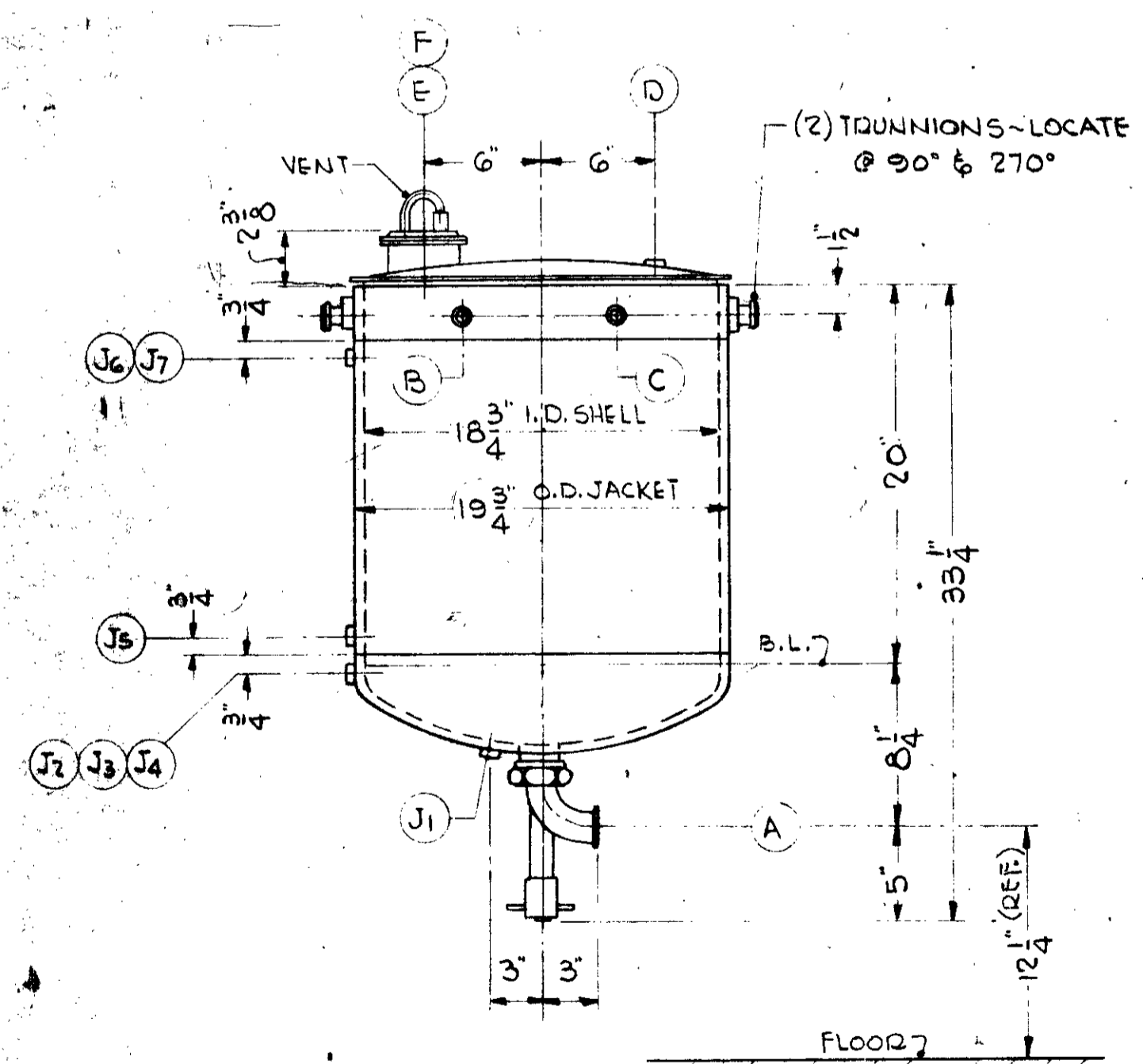
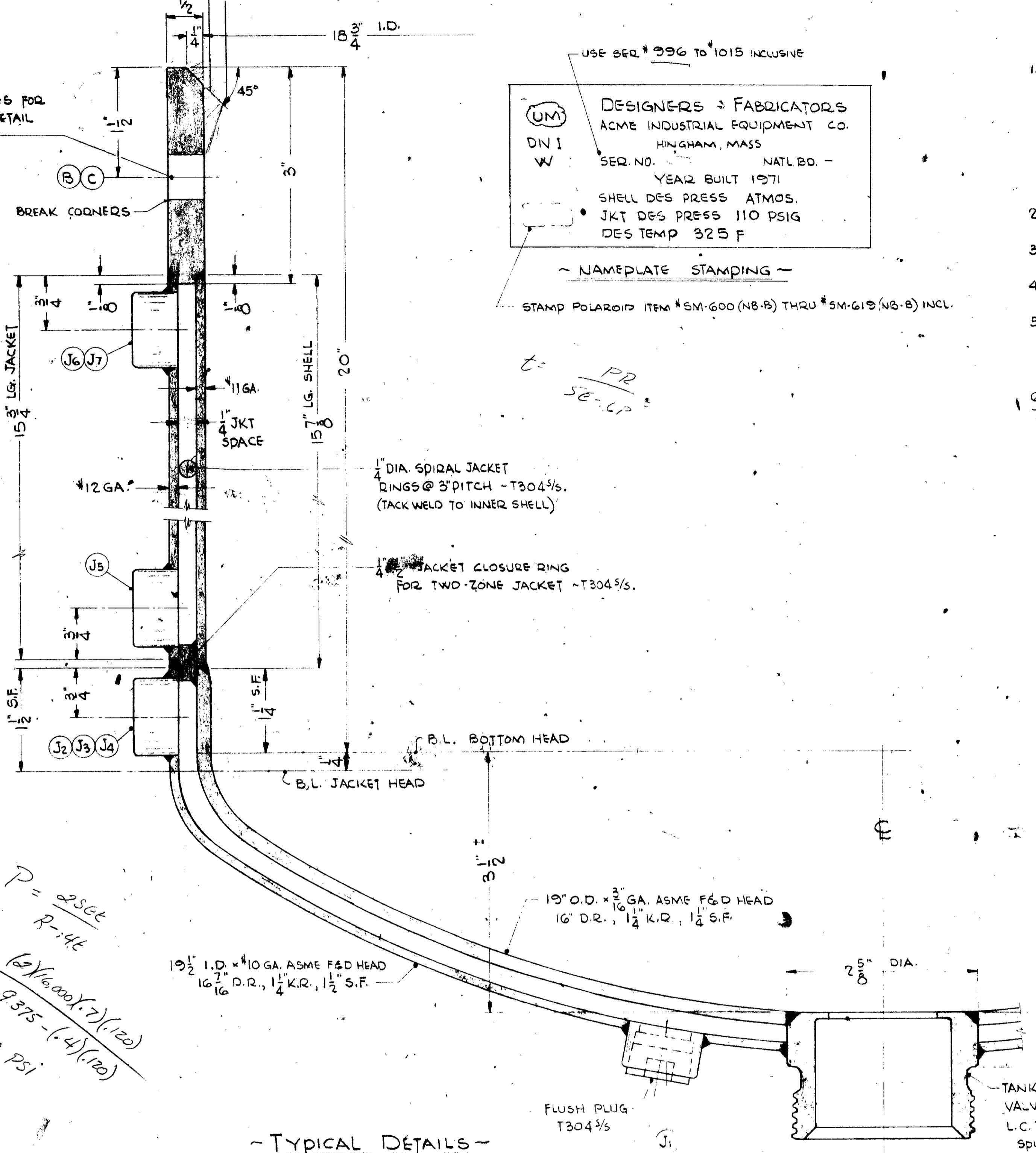


~ ORIENTATION ~



~ ELEVATION ~  
SCALE: 1/2" = 1'-0"

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



~ TYPICAL DETAILS ~  
SCALE: FULL SIZE

DESIGNERS & FABRICATORS  
ACME INDUSTRIAL EQUIPMENT CO.  
HINGHAM, MASS  
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 # SM-600 (NB-B) THRU # SM-619 (NB-B) INCL.

GENERAL NOTES

- MATERIAL: O-RING (COVER) NEOPRENE - SULPHUR FREE (40 DURO)  
VESSEL T316 3/8  
JACKET T304 3/8  
BOLTING & TRUNIONS 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 1/4 SANITARY  
EXTERNAL 1/4 INDUSTRIAL
- FINISH: ASME CODE & CODE STAMP (UM SYMBOL) FOR PRESSURES & TEMP SEE STAMPING.
- DESIGN: ASME CODE & CODE STAMP (UM SYMBOL) FOR PRESSURES & TEMP SEE STAMPING.
- TEST PRESS: VESSEL ATMOSPHERIC  
JACKET 165 PSIG HYDRO.
- REFERENCE DNGS: COIL 3750-A  
COVER & TRUNNION 3732-A  
LEGS 3749-A

- TWENTY (20) TANKS REQ'D.
- CLEANING: REMOVE CARBURIZATION & SPLATTER USING STAINLESS STEEL WIRE BRUSH, OXIDE OR SILICONE SANDING BELTS.  
PASSINATION: ALL WELDS INSIDE & OUTSIDE SHALL BE PASSIVATED AFTER FABRICATION & MECHANICAL CLEANING IS PERFORMED, BY MIXING "OAKITE 133" (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 & WIFE DRY.

Bob:  
1. MAKE COVER LIKE D-1196 A  
ACME DWG. 3714-A - SAME NOZZ. ORIENTATIONAL.  
2. COVER TO BE REMOVABLE  
3. VESSEL SHELL PRESSURE 20# F/V  
4. (6) VESSELS.  
Mike Surpin  
5-1-87

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

MARK	QTY	SIZE	RATING	BORE	SERVICE
F	1	1 1/2"	250#	1.770"	PROCESS (FUTURE) TRI-CLAMP
E	1	3"	250#	2.868"	ACCESS & VENT - TRI-CLAMP
D	1	1"	3000#	SCRD	PROCESS (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	1 1/2"	BY POLAROID SCRD	SCRD	SANITARY VALVE OUTLET

VESSEL NOZZLE DATA

Δ THESE CONNS. TO HAVE FLUSH PLUGS.

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

JACKET NOZZLE DATA

RECEIVED  
APR 26 1971  
CHEM. ENGR.

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SO No. F-650

TOLERANCE UNLESS OTHERWISE NOTED  
DECIMAL FRACTION

20 GAL. MELT TANK  
SM-600 (NB-B) THRU SM-619 (NB-B) INCL.

ACME INDUSTRIAL EQUIPMENT CO.  
HINGHAM MASS. 02043

DRAWING NO. 3735 A

DATE 2-16-71  
REVISION 6

- REORIENTED BAFFLE IN BOTTOM HEAD
- COVER O-RING WAS VITON-A
- GENERAL REVISIONS
- BAFFLE IN JACKET HEAD WAS 1/4" DIA. ROD
- REVISED AS PER MARKED PRINT DATED 2-18-71
- RELEASED FOR SHOP FABRICATION.