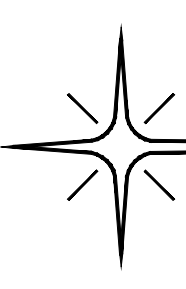
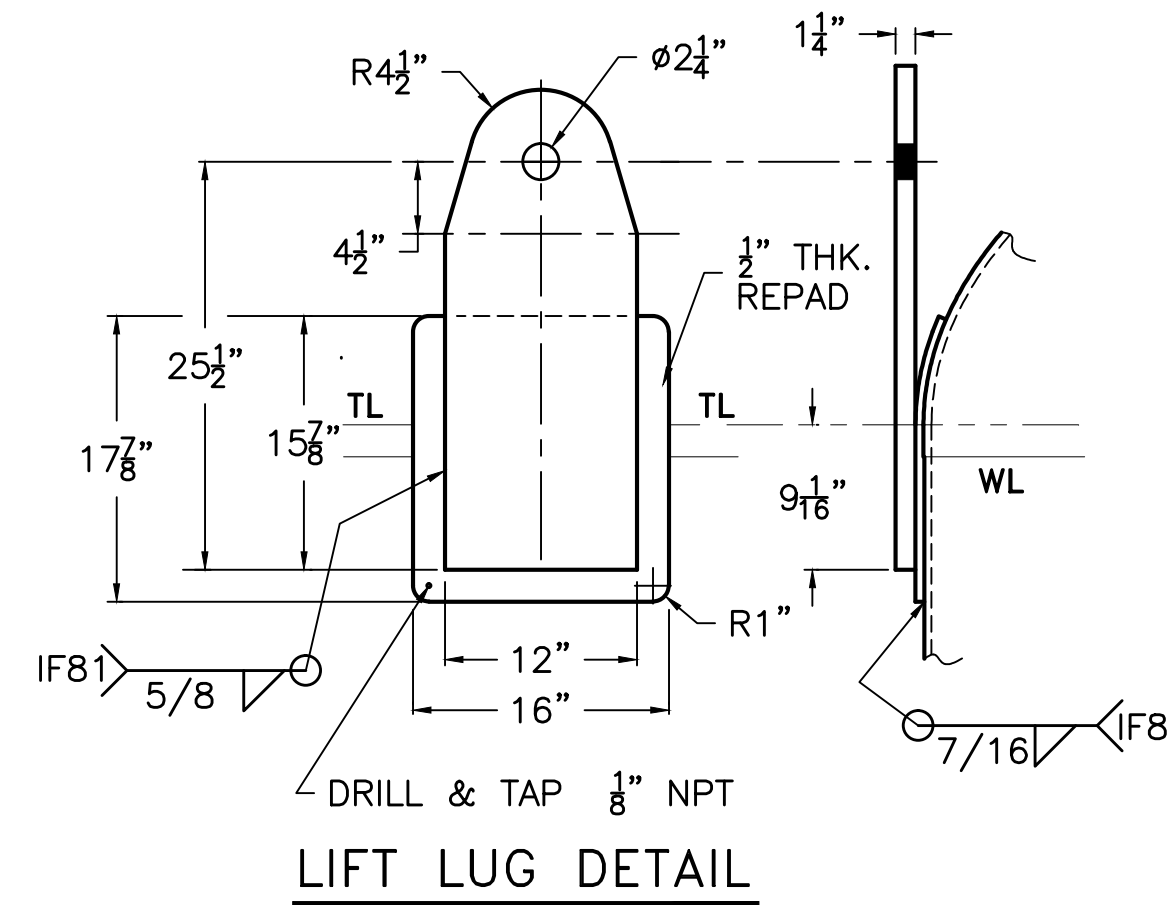
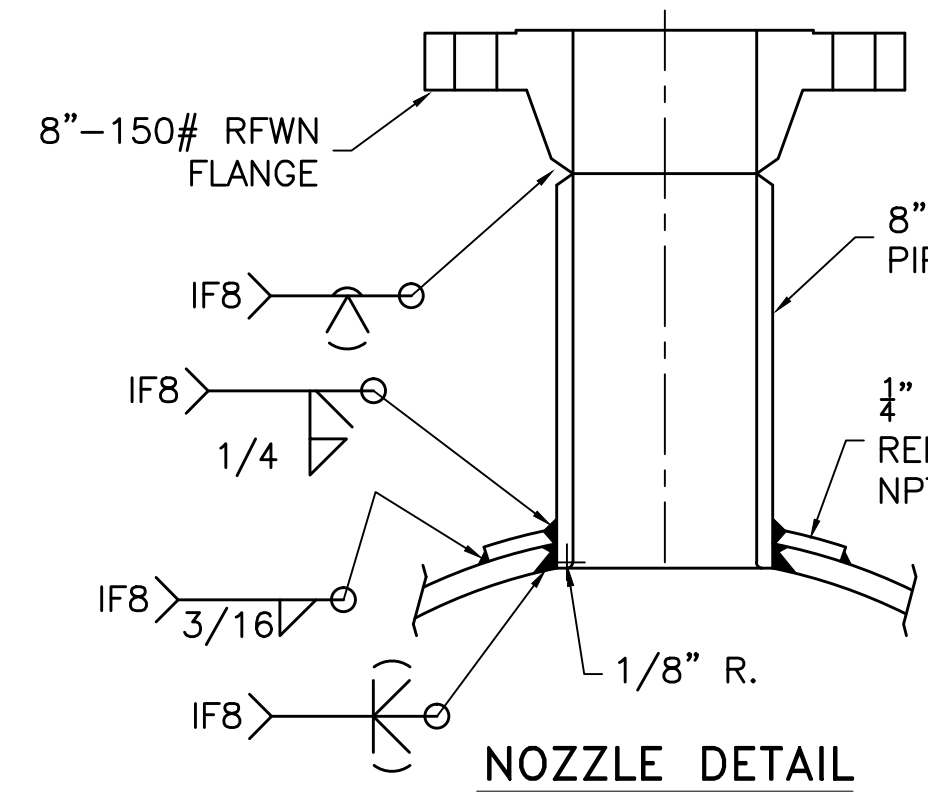


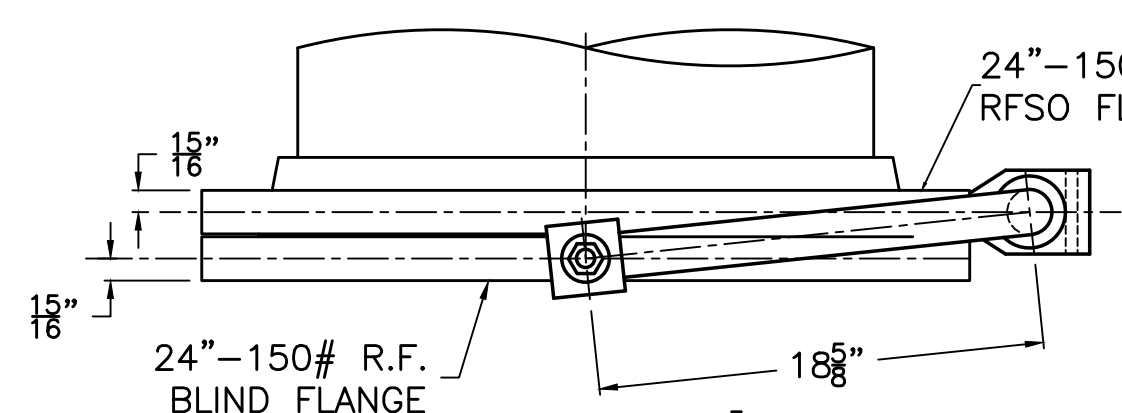
FITTING SCHEDULE			NOTE: NOZZLE FLANGE DIMENSIONS TO CONFORM TO ANSI B16.5 BOLT HOLES TO STRADDLE CENTERLINES PARALLEL TO PRINCIPAL VESSEL CENTERLINES UNLESS OTHERWISE NOTED.		
MK	NO. REQ'D	SIZE & TYPE	PURPOSE		
A	1	3"-150# R.F.W.N. FLG.	WATER INLET		
B	1	12"-150# R.F.W.N. FLG.	CONDENSATE INLET		
C	1	6"-150# R.F.W.N. FLG.	SPARE W/ BLIND (TOP HEAD)		
D	1	8"-150# R.F.W.N. FLG.	VENT		
E	1	8"-150# R.F.W.N. FLG.	OVERFLOW W/ INTERNAL DIP TUBE		
F	1	2"-150# R.F.W.N. FLG.	SPARE W/ BLIND (UPPER SHELL)		
G	1	2"-150# R.F.W.N. FLG.	TEMPERATURE ELEMENT		
H	1	2"-150# R.F.W.N. FLG.	LEVEL TRANSMITTER		
I	1	3"-150# R.F.W.N. FLG.	DRAIN		
J	1	12"-150# R.F.W.N. FLG.	CONDENSATE OUTLET W/ VORTEX BREAKER		
K	1	2"-150# R.F.W.N. FLG.	LEVEL GAUGE		
L	1	2"-150# R.F.W.N. FLG.	LEVEL GAUGE		
M	1	24"-150# R.F.S.O. FLG.	MANWAY W/ BLIND		
N	1	6"-150# R.F.W.N. FLG.	SPARE W/ BLIND (UPPER SHELL)		
VESSEL SPECIFICATIONS					
CONSTRUCTION CODE: ASME SECT. VIII, DIV. 1, 2007 EDITION/A09 ADDENDA					
DESIGN CONDITIONS		SHELL			
IN CUSTOMER SPEC.:		FULL VACUUM TO 75 PSIG AT -20° TO 300°			
M.A.W.P. (STAMPED VALUES)		15 PSIG EXT. to 75 PSIG INT. AT 300°F			
LIMITED BY :		EXTERNAL PRESSURE ON SHELLS			
M.D.M.T.		-20°F AT ABOVE MAWP VALUES			
IMPACT TEST EXEMPT:		PER UHA-51(d)			
CORR. ALLOW:		0.0625"			
RADIOGRAPH:(MULTIPLE		SPOT X-RAY (1) LONGITUDINAL SEAM LOCATION			
WELDERS "PER CODE")		SPOT X-RAY (3) GIRTH SEAM LOCATION			
DYE PENETRANT:		FINISHED LIFT LUG WELDS			
HEAT TREATMENT:		NONE			
PNEUMATIC TEST:		REINFORCEMENT PADS AT 15-PSIG. W/ SOAP-SUDS			
HYDROSTATIC TEST:		124 PSIG			
MATERIAL					
		SHELL			
HEADS:		SA-240 304/304L			
SHELLS:		SA-240 304/304L			
FLANGES & BLINDS:		SA-182 F304/304L			
NOZZLE NECKS PIPE:		SA-312 T304/304L SMLS			
MANWAY NECK PLATE:		SA-240 304/304L			
REINFORCEMENT PADS:		SA-240 304/304L			
VORTEX BRKR & INTERN. CLIPS:		SA-240 304/304L			
VACUUM STIFFENER:		SA-240 304/304L			
LEG SUPPORTS:		ASTM A 36, A 572-50 ON SA-240 304/304L BACKING PADS			
BASE PLATES / GROUNDS:		SA-516-70 / SA-36			
LIFT LUG:		SA-516-70 ON SA-240 304/304L BACKING PADS			
INSUL. SUP'T.:		ASTM A-479 T304/304L			
NAMEPLATE BRACKET:		SA-240 304/304L			
SERVICE GASKETS:		GARLOCK BLUE-GARD 3200 1/8" THK.			
SERVICE BOLTING:		STUDS: SA-193 B7 NUTS: SA-194 2H			
SHIPPING		KLINGER C-4401 FOR ALL NOZZLES (EXCEPT "C, F, M & N") W/ SA-193 B7			
GASKETS & BOLTING:		STUDS AND SA-194 2H HWY HEX NUTS			
SHIP/PURGE COVERS:		SA-105			
GENERAL NOTES					
SANDBLAST: EXTERIOR CARBON STL. AND STAINLESS STL. PER SSPC-SP-10					
PRIME:		INTERTHERM 228, 4.0 TO 6.0 DFT; HTA 441 (GREY)			
FINISH:		INTERTHERM 228, 4.0 TO 6.0 DFT; HTA 441 (GREY)			
CODE INSPECTION & STAMP:					
INSPECTION-OTHER: BY CUSTOMER					
INSULATION: 3" (BY OTHERS)					
NOTE: ALL DIMENSIONS SHOWN ARE IN INCHES, UNLESS OTHERWISE SPECIFIED. 2 REQ'D					
WEIGHT EMPTY: 23,000 LBS.		 KOPETZ MFG., INC. 1500 N. COUNTRY CLUB RD. DECATUR, IL 62521 TELEPHONE (217) 422-5638 FAX (217) 425-4921 e-mail: info@kopetzmf.com			
WT. FULL OF PRODUCT: 179,276 LBS.					
VOL.: 10,000 GAL. (DESIGN S.G. = 1.5)					
REV. NO.	DESCRIPTION	DATE			
1	REV'D PER CLIENT COMMENTS	08/02/10 RDF			
2	PAINT WAS HT-403	10/08/10 RDF			
3	REV'D PER CLIENT COMMENTS AS-BUILT	12/07/10 RDF			
			(2) 120" I.D. x 196" T/T VERT. VESSEL EQUIP. # 101730 & 101731		
DWN: RDF			SHOP ORDER 10-060		REV.
CHKD: J.A.P.			110-060-A		



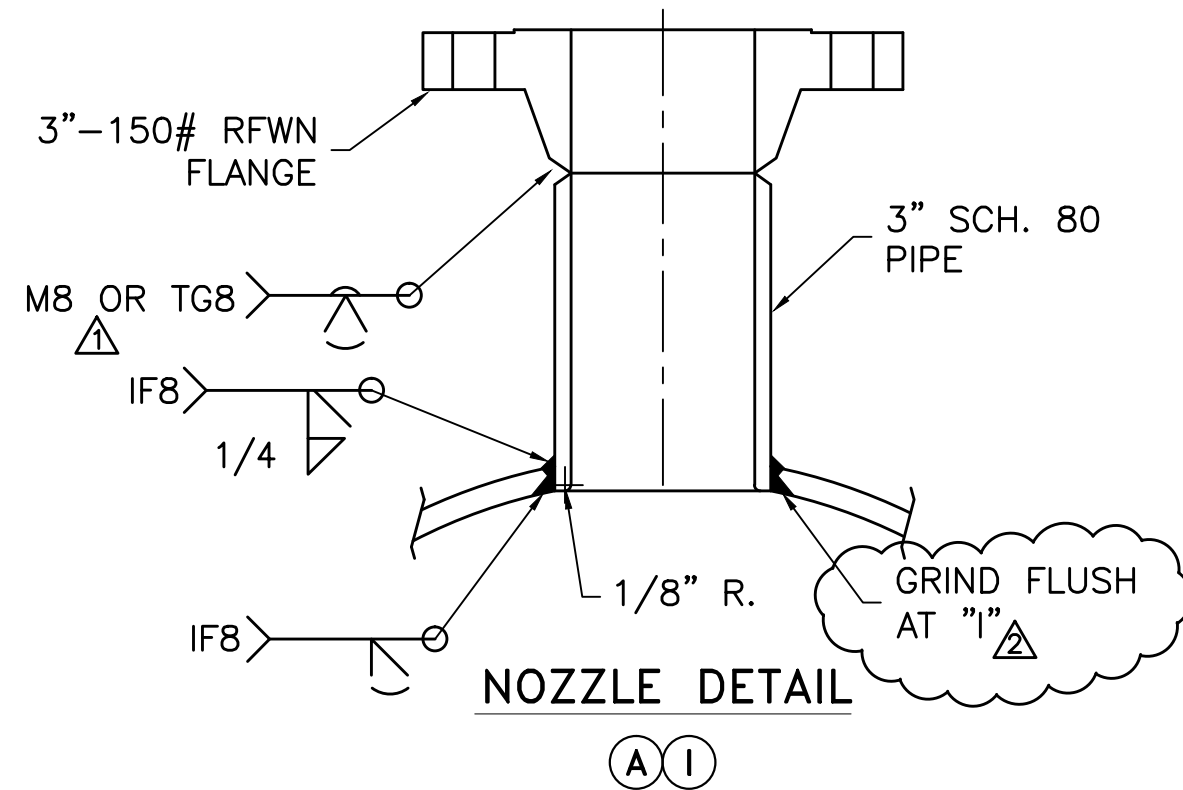
(2) REQUIRED
GRIND WELD SMOOTH UNDER PAD
X-RAY COVERED GIRTH



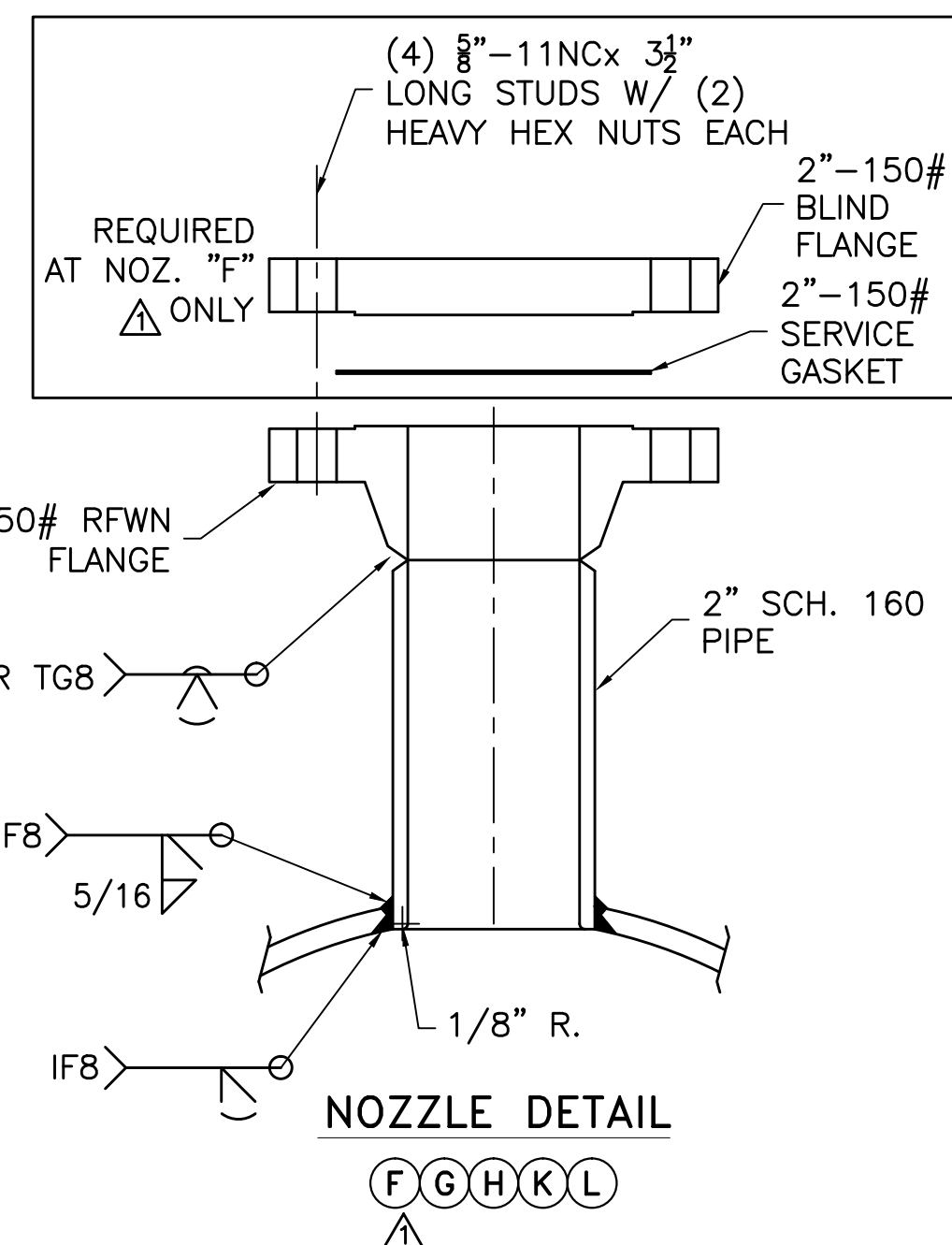
NOZZLE DETAIL
(D)



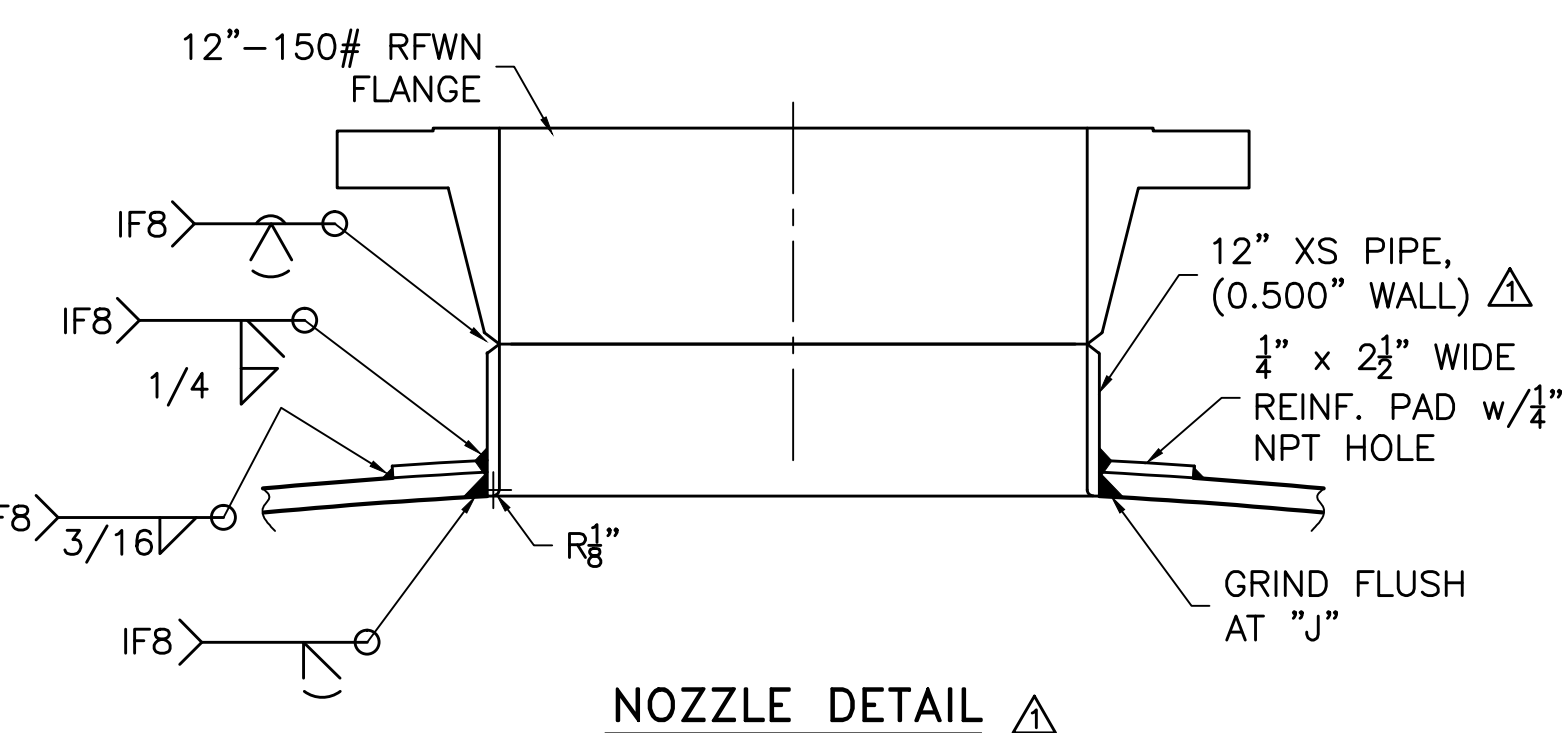
NOZZLE DETAIL
(F)



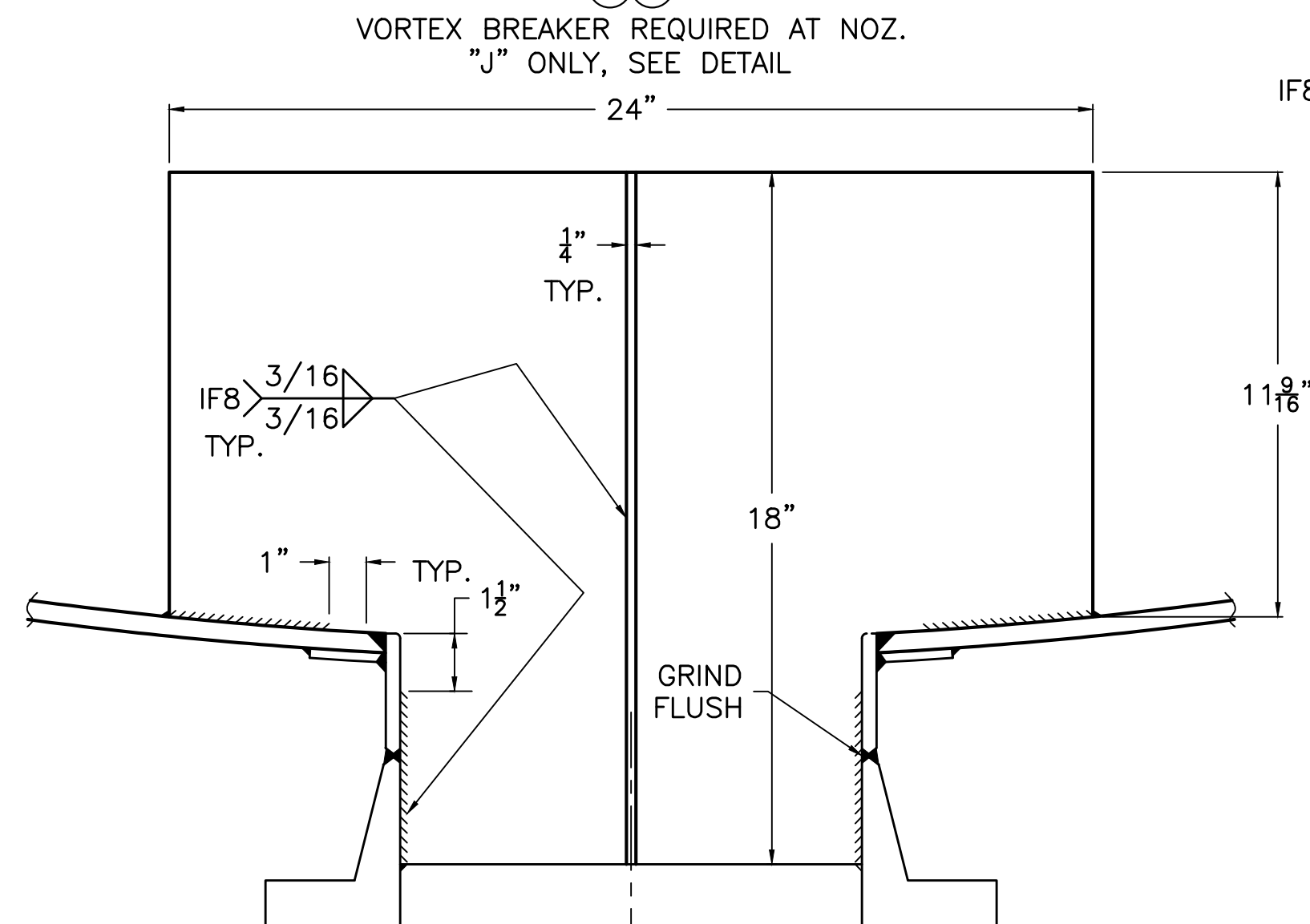
NOZZLE DETAIL
(A)



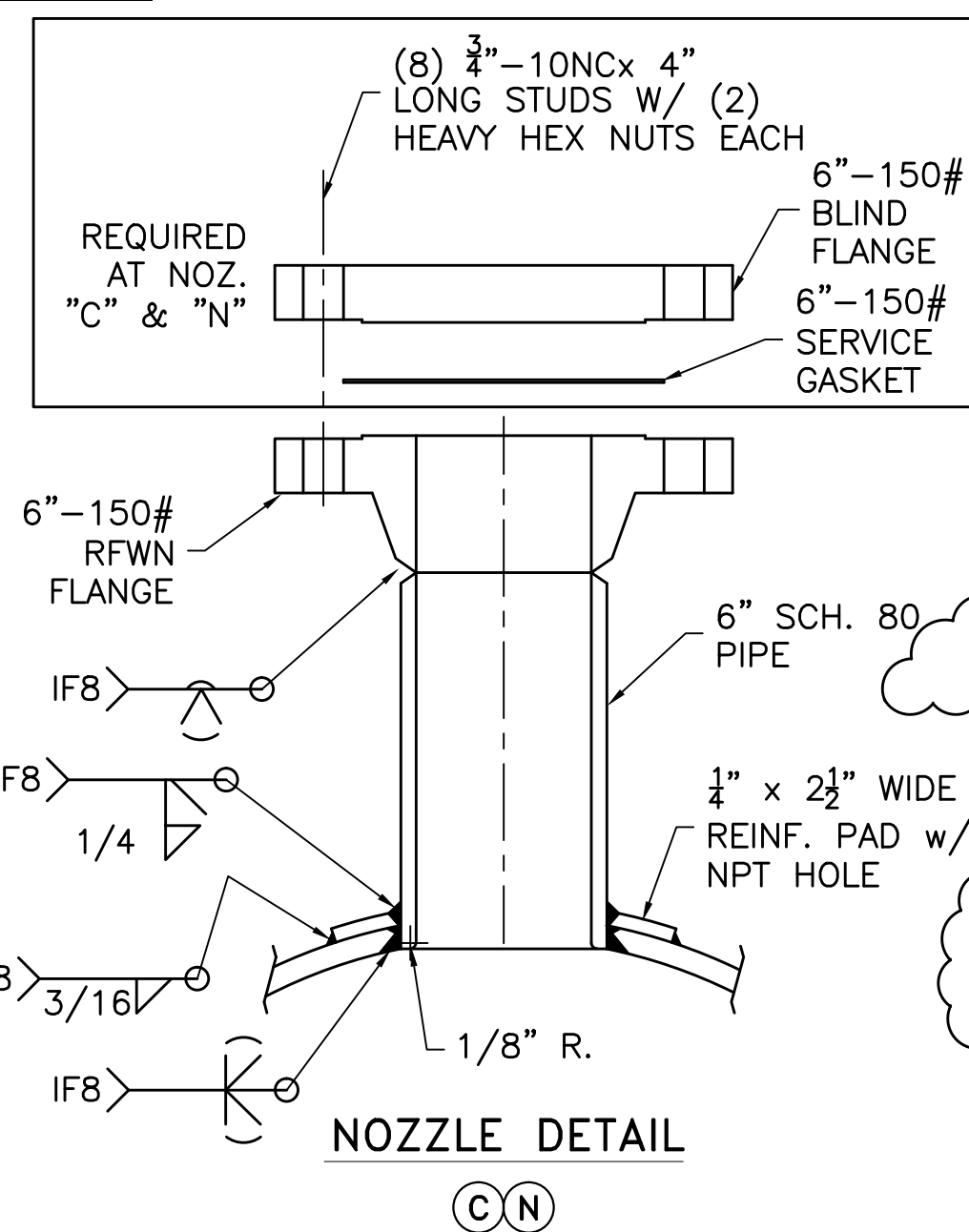
NOZZLE DETAIL
(G)



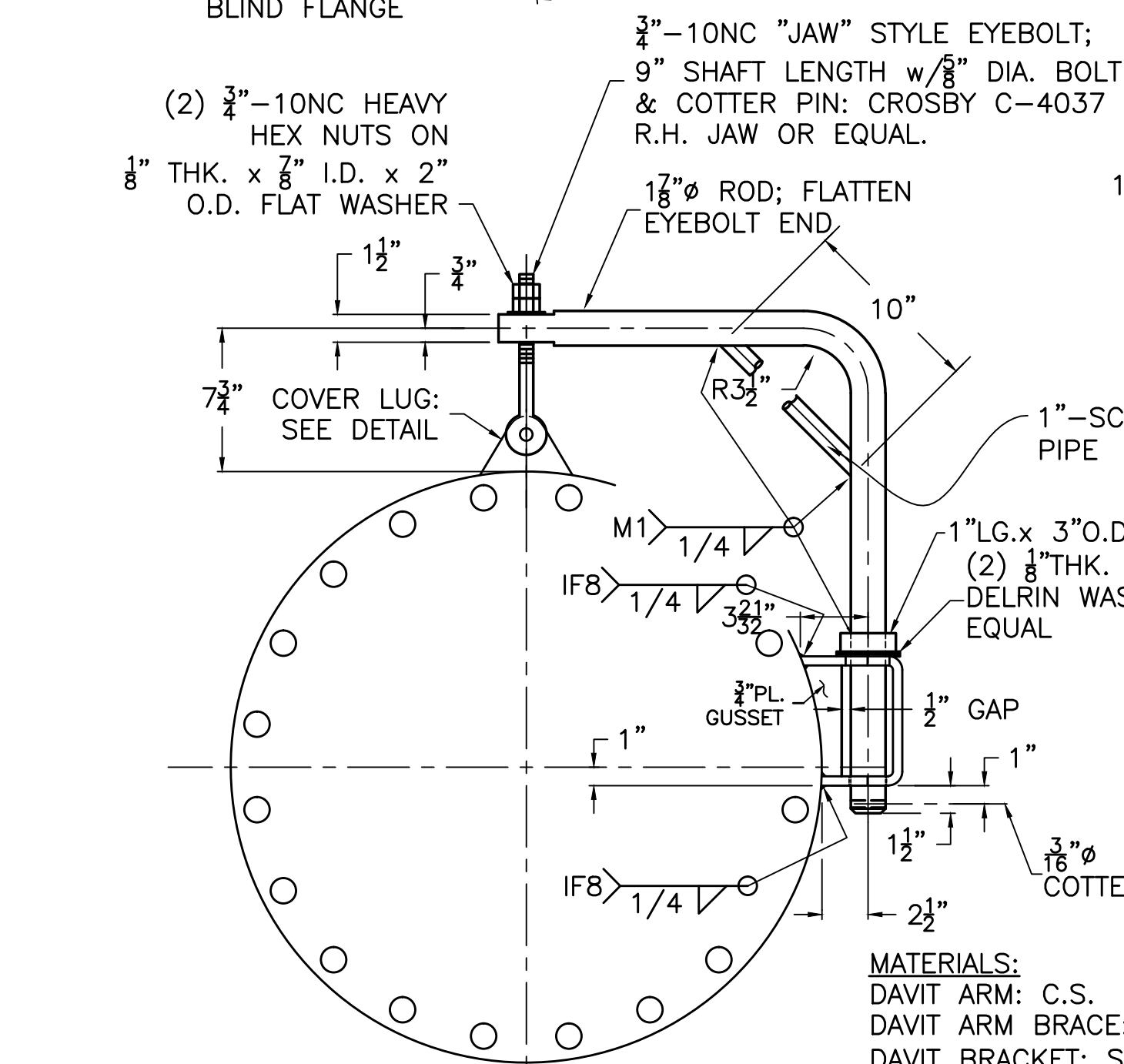
NOZZLE DETAIL
(B)



VORTEX BREAKER DETAIL

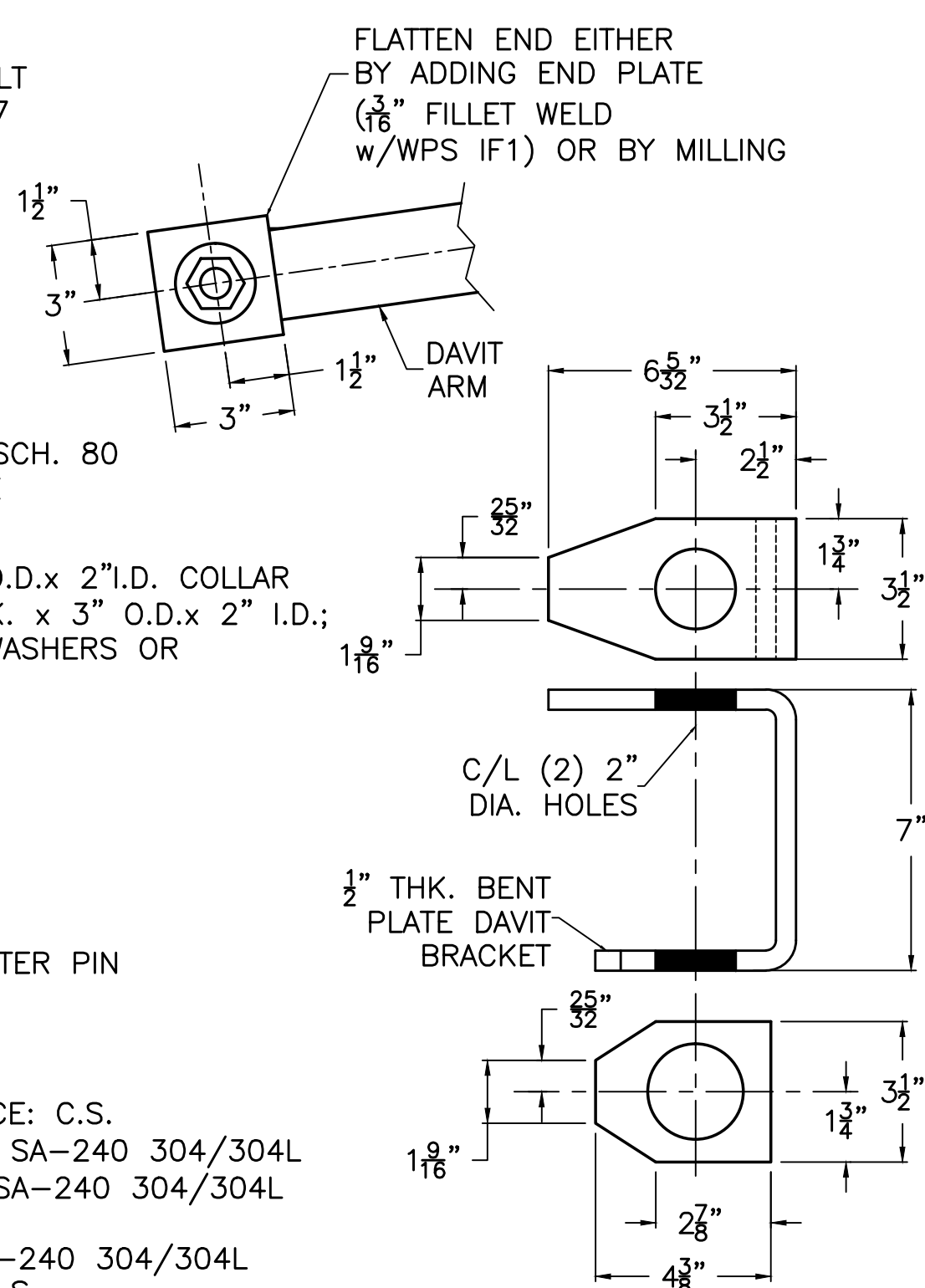


NOZZLE DETAIL
(C)

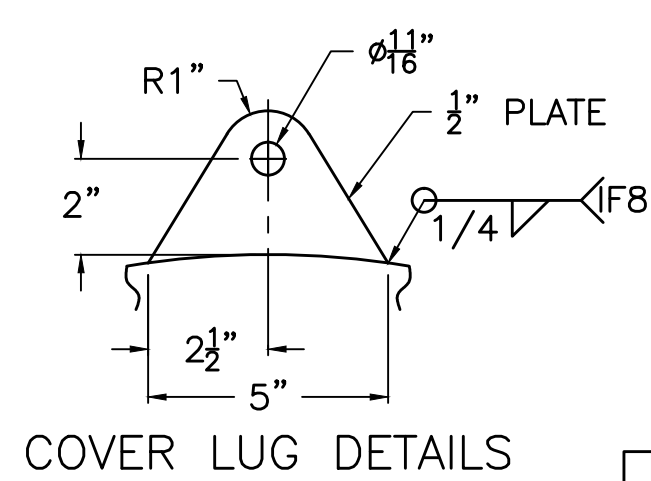


MANWAY DAVIT DETAILS
(1) REQ'D.

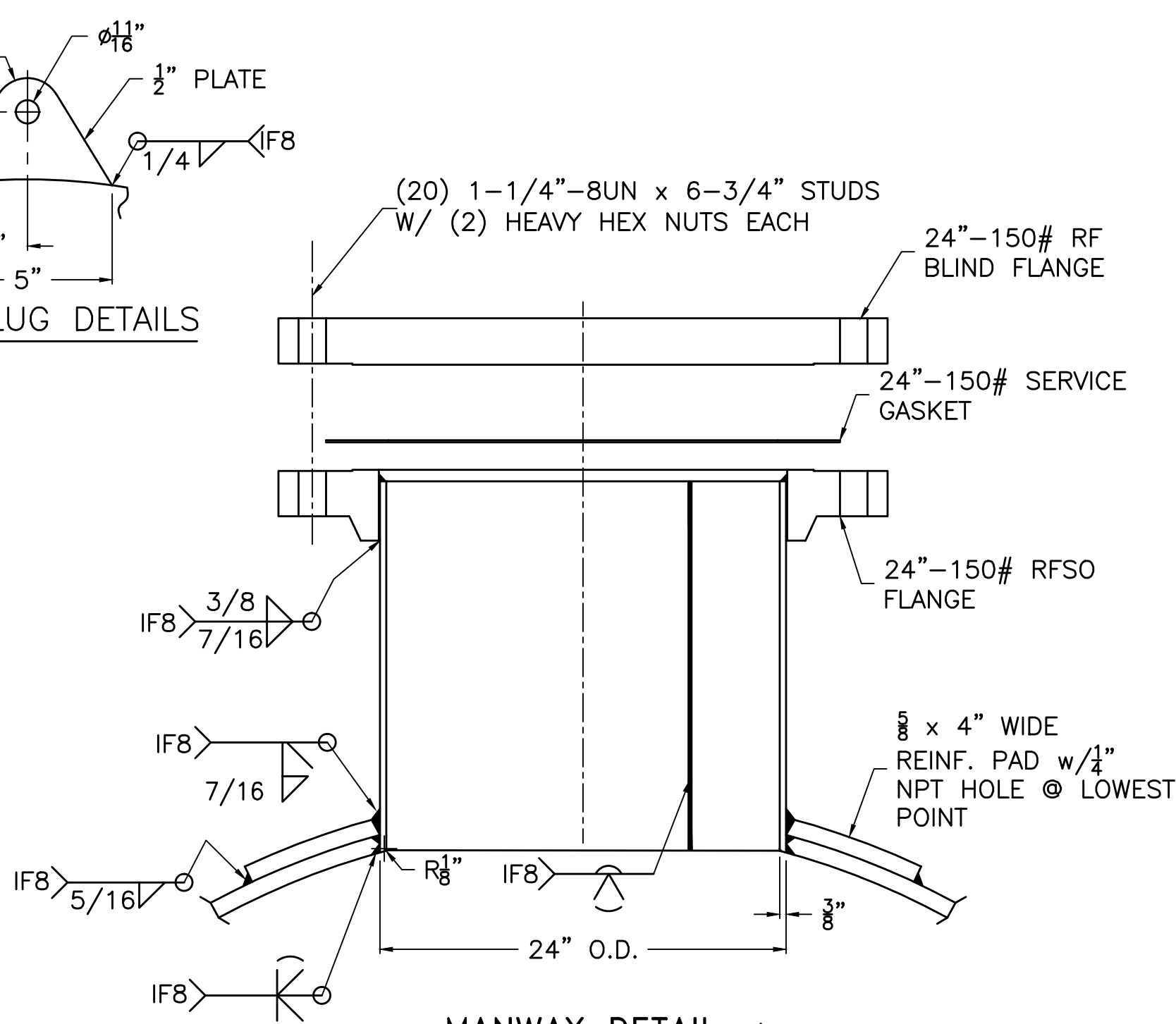
MATERIALS:
DAVIT ARM: C.S.
DAVIT ARM BRACE: C.S.
DAVIT BRACKET: SA-240 304/304L
DAVIT GUSSET: SA-240 304/304L
COLLAR: C.S.
COVER LUG: SA-240 304/304L
COTTER PINS: C.S.
EYEBOLT: C.S. (GALV.)
BOLT/NUTS/WASHER: C.S.



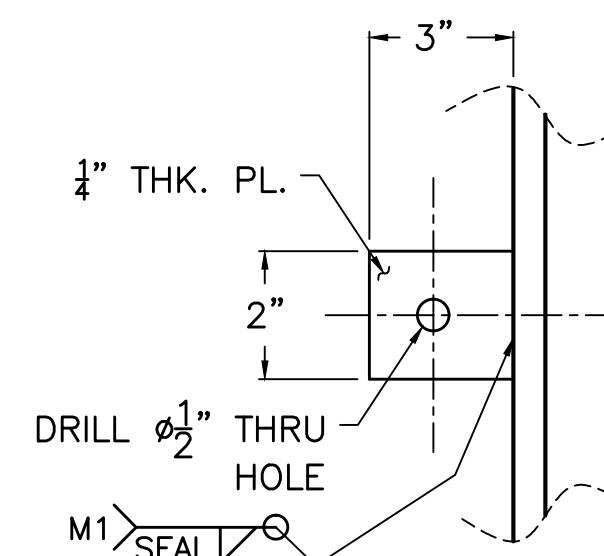
DAVIT BRACKET DETAIL



COVER LUG DETAILS



MANWAY DETAIL
(M)



GROUND LUG DETAIL

REV. NO.	DESCRIPTION	DATE
1	REV'D PER CLIENT COMMENTS	08/02/10 RDF
2	ADDED "GRIND FLUSH" TO "I" DELETED SHOP NOTE 6	10/12/10 J.A.P.
3	CHANGED NOTE 8 TO ALLOW PAD SPICE	10/19/10 RDF

ASME
CERTIFIED FOR CONSTRUCTION
DATE 10-02-10, [REDACTED]

KOPETZ
MFG., INC.

1500 N. COUNTRY CLUB RD.
DECATUR, IL 62521
TELEPHONE (217) 422-5638
FAX (217) 425-4921
e-mail: info@kopetzmfg.com

SHOP NOTES, NOZZLES & MISC. DETAILS
EQUIP. # 101730 & 101731

DWN: RDF	SHOP ORDER 10-060	REV.
CHKD: J.A.P.	L10-060-B	3
DATE: 06-28-10		

SHOP NOTES:

- HYDROTEST SHALL LAST A MINIMUM OF ONE (1) HOUR.
- SERVICE GASKETS MUST BE INSTALLED AT SERVICE BLINDS FOR HYDROTEST. DO NOT BREAK SERVICE BLINDED JOINTS AFTER HYDROTEST. IF THESE JOINTS ARE BROKEN AFTER HYDROTEST, PLEASE NOTIFY PURCHASING TO ACQUIRE NEW GASKET(S).
- PRIOR TO HYDROTESTING, THE VESSEL SHALL BE THOROUGHLY CLEANED OF ALL DIRT, WELD SPATTER, LOOSE SCALE, OIL AND ALL OTHER FOREIGN MATTER.
THE ONLY APPROVED SOLVENTS ARE CHLOROTHANE, TOLUENE & MEK. DO NOT USE WATER FOR CLEANING.
- DO NOT GRIND FINISHED WELDS UNLESS SPECIFIED ON DRAWINGS.

6. (officially deleted)

7. SEISMIC DESIGN PARAMETERS: SEISMIC DESIGN CATEGORY [C(SdS) = .325]; IMPORTANCE FACTOR (Ip) = 1.5; RELATIVE HEIGHT (z/h) = .079; AMPLIFICATION FACTOR (ap) = 1; RESPONSE MODIFICATION FACTOR (Rp) = 2.5.

8. ALL REINFORCEMENT PADS SHALL BE EITHER:

(a.) ONE-PIECE CONSTRUCTION OR

(b.) IF TWO-PIECE CONSTRUCTION, THEY MUST HAVE FULL-PEN. SPLICE WELDS, WITH TWO NPT HOLES NEAR THE LOWEST POINT.

SHIPMENT CHECKLIST:

1. ALL REINFORCING PADS AND BACKING PADS WITH 1/2" NPT HOLES SHALL BE PACKED WITH [REDACTED] RTV OR EQUAL PRIOR TO SHIPPING.

2. VESSEL SHALL BE IDENTIFIED BY STAMPING FACE-PLATE OF THE NAMEPLATE BRACKET PER DETAIL. THIS MUST BE DONE ON ANVIL OR TABLE PRIOR TO ATTACHMENT TO WEB.

3. PRIOR TO SHIPPING, LEAVE SERVICE BLIND, SERVICE GASKETS AND SERVICE BOLTING IN PLACE FOR NOZZLES "C, F, M & N". DO NOT APPLY LUBRICANTS OR SEALANTS OF ANY KIND TO GASKETS OR FLANGE FACES. COAT ALL SERVICE STUDS WITH [REDACTED]

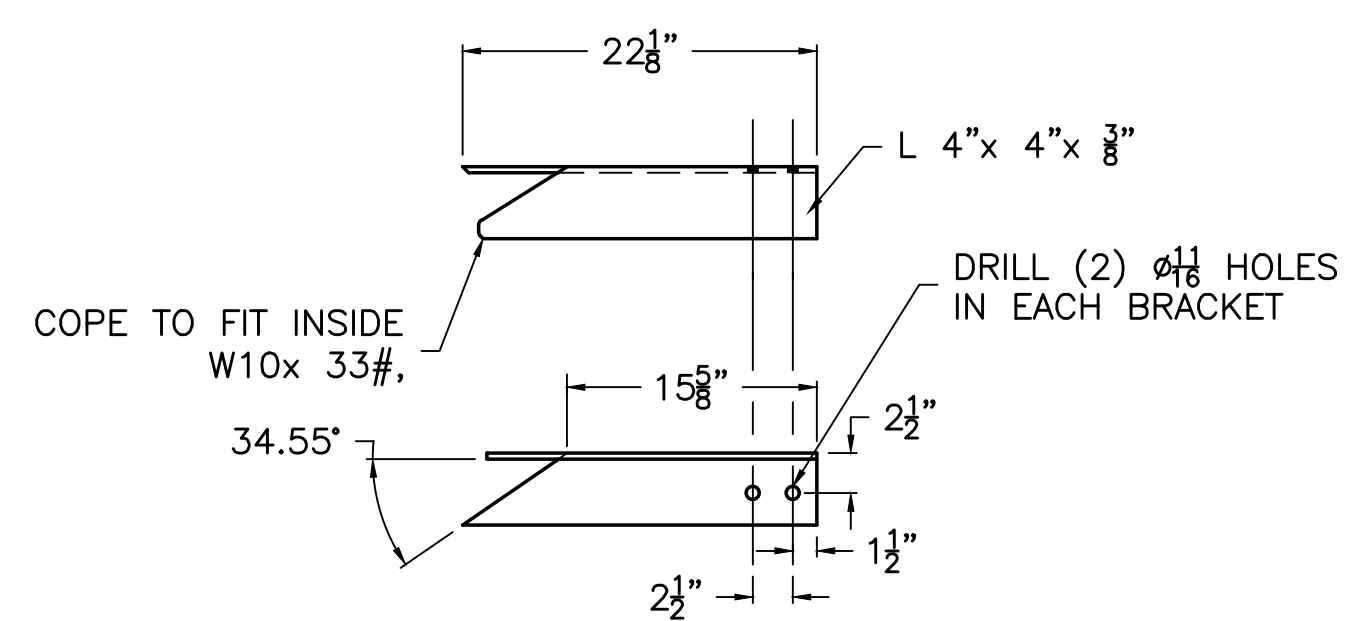
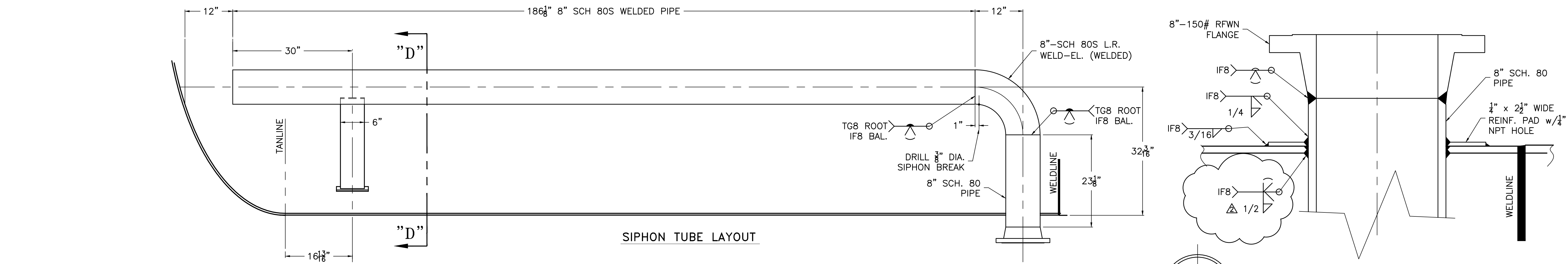
[REDACTED] COMPLETELY SEAL OFF ALL REMAINING FLANGE FACES OF VESSEL USING SHIPPING/PURGE COVERS. SHIPPING GASKETS AND A FULL COMPLEMENT OF SHIPPING STUDS AND HEX NUTS.

SPARE PARTS:

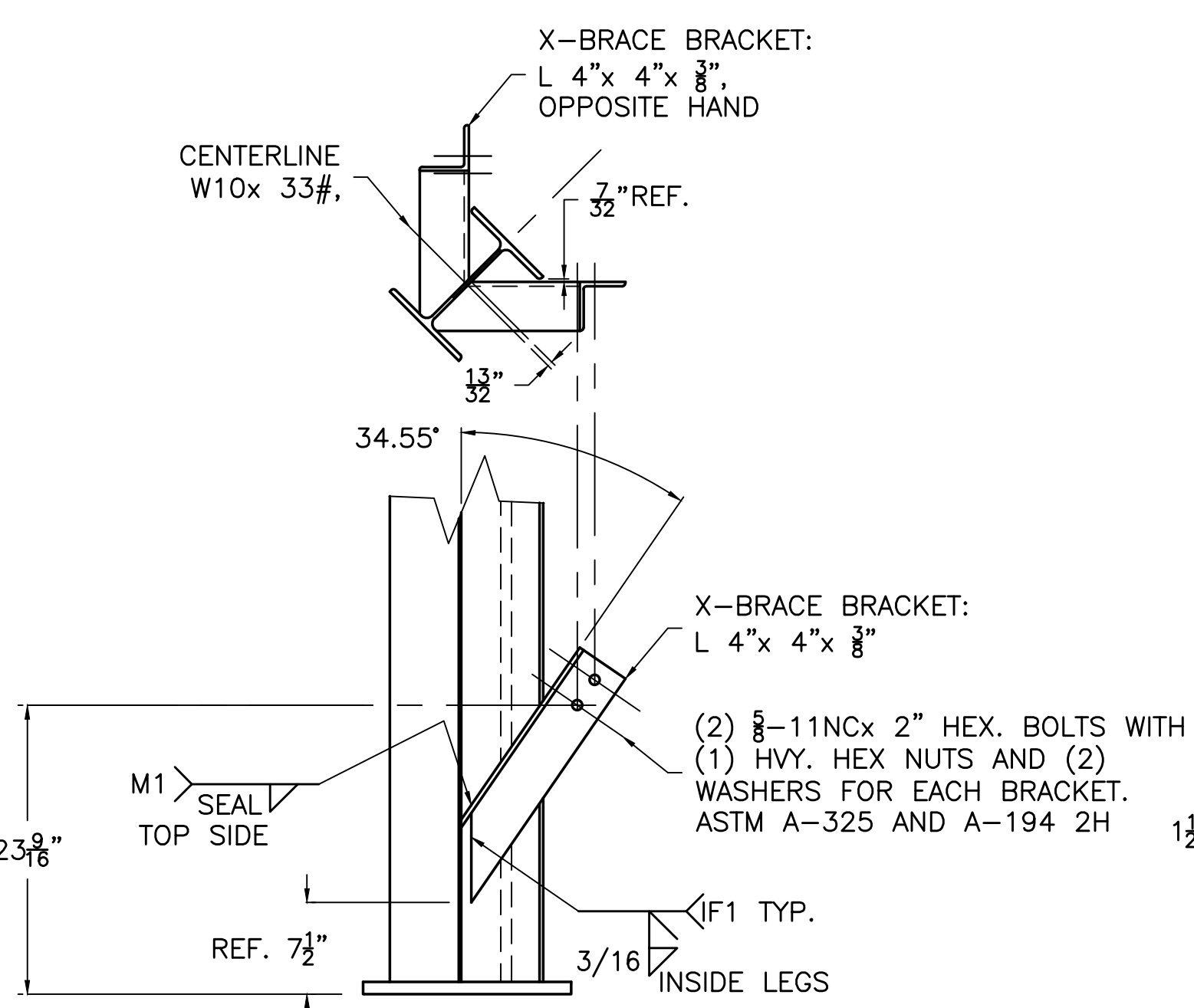
BOX AND TAG (2) SPARE GASKETS FOR EACH NOZZLE WITH A SERVICE BLIND, LABEL EACH CONTAINER WITH PURCHASE ORDER NUMBER AND EQUIPMENT NUMBER.

HOLD POINTS: HYDROSTATIC TEST

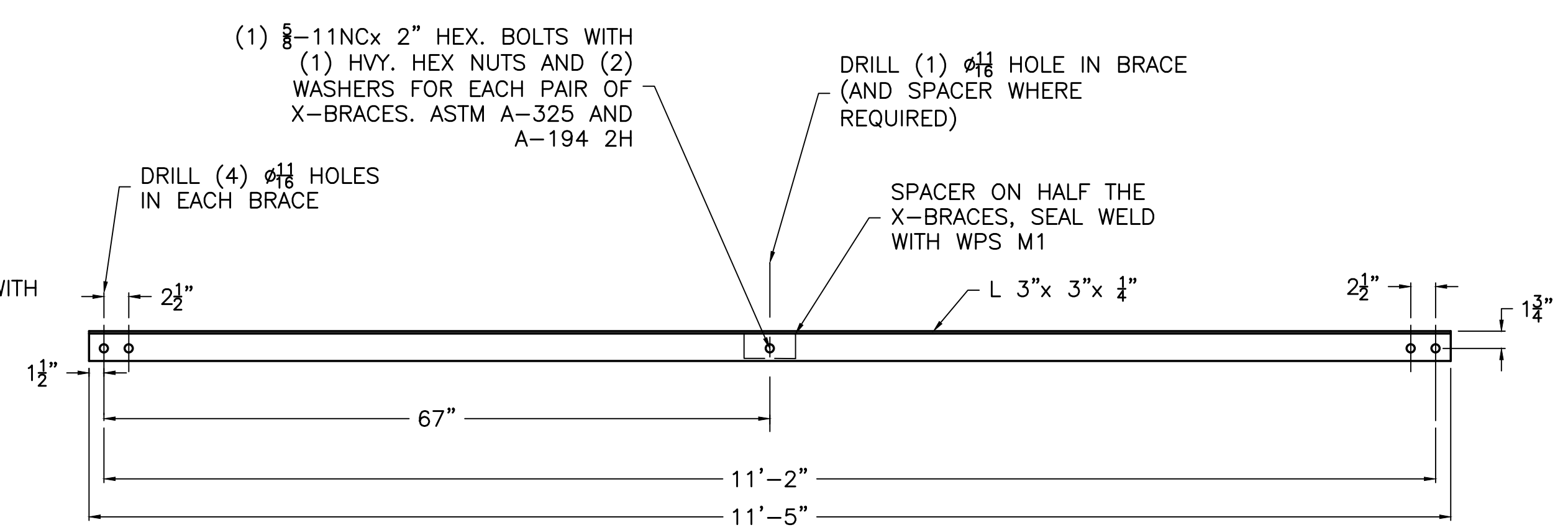
HYDROSTATIC TEST



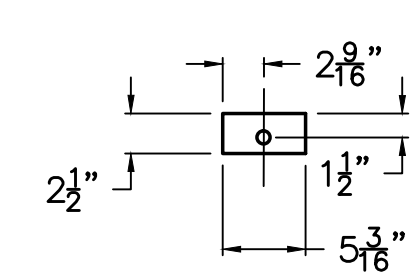
X-BRACE BRACKET DETAIL
(16) TOTAL REQUIRED FOR VESSEL, (8) OPPOSITE HAND.



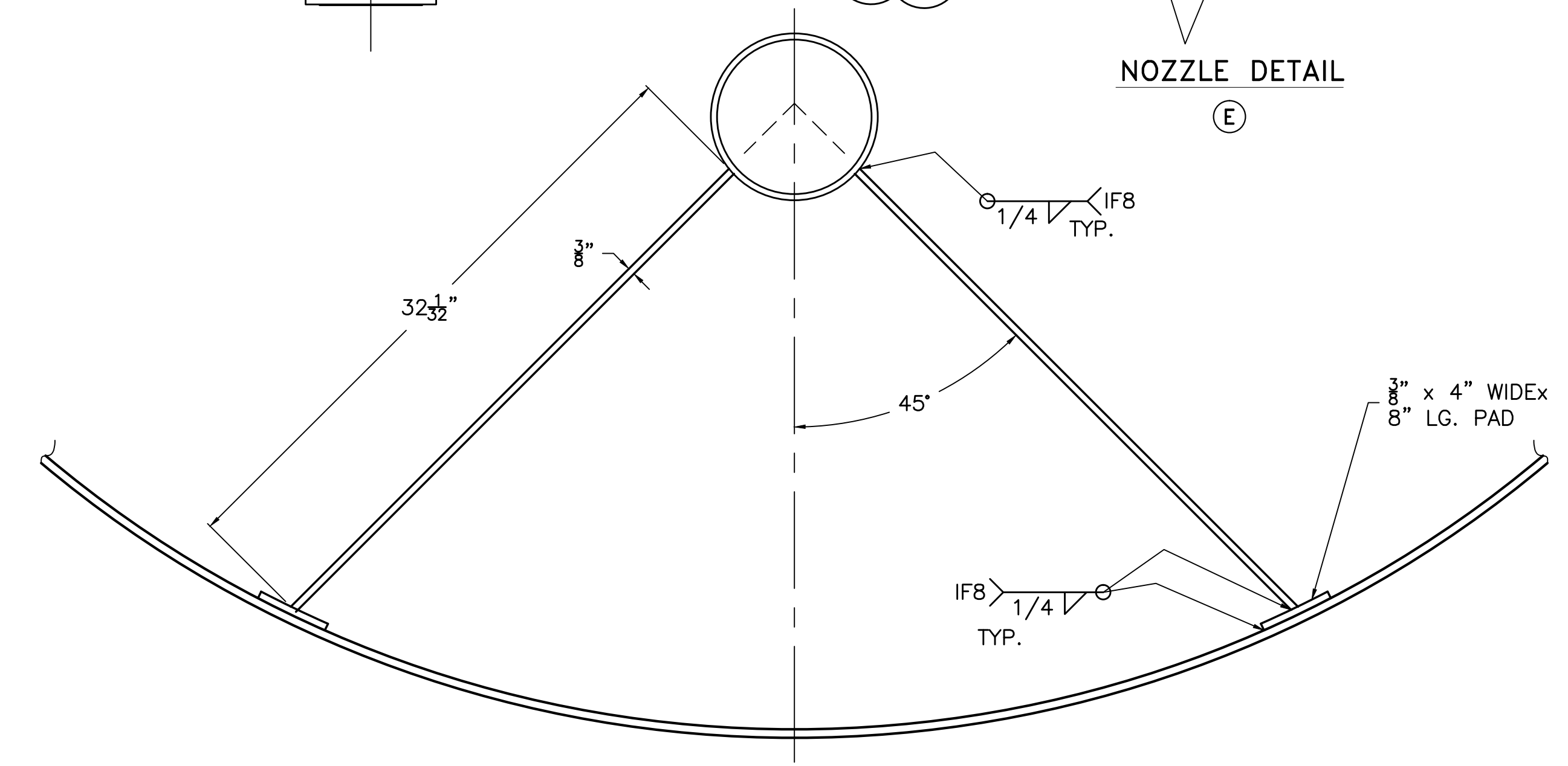
X-BRACE BRACKET ATTACHMENT
ASSEMBLE BRACING AND BRACKETS, THEN FIT AND WELD TO LEGS. (16) TOTAL REQUIRED FOR VESSEL, (8) OPPOSITE HAND.



X-BRACE DETAIL
MATERIAL: ASTM A-36 ANGLE
(8) REQUIRED, (4) WITH SPACER ATTACHED



SPACER DETAIL
MATERIAL: 3/8" THK./ ASTM A-36, (4) REQUIRED



SECTION "D-D"

ASME
CERTIFIED FOR CONSTRUCTION
DATE 10-02-10, [REDACTED]

REV. NO.	DESCRIPTION	DATE	<div> <p>KOPETZ MFG., INC. 1500 N. COUNTRY CLUB RD. DECATUR, IL 62521 TELEPHONE (217) 422-5638 FAX (217) 425-4921 e-mail: info@kopetzmf.com</p> </div>
Δ	REV'D PER CLIENT COMMENTS	07/31/10 RDF	
Δ	INTERIOR FILLET AT "C" WAS 3/8"	10/10/10 RDF	<div> <p>SIPHON PIPE/NOZZLE & PLATFORM CLIP DETAILS EQUIP. # 101730 & 101731</p> </div>
DWN: RDF		SHOP ORDER 10-060	REV.
CHKD: J.A.P.		L10-060-C	2
DATE: 06-28-10			