

**FORM U-1 MANUFACTURER'S DATA REPORT FOR PRESSURE VESSELS**  
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

1. Manufactured and certified by: Precision Stainless, Inc 3300 E. Pythian, Springfield, MO 65802  
(Name and address of Manufacturer)

2. Manufactured for: Polaroid Corporation 3<sup>rd</sup> Floor, 2 Osborne Street Cambridge, MA 02139  
(Name and address of Purchaser)

3. Location of installation: Polaroid Corporation 100 Duchaine Boulevard New Bedford, MA 02745-1295  
(Name and address)

4. Type: Vertical Tank with heat exchanger 980445-1  
(Horiz., vertical., or Sphere) (Tank, separator, jkt. vessel, heat exh., etc.) (Mfg's serial No.)

51600D Rev A 7651 1998  
(CRN) (Drawing No.) (Nat'l Bd. No.) (Year built)

5. ASME Code, Section VIII, Div 1 1995 A-96 Code Case No. Special Service per UG-120(d)  
Edition and Addenda (date)

**# 91697**

**D2034**

Items 6-11 incl. to be completed for single wall vessels, jackets of jacketed vessels, shell of heat exchangers, or chamber of multi-chamber vessels.

6. Shell (a) No. of course(s): 1 (b) Overall length (ft & in): 1' 9-9/16"

No.	Course(s)		Material Spec./Grade or Type	Thickness		Type	Long Joint (Cat. A)			Circum. Joint (Cat. A, B, & C)			Heat Treatment	
	Diameter, in.	Length (ft & in)		Nom.	Corr.		Full, Spot, None	Eff.	Type	Full, Spot, None	Eff.	Temp.	Time	
1	31-1/8" OD	1' 9-9/16"	SA240 304L	.187"	0	1	None	70%	1	None	70%	None	None	

7. Heads: (a) SA240 304L (b) -  
(Mat'l Spec. No., Grade or Type) H.T. - Time & Temp. (Mat'l Spec. No., Grade or Type) H.T. - Time & Temp.

	Location (Top, Bottom, Ends)	Thickness		Radius		Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure		Category A		
		Min.	Corr.	Crown	Knuckle					Convex	Concave	Type	Full, Spot, None	Eff.
(a)	Bottom	.187"	0	-	2"	-	60°	-	-	-	X	1	None	70%
(b)														

If removable, bolts used (describe other fastening) -  
(Mat'l Spec. No., Grade, size, No.)

8. Type of Jacket Open jacket Figure 9 Type 2 Jacket closure Bar  
(Describe as oggee & weld, bar, etc.)

If bar, give dimensions 1/2" x 1/2" If bolted, describe or sketch.

9. MAWP 100 psi at max. temp. 325 325 ° F Min. design metal temp. -20 ° F at 100 psi  
(internal) (external) (internal) (external)

10. Impact test No  
(indicate yes or no and the component(s) impact tested)

11. Hydro., pneu., or comb. Test press. 167 Proof test -

Items 12 and 13 to be completed for tube sections

12. Tubesheet: Stationary (Mat'l Spec. No.) Dia., in. (subject to press.) - Nom. thk., in. - Corr. Allow., in. - Attachment (welded or bolted) -

Floating (Mat'l Spec. No.) Dia., in. - Nom. Thk., in. - Corr Allow., in. - Attachment -

13. Tubes: Mat'l Spec. No., Grade or Type O.D., in. - Nom. Thk., in. or gauge - Number - Type (Straight or U) -

Items 14-18 incl. To be complete for inner chambers of jacketed vessels or channels of heat exchangers

14. Shell (a) No. of course(s) 1 (b) Overall length (ft & in.) 1' 11-3/4"

No.	Course(s)		Material Spec./Grade or Type	Thickness		Type	Long Joint (Cat. A)			Circum. Joint (Cat. A, B, & C)			Heat Treatment	
	Diameter, in.	Length (ft & in)		Nom.	Corr.		Full, Spot, None	Eff.	Type	Full, Spot, None	Eff.	Temp.	Time	
1	29-1/2" ID	1' 11-3/4"	SA240 316L	.312"	0	1	None	70%	1	None	70%	None	None	

15. Heads: (a) - (b) SA240 316L  
(Mat'l Spec. No., Grade or Type) H T - Time & Temp. (Mat'l Spec. No., Grade or Type) H T - Time & Temp.

	Location (Top, Bottom, Ends)	Thickness		Radius		Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure		Category A		
		Min.	Corr.	Crown	Knuckle					Convex	Concave	Type	Full, Spot, None	Eff.
(a)														
(b)	Bottom	.311"	0	-	2"	-	60°	-	-	X	-	1	None	70%

If removable, bolts used (describe other fastening) -  
(Mat'l Spec. No., Grade, size, No.)

16. MAWP \_\_\_\_\_ psi at max. temp. \_\_\_\_\_ ° F. Min. design metal temp. \_\_\_\_\_ ° F. at \_\_\_\_\_ psi.  
 (Internal) (External) (Internal) (External)

17. Impact Test No  
 (Indicate yes or no and the component(s) impact tested)

18. Hydro., ~~pneu.~~ or ~~comb.~~ Test press. \_\_\_\_\_ Proof Test \_\_\_\_\_

19. Nozzles, inspection, and safety valve openings:

Purpose, (Inlet, Outlet, Drain, etc.)	No.	Diameter or Size	Flange Type	Material		Nozzle Thickness		Reinforcement Material	How Attached		Location (Insp. Open)
				Nozzle	Flange	Nom.	Corr.		Nozzle	Flange	
Inlet	1	1.5"	-	SA182 304L	-	3000#	0	-	UW16.1(C)	-	HTS
Outlet	1	1.5"	-	SA182 304L	-	3000#	0	-	UW16.1(C)	-	HTS
RV Conn	1	1.5"	-	SA182 304L	-	3000#	0	-	UW16.1(C)	-	HTS
Vent	1	.75"	-	SA182 304L	-	3000#	0	-	UW16.1(C)	-	HTS
Drain	1	.5"	-	SA182 304L	-	3000#	0	-	UW16.1(C)	-	HTS

20. Supports: Skirt No Lugs: 4 Legs: \_\_\_\_\_ Others: \_\_\_\_\_ Attached: Shell - weld  
 (Yes or No) (No.) (No.) (Describe) (Where and how)

21. Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report:  
 (List the name of part, item number, mfg's. name and identifying number)

22. Remarks: 80 gallon non-code tank with a code stamped open jacket Figure 9, Type 2 heat transfer, steam and water is the heating and cooling medium. Customer to install suitable pressure and/or vacuum relief valves, exempt from impact testing per UHA-51 d1a and e2a. Hydro test in vertical position.

**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. 24003 Expires: April 6 2001

Date: 8-13-98 Name: Precision Stainless, Inc. Signed: Douglas W. Morgan  
 (Manufacturer) (Representative)

**CERTIFICATE OF SHOP INSPECTION**

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 MO and employed by Commercial Union Insurance Company of Boston, MA have inspected the pressure vessel described in this Manufacturer's Data Report on 7/29, 19 98 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: 8/13/98 Signed: E. J. Savine Commissions: NB 7376 "A"  
 (Authorized Inspector) (Nat'l Board incl. Endorsement, State, Province and No.)

**CERTIFICATE OF FIELD ASSEMBLY COMPLIANCE**

We certify that the statements on this report are correct and that the field assembly construction of all parts of this vessel conforms with the requirements of ASME Code, Section VIII, Division 1.

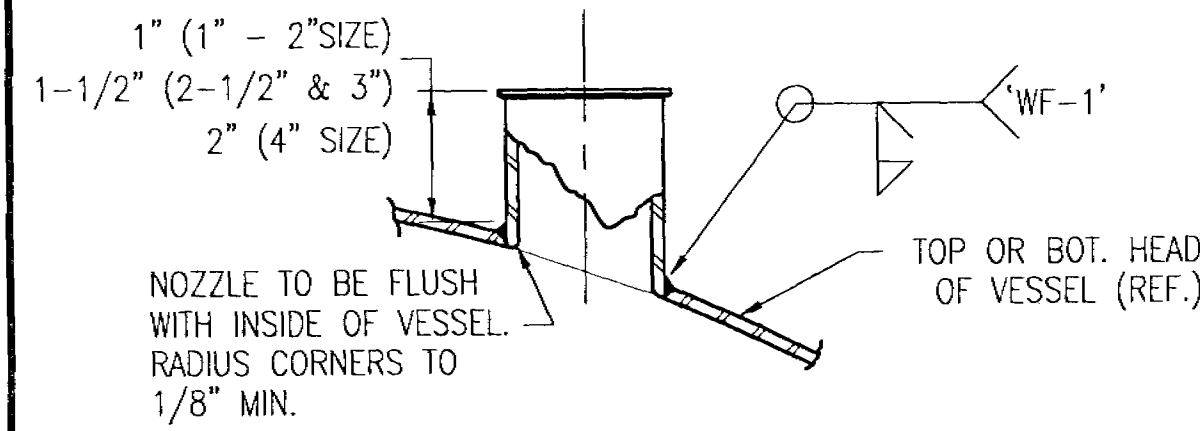
U Certificate of Authorization No. \_\_\_\_\_ Expires: \_\_\_\_\_ 19 \_\_\_\_\_

Date: \_\_\_\_\_ Name: \_\_\_\_\_ Signed: \_\_\_\_\_  
 (Assembler) (Representative)

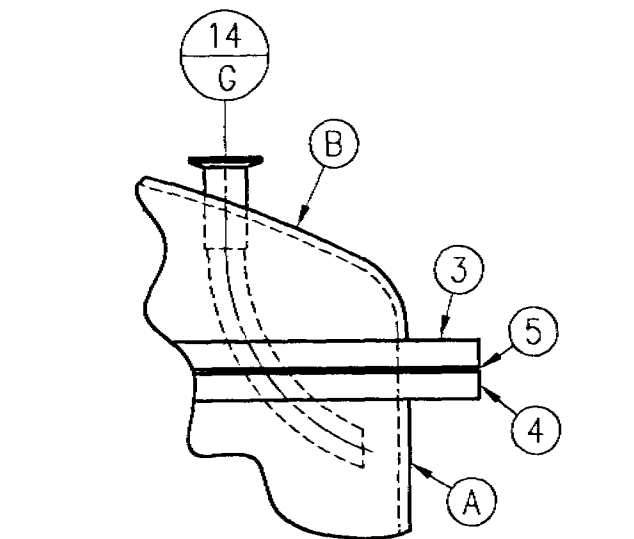
**CERTIFICATE OF FIELD ASSEMBLY INSPECTION**

I undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of \_\_\_\_\_ and employed by \_\_\_\_\_ of \_\_\_\_\_ have compared the statements in this Manufacturer's Data Report with the described pressure vessel and state that parts referred to as data items \_\_\_\_\_ not included in the certificate of shop inspection, have been inspected by me and to the best of my knowledge and belief, the Manufacturer has constructed and assembled this pressure vessel in accordance with ASME Code, Section VIII, Division 1. The described vessel was inspected and subjected to a hydrostatic test of \_\_\_\_\_ psi. 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.

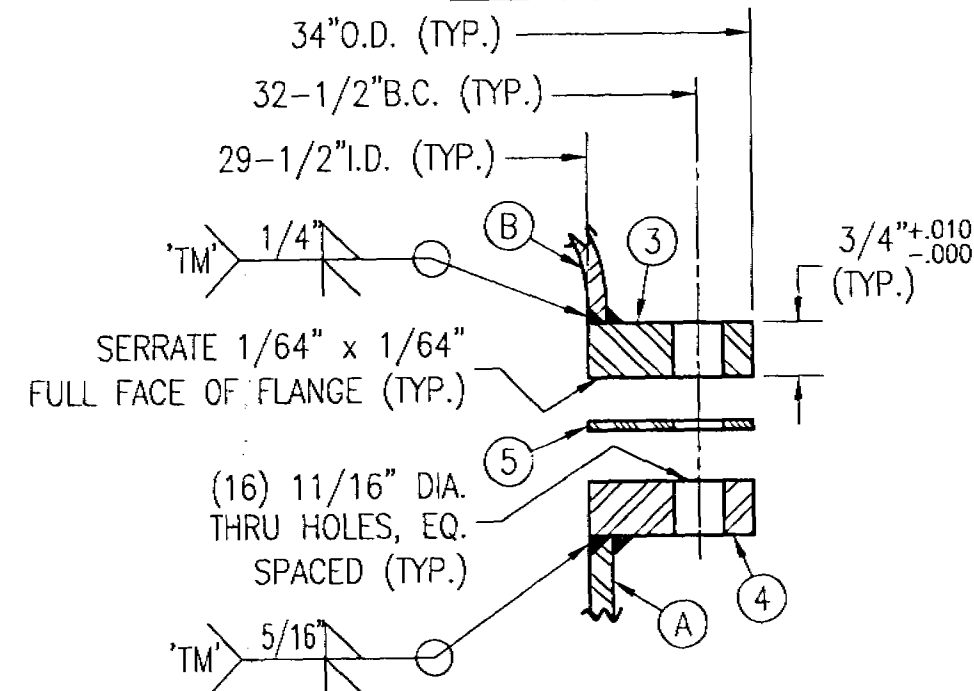
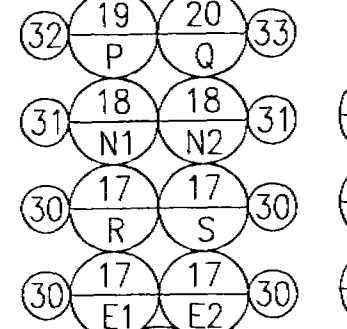
Date: \_\_\_\_\_ Signed: \_\_\_\_\_ Commissions: \_\_\_\_\_  
 (Authorized Inspector) (Nat'l Board incl. endorsement, State, Province and No.)



**FERRULE WELDMENT DETAIL (TYP)**



**AUXILIARY VIEW**  
(SEE PLAN VIEW FOR TRUE ORIENTATION)



**DETAIL A**  
SCALE: 3/8"=1"

NOZZLE SCHEDULE

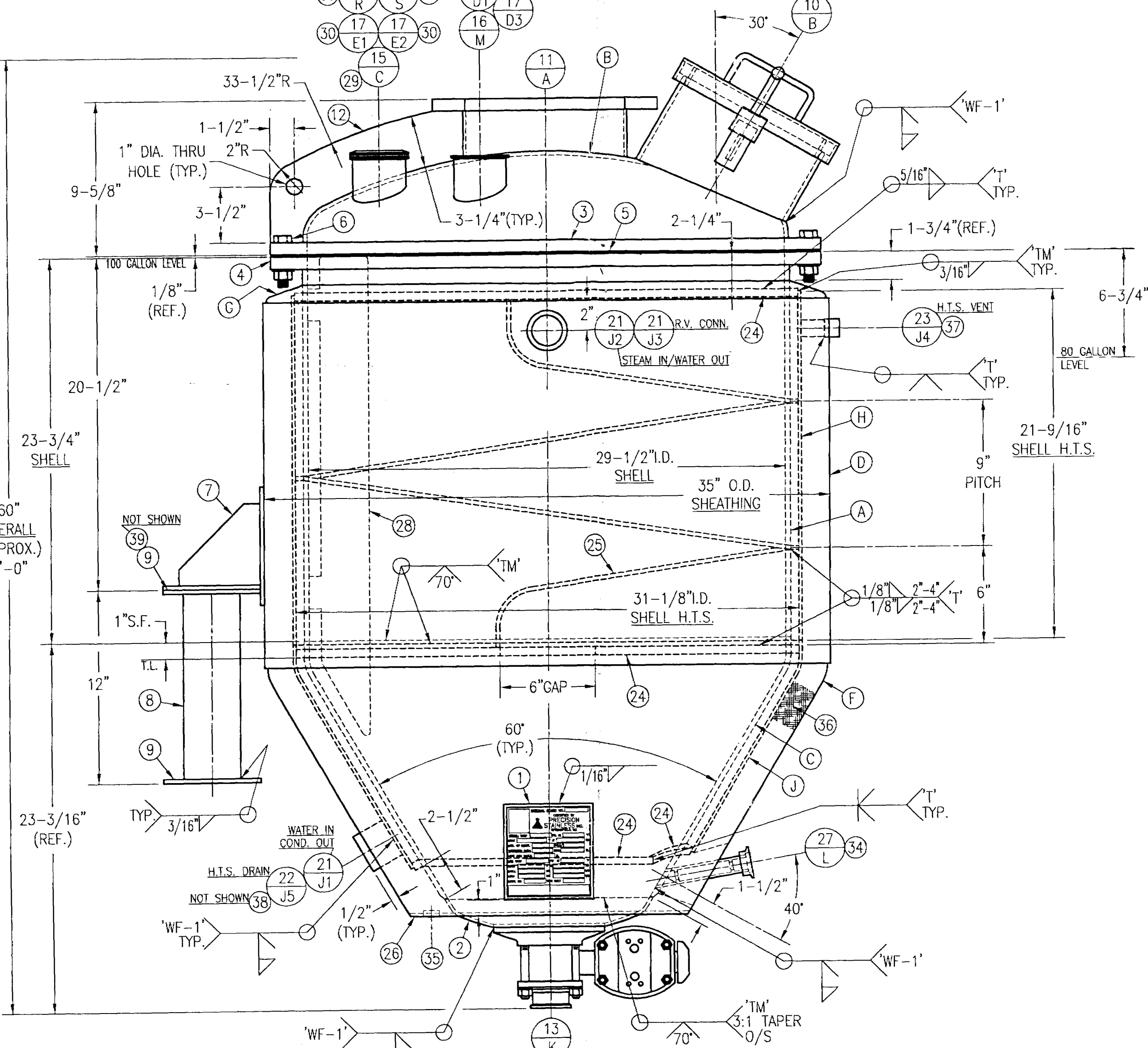
ITEM	SIZE	TYPE	SERVICE
A	9-7/8"	SO. FLANGE	AGITATOR
B	10x15	MANWAY	CHARGEPOINT
C	4"	FERRULE	SPARE w/CAP
D1,D2,D3	2-1/2"	FERRULE	SPRAY CONN.
E1,E2	2-1/2"	FERRULE	SPARE w/CAP
F	2"	FERRULE	VENT
G	1"	FERRULE	NO-FOAM INLET
H	1"	FERRULE	INLET
J1	1-1/2"	FNPT	H.T.S. INLET
J2	1-1/2"	FNPT	H.T.S. OUTLET
J3	1-1/2"	FNPT	R.V. CONN.
J4	1/2"	FNPT	VENT
J5	3/4"	FNPT	DRAIN
K	2"	FLUSH MOUNT	OUTLET VALVE
L	1"	CLAMP-TYPE	THERMOWELL
M	3"	FERRULE	INLET
N1,N2	2"	FERRULE	SPARE w/CAP
P	1-1/2"	FERRULE	SPARE w/CAP
Q	1"	FERRULE	SPARE w/CAP
R	2-1/2"	FERRULE	SPARE w/CAP
S	2-1/2"	FERRULE	SPARE w/CAP

- NOTES: (CONT'D)
- ASME MATERIAL AND WELDING, NOT "U" STAMPED VESSEL, LESS MANWAY, IS DESIGNED FOR 15 PSIG.
  - WELDING PROCEDURE IN ACCORDANCE WITH ASME CODE UW-28, SHALL CONFORM TO THE FOLLOWING SPECIFICATIONS:  
 T = 08080114-01  
 A1 = 08080121-01  
 M = 08080116-02  
 M = 08080134-01
  - WELDING TO BE PER PRECISION STAINLESS DRAWING NO. S00274-C FULL PENETRATION WELDING IS REQUIRED. NO BACK-UP STRIPS ARE TO BE USED ON VESSEL WELD SEAMS.
  - ALL WELDING TO BE DONE BY ASME CERTIFIED WELDERS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ASME PRESSURE VESSEL CODE, SECTION VIII.
  - VESSEL TO BE HYDROSTATICALLY TESTED BY FILLING WITH WATER & MAINTAINING A CONSTANT LEVEL FOR A PERIOD OF (2) HOURS.
  - HEAT TRANSFER SURFACE DESIGNED IN ACCORDANCE WITH THE LATEST EDITION OF THE "ASME" BOILER AND PRESSURE VESSEL CODE, SECTION VIII, DIVISION 1, 1995, ADDENDA A-96.
  - H.T.S. TO BE HYDROSTATICALLY TESTED FOR (2) HOURS. CHECK FOR DEFECTS, REPAIR & RE-TEST IF NECESSARY. SEE DWG. S00289-B FOR HYDROTEST PROCEDURE.
  - ALL PRESSURE BEARING WELDS TO BE DYE PENETRATE TESTED USING (RED) DYE.
  - VESSEL DESIGNED FOR SEISMIC ZONE: 2A
  - PRODUCT SPECIFIC GRAVITY: 1.2
  - CUSTOMER TO FURNISH AGITATOR SPECS:  
 DOWNWARD LOAD \_\_\_\_\_ LBS.  
 TORQUE \_\_\_\_\_ IN.LB.  
 BENDING MOMENT \_\_\_\_\_
  - ELECTROPOLISH COMPLETE INTERIOR OF VESSEL INCLUDING NOZZLES.
  - VESSEL WEIGHT:  
 EMPTY \_\_\_\_\_ 1,375 lbs.  
 FILLED w/ WATER TO 100 GAL. LEVEL \_\_\_\_\_ 2,210 lbs.
  - UPON COMPLETION OF TANK, ALL INTERNAL & EXTERNAL SURFACES ARE TO BE THOROUGHLY CLEANED AND PASSIVATED. UPON COMPLETION OF PASSIVATION, ALL SURFACES ARE TO BE THOROUGHLY WASHED WITH 140°F DEIONIZED WATER.
  - ADD THE FOLLOWING ADDITIONAL INFORMATION TO DATA PLATE:  
 CAPACITY & EMPTY WEIGHT, POLAROID EQUIPMENT NO.
  - H.T.S. FLOWRATE = 30 GPM WITH A MAX. PRESSURE DROP OF 10 PSIG (MEDIA = WATER @ 70°).

CUST. NO.	ITEM NO.	NO. REQ'D.	PART NO. (or) DRAWING NO.	DESCRIPTION
	1	1	90085-2A	PRECISION STAINLESS ASME DATA PLATE (NOTE 22)
	2	1		LOW. BOT. HEAD, 7 GA., 316LS/S (SA-240), 12-1/4"ID, 14"IDR, 1"KR, 11/16"SF, 2-1/8"RID (STRAIGHT FLANGE TO BE FLARED TO 60° INC. ANG. & 12-11/16"ID)
	3	1	DETAIL A	TOP HEAD FLANGE, 1"PL., 316LS/S (SA-240)
	4	1	DETAIL A	SHELL FLANGE, 1"PL., 316LS/S (SA-240)
	5	1	DETAIL A	GASKET, 1/8"THK., EPDM, 29-1/2"ID x 34"OD w/BOLT HOLES TO MATCH ITEM #3 & 4
	6	16		H.H. CAPSCREW, 5/8"-11NC x 2-1/2"LG., 304S/S (SA-193, Gr.B8), w/ HEXNUT, MONEL 400 (SB-164) & 18-8S/S LOCKWASHER
	7	4	51602-D	SUPPORT LUG ASSY, 3/8"PL. GUSSETS, 1/4"PL. BASE & DOUBLER, ALL 304S/S
	8	4		LEG, 3" SCH.40 PIPE, 304S/S
	9	8	51602-D	FLOOR PLATE, 1/4"PL., 304S/S
B	10	1	M00897-D	MANWAY ASSY, 10" x 15"-(1) LUG, COVER = 7 GA., COLLAR = 1/4"PL., 316LS/S (SA-240), w/ HINGE, HANDLE & EPDM GASKET (6"SHORT SIDE COLLAR HT.)
A	11	1	51602-D	AGITATOR FLANGE ASSY., 7 GA., w/ 3/4"THK. FLANGE, ALL 316LS/S (SA-240)
	12	4		GUSSET, 3/8"PL., 304S/S (SA-240)
K	13	1		OUTLET VALVE, 2"SIZE, FLUSH TANK, "PBM", #2"-FI-H-HL-37-TT-3/F0-A3-5P, CLAMP TYPE CONN., 316LS/S (SA-479), w/VITE SEAT, SEAL & PACK. MAT'L, INT. FINISH= 8-10 Ra, ACTUATOR, "WORCESTER" #2039-SN, w/ SPRING RETURN & SWITCH, "GH BETTIS" #3R-021-AFC, DIRECT COUPLED w/ 2-SPOT SWITCH. ELEMENTS
C	14	1	51602-D	NO-FOAM INLET, 1"CLAMP-TYPE, 316LS/S (SA-479) (AUX. VIEW)
C	15	1	S00166-B	FERRULE, 4"CLAMP-TYPE, 316LS/S (SA-479)
M	16	1	S00166-B	FERRULE, 3"CLAMP-TYPE, 316LS/S (SA-479)
D1,D2,D3	17	7	S00166-B	FERRULE, 2-1/2"CLAMP-TYPE, 316LS/S (SA-312)
N1,N2	18	2	S00166-B	FERRULE, 2"CLAMP-TYPE, 316LS/S (SA-479)
P	19	1	S00166-B	FERRULE, 1-1/2"CLAMP-TYPE, 316LS/S (SA-479)
H,Q	20	2	S00166-B	FERRULE, 1"CLAMP-TYPE, 316LS/S (SA-479)
J1,J2,J3	21	3		FULL COUPLING, 1-1/2"-3000# ANSI, 304LS/S (SA-182)
J5	22	1		HALF COUPLING, 3/4"-3000# ANSI, 304LS/S (SA-182)
J4	23	1		HALF COUPLING, 1/2"-3000# ANSI, 304LS/S (SA-182)
	24	4		CLOSURE BAR, 1/2"SQ. BAR, 304LS/S (SA-479)
	25	1		SPIRAL BAFFLE, 1/4" x 1/2"FLAT BAR, 304LS/S (SA-479)
	26	1		CLOSURE RING, 7 GA., 304S/S (SA-240), 12"ID x 17"OD
L	27	1	51602-D	THERMOWELL ASSY., 1"CLAMP-TYPE w/ 3/4"SCH. 80 PIPE, 316LS/S (SA-312), TEFLON INSERT & VITON O-RINGS
	28	2	51602-D	BAFFLE, 1/4"PL., 316LS/S (SA-240)
	29	1	"TRI-CLOVER"	CAP, 316LS/S, #16AMP w/ CLAMP, S/S, #13MHM & GASKET, EPDM, #40MP-E, ALL 4"SIZE
	30	4	"TRI-CLOVER"	CAP, 316LS/S, #16AMP w/ CLAMP, S/S, #13MHM & GASKET, EPDM, #40MP-E, ALL 2-1/2"SIZE

- NOTES
- FLANGE BOLT HOLES TO STRADDLE MAJOR VERTICAL AND HORIZONTAL VESSEL CENTERLINE UNLESS INDICATED OTHERWISE.
  - THE CORROSION RESISTANCE OF THE EQUIPMENT IS NOT THE RESPONSIBILITY OF PRECISION STAINLESS, INC. WITH OUR WRITTEN ACCEPTANCE BASED ON A SPECIFIC SERVICE.
  - SUITABLE PRESSURE AND/OR VACUUM RELIEF VALVE(S) MUST BE INSTALLED BY CUSTOMER FOR VESSEL AND/OR HEAT TRANSFER SURFACE OPERATION.
  - PRODUCTION TO PROVIDE PROTECTION FOR ALL NOZZLES AND FITTINGS PRIOR TO SHIPMENT. VESSEL MUST BE ADEQUATELY VENTED.
  - WELD SEAMS IN VESSEL HEAD AND SHELL SHOULD BE LOCATED, WHERE POSSIBLE, TO AVOID ALL NOZZLES, ACCESS OPENINGS, AND REINFORCEMENT PADS.
  - 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.
  - TOLERANCES PER PRECISION STAINLESS DRAWING NO. S00264-B

MATERIAL	FINISH
(A) Shell: 5/16"PL., 316LS/S (SA-240)	240EP/HRAP
(B) Head, Top: 1/4"PL., 316LS/S (SA-240)	240CP/150
(C) Head, Bottom: 5/16"PL., 316LS/S (SA-240)	240EP/HRAP
(D) Shell: 5/16"PL., 316LS/S (SA-240)	240EP/HRAP
(E) Head, Top: 7 GA., 304S/S	2B/150
(F) Outer Head, Bottom: 7 GA., 304S/S	2B/150
(G) TORICONICAL: 3/4-5/8"OD x 11-1/2"ID, 80NC, ANG. 2"KR, 1"SF, 16-1/8"ID	
(H) Breast Ring: 7 GA., 304S/S (SA-240)	2B/150
(I) Heat Transfer Surface (DWG #S00178-C)	TEST PLATE NO
(J) Shell: 5/16"PL., 316LS/S (SA-240)	SEE CALC'S
(K) Head: 5/16"PL., 316LS/S (SA-240)	SEE CALC'S
(L) Head: 5/16"PL., 316LS/S (SA-240)	SEE CALC'S
(M) Head: 5/16"PL., 316LS/S (SA-240)	SEE CALC'S
(N) Head: 5/16"PL., 316LS/S (SA-240)	SEE CALC'S
(O) Head: 5/16"PL., 316LS/S (SA-240)	SEE CALC'S
(P) Head: 5/16"PL., 316LS/S (SA-240)	SEE CALC'S
(Q) Head: 5/16"PL., 316LS/S (SA-240)	SEE CALC'S
(R) Head: 5/16"PL., 316LS/S (SA-240)	SEE CALC'S
(S) Head: 5/16"PL., 316LS/S (SA-240)	SEE CALC'S

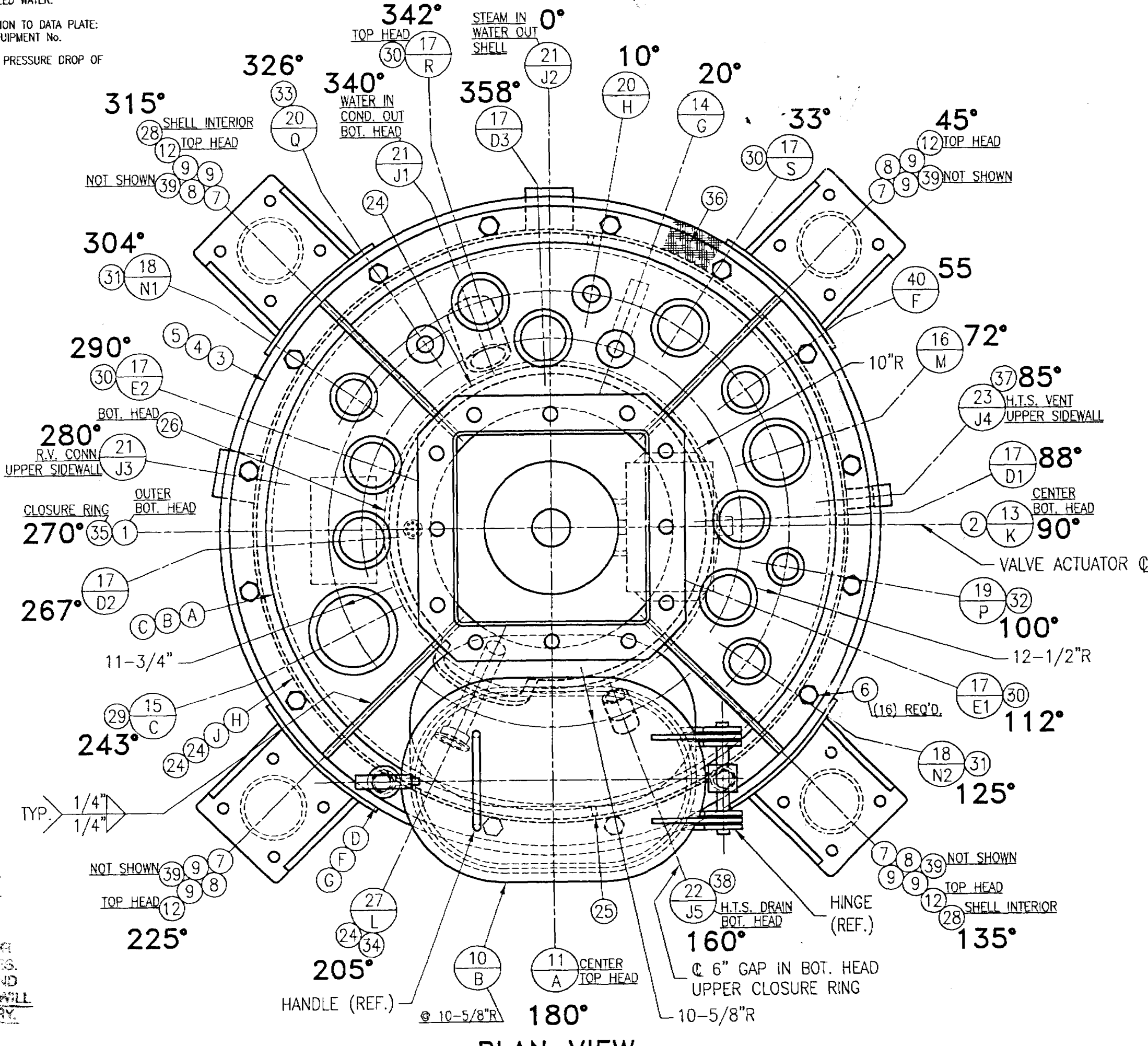


**ELEVATION VIEW**  
(SEE PLAN VIEW FOR TRUE ORIENTATION)

TANK MUST DRAIN COMPLETELY!

CERTIFIED PRINT  
 PRECISION STAINLESS, INC.  
 DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED.  
 DIMENSIONS ARE APPROVED AND CONFIRMED. ALL DIMENSIONS WILL BE WITHIN TOLERANCES AND DELIVERED.

C. Knight MAY 06 1998



**PLAN VIEW**

SPECIFICATIONS	VESSEL	HEAT TRANSFER SURFACE
ASME Code Sec.VIII Div.1	NO (NOTE 8)	YES
Insp. and Stamp	NO	YES
Min/Max Design Temp F	-20/+325	-20/+325
Max Design Press (PSIG)	ATMOS/(NOTE 8)	100
Corrosion Allowance (Inch)	0	0
Hydrostatic Test PSIG	0 (NOTE 12 & 15)	167
Hydro Test Position (Hor/Vert)	Vertical	Vertical
Vacuum Design PSIG	N/A	N/A
Heating Medium		STEAM
Cooling Medium		WATER
Top Head	None	Top Head/Shell Seam
Bot. Head	None	Bot. Head/Shell Seam
Shell (Circ.)	None	Shell (Long.)
Other (Specify):	None	None

EST. EMPTY WEIGHT: (NOTE 20) LBS.	
Scale 3/16" = 1"	Drawing Is Not To Be Scaled
Drawn B. Wright	3-10-98
Checked B. Knight	3-27-98
Approved C. Knight	5-6-98
Des. Eng. Approved J. Knight	5-6-98 (PS-1809)
Customer POLAROID CORPORATION	
Address NEW BEDFORD, MASSACHUSETTS	
Customer Order No. 6100007544	

**80 GALLON MAKE-UP TANK**  
 EQUIP. No.: D-2034-NB-B  
 # 91697

SHIP TO: POLAROID CORPORATION  
 NEW BEDFORD, MASSACHUSETTS

QUANTITY REQ'D. (1) ONE

PRECISION STAINLESS  
 3300 East Pyburn  
 Springfield, MA 01104  
 (477) 865-2990

WORK ORDER NO.	DRAWING NO.
W-980445-1	51600-D

DRAWING NO. 51600-D

REVISED PER CUST. PRINT DATED 4-9-98 & C.O. #1 DATED 4-14-98	REV'D BY	CHECKED BY
5/1/98		