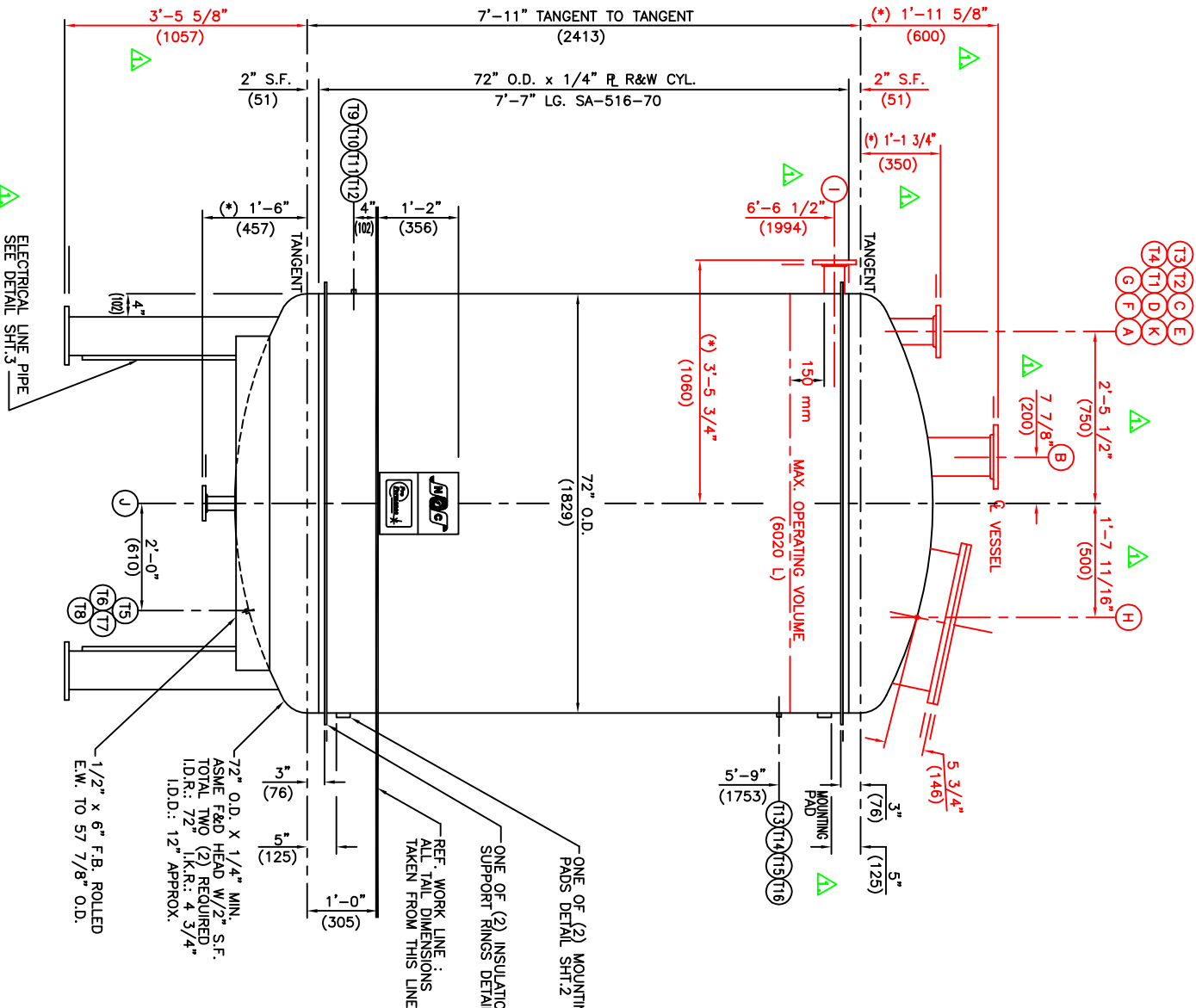




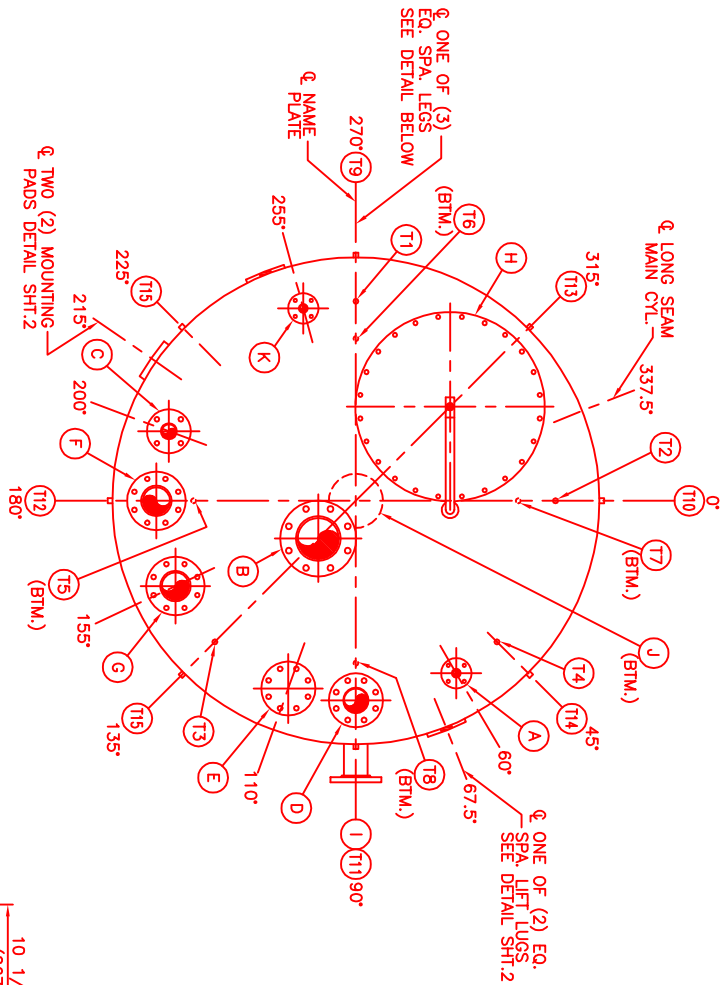
ELEVATION
SEE PLAN VIEW FOR TRUE ORIENTATION
* ALL DIMENSIONS MARKED (*)
ARE STEEL TO STEEL

FLUOROCALD LINING SYSTEM

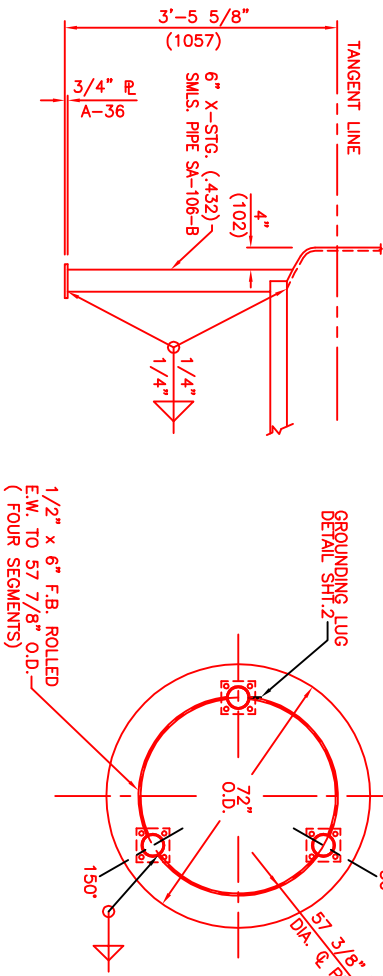
NISSHIN GULF COAST, INC.	
1701 TIDWELL HOUSTON, TEXAS 77093	
LINING	2mm (0.080") FLUOROCALD PTFE
MAX. CAPACITY 2000 GALLONS (7750 LITERS)	
N.G.C. PROJECT No. : 2190	

(DO NOT USE SERVICE BOLTING FOR HYDROTEST)

MARK	SIZE	RIG	QTY	MATERIAL	QTY	NO.	DIA.	LENGTH	MATERIAL	REMARKS
H	24"	30	1	26 1/8" x 24 1/2" x 1/8" KLINGER C-4401 (HYDRO)	24	1 1/2"	3 1/2"	SA-193-B7	TEFLON COATED	
E	80	PN10	1	1/8" KLINGER C-4401 (HYDRO)	8	5/8"	3 3/4"	SA-193-B7	TEFLON COATED	
FLANGE DESCRIPTION										
GASKET & BOLTING SCHEDULE										



PLAN VIEW
TRUE ORIENTATION



LEG DETAIL
THREE (3) REQUIRED

MARK		SIZE	RIG	QTY	FLANGE / ORG	TEST HOLE	STD.	THK	FLANGE CUT LENGTH	INT. PROD.	EXT.	INT.	WIDTH	THK	FIN. PAD	FLANGE	W/	DAVT	REMARKS
T	16	1 1/4"	3000	HALF-THIRD	FF	SO	MANWAY	9"	1 1/4"	~	~	~	~	~	~	~	~	~	PLUG
H	1	24"	30	FF	SO	MANWAY	STD.	3/75	9"	1 1/4"	~	~	~	~	~	~	~	~	
SERVICE																			
K	1	25	10	FF	SO	DOSSING INLET	1"	40	1.33	9"	~	~	~	~	~	~	~	~	
J	1	50	10	FF	SO	OUTLET	2"	40	1.54	9"	~	~	~	~	~	~	~	~	
I	1	80	10	FF	SO	OVERFLOW	3"	40	2.16	10"	~	~	~	~	~	~	~	~	
G	1	100	10	FF	SO	EDUCTOR INLET	4"	40	2.37	10"	~	~	~	~	~	~	~	~	
F	1	100	10	FF	SO	MIXER OUTLET	4"	40	2.37	10"	~	~	~	~	~	~	~	~	
E	1	80	10	FF	SO	SPARE	3"	40	2.16	10"	~	~	~	~	~	~	~	~	YES
D	1	80	10	FF	SO	DI WATER INLET	3"	40	2.16	10"	~	~	~	~	~	~	~	~	
C	1	50	10	FF	SO	HF/HNO3 INLET	2"	40	1.54	9"	~	~	~	~	~	~	~	~	
B	1	150	10	FF	SO	SONIC PROBE	6"	40	2.80	1"-1"	~	~	~	~	~	~	~	~	
A	1	25	10	FF	SO	AIR	1"	40	1.33	9"	~	~	~	~	~	~	~	~	
SERVICE																			
SCHEDULE OF OPENINGS																			

DESIGN CONDITIONS		SHELL	HEADS
DESIGN PRESS.	INTERNAL	25 PSIG. (1.75 BAR G)	
DESIGN TEMPERATURE	● N/A (F)	150° F (65.5° C)	
MIN ALLOW WORKING TEMP.	● 150° F	25 PSIG. (1.75 BAR G)	
MAX DESIGN METAL TEMP.	● 25 PSIG.	20° F. (-6.7° C)	
HYDROSTATIC TEST PRESS. (NEW & COLD)		38 PSIG (2.62 BAR G)	
CORROSION ALLOWANCE		0	
DESIGN JOINT EFFICIENCY		85%	100%
HEAT TREATMENT		NOT REQUIRED	
INSULATION THICKNESS (BY OTHERS)		1 1/2"	
CAPACITY	TOTAL	2000 GALLONS (7750 LITERS)	S.G. = 1.70
MATERIAL SPECIFICATIONS (ASME)			
SHELL & REPADS	SA-516-70	INTERNAL	
HEADS	SA-516-70		
SUPPORTS	SA-106-B / SA-36		
CLIPS & LUGS	SA-36		
FLANGES	SA-516-70 / SA-105		
PIPE	SA-106-B		
BOLTS/NUTS	SEE SCHEDULE		
GASKETS	SEE SCHEDULE		

- GENERAL NOTES
- ALL FLANGE BOLT HOLES SHALL STRADDLE NORMAL VESSEL CENTER-LINES UNLESS NOTED.
 - ALL WELDS SHALL BE NEAT IN APPEARANCE, FREE OF SLAG, DILLS, UNDERCUTS, AND OTHER DEFECTS.
 - VESSEL SHALL BE LEFT CLEAN AND DRY INSIDE AND FREE OF ALL FABRICATION DEBRIS.
 - P.W.I. TO FURNISH BOLTING AND BODY FLANGES UNLESS NOTED (SEE SCHEDULE OF OPENINGS).
 - ALL NOZZLES TO BE FLUSH WITH INSIDE OF VESSEL.
 - ALL INTERNAL WELDS TO BE GROUND FLUSH.
 - ALL WETTED SURFACES LINED WITH 2mm GLASS BACKED TEFLON "FLUOROCALD" (PTFE).
 - AFTER INSTALLATION, 100% OF LINING TO BE SPARK TESTED.
 - DIMENSIONS SHOWN IN PARENTHESIS ARE IN MILLIMETERS.
 - APPLICABLE STANDARDS AND SPECIFICATIONS : DWG. PID-64A

APPROVED WELDING PROCEDURE SPECIFICATIONS (WPS's)	P1 TO P8
WPS-PRO-17(GMAN)	WPS-PRO-37(FCAN)
WPS-PRO-17(GMAN)	WPS-PRO-34(GMAN)
WPS-PRO-30(G1AW)	WPS-PRO-56(SMAN)
WPS-PRO-30(G1AW)	WPS-PRO-86(SAW)

CERTIFIED BY PRO-FORMANCE WELDING, INC. HOUSTON, TEXAS

RT-4

MAWP 25 PSI. 150 °F.

MIN DESIGN METAL TEMP. 20 °F. 25 PSI.

MFR'S SERIAL NO. 6512 YEAR BUILT 1997

ITEM NO. V6401 WT. EMPTY 4,000 LBS.

TEST PRESS. 38 PSI. SA-516-70

P.O. No.: (NGC) N055717 / (OLN) 962105/000

MAWP : 1.75 BAR G @ 65.5° C

PLANT SITE : ZWIJNDRECHT, BELGIUM

PTFE LINED VESSEL--DO NOT WELD OR BURN

SERVICE: ME BLEND TANK

PRO-FORMANCE CODE NAME PLATE (1-310 STAINLESS STEEL)
NAME PLATE TO BE INSTALLED ON 1/4" STNLS. STEEL U-BRACKET.
U-BRACKET TO HAVE 3" STAND OFF.

PAINTING REQUIREMENTS: PER SPEC. 20095.OLN AND SURFACE PREP. PER SPEC. FBPN100.OLN (BY N.G.C.)
DESIGNED & CONST. IN ACCORD. WITH: ASME SECT. VIII DIV.1 1995 (A95)
STAMP: REQUIRED IN.B. REGIS. NOT REQ'D INSPECTION BY: A.I. & CUST.
WEIGHTS, LBS. FAB.D. 4,000 OPERATING: 32,500 TEST: 21,000
CUSTOMER: N.G.C. / OLN P.O. No.: N05717
CUSTOMER DWG. No.: PID-64A ITEM No.: V6401
PROJECT: OLN / BELGIUM SITE: ZWIJNDRECHT, BELGIUM
SERVICE: ME BLEND TANK ONE (1) UNIT REQ'D.

NISSHIN GULF COAST

HOUSTON, TEXAS.

Partners in Quality

Proformance Welding, Inc.

HOUSTON, TEXAS.

REVISIONS		SCALE	
Δ	REVISED PER CLIENT COMMENT 01-31-97	Δ	NOT TO SCALE
Δ		Δ	DRWN 12/20/96
Δ		Δ	CHKD 12/20/96
Δ		Δ	APPD 12/20/96