

MOUNT OVER MANWAY

QUOTE N ♀ 111731s1		P.O. No. WB2711009	
FELDMEIER EQUIPMENT			
575 E. Mill Street Little Falls, New York 13365			
DRAWN BY: RSS	ENGRG. Approved By	AI	REV D
DATE 12/15/03			SHEET: 2 of 2
QTY (1) EP - 1,500 GALLONS x 96" I.D. VERTICAL INSULATED 'EP' PROCESSORS			
SOLD TO: KRAFT FOODS NORTH AMERICA, INC. P.O. BOX 795129, SAN ANTONIO, TX 78279			
SHIP TO: KRAFT FOODS INC. ATLANTIC GELATIN DIVISION, WOBURN, MA			DRAWING NO. E-858-03


ITEM	SIZE	QTY.	DESCRIPTION	SERVICE
A	30"x42"	1	D STYLE DRUM DUMPER INLET WITH HINGED COVER, GASKET & HOLD DOWNS (LESS DUMP GRID & DRUM SUPPORT) (NOTE #6)	DUMPER INLET
B	3"	1	STANDARD SLIP ON VENT ASSEMBLY W/ SCREEN & SHROUD	VENT
C	3"	1	150# RFSO CONNECTION (LESS VALVE)	OUTLET
D	20"	1	150# RFSO CONNECTION IN TOP HEAD	INLET
E	-	1	VERTICAL 48" DIA BOTTOM SWEEP AGITATOR POWERED BY A 5 HP SINGLE SPEED TEFC INVERTER DUTY MOTOR OPERATING @ 43 RPM, 230/460/60/3 (LESS SWITCH)	AGITATOR
[B]	[A]		INCLUDES SS MOTOR SUPPORTS, CIP CONTAINMENT SEAL, SS BOTTOM SHAFT GUIDE W/ REPLACEABLE NYLON BEARING, AND FOOD GRADE LUBRICATION IN THE GEAR BOX	
[D] F	16"x20"	1	STANDARD INSIDE SWING MANWAY WITH GASKET, SAMPLE VALVE AND GRAB HANDLE IN LOWER SIDEWALL W/ SETBACK	MANWAY
G	2-1/2"	3	SANITARY CLAMP CONNECTION IN THE TOP HEAD	INLETS
[B] H	10"	1	150# RFSO CONNECTION IN TOP HEAD FOR ROTOCLONE DUCT	ROTOCLONE DUCT
J	1.5"x3	1	1-1/2" SANITARY CLAMP CONN. W/ DUAL SPRAY BALLS, REMOVABLE, MOUNTED IN A 3" SANITARY CLAMP CONN.	CIP
K	1-1/2"	4	PIPE NIPPLE, MALE NPT, FOR HEAT TRANSFER INLET / OUTLET	HEAT TRANSFER
L	-	1	STAINLESS STEEL REMOVABLE AND ADJUSTABLE BAFFLE	BAFFLE
[C] M	-	7	LEG SUPPORTS W/ ADJUSTABLE SPUN BALL FEET	LEGS
N	-	2	LIFT LUGS - 304 SS (NOT SHOWN)	LIFT LUGS
[B] P	3"	1	SANITARY CLAMP CONNECTION IN THE LOWER SIDEWALL W/ CAP, CLAMP & GASKET	HOSE PORT
[C] Q	-	1	PRODUCT INLET TRANSITION: 54"x54"x20" 150# FLANGE, INCLUDES FLEXIBLE CONNECTION 316L STN. STL. (LESS MOUNTING HARDWARE)	INLET

GENERAL NOTES:

- ALL GROVE & BUTT WELDS TO BE FULL PENETRATION UNLESS NOTED OTHERWISE.
- ALL EXTERNAL PIPING & COMPONENTS TO BE SUPPORTED INDEPENDENT OF VESSEL.
- ALL SHEATHING PENETRATIONS FLARED AND SILICONE CAULKED.
- FLANGE BOLT HOLES TO STRADDLE MAJOR TANK CENTERLINES.
- FOR CIP CLEANING, THE MANWAY DOOR MUST BE OPEN.
- 30" x 42" COVER WILL NOT RETAIN ALL CIP SOLUTION.

ASME NOTES:

- MATERIALS & CONSTRUCTION PER ASME SECTION VIII, DIV 1, 2001 EDITION, 2002 ADDENDA.
- ALL WELDERS AND WELDING PROCEDURES ARE CERTIFIED IN ACCORDANCE WITH ASME SECTION IX.
- SEE NAMEPLATE DETAILS FOR CODE STAMPING REQUIREMENTS.
- VESSEL IS EXEMPT FROM IMPACT TESTING PER UHA-51(d&e).
- YEAR IN WHICH COMPLIANCE WITH ALL CODE REQUIREMENTS HAVE BEEN MET IS TO BE STAMPED IN THIS SPACE.
- HEAT TRANSFER DESIGN OPTION; SIDE WALL: CW08.
- HEAT TRANSFER JACKET ASME CODE BOUNDARY ENDS AT THE FIRST CIRCUMFERENTIAL JOINT OF THE INLET & OUTLET PIPE NIPPLES. REF ASME SECTION VIII, U-1(e)(1)(a).
- REFER TO BILL OF MATERIALS #E-858-03 FOR SUB ASSEMBLIES.

		CERTIFIED BY FELDMER EQUIPMENT, INC. Little Falls, New York, USA	
VESSEL MAWP <input type="text"/> XXX PSI AT <input type="text"/> XXX °F		MIN. DESIGN METAL TEMP <input type="text"/> XXX °F AT <input type="text"/> XXX PSI	
JACKET MAWP <input type="text"/> 100 PSI AT <input type="text"/> 350 °F		MIN. DESIGN METAL TEMP. <input type="text"/> -20 °F AT <input type="text"/> 100 PSI	
YEAR BUILT <input type="text"/>		SERIAL NO. <input type="text"/> E-858-03	
MADE IN THE UNITED STATES OF AMERICA			

SEE ASME NOTE 5

WELDING SPECIFICATIONS:			
LISTED SPEC'S. ARE APPROVED FOR USE UNLESS OTHERWISE NOTED ON THIS DRAWING			
W101A	R4	WCB 1000	R7
W102B	R1		
W111	R-		
W101S	R-		

INTERNAL FINISH SPECIFICATION:	
MATERIAL:	#4 FINISH
WELDS:	150 GRIT
EXTERNAL FINISH SPECIFICATION:	
MATERIAL:	#4 FINISH
EXCEPT:	FLAT BOTTOM TRIM
WELDS:	#2B FINISH
EXCEPT:	150 GRIT
MANWAY HDWR, MOTOR SUPPORTS, LIFTING LUGS, FLAT BOTTOM TRIM, 20" FLANGES & TRANSITION ANGLE	UNIFORMLY MASKED AND CLEANED ONLY TO REMOVE DISCOLORATION

TESTING PRESSURE:	
VESSEL: N/A	JACKET: 134 PSIG

APPROXIMATE WEIGHTS:	
EMPTY VESSEL: 3,950 LBS.	

CIP REQUIRED: 80 GPM @ 25 PSIG

DESIGN DATA

VESSEL WORKING CAPACITY: 1,500 GALLONS				
VESSEL DESIGN ATMOSPHERIC OPERATION			HEAT TRANSFER: ASME CODE 'UM' STAMPED	
			PRESSURE: 100 PSIG	
			MAX. TEMP.: 350° F	
			MIN. TEMP.: -20° F	
VESSEL MATERIAL:	SPEC.	GRADE	THICKNESS/CLASS	NOTES
SHELL:	SA-240	316L	10 GA (0.1350")	96" I.D.
TOP HEAD (F&D):	SA-240	316L	7 GA (0.187")	102" I.D.
BOTTOM HEAD (FLAT FLANGED):	SA-240	316L	10 GA (0.1350")	96" I.D., 3/4" PITCH PER FOOT
SHEATHING:	SA-240	304	12 GA (0.1054")	-
FLAT BOTTOM SHEATHING:	SA-240	304	12 GA (0.1054")	-
SANITARY CLAMP FERRULES:	SA-479	316L	-	-
RFSO FLANGE:	SA-182	316L	150#	-
NOZZLE EXTENSION:	SA-312	316L	-	-
NOZZLE EXTENSION - 20":	SA-240	316L	7 GA (0.187")	20" O.D.
D STYLE DRUM DUMPER	SA-240	316L	-	WITH HINGED COVER
FALSE BOTTOM:	SA-240	316L	10 GA (0.1350")	W/ (8) REMOVABLE SECTIONS
HEAT TRANSFER:				FOR WATER OR STEAM
CHANNEL JACKET (SIDEWALL):	SA-240	304	16 GA (0.0595")	80 SQ.FT., (2) ZONES
JACKET MANIFOLDS (SIDEWALL):	SA-240	304	10 GA (0.1350")	'C' MANIFOLDS - 7/8" x 2-7/8"
PIPE NIPPLES:	SA-312	304	1-1/2" SCH 40	MALE NPT
OTHER MATERIAL:				
LIFT LUGS:	SA-240	304	-	NOT SHOWN
LEG SUPPORTS: [C]	SA-312	304	3" SCH 40	-
FEET: [C]	SA-312	304	2" SCH 40	ADJUSTABLE W/ BALLED ENDS
SWEEP BLADE:	SA-240	316L	-	-
AGITATOR SHAFT:	SA-312	316L	2" SCH 40	-
MOTOR RAILS:	SA-312	304	2" SCH 40	-
INSULATION (SIDEWALL AND BOTTOM):	-	-	3" CHLORIDE AND ASBESTOS FREE SOFT FIBERGLASS	
SHOP TOLERANCES:				
SHELL: DEVIATION FROM VERTICAL: ± 1/2"		NOZZLES: PROJECTION: SHORTEST DISTANCE FROM OUTSIDE SURFACE TO FLG.		
OUT OF ROUNDNESS: ± 1" OF NOM. "D"		FACE ± 1/4"		
HEADS: OUTER PROFILE: NOT TO EXCEED 1.25" OF NOM. "D"		DEVIATION FROM HORIZONTAL, VERTICAL OR INTENDED POSITION ± 1/2"		
INNER PROFILE: NOT TO EXCEED .625" OF NOM. "D"		DEVIATION OF BOLT HOLES IN ANY DIRECTION ± 1/8"		
MANWAY: LOCATION IN ANY PLANE ± 1/2"		DEVIATION FROM ANGULAR LOCATION ± 1/2"		
SUPPORTS: DEVIATION FROM ANGULAR LOCATION ± 1"		WELD FILLET SIZE: + 1/8", - 0"		
DEVIATION FROM REFERENCE LINE ± 1/4"				

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NO.	ALTERATION	DATE	CHG. BY
[D]	REVISED AS BUILT - ADDED SETBACK	4/12/04	RGF
[C]	LEG SUPPORTS WERE 4" SCH 40 PIPE, FEET WERE 3" SCH 40 PIPE, ADDED ITEM Q, PER CHANGE ORDER #2, AND ADDED 20" FLGS & ANGLE TO (EXCEPT) WELD FINISH	3/30/04	AWS
[B]	MOTOR WAS 2 HP @ 25 RPM, ADDED 3" CONN. FOR CLEANING UNDER FALSE BOTTOM & ROTOCLONE DUCT CONN. WAS 6" RFSO	3/12/04	RGF
[A]	MANWAY WAS 13" FROM BOTTOM HD SEAM MOTOR WAS 2 HP @ 41 RPM BLADE WAS 36" DIA	12/22/03	RSS

ASME NAMEPLATE STAMPING