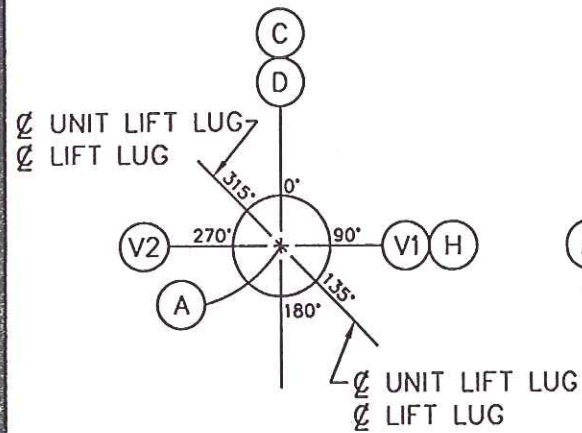
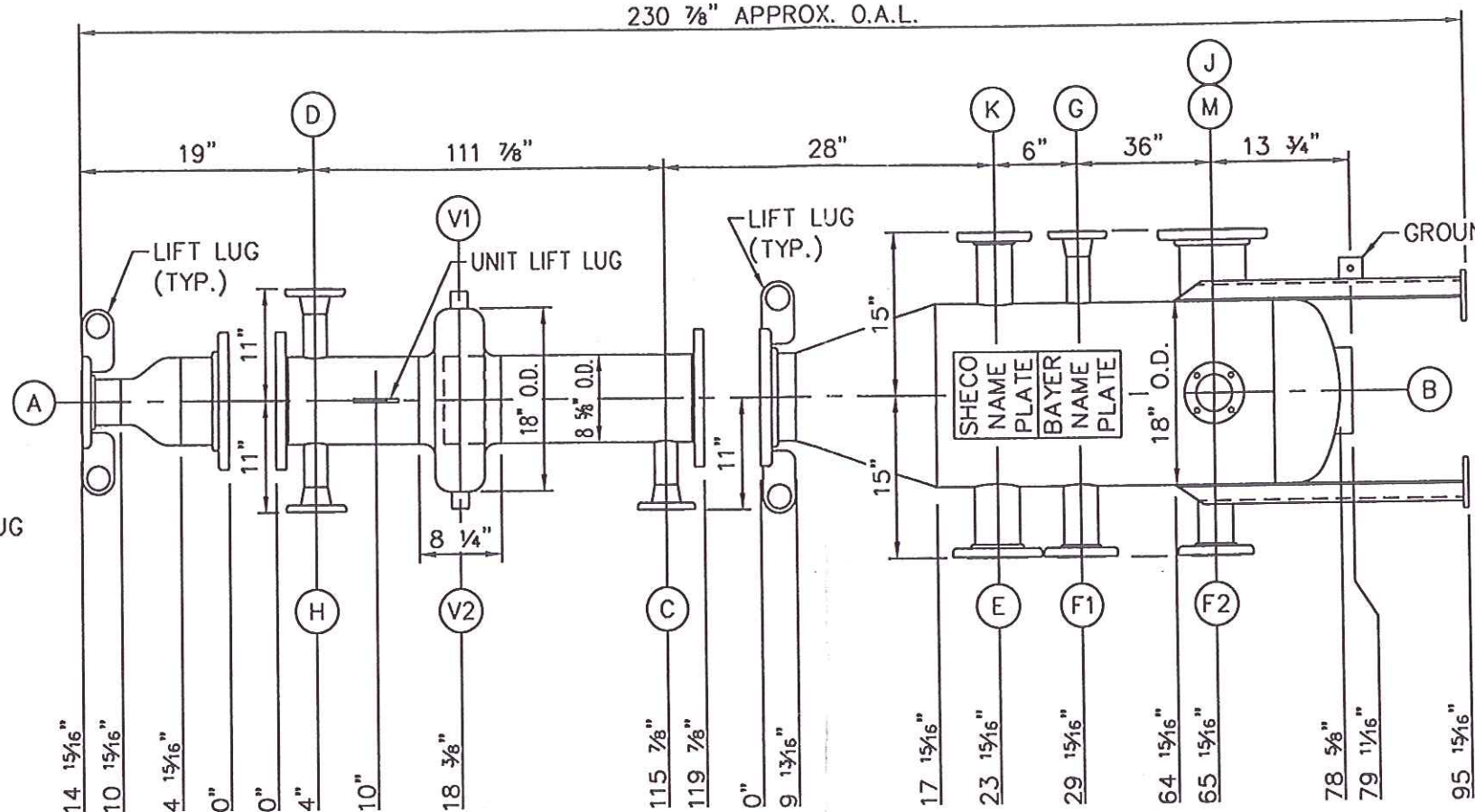


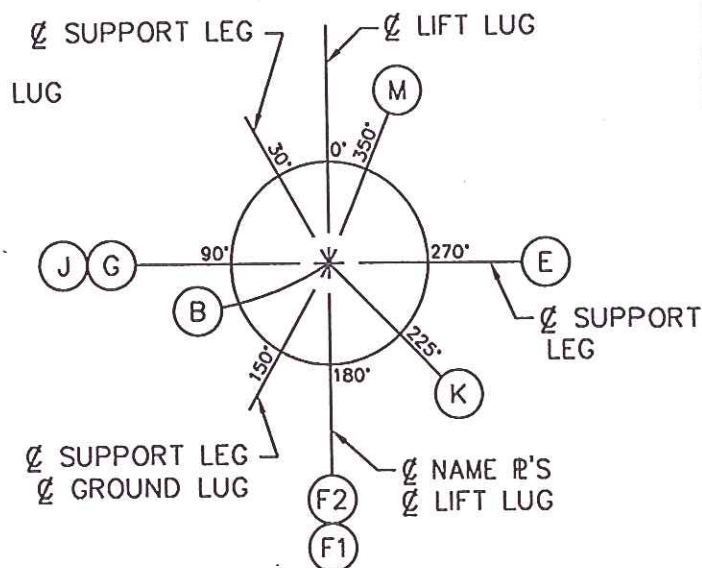
230 7/8" APPROX. O.A.L.



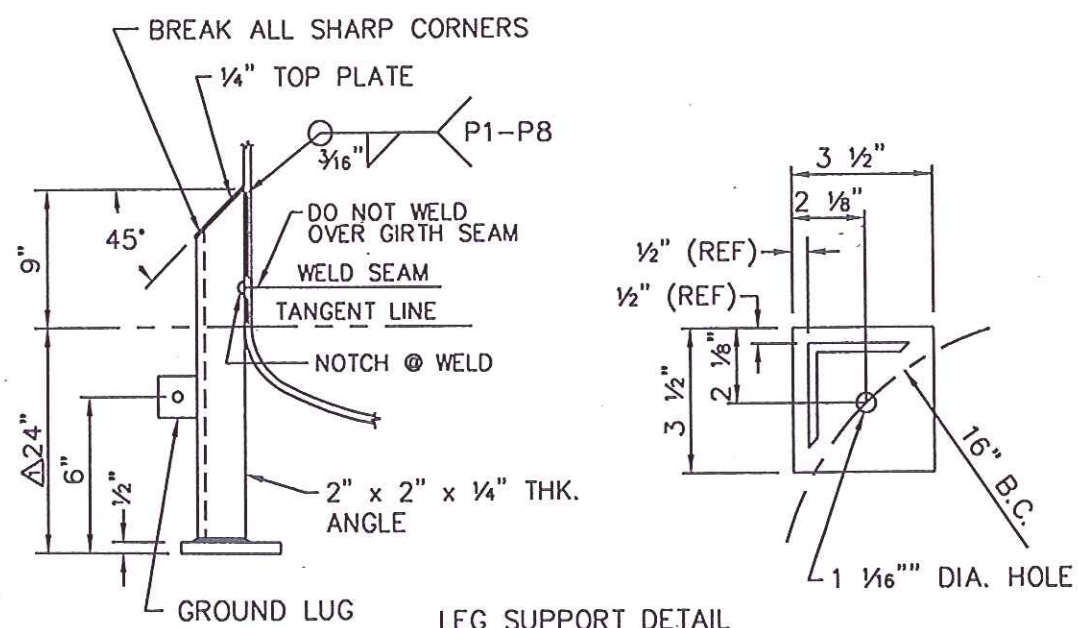
△ ORIENTATION



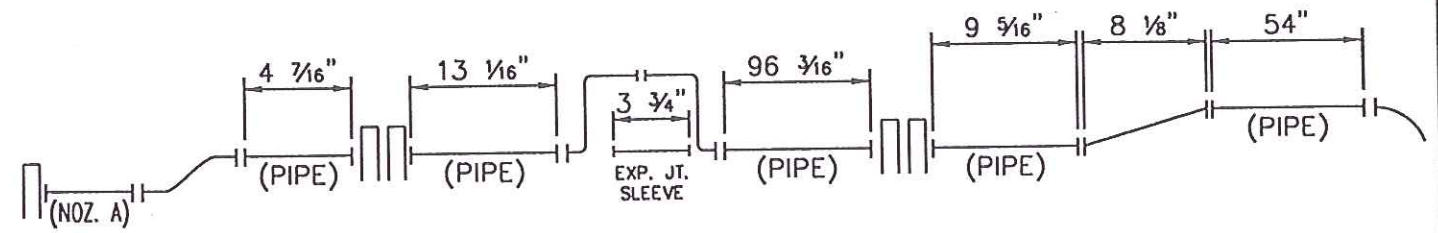
△ ELEVATION



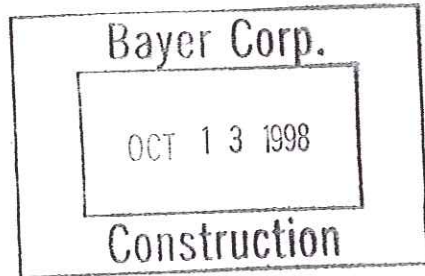
△ ORIENTATION



LEG SUPPORT DETAIL  
(3) REQ'D.



THEORETICAL COURSE LENGTH



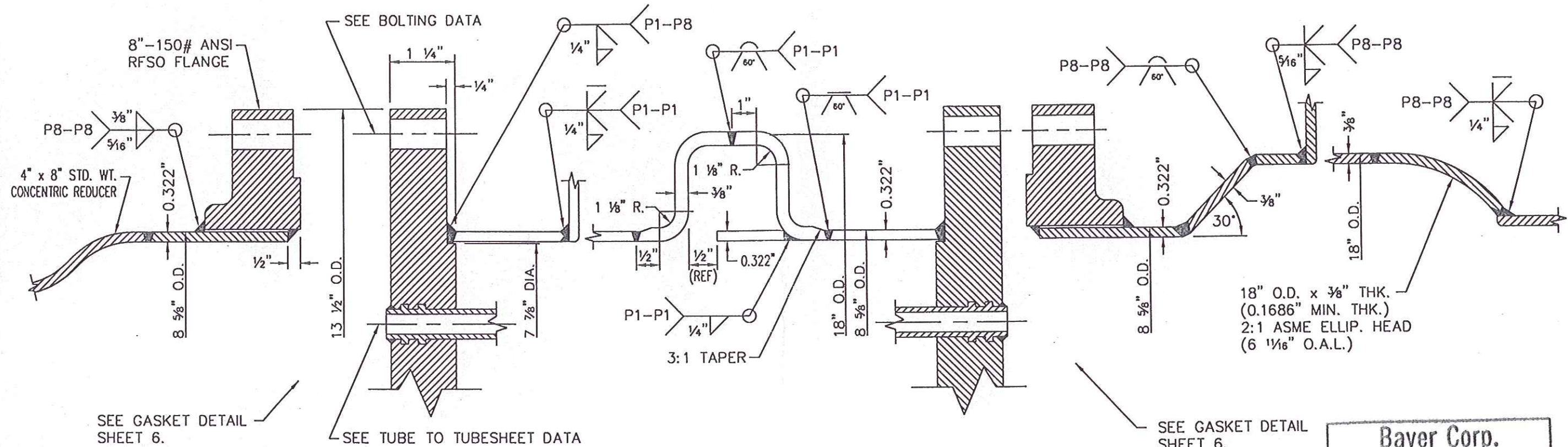
- C.ST'L
- 316L S.ST'L
- 304 S.ST'L

CERTIFIED	ENG. JDP 9/30/98	
CUSTOMER BAYER CORPORATION		
CUSTOMER P.O. NO. CO6F11527		
ITEM NO. 0242-32-298	PROJ. NO. 6192	
PLANT BUSHY PARK, SC		
TEMA SIZE AND TYPE (1) 8-120 BEM OFF SPEC DMAC CONDENSER		
SOUTHERN HEAT EXCHANGER CORP. P.O. BOX 1850 TUSCALOOSA, AL. 35403		
DATE 08/19/98	ORDER NO.	DWG. NO. SB-3563-1
BY J.D. Crowder	98-250	SHEET 2 OF 6

# 106381

SHOP NOTE:  
NO CERAMIC BACKERS  
NO FCAW

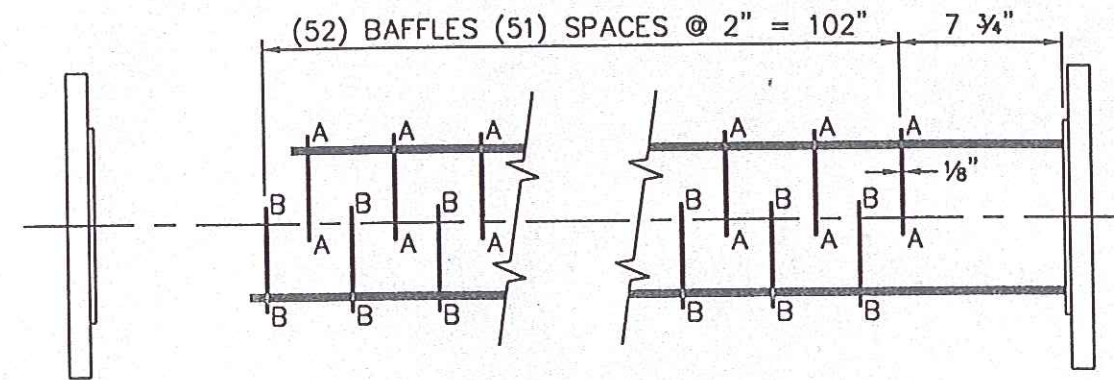
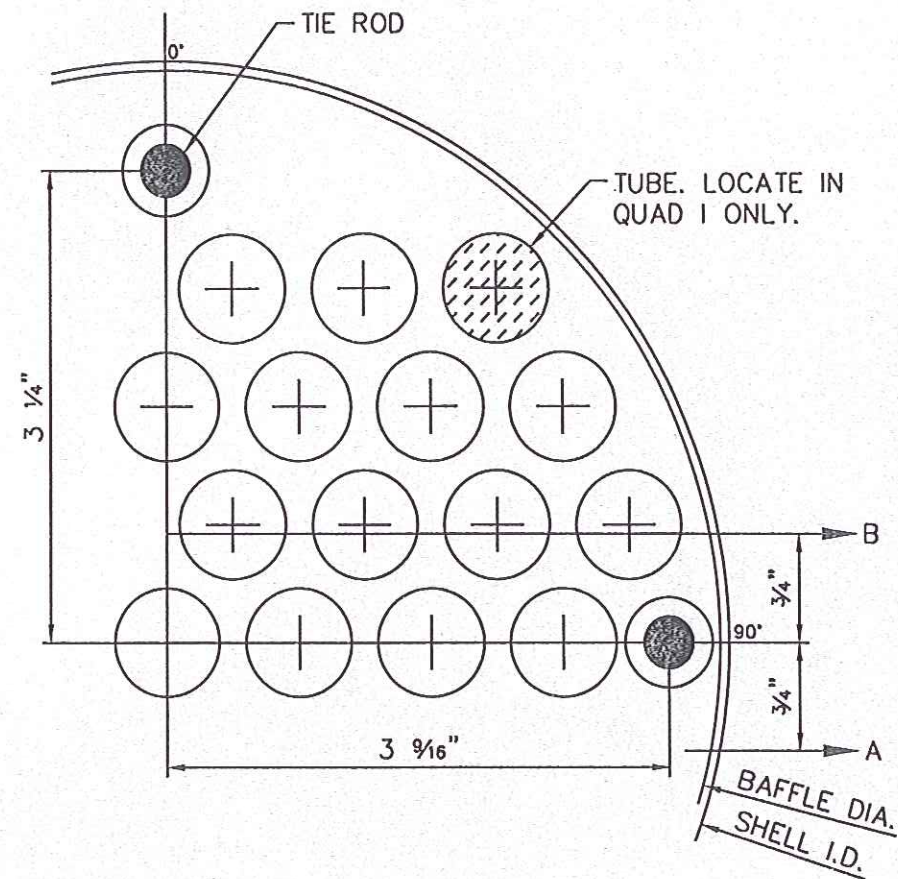
C.ST'L  
 316L S.ST'L  
 304 S.ST'L



**Bayer Corp.**  
 OCT 13 1998  
**Construction**

BOLTING DATA			TUBE TO TUBESHEET DATA		CERTIFIED			
BOLT CIRCLE DIA.	.11 3/4"	NO OF JACKSCREWS (FLG. ONLY)	TUBE PROJ. (LEFT T.S.)	1/16"	ENG.	JDP	9/30/98	
NO. OF HOLES	8	JACKSCREW HOLE DIA.	TUBE PROJ. (RIGHT T.S.)	1/16"	CUSTOMER BAYER CORPORATION			
HOLE DIA.	7/8"	JACKSCREW TAP SIZE	WELD	SEAL	CUSTOMER P.O. NO. C06F11527			
STUD SIZE	3/4"-10	JACKSCREW LOCATION	FILLER METAL	NONE	ITEM NO.	0242-32-298	PROJ. NO. 6192	
STUD LENGTH	4 1/4"	NO. OF DOWELS	SERRATED	YES	PLANT BUSHY PARK, SC			
NO. OF TAPPED HOLES	-	DOWEL HOLE DIA. (FLG.)	AIR TEST	YES	TEMA SIZE AND TYPE (1) 8-120 BEM OFF SPEC DMAC CONDENSER			
TAPPED HOLE DIA.	-	DOWEL PIN DIA.	ROLL DEPTH	1/8" OF B.F.				
TAP SIZE	-	DOWEL PIN HOLE SIZE (T.S.)	WALL REDUCTION	5-6%	<b>SOUTHERN HEAT EXCHANGER CORP.</b> P.O. BOX 1850 TUSCALOOSA, AL. 35403			
NO. TO COUNTERBORE	-	DOWEL LOCATION	DYE CHECK	YES				
COUNTERBORE DIA. x DEPTH	-		HYDRO TEST	YES	DATE	08/19/98	ORDER NO.	DWG. NO. SB-3563-1
NO. OF PULLING EYES					BY	J.D. Crowder	98-250	SHEET 3 OF 6
PULLING EYE HOLE DIA.								
PULLING EYE TAP SIZE								
PULLING EYE LOCATION (T.S. ONLY)								

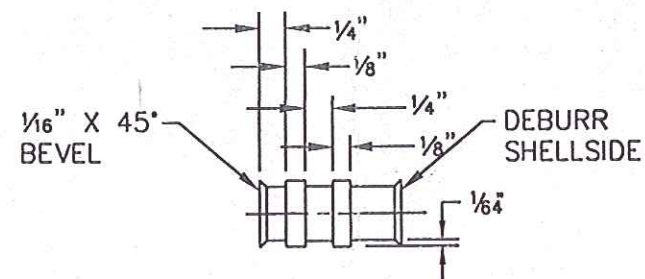
#106381



BUNDLE DETAIL

Bayer Corp.  
OCT 13 1998  
Construction

TUBE O.D.	3/4"
NO OF TUBE HOLES	46
SIZE OF TUBE HOLE IN TUBESHEET	0.760"
SIZE OF TUBE HOLE IN BAFFLE	25/32"
PITCH	1 5/16" 30°
TIE ROD O.D.	3/8"
NO. OF TIE RODS	4
TIE ROD HOLE SIZE IN TUBESHEET	7/16" x 1/2" DP. (SEAL WELD)
TIE ROD HOLE SIZE IN BAFFLE	7/16"
SPACER O.D.	5/8"
DUMMY TUBE O.D.	-
NO. OF DUMMY TUBES	-
DUMMY TUBE HOLE SIZE IN BAFFLES	-
O.T.L.	7.5104"
BAFFLE DIA.	7.8560"
BAFFLE CUT ALTERNATES	(26) A-A, (26) B-B

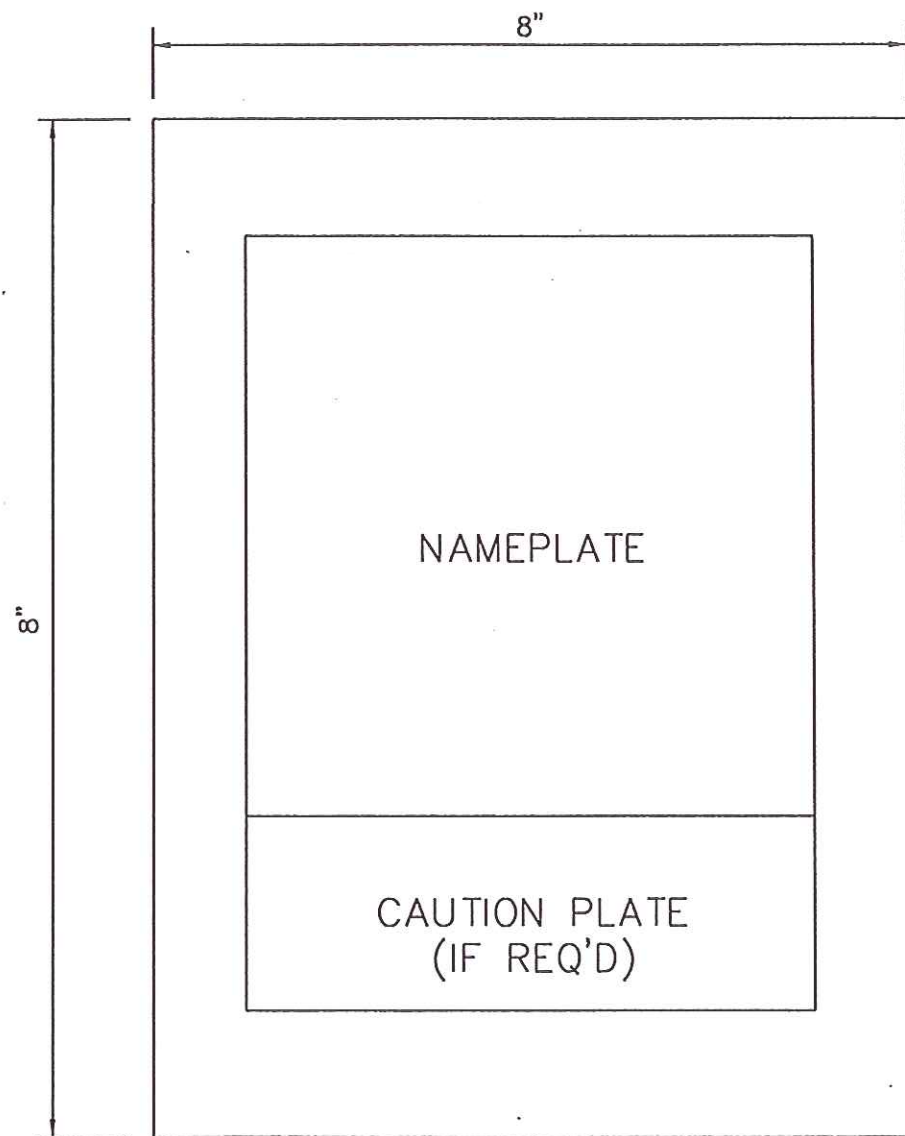
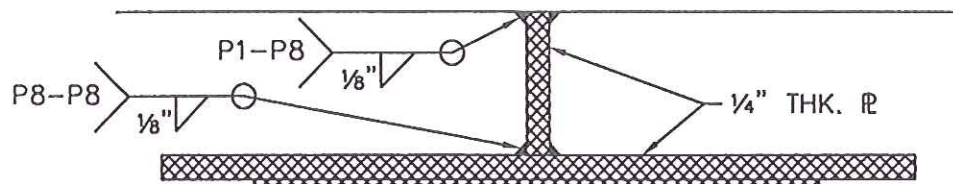


TUBE HOLE DETAIL

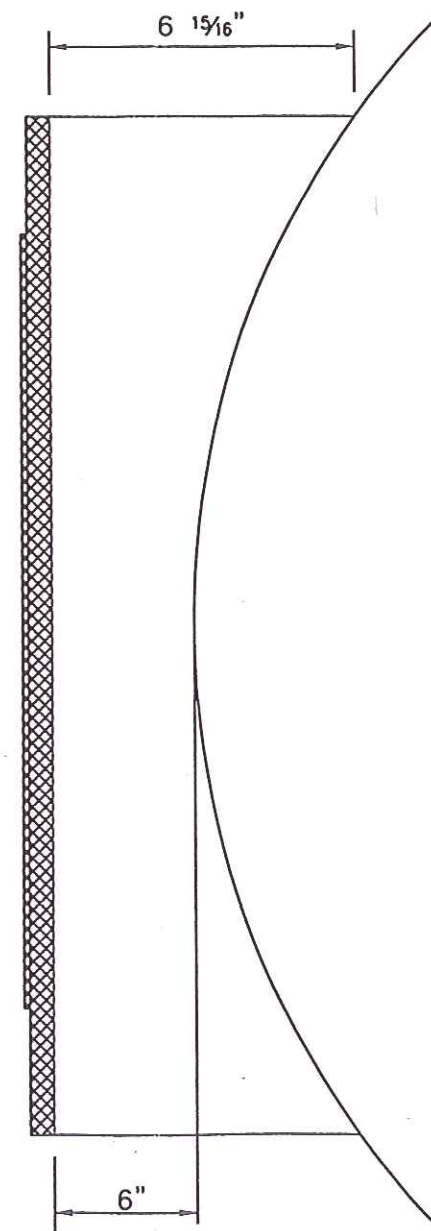
-  C.ST'L
-  316L S.ST'L
-  304 S.ST'L

CERTIFIED	ENG. JDP 9/30/98	
CUSTOMER BAYER CORPORATION		
CUSTOMER P.O. NO. C06F11527		
ITEM NO. 0242-32-298	PROJ. NO. 6192	
PLANT BUSHY PARK, SC		
TEMA SIZE AND TYPE (1) 8-120 BEM OFF SPEC DMAC CONDENSER		
SOUTHERN HEAT EXCHANGER CORP. P.O. BOX 1850 TUSCALOOSA, AL. 35403		
DATE 08/19/98	ORDER NO. 98-250	DWG. NO. SB-3563-1
BY J.D. Crowder		SHEET 4 OF 6

#106381



NAME PLATE DETAIL  
(2 REQ'D)



-  C.ST'L
-  316L S.ST'L
-  304 S.ST'L

<b>EXCHANGER</b>		BAYER CORPORATION PITTSBURGH, PA.		NATIONAL BOARD NO. <b>LATER</b>	
EQUIP. MFR.	SOUTHERN HEAT EXCHANGER CORP.			MFR. S/N	98-250
BAYER P.O. NO.	C06F11527	ORDER DATE	07 29 98	YEAR BUILT	1998
BAYER ASSET NO.	0032260700	SHELL SIDE		TUBE SIDE	
BAYER INSP. STAMP		PRESS.	TEMP.	PRESS.	TEMP.
BAYER ITEM NO.	0242-32-298	188	400	152/F.V.	400
SHELL THKS.	0.322"	MAT'L.S. OF CONST.		C.ST'L	
HEAD THKS.	0.322"/3/8"	TUBE DATA		316L S.ST'L	
NO. OF PASSES	SS/TS : 1/1	NO.	O.D.	B.W.G.	
AREA	88 SQ. FT.	46	0.75"	14	
		SPECIAL NOTES			
		MDMT = 20° F			
		INS. CO. COMMERCIAL UNION			

Bayer Corp.  
OCT 13 1998  
Construction

CERTIFIED	ENG. JDP 9/20/98	
CUSTOMER BAYER CORPORATION		
CUSTOMER P.O. NO. C06F11527		
ITEM NO. 0242-32-298	PROJ. NO. 6192	
PLANT BUSHY PARK, SC		
TEMA SIZE AND TYPE		
(1) 8-120 BEM OFF SPEC DMAC CONDENSER		
SOUTHERN HEAT EXCHANGER CORP.		
P.O. BOX 1850 TUSCALOOSA, AL. 35403		
DATE 08/19/98	ORDER NO. 98-250	DWG. NO. SB-3563-1
BY J.D. Crowder		SHEET 5 OF 6

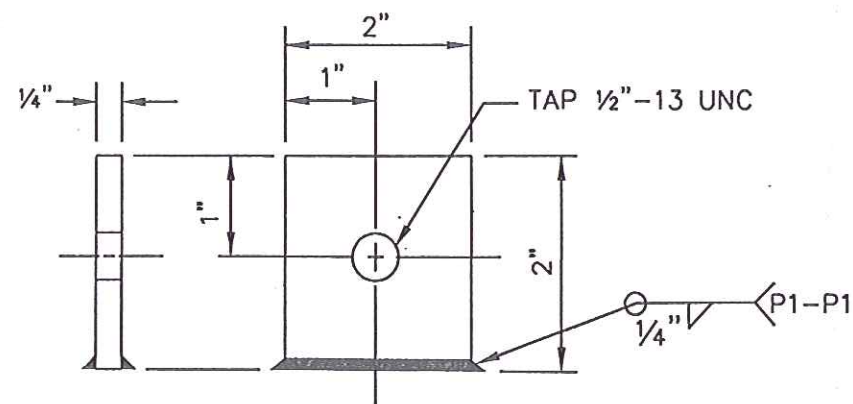
# 106381

JOINT CATEGORY PER UW-3	WELD PROCEDURE	
	ROOT PASS	FILL PASS
A	W-3,W-45,W-97	W-3,W-45
B	W-3,W-45,W-97	W-3,W-45
C	W-3,W-45,W-97	W-3,W-45,W-97
D	W-3,W-45,W-97	W-3,W-45,W-97
TUBE TO TUBESHEET	W-97	
NON-PRESSURE ATTACHMENTS	W-3,W-45/W-2	W-3,W-45/W-2

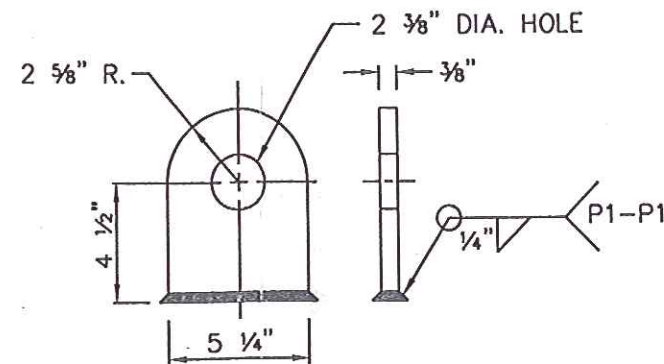
WELD MAP FOR TUBE SIDE

JOINT CATEGORY PER UW-3	WELD PROCEDURE	
	ROOT PASS	FILL PASS
A	N/A	N/A
B	W-42,W-54,W-96	W-42,W-54,W-96
C	W-42,W-54,W-96	W-42,W-54,W-96
D	W-42,W-54,W-96	W-42,W-54,W-96
TUBESHEET TO SHELL	W-2,W-172	W-2,W-172
NON-PRESSURE ATTACHMENTS	W-42,W-54	W-42,W-54

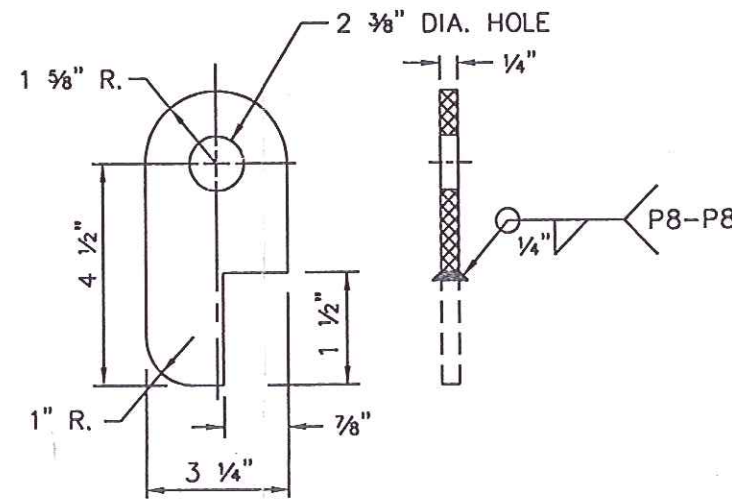
WELD MAP FOR SHELL SIDE



GROUND LUG DETAIL  
(1) REQ'D.

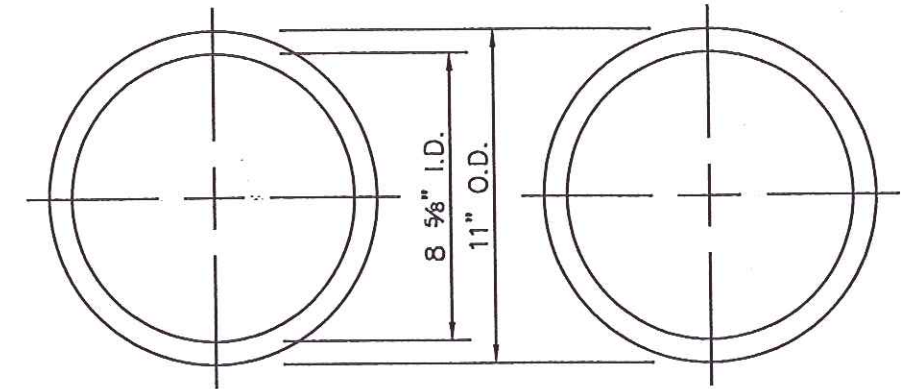
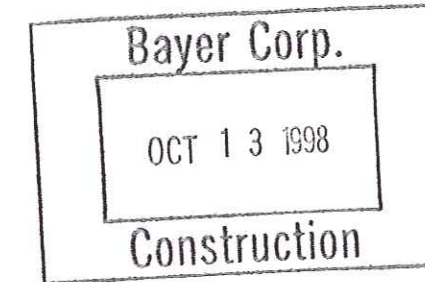


UNIT LIFT LUG DETAIL  
(2) REQ'D.



LIFT LUG DETAIL  
(4) REQ'D.

- C.ST'L
- 316L S.ST'L
- 304 S.ST'L



LEFT BONNET  
(2) REQ'D.

RIGHT BONNET  
(2) REQ'D.

GASKET DETAIL  
(INCLUDES ONE SPARE SET)  
1/16" THK. GARLOCK 3510 GASKET

CERTIFIED	ENG. JDP 9/30/98	
CUSTOMER BAYER CORPORATION		
CUSTOMER P.O. NO. C06F11527		
ITEM NO. 0242-32-298	PROJ. NO. 6192	
PLANT BUSHY PARK, SC		
TEMA SIZE AND TYPE		
(1) 8-120 BEM OFF SPEC DMAC CONDENSER		
SOUTHERN HEAT EXCHANGER CORP.		
P.O. BOX 1850 TUSCALOOSA, AL. 35403		
DATE 08/19/98	ORDER NO. 98-250	DWG. NO. SB-3563-1
BY J.D. Crowder		SHEET 6 OF 6

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