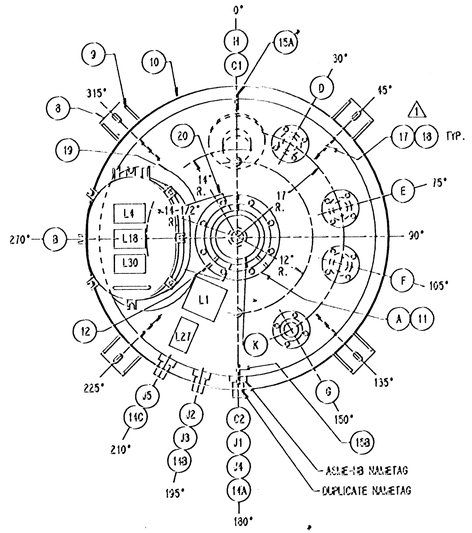
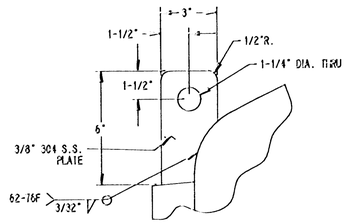
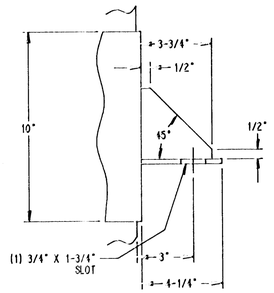


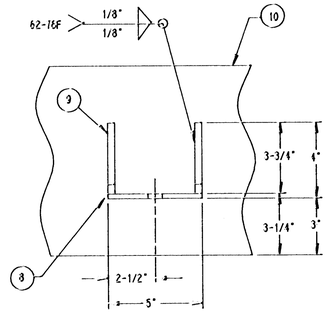
PLAN VIEW OF VESSEL
(1"=1'0")

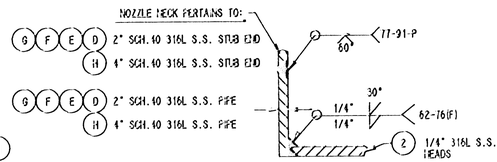


LIFT LUG DETAIL
(1/4"=1")

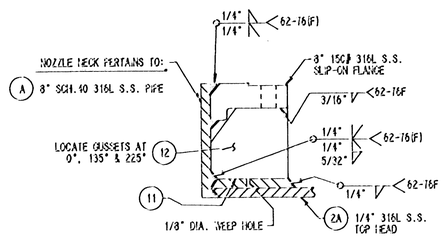


SUPPORT LUG DETAIL
(1/4"=1")

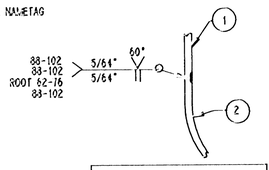




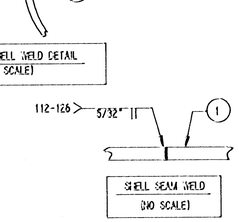
WELD DETAIL FOR FITTINGS D E F G H
(NO SCALE)



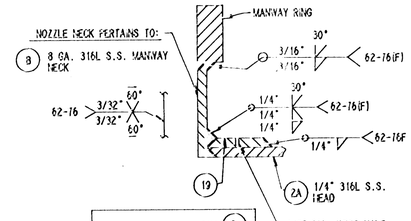
WELD DETAIL FOR FITTING A
(NO SCALE)



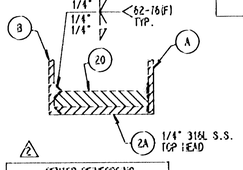
HEAD TO SHELL WELD DETAIL
(NO SCALE)



SHELL SEAM WELD
(NO SCALE)



WELD DETAIL FOR FITTING B
(NO SCALE)



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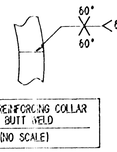

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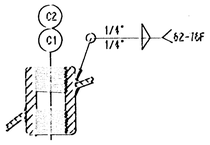

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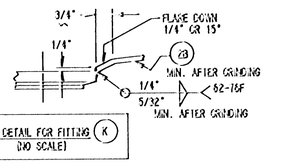

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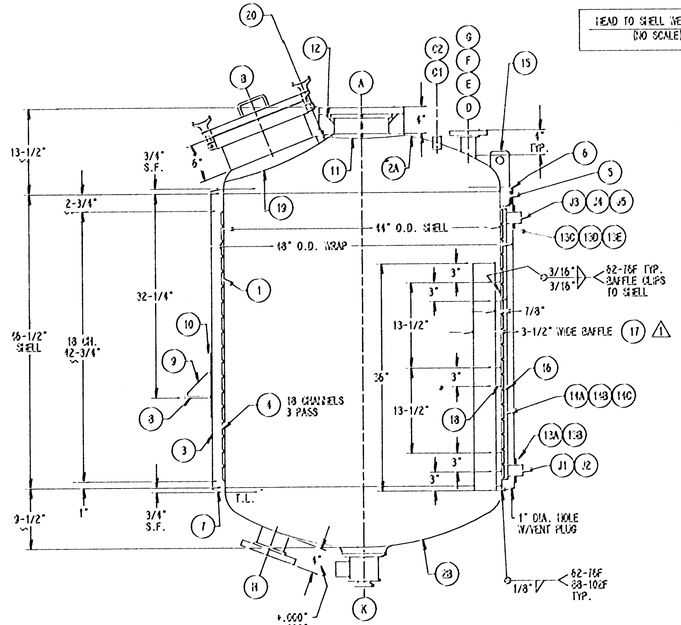
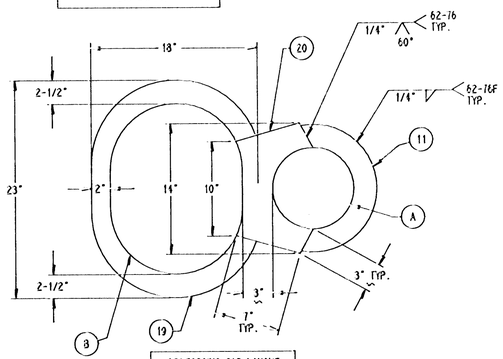


ELEVATION VIEW OF VESSEL
(1"=1'0")



REINFORCING PAD LAYOUT FOR FITTINGS "A" & "B"
(1/8"=1")

WARRANTY

Walker Stainless Equipment Co. warrants new tanks or equipment manufactured by us to be free from defects in material and workmanship under normal use and service for a period of 1 year after shipment from the factory.

For breach of warranty of any kind, the measure of damages to be recoverable from Walker Stainless Equipment Co. shall be limited to repair or replacement of the part or equipment which examination discloses to the satisfaction of seller to be defective, or the payment of the price or making such repair or replacement, at the option of the seller.

This warranty is expressly in lieu of all other warranties, expressed or implied, and all other obligations and liabilities on our part. Any warranty of merchantability is expressly excluded. We neither assume nor authorize any other persons to assume for us any liability in connection with the sale of our products, and no other warranty will be honored unless in writing and signed by an officer of the corporation. This warranty shall not apply to any product of our manufacture which has been repaired or altered outside our factory, or which in our opinion, has been subject to misuse, negligence or accident. Seller will not assume any charges for repairs made during warranty by anyone other than Walker Stainless. Also seller assumes no liability or responsibility for transportation to and from repair point, nor any loss of time due to repair. This warranty does not cover components of other manufacturers beyond such warranty as is made by such manufacturer.

Any action for breach of warranty shall be commenced within one (1) year of said breach or be forever barred.

All information including design details and dimensions contained hereon are confidential and proprietary and must not be reproduced, disclosed to others, or used in the production of parts shown, unless authorized in writing by Walker Stainless Equipment Company.

NOTES

1. Dimensions, unless otherwise indicated are nominal and standard shop tolerances are to be expected. Measurements for any field attachments should be verified on site by others before fabrication of the attachments.

2. If used in contact with materials containing salt, chlorides or other corrosive materials, the corrosion resistance of this equipment is not the responsibility of Walker Stainless Equipment Company.

MATERIAL SCHEDULE

ITEM	QTY.	SIZE/THICK	MATERIAL	DESCRIPTION	HEAT #
1	1	7 GA.	316L S.S.	INNER SHELL	
2	2	1/4"	316L S.S.	HEADS (F & D) 40" O.R. - 4" K.R. - 3/4" S.F.	
3	1	10 GA.	304 S.S.	OUTER WRAP /3	
4	1	16 GA.	304L S.S.	HEAT EXCHANGE SURFACE (CHANNEL)	
5	1	1-1/2"	INSWOOL	INSULATION /3	
6	1	1/4"	304 S.S.	TOP BREAST RING /3	
7	1	10 GA.	304 S.S.	BOTTOM BREAST RING /3	
8	4	1/4" X 5" X 4-1/4"	304 S.S.	SUPPORT LUG BASE /3	
9	8	3/8"	304 S.S.	SUPPORT GUSSETS	
10	1	10 GA. X 10" WIDE	304 S.S.	SUPPORT LUG TO OUTER WRAP BAND	
11	1	1/4" MIN. X 13-1/2" O.D.	304 S.S.	REINFORCING PAD FOR FITTING "A"	
12	3	1/4"	304 S.S.	REINFORCING GUSSETS FOR FITTING "A"	
13	5	14 GA.	304 S.S.	ESCUTCHEONS	
14	3	10 GA.	304L S.S.	SIDE HEADERS /3	
15	2	3/8"	304 S.S.	LIFT LUGS PER DETAIL	
16	2	12 GA.	304L S.S.	PASS BAFFLE	
17	4	1/4" MIN. X 3-1/2" WIDE X 36" LONG	316L S.S.	BAFFLES /1	
18	12	1/4" MIN. X 3" X 7/8"	316L S.S.	BAFFLE CLIPS /1	
19	1	1/4" MIN. X 23" O.D. X 18" O.D.	304 S.S.	MANWAY REINFORCING COLLAR /2	
20	1	1/2" MIN. X 14" X 7"	304 S.S.	REINFORCING COLLAR BETWEEN MANWAY & FITTING "A"	/2

NOZZLE SCHEDULE

ITEM	QTY	MATERIAL STUB	MATERIAL FLANGE	SIZE	RATE	DESCRIPTION
A	1	SCH.40 316L S.S.	316L S.S.	8" IPS	150#	SLIP-ON FLANGE (AGITATOR)
B	1	8 GA. 316L S.S.	316L S.S.	14" X 18"	150#	MANWAY W/RINGE & (8) SWING BOLTS
C	2	316L S.S.		3/4" TPT	3000#	FULL COUPLING (SPRAYBALL)
D	1	SCH.40 316L S.S.	304 S.S.	2" IPS	150#	LAP JOINT FLANGE W/BLIND (SPARE)
E	1	SCH.40 316L S.S.	304 S.S.	2" IPS	150#	LAP JOINT FLANGE W/BLIND (SPARE)
F	1	SCH.40 316L S.S.	304 S.S.	2" IPS	150#	LAP JOINT FLANGE W/BLIND (SPARE)
G	1	SCH.40 316L S.S.	304 S.S.	2" IPS	150#	LAP JOINT FLANGE (VENT)
H	1	SCH.40 316L S.S.	304 S.S.	4" IPS	150#	LAP JOINT FLANGE (LEVEL CONNECTION)
K	1	316L S.S.		2"	----	FF-IH-17-TT-2-FO W/AIR OPEN/SPRING CLOSE WORCESTER #2539 ACTUATOR & BETTIS #GR-021 AFC PROXIMITY SWITCH INDICATING FULL CLOSED POSITION
J1	1	304L S.S.		1-1/2" TPT	3000#	FULL COUPLING (INLET)
J2	1	304L S.S.		3/4" TPT	3000#	FULL COUPLING (DRAIN)
J3	1	304L S.S.		1-1/2" TPT	3000#	FULL COUPLING (OUTLET)
J4	1	304L S.S.		1-1/2" TPT	3000#	FULL COUPLING (RELIEF VALVE CONNECTION)
J5	1	304L S.S.		1/2" TPT	3000#	FULL COUPLING (VENT CONNECTION)

STANDARD INFORMATION:

ASME:	YES LATEST EDITION
DESIGN PRESSURE & TEMP.:	SHELL: 15 PSIG & -15 PSIG AT 325°F./-20°F. JACKET: 120 PSIG AT 325°F./-20°F.
HYDROTEST AT AMBIENT:	SHELL: 120 PSIG. JACKET: 250 PSIG.
CORROSION ALLOWANCE:	NONE
PASSIVATION REQ'D.:	YES (OAKITE 33)
SHOP TOLERANCE:	±1/8"
RADIOGRAPH:	NO
N.D.E.:	NO
P.W.H.T.:	NO
TANK CONTENTS:	AQUEOUS WATER BASE SOLUTION
SP. GR.:	1.0
APPROX. EMPTY WEIGHT:	2250 LBS. ✓ WEIGHT FULL OF WATER: 5300 LBS.
FINISH:	INSIDE: 150 GRIT W/WELDS GROUND & POLISHED (#-6). OUTSIDE: GLASS BEAD BLASTED W/WELDS FREE OF BLEMS.
REFERENCE DRAWINGS:	S-10010-B SIDEWALL HEADERS S-16934-C MANWAY S-22258-B SHELL & COLDWALL

SPECIAL NOTES:
1. ALL WELDS TO BE FULL PENETRATION AND CONTINUOUS, UNLESS NOTED OTHERWISE.
2. SOLVENT CLEAN AND PAINT HEAT EXCHANGE SURFACES WITH (2) COATS OF TRIMALOX 70.
3. SETUP ALL THREADS AFTER WELDING.
4. GRIND INTERNAL THREADS OUT OF COUPLINGS ON JACKET FITTINGS.

91715

SAFETY LABEL SCHEDULE

ITEM	QTY	PART #	DESCRIPTION
L1	1		NAMETAG
L4	1	M9991-4	RELIEVE PRESSURE
L18	1	GF991-18	AIR OUT TANK
L27	1	M9991-27	HOT SURFACES
L30	1	GF991-30	MANHOLE CIP

12-1-92	/3	OUTER WRAP WAS LABELED 316L, INSULATION WAS LABELED 304L, TOP BREAST RING WAS LABELED 304L, BOTTOM BREAST RING WAS LABELED 304L, SUPPORT LUG BASE WAS LABELED 316L & SIDE HEADERS WERE LABELED 304 SS — R.D. 12/1/92
11-20-92	/2	ADD MANWAY NECK WELD TO DETAIL & ADD REINFORCING TO MANWAY & NOZZLE "A" — R.D. 11/20/92
11-3-92	/1	ADD (8) BAFFLES "17" AT 45°, 135°, 225° & 315° — RD 11/13/92
DATE	ISSUE	REVISION DESCRIPTION — APP'D. BY

CERTIFIED
SIG.
DATE 12/7/92

WALKER STAINLESS EQUIPMENT CO., INC.
NEW LISBON, WISCONSIN 53950

SCALE:	AS NOTED	APPROVED BY: R.D. 11/13/92	DRAWN BY: C.H.
DATE:	10-2-92		REVISED: /3

300 GALLON 316L S.S. WETTED PARTS VESSEL

JOB: POLAROID CORP., WALTHAM, MASS.

DRAWING NUMBER: SP-22083-0

NOTE! DO NOT SCALE THIS DRAWING!

62-16F SEAL

NAT'L BD. N.B. #

CERTIFIED BY WALKER STAINLESS EQUIPMENT CO. INC.
WALKER — U STAMP — MAWP 15 & 15 PSIG — MDMT -20°F — MAWP 120 PSIG — MDMT -20°F
SHELL: FULL VACUUM AT 325°F — P.W.H.T. NO — R.T. NO
JACKET: FULL VACUUM AT 325°F — P.W.H.T. NO — R.T. NO
ASME VR 7865 — DATE
CAPACITY 300 GALLON — MATL 316L S.S.
SERIAL WETTED — JOB SP-22083-0
EQUIP. NO. A-3030-131-8

0 11/13/92