

CHAMBER WEIGHTS	
EMPTY.....	XX,000 LBS.
OPERATING....	XX,000 LBS.
EMERGENCY....	XXX,000 LBS.

NOZZLES, PORTS
OUTLETS AND MANWAYS

ITEM	SIZE	DESCRIPTION
A	ø400mm	AIR/PRODUCT OUTLET
B	582x437 mm	AIR INLET
C	ø169mm	PRODUCT INLET
D	ø500mm	UPPER MANHOLE
E	ø108mm	LIGHT PORT
F1	450x351 mm	LOWER MANHOLE
F2	450x351 mm	LOWER MANHOLE
G	ø140mm	SIGHT PORT - 140/H
H	1/2" NPTF	PRESS. TRANSMITTER

PLACE NOZZLE "H" FOR
PRESSURE DIFF. XTRM
(PDT-5116) BY OTHERS
AT AN ACCESSIBLE LOCATION

PLEASE VERIFY
DIMENSION &
PLACE AS SHOWN

PARTICULARS S.I.P. INC.			
PROJECT NO.	52865-01	P.O. CONTRACT NO.	0021
DATE	05 MAR 1968	ISS NO.	D-1503
INCIDENT TYPE: <u>RECEIVED</u> (RECEIVED FOR FABRICATION) PART NOT COMPLETED INCLUDING BIDDING OR ANY OBLIGATION OR PERFORMANCE WITH RESPECT TO THIS CONTRACT OR TO BE OBTAINED BY RELATED PURCHASE AGREEMENTS. ☒ NOT RELEASED FOR FABRICATION-CORRECT & RESUBMIT W/ FINAL-COINT. REPORT ☒ W/ FINAL INSPECTION-COINT. REPORT ☒ WIN NOT RELEASED FOR FABRICATION-CORRECT & RESUBMIT W/ FINAL INSPECTION ☒ W/ FINAL INSPECTION ☒ W/ INSPECTION FOR FABRICATION-RESUBMIT & QUALITY DEPENDABLE ☐ W/ VMD			
☐ INFORMATION ☐ CORRECTION & RESUBMIT WITHIN 2 WEEKS ☒ CORRECTION & RESUBMIT			
<i>A. Bohrdt</i> REVIEWED BY		<i>7/26/68</i> DATE	

SHIPPING NOTES:

1. DRYER CHAMBER SHALL BE SHIP ASSEMBLED, MATCHED-MARKED AND BROKEN DOWN FOR SHIPMENT IN THREE PIECES. (1) TOP SECTION, (2) MIDDLE SECTION AND (3) AIR HOUSE.
2. BOTTOM BRACKET, SPIND MOTOR, ROTOR WING ASSEMBLY AND GEAR ASSEMBLY WILL ALSO BE SHIPPED DISASSEMBLED.

GENERAL NOTES:

1. WELDING SHALL BE IN ACCORDANCE WITH THE LATEST A.W.S. CODE.
2. WELDING OF STAINLESS STEEL TO STAINLESS STEEL SHALL BE THE TUNGSTEN INERT GAS SHIELDED ARC WELDING METHOD. AUTOMATIC TUNGSTEN INERT GAS SHIELDED ARC WELDING SHALL BE EMPLOYED WHERE EVER APPLICABLE. ALL WELDS SHALL BE FLANISHED. ALL WELDS MUST HAVE 100% PENETRATION LEAVING NO CRACKS OR CREVICES.
3. WELDING OF CARBON STEEL TO CARBON STEEL SHALL BE METALLIC INERT GAS ARC WELDING METHOD OR COATED ELECTRODE ARC WELDING METHOD WITH PREFERENCE IN THAT ORDER.
4. WELDING RODS SHALL BE SIMILAR IN COMPOSITION TO THE STAINLESS STEEL BEING WELDED. WHEN WELDING CARBON STEEL TO STAINLESS STEEL, STAINLESS STEEL WELDING RODS SHALL BE USED.
5. ALL PROCESS GAS WETTED WELDS SHALL BE LIQUID PENETRANT EXAMINED.
6. FINISHES:
7. MILD STEEL SURFACES: ALL WELDS TO BE GROUND SMOOTH. PAINT IN ACCORDANCE WITH NOTE: 3.
8. STAINLESS STEEL SURFACES: INTERNAL WELDS SHALL BE GROUND SMOOTH TO SGRIT FINISH. EXTERNAL WELDS BEAD BLAST.
9. STEEL FINISH- 2B ON PRODUCT CONTACT SURFACES.
10. PAINTING:
11. ALL CARBON STEEL INTERNAL AND EXTERNAL SHALL BE CLEANED AND PRIMERED PER NIRO GROUP 2. STANDARDS SHEET 1.11.
12. PRECAUTIONS:
13. CARE SHOULD BE TAKEN THROUGHOUT THE FABRICATION AND ERECTION TO PROTECT THE ORIGINAL MILL FINISH AND TO AVOID SCRATCHES, DENTS, HAMMER MARKS AND OTHER BLEMISHES.
14. ALL BOLTS SHALL BE U.S. SUPPLIED AND SHALL BE STAINLESS STEEL. APPLY ANTIGALLING COMPOUND TO THREADS, EXCEPT INTERNAL PARTS.
15. 316 STAINLESS STEEL MAY BE SUBSTITUTED FOR 304 STAINLESS STEEL EXCEPT WHERE MATERIAL HAS BEEN CALLED OUT ON THIS DRAWING WITH PRIOR APPROVAL FROM NIRO COLUMBIA.

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SWIRL FLUIDIZER SWF 125
OUTLINE AND ASSEMBLY

ISK MAGNETICS

CONTRACT	CAT.	DRAWING	REV.
030-4929		4929-3470-001	A

[illegible]