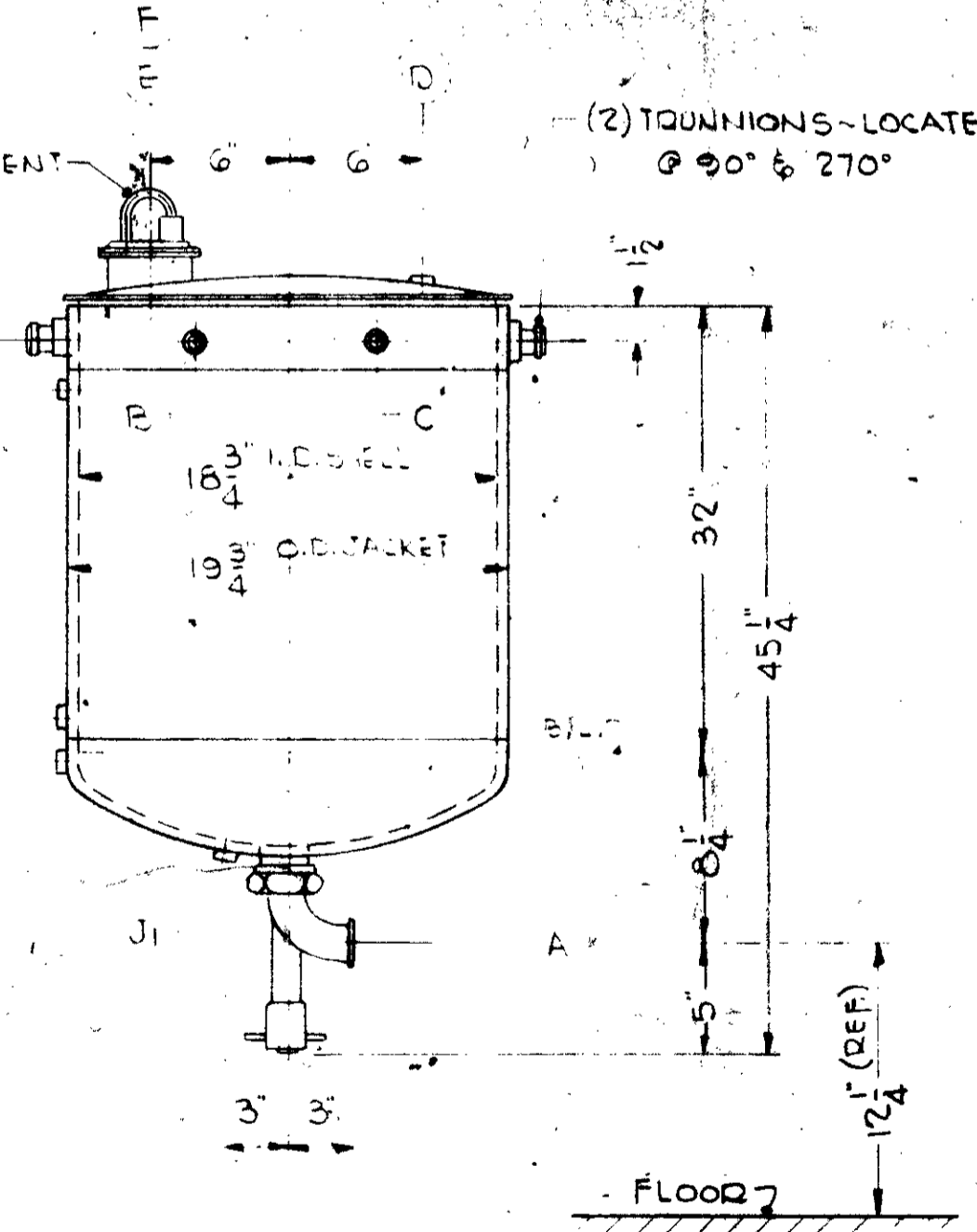
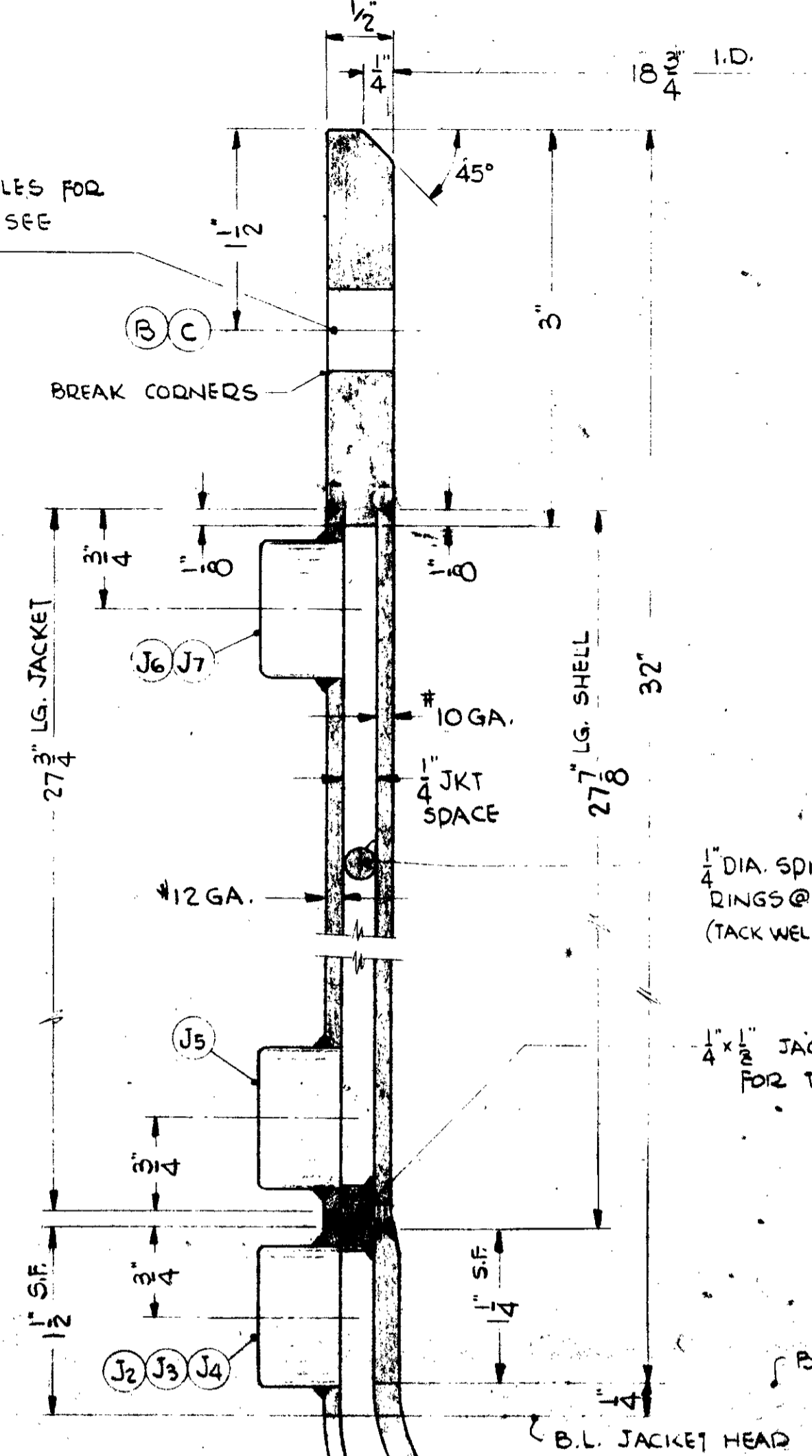


ORIENTATION



ELEVATION  
SCALE: NONE

(2) 1/16" DIA DEAMED HOLES FOR COIL FEED THRU, SEE DETAIL OF COIL.



TYPICAL DETAILS  
SCALE: FULL SIZE

DESIGNERS - FABRICATORS  
ACME INDUSTRIAL EQUIPMENT CO.  
HINGHAM, MASS

UM

DIN 1

W

SEQ NO.

YEAR BUILT 1971

SHELL DES PRESS ATMOS

JKT DES PRESS 110 PSIG

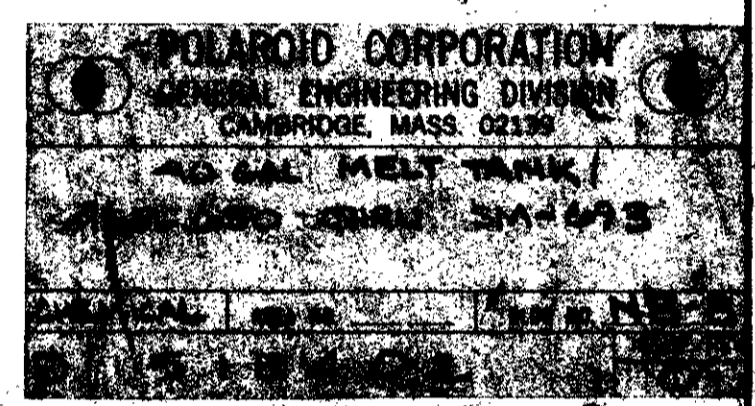
DES TEMP 325 F

NAMEPLATE STAMPING

STAMP POLAROID ITEM # SM-650(NB-B) THRU # SM-693(NB-B) INCL.

GENERAL NOTES

- MATERIAL: O-RING (COVER) - NEOPRENE - SULPHUR FREE (40 DURO)  
VESSEL - T316 3/8  
JACKET - T304 3/8  
BOLTING & TRUNNIONS - T304 3/8 WITH T303 3/8 NUTS  
COIL (INTERNAL) - T316 3/8  
O-RING (COIL) - VITON O-RING  
GASKET (TRI-CLAMP) - VITON  
JACKET SPIRAL BAFFLES - T304 3/8  
INTERNAL - #4 SANITARY  
EXTERNAL - #4 INDUSTRIAL
- FINISH: INTERNAL - #4 SANITARY  
EXTERNAL - #4 INDUSTRIAL
- DESIGN: ASME CODE & CODE STAMP (UM SYMBOL) FOR PRESSURES & TEMP SEE STAMPING.
- TEST PRESS: VESSEL - ATMOSPHERIC  
JACKET - 165 PSIG
- REFERENCE DWGS: COIL - 3750-A  
COVER & TRUNNION - 3732-A  
LEGS - 3749-A
- FORTY-FOUR (44) TANKS REQUIRED.
- 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 & SWABING. 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.



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

MARK	QTY	SIZE	RATING	BORG	SERVICE
F	1	1/2"	250*	1.770"	PROCESS (FUTURE) TRI-CLAMP
E	1	3"	250*	2.868"	ACCESS & 3/8" VENT - TRI-CLAMP
D	1	1"	300*	SCRD	PROCESS (FUTURE) W/PLUG
C	1	1/4"	SPEC. QUICK DISCONNECT	7/8"	COIL OUTLET
B	1	1/4"	SPEC. QUICK DISCONNECT	7/8"	COIL INLET
A	1	1/2"	BY POLAROID	SCRD	SANITARY VALVE OUTLET

VESSEL NOZZLE DATA

Δ THESE CONNS. TO HAVE FLUSH PLUGS.

MARK	QTY	SIZE	RATING	BORG	SERVICE
Δ J7	1	1/2"	3000*	SCRD	RELIEF VALVE (SIDE)
J6	1	1/2"			OUTLET & VENT (SIDE)
J5	1	1/2"			INLET & DRAIN (SIDE)
Δ J4	1	1/2"			RELIEF VALVE (BOTTOM)
J3	1	1/2"			OUTLET & VENT (BOTTOM)
J2	1	1/2"			INLET (BOTTOM)
Δ J1	1	1/2"			DRAIN (BOTTOM)

JACKET NOZZLE DATA

E.R.E.D  
MAY 26 1987  
X PTN 222-6403

RECEIVED  
APR 26 1971  
CHEM. ENGR.

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NO. F-650

TOLERANCE UNLESS OTHERWISE NOTED: DECIMAL FRACTION

DRAWN BY: 12 1007-74A

CHECKED: [Signature]

APPROVED: [Signature]

SCALE: NOTED

DATE: 2-16-71

REVISION: 5

40 GAL MELT TANK  
SM-650(NB-B) THRU SM-693(NB-B) INCL.

ACME INDUSTRIAL EQUIPMENT CO.  
HINGHAM MASS 01943

DRAWING NO. 3741 A

REVISION	DATE	BY	REASON
5. REORIENTED BAFFLE IN BOTTOM HEAD	6-28-71	EFS	
4. COVER O-RING WAS VITON-A	4-22-71	WRM	
3. GENERAL REVISIONS	3-12-71		
2. REVISED AS PER MARKED PRINT DATED 3-15-71	3-3-71		

41806-91809 / 91993 / 92077 / 93171 - 93 173