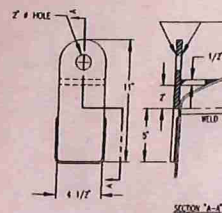
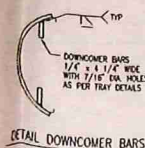


SHELL NOZZLE ORIENTATION

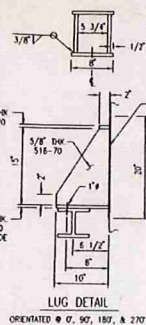


LIFTING LUG DETAIL

12 ROD N.T.S.

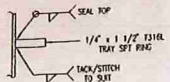


DETAIL DOWNCOMER BARS



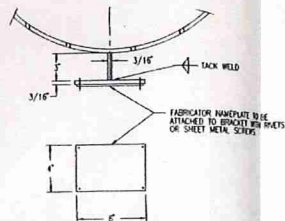
LUG DETAIL

ORIENTED @ 0°, 90°, 180°, & 270° N.T.S.



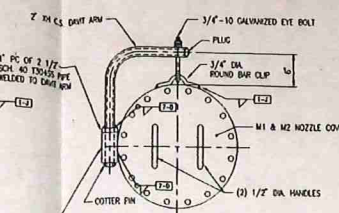
DETAIL TRAY SPT RINGS

SEE KNOCK-OUTS (Dwg D-200407-0000)



NAMEPLATE BRACKET DETAIL

(NOT TO SCALE)



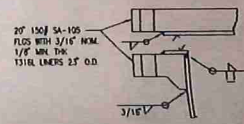
VORTEX DETAIL

SB-575-C276 (NOT TO SCALE)

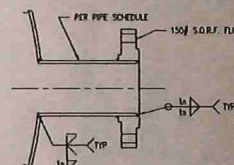
- NOTES
- CONSTRUCTION SHALL BE IN ACCORDANCE WITH THE LATEST ASME CODE SECTION VIII, DIV. 1. ASME STAMP AND NATIONAL BOARD STAMP REQUIRED.
 - MATERIAL OF CONSTRUCTION TO BE:
 - SA 240 316L EXCEPT BOTTOM 7"-S" WHICH IS TO BE SB 575 HASTELLOY C-276
 - HEADS:
 - TOP: SA 240 316L, BOTTOM: SB 575 HASTELLOY C-276
 - NOZZLES:
 - SEE NOZZLE SCHEDULE
 - FLANGES:
 - SEE NOZZLE SCHEDULE
 - CSTL FLANGES TO BE LINED WITH APPROPRIATE ALLOY.
 - BOLTS:
 - A193 B7 CSTL, ZINC PLATED
 - A194 2H CSTL, ZINC PLATED
 - LUGS:
 - SA 516 60 70 W/ 304SS BACKING BAND
 - LOCATE ALL WELDING SEAMS TO CLEAR NOZZLES.
 - ALL BOLT HOLES STRUCKLE PRINCIPAL CENTERLINES UNLESS OTHERWISE NOTED.
 - ALL NOZZLES SHALL PROJECT 6" FROM OUTSIDE OF EQUIPMENT TO FACE OF FLANGE, UNLESS OTHERWISE NOTED. NO SHALL BE MOUNTED TRUE TO CENTERLINES.
 - VENDOR SHALL FURNISH BOLTS, NUTS AND GASKETS WHERE WELDING FLANGES ARE SUPPLIED ALLOY STEEL STUD BOLTS. ASTM A193-B7 WITH HEAVY HEX NUTS ASTM A194-2H.
 - ALL WELDING SHALL BE FULL, CONTINUOUS, FREE FROM SLAG, POROSITY AND OTHER DEFECTS.
 - NO FLANGES SHALL BE WARPED, BUT SHALL BE TRUE AND GASKET SMOOTH.
 - GASKETS 1/8" THICK OILON 3510.
 - FABRICATOR TO SUPPLY GASKETS FOR HYDROTEST.
 - WHEN WELDING DISPARATE METALS, THE WELDER MUST SHALL COVER THE TYPE OF WELD TO BE USED.
 - PAINTING:
 - PER ROSS SPEC. 011-03.
 - FABRICATOR RESPONSIBILITIES:
 - A) FABRICATOR TO SUPPLY DETAIL OF THE FOLLOWING EQUIPMENT SUPPORT.
 - B) FABRICATOR TO VERIFY ALL SHELL, HEAD, NOZZLE AND SUPPORT THICKNESSES. KPI IS TO HAVE A COPY OF CALCULATIONS.
 - LIQUID PENETRANT EXAM AS PER DMF-58.
 - WARRANTS TO BE PROVIDED WITH SHIFTS.
 - NOZZLE "F" NOT DESIGNED FOR REMOVAL SUPPORT LOADS.
 - CONVENIENT WELDING PROCEDURES:
 - 1-1 CARBON STEEL TO C.S.
 - 6-0 STAINLESS STEEL TO S.S.
 - 7-0 STAINLESS STEEL TO C.S.
 - H-2 C-276 TO C-276
 - H-3 C-276 TO STAINLESS
 - H-5 C-276 TO C.S.
 - WIT'S RECORD ON HEADS, SHELLS, AND NOZZLE NECKS.

DESIGN DATA

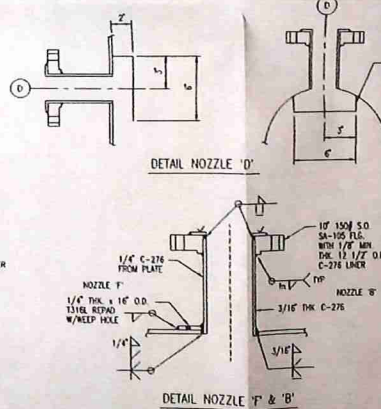
HORIZONTAL		VERTICAL	
TYPE SUPPORT	CHAR	LUSS	LUSS
PAINT EXT. CARBON STEEL: SEE NOTE 12			
INSULATION RINGS: 5 FOR 2" INSULATION			
ESTIMATED WEIGHT			
EMPTY	8500 LBS	FULL	34500 LBS
OPERATING			
14300 LBS			
VESSEL			
CAPACITY			
DIAMETER			
36" O.D.			
LENGTH			
59'-6"			
BASIC MATERIAL			
316L S.S.			
INSIDE FINISH			
DESIGN TEMP.			
400° F			
DESIGN PRESS.			
50 PSIG/100			
CORROSION ALLOWANCE			
NONE			
HYDROSTAT			
100 PSIG IN HORIZONTAL			
CONSTRUCTION CODE			
ASME			
HEAT TREATMENT			
NONE			
PHOTOGRAPHY			
F&D			
GASKETS			
HARDWARE			
AGREATOR			
SPECIAL TESTS			
14			
JOINT EFFICIENCY			
SHELL 0.7			
HEADS 0.85			



TYPICAL MANHOLE DETAIL



TYPICAL NOZZLE DETAIL (U.O.N.)

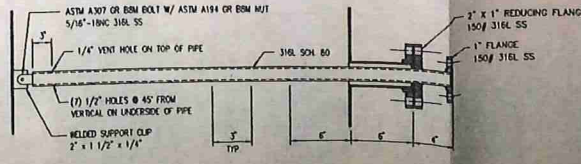


DETAIL NOZZLE 'D'

DETAIL NOZZLE 'F' & 'B'

ITEM	SERVICE	DESCRIPTION	ORIENT	CORR ALLOW	NECK MATL	IMPACT TEST	NOMINAL TEST	SIZE	TYPE	CLASS	RATING	FLG MATL	MATERIAL	IMPACT NORMAL TEST	REINFORCING PAD
G	CAUSTIC (FUTURE) W/BLIND	SOH 80	270.0	0	SA 312 316L WELD NICH	-	-	1	SO	150F	200	-	-	-	-
E	PRODUCT DRAW	SOH 40	270.0	0	SA 312 316L WELD NICH	-	-	4	SO	150F	160	A182F316L	-	-	-
F	PRESSURE	SOH 60	43.0	0	SA 312 316L WELD NICH	-	-	1	SO	150F	160	-	-	-	-
F	REBOILER RETURN	1/4" WALL MW	270.0	0	SB-375-C276	-	-	10	SO	150F	200	A105	SA-240-316L	-	-
L2	LEVEL GAUGE/TRANS	SOH 40	135.0	0	SA 312 316L WELD NICH	-	-	3	SO	150F	200	SB-564-H10276	-	-	-
L1	LEVEL GAUGE/TRANS	SOH 40	135.0	0	SA 312 316L WELD NICH	-	-	3	SO	150F	200	SB-564-H10276	-	-	-
L2	TEMPERATURE	SOH 40	90.0	0	SA 312 316L WELD NICH	-	-	1	SO	150F	160	A182F316L	-	-	-
T1	TEMPERATURE	SOH 80	90.0	0	SA 312 316L WELD NICH	-	-	1	SO	150F	160	A182F316L	-	-	-
D	REFLUX	SOH 80	0.0	0	SA 312 316L WELD NICH	-	-	1	SO	150F	160	A182F316L	-	-	-
A	FEED RECEPTACLE	SOH 80	0.0	0	SA 312 316L WELD NICH	-	-	2	SO	150F	160	A182F316L	-	-	-
M3	MANWAY	3/16" WALL	90.0	0	SA 240 316L WELD NICH	-	-	20	SO	150F	200	A105	-	-	-
M2	MANWAY	3/16" WALL	90.0	0	SA 240 316L WELD NICH	-	-	20	SO	150F	200	A105	-	-	-
M1	MANWAY	3/16" WALL	90.0	0	SA 240 316L WELD NICH	-	-	20	SO	150F	200	A105	-	-	-
B	LIQUID OUTLET	3/16" THK	-	0	SB-375-C276	-	-	10	SO	150F	200	A105	-	-	-
C	VAPOR OUTLET	SOH 40	-	0	SA 312 316L WELD NICH	-	-	6	SO	150F	200	A182F316L	-	-	-

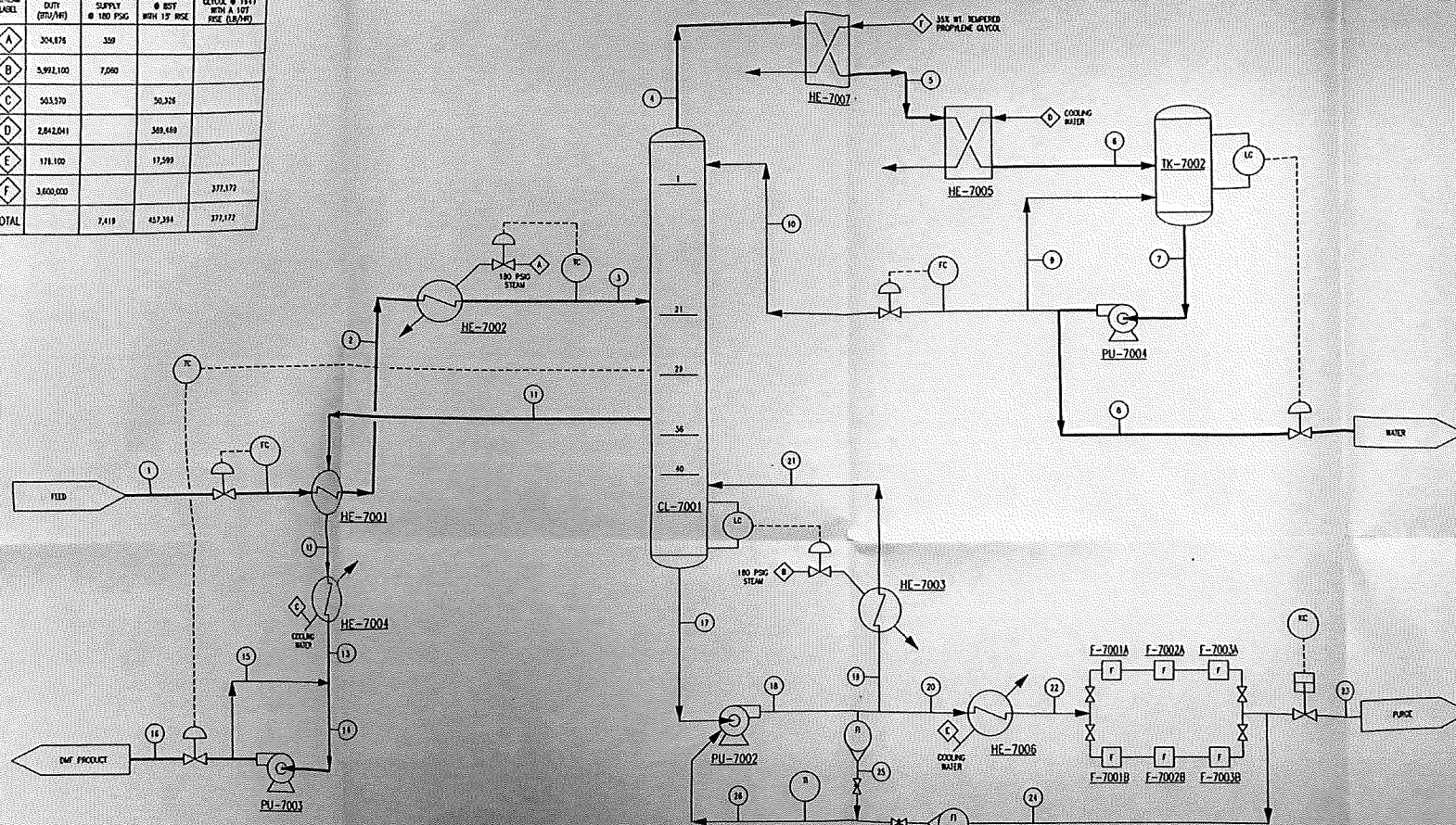
NOZZLE SCHEDULE



NOZZLE A DETAIL

1		ADDED NOZZLE 'D' DETAIL & REVERSED DRAFT ORIENTATION	4-3-98	CUB	CUB
0		FOR CONSTRUCTION	3-18-98	CUB	CUB
P2		REVISED NOZZLES, REHANGERED TRAYS	2-26-98	EV	EV
REV		DESCRIPTION	DATE	BY	APPROV
REVISIONS					
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CLIENT INFORMATION			LAYOUT DRAWING FOR		
PROJ NO.	PO NO.		CL-7001		
SCALE	1/4" = 1'-0"		36" O.D. TRAYED COLUMN		
DESIGNED	EV	DATE	2-15-98	JOB NO.	197-1222
DESIGNED	EV	DATE	2-15-98	DRAWING NO.	
CHECKED	RWB	DATE	2-17-98	REV.	
APPROVED	RWB	DATE	2-19-98	D-1222-08-01	1

UTILITIES				
SERVICE LEVEL	HEAT DUTY (BTU/HR)	STEAM SUPPLY @ 180 PSIG	COOLING WATER @ 85°F WITH 1°F RISE	SEE WT PROPOSED GLASS @ 114°F WITH A 10°F RISE (LBS/HR)
A	304,476	380		
B	5,992,100	7,060		
C	503,370		50,326	
D	2,642,041		369,469	
E	178,100		17,599	
F	3,600,000			377,172
TOTAL		7,419	437,394	377,172



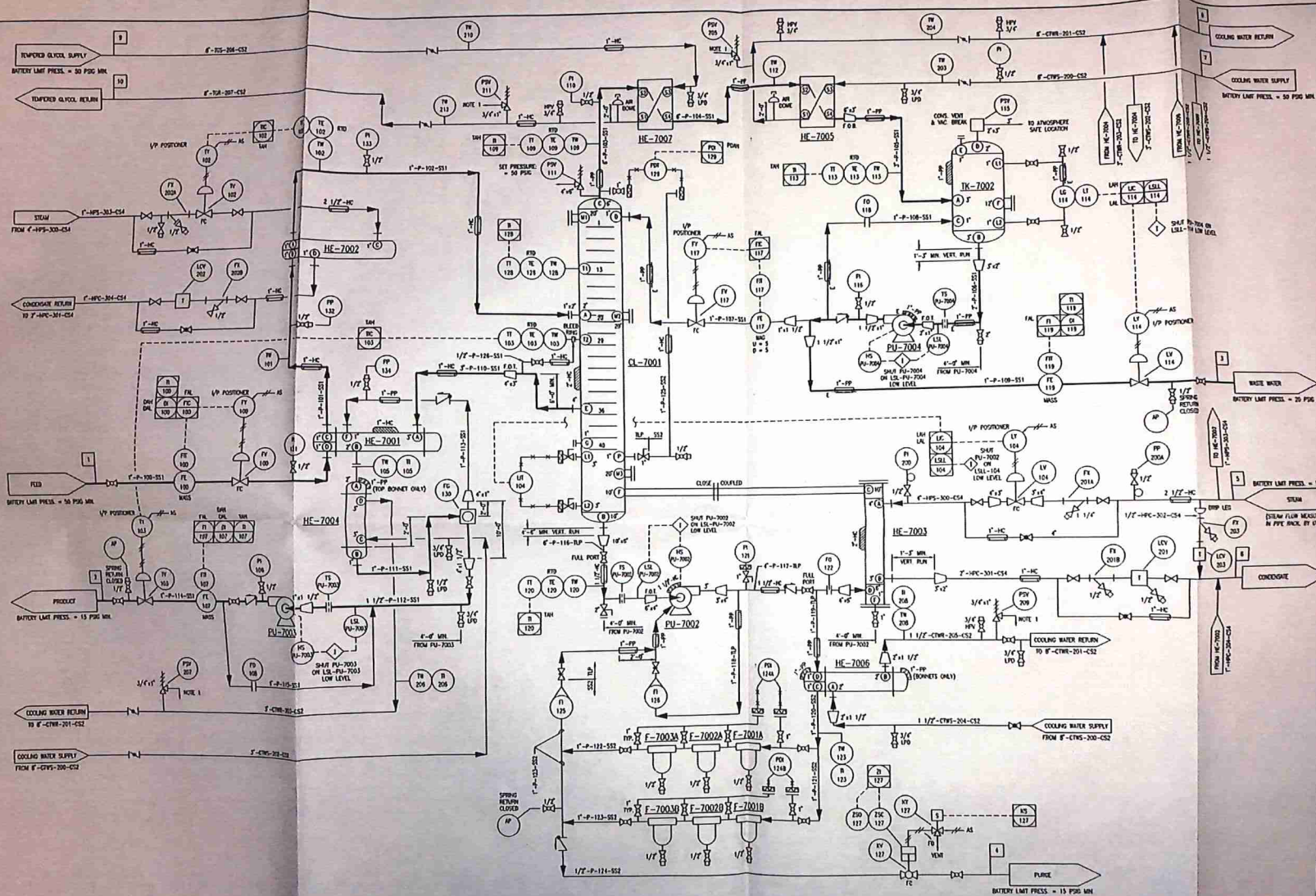
EQUIPMENT LIST		
ITEM	DESCRIPTION	MATERIAL
CL-7001	DISTILLATION COLUMN	316LSS/ASTELLLOY C-276
F-7002	BOTTOMS FILTERS	316SS
HC-7001	FEED PRE-HEATER	SHELL: CARBON STEEL TUBES: 316SS
HC-7002	STEAM HEATER	SHELL: CARBON STEEL TUBES: 316LSS
HC-7003	MIXEDER	SHELL: CARBON STEEL TUBES: ASTELLLOY C-276
HC-7004	PRODUCT COOLER	SHELL: CARBON STEEL TUBES: 316LSS
HC-7005	COLUMN CONDENSER	JOSS/GASKETS EPDM
HC-7006	BOTTOM PURGE COOLER	SHELL: CARBON STEEL TUBES: HASTELLOY C-276
HC-7007	HEAT RECOVERY CONDENSER	JOSS/GASKETS EPDM
PU-7002	BOTTOMS PUMP	HASTELLOY C
PU-7003	PRODUCT PUMP	316SS
PU-7004	REFILL PUMP	316SS
IX-7002	REFILL DRUM	316LSS

NOTES:

1. MATERIAL BALANCE SHOWING IS FOR 15% WT DRY MATERIAL FEED COMPOSITION.
2. UTILITIES DATA REFLECT MAXIMUM DUTY ACROSS THE 14-15% WT RANGE FOR THE DRY FEED.
3. WHEN HE-7007 IS NOT IN SERVICE STREAM 8 WILL BE AS STREAM 4.
4. FOR MATERIAL BALANCE PURPOSE SOLIDS ARE CONSIDERED TO BE COMPLETELY REMOVED BY FILTERS.
5. NO ALLOWANCE IS MADE FOR SOLVENT LOSSES DUE TO CHANGING OF FILTERS.

MATERIAL BALANCE STREAM NUMBER & IDENTITY		(1) (2) (3) (4) (5) (6) (7) (8) (9) (10) (11) (12) (13) (14) (15) (16) (17) (18) (19) (20) (21) (22) (23) (24) (25) (26)																											
		COND. PREHEAT FEED HC-7001	MAIN FEED STEAM HEADS HC-7002	HEAT EXCH. FEED HC-7003	WATER- COOLING WATERS	WATER- COOLING WATERS	CONDENSING WATERS TO TE-7002	CONDENSING WATERS TO PU-7004	DESALINE PRODUCT TO J0001	MAIN FLOW PRODUCT TO PUMP PU-7004	REFLUX TO COLUMN CL-7001	DMF VAPOR PRODUCT TO HC-7001	CONDENSING WATERS TO HC-7001	COOLED DMF FLOW PRODUCT TO HC-7004	DMF PRODUCT TO PUMP PU-7003	MAIN FLOW PRODUCT TO PUMP PU-7003	DMF PRODUCT TO STORAGE	COLUMN PUMP TO PUMP PU-7002	COLUMN PUMP TO PUMP PU-7002	COLUMN PUMP TO RESOLVER HC-7003	PLUCE STEAM TO HC-7004	MODIFIER PUMP TO COLUMN CL-7001	COOLED PUMP STEAM TO FILTERS	COOLING WATERS TO PUMP (BY OTHERS)	COLUMN PUMP TO PUMP PU-7001	MAIN FLOW PRODUCT TO PUMP PU-7002			
COMPONENT		MOL. WT.																											
1	WATER	18.615	3369.7	3369.7	1381.7	5487.2	5487.2	5487.2	5368.8	3368.8	7117.5	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.0	0.0	0.0	0.0	0.0	0.0	0.0		
2	DMTH/PERFORMANCE	73.095	5947.7	5947.7	5947.7	5.5	5.5	5.5	5.5	5.5	2.1	2.1	588.1	588.1	588.1	588.1	469.1	588.1	11081.65	114077.2	11081.64	1517.6	11081.64	1517.6	0.1	174.1	1969.3	5419.0	
3	FORMIC ACID	46.028	0.2	0.2	0.1	0.0	0.0	0.0	0.0	0.0	0.0	0.2	0.2	0.2	0.2	0.2	0.2	1487.7	1531.6	1487.7	20.4	1487.7	20.4	0.0	20.1	25.5	45.1		
4	SOLIDS	-	4.0	4.0	4.1	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	0.0	1167.9	1187.3	1182.3	15.5	1182.3	15.5	0.0	68	78.1			
TOTAL		LB/HR	3969	3969	3969	849.3	549.1	549.1	7959	3372.6	2157.5	2116.7	588.4	588.4	588.4	2907.8	5118.1	588.4	111853.1	117298.1	110244.3	1553.6	112224.3	1553.6	0.2	636.4	1911.9	5170.0	
TEMPERATURE		°F	70	121	20	218	216	146	146	146	328	328	115	116	111	113	330	328	328	328	330	115	110		110	328	83		
PRESSURE		PSIG	40	15.7	3.1	2.8	1.0	0.3	20.8	20	43.8	2.6	0.8	10.0	8.0	10.0	8.0	26.5	4.0	26.5	4.0	26.5	4.0		26.5	26.5			
DENSITY		LB/FT ³	0.750	60.967	56.36	60.9631	56.969	61.822	61.822	61.861	61.861	0.779	0.7434	0.7434	0.7434	0.7434	0.7434	0.7434	0.7434	0.7434	0.7434	0.7434		0.7434	0.7434	0.7434			
VISCOSITY		CP	0.0070	0.563	0.36	0.012	0.275	0.611	0.714	0.693	0.692	0.033	0.005	0.033	0.033	0.033	0.033	0.033	0.033	0.033	0.033	0.033		0.033	0.033	0.033			
FLOW		CM/HR	8.0	8.1	8.1	17.822	11.3	11.1	14.7	8.0	8.0	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3	0.3		0.3	0.3	0.3			
HEAT CAPACITY		BTU/LB/°F	0.622	0.914	0.924	0.500	1.002	1.009	0.996	0.996	0.996	0.91	0.926	0.926	0.926	0.926	0.926	0.926	0.926	0.926	0.926		0.926	0.926	0.926				
THERMAL COND.		BTU/HR/FT ²	0.261	0.252	0.307	0.014	0.363	0.371	0.351	0.351	0.351	0.273	0.273	0.273	0.273	0.273	0.273	0.273	0.273	0.273	0.273		0.273	0.273	0.273				
MOLECULAR WEIGHT		LB/MOLE	20.311	20.311	20.311	18.029	18.029	18.029	18.029	18.029	18.029	18.029	18.029	18.029	18.029	18.029	18.029	18.029	18.029	18.029	18.029		18.029	18.029	18.029				

S	AS BUILT	7-9-86	CN
P	FOR DESCRIPTION APPROVAL	7-2-86	CN
REV.	DESCRIPTION	DATE	APP.
REVISIONS			
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CLIENT INFORMATION		PROCESS FLOW DIAGRAM	
PROJ. NO. TO NO.			
SCALE	NONE		
DRAWN BY RECHECKED BY	DATE 7-27-86	JOB NO. TST-1222	
DESIGNED BY	DATE	DRAWING NO.	REV.
ISSUED BY DATE	7-2-86	D-1222-00-01	0



- NOTES
1. PIPE SCHEDULE OF 100 LBS. TO BE USED FOR ALL PIPING UNLESS OTHERWISE SPECIFIED.
 2. LINE NO. 1-100, 101, 102, 103, 104, 105, 106, 107, 108, 109, 110, 111, 112, 113, 114, 115, 116, 117, 118, 119, 120, 121, 122, 123, 124, 125, 126, 127, 128, 129, 130, 131, 132, 133, 134, 135, 136, 137, 138, 139, 140, 141, 142, 143, 144, 145, 146, 147, 148, 149, 150, 151, 152, 153, 154, 155, 156, 157, 158, 159, 160, 161, 162, 163, 164, 165, 166, 167, 168, 169, 170, 171, 172, 173, 174, 175, 176, 177, 178, 179, 180, 181, 182, 183, 184, 185, 186, 187, 188, 189, 190, 191, 192, 193, 194, 195, 196, 197, 198, 199, 200, 201, 202, 203, 204, 205, 206, 207, 208, 209, 210, 211, 212, 213, 214, 215, 216, 217, 218, 219, 220, 221, 222, 223, 224, 225, 226, 227, 228, 229, 230, 231, 232, 233, 234, 235, 236, 237, 238, 239, 240, 241, 242, 243, 244, 245, 246, 247, 248, 249, 250, 251, 252, 253, 254, 255, 256, 257, 258, 259, 260, 261, 262, 263, 264, 265, 266, 267, 268, 269, 270, 271, 272, 273, 274, 275, 276, 277, 278, 279, 280, 281, 282, 283, 284, 285, 286, 287, 288, 289, 290, 291, 292, 293, 294, 295, 296, 297, 298, 299, 300, 301, 302, 303, 304, 305, 306, 307, 308, 309, 310, 311, 312, 313, 314, 315, 316, 317, 318, 319, 320, 321, 322, 323, 324, 325, 326, 327, 328, 329, 330, 331, 332, 333, 334, 335, 336, 337, 338, 339, 340, 341, 342, 343, 344, 345, 346, 347, 348, 349, 350, 351, 352, 353, 354, 355, 356, 357, 358, 359, 360, 361, 362, 363, 364, 365, 366, 367, 368, 369, 370, 371, 372, 373, 374, 375, 376, 377, 378, 379, 380, 381, 382, 383, 384, 385, 386, 387, 388, 389, 390, 391, 392, 393, 394, 395, 396, 397, 398, 399, 400, 401, 402, 403, 404, 405, 406, 407, 408, 409, 410, 411, 412, 413, 414, 415, 416, 417, 418, 419, 420, 421, 422, 423, 424, 425, 426, 427, 428, 429, 430, 431, 432, 433, 434, 435, 436, 437, 438, 439, 440, 441, 442, 443, 444, 445, 446, 447, 448, 449, 450, 451, 452, 453, 454, 455, 456, 457, 458, 459, 460, 461, 462, 463, 464, 465, 466, 467, 468, 469, 470, 471, 472, 473, 474, 475, 476, 477, 478, 479, 480, 481, 482, 483, 484, 485, 486, 487, 488, 489, 490, 491, 492, 493, 494, 495, 496, 497, 498, 499, 500, 501, 502, 503, 504, 505, 506, 507, 508, 509, 510, 511, 512, 513, 514, 515, 516, 517, 518, 519, 520, 521, 522, 523, 524, 525, 526, 527, 528, 529, 530, 531, 532, 533, 534, 535, 536, 537, 538, 539, 540, 541, 542, 543, 544, 545, 546, 547, 548, 549, 550, 551, 552, 553, 554, 555, 556, 557, 558, 559, 560, 561, 562, 563, 564, 565, 566, 567, 568, 569, 570, 571, 572, 573, 574, 575, 576, 577, 578, 579, 580, 581, 582, 583, 584, 585, 586, 587, 588, 589, 590, 591, 592, 593, 594, 595, 596, 597, 598, 599, 600, 601, 602, 603, 604, 605, 606, 607, 608, 609, 610, 611, 612, 613, 614, 615, 616, 617, 618, 619, 620, 621, 622, 623, 624, 625, 626, 627, 628, 629, 630, 631, 632, 633, 634, 635, 636, 637, 638, 639, 640, 641, 642, 643, 644, 645, 646, 647, 648, 649, 650, 651, 652, 653, 654, 655, 656, 657, 658, 659, 660, 661, 662, 663, 664, 665, 666, 667, 668, 669, 670, 671, 672, 673, 674, 675, 676, 677, 678, 679, 680, 681, 682, 683, 684, 685, 686, 687, 688, 689, 690, 691, 692, 693, 694, 695, 696, 697, 698, 699, 700, 701, 702, 703, 704, 705, 706, 707, 708, 709, 710, 711, 712, 713, 714, 715, 716, 717, 718, 719, 720, 721, 722, 723, 724, 725, 726, 727, 728, 729, 730, 731, 732, 733, 734, 735, 736, 737, 738, 739, 740, 741, 742, 743, 744, 745, 746, 747, 748, 749, 750, 751, 752, 753, 754, 755, 756, 757, 758, 759, 760, 761, 762, 763, 764, 765, 766, 767, 768, 769, 770, 771, 772, 773, 774, 775, 776, 777, 778, 779, 780, 781, 782, 783, 784, 785, 786, 787, 788, 789, 790, 791, 792, 793, 794, 795, 796, 797, 798, 799, 800, 801, 802, 803, 804, 805, 806, 807, 808, 809, 810, 811, 812, 813, 814, 815, 816, 817, 818, 819, 820, 821, 822, 823, 824, 825, 826, 827, 828, 829, 830, 831, 832, 833, 834, 835, 836, 837, 838, 839, 840, 841, 842, 843, 844, 845, 846, 847, 848, 849, 850, 851, 852, 853, 854, 855, 856, 857, 858, 859, 860, 861, 862, 863, 864, 865, 866, 867, 868, 869, 870, 871, 872, 873, 874, 875, 876, 877, 878, 879, 880, 881, 882, 883, 884, 885, 886, 887, 888, 889, 890, 891, 892, 893, 894, 895, 896, 897, 898, 899, 900, 901, 902, 903, 904, 905, 906, 907, 908, 909, 910, 911, 912, 913, 914, 915, 916, 917, 918, 919, 920, 921, 922, 923, 924, 925, 926, 927, 928, 929, 930, 931, 932, 933, 934, 935, 936, 937, 938, 939, 940, 941, 942, 943, 944, 945, 946, 947, 948, 949, 950, 951, 952, 953, 954, 955, 956, 957, 958, 959, 960, 961, 962, 963, 964, 965, 966, 967, 968, 969, 970, 971, 972, 973, 974, 975, 976, 977, 978, 979, 980, 981, 982, 983, 984, 985, 986, 987, 988, 989, 990, 991, 992, 993, 994, 995, 996, 997, 998, 999, 1000.

REV.	DESCRIPTION	DATE	APPROV.
2	REVISED LINE 1 P-125 TO 1" SPEC. BREAK AT P-125, ADD NOTE 1	6-5-98	CAB
1	REVISED PER CHANGE ORDER 2	5-25-98	CAB
0	ISSUED FOR CONSTRUCTION	5-13-98	CAB
F1	FOR CUSTOMER APPROVAL	2-27-98	CAB

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CLIENT INFORMATION		P&ID DMF DISTILLATION SYSTEM	
PROJ. NO.	1000	JOB NO.	797-1222
SCALE	1"=1'-0"	DATE	1-16-98
DESIGNED	DATE	DRAWING NO.	
CHKD.	DATE	REV.	2