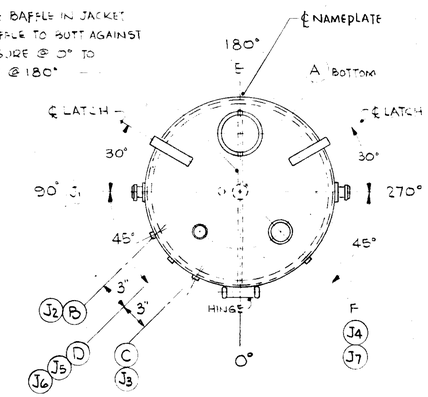
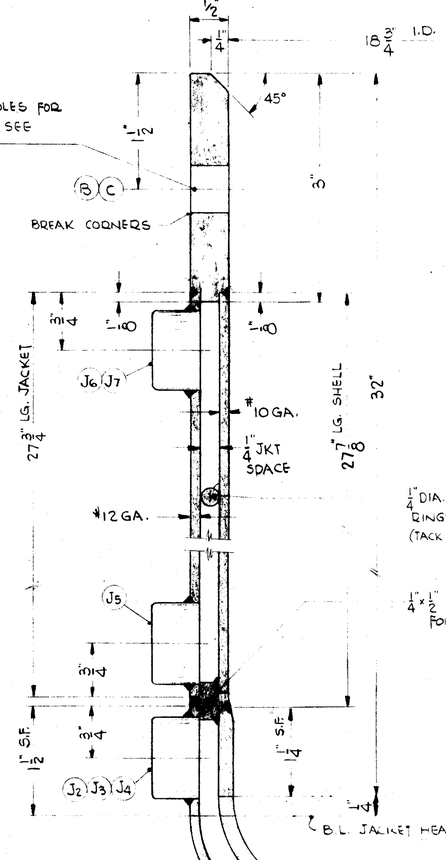
1" ø OD × .020 WALL TUBE BAFFLE IN JACKET HEAD. BAFFLE TO BUTT AGAINST JKT. CLOSURE @ 0° TO KNUCKLE @ 180°



— ORIENTATION —



1/4" DIA. SPIRAL JACKET RINGS @ 3" PITCH — T304 S/S. (TACK WELD TO INNER SHELL)

1/4" × 1/2" JACKET CLOSURE RING FOR TWO-ZONE JACKET — T304 S/S.

B.L. BOTTOM HEAD

USE SER.# 952 TO 995 INCLUSIVE

DESIGNERS - FABRICATORS
ACME INDUSTRIAL EQUIPMENT CO.
HINGHAM MASS.
DIN I W
SER. NO. NATL BD —
YEAR BUILT 1971
SHELL DES PRESS ATMOS
JKT DES PRESS 110 PSIG
DES TEMP 325 F

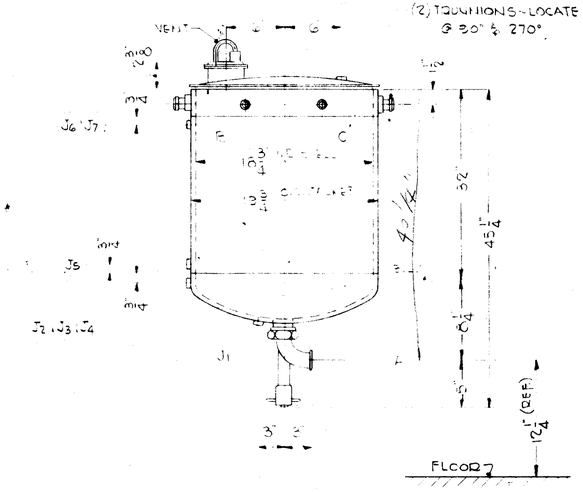
— NAMEPLATE STAMPING —

STAMP POLAROID ITEM #5M-650(N8-B) THRU #5M-693(N8-B) INCL.

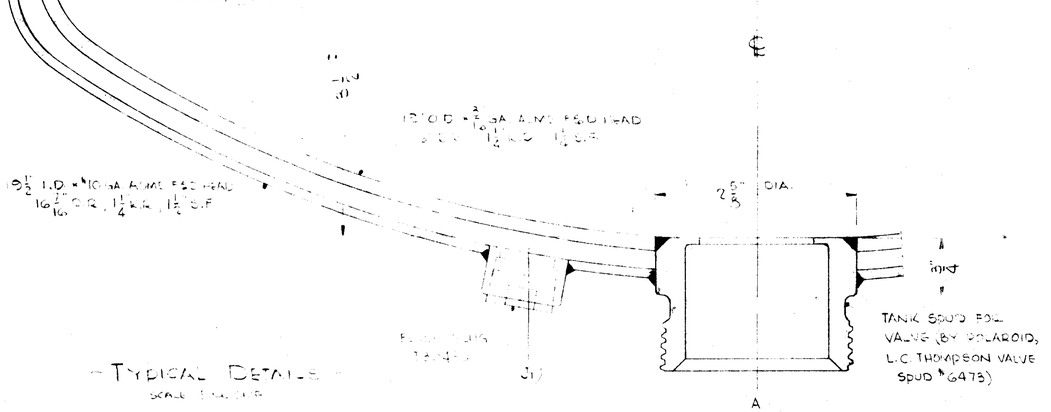
General Notes

1. MATERIAL: "O" RING (COVER) — NEOPRENE · SULPHUR FREE (40 DURO)
   VESSEL — T316 S/S
   JACKET — T304 S/S
   BOLTING & TRUNIONS — T304 S/S WITH T303 S/S NUTS
   COIL (INTERNAL) — T316 S/S
   "O" RING (COIL) — VITON "O" RING
   GASKET (TRI-CLAMP) — VITON
   JACKET SPIRAL BAFFLES — T304 S/S
2. FINISH: INTERNAL — #4 SANITARY
   EXTERNAL — #4 INDUSTRIAL
3. DESIGN: ASME CODE & CODE STAMP (UM SYMBOL)
   FOR PRESSURES & TEMP SEE STAMPING.
4. TEST PRESS: VESSEL — ATMOSPHERIC
   JACKET — 165 PSIG
5. REFERENCE DWGS: COIL — 3750-A
   COVER & TRUNNION — 3732-A
   LEGS — 3749-A
6. FORTY-FOUR (44) TANKS REQUIRED.
7. CLEANING: REMOVE CARBURIZATION & SPLATTER USING STAINLESS STEEL WIRE BRUSH, OXIDE OR SILICONE SANDING BELTS.
   PASSIVATION: ALL WELDS INSIDE & OUTSIDE SHALL BE PASSIVATED AFTER FABRICATION & MECHANICAL CLEANING IS PERFORMED, BY MIXING "OAKITE #33" (LIQUID) WITH "OAKITE HI-LITE" (POWDER) INTO A PASTE & SWABBING. APPLY AT A TEMPERATURE OF APPROX 60°F. LET SET FOR 30 MIN. RINSE ENTIRE VESSEL (INSIDE & OUTSIDE) WITH CLEAN FRESH 140°F WATER & WIPE DRY.

ISSUED
DEC 16 1971
CHEM. ENG. DEPT.
1-008



— ELEVATION —
SCALE: NONE



— TYPICAL DETAILS —
SCALE: NONE

* COMPLETE TRI-CLAMP FITTING INCLUDING GASKET, CAP & CLAMP.

MARK	QTY	SIZE	RATING	BORE	SERVICE
* F	1	1½	250#	1.770"	PROCESS (FUTURE) TRI-CLAMP
* E	1	1	250#	2.466"	ACCESS & VENT - TRI-CLAMP
D	1	1	300#	SCRD	PROCESS (FUTURE) W/PLUG
C	1	¼"	SPEC. QUICK DISCONNECT	7/32"	COIL OUTLET
B	1	¼"	SPEC. QUICK DISCONNECT	7/32"	COIL INLET
A	1	1½"	BY POLAROID	SCRD	SANITARY VALVE OUTLET

VESSEL NOZZLE DATA

Δ THESE CONNS. TO HAVE FLUSH PLUGS.

MARK	QTY	SIZE	RATING	BORE	SERVICE
Δ J7	1	½	300#	SCRD	RELIEF VALVE (SIDE)
J6	1	1			OUTLET & VENT (SIDE)
J5	1	¾			INLET & DRAIN (SIDE)
Δ J4	1	½			RELIEF VALVE (BOTTOM)
J3	1	1½			OUTLET & VENT (BOTTOM)
J2	1	1½			INLET (BOTTOM)
Δ J1	1	1½			DRAIN (BOTTOM)

JACKET NOZZLE DATA

RECEIVED
APR 26 1972
CHEM. ENGR

REV.	DESCRIPTION	BY	DATE	APPROVED
4	COVER "O" RING WAS VITON-A	EFS	6-28-71	
3	GENERAL REVISIONS	WRM	4-22-71	
2	ADDED SER. NOS.	WRM	3-3-71	
1	ADDED SER. NOS.	WRM	2-18-71	

F 650

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TOLERANCE UNLESS OTHERWISE NOTED: DECIMAL ± FRACTION ±
DRAWN
CHECKED
APPROVED
SCALE
DATE
DRAWING NO. 4

40 GAL. INSUL. TANK
5M-650 (N8-B) THRU 5M-693 (N8-B) INCL.
ACME INDUSTRIAL EQUIPMENT CO.
DRAWING NO. 3750-A
DATE ISSUED 3/1/71
SCALE NONE
SHEET NO. 1
REV. A

1-008 5M-650 THRU 693

ACME STANDARD TOOL © U.M. INC. 67888