



* LAP JOINT CONNECTIONS SHALL BE MADE WITH 316L STN STL STUB ENDS WITH SA-105 C.S. (YELLOW ZINC CHROMATE COATED) LAP-JOINT FLANGES

NOTES: 1.) EXTERIOR CARBON STEEL SURFACES TO BE PAINTED WITH (2) COATS OF FLAME CONTROL NO.850 SERIES PFAUDLER BLUE @ 1 TO 1.5 MILS DFT, APPLIED OVER A COMMERCIALY BLASTED SURFACE PER SSPC-SP6. COMMERCIAL PARTS TO BE PAINTED WITH SAME PAINT ALSO.

EXTERIOR STAINLESS STEEL SURFACES TO BE GLASS BEAD BLASTED AFTER ALL WELDING IS COMPLETE.

- 2.) ALL MACHINED SURFACES MUST BE PROTECTED WHILE BEING MOVED THROUGH THE SHOP.
- 3.) RUNOUT TEST: MOUNT DRIVE & ROTOR ASSEMBLY ON TEST STAND & CHECK RUNOUT OF ROTOR RUNNING AT TOP SPEED. MAX. RUNOUT NOT TO EXCEED 1/4" F.I.R.. MATCH MARK DISTRIBUTOR & SEPARATOR SECTION(S).
- 4.) VACUUM TEST PER QC MANUAL SECT. E-3.
- 5.) FLANGE CONNECTIONS TO STRADDLE CENTERLINES.
- 6.) PRESSURE RELIEF DEVICE(S) PER PAR. UG-125 OF ASME CODE, SECT. VIII DIV 1. MUST BE PROVIDED AND INSTALLED BY CUSTOMER.
- 7.) SIDE SUPPORTS DESIGNED FOR SEISMIC ZONE 4 (UBC).
- 8.) IN ORDER TO AVOID INJURY AND ASSURE THE SAFE OPERATION OF ALL PFAUDLER VESSELS, NO VESSEL SHOULD BE OPERATED WITHOUT ALL OPENINGS AND PASSAGEWAYS SECURELY CLOSED. IN CASES WHERE THE TOP HEAD OF THE VESSEL HAS BEEN REMOVED, THE OPENING SHOULD BE SECURED BY A SUITABLE COVER WHILE THE VESSEL IS IN OPERATION. ALL PERSONS OPERATING A PFAUDLER VESSEL SHOULD HAVE PRIOR INSTRUCTION IN THE PROPER USE OF THE VESSEL DURING OPERATION.
- 9.) BEFORE LIFTING DRIVE AND ROTOR ASSEMBLY, REMOVE DUST CAP FROM TOP OF DRIVE AND ALIGN MATCH MARKS TO PREVENT WIPERS FROM FALLING INTO VAPOR OUTLET. (SEE DETAIL)
- 10.) COVER FOR NOZZLE "B" TO BE WELDED AT ASSEMBLY. AFTER TESTING IS COMPLETE, NOZZLE IS TO BE TRIMMED TO PROJECTION SHOWN. NO WELD PREP IS REQUIRED.
- 11.) CRN#: (jacket chamber only) later
- 12.) INNER VESSEL DESIGNED TO ASME CODE, BUT NOT STAMPED.
- 13.) SHIP LOOSE: - GEAR LUBE
- WIPER BLADES
- FORCED CIRCULATED LUBRICATOR
- 14.) REMOVE INSULATION RING SEGMENTS TO CLEAR TRUNNIONS FOR LIFTING. REPLACE AT INSTALLATION

BASE MATERIAL			
VESSEL SHELL	1/8"CLAD PLATE,SA264-316L ON 3/4" SA-516 GR 70 BACKING		
TOP HEAD	SA-240-316L		
BOTTOM HEAD	SA-240-316L		
JACKET SHELL	SA-516 GR70		
INTERNAL CONDENSER TUBES	----		
CONDENSER CHANNEL	----		
CONDENSER TUBESHEET	----		
THICKNESS			
	VESSEL	JACKET	INTERNAL CHAMBER
COVER - TOP	.75"F&D	----	----
HEAD - BOTTOM	.75"F&D	----	----
SHELL	3/4"	1/2"	----
LOWER SHELL	----	----	----
JACKET SEALER	----	1.25"	----
TUBES	----	----	----
TUBESHEET	----	----	----
DESIGN & INSPECTION			
SPECIFICATION	VESSEL	JACKET	INTERNAL CHAMBER
ASME CODE DESIGN & STAMP	(NOTE.12)	YES	----
DESIGN PRESS. PSI.	15/FV	110/FV/110*	----
DESIGN TEMP. °F.	650	650	----
MIN. DESIGN METAL TEMP. °F	-20	-20	----
HYDROTEST PRESS. PSI	21	153	----
RADIOGRAPH	N/A	N/A	----
CORROSION ALLOWANCE	N/A	N/A	----
HEAT TRANSFER AREA	N/A	231SQ.FT.	----
* WITH FULL VACUUM IN VESSEL			
SEE OPERATING LIMITATIONS, INSTALLATION & MAINTENANCE INSTRUCTIONS #IM 39-101			
TEMPERATURE LIMITATIONS: KALREZ "O" RINGS: 600°F			
MECHANICAL SEAL FOR SHAFT ENCLOSURE: 600°F			
CUSTOMER: OCEAN NUTRITION			
ADDRESS: MULGRAVE, NOVA SCOTIA			
CONSIGNEE: OCEAN NUTRITION			
ADDRESS: MULGRAVE, NOVA SCOTIA			
CUST. ORDER NO.: ----			
CUST. TAG NO.: ----			

