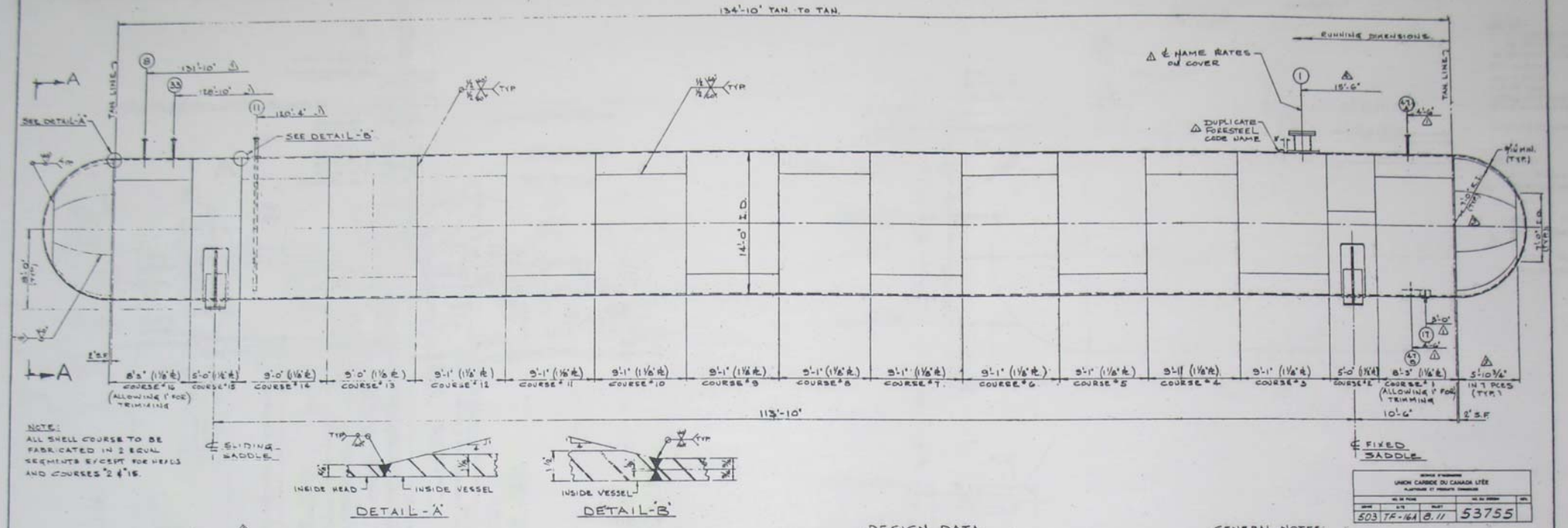
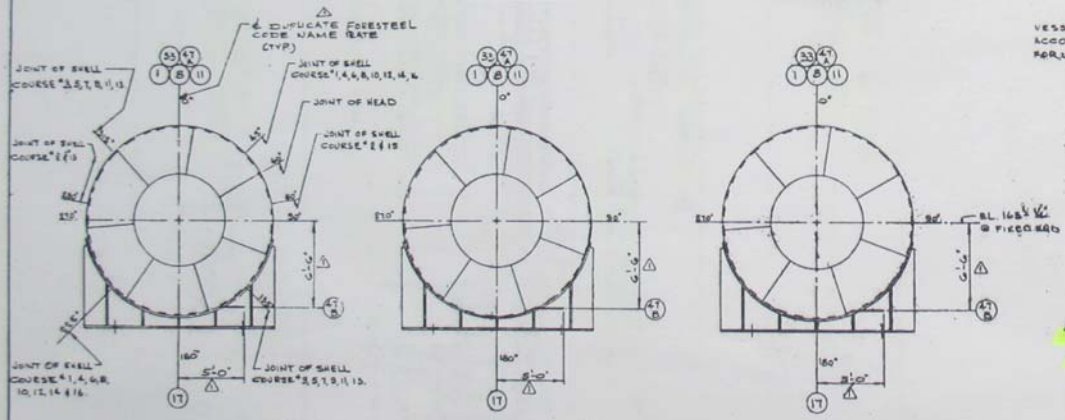


NOTE:
ALL SHELL COURSE TO BE FABRICATED IN 2 EQUAL SEGMENTS EXCEPT FOR HEADS AND COURSES #2 & #15.

503	TF-16A	8.11	53755

UNION CARBIDE DU CANADA LTÉE



ORIENTATION VIEW 'A'-'A'
VESSEL Nº 0610

ORIENTATION VIEW 'A'-'A'
VESSEL Nº 0620
NOTE: FOR WELDED JOINTS ORIENTATION SEE #0610

ORIENTATION VIEW 'A'-'A'
VESSEL Nº 0630.
NOTE: FOR WELDED JOINTS ORIENTATION SEE #0610

DESIGN DATA

VESSEL TO BE DESIGNED, FABRICATED AND TESTED IN ACCORDANCE WITH A.S.M.E. CODE SECTION VIII EDITION DIVISION I 1968 FOR UNFIRED PRESSURE VESSELS & UCC. STD. SPEC. COP.1-65, COP-81-65.

DESIGN PRESSURE	225 PSIG.
DESIGN TEMPERATURE	-20°F to 250°F
OPERATING PRESSURE (MAX.)	15 TO 190 PSIG.
OPERATING TEMPERATURE (MAX.)	-20°F TO 86°F
MAX ALLOWABLE PRESSURE (NEW & COLD)	232.5 PSIG. (LIMITED BY 16" SHELL)
LONGITUDINAL JOINT EFFICIENCY	100%
RADIOGRAPHY	FULL X-RAY
STRESS RELIEVED	SEE NOTE #6
CORROSION ALLOWANCE	NO
TEST HYDROSTATIC	341 PSIG (AT TOP OF NOZZLE)
REGISTRATION	BY DEPT. OF LABOUR OF QUEBEC.
CANADIAN REGISTRATION NUMBER	D-2340-6
ERECTION WEIGHT	302,000 LBS
TOTAL WEIGHT OPERATING	373,000 LBS
WEIGHT FULL OF WATER	1,684,000 LBS.
PAINTING	YES (SEE NOTE 4)

MFG. SERIAL No.
ITEM 0610 — FP-1181-70
" 0620 — FP-1180-70
" 0630 — FP-1189-70

MATERIAL SPECIFICATIONS:

SHELL AND HEADS	ASTM-A-516-70 NORMALIZED
REINFORCING PADS	ASTM-A-516-70 NORMALIZED
SADDLE	ASTM-A-516-70 NORMALIZED
SADDLE BAND	ASTM-A-516-70 NORMALIZED
MANWAY FLANGE	ASTM-A-516-70 NORMALIZED
NOZZLE NECK PLATE	ASTM-A-516-70 NORMALIZED
PIPE NOZZLE NECK	ASTM-A-106-B
NOZZLE FLANGE	ASTM-A-105-II NORMALIZED
BLIND FLANGE FOR MANWAY	ASTM-A-516-70 NORMALIZED
INTERNAL PLATE	ASTM-A-285-C F.B.Q
STUD BOLTS	ASTM-A-193-B7
NUTS	ASTM-A-194-2H
GASKET	COMP. ASBESTOS
EXTERNAL CLIPS	ASTM-A-516-70 P.V.Q

GENERAL NOTES:

1) FLANGE BOLT HOLES TO BE STRADDLE NORTH & SOUTH ℄ OR NATURAL HORIZONTAL & VERTICAL ℄ OF VESSEL.

2) AFTER HYDROSTATIC TESTING, VESSEL TO BE COMPLETELY DRAINED OF WATER AND ALL INSIDE SURFACES AIR-DRIED. THE INTERIOR TO BE THOROUGHLY CLEANED OF FOREIGN MATTER.

3) ALL GASKET AND MACHINED SURFACES TO BE CLEANED WITH SOLVENT AND COATED WITH "RUST VETO" Nº 342, A HEAVY DUTY RUST-PREVENTIVE GREASE, MANUFACTURED BY THE E.F. HOUGHTON COMPANY.
MANWAY AND NOZELES FURNISHED WITH REGULAR BLIND FLANGES TO HAVE THE BLIND FLANGES INSTALLED USING THE TEST GASKET.
ALL OTHER FLANGED OPENINGS TO BE PROVIDED WITH COVERS TO ENSURE PROTECTION FROM MECHANICAL DAMAGE.

4) FINISH: (SPEC. TO-101) OUTSIDE SURFACES ONLY:
PREPARATION: SSPC-SP2 OR SP3 HAND OR POWER TOOL CLEANING.
PAINTING: 2 COATS OF ROSKOTE 612 OR EQUAL TARMASTIC. MINIMUM DRY FILM THICKNESS 8 MILLS PER COAT.

5) VESSEL TO BE INSTALLED AT UNION CARBIDE CAN. LTD. MONTREAL EAST, BY OTHERS.

6) STRESS RELIEVE COURSE #2 & 15 (1 1/2" & 1") ONLY WITH 1" & SADDLE BAND.

REFERENCE DRAWINGS:

SADDLE	A-578-070-2
NOZZLE DETAIL	A-578-070-3
CLIPS DETAIL	A-578-070-4 (ITEM #610, ITEM #630)
CLIPS DETAIL	A-578-070-5 ITEM #620

PROPERTY NO. 6392-496, -497, -498

FORESTEEL INDUSTRIES LTD.
CERTIFIED DRAWING
DATE - 28 MAY 1971 SIGNATURE

47A	1	1 1/2"-150# (R.F.)	W.N.F. BORE 1.500"	EXTERNAL LEVEL	---	8'-11 1/2"	1 1/2" SCH. 80 PIPE	.200"			
47B	1	1 1/2" ∅ PIPE	———	EXTERNAL LEVEL	SEE DWG #1		1 1/2" SCH. 80 PIPE	.200"			
——	—				—			—			
33	1	2"-300# (R.F.)	W.N.F. BORE 1.94"	SAFETY VALVE	—	8'-11 1/2"	2" SCH. 80 PIPE	.218"			
17	1	4" ∅ PIPE	———	BOTTOM OUTLET	—	7'-8 1/2"	4" SCH. 80 PIPE	.337"	2" WIDE x 1/8" THK. ALL AROUND	WITH VORTEX BREAKER	
11	1	3"-150# (R.F.)	W.N.F. BORE 3.30"	FEED FROM 0450	—	8'-11 1/2"	3" SCH. 80 PIPE	.300"	2" WIDE x 1 1/8" THK. ALL AROUND		
8	1	2"-150# (R.F.)	W.N.F. BORE 1.94"	VENT TO ATM.	—	8'-11 1/2"	2" SCH. 80 PIPE	.218"	———		
1	1	20" DIA.	FLAT FLG.	MANWAY	—	8'-11 1/2" / 8'-10"	PLATE	1/2"	10" WIDE x 1 1/8" THK. ALL AROUND	WITH COVER BOLTS & GASKET	
MARK	QTY/ BLDG	SIZE & RATING	TYPE	SERVICE		PROJ. NOZZLE FROM ℄ VESSEL TO REF. FACE, PAD	NOZZLE NECK	WALL THK.	REINFORCING PAD	REMARKS	

NOZZLE SCHEDULE (FOR ONE UNIT)

——	OH	R.G.		MAR 18 1970	UNCLEAR FIELD PROJ. ELEV. CORRECTED ALL NOZZLES PROJ. ELEV. CORRECTED TO ELEV.	G.M.		
——	OH	R.G.		APR 28 1970	MANWAY WAS AT 10'-6" UNDER SADDLE, NOW 8 ADDED.	G.M.		
——	✓	G.M.		MAY 1970	1'-0" TO TAN LINE WAS TO BEAM HEAD. NOW TO SADDLE CL	R.G.		
——	G.M.			JUNE 1970	CANADIAN REGISTRATION NUMBER ADDED.	R.G.		
578-071 FOR ONLY	R.G.	G.M.		JUNE 29 1970	DESIGN PRESS. & TEMP. CHANGED. ADDED PER PARAGRAPH ON PAGE 2 CLIPS MAY'S SPECS. MFG. SERIAL NUMBERS. (ITEM 0610 - FP-1181-70, ITEM 0620 - FP-1180-70, ITEM 0630 - FP-1189-70) ITEM 0610 DELETED. PROJ. NOZZLE ELEVATION RUNNING DIMS. FOR NOZZLE ADD. AS REQUESTED.	R.G.		
EXTRA ℄ LINES	LAY BY	CHK BY	NO.	DATE	REVISIONS	BY	THE LUMMUS CO. OF CAN. LTD.	DWG NO.

LES INDUSTRIES FORESTEEL LIMITEE
FORESTEEL INDUSTRIES LIMITED
MONTREAL, QUEBEC.

MIX TANK VESSEL # 4134-0610, #0620 & #0630 (P.O. # 6465-300)
THE LUMMUS CO. OF CANADA LTD.
FOR UNION CARBIDE CAN. LTD.
10855 METROPOLITAN BLVD. EAST
MONTREAL EAST, QUE.

DR. BY	R. GELINAS
CHK. BY	
APP. BY	
DATE	MAY 22, 1970
SCALE	1/8" = 1'-0"
DWG. NO.	A-578-070-1
SHT.	5