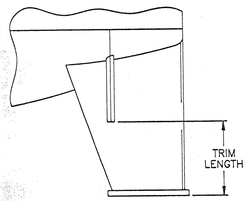
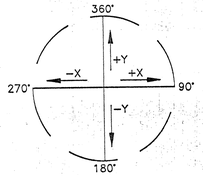
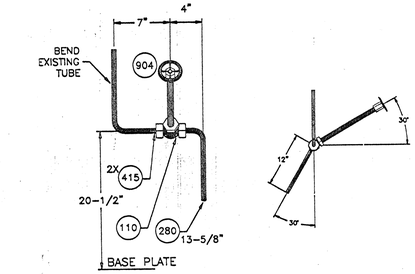
NOTES

1. REFERENCE SCHEMATIC DRAWING CS-12004.
2. ALL PIPING PER ANSI/ASME B31.3, PEI SPEC F-74.
3. CLEANING PER PEI SPEC F-12.
4. CLEAN ALL CONNECTIONS AND REMOVE FLUX PRIOR TO PRESSURE TESTING.
6. ALL SILVER BRAZED JOINTS PER PEI SPEC F-12 (C). ALL WELDED JOINTS PER R1, R2, R3 & R4.
7. SHIP SPARE RUPT DISC WITH TANK ITEM #17

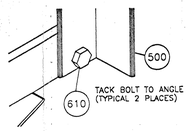




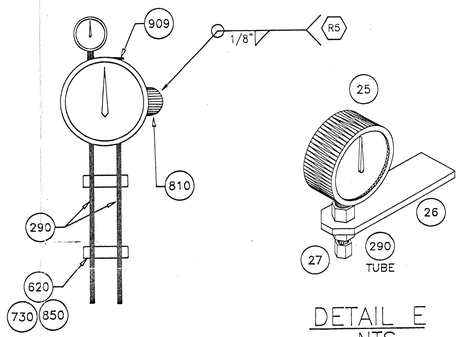
LINE PENETRATION LOCATIONS, SIZES, AND TRIM LENGTHS					
LINE	"X"	"Y"	LINE SIZE	TRIM LENGTH	FUNCTION
A	(-)31-1/4"	(-)43-7/8"	2.375"OD	17-7/8"	BOTTOM FILL
B	36-3/8"	(-)39-3/4"	1.660"OD	22-3/4"	VENT & SAFETY
C	(-)42-1/4"	(-)33-3/4"	1.660"OD	17-3/4"	TOP FILL
D	(-)36-11/16"	(-)37-15/16"	.375"OD	N/A	BOTTOM GAGE
E	(-)39-3/4"	(-)36-3/4"	.375"OD	N/A	TOP GAGE
F	(-)35-3/8"	(-)40-7/8"	.375"OD	N/A	FULL TRYCOCK
G	47"	(-)26-1/8"	1.660"OD	15-13/16"	BOTTOM LIQUID DRAW
H	(-)36-5/16"	37-1/8"	5/8"NPS	N/A	VACUUM GAGE VALVE
K	53-3/4"	14-7/8"	1-1/2"NPS	N/A	EVACUATION VALVE
L	(-)53-7/8"	0"	1.660"OD	15-3/8"	VAPORIZER SUPPLY
M	(-)45-1/16"	(-)29-1/2"	.625"OD	22"	ECONOMIZER RETURN
P	(-)53-1/4"	8-1/4"	2.375"OD	14"	PRESSURE BUILD VAPOR



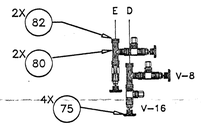
DETAIL A
NTS



DETAIL B
NTS

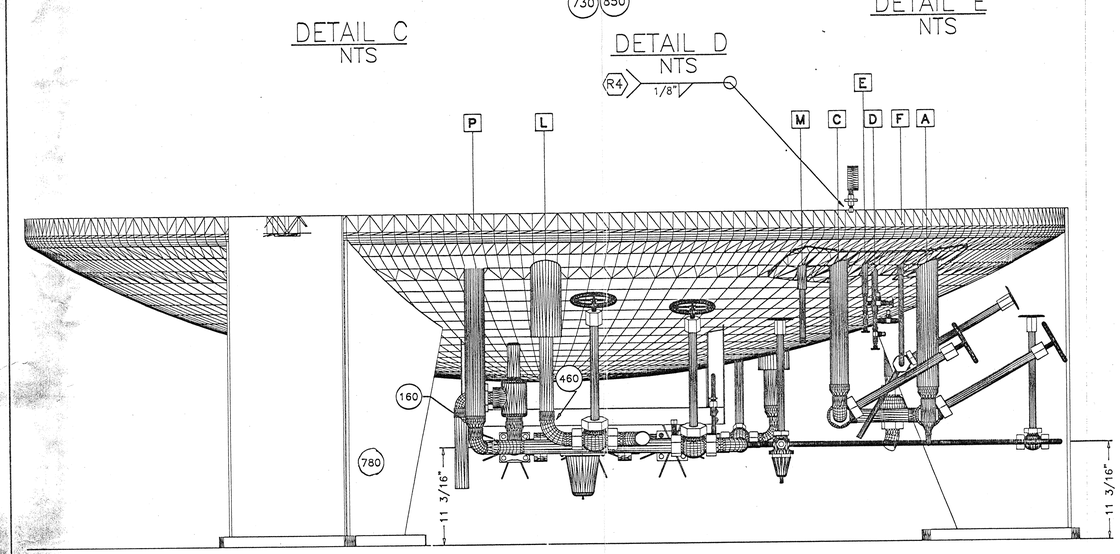


DETAIL E
NTS

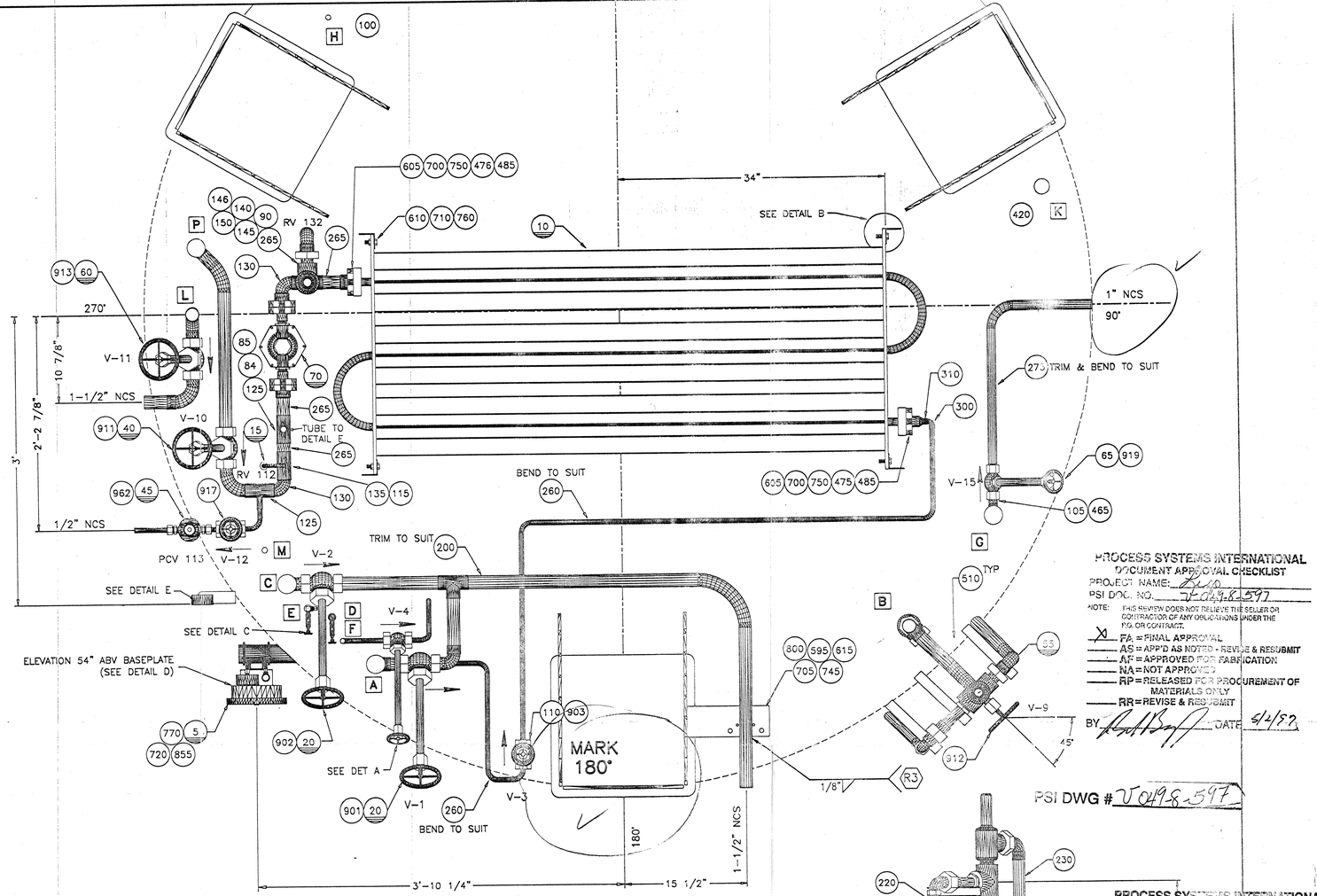


DETAIL C
NTS

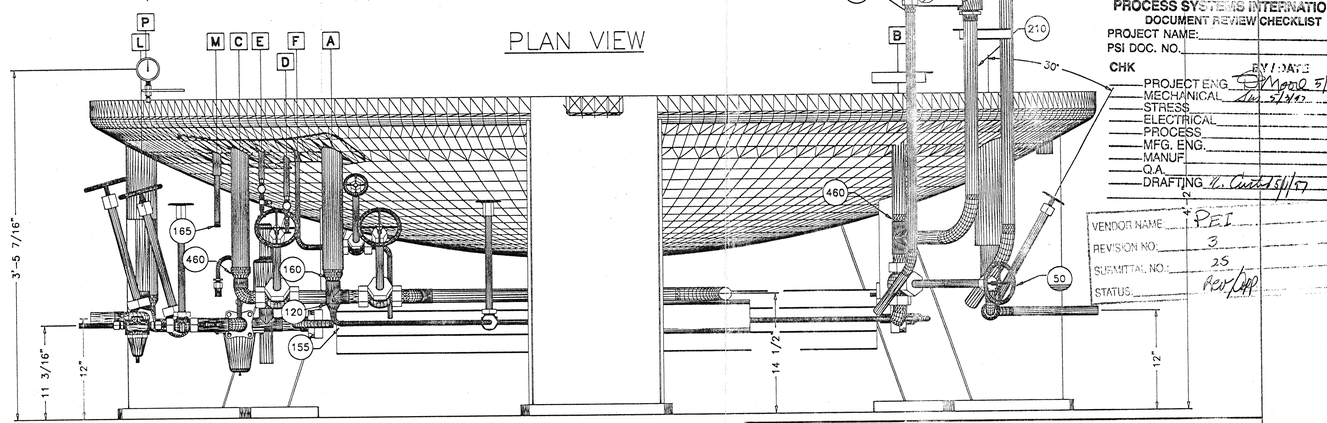
DETAIL D
NTS



LEFT-FRONT VIEW



PLAN VIEW



FRONT VIEW

CERTIFIED
FOR MANUFACTURE
BY RMD
DATE 4/22/97
NOT VALID UNLESS SIGNED
PROCESS ENGINEERING
FORM 69

PROCESS SYSTEMS INTERNATIONAL
DOCUMENT APPROVAL CHECKLIST
PROJECT NAME: EXP
PSI DOC. NO. V-0498-597
NOTE: THIS REVIEW DOES NOT RELIEVE THE SELLER OR CONTRACTOR OF ANY OBLIGATIONS UNDER THE P/O OR CONTRACT.

- X FA = FINAL APPROVAL
- AS = APP'D AS NOTED - REVISE & RESUBMIT
- AF = APPROVED FOR FABRICATION
- NA = NOT APPROVED
- RP = RELEASED FOR PROCUREMENT OF MATERIALS ONLY
- RR = REVISE & RESUBMIT

BY [signature] DATE 5/4/97

PSI DWG # V-0498-597

PROCESS SYSTEMS INTERNATIONAL
DOCUMENT REVIEW CHECKLIST
PROJECT NAME:
PSI DOC. NO.

CHK		BY / DATE
	PROJECT ENG.	RMD 5/1/97
	MECHANICAL	[illegible] 5/2/97
	STRESS	
	ELECTRICAL	
	PROCESS	
	MFG. ENG.	
	MANUF.	
	Q.A.	
	DRAFTING	V. Cantu 5/1/97

VENDOR NAME: PEI
REVISION NO.: 3
SUBMITTAL NO.: 25
STATUS: Rev/App

NO	DATE	BY	CHKD	RECORD OF REVISION
3	4/15/1997	TJN	WVA	CHANGED BOM
2	4/11/1997	TJN	WVA	MODIFIED ITEMS 45 & 55
1	4/8/1997	TJN	WVA	CHANGED BOM

TOLERANCES UNLESS NOTED F-19 & TEMA STD.
TOLERANCES ON: 2 PL DECIMALS +/- 3 PL DECIMALS +/- ANGLES +/- FRACTIONS +/-

APPROVALS	BY	DATE
DRAFTER	TJN	1/30/1997
CHECKER	WVA	2/6/1997
ENGINEERING DESIGN	WK	2/6/1997
MANUFACTURING	RR	2/6/1997
WELDING ENGINEERING	RRP	2/6/1997
QUALITY ASSURANCE	LH	2/6/1997
MAT. RES. PLANNING	SM	2/6/1997

PROCESS ENGINEERING
146 Main Street, PO Box 467
Plaistow, NH 03865
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EXTERNAL PIPING ASSEMBLY
V-17260/14400-8-50 LN2

JOB NO: N-140/15196 | U/M 20 | SCALE 1-1/2"=12"
PART NO. 880.500 & 880.300 | DRAWING NO. D-45682 | REV. 3
SHEET NO: 1 OF 1

SM 4/15/97

U90-D970730-00-V