



GEN. NOTES CONT'D.
 13. WHEN LIFTING BOX, USE LIFTING BEAM D199050
 DO NOT LIFT WITH COVER PLUGS IN PLACE (ALSO SEE NOTE ON VIEW D-D)
 14. HYDRO TEST BOX BY FILLING WITH WATER & HOLDING FOR 24 HOURS
 15. FOR PAINTING SEE DWG W800784

ANALYZE FOR SAFETY, ECOLOGY, AND MINIMUM ESSENTIAL DESIGN

GENERAL NOTES:
 1. MATERIAL: BOYA INTERIOR PIES TO BE 304L SS, PER 300M EXTERIOR MUST BE 316 CHROME/NI, AND WILL BE DESIG. WITH 'S'. ALL CORE PIPING WILL BE 304L CORE EVAL. PER SPEC. 4482. PIPING OTHER 304L PIPING TO BE COMM. QUALITY PER SW 300M (CORR. EVAL. NOT REQ'D).
 2. WELDING: 5/5 TO 5/5 PER SPEC. SW 1W C.S. 5/5 PER SPEC. 5G 5/15 5/5 TO C.S. PER SPEC. SW 20.1W USING E309 OR E310 ELECTRODES.
 3. ALL UNDERPIN METAL SURFACES IN CONTACT WITH EARTH TO BE COATED 3BB WRAPPED PER SRP STD. 7797 SYST. C.
 4. FABRICATION TO BE IN ACCORDANCE WITH DUPONT STD. SGE5
 5. HYDROSTATIC TEST ALL CORE PIPE PER SPEC. 4482 CODE P 48
 6. DYE CHECK ALL PENETRATION WELDS THRU VALVE BOX & BOTTOM CLOSURE WELDS & ALL LIFTING LUG WELDS.
 7. BREAK ALL SHARP EDGES
 8. NO CORROSION ALLOWANCE REQ'D EXCEPT ON BRING PER PIPING SPEC. 4482.
 9. WGT. WITHOUT COVER 18,500 LBS.
 10. ROLLER SLOTS TO BE CHECKED FOR SMOOTH ROLLER TRAVEL BEFORE FINAL ASSEMBLY.

D 189542 LAST 49 REV. 11. CORR. EVAL. HAS BEEN WAIVED ON 3/4" DIA. GRAYLOC HUBS AND ALL VALVES.
 NOTES: CONTINUED @ (A-20)
 BEVEL PIPE END FOR WELDING. TAPER BASE CORE PIPE TO MATCH SCH 40S PIPE.
 6" SCH. 40S PIPE FOR NOZZ. A, B, E & F (JCKT.)
 1" SCH. 40S PIPE & 1" SCH. 40S L.R. WELD ELL. (NOZZ. A & B ONLY)
 SECTION E-E

D 189542 LAST 49 REV. TYPE 27
SAVANNAH RIVER PLANT
BLDG 241 H DWPF SLUDGE
PRECIPITATE TRANSFER
VALVE BOX DETAIL SH. 1
PROCESS TK 49

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REVISION			REVISED			CHKD			APPD			DATE			PROJ. NO.			REVISION			REVISED			CHKD			APPD			DATE			DWGS			STDS			TOLERANCES ON ALL DIMENSIONS, UNLESS OTHERWISE NOTED, TO BE:			PROJECT 951780			SCALE 1/2"=1'-0" UNLESS NOTED			DATE: 10-31-95			DRAWN BY: SAVANNAH			CHECKED: JOHN RILEY			APPROVED: [Signature]			APPROVED: [Signature]			E. I. DU PONT DE NEMOURS & CO., INC. WILMINGTON, DELAWARE ENGINEERING DEPARTMENT			D 189542		
41						951780	27						49			951780	28						951780	1-4						W800784	5G 55	ANGLES ± 0°30'			DECIMALS: 1-PLACE ± 0.05 IN. 2-PLACE ± 0.01 IN. 3-PLACE ± 0.005 IN.			APPROVED: [Signature] 3/11/95			APPROVED: [Signature]			E. I. DU PONT DE NEMOURS & CO., INC. WILMINGTON, DELAWARE ENGINEERING DEPARTMENT			D 189542																					
48						951780	28						34			951780	29						951780	12						4482-148	5W 17 W	FRACTIONS ± 1/16"																																				
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THE PHOTOGRAPHIC LINES ON THIS TRACING MAY BE REMOVED WITH A WET ERASER