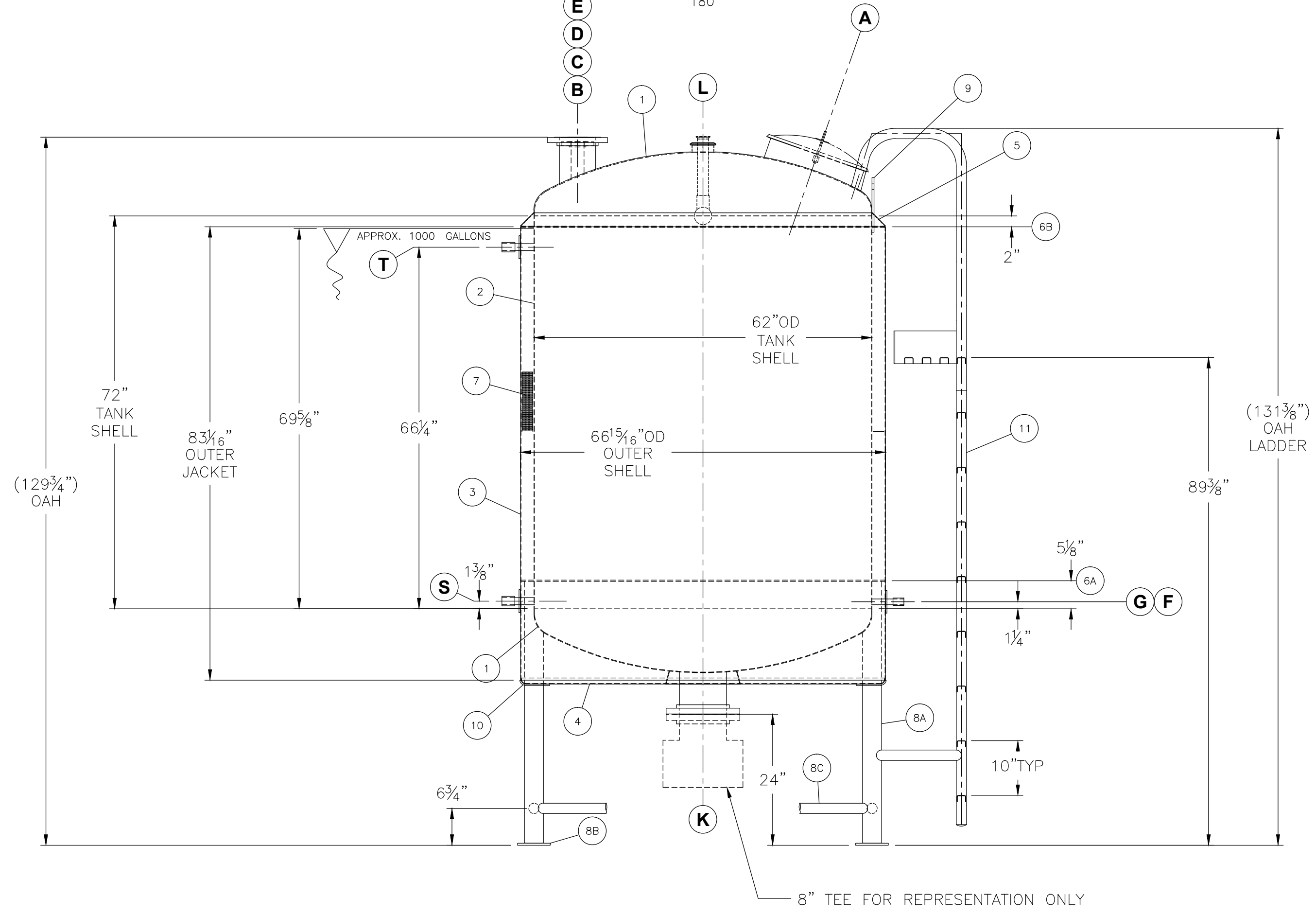
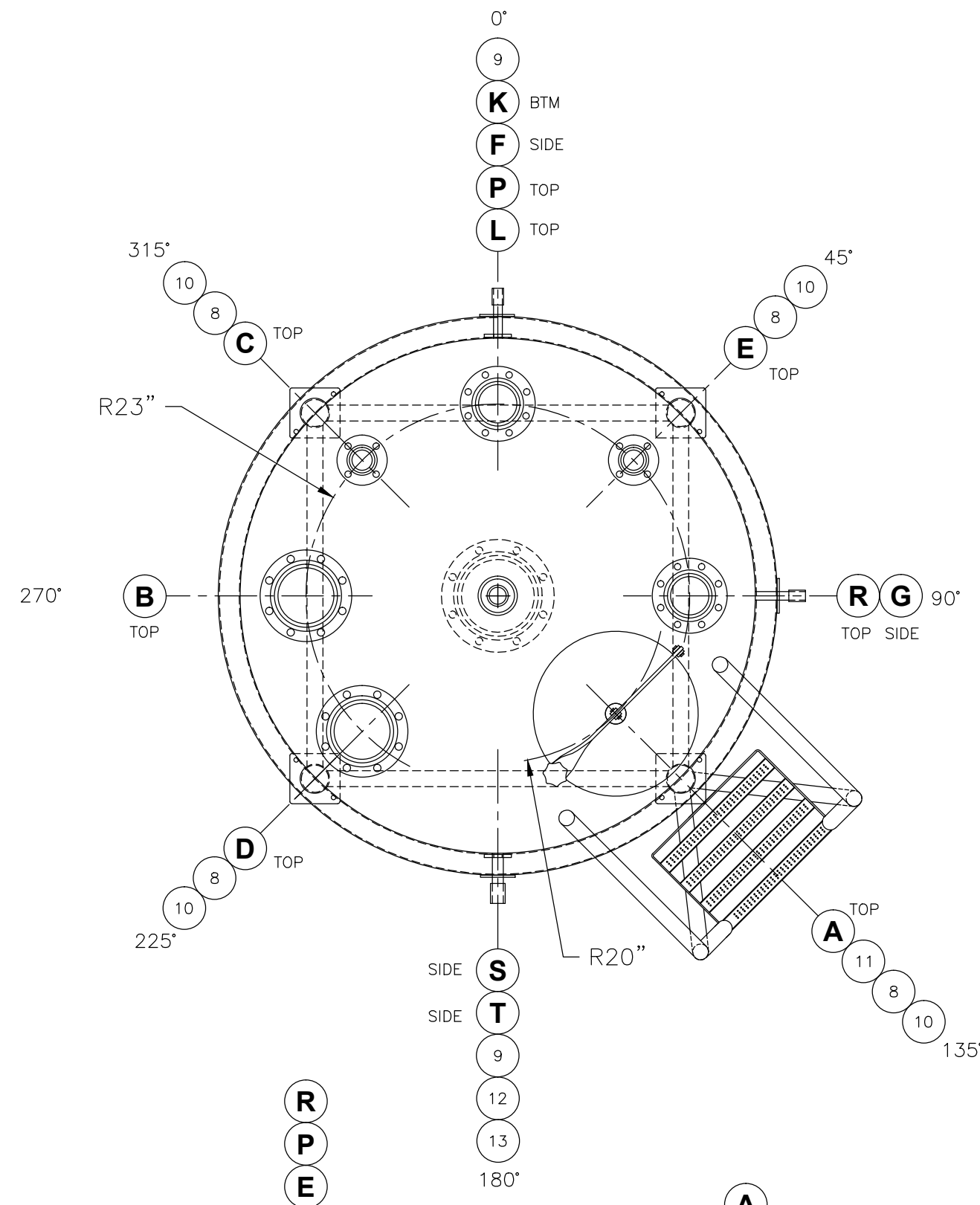
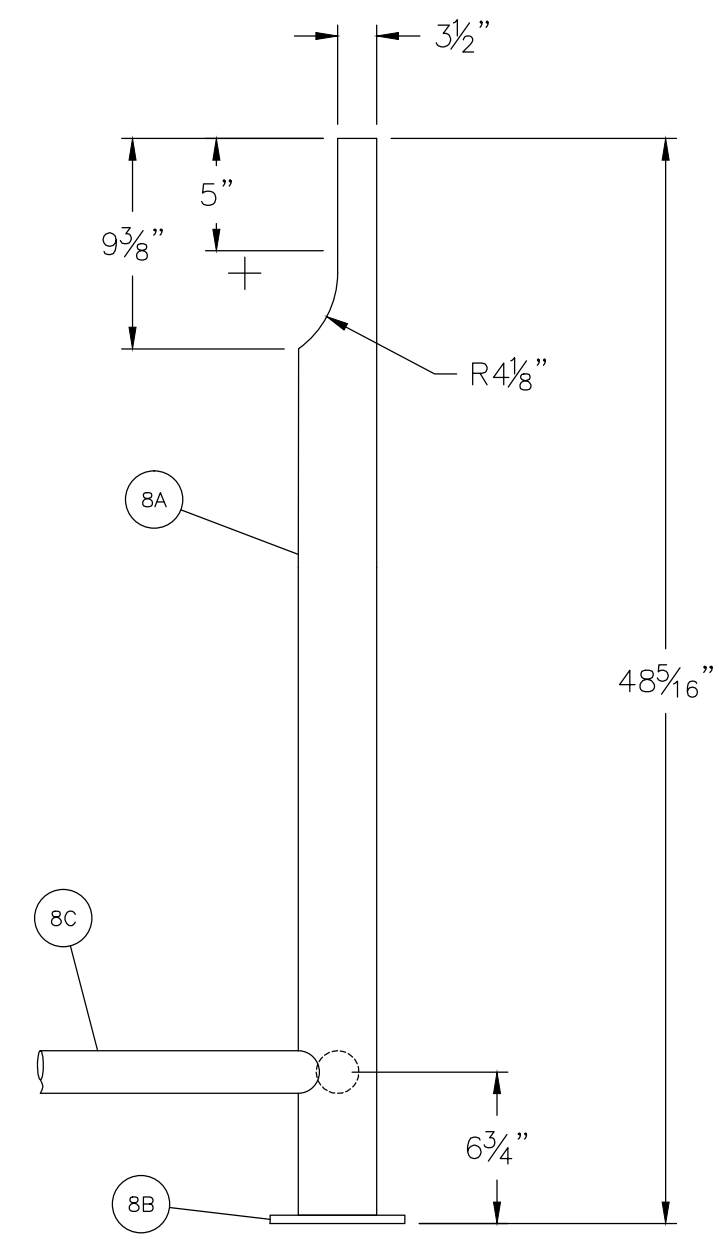


PLAN VIEW
(SHOWS TRUE ORIENTATION)



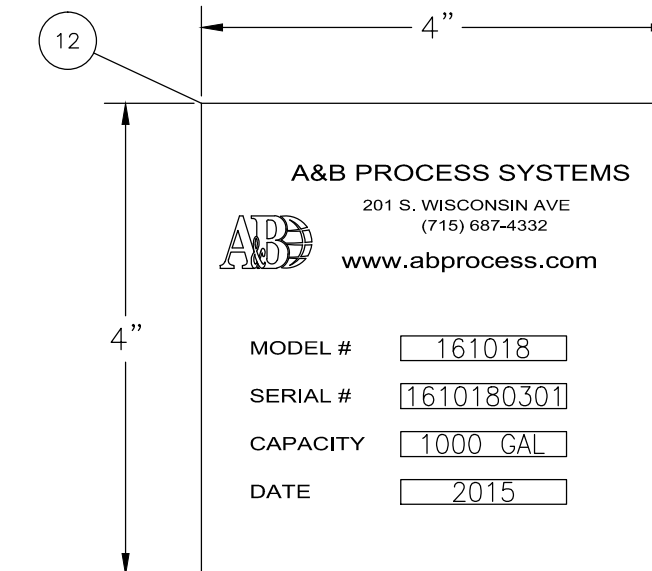
NOZZLE SCHEDULE															
MARK	SIZE	CONNECTION TYPE	SERVICE	PROJECT ±1/4		DETAIL NO.	WELD SIZE								
				IN	OUT		T1	T2	T3	T4	T5	T6	T7		
A	18"	BW	MANWAY	FLUSH	MIN	N-1	-	-	-	-	-	-	-	-	-
B	6"	150# RFSO	INLET	FLUSH	6"	N-1	-	-	-	-	-	-	-	-	-
C	2"	150# RFSO	WATER FILL	FLUSH	6"	N-1	-	-	-	-	-	-	-	-	-
D	6"	150# RFSO	VENT/OVERFLOW	FLUSH	6"	N-1	-	-	-	-	-	-	-	-	-
E	2"	150# RFSO	SPARE	FLUSH	6"	N-1	-	-	-	-	-	-	-	-	-
F	3/4"	F-NPT	TEMP TRANSMITTER	FLUSH	6"	N-1	-	-	-	-	-	-	-	-	-
G	3/4"	F-NPT	TEMP INDICATOR	FLUSH	6"	N-1	-	-	-	-	-	-	-	-	-
K	8"	150# RFSO	OUTLET	FLUSH	7 11/16"	N-1	-	-	-	-	-	-	-	-	-
L	2"x4"	TC FERRULE	SPRAYBALL	FLUSH	1 1/2"	N-1	-	-	-	-	-	-	-	-	-
P	4"	150# RFSO	SPARE	FLUSH	6"	N-1	-	-	-	-	-	-	-	-	-
R	4"	150# RFSO	INLET	FLUSH	6"	N-1	-	-	-	-	-	-	-	-	-
S	1"	F-NPT	LEVEL-LOW	FLUSH	6"	N-1	-	-	-	-	-	-	-	-	-
T	1"	F-NPT	LEVEL-HIGH	FLUSH	6"	N-1	-	-	-	-	-	-	-	-	-

STANDARD - NOZZLE PROJECTIONS GIVEN IN SCHEDULE ARE FOR SHORT SIDE LENGTHS MEASURED FROM ID OF VESSEL
NOZZLE PROJECTION MEASUREMENTS ARE TAKEN FROM THE INSIDE
NOZZLE LENGTHS ON DISHED HEADS OR SIDEWALLS NOT TO EXCEED 1 1/2 PIPE DIAMETERS FROM LONG SIDE UNLESS NOTED OTHERWISE IN NOZZLE SCHEDULE



LEG DETAIL
SCALE: 1/8"=1"
(4) REQ'D

- 1) PLACE 1.5" ABOVE BOTTOM HEAD SEAM @ 180° A&B LOGO TO BE PLACED 1.5" BELOW TOP HEAD SEAM.



IDENTIFICATION TAG DETAIL

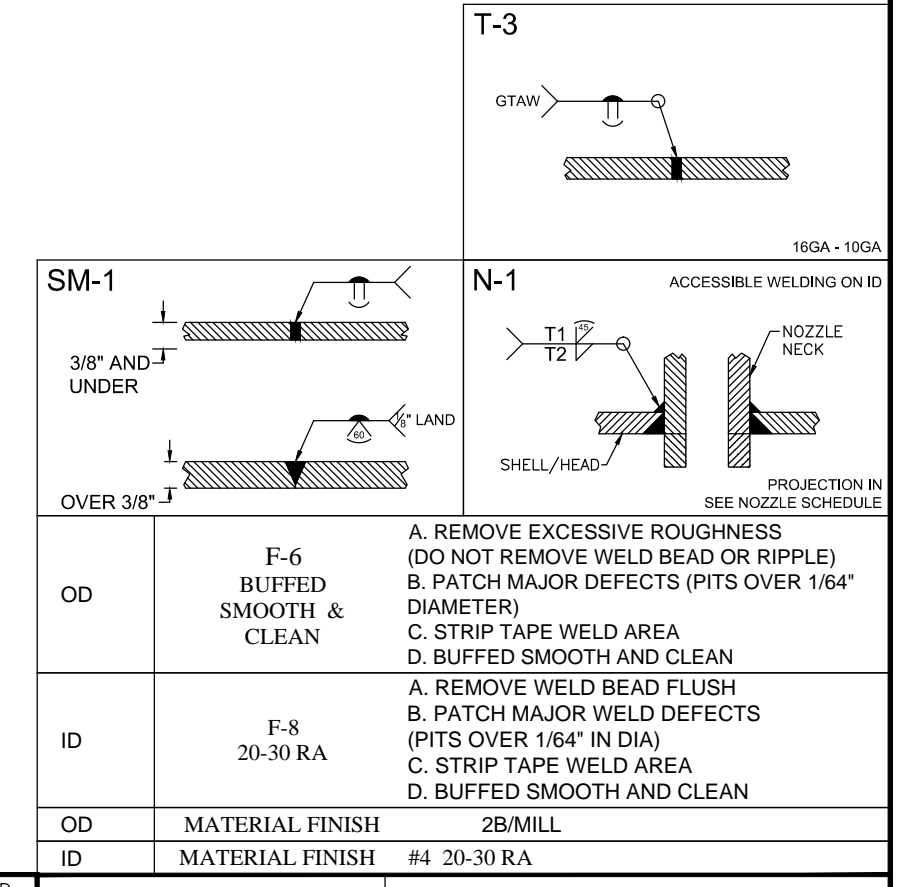
NOTES:

- 1) UNLESS OTHERWISE SPECIFIED ALL DIMENSIONS ARE IN INCHES.
- 2) DIMENSIONS ENCLOSED WITHIN PARENTHESES INDICATE REFERENCE.
- 3) EQUIVALENT ALTERNATIVE MATERIAL MAY BE USED AFTER AUTHORIZED INSPECTOR'S APPROVAL.
- 4) ALL WELDS TO BE CONTINUOUS WELDED PER MANUFACTURER'S STD UNLESS OTHERWISE NOTED.
- 5) WELDS SHALL BE NEAT IN APPEARANCE, FREE OF SLAG, UNDERCUTS AND OTHER DEFECTS.
- 6) VESSEL TO BE THOROUGHLY CLEANED AND DRIED WHERE ACCESSIBLE BEFORE SHIPPING.
- 7) PROTECT ALL MACHINED SURFACES, AND ALL CONNECTIONS WITH WOOD OR PLASTIC PROTECTORS BEFORE SHIPMENT.
- 8) CODE BOUNDARY TO END 1" ABOVE AND 1" BELOW EDGE OF DIMPLE PLATE.
- 9) REINFORCING PADS AND PAD SECTIONS SHALL HAVE 1/8" WEEP HOLE LOCATED AS LOW AS POSSIBLE IN THE PAD WHEN THE VESSEL IS IN OPERATING POSITION.
- 10) OUTER SHELL TO INCLUDE 1" DIA. VENT W/ 1/8" DIA. HOLES LOCATED AT LOWEST POINT.
- 11) WELD 7GA X 1 1/2" X 3" C-CHANNEL TO OUTER SHELL SEAM ON THE INSIDE FOR EXTRA STIFFNESS (OUTER SHELL TO OVERLAP).
- 12) FLANGE BOLT HOLES SHALL STRADDLE MAJOR VESSEL CENTERLINES UNLESS NOTED.
- 13) IF USED IN CONTACT WITH MATERIALS CONTAINING SALT, CHLORIDES OR OTHER CORROSIVE MATERIALS, THE CORROSION RESISTANCE OF THIS EQUIPMENT IS NOT THE RESPONSIBILITY OF A&B PROCESS SYSTEMS CORP.
- 14) PASSIVATION REQ'D. -NO
- 15) RIBOFLAVIN TESTING REQ'D. -NO
- 16) ORBITAL WELDING REQ'D. -NO
- 17) PIPE WELD MAPPING REQ'D. -NO
- 18) (1) TANK REQUIRED AS SHOWN.
- 19) USE BURST TEST PROCEDURE #102

BILL OF MATERIAL									
ITEM	QTY	DESCRIPTION	MAT'L SPEC	DWG/REF	NOTES				
1	2	HEADS - 10GA #62" OD ASME F&D 62" CR 4" KR 1" SF	SA-240-316	-					
2	1	SHELL - 10GA #62" OD 72" TALL	SA-240-316	-					
3	1	OUTER TANK SHELL - 12GA #66 15/16" OD 86 1/16" TALL	SA-240-304	-					
4	1	OUTER BOTTOM HEAD - 12GA #66 3/4" OD FLAT, 3/4" KR, 1/4" SF	SA-240-304	CUT					
5	1	BREAST RING - 12GA	SA-240-304	-					
6A	1	LOWER SUPPORT RING - 1/4" PLATE X #62" ID	SA-240-304	CUT					
6B	1	UPPER SUPPORT RING - 1/4" PLATE X #62" ID	SA-240-304	CUT					
7	1	TANK WRAP - 2" THICK CHLORIDE FREE	CHLORIDE FREE	-					
8A	4	LEGS - 3" SCH 10 PIPE, 47 15/16"	304	-					
8B	4	FOOTPAD - 6" X 6" X 3/8" THK	SA-240-304	S540-2506-2					
8C	14	LEG BRACING - 1 1/2" SCH 10 PIPE, 40 7/8" LONG	304	-					
9	2	TANK LIFTING LUGS - 3 1/4" X 10" X 3/8" THK	SA-240-304	S711-0038					
10	4	PIPETTE BOOTS - SIZE 3	WHITE SILICONE	-					
11	1	LADDER ASSEMBLY	304	-11					
12	1	A&B ASME ID TAG	SA-240-316L	-					
13	1	A&B LOGO - SMALL - MEDIUM - LARGE	VNLY	-					
14	1	DECAL - DANGER CONFINED SPACE	VNLY	-					
15	1	DECAL - CAUTION CHEMICAL HAZARD	VNLY	-					
16	1	DECAL - CAUTION HOT SURFACE	VNLY	-					
A	1	MANWAY - 18" A&B COLLARED MANWAY W/ EPDM GASKET	316	-					
B,D	2	FLANGE - 6" 150# RFSO	SA-182F-316	-					
	2	PIPE - 6" SCH 40	SA-312-316	-					
C	1	FLANGE - 2" 150# RFSO	SA-182F-316	-					
	1	PIPE - 2" SCH 40	SA-312-316	-					
E	1	FLANGE - 2" 150# RFSO	SA-182F-316	-					
	1	PIPE - 2" SCH 40	SA-312-316	-					
	1	FLANGE - 2" 150# RF BLIND	SA-182F-316	-					
	1	RING GASKET - 2" X X1/16 THK 150#	CARLOCK	-					
	4	BOLT - 5/8"-11UNC X 2" LG	18-8	-					
	4	HEX NUT - 5/8"-11UNC	18-8	-					
F,G	2	COUPLING - 3/4" F-NPT FULL COUPLING 3000#	SA-182F-316	-					
	2	PIPE - 3/4" SCH 40	SA-312-316	-					
	2	FLAT PIPTITE BOOT - SIZE 2	WHITE SILICONE	-					
K	1	FLANGE - 8" 150# RFSO	SA-182F-316	-					
	1	PIPE - 8" SCH 40	SA-312-316	-					
	1	ALCOVE - 12" WLD TUBE 12GA	SA-249-304	PA304010					
L	1	FERRULE - 4" TC LG LT TANK, #7	316	-					
	1	GASKET - 4" TUBE TC	EPDM	-					
	1	CLAMP - 4" TUBE TC SINGLE HINGED HD W/ WING NUT	304	-					
	1	SINGLE SPRAYBALL ASSEMBLY - #2 1/2" X 2" TC CONNECTION, 180° COVERAGE	316	65GPM @ 25PSIG					
P	1	FLANGE - 4" 150# RFSO	SA-182F-316	-					
	1	PIPE - 4" SCH 40	SA-312-316	-					
	1	FLANGE - 4" 150# RF BLIND	SA-182F-316	-					
	1	RING GASKET - 4" X X1/16 THK 150#	CARLOCK	-					
	4	BOLT - 5/8"-11UNC X 2" LG	18-8	-					
	4	HEX NUT - 5/8"-11UNC	18-8	-					
R	2	FLANGE - 4" 150# RFSO	SA-182F-316	-					
	2	PIPE - 4" SCH 40	SA-312-316	-					
S,T	2	COUPLING - 1" F-NPT FULL COUPLING 3000#	SA-182F-316	-					
	2	PIPE - 1" SCH 40	SA-312-316	-					
	2	FLAT PIPTITE BOOT - SIZE 2	WHITE SILICONE	-					

DESIGN DATA	
DESIGN AND FABRICATED TO COMP'S	
SHELL	JACKET
DESIGN PRESSURE, PSIG	ATMOS
DESIGN TEMPERATURE °F	300
TRANSFER MEDIA	-
SEISMIC REVIEW FOR:	TROY, MI
ERECTION (SHIPPING) WEIGHT, LBS	APPROX. - 2750
OPERATING WEIGHT: (FILLED TO -" ELEV., SG= -) LBS	APPROX. -
DATA NOT SHOWN IS NOT INCLUDED IN THE DESIGN	

3FR-T0402-006
T04/601



This drawing is being submitted by A&B Process Systems for design verification.
Please note this version supersedes all previous documentation.
 APPROVED
 APPROVED AS NOTED
BY: _____
DATE: _____

MACHINING TOLERANCES (UNLESS NOTED OTHERWISE)	FABRICATION TOLERANCES (UNLESS NOTED OTHERWISE)
.XXX ± .005	X OR FRACT. = ±1/4
.XX ± .010	HOLE DIAMETERS = ±1/8
X ± .020	HOLD DIM'S ±1/8"
X OR FRACT. = ± .030	X DEGREE = ± 1 DEGREE
	TOLERANCES DO NOT APPLY TO LISTED REF DIM'S

A	01DEC15	RELEASE FOR FAB	MJH	FBD
2	30NOV15	RESUBMITTED FOR APPROVAL	FBD	MJH
1	25NOV15	RESUBMITTED FOR APPROVAL	SRS	FBD
0	16NOV15	SUBMITTED FOR APPROVAL	SRS	FBD
NO.	DATE	REVISION DESCRIPTION	DWN BY	CHK BY
		CLIENT NAME: NESTLE		DRAWN BY: SRS
		CLIENT LOCATION: TROY, MI		JOB NUMBER: 161018

A & B PROCESS SYSTEMS CORP.
201 S. WISCONSIN AVE.
STRATFORD, WI. 54484
(715) 687-4332
www.abprocess.com

TITLE: 1000 GALLON STORAGE TANK TANK ASSEMBLY

SCALE: 1/16"=1"

SHEET 1 of 1 REV A