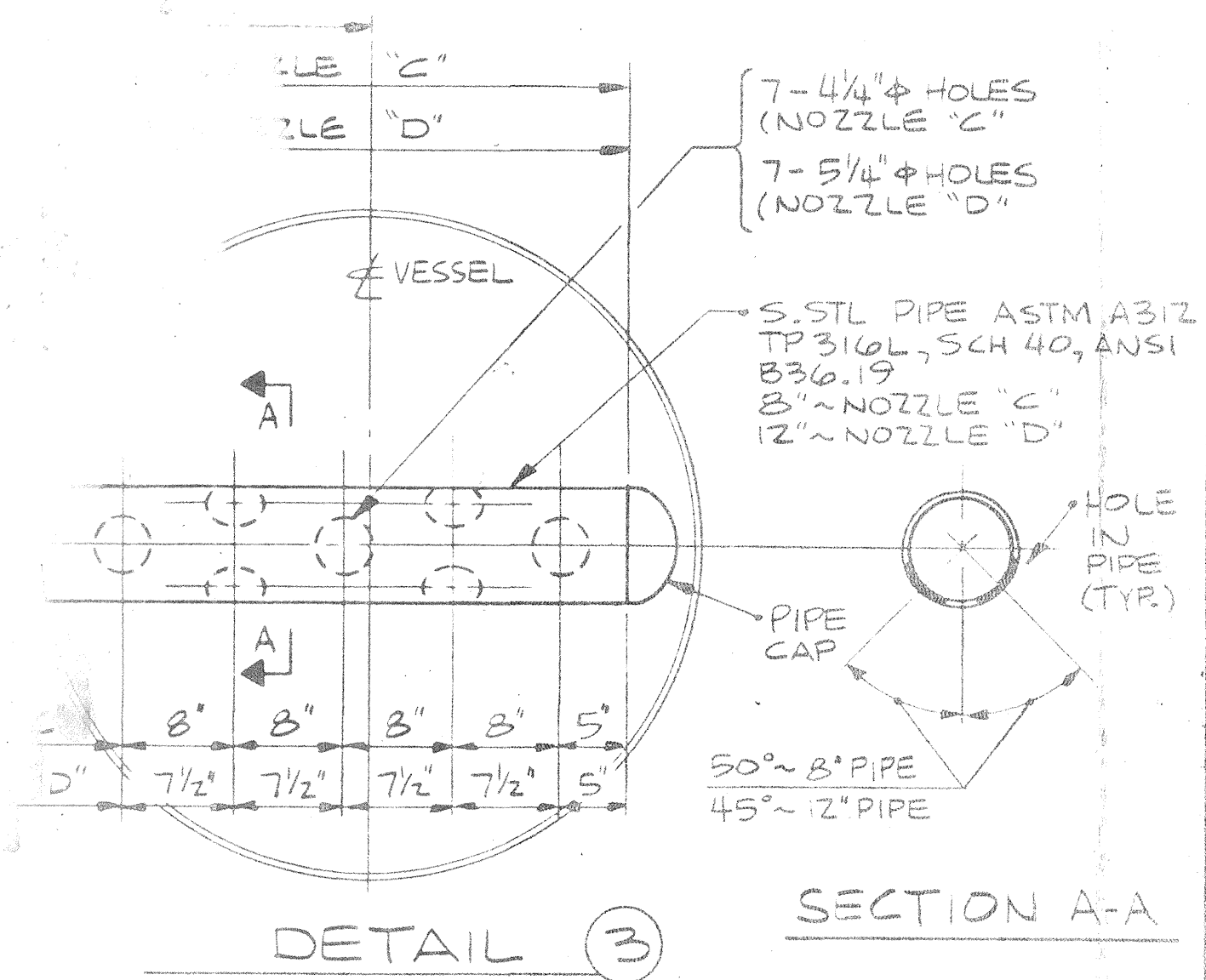
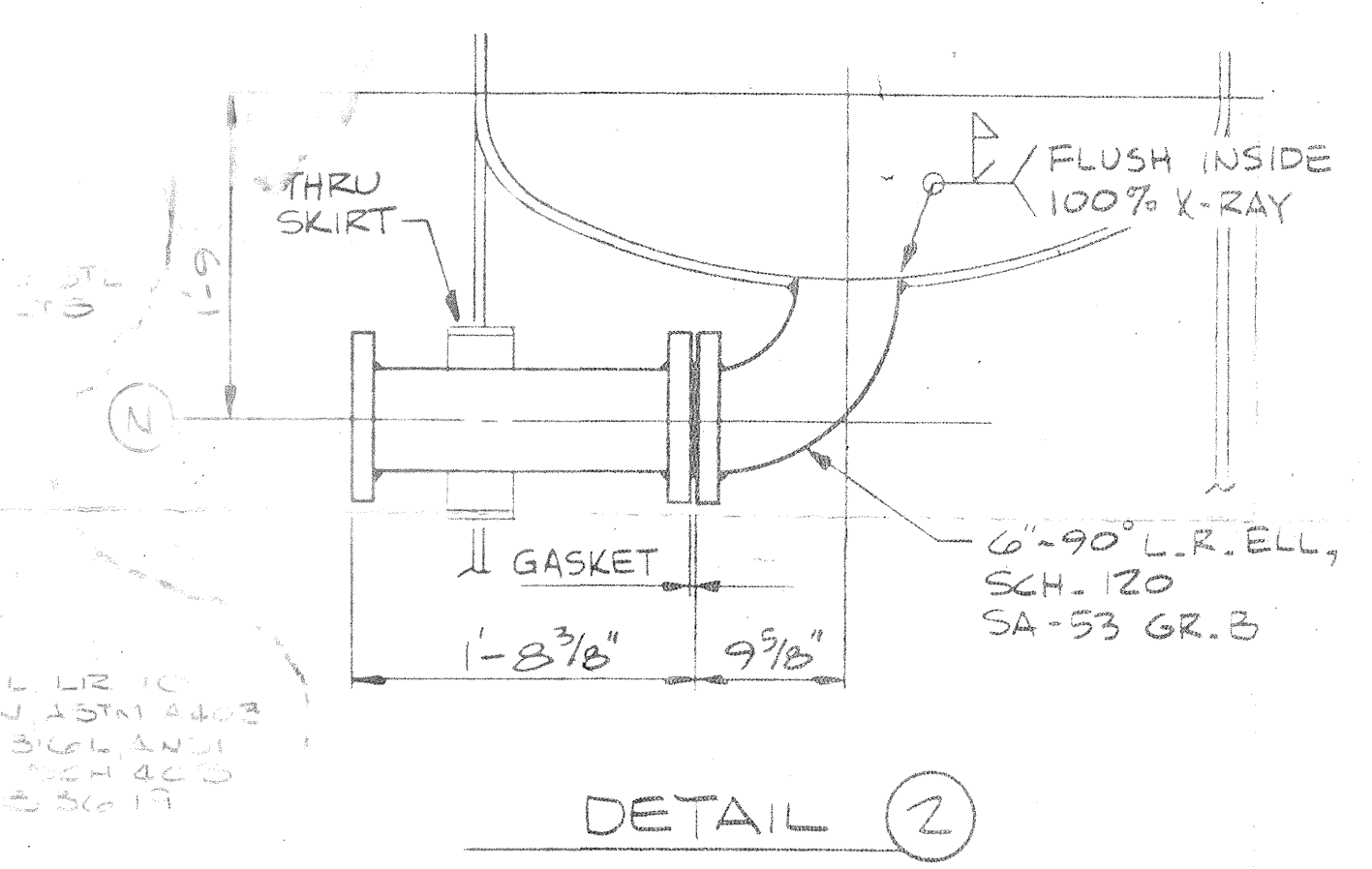
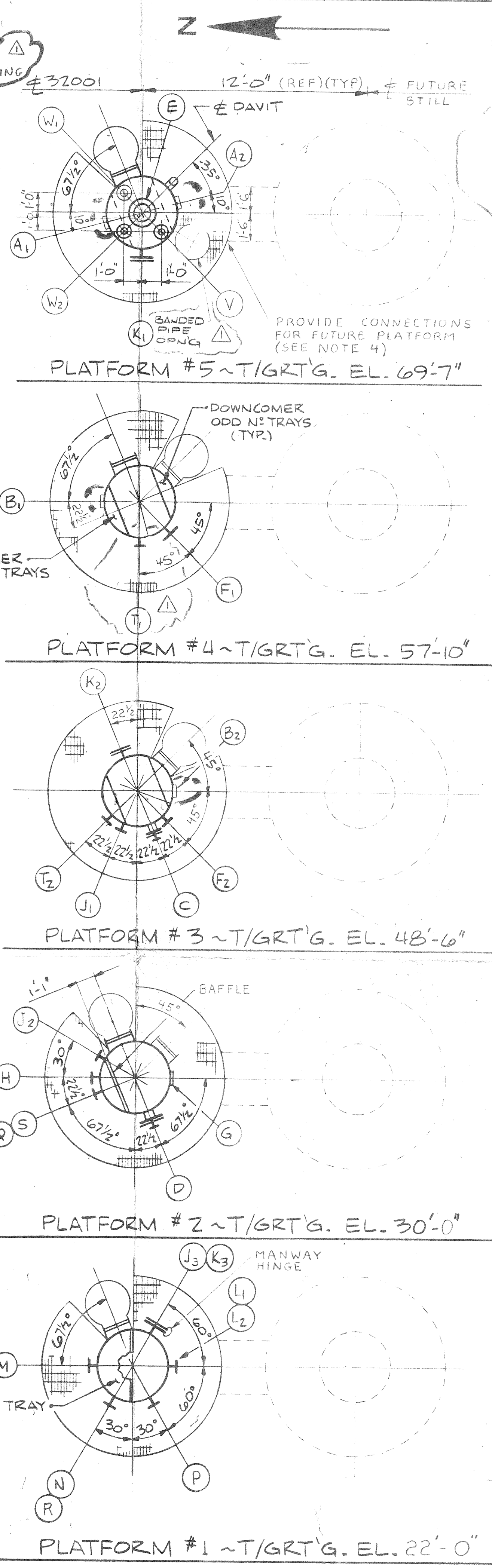
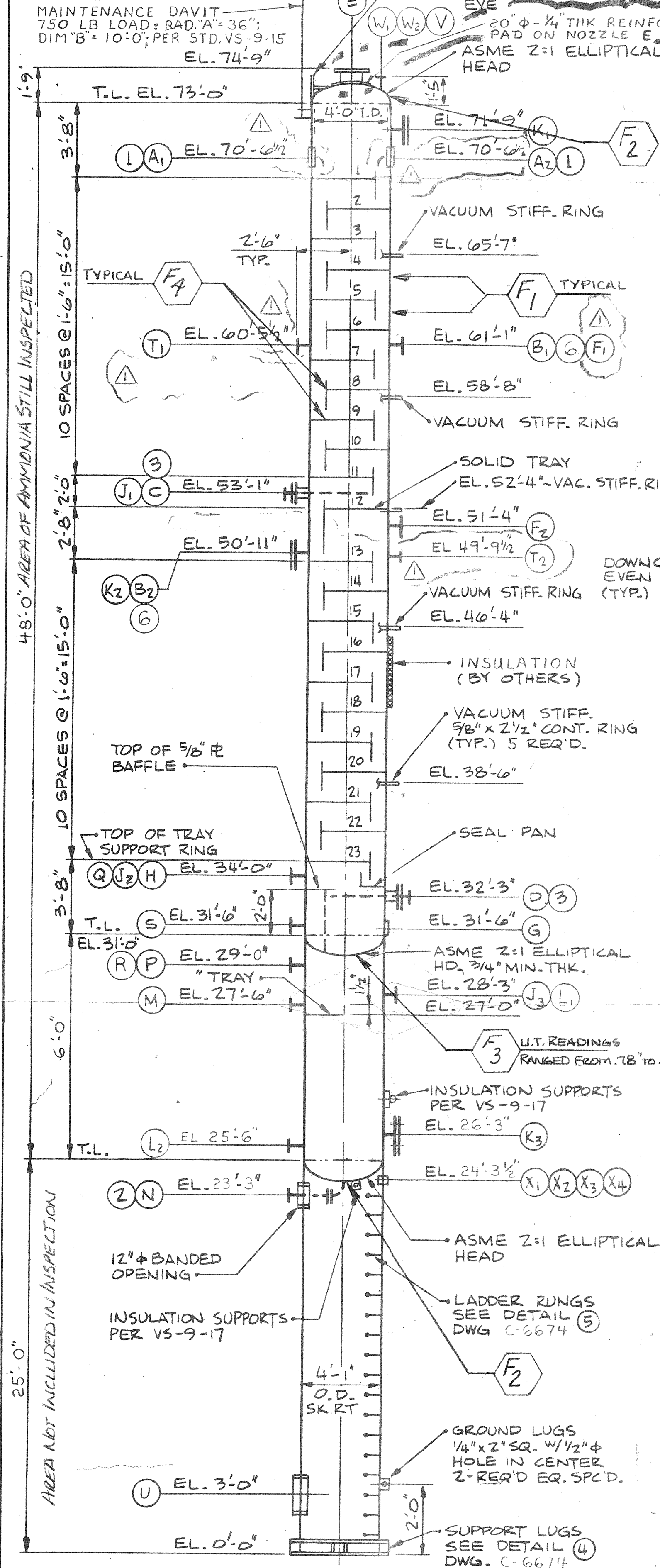


C-6673



ITEM NO. 32001		Nº. REQ'º		
REFERENCES SPEC. VS-1-1 ~ ST				
VS-9-17, SS-31-8, SS-31-9, SS-31-10, SS-31-11				
DESIGN CONDITIONS (BOTH CHAMBER)				
VESSEL EV. F 15 PSIG @ 300° F		PSIG @ 300° F		
OPERATING CONDITIONS				
VESSEL TOP 110° TO 110° W.C. @ 215° - 230° F		BOTT. 100° PSIA @ 300° F		
MATERIALS				
SHELL, HDS. SA-516 GR. 70		SA-516 GR. 70		
SKIRT SA-285 GR. C		SA-285 GR. C		
PLATFORM GRATING GALVANIZED				
BOLTING SA-193 GR. B7		SA-194 GR. 2H		
GASKETS 1/16 THK COMPRESSED AIR				
SUPPORTS CARBON STEEL				
CORROSION ALLOWANCE 1/4" ON ALL PRESSURE THICKNESS				
SHELL 1/2" TOP HD.		JACKET JACKET HD.		
CONSTRUCTION FUSION WELDED				
CODE ASME B & PV CODE SEC				
STRESS RELIEF - RADIOG.				
TESTING PER CODE REQUIREMENTS				
INSPECTION BY BUYER & CODE APPROVED				
STAMPING ASME & NATIONAL BOARD				
NAME PLATE DRAWO/STILL				
PAINT - EXTERIOR TO BE PAINTED PER				
OPERATING CAPACITY GAL. 75				
FULL CAPACITY 4650 GAL. S.O.				
ESTIMATED WEIGHT - SEE NOTE 6.				
EMPTY 52,000 LBS. - FULL OF		OPERATING LBS. - FULL OF		
INSULATION SUPPORTS ARE REQUIRED PER STD. VS-9-17				
X	4	3'	-	BANDED SKIRT - VENT
W	2	2'	150°	RF TW W/BLD. FLG. TAPPED
V	1	2'	150°	RF FT W/BLD. FLG. TAPPED
U	1	15'		BANDED ACCESS OPENING
T	2	1'	50°	RF SAMPLE CONNECTIONS
S	1	6'	150°	RF LIQUID OUTLET TO SKIRT
R	1	2'	150°	RF VENT FROM OUTLET
Q	1	2'	150°	RF SEAL LEG VENT
P	1	6'	150°	RF VAPOR OUTLET
L	2	2'	150°	RF LEVEL W/BLD. FLG. TAPPED
K	3	24"	150°	RF MANWAY - SEE TABLE
J	3	2'	150°	RF FT W/BLD. FLG. TAPPED
H	1	2'	150°	RF TW W/BLD. FLG. TAPPED
G	1	2'	150°	RF PAD DRAIN
F	2	12"	150°	RF PRESSURE EQUALIZER
E	1	14"	150°	RF VAPOR OUTLET
D	1	24"	150°	RF 12" STEAM SPARGE - SEE DET
C	1	10"	150°	RF 8" STEAM SPARGE - SEE DET
B	2	1'	150°	RF PAD CAUSTIC INLET W/PIPE STOP
A	2	3"	150°	RF LIQUID INLET 1/3" PIPE - SEE DET
MARK REQ'D SIZE RATING FACING				REMARKS

AMMONIA LIQUOR  
 MAN COMPONENTS INCLUDING REQUIRED  
 FINISHED BY BUYER, SHIPPED PREPAID TO MANUFACTURERS  
 FOR INSTALLATION INTO AMMONIA STILL.  
 ALL PIPE TO BE S.S.T.L. 316L @ CONN. 31 & B2. (DWG. C-6673)  
 BUYER SHALL FURNISH ALL LADDERS AND PLATFORMS  
 PER WITH DRAWO STDS. SS-31-8, SS-31-9, SS-31-10 AND  
 USED AS REQUIRED TO COMPLY TO OSHA STANDARDS.  
 ALL CLOSING SAFETY GATES WHERE APPLICABLE, FINE  
 GEMS SHALL BE PINNED ON ONE END AND HAVE SLOTTED  
 ON OTHER END TO ELIMINATE ANY RESTRAINT DUE TO  
 THERMAL EXPANSION BETWEEN COLUMNS. THERMAL EXPANSION  
 SHALL BE PROVIDED FOR ON ONE COLUMN OPERATING WHILE THE OTHER  
 IS SHUT DOWN CONDITION. (PROVIDE FOR FUTURE DRAWO STDS.)  
 THIS INCLUDES WEIGHT OF TRAYS AND 17,900 LBS FOR  
 OF PLATFORM AND LADDERS.  
 ALL SHALL HAVE DAVITS PER STD. VS-9-3;  
 ALL SHALL HAVE HINGES PER STD. VS-9-5

**ORBITAL ENGINEERING**  
 PITTSBURGH • CLEVELAND • CHICAGO  
 PROJECT NO. **W-6058** SHE

<b>Dravo Still</b>		CONTRACT NO.
APPROVAL ISSUE	CONSTRUCTION ISSUE	
J.E.	J.E.	
G.L.	G.L.	
S.E.	S.E.	
C.S.	C.S.	
D/S	D/S	
ISSUE NO.		
DATE ISSUED		
DRAWO/STILL		
DRAWING		
NUMBER		

REFERENCE DRAWINGS LISTED  
**Interlake**  
 CHICAGO COKE  
 AMMONIA STILL SYSTEM  
 AMMONIA STILL - SHIP  
 VESSEL ARRANGEMENT AND

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REVISIONS	DATE	BY	DESCRIPTION
1	11/85	REV	OPERATING CONDITIONS
2	11/85	REV	NOZZLE LOCATION
3	11/85	REV	ADD REINFORCING

DEFI CONTRACT #244-2L

SCALE 1/4" = 1'-0"

DO NOT SCALE WORK TO DIMENSIONS

SCALE 1/4" = 1'-0" APP