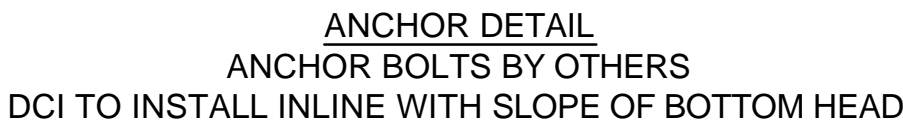


1 TO PREVENT FOAMING, WHIPPING, OR OTHER PRODUCT DAMAGE,
A VARIABLE FREQUENCY DRIVE (INVERTER) SHOULD BE INSTALLED ON
THIS AGITATOR MOTOR TO ADJUST THE ROTOR SPEED FOR LOW OR
INTERMEDIATE OPERATING LEVELS. THIS VARIABLE FREQUENCY
DRIVE IS ALSO TO BE SET TO SOFT START AND STOP THE MOTOR.
CORRECT AMP DRAW AND OTHER SETTINGS MUST BE CORRECTLY
PROGRAMMED IN THE VFD. DCI WILL NOT WARRANTY DAMAGE CAUSED
BY INCORRECT VFD PROGRAMMING.



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NOZZLE SCHEDULE	ITEM NO.	NOZZLE ACCESSORIES
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DCI, INC. SHALL NOT BE RESPONSIBLE FOR THE CORROSION RESISTANCE OF EQUIPMENT OR ANY RESULTING DAMAGES. IT IS THE PURCHASER'S RESPONSIBILITY TO SPECIFY THE CORROSION RESISTANCE CONSTRUCTION SPECIFICATION FOR THE INTENDED APPLICATION(S). CONSULTATION WITH QUALIFIED PERSONNEL IN MATERIAL SELECTIONS IS HIGHLY RECOMMENDED.

2 WHERE "COMPLETE SEAL WELDS" VS. THE USE OF "EXPANSION ISOLATION SEALS" ON THE OUTSIDE SHEATHING ARE USED, CRACKING WILL BE EXCLUDED FROM THE WARRANTY DUE TO THE EXCESSIVE THERMAL AND MECHANICAL STRESSES OF THE EQUIPMENT UNDER NORMAL OPERATING CONDITIONS.

3 ALL TOLERANCES ARE IN ACCORDANCE WITH THE LATEST EDITION OF THE "ASME" BOILER AND PRESSURE VESSEL CODE, SECTION VIII, DIVISION 1, 2007 EDITION, 2008 ADDENDA, AND DCI STANDARD VESSEL TOLERANCES DRAWING 020000.

4 ALL ASME WELDING TO BE DONE BY ASME QUALIFIED WELDERS.

5 ALL ASME WELDING PROCEDURES ARE IN ACCORDANCE WITH ASME CODE UW-28.

6 ASME CODE JURISDICTION ENDS AT THE FIRST SEALING SURFACE EXCLUDING MANWAY.

7 VESSEL AND/OR HEAT TRANSFER SURFACE DESIGNED IN ACCORDANCE WITH THE LATEST EDITION OF THE "ASME" BOILER AND PRESSURE VESSEL CODE, SECTION VIII, DIVISION 1, 2007 EDITION, 2008 ADDENDA.

8 VESSEL AND/OR HEAT TRANSFER SURFACE TO BE HYDROSTATICALLY OR PNEUMATICALLY TESTED PER UG-99. CHECK FOR DEFECTS, REPAIR AND RETEST IF NECESSARY.

9 SUITABLE PRESSURE AND/OR VACUUM RELIEF DEVICES MUST BE INSTALLED BY CUSTOMER FOR OPERATION OF VESSEL AND/OR HEAT TRANSFER SURFACE.

10 ALL FLANGES WILL HAVE BOLT HOLES STRADDLE THE 0°-180° AND 90°-270° CENTERLINES, UNLESS SPECIFIED OTHERWISE.

11 NOZZLES AND/OR OPENINGS IN VESSELS, SHALL NOT BE LOCATED IN OR WITHIN .5" OF WELD SEAMS IN HEADS AND/OR SHELLS WITHOUT PRIOR ENGINEERING APPROVAL. THE VESSEL OPENING IS IN OR WITHIN 0.5" OF WELD SEAM, AN ADDITIONAL ENGINEERING CALCULATION AND/OR X-RAY MAY BE REQUIRED TO MEET UW-14 REQUIREMENTS.

12 ALL REINFORCEMENT PADS MUST BE PROVIDED WITH (1) 1/8 DIA. WEEP HOLE LOCATED AT THE LOWEST POINT WHEN THE VESSEL IS IN ITS NORMAL OPERATING POSITION.

13 ALL CUSTOMER SUPPLIED PARTS MUST HAVE PROPER IDENTIFICATION AND PART IN ITS NORMAL OPERATING POSITION (EXAMPLE: PARTIAL DATA), AND MILL TEST REPORTS BEFORE BEING WELDED TO VESSEL.

14 PRODUCTION TO PROVIDE PROTECTION FOR ALL NOZZLES AND FITTINGS PRIOR TO SHIPMENT. VESSEL MUST BE ADEQUATELY VENTED.

15 FINAL BORE OF 25MM INGOLD FITTINGS ID TO .985"-.998" AFTER WELDING. (WHEN APPLICABLE)

16 NOZZLE END I.D. SURFACES HAVE A MINIMUM 1/16 RADIUS.

DCI SURFACE FINISH DEFINITIONS:
A= AS IS WELD OR MATERIAL
C= COLOR CLEANED WELD
BB = BEAD BEHIND WELD OR MATERIAL
HRP = HOT ROLLED PLATE MATERIAL
2B = COLD ROLLED BRIGHT MILL MATERIAL
2D = COLD ROLLED DULL MILL MATERIAL
NUMERIC VALUE = RA
NUMERIC VALUE + "E" = RA AFTER FINAL ELECTRO-POLISH.
WELD FINISH SAME AS BASE MATERIAL UNLESS NOTED OTHERWISE, EX: 3270 (BASE/WELD).

DCI TO PERFORM THE FOLLOWING TESTS AND PROCEDURES:
X-7033-7 : HYDROSTATIC PRESSURE TEST
X-7033-7 : BASIC SURFACE FINISH TEST
X-7065-3 : BPE DRAINAGE TEST PROCEDURE

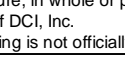
MATERIAL CERTS REQUIRED FOR THE FOLLOWING:
☒ PRESSURE VESSEL COMPONENTS
☒ REMOVABLE ACCESSORIES/WETTED PARTS
☐ AGITATOR SEALS
*ADDITIONAL COSTS APPLY

CRN FOR DIMPLE JACKET AND DIMPLE JACKET FLANGES TO BE DETERMINED

TANK MAY BE LIFTED WITH HOLD-DOWN LUGS.

CUSTOMER TO INSTALL ON SLOPED PAD

OVERFLOW LINE TO BE 6" FROM OUTLET CENTER.

TITLE 40,000 LTR ISOLATES SILO, TK-720002			
DCI ORDER NO.: CS27312		QTY. REQ.: 1	
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DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED			
		SCALE: 1/16" DO NOT SCALE DRAWING	
PRODUCTION CCH		APPROVAL CCH	
DATE 2/01/10		DATE 1/20/10	
ST. CLOUD, MN		PROJ. MAN. SAH	
SHEET 1 OF 2		PREFIX DRAWING NO. REV	
014-01		JSA4784 B	


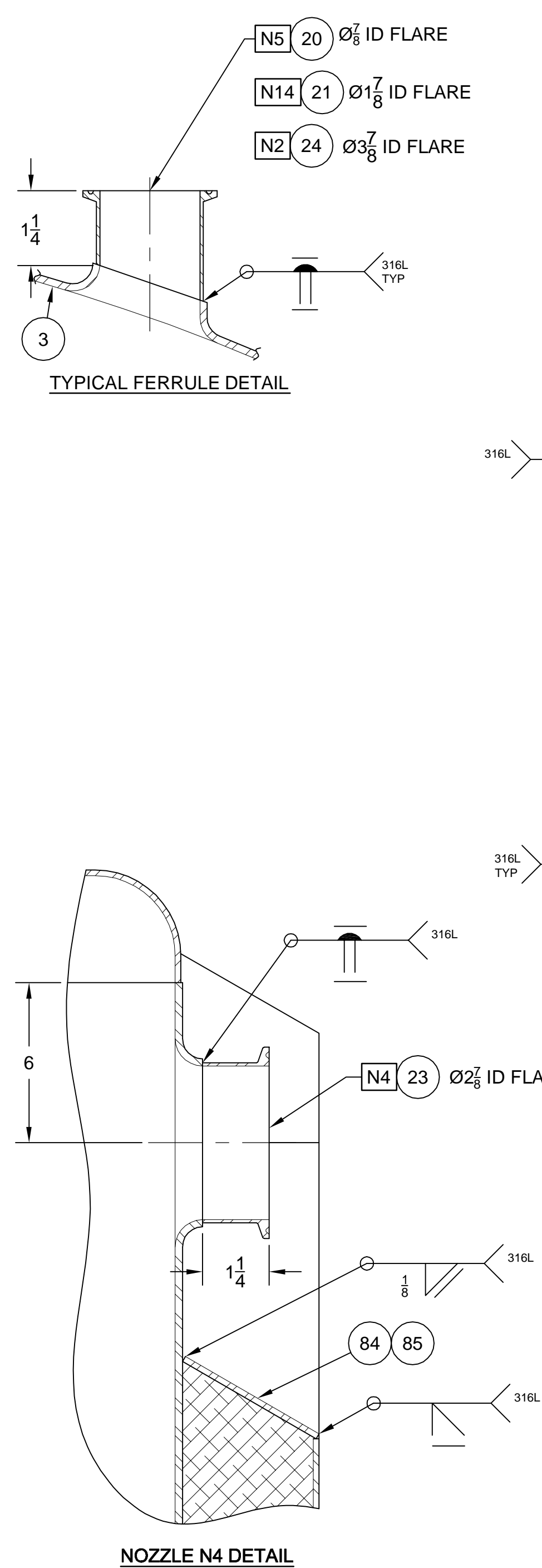
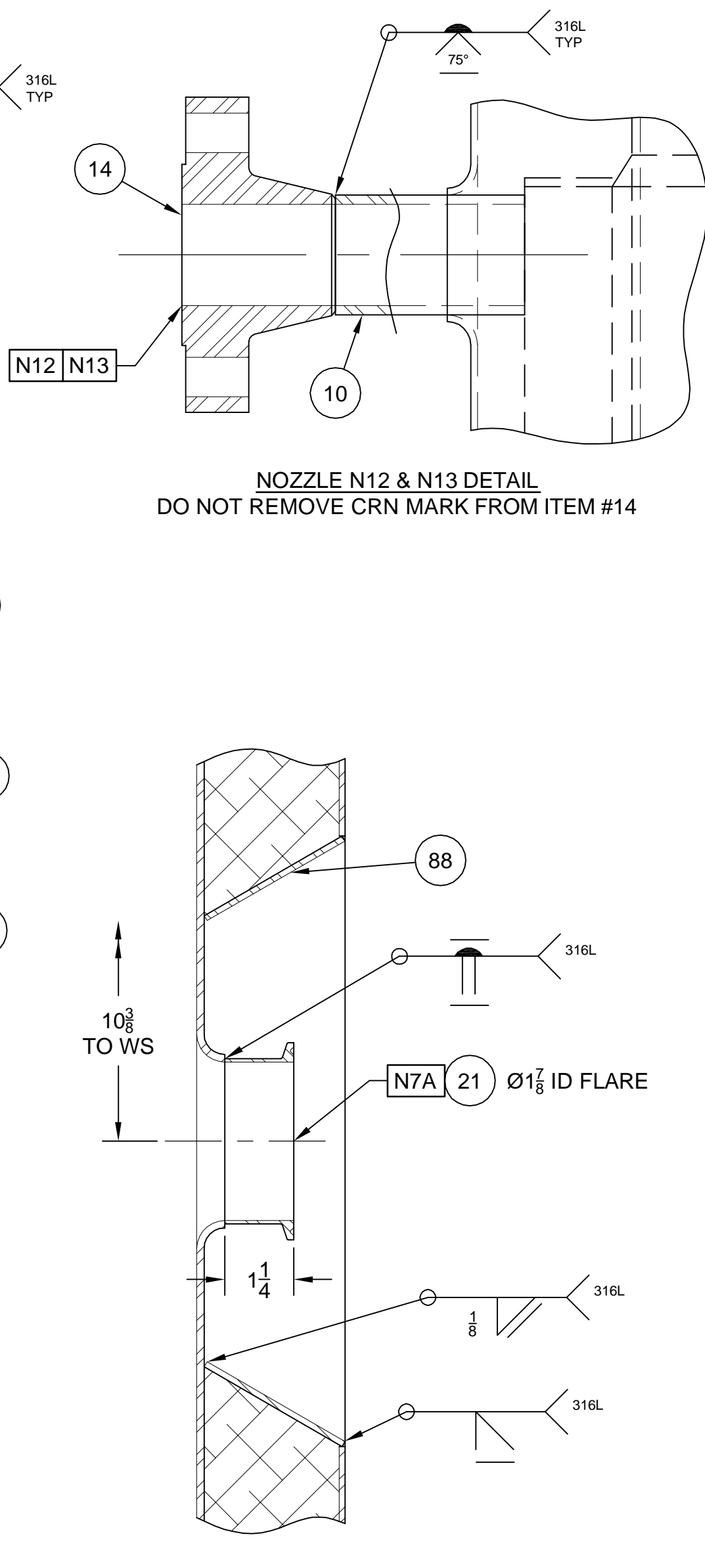
 ST. CLOUD, MN	SCALE: 1/16		DO NOT SCALE DRAWING	
	PRODUCTION CCH		APPROVAL CCH	
	DATE 2/01/10		DATE 1/20/10	
	PREFIX 014-01		DRAWING NO. JS4784	
SHEET 1 OF 2			PROJ. ENG. GSM	
			PROJ. MAN. SAH	
			REV B	

Diagram showing two adjacent circles labeled 30 and 31.



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ENG. _____

Q.C. _____

A.I. Acceptance _____

TITLE	40,000 LTR ISOLATES SILO, TK-72002
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DCI ORDER NO.: CS27312		QTY. REQ.: 1	
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DIMENSIONS ARE IN INCHES UNLESS SPECIFIED			
	SCALE: N/A	DO NOT SCALE DRAWING	
	PRODUCTION CCH	APPROVAL CCH	PROJ. ENG. GSM
	DATE 2/01/10	DATE 1/20/10	PROJ. MAN. SAH
	PREFIX 014-01	DRAWING NO. 1S4784	REV
ST. CLOUD, MN			
SHEET 2 OF 2			

SY. CROSS-DIM.	PREFIX	DRAWING NO.	REV
SHEET 2 OF 2	014-01	JS4784	B

