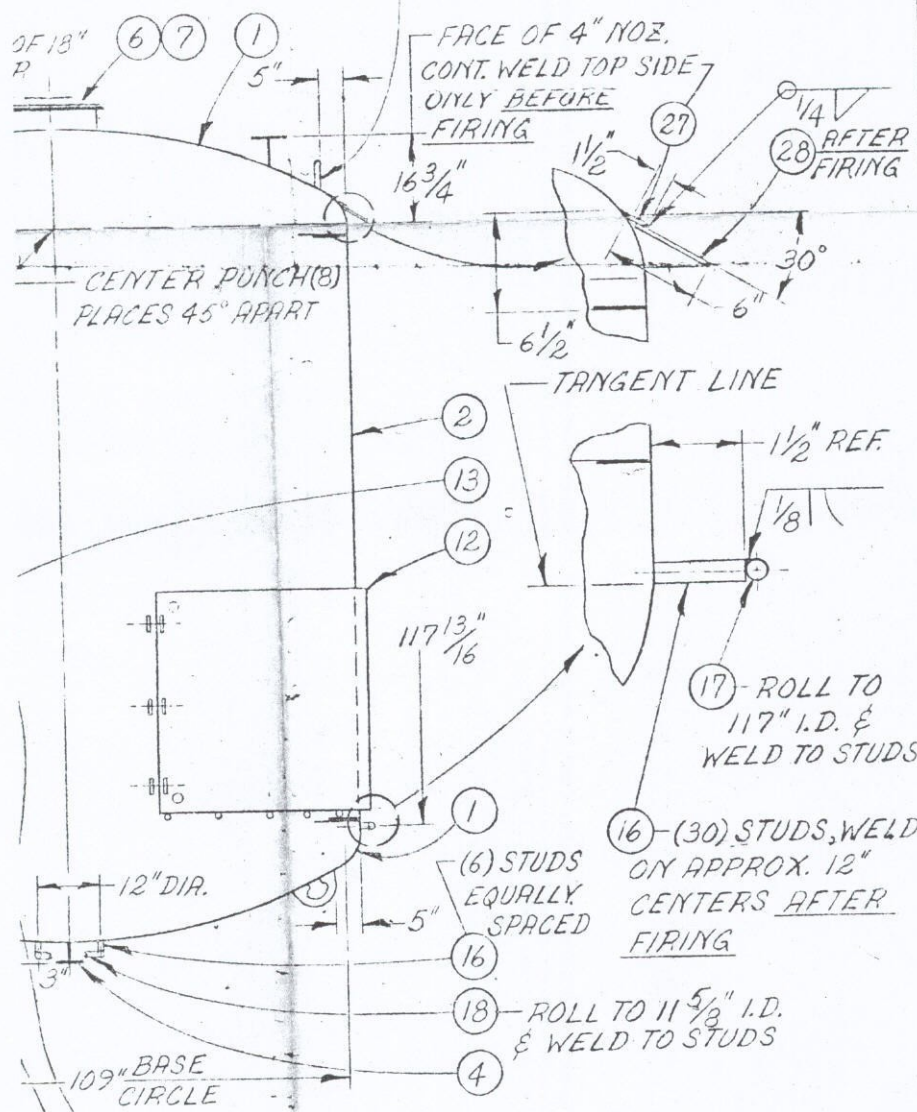


18	1	---	THIS DWG	MING. INGS. SUPPLY CO. X 37 3/4" DEVL. LG.
19	12	1602887	---	BOLT, HEX. HD. SA 173B7, 1/2" X 1 1/2"
20	12	1602374	---	WASHER, PLAIN, 1/2"
21	12	1602072	---	NUT, HEX., SA-174-2H, 1/2"-13
22	8	---	THIS DWG	PIPE, LEG. STL., 3" SCH. 80, 2" LGE. WPT
23	8	---	THIS DWG	PLATE, BASE, STL., 3/4" TH.
24	16	1602988	---	BOLT, HEX. HD., STL. CAP. 5/8" X 1 1/2"
25	32	1602055	---	WASHER, PLAIN, CAP. PL., 5/8"
26	16	1601942	---	NUT, HEX., STL. CAP. PL., 5/8"-11

AREAS COVERED BY PLATE COILS. APPLY 1/8 TH. PACIT 1000 TO INNER SIDE OF PLATE COIL USING TOWEL BEFORE ATTACHING PLATE COIL TO VESSEL. OILS TIGHT FOR RING ON SHELL.



BASE MATERIAL		
VESSEL	SA-285, GR. B	
JACKET	---	
SEALER	---	
THICKNESSES	TANK	JKT.
HD. - TOP	5/8"	
HD. - BOT.	5/8"	
SHELL	9/16"	
SEALER		
DESIGN & INSPECTION		
SPECIFICATION	TANK	JKT.
CODE DESIGN	YES	
INS. INSP. & STAMP	YES	
DESIGN PRESS. PSIG	50 IFV	11 *
DESIGN TEMP. °F.	650°	
STAMP NAMEPLATE	50 PSIG @ 650°F	
HYDRO TEST PSIG	50	
RADIOGRAPH	NO	
HEAT TREAT SPEC. NO.		

SEE OPERATING LIMITATIONS INSTALLATION MAINTENANCE INSTRUCTIONS, MANUAL #IMBI-100

CUSTOMER INSPECTION FOR INSTALLATION IN AREAS SUBJECT TO 25 PSF WIND LOAD NO SEISMIC LOAD

F.V. = FULL VACUUM
VESSEL FINISH & ACCESSORY MAT'L'S.
VESSEL 3315/3315
ACCESSORIES 3315
PLUGS TANTHALUM
CEMENT FURAN

GASKETS	REFERENCES
CRT	K273-0142-50
PAINT SEE NOTE	CIN# 0915
	CIN# 0953
CAP. RATED 6000 GAL.	
CAP. FULL 6100 GAL.	
WT. UNJKTD 13,700 LBS	
WT. JKTD	
WT. / ACC'S. 13,800 LBS	
	PC# 263

TITLE
6000 GAL. VESSEL
114" O.D. X 118" PCW

CUSTOMER HERCULES, INC.
ADDRESS WILMINGTON, DEL.
CONSIGNEE HERCULES, INC.
ADDRESS BRUNSWICK, GA.
CUST. ORDER NO. 336-021-3470039-000TES

NOTE: TAG EACH ITEM "CMC EXPANSION PROJECT" T560-1A & B, MCA STORAGE TANKS

ES
12"
YP.
TYP.
LB. AND STD.

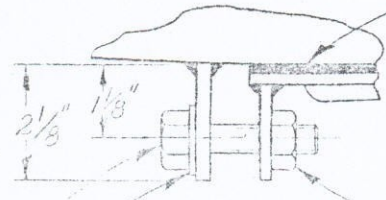
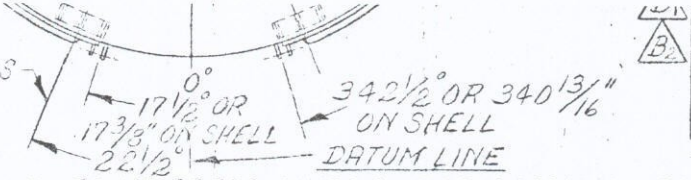
LTR	REVISION	APP	DATE
A	REV. PER CUSTOMERS MARKED APP. I.B. R. DATED 5-22-75 D.C.D. 6-26-75 FS.		7-2-75
B	NOTE #22 N.P.T. ADDED TO DESCRIPT. 2) BASE PLATE REV. WAS 1" THICKNESS D.C.D. 10-24-75 FS.		10-25-75
C	SANDELAST ROLDED D.C.D. 12-1-75		12-5-75

THE PFAUDLER CO.
a division of RITTER PFAUDLER CORPORATION
ROCHESTER, NEW YORK
plants in ELYRIA, OHIO and ROCHESTER, NEW YORK

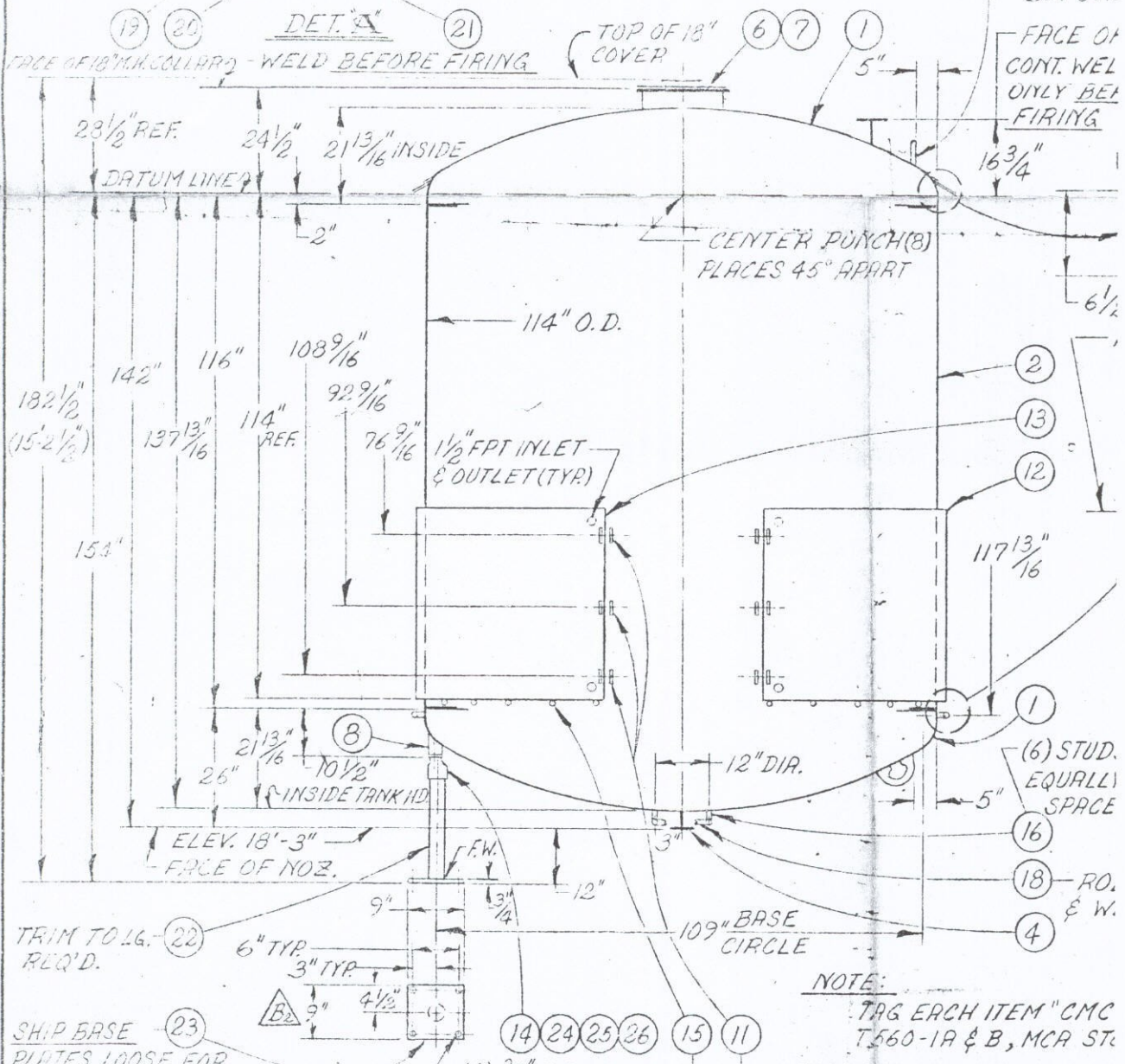
SCALE 1/2" = 1'-0"
NO. REQ'D. 2
V P F
17122

10 - WELD IN FINAL ASSY.

PRINT NOTE: SANDBLAST Δ/C ϕ LEGS
 1-FOR CARBOGLAS SEE DWG. #3138808
 2-BALANCE OF VESSEL TO BE PFAUDLER
 BLUE



DO NOT PRINT AREAS COVERED BY PLATECOILS. APPL. LAYER OF "TRACIT" 1000 TO INNER SIDE OF PLATE COIL SERRATED TROWEL BEFORE ATTACHING PLATE COIL. PULL PLATECOILS TIGHT FOR UNIFORM BERRING ON SHELL.



3 - REMOVE BEFORE FIRING

FACE OF CONT. WEL ONLY BE FIRING

CENTER PUNCH (8) PLACES 45° APART

(6) STUD. EQUALLY SPACE

(18) RO. & W.

TRIM TO LG. REQ'D.

SHIP BASE PLATES LOOSE FOR FIELD WELD BY CUSTOMER.

(12) WELD AFTER FIRING ON 12" CENTERS (SUPT. FOR COILS) TYP. WELD BEFORE FIRING TYP.

NOTE: TAG EACH ITEM "CMC T-560-1A & B, MCA ST.

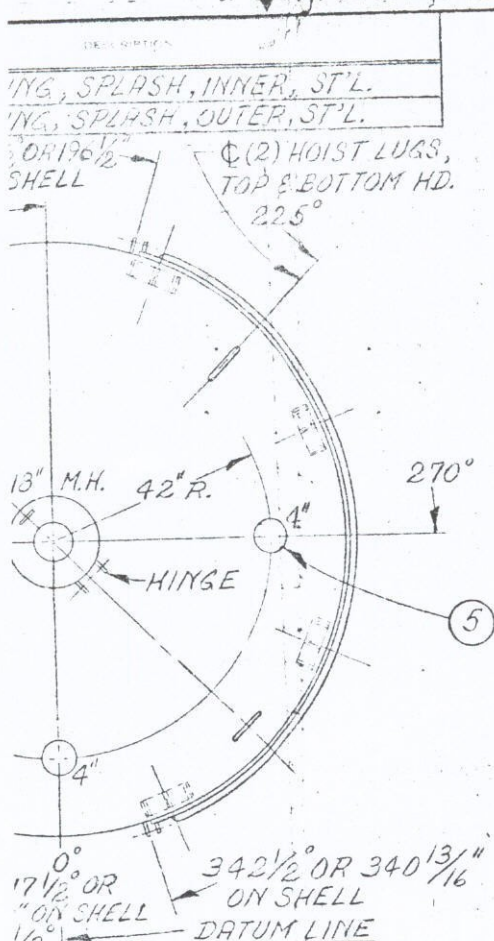
LTR	REVISION
A	REV. PER CUSTOMERS MARKL APP. (B.A. DATED 5-22-75
	D.G.D. 6-26-75 AS.
B	DIFF. #22 INPT ADDED TO DESCRIPT. 2) BASE PLATE REV. WAS 1" TH. X 12" W.
	D.G.D. 10-24-75 AS.
C	SANDBLAST RUDED P.G.D. 12-1-75

ALL TANK NOZZLES FURNISHED WITH LOOSE SPLIT FLG. 150 LB. ANG STD. DRILLING

WORK FROM DIMENSIONS - DO NOT SCALE

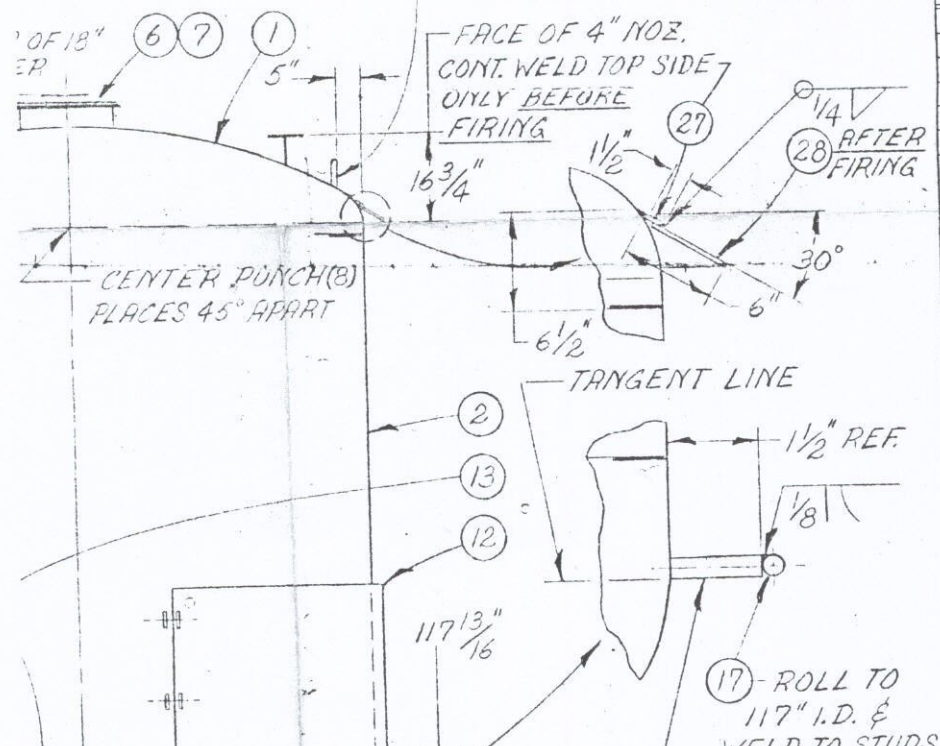
SEE PLAN VIEW FOR ORIENTATION

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REF NO.	QUANTITY	PART NO.	PER DWG. NO.	DESCRIPTION
1	2	3104423	3104570	HEAD, ASME, F&D, 114 O.D.
2	1	3138693	3132398	SHELL, TANK
3	6	3118136	3118136	LUG, HOIST
4	1	1100303	1100303	NOZ., FRGD., MED. WT., 3"
5	3	1100304	1100304	NOZ., FRGD., MED. WT., 4"
6	1	3120697	3120697	COLLAR ASSY., 18" M.H.
7	1	1121313	1120303	COVER ASSY., 18" M.H., 4" OBS. GL.
8	8	3102870	3102870	SUPT ASSY. CHANNEL, 3 TPE
9	2	3128901	3128901	SUPT., NAMEPLATE
10	1	3106780	3106780	NAMEPLATE ASSY.
11	12	3136141	3109296	LUG, SUPT., STL.
12	1	3138783	3138783	PLATE COIL, 43" X 14 3/4" STYLE #31 FR.
13	1	3138784	3138784	PLATE COIL, 43" X 14 3/4" STYLE #33 FLS
14	8	3126516	3126512	BRKT., LEG., 3"
15	24	3202998	3202997	LUG, INS., NELSON
16	36	1610889		STUD, NELSON, NPF 3/8" X 1 1/2"
17	1		THIS DWG.	RING, INS. SUPT., 3/8" DIA. X 3 3/4" DEV. LG.
18	1		THIS DWG.	RING, INS. SUPT., 3/8" DIA. X 3 3/4" DEV. LG.
19	12	1602887		BOLT, HEX. HD., SA-193B7, 1/2"-13 X 2 1/4"
20	12	1602374		WASHER, PLAIN, 1/2"
21	12	1602072		NUT, HEX., SA-194-2H, 1/2"-13
22	8		THIS DWG.	PIPE, LEG, STL., 3" SCH. 80, 2 1/2" O.E. NPT
23	8		THIS DWG.	PLATE, BASE, STL., 3/4" TH.
24	16	1602988		BOLT, HEX. HD., STL. A-2, 5/8" X 2 1/2"
25	32	1602055		WASHER, PLAIN, CAD. PL., 5/8"
26	16	1601942		NUT, HEX., STL. CAD. PL., 5/8"-11

AREAS COVERED BY PLATE COILS. APPLY 1/8" TH. PACIT 1000 TO INNER SIDE OF PLATE COIL USING ROWEL BEFORE ATTACHING PLATE COIL TO VESSEL. COILS TIGHT FOR BRING ON SHELL.



BASE MATERIAL		
VESSEL	SA-285, GR. B	
JACKET		
SEALER		
THICKNESSES	TANK	JKT.
HD. - TOP	5/8"	
HD. - BOT.	5/8"	
SHELL	9/16"	
SEALER		
DESIGN & INSPECTION		
SPECIFICATION	TANK	JKT.
CODE DESIGN	YES	
INS. INSP. & STAMP	YES	
DESIGN PRESS. PSIG	50 IFV	1 *
DESIGN TEMP. °F	650°	
STAMP NAMEPLATE	50 PSIG @ 650°F	
HYDRO TEST PSIG	50	
RADIOGRAPH	NO	
HEAT TREAT SPEC. NO.		
SEE OPERATING LIMITATIONS INSTALLATION MAINTENANCE INSTRUCTIONS, MANUAL IM81-100		
CUSTOMER INSPECTION FOR INSTALLATION IN AREAS SUBJECT TO 25 P.S.F. WIND LOAD NO SEISMIC LOAD		
F.V. = FULL VACUUM		
VESSEL FINISH & ACCESSORY MAT'L'S.		
VESSEL	3.315/3.315	
ACCESSORIES	3.315	
PLUGS	TANTHALUM	
CEMENT	FURRY	
GASKETS	CRT	
PAINT	SEE NOTE	
		REFERENCES
		R273-1143-63
		CIN# 0915
		CIN# 0952