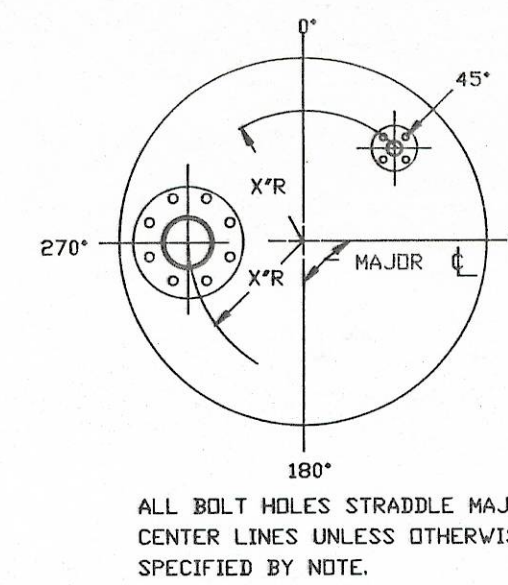


ELEVATION VIEW (NOZZLES ROTATED FOR CLARITY)
SCALE: 1"=1'

CAD REFERENCE NO. RD00077A



ALL BOLT HOLES STRADDLE MAJOR CENTER LINES UNLESS OTHERWISE SPECIFIED BY NOTE.

TRAVELERS - R-2 SHELL - FOR U.S. 66(a) U.S. 20(A), U.S. 11(A)		ASME CODE SPECIFICATION	
Date: 7-77		Approval: [Signature]	
SHELLSIDE OR VESSEL		TUBESIDE OR JACKET SEE NOTE 10	
DESIGN CONDITIONS: 50 PSIG -20 TO 370 °F	30 in HG -20 TO 370 °F	DESIGN CONDITIONS: 150 PSIG -20 TO 370 °F	in HG -20 TO 370 °F
OPERATING CONDITIONS: PSIG	in HG	OPERATING CONDITIONS: PSIG	in HG
CORROSION ALLOWANCE: 0		CORROSION ALLOWANCE: 0	
HYDROSTATIC TEST PRESSURE: 75 PSIG		HYDROSTATIC TEST PRESSURE: 240 PSIG	
RADIOGRAPHY (SEE NOTE 9)		RADIOGRAPHY: NONE	
POST WELD HT.: NONE		POST WELD HT.:	
JOINT EFF. HEAD: 0.65 HEAD TO SHELL 0.70		JOINT EFF. HEAD:	
SHELL: 0.70		SHELL:	
MATERIALS		MATERIALS	
SHELL: SA-240-316L		JKT: SA-312-304	
HEAD: SA-240-316L		HEAD:	
FLANGES: SA-182-316L		FLANGES: SA-182-304	
BOLTING: SA-193-B7		BOLTING: SA-193-B7	
GASKET: TEFLON		GASKET:	
INTERNAL: 316L		INTERNAL:	
SUPPORT: SA-36 C.S.		SUPPORT:	
INSULATION:		INSULATION:	
APPROX. SHIPPING WEIGHT: 13,000 LBS.		APPROX. WEIGHT FULL OF WATER: 28,000 LBS.	

- NOTES:
- ALL NOZZLES TO BE COVERED PRIOR TO SHIPPING VESSEL.
 - THIS VESSEL DESIGNED FOR NON LETHAL SERVICE.
 - 1/8 NPT WEEP HOLES TO BE AT LOWEST POINT WHERE INDICATED.
 - FURNISH CUSTOMER WITH 2 SETS OF MILL TEST REPORTS.
 - REMOVE ALL BURRS, WELDS, SLAG, GREASE AND BREAK SHARP EDGES.
 - PROTECT GASKET SURFACES AND POLISHED MATERIAL SURFACES AT ALL TIMES.
 - BEAD BLAST ALL EXTERIOR SURFACES AND APPLY ONE PRIMER COAT OF CARBOLINE C2-11 TO ALL C.S. SURFACES. APPLY ONE FINISH COAT OF ROSENMUND BLUE TO ALL C.S.
 - NO. 11 CHECK ALL SING. MATERIALS THAT COMES INTO CONTACT WITH CONTENTS.
 9. SPOT X-RAY TOP HEAD AND/OR BOTTOM PLATE IF 2 PIECE IS USED.
 10. THE HEATED FILTER BED CHAMBER IS NOT INCLUDED IN THE CODE STAMPING. DESIGN CONDITIONS: MAX 138 PSI @ 20-30°F, HYDROTEST TO 240 PSI.

CERTIFIED PRINT
By: [Signature] Date: 9/10/82
Dist. Order
Gaston Co. Order
GASTON COUNTY FABRICATION
STANLEY, N.C. 28164

NO. 11 CHECK ALL SING. MATERIALS THAT COMES INTO CONTACT WITH CONTENTS.

9. SPOT X-RAY TOP HEAD AND/OR BOTTOM PLATE IF 2 PIECE IS USED.

10. THE HEATED FILTER BED CHAMBER IS NOT INCLUDED IN THE CODE STAMPING.

NO.	QTY.	SIZE	RATING	TYPE	SCH.	SERVICE/DESCRIPTION
S1-S4	4	1-1/2"	150#	R.F.S.D.	40	BASE HEAT IN/OUT
W	1	19-1/2"	150#			CENTER DISCHARGE
V	1	1"	150#	R.F.S.D.	40	BALANCE LINE
U1-U8	4	1-1/2"	150#	R.F.S.D.	40	FILTRATE OUTLET
T	1	2-1/2"	50#			THERMOWELL
Q	1	2"	150#	R.F.S.D.	40	VENT
P	1	3"	150#	R.F.S.D.	10	JACKET OUTLET
N	1	3"	150#	R.F.S.D.	10	JACKET INLET
M	1	26"	50#			MANWAY
L	1	18"				AGITATOR
K	1	6"	150#	R.F.S.D.	40	VACUUM
J	1	2"	150#	R.F.S.D.	40	SPARE VALVE
I	1	1"	150#	R.F.S.D.	40	BALANCE LINE
H	1	2"	150#	R.F.S.D.	40	SAMPLE
G	1	6"	150#	PAD		SIGHT GLASS ON MANWAY
F2	1	1"	3000#	1/2-DRG		LIGHT CONN
F1	1	1"	3000#	1/2-DRG		LIGHT CONN
E	1	4"	150#	R.F.S.D.	40	SAFETY VALVE
D	1	1"	150#	R.F.S.D.	40	PRESSURE GAUGE
C	1	3"	150#	R.F.S.D.	40	PRODUCT INLET
B	1	1"	150#	R.F.S.D.	40	PRESSURE GAS
A	1	3"	150#	R.F.S.D.	40	SPRAY BALL

CALC ASS'Y No. CA-R6-E

FABRICATION DIVISION NAMEPLATE
Serial No. F-80744-590-1
Size 6in Material SA-240 316L
Customer P.O. No. 00001197
Item No. SC-170

NO.	QTY.	DESCRIPTION	MATERIAL	G.C. PART NO.	DRAWING NO.	QTY./REV.
32	1	TEMPLATE - FILTER CLOTH		3600517	B-3600517	1
31	1	TEMPLATE - SUPPORTING SCREEN		3600516	B-3600516	1
30	1	TEMPLATE - METAL FILTER CLOTH		3600515	B-3600515	1
29	1	TEMPLATE - FILTER CLOTH		3600514	B-3600514	1
28	1	TEMPLATE - SUPPORTING SCREEN		3600513	B-3600513	1
27	1	TEMPLATE - METAL FILTER CLOTH		3600512	B-3600512	1
26	2	O - RING (275°) DIA. X 19-1/4" I.D.	VITON	9120599		2
24	16	NUT, HEX 3/4"NC	SA-194-C 304	0100352		16
23	8	STUD, THRD 3/4"NC X 6-1/2"LG.	SA-193-B5 304	0100062		8
22	8	NUT, HEX 5/8"NC	SA-194-G8 304	0002772		8
21	4	STUD, THRD 5/8"NC X 3-1/2"LG.	SA-193-B8 304	0115470		4
19	1	GASKET, 4-1/8"OD X 2-3/8"ID X 1/8"THK.	TEFLON	9103730		1
17	1	FLANGE, BLIND - 2"-150# ANSI	SA-182-316L	0120480		1
16	1	WASHER, PLAIN - 1/2"	304	6605912		1
15	1	WASHER, LOCK - 1/2"	304	6605937		1
14	1	BOLT, HEX HD 1/2"NC X 1 1/4"	304	6605917		1
13	1	WARNING LABEL	S.S.	7825410		1
12	1	BRACKET, NAMEPLATE - WARNING LABEL	304	1604092	B-1604092	1
11	1	NAMEPLATE, FAB. DIV.	304	7005261		1
9	1	NAMEPLATE, ASSE.	304	7005273		1
8	2	BRACKET, NAMEPLATE	304	1604046	B-1604046	2
7						
6						
5						
4						
3	1	FILTER PLATE 6x5 1/2" SEG. STD., 6m2	B / M	3600442	E-3600442	1
2	1	SHELL & BASE ASSEMBLY	B / M	3600440	E-3600440	1

BILL OF MATERIAL P/N 3600439

REV.	DESCRIPTION	DATE	BY	CHECKED/APPROVED
G				
F				
E				
D	MANWAY NOTE TO VMS 150 PSI	9-9-92	[Signature]	[Signature]
C	ADDED FILTER PLATE TEMPLATES	9/15/90	G.M.	
B	CUSTOMER CHANGES HYDRO PRESS TO 240 PSIG ADD TRAY AND VALVE PART REVISE WITH #9 ADD ONE ASSY NO.	17 JULY 90	R.D.	[Signature]
A	CUSTOMER CHANGES CHANGES BOLTING TO 304, ADDED JOINT EFFICIENCY, REWORKED NOZZLE NIP AL AS	7/5/90	KAL	G.M. 7/10

GASTON COUNTY FABRICATION
A DIVISION OF GASTON COUNTY DYING MACHINE COMPANY
STANLEY, NORTH CAROLINA 28164-2900

SHT. 1 OF 13

This shop drawing is the property of Gaston County Dyeing Machine Company and is not to be used without written permission.

CUSTOMER	ROSENMUND INC. CHARLOTTE, N.C.
TITLE	FINAL ASSEMBLY 6m2 316L
TAG NO.	SC-170
CUSTOMER P.O. NO.	00001197
CUSTOMER ITEM NO.	SC-170
DRAWN BY	GENE MOODY
DATE	7-28-91
CHECKED BY	[Signature]
DATE	9/11/90
SHOP ORDER NO.	F-80744A
NO. REQUIRED	1
SHEET	1 OF 1
SCALE	1"=1'
REV.	No. E-3600439