG'S.	SA-182F-304	
PADS	SA-240T-304	
BOLTS	SA-193-B7	
NUTS	SA-194-2H	
SUPT'S	SA-36	
GSK'T	CARLOCK 6326 OR EQUAL UNLESS NOTED MILLED TYPE (TFE)	

CERTIFIED

RELEASED FOR FABRICATION

DATE 6-19-91
PROJECT ENGINEER

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

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

PICKLE & PASSIVATE ALL STAINLESS STEEL
SANDBLAST ALL C/S PER SSPC-SB6.
PAINT ALL C/S w/PORTER 7501 MAGNA PRIME (5.0 MILS D.F.T.)
FINISH w/PORTER 8731 HYTHANE ULTRA "SOFIX BLUE" (4.0 MILS D.F.T.)

CONTENTS: PERCH. SP. GR. = 1.624
CAPACITY: 690 GALLONS APPROX.
WT. EMPTY: 2,100 LBS. APPROX.
WT. WITH CONTENTS: 7,858 LBS. APPROX. w/WATER
FLG. FACE FINISH: STANDARD AS PURCHASED

COVER ALL OPENINGS PRIOR TO SHIPMENT

DRAWN BY: TIM CASS
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.: C9011 A
PROJ. No.: 5262A
PLANT: CHATTANOOGA, TENNESSEE

ALLOY FABRICATORS, INC.

TRENTON, GA.

CUSTOMER

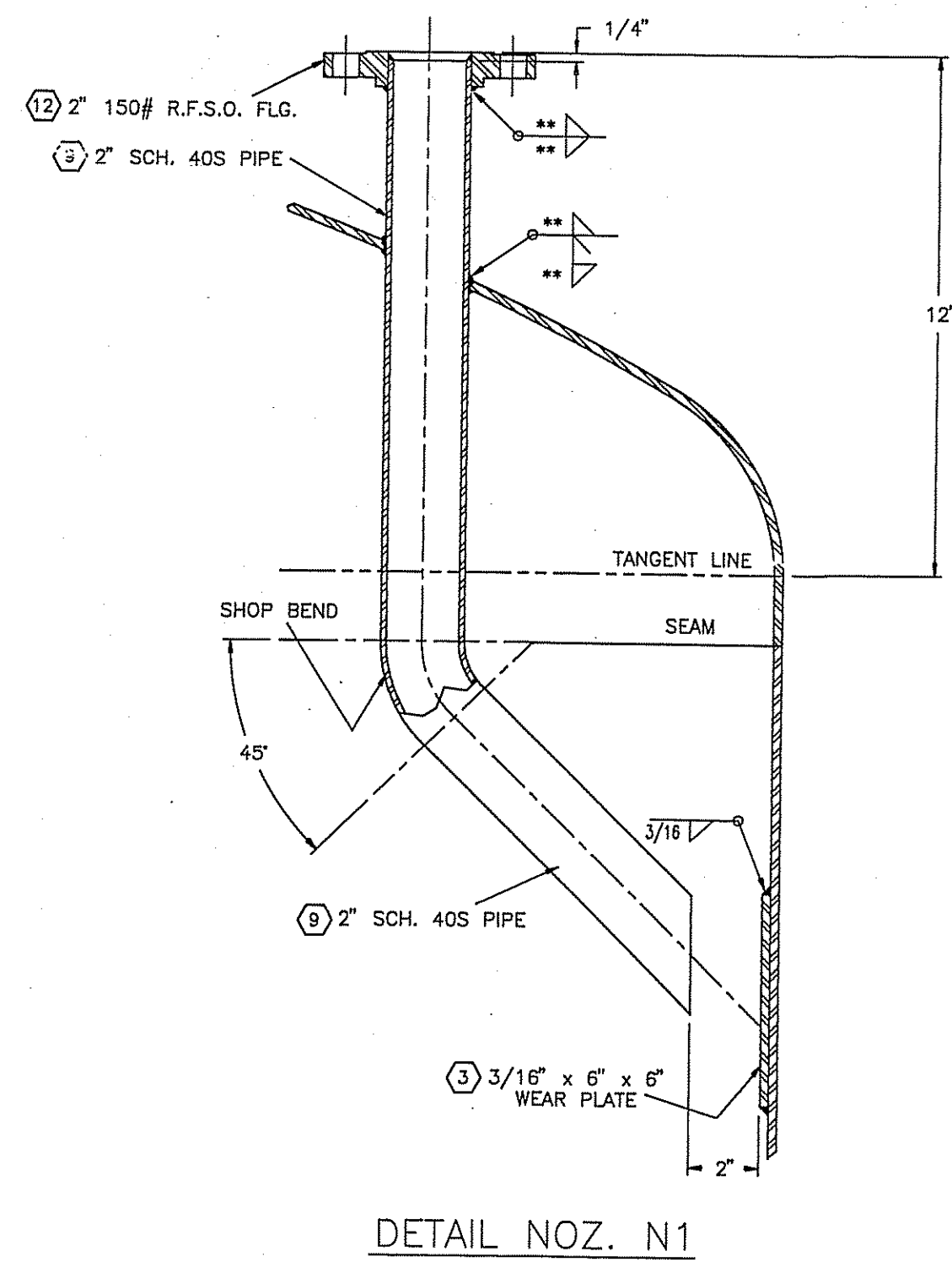
SOFIX CORPORATION

DWG. TITLE

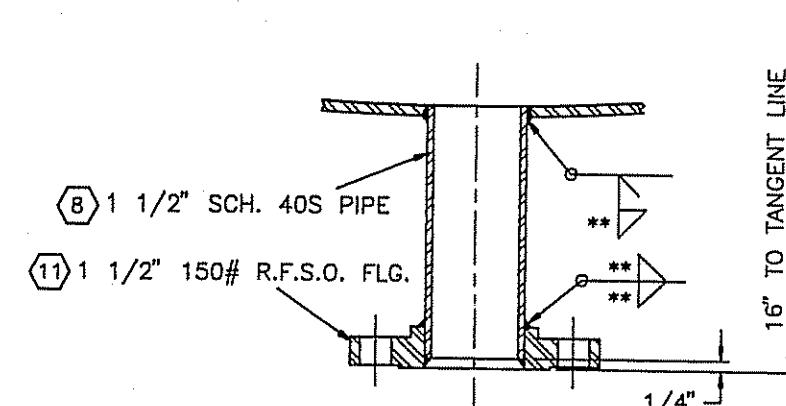
RECEIVER

DATE	SCALE	DRAWING NO. 1 of 2	ISSUE
4-23-91	NONE	1-152-A	1

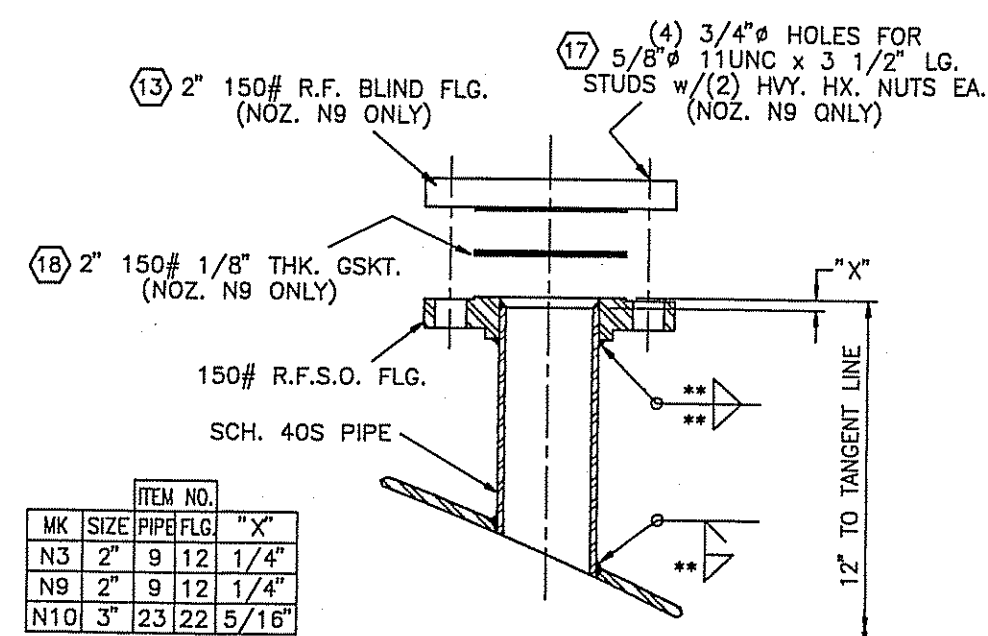
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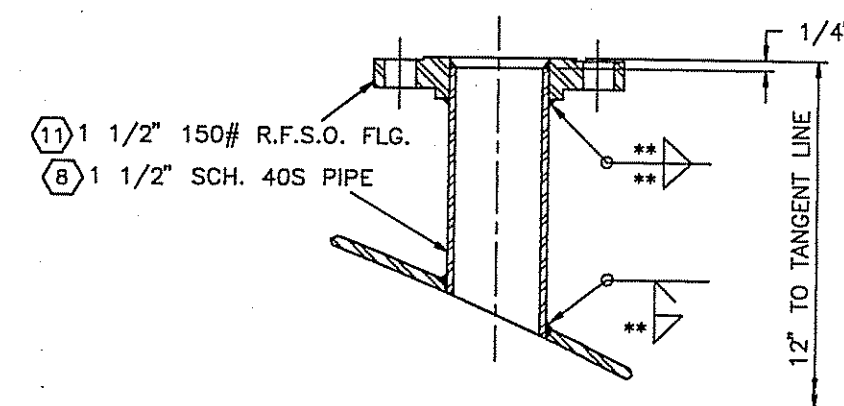
DETAIL NOZ. N1



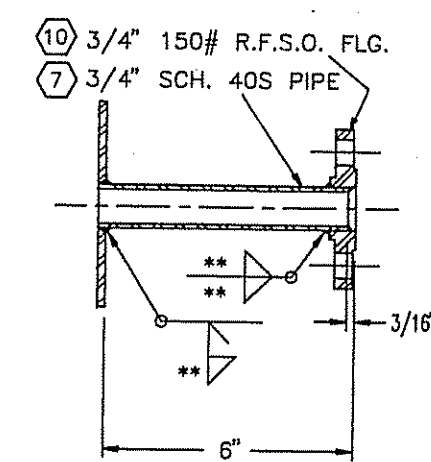
DETAIL NOZ. N2
SEE VORTEX BREAKER DETAIL



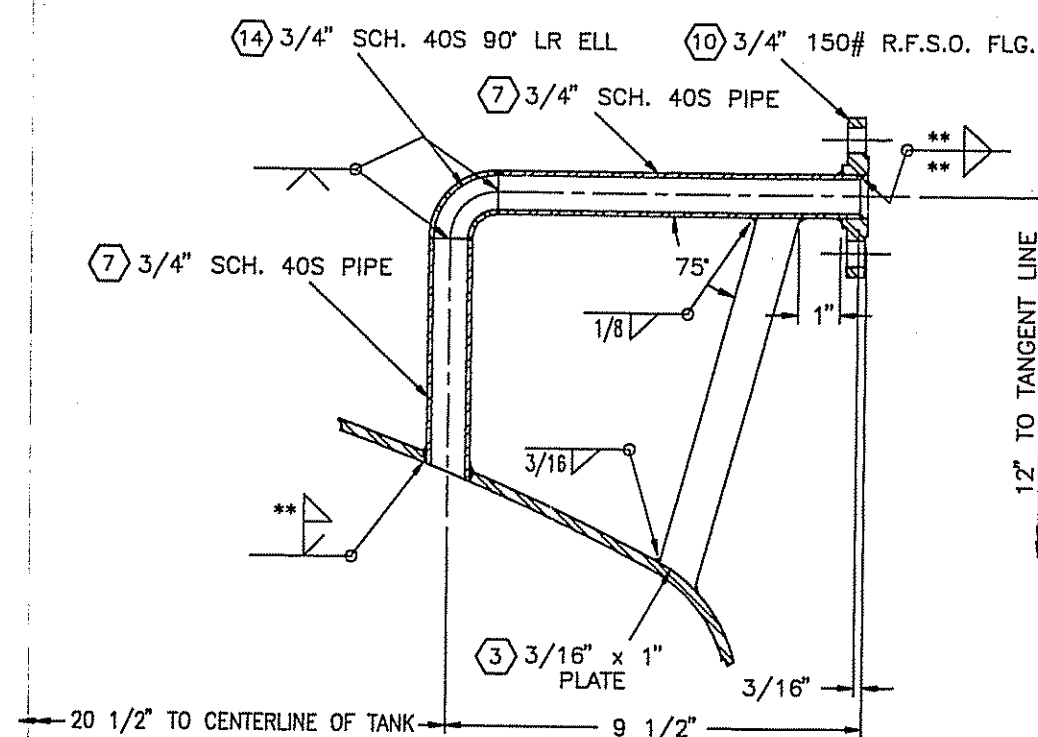
DETAIL NOZ. N3, N9, & N10



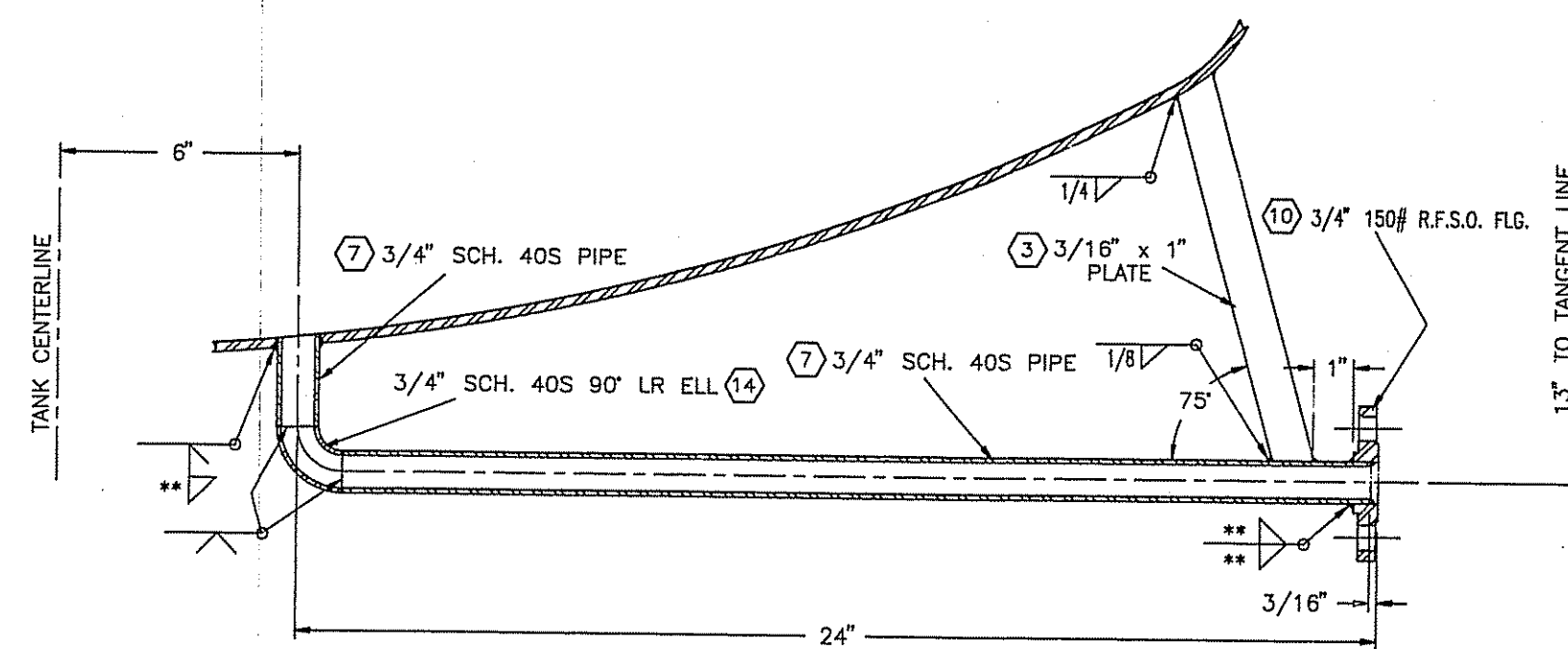
DETAIL NOZ. N4, & N5



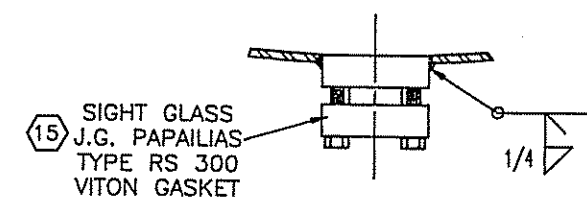
DETAIL NOZ. N6



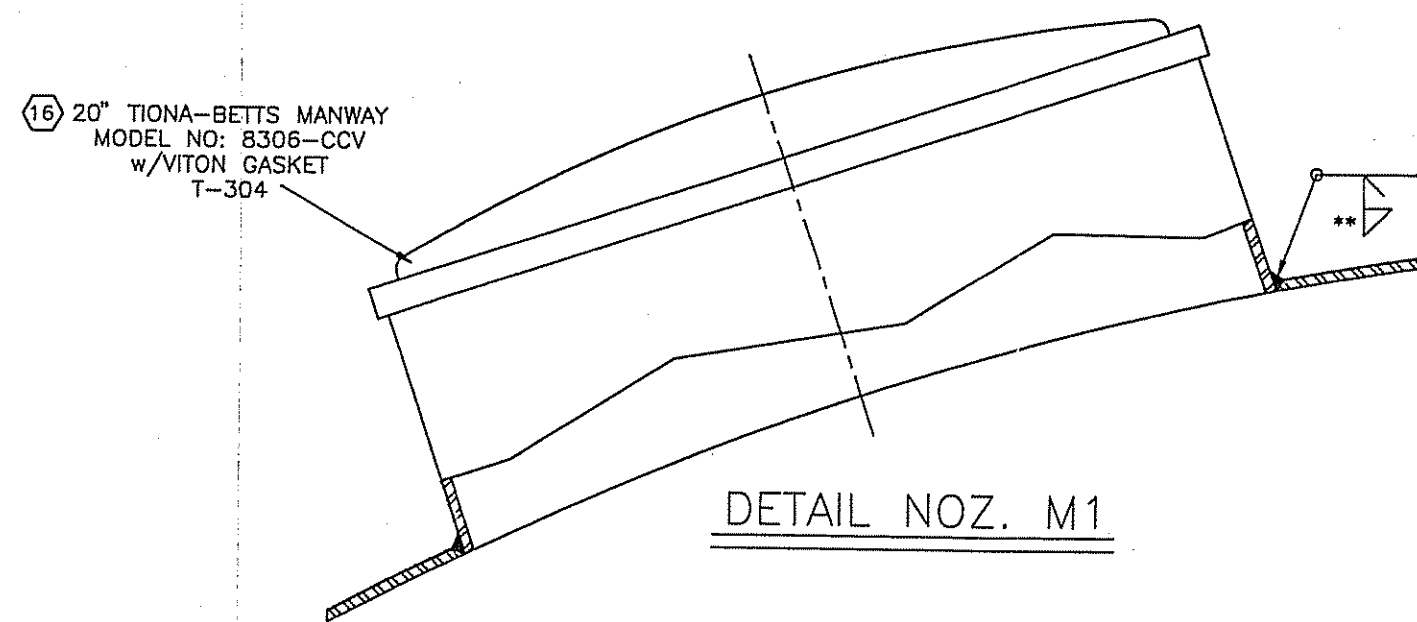
DETAIL NOZ. 7a



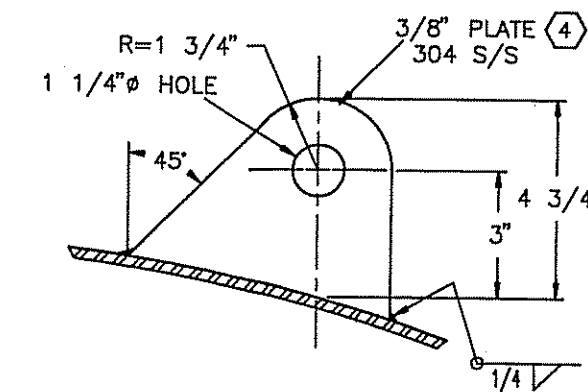
DETAIL NOZ. 7b



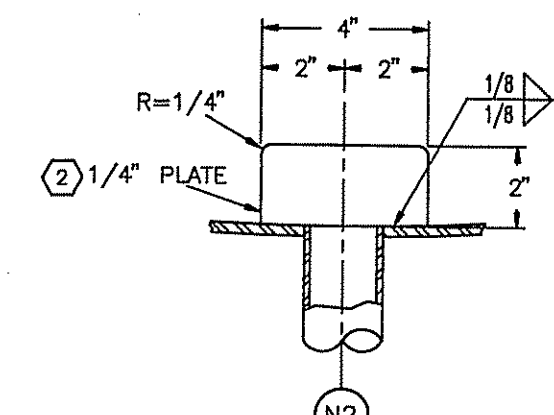
DETAIL NOZ. N8
(2) REQUIRED



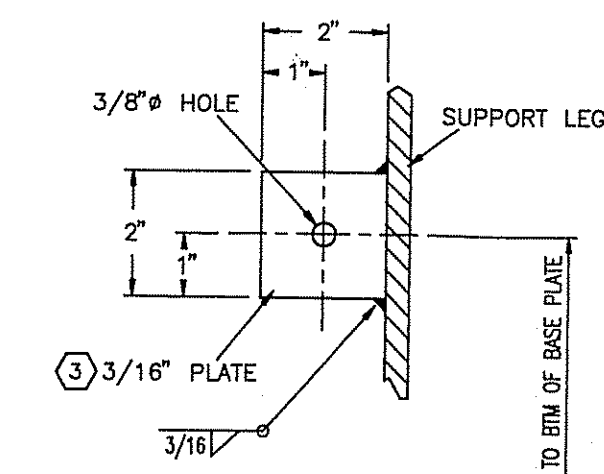
DETAIL NOZ. M1



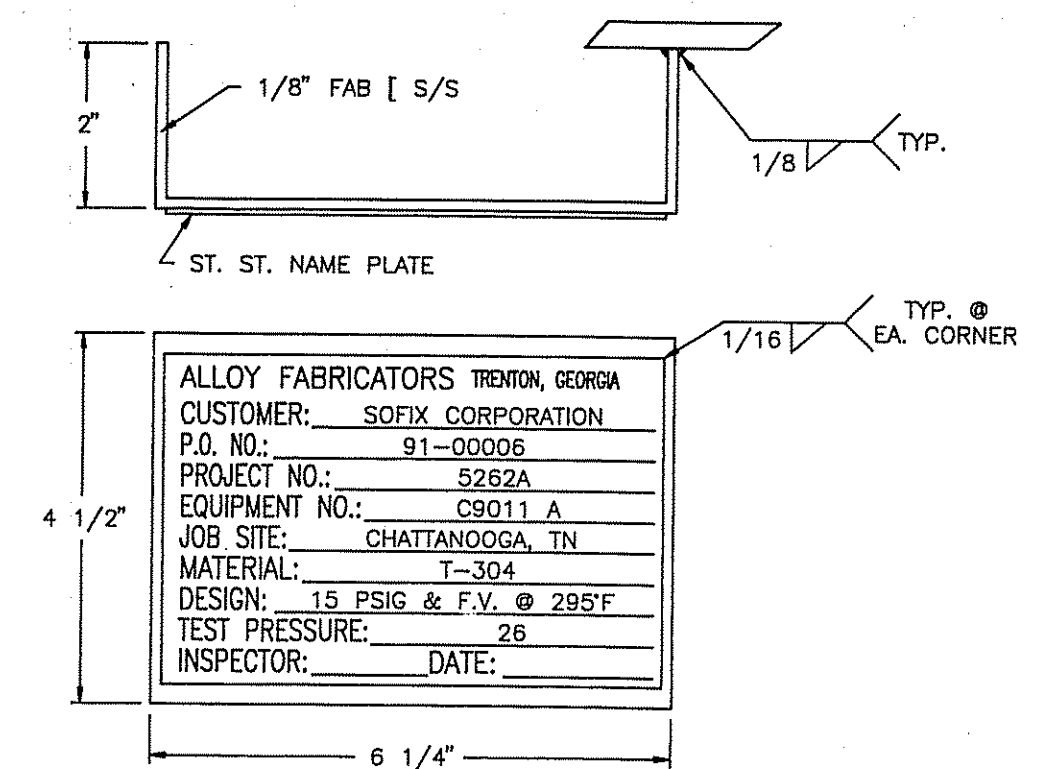
LIFTING LUG DETAIL
(3) REQ'D @ 120' APART



VORTEX BREAKER DETAIL



GROUNDING LUG DETAIL
(1) REQUIRED



NAME PLATE DETAIL

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

CERTIFIED
RELEASED FOR FABRICATION
Don Elliott DATE 6-19-91
PROJECT ENGINEER

REV.	DATE	DESCRIPTION	CUST. DATA	DRAWING STATUS
1	4-23-91	SCALE NONE	DATE 4-23-91	DATE 4-23-91
2	6-19-91	SCALE NONE	DATE 6-19-91	DATE 6-19-91
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RECEIVED
JUN 25 1991

U. I. WILLIAMS

114414