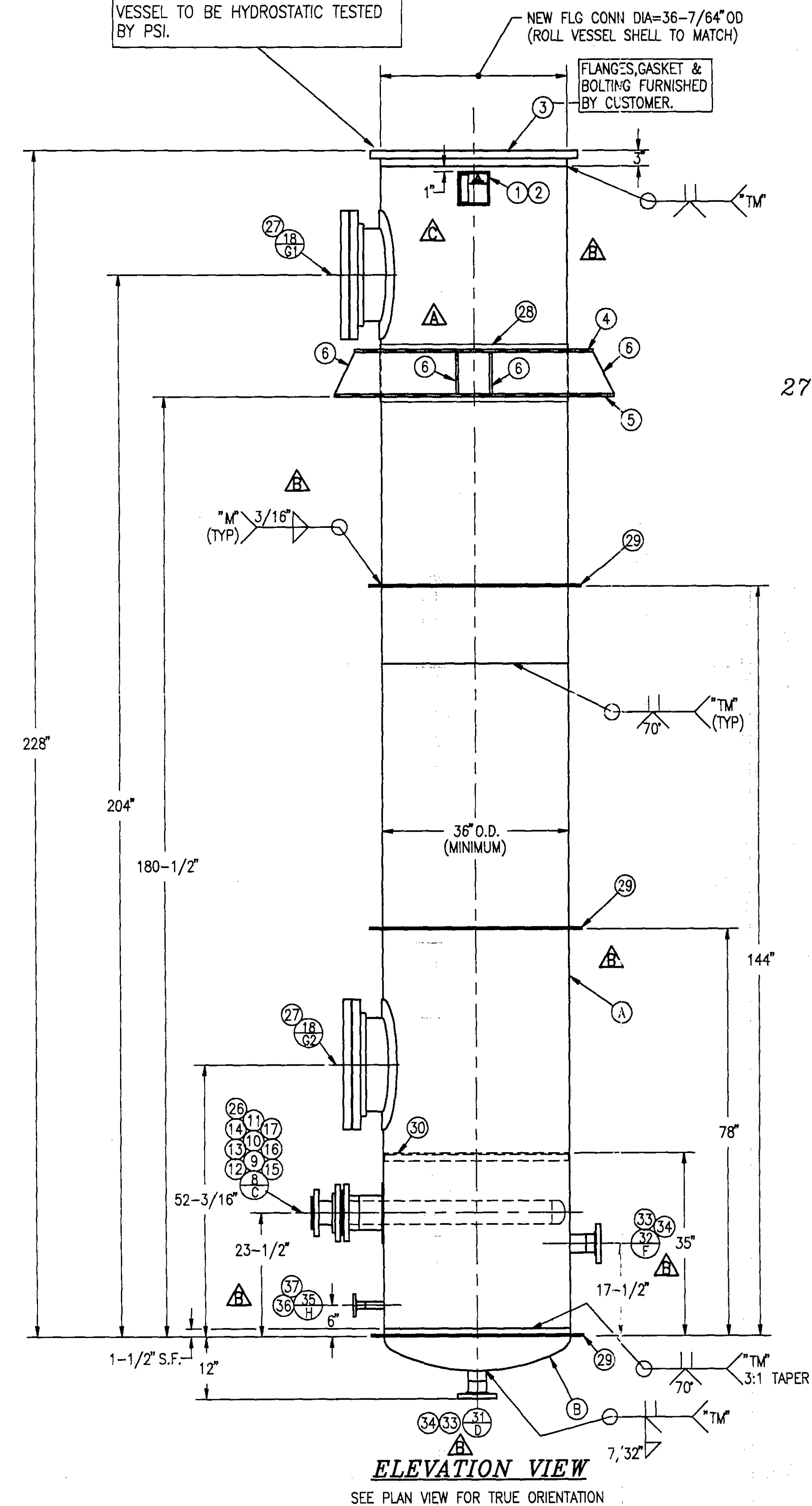
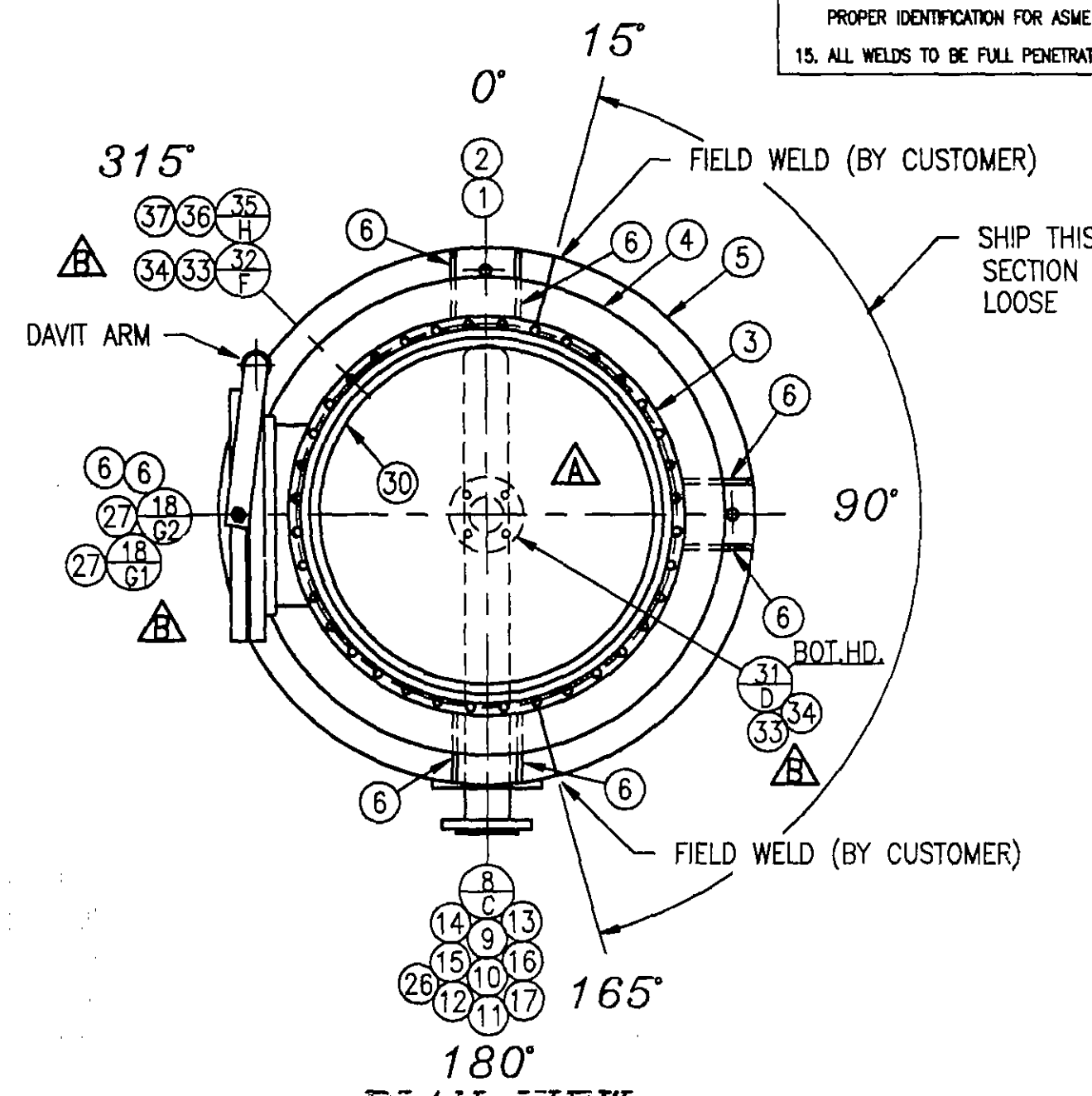
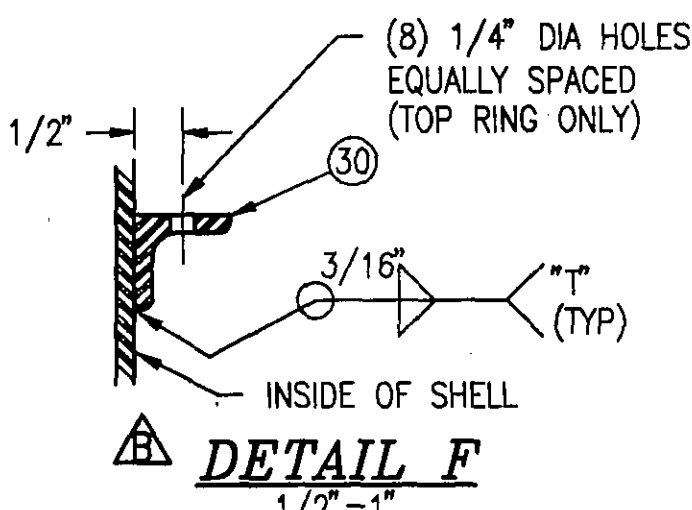


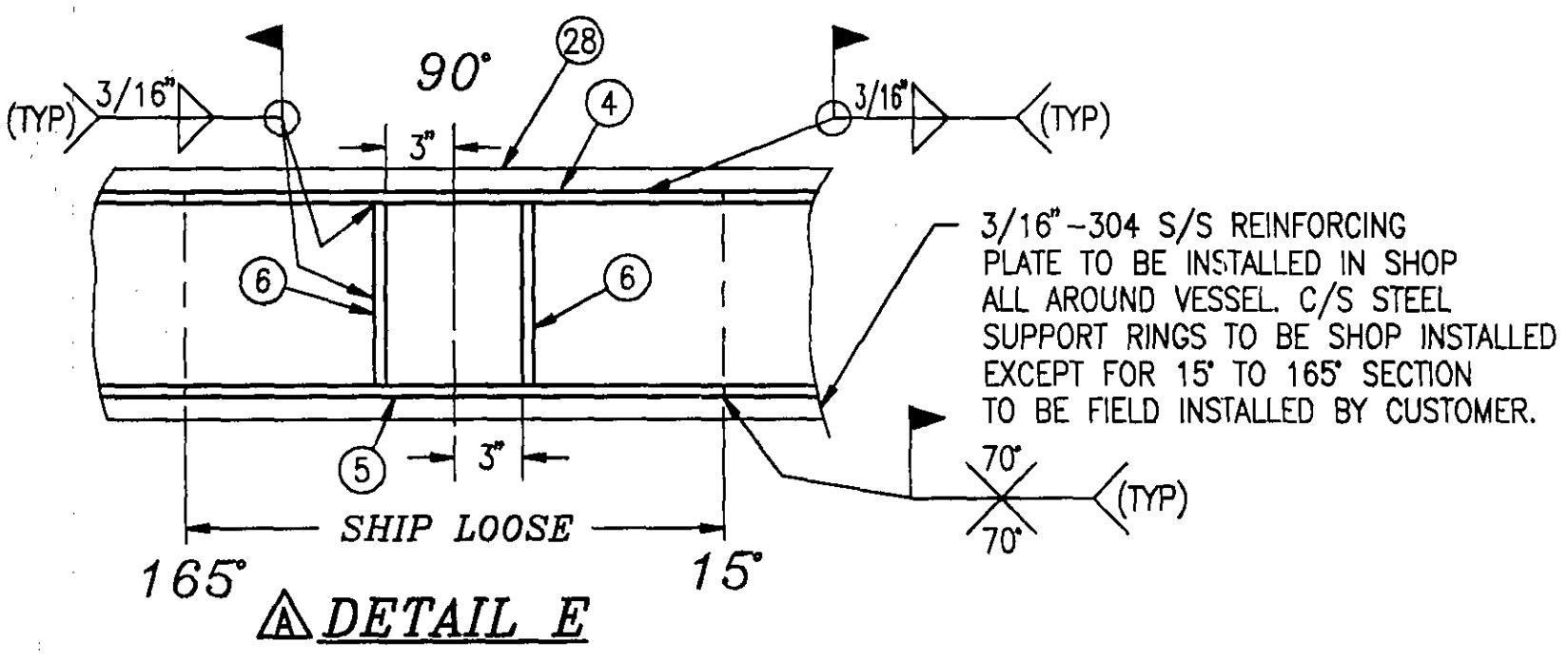
PRODUCTION NOTE:
NEW COLUMN SECTION PROVIDED
BY CUSTOMER TO BE BOLTED TO
SECTION MF'D BY PSI AND COMPLETE
VESSEL TO BE HYDROSTATIC TESTED
BY PSI.



ELEVATION VIEW
SEE PLAN VIEW FOR TRUE ORIENTATION

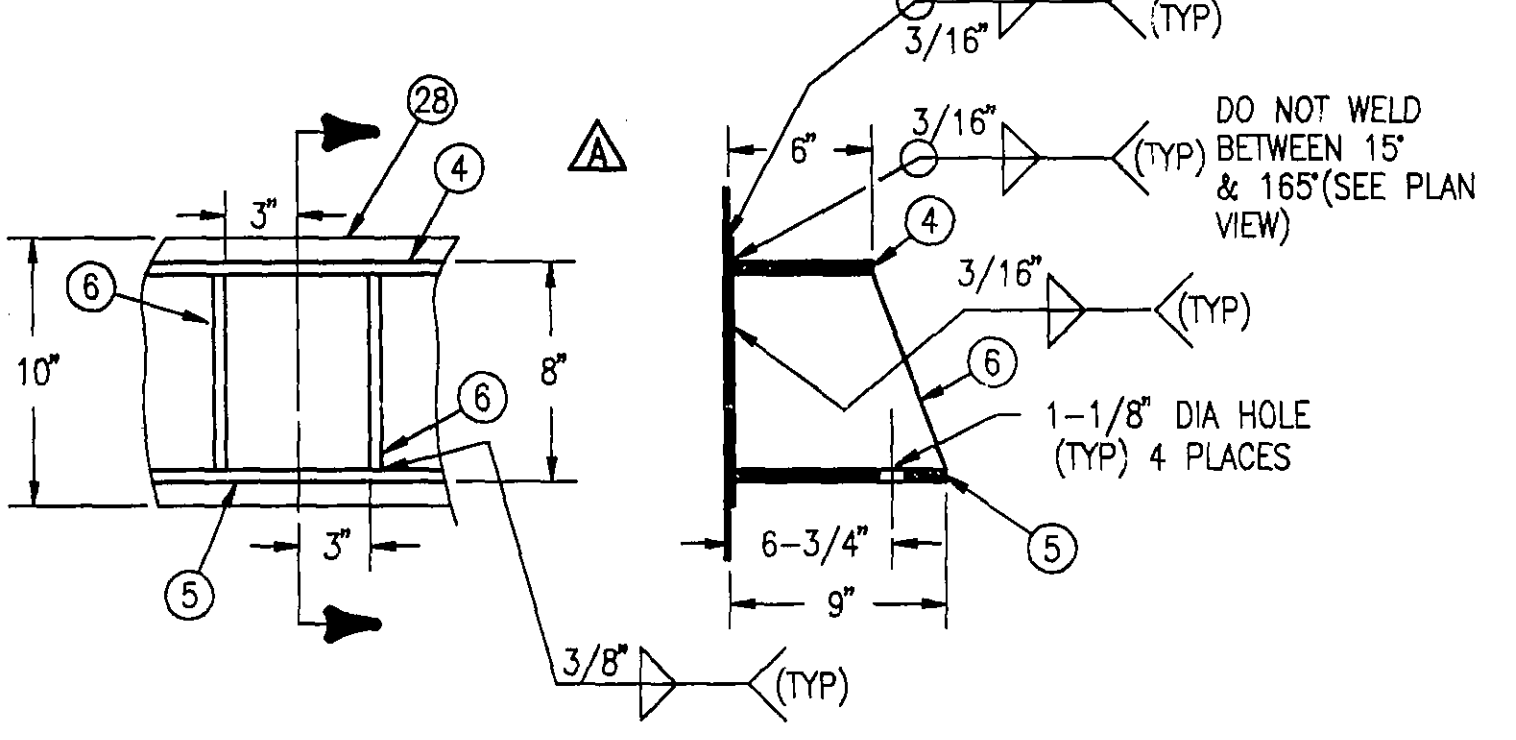


PLAN VIEW



DETAIL E

PRODUCTION NOTE:
GUSSETS @ 90° WILL BE FIELD
WELDED BY CUSTOMER



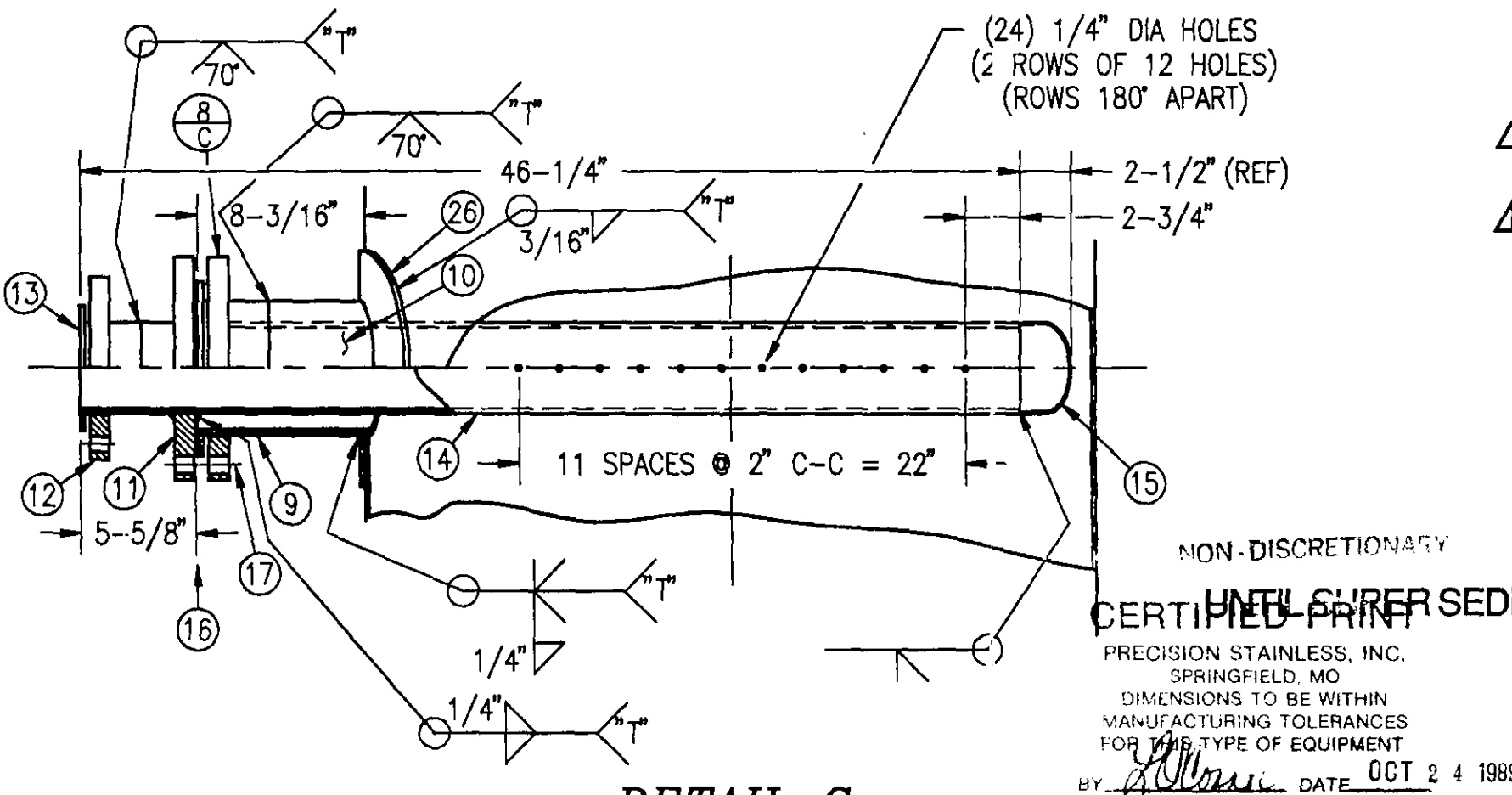
DETAIL B

SCALE: 1-1/2"=12"
(SEE DETAIL E FOR FIELD WELDED SECTION)

NOTES (CONT.)
8. WELDING PROCEDURE, IN ACCORDANCE WITH ASME CODE UW-28,
SHALL CONFORM TO THE FOLLOWING SPECIFICATIONS:
A=0808721-01
T = 0808714-01
0808715-02
0108711-01
M = 0808734-01
0108733-01
9. ALL WELDING TO BE DONE BY ASME CERTIFIED WELDERS.
10. VESSEL TO BE HYDROSTATICALLY TESTED FOR (2) HOURS.
CHECK FOR DEFECTS, REPAIR & RE-TEST IF NECESSARY.
MODIFIED VESSEL AND NEW VESSEL TO BE BOLTED TO-
GETHER FOR HYDROSTATIC TEST AS COMPLETE UNIT.
11. THIS DRAWING SIMILAR TO DWGS. 25001-1, 25001-2 &
25001-3 DATE 6-8-89
12. EMPTY WT OF VESSEL TO BE MODIFIED: 3300#
WEIGHT ADDED BY MODIFICATIONS: 1000#
TOTAL WEIGHT OF MODIFIED VESSEL: 4300#
WEIGHT OF EXPANSION VESSEL: 4000#
LESS PACKAGING: 4000#
TOTAL WEIGHT OF EMPTY VESSEL: 8300#
13. PAINT ALL C/S SURFACES W/ONE COAT OF PRIMER.
(USE ZINC CHROMATE PRIMER)
14. CUSTOMER VESSEL MUST HAVE TEST REPORTS &
PROPER IDENTIFICATION FOR ASME CODE INSPECTION.
15. ALL WELDS TO BE FULL PENETRATION.

QTY	ITEM NO.	NO. REQ'D.	PART NO. (PSI) DRAWING NO.	DESCRIPTION
1	1		90085-1A	PRECISION STAINLESS ASME DATA PLATE
2	1		S00162-3B	NAMEPLATE BRACKET, 14 GA, 304 S/S, 2B/2S
3	1		CUST.FURN.	FLANGE, 36" W/ EXT. RING, (SA-240), HRAP, (SEE DETAIL A)
4	1		DETAIL B & E	TOP SUPPORT RING, 1/2" PL, C/S, 36-3/8" ID X 48" OD
5	1		DETAIL B & E	BOT. SUPPORT RING, 1/2" PL, C/S, 36-3/8" ID X 54" OD
6	8		DETAIL B & E	GUSSETS, 1/2" PL, C/S
7	-		-	-
8	1		DETAIL C	FLANGE, 6"-150#, ANSI, L/J, C/S, (SA-105)
9	1		DETAIL C	STUB END, 6" SCH 40, 304L S/S, (SA-403) HRAP, TYPE A, MSS LGTH.
10	1		DETAIL C	PIPE, 6" SCH 40, 304L S/S, (SA-312), HRAP
11	1		DETAIL C	FLANGE, 6"-150#, ANSI, BLIND, 304L S/S, (SA-182)
12	1		DETAIL C	FLANGE, 4"-150#, ANSI, L/J, C/S, (SA-105)
13	1		DETAIL C	STUB END, 4" SCH 40, 304L S/S, (SA-403) HRAP, TYPE A, MSS LGTH.
14	1		DETAIL C	PIPE, 4" SCH 40, 304L S/S, (SA-312), HRAP
15	1		DETAIL C	CAP, 4" SCH 10, 304L S/S, (SA-403), HRAP
16	1		DETAIL C	GASKET, 1/8" THK, "GARLOCK 900", 4-3/4" ID X 8-1/2" OD, (OR EQUAL)
17	8		DETAIL C	BOLTS, HEX HEAD, 3/4"-10NC X 3-1/2" LG, (SA-193-B7), ZINC PLTD C/S
-	8		DETAIL C	LOCKWASHERS, 3/4", ZINC PLTD C/S
-	8		DETAIL C	HEAVY HEX NUTS, 3/4"-10NC, (SA-194-2H), ZINC PLTD C/S
18	2		44525-C	MANWAY ASSY, 18" OD, FLAT BOLTED, 304L S/S CLAD, W/ DAVIT ARM
19	-		-	-
20	-		-	-
21	-		-	-
22	-		-	-
23	-		-	-
24	-		-	-
25	-		-	-
26	1		DETAIL C	DOUBLER PLATE, 1/4" PL, 304 S/S, (SA-240), HRAP, 6-5/8" ID X 11-5/8" OD
27	2		44525-C	DOUBLER PLATE, 1/4" PL, 304 S/S, (SA-240), HRAP, 18" ID X 25" OD
28	1		DETAIL B & E	REINFORCING PAD, 3/16" PL, 304 S/S, HRAP
29	3		-	STIFFENING RINGS, 3/8" X 3" FLAT BAR, 304 S/S, HRAP, (SA-240)
30	2		DETAIL F	SUPPORT RING, 1" X 1" X 1/4" ANGLE, 304L S/S, HRAP (SEE PRODUCTION NOTE BELOW)
31	1		DETAIL C	FLANGE, 3"-150#, ANSI, L/J, C/S, (SA-105) (LIQUID OUTLET)
32	1		DETAIL C	FLANGE, 3"-150#, ANSI, L/J, C/S, (SA-105) (LEVEL)
33	2		DETAIL C	STUB END, 3" SCH 40, 304L S/S, (SA-403), HRAP, TYPE A, MSS LENGTH
34	2		DETAIL C	PIPE, 3" SCH 40, 304L S/S, (SA-312), HRAP
35	1		DETAIL C	FLANGE, 1"-150#, ANSI, L/J, C/S, (SA-105) (TEMP. GAGE)
36	1		DETAIL C	STUB END, 1" SCH 40, 304L S/S, (SA-403), HRAP, TYPE A, MSS LENGTH
37	1		DETAIL C	PIPE, 1" SCH 40, 304L S/S, (SA-312), HRAP

PRODUCTION NOTE:
ONLY 1 ITEM 30 WILL BE USED IN THIS VESSEL.
THE OTHER ITEM 30 WILL BE WELDED INTO
THE CUSTOMERS APV CREPACO COLUMN WHICH
MATES WITH THE PSI COLUMN. PSI WILL WELD
THE RING IN PLACE BEFORE HYDROTESTING THE
COMPLETE COLUMN ASSY. CONTACT ENGINEERING
FOR EXACT LOCATION TO PLACE RING IN CREPACO
COLUMN.



DETAIL C

SCALE: 1-1/2"=12"

REV	DESCRIPTION	DATE	BY	CHECKED BY
C	MOVE (1) ANGLE SUPPORT FROM LOWER COLUMN TO UPPER COLUMN	ARC 10-20-89	Loc 10-23-89	
B	WAS MODIFY EXISTING VESSEL. ADD ITEMS A & C. 20 HOURS 35 MANWAY ASSY NOW ON DWG. 44525-C. DEL. DETAILS A & D	ARC 10-11-89	Loc 10-16-89	
A	CUSTOMER WAS FROM-TOOK CONSTRUCTION. P.D. NO. WAS 01286. ADD DETAIL F	ARC 10-4-89	RDS 10/5/89	
	CHANGE SUPPORT PLATES AND ADD REINFORCING PLATE PER FOLGER COFFEE CO. FAX 10-2-89			

NOTES
1. FLANGE BOLT HOLES TO STRADDLE MAJOR VERTICAL AND HOR-
IZONTAL VESSEL CENTERLINE UNLESS INDICATED OTHERWISE.
2. THE CORROSION RESISTANCE OF THE EQUIPMENT IS NOT
THE RESPONSIBILITY OF PRECISION STAINLESS, INC. WITH
OUT WRITTEN ACCEPTANCE BASED ON A SPECIFIC SERVICE.
3. SUITABLE PRESSURE AND/OR VACUUM RELIEF VALVE(S) MUST
BE INSTALLED BY CUSTOMER FOR VESSEL AND/OR HEAT TRANS-
FER SURFACE OPERATION.
4. 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-BB.
5. PRODUCTION TO PROVIDE PROTECTION FOR ALL NOZZLES AND
FITTINGS PRIOR TO SHIPMENT. VESSEL MUST BE ADEQUATELY
VENTED.
6. WELD SEAMS IN VESSEL HEAD AND SHELL SHOULD BE LOCATED,
WHERE POSSIBLE, TO AVOID ALL NOZZLES, ACCESS OPENINGS,
AND REINFORCEMENT PADS.
7. ALL REINFORCEMENT PADS MUST BE PROVIDED WITH (1) ONE
1/8" DIA. WEEPHOLE LOCATED AT LOWEST POINT WHEN VESSEL
IS IN ITS NORMAL OPERATING POSITION.

MATERIAL	FINISH
(A) Shell: 3/16" PL, 304L S/S, (SA-240)	HRAP
(B) Head, Top:	
(C) Head, Bottom: 1/4" PL, 304L S/S, (SA-240)	HRAP
(D) Jacket:	
(E) Head, Top:	
(F) Head, Bottom:	
(G) Breast Ring:	
HEAT TRANSFER SURFACE (DWG #S00178-A) TEST PLATE NO.:	
(H) Shell: <input type="checkbox"/> Dimpled <input type="checkbox"/> Other <input type="checkbox"/> Prefinished	SK#-
(I) Head: <input type="checkbox"/> Dimpled <input type="checkbox"/> Other <input type="checkbox"/> Prefinished	SK#-
Insulation:	
Paint, H.T.S.:	
Paint: PRIME PAINT ALL C/S W/ ZINC CHROMATE PRIMER	
WELD FINISHES	
Interior: GRIND SMOOTH TO 80 GRIT	
Exterior: BLEND & CLEAN	

SPECIFICATIONS	VESSEL	HEAT TRANSFER SURFACE
ASME Code Sec. VII Div. 1	YES	
Insp. and Stamp	YES	
Max. Design Temp F	+18/300	
Max. Design Press PSIG	50	
Corrosion Allowance (Inch)	0	
Hydrostatic Test PSIG	82	
Vacuum Design In.Hg.	29.92	
Heating Medium		
Cooling Medium		
Radiograph	NONE	

EST. EMPTY WEIGHT: (NOTE #12) LBS.
Scale 3/4"=12" Drawing is Not to Be Scaled
Drawn A.P. Gannon 9-6-89
Checked L.O. Gannon 9-15-89
Approved J.O. Warner 9-28-89
Customer PROCTER & GAMBLE CO.
Address CINCINNATI, OHIO
Customer Order No. ENE-FT-45646-JB

STRIPPER COLUMN

FOLGER COFFEE CO.
SHIP TO: SHERMAN, TX

QUANTITY REQ'D. (1) ONE PV-11087-1

PRECISION STAINLESS
3300 East Pythian
Springfield, Mo. 65801
(417) 865-2890

WORK ORDER NO. P-9536
DRAWING NO. 44486 D

Bottom

100704