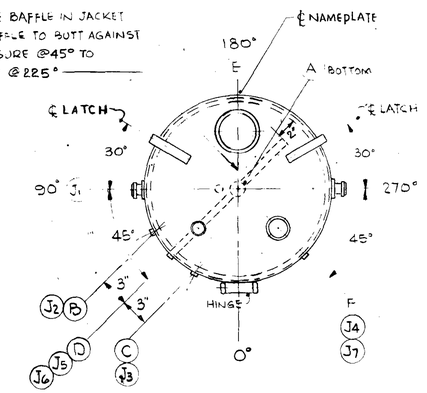
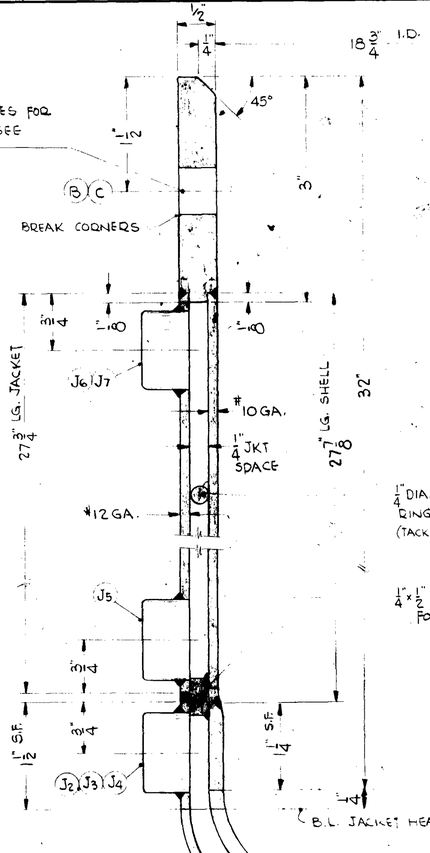
1/4" OD x .020 WALL TUBE BAFFLE IN JACKET HEAD. BAFFLE TO BUTT AGAINST JKT. CLOSURE @ 45° TO KNUCKLE @ 225°



— ORIENTATION —

(2) 11/16" DIA REAMED HOLES FOR COIL FEED THRU, SEE DETAIL OF COIL.



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

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

USE SER # 952 TO 995 INCLUSIVE

DESIGNERS - FABRICATORS
ACME INDUSTRIAL EQUIPMENT CO.
HINGHAM MASS
DIN 1
W
SER NO.
NAT'L BD -
YEAR BUILT 1971
SHELL DES PRESS ATMOS
JKT DES PRESS 110 PSIG
DES TEMP 325 F

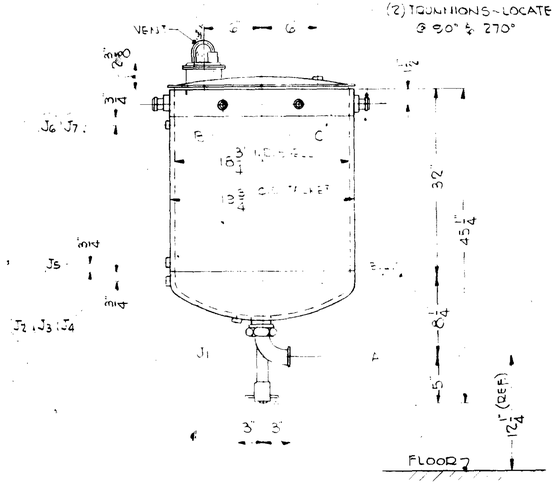
— NAMEPLATE STAMPING —

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

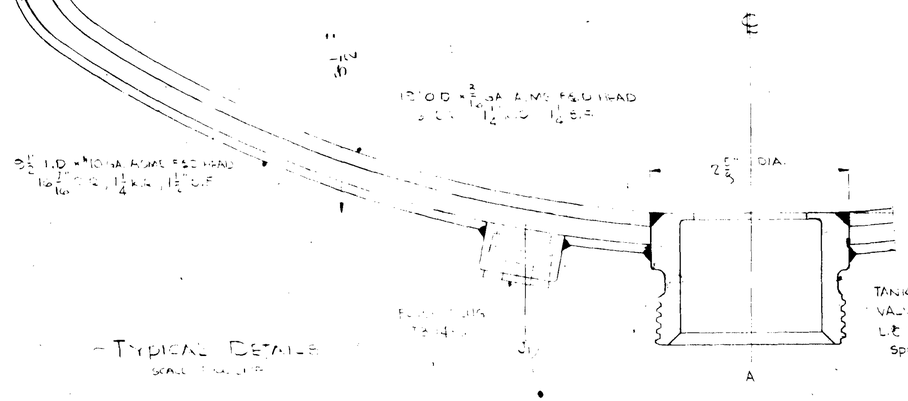
General Notes

1. MATERIAL:
   - "O" RING (COVER) — NEOPRENE - SULPHUR FREE (40 DURO)
   - VESSEL — T316 S/S
   - JACKET — T304 S/S
   - BOLTING & TRUNNIONS — 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.

(2) TRUNNIONS - LOCATE @ 90° & 270°



— ELEVATION —
SCALE: NONE



— TYPICAL DETAIL —
SCALE: FULL SIZE

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

MARK	QTY	SIZE	RATING	BORE	SERVICE
* F	1	1½"	250#	1.110"	PROCESS (FUTURE) TRI-CLAMP
* E	1	3"	25#	2.868"	A. INSS & 3/8" VENT - TRI-CLAMP
D	1	1"	3000#	SCRWD	STAINLESS (FUTURE) W/PLUG
C	1	1/4"	SPEC. QUICK DISCONNECT	7/32"	COIL OUTLET
B	1	1/4"	SPEC. QUICK DISCONNECT	7/32"	COIL INLET
A	1	1½"	BY POLAROID	5 1/2"	SANITARY VALVE OUTLET

VESSEL NOZZLE DATA

Δ THESE CONNS. TO HAVE FLUSH PLUGS.

MARK	QTY	SIZE	RATING	BORE	SERVICE
Δ J7	1	½"	3000#	SCRWD	RELIEF VALVE (SIDE)
J6	1	½"			OUTLET & VENT (SIDE)
J5	1	½"			INLET & DRAIN (SIDE)
Δ J4	1	½"			RELIEF VALVE (BOTTOM)
J3	1	½"			OUTLET & VENT (BOTTOM)
J2	1	½"			INLET (BOTTOM)
Δ J1	1	1"			DRAIN (BOTTOM)

JACKET NOZZLE DATA

EQUIP. & FAC. ENG. DIV.
NOV 20 1981

RECEIVED
APR 26 1971
CHEM. ENGR

5. REORIENTED BAFFLE IN BOTTOM HEAD	4. COVER "O" RING WAS VITON-A 6-28-71 EFS	3. GENERAL REVISIONS: 4-22-71 WRM	2. REVISED AS PER MARKED PRINT DATED 3-12-71 3-15-71 WRM; REVISED PER MARKED PRINT DATED 2-18-71 3-3-71

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F-650

TOLERANCE UNLESS OTHERWISE NOTED: DECIMAL ± ; FRACTION ±
DRAWN
CHECKED
APPROVED
SCALE
DATE
REVISIONS 5

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

ACME INDUSTRIAL EQUIPMENT CO
HINGHAM MASS

DRAWING NO. 3141 A

93247 / 94248-94249 / 94280-94282