

THE HARTFORD STEAM BOILER INSPECTION AND INSURANCE COMPANY
MANUFACTURERS' DATA REPORT FOR UNFIRED PRESSURE VESSELS
 As Required by the Provisions of the A.S.M.E. Code Rules

1. Manufactured by Downingtown Iron Works, Downingtown, Pa.
(Name and address of the manufacturer)

2. Manufactured for Phillips Petroleum Co., Detroit, Michigan.
(Name and address of the purchaser)

3. Type Horizontal Unfired Pressure Vessel No. 1278 Int. Bd. #534 Year built 1940
(Horizontal or Vertical) (Mfrs. serial, or A.S.M.E. No.) (State and State No.)

4. Have mill test reports been checked on all the plates entering this unfired pressure vessel YES.

Do the chemical and physical properties of all plates meet the requirements of the Code. Yes.

5. SHELL OR DRUMS: No. 1 Diameter 8 ft. 0.0 in. Length over all 50 ft. 1-1/4 Height ft. in.
(or width)

6. STAMPS ON shell plates F. H. 70,000 Rivets, stays and braces
(Brand and lowest tensile strength) (Iron or Steel)

7. SHELL PLATES 27/32" Butt straps in. Style of seams: Longitudinal Double Butt Girth Double Butt
(Outer) (Thickness) (Thickness) (Riveted, Forge Welded, Braze, or Fusion Welded) (Type of)

8. Diameter of rivet holes in. Pitch of rivets X Efficiency of joint 90 %

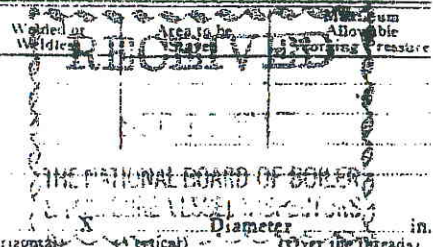
9. GIRTH JOINTS Diameter rivet holes in. Pitch of rivets in. No. of courses 8
(Single or double riveted)

10. INNER SHELL in. Style of seams: Longitudinal Girth Length of section or course ft. in.
(Thickness) (Riveted, Forge Welded, Braze, or Fusion Welded - Type of)

11. HEADS; flat or dished in. Radius of dish 84" in. Side to pressure Concave.
(Thickness) (Concave or convex)

If removable, bolts used method of fastening
(Number and size) (Describe or sketch)

| STAYS | No. | Size | Net Area | Welded or Riveted | Area to be deducted from allowable pressure |
|-------------------------------|-----|------|----------|-------------------|---|
| (a) F. H. | | | | | |
| (b) R. H. | | | | | |
| (c) Through | | | | | |
| (d) Diagonal and Gusset Stays | | | | | |



13. STAY BOLTS If hollow 14. Maximum pitch in.
(Iron or Steel) (Size of hole) (Horizontal) (Vertical) (Over the threads)

15. SAFETY VALVE outlets: No. 8 Size 4"

16. FUSELLE PLUG (if used): No. Diameter and material of filling Location

17. OUTLETS: No. 3 Size 1-2" Material of nozzle or reinforcement How attached
(Riveted, welded, etc.)

18. DRAIN connection in. HAND HOLES OR SIGHT HOLES
(Size) (Number, size and location)

19. MANHOLES: 1- 18" Dia. in shell. Reinforcement Welded.
(Number) (Size and location of each) (Riveted, welded, etc.)

20. Method of supporting vessel Concrete Cradles.

21. Bursting pressure 1002 lb. per sq. in. Hydrostatic test 300 and 400 lb.

22. Constructed for pressure of 200 lb. per sq. in. Maximum stress in shell plate 13,968 lb. per sq. in.

Remarks: Propane Gas ASME U-69, Max. Operating Temp. 250 Deg. F.
Temperature limited due to series #15 H.H. bolt flg.

We certify the above data to be correct and that all details of material and construction and workmanship on this unfired pressure vessel conform to the A. S. M. E. Unfired Pressure Vessel Code.

Date Sept. 3 19 40 Signed Downingtown Iron Works. by

Form 641 D. I. C. 40-843. P. P. Co. 790413. Dwg. C-884. U. H. Arway.

CERTIFICATE OF SHOP INSPECTION

H.S.B. #87507

Insurance Company's Serial Number.....

Dtn. Iron Wks.

Downingtown

VESSEL MADE BY.....at.....

I, the undersigned, holding a certificate of competency as an inspector of steam boilers in THE STATE OF
Penna.

and employed by the **HARTFORD STEAM BOILER INSPECTION AND INSURANCE COMPANY**

of HARTFORD, CONN., inspected internally and externally, the vessel specified in this report, on.....

Sept. 3.....1940, and certify that the statements made on this report are correct, corresponding with the mill test reports of material as furnished by the builders, and measurements made of the vessel when completed; and that this vessel is constructed in accordance with the A. S. M. E. Boiler Code Rules for the Construction of Unfired Pressure Vessels.

Earl Miller
Inspector for State or Boiler Insurance Company.

Commission No.
Penna. No. 863
Nat. Bd. No. 753