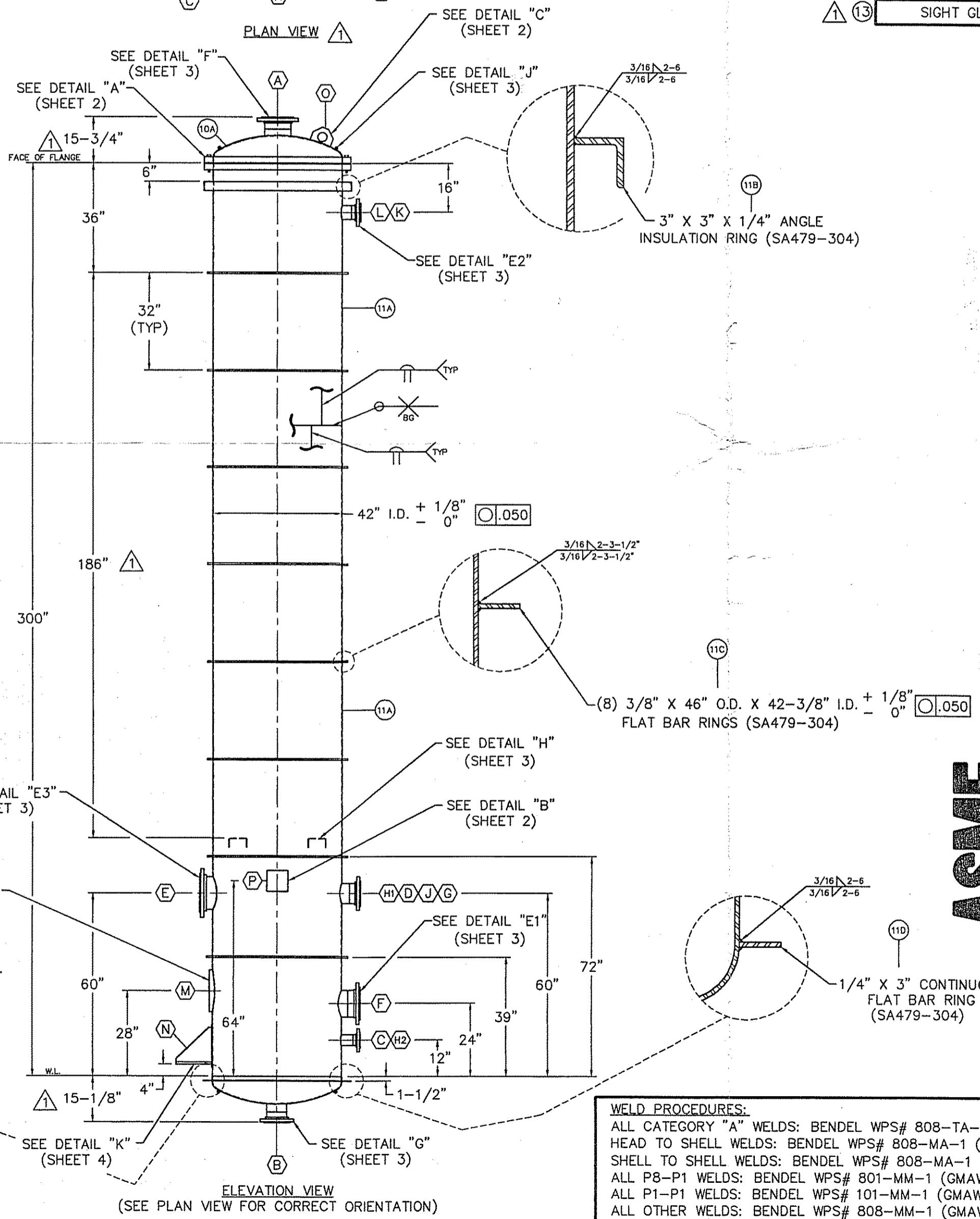
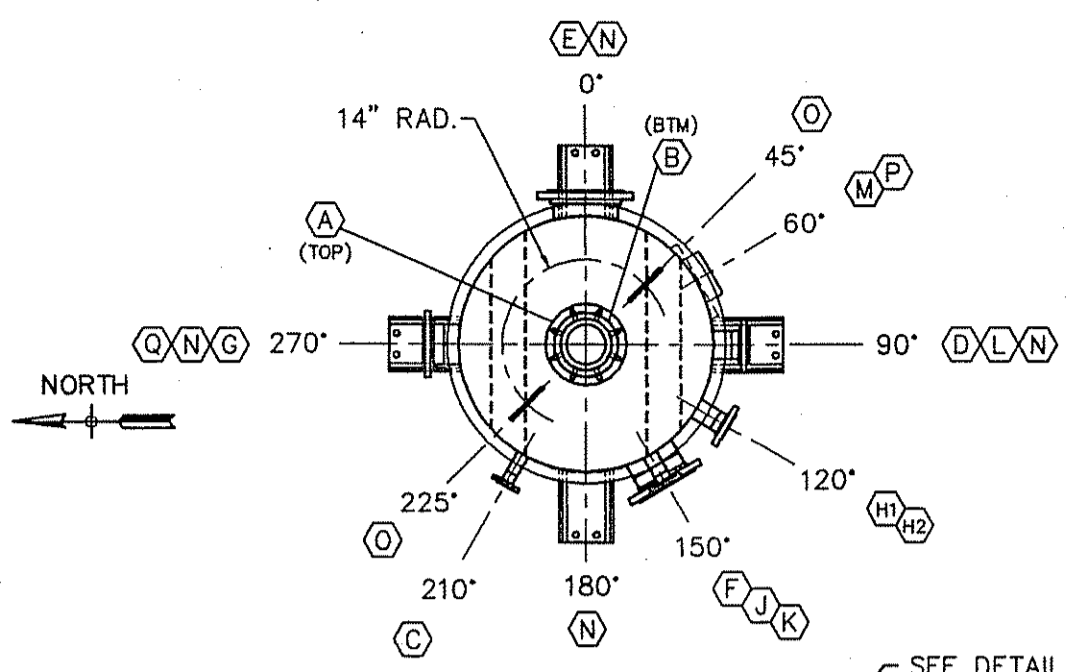


A-4065-10  
 107-8205  
 4500204785  
 B. LITTLE  
 4025  
 4/7/99

EQUIPMENT NO.:  
 P.O. NO.:  
 APPROVED BY:  
 SHEET NO.:  
 ACCT. NO.:  
 DATE:



**WELD PROCEDURES:**  
 ALL CATEGORY "A" WELDS: BENDEL WPS# 808-TA-1 (GTAW)  
 HEAD TO SHELL WELDS: BENDEL WPS# 808-MA-1 (GMAW)  
 SHELL TO SHELL WELDS: BENDEL WPS# 808-MA-1 (GMAW)  
 ALL P8-P1 WELDS: BENDEL WPS# 801-MM-1 (GMAW)  
 ALL P1-P1 WELDS: BENDEL WPS# 101-MM-1 (GMAW)  
 ALL OTHER WELDS: BENDEL WPS# 808-MM-1 (GMAW)

	SERVICE	MK.	SIZE	LOCATION	PROJ.	DESCRIPTION
15	VAPOR OUTLET	A	8"	CENTER/TOP	6"	150# L.J. FLG. W/SCH.40 "A" STUB END
16	OUTLET	B	6"	CENTER/BOTTOM	6"	150# L.J. FLG. W/SCH.40 "A" STUB END
20	TEMPERATURE	C	1-1/2"	210°/SHELL	6"	150# L.J. FLG. W/SCH.40 "A" STUB END
19	PRESSURE	D	2"	90°/SHELL	6"	150# L.J. FLG. W/SCH.40 "A" STUB END
14	REBOILER INLET	E	10"	0°/SHELL	4"	150# L.J. FLG. W/SCH.40 "A" STUB END
15	INSPECTION PORT	F	8"	150°/SHELL	6"	150# L.J. FLG. W/SCH.40 "A" STUB END
16	SAFETY VALVE	G	6"	270°/SHELL	6"	150# L.J. FLG. W/SCH.40 "A" STUB END
18	LEVEL	H1	3"	120°/SHELL	6"	150# L.J. FLG. W/SCH.40 "A" STUB END
18	LEVEL	H2	3"	120°/SHELL	6"	150# L.J. FLG. W/SCH.40 "A" STUB END
19	SPARE	J	2"	150°/SHELL	6"	150# L.J. FLG. W/SCH.40 "A" STUB END
19	PRESSURE	K	2"	150°/SHELL	6"	150# L.J. FLG. W/SCH.40 "A" STUB END
17	FEED INLET	L	4"	90°/SHELL	6"	150# L.J. FLG. W/SCH.40 "A" STUB END
13	SIGHT GLASS	M	6"	60°/SHELL	-	R.F. STUDDING PAD
21		N	-	0°/90°/180°/270°/SHELL	-	(4) SUPPORT LUGS
22		O	-	45°/225°/TOP	-	(2) LIFT LUGS
23		P	-	60°/SHELL	-	BENDEL & ASME NAMEPLATE W/BACKET
26		Q	-	270°/N	-	GROUNDING LUG

MATERIAL	
SHELL	7 GA. (0.187") SA240-316L
HEADS (.18" MIN)	.293" NOM. ASME F&D W/1-1/2" S.F. SA240-316L
COUPLINGS	NONE
NOZZLES	FLANGES SA105 (B16.5)
	NECKS SA312TP316L (B36.10)(WELDED). SA403WP316L STUB ENDS
MANHOLES AND / OR HANDHOLES	FLANGES NONE
	NECKS NONE
	COVERS NONE
GASKETS	EPDM
BOLTING	SA193-B7/SA194-2H
SUPPORTS	SA36
REINFORCEMENT PADS	SA240-316L
DESIGN PRESSURE	50 PSI & 14.7 PSI (EXT)
DESIGN TEMPERATURE	375°F; MDMT: -20°F AT 50 PSI
CORROSION ALLOWANCE	NONE
RADIOGRAPHY	NONE
HEAT TREATMENT	NONE
IMPACT TESTING	NONE; EXEMPT PER UHA-51 & UG-20
PAINTING	EXTERIOR SANDBLAST; ONE COAT OF SW HIGH-TEMP. 850 PRIMER
HYDROSTATIC TEST	80 PSI
CODE & STAMPING	"U" (ASME SECTION VIII, DIV.1 95 ED, A97; W/NAT'L BD REGIST.)
INSPECTION	BENDEL Q.C. A.I. & CUSTOMER
SPECIFIC GRAVITY	1.0
NOMINAL CAPACITY	1,880 GAL.
WEIGHT EMPTY	5,000 LBS.
APPROVED	VINCE PETRUCCI
DATE	3/18/99

**NOTES:**  
 FLANGE BOLT HOLES SHALL STRADDLE 0° - 180° CENTERLINES  
 DRAIN NOZZLES SHALL BE FLUSH WITH INSIDE OF VESSEL  
 FABRICATION TOLERANCES PER BENDEL "STD-8" EXCEPT AS NOTED  
 INTERIOR WELDS GROUND FLUSH AND SMOOTH IN UPPER 222" OF TANK  
 UPPER 222" OF TANK SHALL BE ROUND WITHIN .05"  
 UPPER 222" OF INTERIOR SHALL BE SNAG-FREE WHEN WIPED WITH A NYLON PANTYHOSE  
 CUSTOMER TO INSPECT TANK PRIOR TO SHIPMENT

DATE	REVISION	BY
12-9-98	FOR CUSTOMER APPROVAL	J.C.
1-7-99	REVISED PER CUSTOMER COMMENTS, RELEASED FOR FABRICATION	R.A.
3-18-99	AS BUILT	J.C.

SUBJECT WASTE WATER STILL		<b>BENDEL</b> CHARLOTTE, N.C.
CUSTOMER KOSA WILMINGTON, NC		
SCALE: NONE	S.O. NO. 4516	JOB NO. 1142
DWG. NO. 01451698		SH. NO. 1 OF 4

**ASME**

# 103532