

FORM U-1A MANUFACTURER'S DATA REPORT FOR PRESSURE VESSELS (Alternative Form for Single Chamber, Completely Shop-Fabricated Vessels Only) As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

Eq. No. 22-C-18

NON DISCRETIONARY UNTIL SUPERSEDED

1. Manufactured and certified by Precision Stainless, Inc., 501 N. Belcrest, Springfield, MO 65802
2. Manufactured for Procter & Gamble, Cincinnati, OH
3. Location of installation The Folger Coffee Company, 400 West F. M. 1417, Sherman, TX 75090
4. Type Vertical 8885-1 thru 8885-6 43899-0 2429 thru 2434 1989

5. The chemical and physical properties of all parts meet the requirements of material specifications of the ASME BOILER AND PRESSURE VESSEL CODE. The design, construction, and workmanship conform to ASME Rules, Section VIII, Division 1, 1986 Edition
to Addendum A-87

6. Shell: SA240 304L .25 0 2'-11-1/2" 38'-7-15/16"
7. Seams: Welded Single Butt Spot 85 Welded Double Butt Spot 4
9. Heads: (a) Matl. SA240 304L (b) Matl. SA240 304L

Table with 10 columns: Location (Top/Bottom), Minimum Thickness, Corrosion Allowance, Crown Radius, Knuckle Radius, Elliptical Ratio, Conical Apex Angle, Hemispherical Radius, Flange Diameter, Side to Pressure (Concave).

10. M.A.W.P. 150 psi at max. temp. 400
Min. design metal temp. -20 of at 150 psi Hydro. test pressure 241

Table for Nozzles, Inspection and safety valve openings with columns: Purpose, No., Diam. of Size, Type, Matl., Nom. Thk., Reinforcement Matl., How Attached, Location.

11. Supports: Skirt No Lugs 4 Lugs Other Attached Shell Weld

12. Remarks: Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report: Customer to install gate valve between transition and both head and supply bolts. Transition shell 250 mm thickness, 3 K. R., SA240 304L. Name plate per Code Case 2051. Support rings 3/8 plate, SA240 304. Customer to install safety valves. Vessel hydro-statically tested in horizontal position at 241 psi See II.4.

CERTIFICATE OF SHOP COMPLIANCE
We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME Code for Pressure Vessels, Section VIII, Division 1. "U" Certificate of Authorization No. 11658 expires April 6, 1992. Date 6-8-89 Go, name Precision Stainless, Inc. Signed Douglas W. Morgan

CERTIFICATE OF SHOP INSPECTION
Vessel constructed by Precision Stainless, Inc. at Springfield, MO
I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of Missouri and employed by Commercial Union Insurance Co.
have inspected the component described in this Manufacturer's Data Report on April 14, 1989, and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME Code, Section VIII, Division 1. By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.
Date 6-8-89 Signed Otis P. Cooper Commission NB 8293 2445

FORM U-4 MANUFACTURER'S DATA REPORT SUPPLEMENTARY SHEET
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

- 1. Manufactured and certified by Precision Stainless, Inc., 501 N. Belcrest, Springfield, MO 65802
(Name and address of manufacturer)
- 2. Manufactured for Procter & Gamble, Cincinnati, OH
(Name and address of purchaser)
- 3. Location of installation The Folger Coffee Company, 400 West F. M., 1417, Sherman, TX 75090
(Name and address)
- 4. Type Vertical 8985-1 thru 8985-6 -- 43899-D 2429 thru 2434 1989
(Specs, mat., work, etc.) (Order's serial No.) (CRN) (Dist.) (MFG. No., Mat.) (Year built)

Data Report Item Number	Purpose	No.	Dia. or Size	Type	Mat.	Remarks	Nom. Thk.	Relf. Mat.	How Attached	Location
Item #10	Agitator	1	12"	Pipe	SA240	304L	.375	--	Weld	
	Spare	3	3"	Pipe	SA312	304L	Sch 40	--	Weld	
	Trans.	2	3"	Pipe	SA312	304L	Sch 40	--	Weld	
	Lev. switch	1	2"	Pipe	SA312	304L	Sch 40	--	Weld	
	Spare	1	2"	Pipe	SA312	304L	Sch 40	--	Weld	
	Spare	2	1"	Pipe	SA312	304L	Sch 40	--	Weld	
	Inlet	1	8"	Pipe	SA240	304L	Sch 40	SA240	1/4" Weld	
	Outlet	1	6"	Pipe	SA240	304L	Sch 40	--	Weld	
	Sightglass	2	4"	End Flange	SA240	304L	150#	--	Weld	

Date 6-8-89 Co. name Precision Stainless, Inc. Signed Douglas W. Morgan
(Date) (Manufacturer) (Manufacturer)

Date 6-8-89 Signed Ottis A. Cooper Commission NB 2293
(Date) (Manufacturer) (State, Title, and No.)

NATIONAL BOARD INSPECTION CODE

Form R-2 (back)

(Form R No.)

DESIGN CERTIFICATION

I, Russell D. Copeland, certify that to the best of my knowledge and belief the statements in this report are correct and that the Design Change described in this report conforms to the National Board Inspection Code.

National Board "R" Certificate of Authorization No. 2957 expires on OCT, 27 20 01
Date 11/5/99, 19 99 Paul Mueller Company Signed Russell D. Copeland
(name of design organization) (authorized representative)

CERTIFICATE OF DESIGN CHANGE REVIEW

I, Frank Hamtak, holding a valid Commission issued by The National Board of Boiler and Pressure Vessel Inspectors and certificate of competency issued by the jurisdiction of Missouri and employed by Commercial Union Ins Co. of Boston Ma have reviewed the design change as described in this report and state that to the best of my knowledge and belief such change complies with the applicable requirements of the National Board Inspection Code.

By signing this certificate, neither the undersigned nor my employer makes any warranty, expressed or implied, concerning the work described in this report. Furthermore, neither the undersigned nor my employer shall be liable in any manner for any personal injury, property damage or loss of any kind arising from or connected with this inspection.
Date 11-5, 19 99 Signed Frank Hamtak Commissions NB# 11474A
(inspector) (National Board (incl. endorsements), and jurisdiction, and no.)

CONSTRUCTION CERTIFICATION

I, Russell D. Copeland, certify that to the best of my knowledge and belief the statements in this report are correct and that all material, construction, and workmanship on this Alteration conforms to the National Board Inspection Code.

National Board "R" Certificate of Authorization No. 2957 expires on OCT, 27 20 01
Date 11/5, 19 99 Paul Mueller Company Signed Russell D. Copeland
(name of Alteration organization) (authorized representative)

CERTIFICATE OF INSPECTION

I, Frank Hamtak, holding a valid Commission issued by The National Board of Boiler and Pressure Vessel Inspectors and certificate of competency issued by the jurisdiction of Missouri and employed by Commercial Union Ins Co of Boston Ma have inspected the work described in this report on 11-5, 19 99 and state that to the best of my knowledge and belief this work complies with the applicable requirements of the National Board Inspection Code.

By signing this certificate, neither the undersigned nor my employer makes any warranty, expressed or implied, concerning the work described in this report. Furthermore, neither the undersigned nor my employer shall be liable in any manner for any personal injury, property damage or loss of any kind arising from or connected with this inspection.
Date 11-5, 19 99 Signed Frank Hamtak Commissions NB# 11474A
(inspector) (National Board (incl. endorsements), and jurisdiction, and no.)

NON DISCRETIONARY
UNTIL SUPER SEDED

2434

WATER TIGHT

SERIAL NO. 2434

CERTIFIED BY

PRECISION
STAINLESS INC.
SPRINGFIELD, MO

MAXIMUM WORKING PRESSURE

150 PSIG AT 200 °F

MIN. DESIGN METAL TEMP.

20 °F AT 150 PSI

MFG'S SERIAL NO. 19285

YEAR BUILT 1989

SHELL THICKNESS .25

HEAD THICKNESS 3/16 .25

HEAD DISH RADIUS 36

W
304L

PAVE
65564
1/2 13820
1/4 2232

EXTRACTION Column.

NO. 10872-6
22-C-18

NON DISCRETIONARY
UNTIL SUPER SEDED

