

**FORM U-3 MANUFACTURERS' CERTIFICATE OF COMPLIANCE COVERING
PRESSURE VESSELS TO BE STAMPED WITH THE UM SYMBOL**
[See Par. U-1(h)]

91686
4

1. Manufactured by WALKER STAINLESS EQUIPMENT CO., NEW LISBON, WISCONSIN
(Name and address of Manufacturer)
2. Manufactured for POLAROID CORP. WALTHAM, MASSACHUSETTS
(Name and address of Purchaser)
3. Type VERTICAL Pressure Vessel No. WIS ASME 294 Year built 1971
(Horizontal or Vertical) (Mfrs. Serial No.) (State and State No.)
4. Do the chemical and mechanical properties of all materials meet the requirements of the Code? YES
5. Shell or Drums: No. 1 Diameter 5 Ft. 0 In. Length over-all 15 Ft. 7 In. Height 5 Ft. 0 In.
(Or Width)
6. Markings on shell plates SA-240 75,000 Rivets, stays, and braces T-304 S.S.
(Fig. or F.B. & Spec. Min. T.S.) (Iron or Steel)
7. Shell Plates .062 In. Butt straps - - In. Styles of seams: Longitudinal WELDED Girth WELDED
(Outer) (Thickness) (thickness) (Riveted, Forge Welded, Brazed, or Welded—Type of Joint)
8. CHANNEL 1-13/16" WX 5/16" HX 2"
~~Diameter of rivet holes~~ In. Pitch of rivets - × - × - Efficiency of joint 55 %
9. Girth Joints - - Diameter of rivet holes - In. Pitch of rivets - In. No. of courses - -
(Single or Double Riveted)
10. Inner Shell .135 In. Style of seams; Longitudinal WELDED Girth WELDED Length of section of course 15 Ft. 7 In.
(Thickness) (Riveted, Forge Welded, Brazed, or Welded—Type of Joint)
11. Heads: Flat or dished .135 In. Radius of dish 76 In. Side to pressure - - -
(Thickness) (Concave or Convex)
- If removable, bolts used - - - or method of fastening - - -
(Number and Size) (Describe or Sketch)
12. Staybolts - - If hollow - - 13. Maximum pitch - × - Diameter - - - In.
(Iron or Steel) (Size of Hole) (Horizontal) (Vertical) (Over the Threads)
14. Safety Valve Outlets: No. 1 Size CUSTOMER TO SUPPLY & INSTALL
15. Have the welders and the welding procedure been qualified in accordance with Code requirements? YES
16. JACKET
~~Drain~~ Connection 4 In. ~~Hand Holes or Sight Holes~~ 1/2, 1 1/2 3000# COUPLINGS
(Size) (Number, Size, and Location)
17. Constructed for maximum allowable working pressure 150 psi at 325 °F.

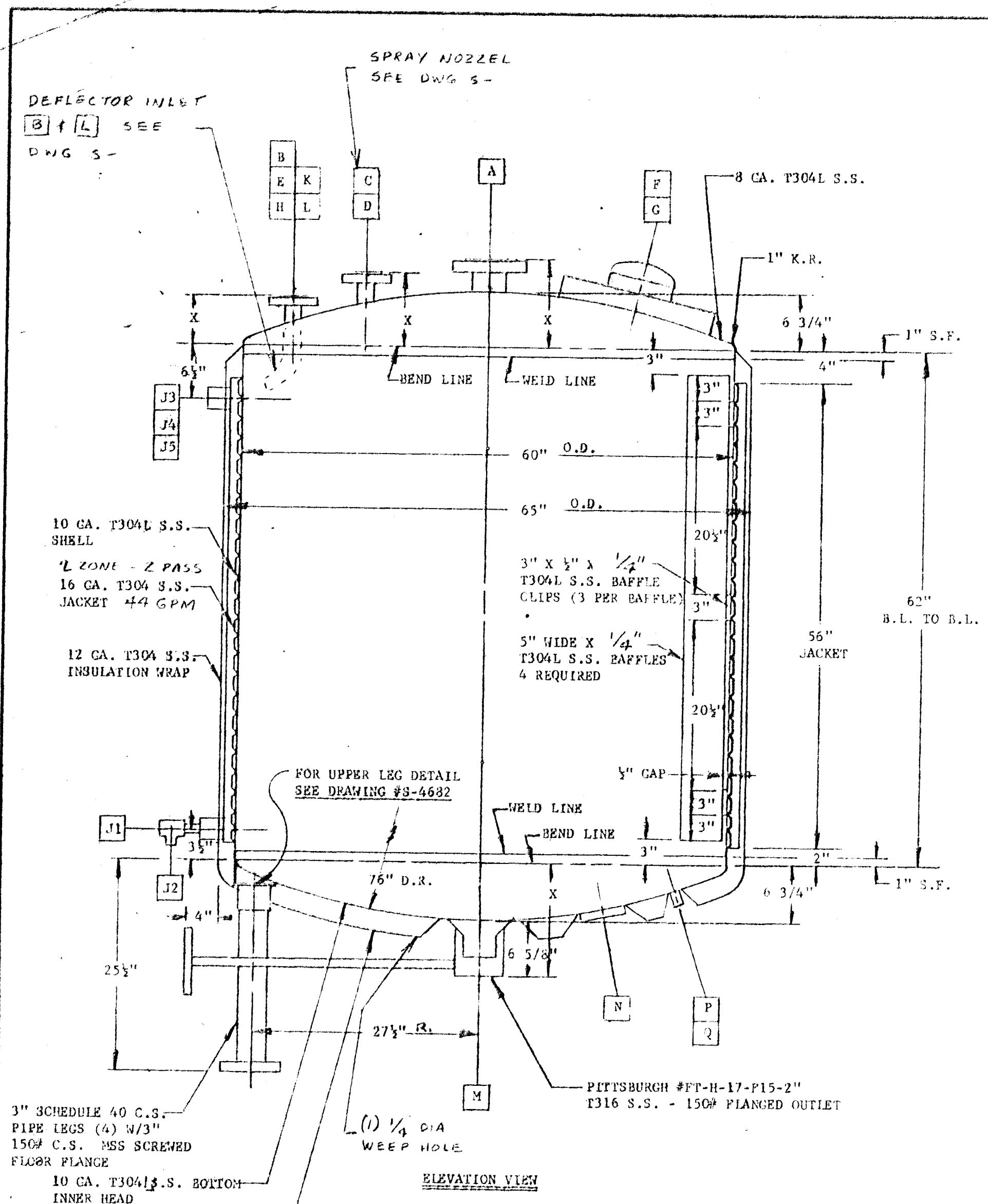
Hydrostatic test 275 psi. at ambient temperature

Remarks: PRINT #SP-4680-1. APPROXIMATELY 73 SQ. FT. OF CHANNEL HEAT JACKET
(Vessel to be used for air, gas, ammonia, etc.)

WELDED TO OUTER SURFACE OF SHELL. 750 GALLON NO. D-1231 (NB-A)

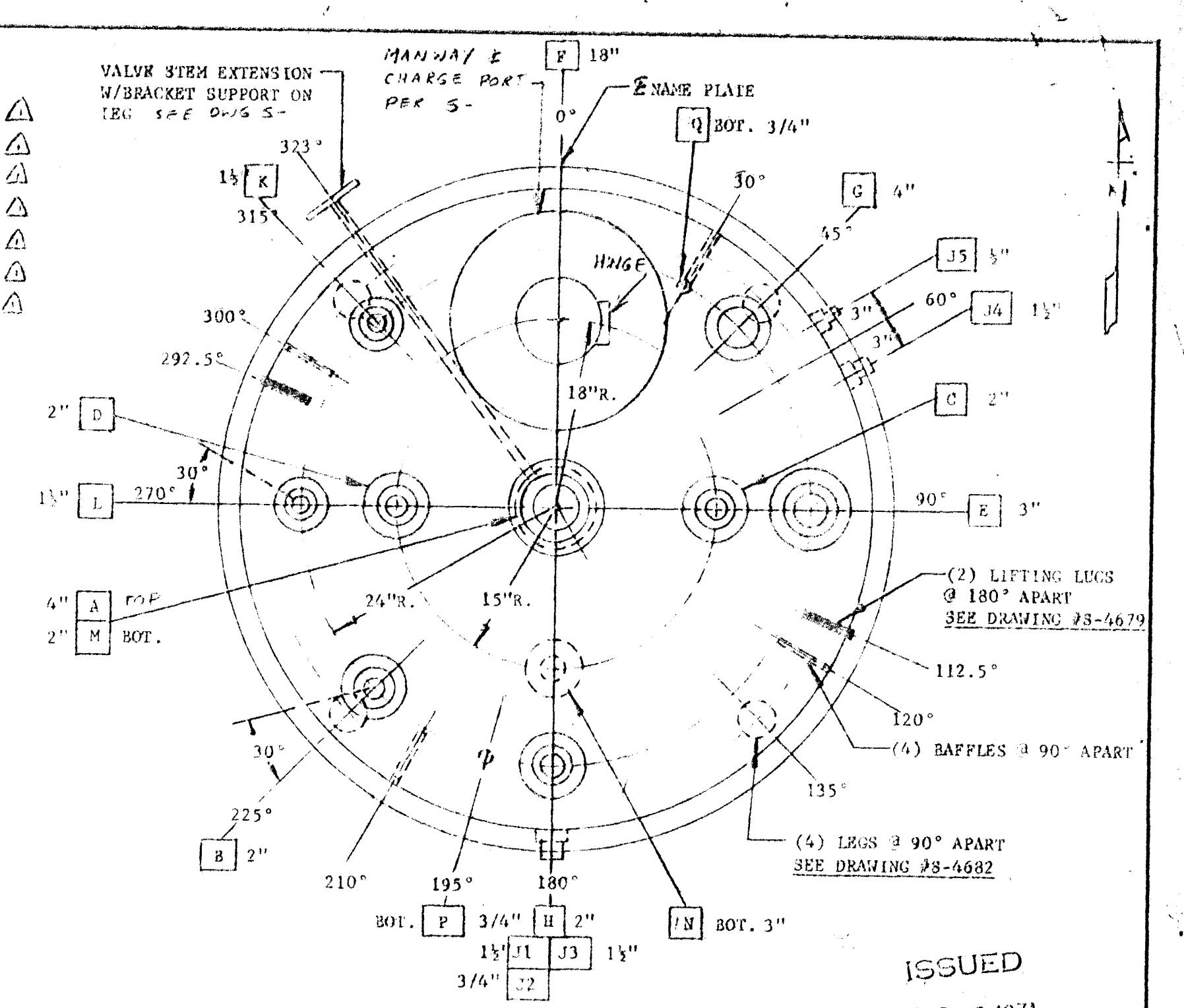
We certify the above data to be correct and except for the omission of shop inspection that all details of material and construction and workmanship of this unfired pressure vessel conform to the ASME Pressure Vessel Code, Section VIII, Division I.

Date DEC 16 19 71 Signed WALKER STAINLESS EQUIP. by Bob Deery
(Manufacturer)



JACKET NOZZLE DATA					
MARK NO.	NO. REQ'D	SIZE	RATING	BORE	SERVICE
J1	1	1 1/2"	3000# HALF COUPLING	SCREWED	INLET
J2	1	3/4"	3000# FULL COUPLING	SCREWED	DRAIN
J3	1	1 1/2"	3000# FULL COUPLING	SCREWED	OUTLET
J4	1	1 1/2"	3000# FULL COUPLING	SCREWED	R.V. CONN.
J5	1	1/2"	3000# FULL COUPLING	SCREWED	VENT

NOZZLE	"X" DIMENSION
A	10 3/4"
B	7 1/2"
C	9 1/2"
D	9 1/2"
E	7 1/2"
H	7 1/2"
K	7 1/2"
L	7 1/2"
M	13 3/8"



CERTIFIED FOR FABRICATION

NOTE TABLE		
	VESSEL	JACKET
OPERATING PRESSURE:	ATMOSPHERIC	80 PSIG
OPERATING TEMPERATURE:	180°F.	180°F.
DESIGN PRESSURE:	15 PSIG	150 PSIG
DESIGN TEMPERATURE:	325°F.	325°F.
MAXIMUM ALLOWABLE WORKING PRESSURE:	15 PSIG @ 325°F.	150 PSIG @ 325°F.
HYDROSTATIC TEST PRESSURE:	25 PSIG	225 PSIG @ AMBIENT TEMPERATURE
STAMPING:	ASME SECTION VIII (JACKET ONLY) (UM)	
HEADS:	SHALLOW FLANGED & DISHED	
EMPTY WT.:	2100# APPROX. - PLUS AGITATOR	
WT. FULL OF WATER:	8,325# APPROX. - PLUS AGITATOR	
NOZZLES:	SEE NOZZLE DATA TABLE	
SPARE NOZZLES:	CAPPED W/PROPER PLUGS, FLANGES & BOLTS	
ALL OTHER OPENINGS:	BLANKED W/PLYWOOD COVERS	
CLEANING:	REMOVE CARBURIZATION & PASSIVATE INTERIOR & EXTERIOR	
FINISH:	INSIDE: #2B W/WEIDS GROUND FLUSH OUTSIDE: #2B W/WEIDS BUFFED CLEAN PLATE: #4 POLISH THROUGHOUT	
PAINT:	CARBON STEEL (LEGS & FLOGS) W/ EPOXY	

MATERIAL					
VESSEL, SHELL, HEADS, NOZZLES; Baffles & Clips; T304 LSS					
INSULATION WRAP 304 S.S.					
LAP JOINT FLANGES: C.S. EPOXY COATED					
GASKETS: ASBESTOS (GRAPHITE FILL) & NOZZLE "P" PACK NEOPRENE					
SUPPORT LEGS: REINFORCING PLATE T304 S.S. W/C.S. PIPE & SCREWED FLANGE					
BOLTING: NICKLE PLATED C.S. ASTM A197 & HEX NUTS ASTM A194					
INSULATION: 2" FIBERGLASS (SIDES & BOTTOM)					

VESSEL NOZZLE DATA						
MARK NO.	NO. REQ'D	SIZE	RATING	BORE	SERVICE	MATERIAL
A	1	4"	150# ASA L.J. FLANGE	SCH. 40	AGITATOR APPROX. WT. 350#	T304L S.S.
B	1	2"	150# ASA L.J. FLANGE	SCH. 40	FIXED DEFLECTOR INLET	T304L S.S.
C	1	2"	150# ASA L.J. FLANGE	SCH. 10	SPRAY	T304L S.S.
D	1	2"	150# ASA L.J. FLANGE	SCH. 10	SPRAY	T304L S.S.
E	1	3"	150# ASA L.J. FLANGE	SCH. 10	VENT	T304L S.S.
P	1	18"	15 PSIG	---	MANWAY W/8" QUICK OPENING CHARGE PORT	T304L S.S.
C	1	4"	SPECIAL WELDING PAD	---	LIGHT GLASS W/300 WATT X-PROOF LITE	T304L S.S.
H	1	2"	150# ASA L.J. FLANGE	SCH. 10	SPARE	T304L S.S.
K	1	1 1/2"	150# ASA L.J. FLANGE	SCH. 10	SPARE	T304L S.S.
L	1	1 1/2"	150# ASA L.J. FLANGE	SCH. 40	SPARE W/FIXED DEFLECTOR INLET	T304L S.S.
M	1	2"	SPECIAL WELDING PAD	---	OUTLET (FLUSH BOT BALL VALVE)	T316 S.S.
N	1	3"	SUM. TO LEGS STODDING	---	L.L. CONN.	T304L S.S.
P	1	3/4"	3000# HALF COUPLING	SCREWED	IN CONN. 3" PROJ. WELL BY POLAROID	T304L S.S.
Q	1	3/4"	3000# MOD. COUPLING	SCREWED	SAMPLE CONN.	T304L S.S.

WALKER D-1231
STAINLESS EQUIPMENT CO.
 NEW URBON, WISCONSIN
 SCALE: 1" = 1'-0" APPROVED: 91668
 DATE: 8/4/71 DRAWN BY: B.A.R.
 750 GALLON VESSEL - TANK NO. D-1231 (SEE A)
 POLAROID CORP., WALTHAM, MASSACHUSETTS DRAWING NUMBER: SP-4680-1
 NOTE - DO NOT SCALE THIS DRAWING!