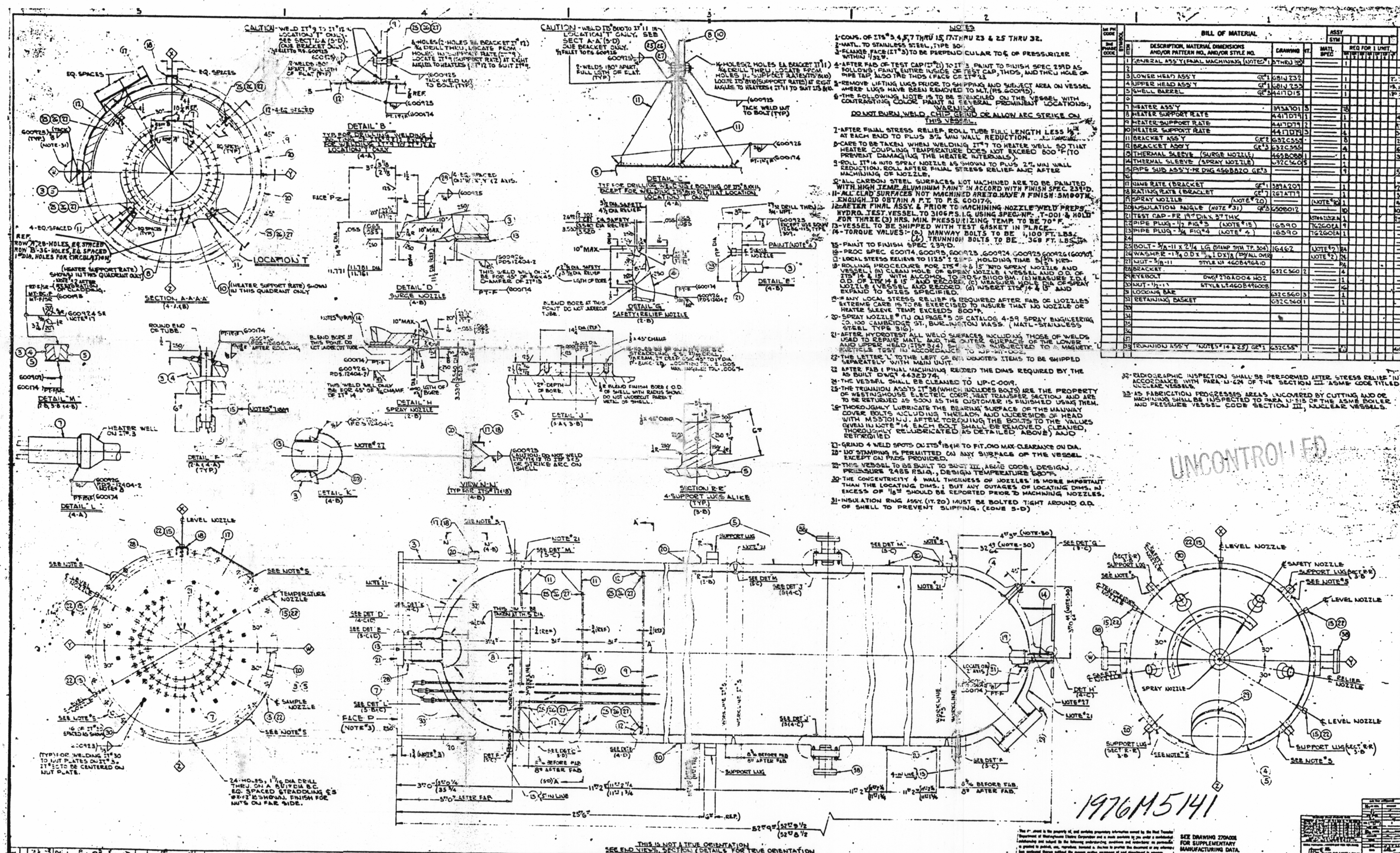




1. COILS OF 2 1/2" 3.4, 5.7 THRU 15.7 THRU 23 & 25 THRU 32.
2. MATERIAL TO STAINLESS STEEL, TYPE 304.
3. FLANGE FACE (17) TO BE PERPENDICULAR TO FACE OF PRESSURIZER.
4. AFTER FAB OF TEST CAP (17) TO IT, PAINT TO FINISH SPEC 234D AS FOLLOWS: PAINT ENTIRE INSIDE OF TEST CAP, THUS, AND THRU HOLE OF PIPE TAP ALSO THE INSIDE OF TEST CAP, THUS, AND THRU HOLE OF PIPE TAP.
5. REMOVE LIFTING LUGS TO SPRING AND SUBJECT AREA ON VESSEL WHERE LUGS HAVE BEEN REMOVED TO M.T. (R.S. 60015).
6. THE FOLLOWING NOTE IS TO BE CHECKED ON THE VESSEL WITH CONTRASTING COLOR PAINT IN SEVERAL PROPOSED LOCATIONS:
- DO NOT BURN, WELD, OR CUT OR ALLOW ARC STRIKE ON THIS VESSEL.
7. AFTER FINAL STRESS RELIEF, ROLL TUBE FULL LENGTH LESS 1/4" AT EACH END TO PLUS 3/4" MIN WALL REDUCTION.
8. CARE TO BE TAKEN WHEN WELDING IT TO HEATER WELL SO THAT HEATER COUPLING TEMPERATURE DOES NOT EXCEED 800°F TO PREVENT DAMAGING THE HEATER INTERFACES.
9. ROLL IT IN AND SPRAY NOZZLE AS SHOWN TO PLUS 2 1/4" MIN WALL REDUCTION. ROLL AFTER FINAL STRESS RELIEF AND AFTER MACHINING OF NOZZLE.
10. ALL CARBON STEEL SURFACES NOT MACHINED ARE TO BE PAINTED WITH HIGH TEMP ALUMINUM PAINT IN ACCORD WITH FINISH SPEC 234D.
11. ALL CLAD SURFACES NOT MACHINED ARE TO HAVE A FINISH: 3M007K.
12. AFTER FINAL ASSY. & PRIOR TO MACHINING NOZZLE WELD PREP, HYDRO TEST VESSEL TO 3106 PSI, USING SPEC. N.P. 1-001 & HOLD FOR THREE (3) HRS. MIN. PRESSURIZING TEMP. TO BE 70°F.
13. VESSEL TO BE SHIPPED WITH TEST GASKET IN PLACE.
14. TORQUE VALUES: (A) MAINWAY BOLTS TO BE 1100 FT. LBS. (B) TORQUE VALUES: (C) MAINWAY BOLTS TO BE 368 FT. LBS.
15. PAINT TO FINISH SPEC 234D.
16. PROC SPEC 60014, 60015, 60016, 60017, 60018, 60019, 60020, 60021, 60022, 60023, 60024, 60025, 60026, 60027, 60028, 60029, 60030, 60031, 60032, 60033, 60034, 60035, 60036, 60037, 60038, 60039, 60040, 60041, 60042, 60043, 60044, 60045, 60046, 60047, 60048, 60049, 60050, 60051, 60052, 60053, 60054, 60055, 60056, 60057, 60058, 60059, 60060, 60061, 60062, 60063, 60064, 60065, 60066, 60067, 60068, 60069, 60070, 60071, 60072, 60073, 60074, 60075, 60076, 60077, 60078, 60079, 60080, 60081, 60082, 60083, 60084, 60085, 60086, 60087, 60088, 60089, 60090, 60091, 60092, 60093, 60094, 60095, 60096, 60097, 60098, 60099, 60100.
17. LOCAL STRESS RELIEF IS REQUIRED AFTER FAB OF NOZZLES EXTREME CARE IS TO BE EXERCISED TO INSURE THAT NO NOZZLE OF HEATER SLEEVE TEMP. EXCEEDS 800°F.
18. SPRAY NOZZLE 1/4" O.D. X 1/4" I.D. X 1/4" L. SPRAY ENGINEERING CO. 100 CAMBRIDGE ST. BURLINGTON, MASS. 01803.
19. AFTER HYDROTEST, ALL WELD SURFACES INCLUDING THOSE OF WELDS USED TO REPAIR WELD AND THE OUTER SURFACES OF THE LOWER AND UPPER HEATER SLEEVES ARE TO BE INSPECTED BY A MAGNETIC PARTICLE TEST IN ACCORDANCE TO UP-100.
20. THE LETTER 'L' TO THE LEFT OF OR ABOVE ITEMS TO BE SHIPPED SEPARATELY WITH MAIN UNIT.
21. AFTER FINAL MACHINING, REEDED THE DIMS. REQUIRED BY THE VESSEL SHALL BE CLEANED TO UP-100.
22. THE TRANSFER ASSY. (17) (WHICH INCLUDES BOLTS) ARE THE PROPERTY OF WESTINGHOUSE ELECTRIC CORP. HEAT TRANSFER SECTION AND ARE TO BE RETURNED AS SOON AS THE CUSTOMER IS FINISHED USING THEM.
23. THOROUGHLY LUBRICATE THE BEARING SURFACE OF THE MAINWAY COVER BOLTS INCLUDING THE LUGS AND THE UNDERSIDE OF HEAD COVER BOLTS. AFTER TIGHTENING THE BOLTS TO THE VALUES GIVEN IN NOTE 14, EACH BOLT SHALL BE REMOVED, CLEANED, THOROUGHLY REOIL, AND REOILED (AS DETAILED ABOVE) AND RETIGHTENED.
24. GRIND & WELD SPOTS OUTS 1/8" MIN TO FIT .000 MAX CLEARANCE ON DIA.
25. NO STAMPING IS TO BE PERMITTED ON ANY SURFACE OF THE VESSEL EXCEPT ON FACE PROVIDED.
26. THIS VESSEL TO BE BUILT TO SECTION III, ASME CODE, DESIGN PRESSURE TABS 250.1, DESIGN TEMPERATURE 600°F.
27. THE CONCENTRICITY & WALL THICKNESS OF NOZZLES IS MORE IMPORTANT THAN THE LOCATING DIMS. BUT ANY OUTAGES OF LOCATING DIMS. IN EXCESS OF 1/4" SHOULD BE REPORTED PRIOR TO MACHINING NOZZLES.
28. INSULATION RING (17) (20) MUST BE BOLTED TIGHT AROUND O.D. OF SHELL TO PREVENT SWELLING. (SEE 3-D).

BILL OF MATERIAL		ASSY		REQ FOR 1 UNIT	
ITEM NO.	DESCRIPTION, MATERIAL, DIMENSIONS AND/OR PATTERN NO. AND/OR STYLE NO.	DRAWING	MT.	SYM.	REQ FOR 1 UNIT
1	GENERAL ASSY (FINAL MACHINING) (NOTE 1)	3THD 30			
2	LOWER HEAD ASSY	GE1 5814232			
3	SUPPLIER HEAD ASSY	GE1 5814233			
4	SHELL BARREL	GE1 5814234			
5	HEATER ASSY	345A101			
6	HEATER SUPPORT RAYS	4411014			
7	HEATER SUPPORT RATE	4411015			
8	HEATER SUPPORT RATE	4411016			
9	BRACKET ASSY	GE1 5814235			
10	BRACKET ASSY	GE1 5814236			
11	THERMAL SLEEVE (SURGE NOZZLE)	442B001			
12	THERMAL SLEEVE (SPRAY NOZZLE)	571C503			
13	PIPE SUB ASSY (R.D.G. 456B202) GE1	571C503			
14	NAME RATE (BRACKET)	GE1 381A201			
15	BRASS RATE (BRACKET)	GE1 261A111			
16	SPRAY NOZZLE (NOTE 10)	571C503			
17	INSULATION ANGLE (NOTE 31)	GE1 5808012			
18	TEST CAP - FR 1/4" DIA. 37 THY	5814237			
19	PIPE PLUG - 1/4" DIA. 3 (NOTE 15)	16590			
20	PIPE PLUG - 1/4" DIA. 4 (NOTE 4)	16590			
21	BOLT - 3/4" X 2 1/4" LG. SHIP 2H TP 304	16462			
22	WASHER - 1 1/4" O.D. X 1 1/4" I.D. X 1/4" THY	16462			
23	NUT - 3/4" I.D. X 1 1/4" LG. SHIP 2H TP 304	16462			
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UNCONTROLLED

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Attachment to IPN-02-024
RR 3-16, Rev. 1
D-4