

NOZ. NO.	SIZE	EXT. LG.
D-26	8"	8-1/4"
E-9	3"	8-1/4"
H1-19	1"	6-1/4"
H2-20	1"	6-1/4"
J1-10	3"	4-1/4"
K-27	6"	8-1/4"
L1-15	2"	6-1/4"
N-11	3"	8-1/4"

(MEASURED FROM INSIDE OF SHELL @ NOZZLE CENTERLINE.)

ITEM NO.	NO. REQ'D.	PART NO. (QTY) DRAWING NO.	DESCRIPTION
1	1	90085-1A	PRECISION STAINLESS ASME DATA PLATE
2	1	500162-3B	NAME PL BRACKET, 12 GA 304 S/S, (SA-240), 2B/2S
3	1		TOP HEAD, 2:1 ELLIP, 3/8" PL, 304L S/S, (SA-240), HRAP/2S, 36" ID, 1-1/2" SF, 10-1/2" FID
4	1		SHELL ASSY, 1/4" PL, 304L S/S, (SA-240), HRAP/2S
5	1		BOTTOM HEAD, TORICONIAL, 1/4" PL, 304L S/S, (SA-240), 36" OD X 18" OD, 3" KR
6	2	43900-D	LIFTING LUG, 3/8" PL, 304 S/S, (SA-240)
A	7	500023-7B	VANSTONE NOZ, 12", 150#-LJ, C/S, (SA-105), W/304L S/S, (SA-40) FAB'D STUB END
G	8		FLANGE, 3", 150#-LJ, C/S, (SA-105), (SPARE)
E	9		FLANGE, 3", 150#-LJ, C/S, (SA-105), (SPARE)
J1	10		FLANGE, 3", 150#-LJ, C/S, (SA-105), (PRESS TRANS.)
N	11		FLANGE, 3", 150#-LJ, C/S, (SA-105), (SPARE)
P	12		FLANGE, 3", 150#-LJ, C/S, (SA-105), (PRESS TRANS.)
13	5		STUB END, 3" SCH 40, TYPE A, MSS, LENGTH, 304L S/S, (SA-40)
14	5		PIPE, 3" SCH 40, 304L S/S, (SA-312), HRAP
L1	15		FLANGE, 2", 150#-LJ, C/S, (SA-105), (LEVEL SWITCH)
S	16		FLANGE, 2", 150#-LJ, C/S, (SA-105), (SPARE)
17	2		STUB END, 2" SCH 40, TYPE A, MSS, LENGTH, 304L S/S, (SA-40)
18	2		PIPE, 2" SCH 40, 304L S/S, (SA-312), HRAP
H1	19		FLANGE, 1", 150#-LJ, C/S, (SA-105), (SPARE)
H2	20		FLANGE, 1", 150#-LJ, C/S, (SA-105), (SPARE)
21	2		STUB END, 1" SCH 40, TYPE A, MSS, LENGTH, 304L S/S, (SA-40)
22	2		PIPE, 1" SCH 40, 304L S/S, (SA-312), HRAP
T	23	1	CUST FURN 1" DRAIN CONN. (PART OF ITEM 24)
B	24	1	CUST FURN 12" VALVE, 'STACY'
25	1	REF	18" KNIFE EDGE GATE VALVE, (CUST FURNISHED & INSTALLED)
D	26	1	500023-5B VANSTONE NOZ, 8", 150#-LJ, C/S, (SA-105), W/304L S/S, (SA-1) FAB'D STUB END
X	27	1	500023-4B VANSTONE NOZ, 6", 150#-LJ, C/S, (SA-105), W/304L S/S, (SA-1) FAB'D STUB END
Q1	28	1	CWP-2 SIGHTGLASS ASSY, 4", 304L S/S PAD, (SA-240), 18" RAD PAD, 'ERNO'
Q3	29	1	CWP-2 SIGHTGLASS ASSY, 4", 304L S/S PAD, (SA-240), 7" RAD PAD, 'ERNO'
30	3		SUPPORT RINGS, 3/8" PL, 304 S/S, (SA-240), 36-1/8" ID X 41/8" OD
31	4	43900-D	REINFORCING PLATE, 1/4", 304 S/S, (SA-240)
32	1	43900-D	SUPPORT PAD, 1/2" C/S PL (SHIP JOSE)
33	8	43900-D	GUSSETS, 1/2" C/S PL (SHIP JOSE)
34	2		FLANGE, 18"-150# ANSI, 304L S/S, (SA-182)
35	1		REINFORCING RING, 1/4" PL, 304 S/S, (SA-240), 8-3/4" ID X 1-1/4" OD
G	36	2	FLANGE, 3"-150# ANSI, BLIND, 304L S/S, (SA-182)
S	37	1	FLANGE, 2"-150# ANSI, BLIND, 304L S/S, (SA-182)
H1, H2	38	2	FLANGE, 1"-150# ANSI, BLIND, 304L S/S, (SA-182)
39	2		GASKET, 1/8" THK, 'GARLOCK BLUE GUARD 3000', 3-1/2" ID X 3/8" OD
40	1		GASKET, 1/8" THK, 'GARLOCK BLUE GUARD 3000', 2-3/8" ID X 1/8" OD
41	2		GASKET, 1/8" THK, 'GARLOCK BLUE GUARD 3000', 1-5/16" ID X 5/8" OD
42	2		GASKET, 1/8" THK, 'GARLOCK BLUE GUARD 3000', 18-3/16" ID
43	8		BOLTS, 5/8"-11NC, HEX HD, (SA-193-87), 4" LG W/HEX NUTS, -194-2H, 18-8 S/S
44	4		BOLTS, 5/8"-11NC, HEX HD, (SA-193-87), 3-1/2" LG W/HEX NUTS, -194-2H, 18-8 S/S
45	12		LOCKWASHERS, 5/8", 18-8 S/S
46	4		BOLTS, 1/2"-13NC, HEX HD, (SA-193-87), 3" LG W/HEX NUTS, -194-2H, 18-8 S/S
47	8		BOLTS, 1/2"-13NC, HEX HD, (SA-193-87), 2-1/2" LG W/HEX NUTS, -194-2H, 18-8 S/S
48	12		LOCKWASHERS, 1/2", 18-8 S/S
49	2		RING, EXTENSION, 1/4" PL, 304L S/S, (SA-240), HRAP, (ROLL TO OD)
50	1	43900-D	CONE SECTION, 1/4" PL, 304L S/S, (SA-240), 18" OD X 12-3/4"
51	1	GL	PAINT, PRIMER, ZINC CHROMATE

- NOTES**
- FLANGE BOLT HOLES TO STRIKE MAJOR VERTICAL AND HORIZONTAL VESSEL CENTERLINE UNLESS INDICATED OTHERWISE.
 - THE CORROSION RESISTANCE OF THE EQUIPMENT IS NOT THE RESPONSIBILITY OF PRECISION STAINLESS, INC. WITH OUT WRITTEN ACCEPTANCE BASED ON A SPECIFIC SERVICE.
 - SUITABLE PRESSURE (AND/OR VACUUM RELIEF VALVE(S)) MUST BE INSTALLED BY CUSTOMER FOR VESSEL AND/OR HEAT TRANSFER SURFACE OPERATION.
 - ALL TOLERANCES ARE IN ACCORDANCE WITH THE LATEST EDITION OF THE 'ASME' BOILER AND PRESSURE VESSEL CODE, SECTION VIII, DIVISION 1, 1989 EDITION, ADDENDUM A-87.
 - PRODUCTION TO PROVIDE PROTECTION FOR ALL NOZZLES AND FITTINGS PRIOR TO SHIPMENT, VESSEL MUST BE ADEQUATELY VENTED.
 - WELD SEAMS IN VESSEL HEAD AND SHELL SHOULD BE LOCATED, WHERE POSSIBLE, TO AVOID ALL NOZZLES, ACCESS OPENINGS, AND REINFORCEMENT PADS.
 - ALL REINFORCEMENT PADS MUST BE PROVIDED WITH (1) ONE 1/8" DIA WEEDHOLE LOCATED AT LOWEST POINT WHEN VESSEL IS IN ITS NORMAL OPERATING POSITION.
 - ALL WELDING TO BE DONE BY ASME CERTIFIED WELDERS.
 - THIS DRAWING SIMILAR TO PROCTER & GAMBLE DWG. NO. 544203-33C-544204-3 DATE 11-7-88
 - TAG VESSEL(S) AS FOLLOWS:
 P-8985-1 = 22-C-13
 P-8985-2 = 22-C-14
 P-8985-3 = 22-C-15
 P-8985-4 = 22-C-16
 P-8985-5 = 22-C-17
 P-8985-6 = 22-C-18
 - PRODUCT SPECIFIC GRAVITY: 1.0
 - BLAST C/S SURFACES PER SSPC-SP11 PART ALL CARBON STEEL SURFACES WITH ONE COAT (3 MILS THK) OF ZINC CHROMATE PRIMER
 - WELDING PROCEDURE IN ACCORDANCE WITH ASME CODE UW-28, SHALL CONFORM TO THE FOLLOWING SPECIFICATIONS:
 A1 = 0805721-01
 W = 0806434-01
 - ALL CUSTOMER SUPPLIED PARTS MUST HAVE PROPER IDENTIFICATION & MILL TEST REPORTS BEFORE BEING WELDED TO VESSEL.
 - VESSEL TO BE HYDROSTATICALLY TESTED FOR (2) HOURS. CHECK FOR DEFECTS, REPAIR & RE-TEST IF NECESSARY.

WELD FINISHES

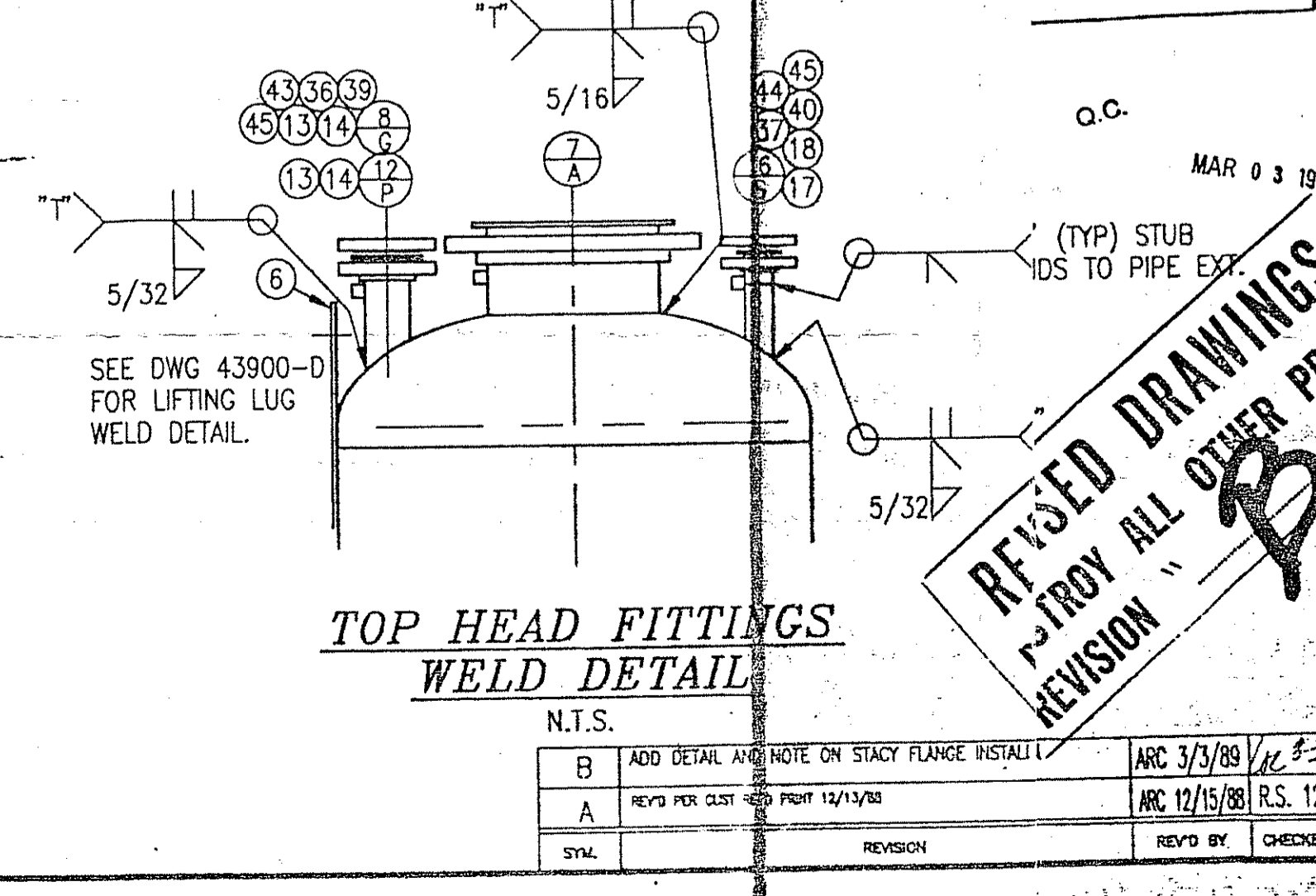
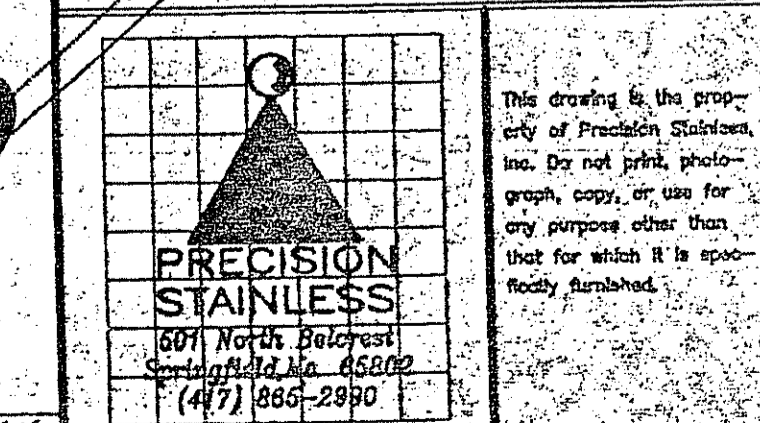
Interior: GRIND SMOOTH, NOT FLUSH
 TO 80 GRIT
 Exterior: PICKLE PASTE

Heat Transfer Surface:

SPECIFICATIONS	VESSEL	HEAT TRANSFER SURFACE
ASME Code Sec. VIII Div. 1	YES	
Insp. and Stamp	YES	
Max Design Temp F	-20 TO 400	
Max Design Press PSIG	150	
Corrosion Allowance (Inch)	0	
Hydrostatic Test PSIG	241	
Vacuum Design In.Hg.	29.92	
Heating Medium		
Cooling Medium		
Radiograph	SPOT	

EST. EMPTY WEIGHT: 5500 LBS.
 Scale: 1/2"=12" Drawing In Not To Be Scaled
 Drawn: A.R. Evans 11-30-88
 Checked: R. Smith 12-5-88
 Approved: R. Smith 12-15-88
 Customer: PROCTER & GAMBLE
 Address: CINCINNATI, OH
 Customer Order No.: ENE-FT-45564-JB

TITLE
 EXTRACTION COLUMNS
 NON DISCRETIONARY UNTIL SUPER SEDED
 SHIP TO: SHERMAN, TX
 QUANTITY REQ'D. (6) SIX



REV	BY	DATE	DESCRIPTION
B		ARC 3/3/88	ADD DETAIL AND NOTE ON STACY FLANGE INSTALL
A		ARC 12/15/88	REV'D PER CUSTOMER PRINT 12/15/88

WORK ORDER NO. P-8985-1 TO 6
 DRAWING NO. 43899 D
 SHERMAN, TX