NON DISCRETIONARY UNTIL SUPERSEDED

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

11087-1

1. Manufactured and certified by Precision Stainless, Inc., 501 North Belcrest, Springfield, MO 65802
(Name and address of manufacturer)

2. Manufactured for Folger Coffee Co., 400 West F. M. 1417, Sherman, TX 75090
(Name and address of purchaser)

3. Location of installation Folger Coffee Co., 400 West F. M. 1417, Sherman, TX 75090
(Name and address)

4. Type Vertical Tank (Horiz. or vert., tank) | 9536 (Mfgr's serial No.) | -- (CRN) | 44486-D, Rev. C (Drawing No.) | 2740 (Nat'l. Bd. No.) | 1989 (Year built)

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 (Year)

to A-88 (Addenda (Date)) | -- (Code Case Nos.) | -- (Special Service per UG-120(d))

6. Shell: SA240 304L (Matl. (Spec. No., Grade)) | .187 (Nom. Thk. (in.)) | 0 (Corr. Allow. (in.)) | 2' -11.625" (Diam. I.D. (ft. & in.)) | 19' -6.625" OAL (Length (overall) (ft. & in.))

7. Seams: Weld Single Butt (Long. (Welded, Dbl., Sngl., Lap, Butt)) | -- (R.T. (Spot or Full)) | 70% (Eff. (%)) | -- (H.T. Temp. (°F)) | -- (Time (hr)) | Weld Double Butt (Girth (Welded, Dbl., Sngl., Lap, Butt)) | -- (R.T. (Spot, Partial, or Full)) | 2 (No. of Courses)

8. Heads: (a) Matl. SA240 304L (Spec. No., Grade) (b) Matl. -- (Spec. No., Grade)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a)	Bottom	.218"	0	36"	3"	--	--	--	--	Concave
(b)	--									

If removable, bolts used (describe other fastenings) -- (Matl., Spec. No., Gr., Size, No.)

9. MAWP 50 psi at max. temp. 300 °F
Min. design metal temp. +18 °F at 50 psi. Hydro., ~~pneumatic~~ test pressure 82 psi.

10. Nozzles, Inspection and safety valve openings:

Purpose (Inlet, Outlet, Drain)	No.	Diam. or Size	Type	Matl.	Nom. Thk.	Reinforcement Matl.	How Attached	Location
Inspection	2	18"	Manway	SA240 304L	.25"	SA240 304	Weld	Shell
Sparge	1	6"	Pipe	SA312 304L	SCH40	SA240 304	Weld	--
Temp. Gauge	1	1"	Pipe	SA312 304L	SCH40	--	Weld	--
Inlet-Outlet	1-1	3"	Pipe	SA240 304L	SCH40	--	Weld	--

11. Supports: Skirt No (Yes or no) Lugs -- (No.) Legs -- (No.) Other 2 support rings (Describe) Attached Upper Shell (Where and how) 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: Column stub end section, item 12 Hebeler Welding Co., 8988
(Name of part, item number, Mfg'r's name and identifying stamp)

Vessel is a stripper column, lower section to be bolted by top 36" flange to existing customer vessel in field. Hydro -test in horizontal position. Exempted from impact testing per UHA-51.

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, 19 92.

Date 2-19-90 Co. name Precision Stainless, Inc. (Manufacturer) Signed Douglas D Morgan (Representative)

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 Texas and employed by Commercial Union Insurance Co.

have inspected the component described in this Manufacturer's Data Report on Nov. 8, 19 89, 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 2-19-90 Signed Allen A Cooper (Authorized Inspector) Commissions NB 8293 Texas 2445 (Nat'l Board (incl. endorsements), State, Prov. and No.)

NON DISCRETIONARY UNTIL SUPERSEDED

FORM U-2 MANUFACTURER'S PARTIAL DATA REPORT

A Part of a Pressure Vessel Fabricated by One Manufacturer for Another Manufacturer
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

1. Manufactured and certified by HEBELER WELDING CO., INC. 2000 Military Rd. Tonawanda, N.Y. 14150
(Name and address of manufacturer)

2. Manufactured for APV Crepaco, Inc. 395 Fillmore Ave. Tonawanda, N.Y. 14150
(Name and address of purchaser)

3. Location of Installation Unknown
(Name and address)

4. Type: Vert. | H1327 | -- | 4214376104 | -- | 1989
(Horiz. or vert. tank) | (Mfg's serial No. of Part) | (CRN) | (Drawing No.) | (Nat'l. Bd. No.) | (Year built)

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
(Year)

1987 (Addenda (Date)) | -- (Code Case No.) | -- (Special service per UG-120(d))

6. (a) Drawing prepared by APV Crepaco (b) Description of part inspected Column stub and section

7. Postweld heat treatment: Temp. -- °F Time --

Items 8–13 incl. to be completed for single wall vessels, jackets of jacketed vessels, or shells of heat exchangers

8. Shell: SA240-304L (Matl. (Spec. No., Grade)) | 3/16" (Nom. Thk. (in.)) | -- (Corr. Allow. (in.)) | 35-5/8" (Diam. I.D. (ft & in.)) | 3" (Length (overall) (ft & in.))

9. Seams: Dbl. Butt (Long. (Wld., Dbl., Sngl., Lap, Butt)) | -- (R.T. (Spot or Full)) | 70% (Eff. (%)) | -- (H.T. Temp. (°F)) | -- (Time) | Full Fillet (Girth (Wld., Dbl., Sngl., Lap, Butt)) | -- (R.T. (Spot, Partial, or Full)) | 1 (No. of Courses)

10. Heads: (a) Matl. None (Spec. No., Grade) (b) Matl. None (Spec. No., Grade)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a)										
(b)										

If removable, bolts used (describe other fastenings) _____
(Matl., Spec. No., Gr., Size, No.)

11. Type of Jacket _____ Proof Test _____

12. Jacket Closure _____ If bar, give dimensions _____
(Describe as ogee & weld, bar, etc.)
If bolted, describe or sketch.

13. MAWP _____ psi at max. temp. _____ °F. Min. design metal temp. _____ °F at _____ psi.
Hydro., pneu., or comb. test press. _____ psi.

Items 14 and 15 to be completed for tube sections

14. Tubesheets: _____ (Stationary Matl. (Spec. No., Gr.)) | _____ (Diam. (in.) (subject to pressure)) | _____ (Nom. Thk. (in.)) | _____ (Corr. Allow. (in.)) | _____ (Attach. (Wld., Rolled))

_____ (Floating Matl. (Spec. No., Gr.)) | _____ (Diam. (in.)) | _____ (Nom. Thk. (in.)) | _____ (Corr. Allow. (in.)) | _____ (Attach.)

15. Tubes: _____ (Matl. (Spec. No., Grade)) | _____ (O.D. (in.)) | _____ (Nom. Thk. (in. or gauge)) | _____ (No.) | _____ (Type (straight or "U"))

Items 16–18 incl. to be completed for inner chambers of jacketed vessels or channels of heat exchangers

16. Shell: _____ (Matl. (Spec. No., Gr.)) | _____ (Nom. Thk. (in.)) | _____ (Corr. Allow. (in.)) | _____ (Diam. I.D. (ft & in.)) | _____ (Length (overall) (ft & in.))

17. Seams: _____ (Long. (Wld., Dbl., Sngl., Lap, Butt)) | _____ (R.T. (Spot or Full)) | _____ (Eff. (%)) | _____ (H.T. Temp. (°F)) | _____ (Time) | _____ (Girth (Wld., Dbl., Sngl., Lap, Butt)) | _____ (R.T. (Spot, Partial, or Full)) | _____ (No. of Courses)

18. Heads: (a) Matl. _____ (Spec. No., Grade) (b) Matl. _____ (Spec. No., Grade)

	Location (Top, Bottom, Ends)	Minimum Thickness	Corrosion Allowance	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a)										
(b)										

If removable, bolts used (describe other fastenings) _____
(Matl., Spec. No., Grade, Size, No.)

This Form (600110) may be obtained from the ASME Order Dept., 22 Law Drive, Box 2300, Fairfield, NJ 07007-2300

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