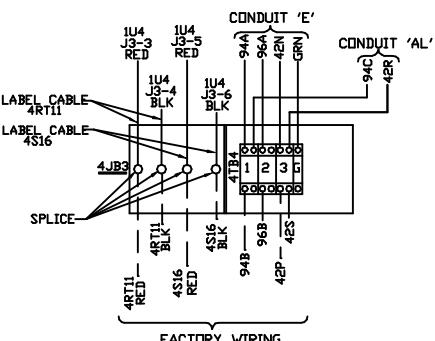
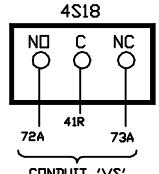


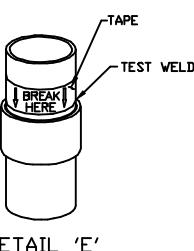
THREE PIECE UNIT - CONNECTIONS			
CONNECTION (BALLOON #)	RESPONSIBILITIES - FOR VARIOUS SHIPPING OPTIONS		
	FACTORY	CONTRACTOR (JOBSITE)	
DAUF & EAUF ONLY	DDU & EDU ONLY	DISASSEMBLY DAUF & EAUF ONLY	REASSEMBLY ALL
PIPING			
1			GRIND OUT GROOVE WELD SEE CONTRACTOR NOTE
2			PROVIDE GROOVE WELD AT EACH CONNECTION TYPE 5G WELD SEE CONTRACTOR NOTE 5
3			
4			
5			
6			
7			
8			
9			
10			
11			
12			
13			
14			
TIE PLATES			
20		REMOVE 20 - 7/8 DIA BOLTS & NUTS	INSTALL GASKET, 4-5/8 DIA BOLTS, NUTS & JOIN 1/2" UNION
21	ASSEMBLE TIE PLATES	REMOVE 4 - 1 1/4 DIA BOLTS & NUTS	INSTALL 20 - 7/8 DIA BOLTS & NUTS
22		PLACE IN BAG AND PUT IN LOOSE PARTS BOX	INSTALL 4 - 1 1/4 DIA BOLTS & NUTS
23			
ELECTRICAL			
4R1			
4R2			
4R3			
4RT8			
4RT9			
4RT17			
4RT18			
4RT19			
4RT22			
CONDUIT SS		REMOVE SENSORS FROM BULBWELLS AND TAPE TO EVAP AT CONVENIENT LOCATION SEE FACTORY NOTE 2	INSTALL SENSORS IN BULBWELLS USING HEAT CONDUCTIVE LUBE. SENSORS (4RT17, 4RT18 & 4RT19) MUST BE COVERED WITH INSULATION PROVIDED IN LOOSE PARTS BOX
4S17		DISCONNECT CONDUIT SS & 4S17 (CABLE 3) AND ROLL UP & TAPE TO EVAP SEE FACTORY NOTE 2	NO DISASSEMBLY REQUIRED
4S18		DISCONNECT CONDUIT VS AND ROLL UP & TAPE TO EVAP, SEE FACTORY NOTE 2	INSTALL CONDUIT SS TO ENERGY VALVE 4B11 & CONN CABLE 3 (4S17) TO BPI SW. SEE DETAIL 'F'
CONDUITS E & AL		DISCONNECT CONDUIT E, AL, 4RT11 & 4S16 AT 4JB3 AND ROLL UP & TAPE TO EVAP SEE FACTORY NOTE 2	INSTALL CONDUIT VS TO PRESS SW (4S18), SEE DETAIL 'D'
4RT11			
4S16			



DETAIL 'C'



DETAIL 'D'

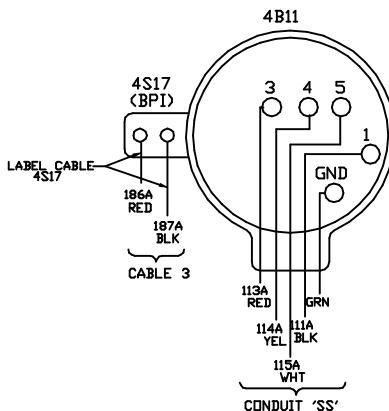


DETAIL 'F'

TWO PIECE UNIT - CONNECTIONS				
RESPONSIBILITIES - FOR VARIOUS SHIPPING OPTIONS				
CONNECTION BALLOON #	FACTORY	CONTRACTOR (JOBSITE)		
	DAGF & EAGF ONLY	DDG & EDG ONLY	DISASSEMBLY DAGF & EAGF ONLY	REASSEMBLY ALL
2				
3				
4				
5				
6				
7				
8	PROVIDE A TEST WELD AT EACH JOINT FOR TESTING & SHIPMENT SEE FACTORY NOTES 1 & 3	PROVIDE A TEST WELD AT EACH JOINT FOR TESTING. AFTER ALL TESTS ARE COMPLETE, REMOVE WELDS AND BREAK UNIT INTO 2-Pieces FOR SHIPMENT. ALL PIPE CONNS ON EACH SECT TO BE CAPPED WITH A PLASTIC PLUG & TAPE SECURELY TO SEAL CONN FOR SHIPMENT SEE FACTORY NOTE 1	REMOVE FILLET WELDS SEE DETAIL 'B' SEE CONTRACTOR NOTE 1	PROVIDE FILLET WELD AT EACH CONNECTION TYPE 4F WELD SEE CONTRACTOR NOTE 5
9				
10				
11				
12				
13				
14				
TIE PLATES				
22	ASSEMBLE TIE PLATES	REMOVE 15 - 7/8 DIA BOLTS & NUTS REMOVE 4 - 1 1/4 DIA BOLTS & NUTS PLACE IN BAG AND PUT IN LOOSE PARTS BOX	REMOVE 15 - 7/8 DIA BOLTS & NUTS REMOVE 4 - 1 1/4 DIA BOLTS & NUTS	INSTALL 15 - 7/8 DIA BOLTS & NUTS INSTALL 4 - 1 1/4 DIA BOLTS & NUTS
23				
ELECTRICAL				
4R1				
4R2				
4R3				
4RT8				
4RT9				
4RT17		REMOVE SENSORS FROM BULBWELLS AND TAPE TO EVAP AT CONVENIENT LOCATION SEE FACTORY NOTE 2		INSTALL SENSORS IN BULBWELLS USING HEAT CONDUCTIVE LUBE. SENSORS (4RT17, 4RT18 & 4RT19) MUST BE COVERED WITH INSULATION PROVIDED IN LOOSE PARTS BOX
4RT18				
4RT19				
4RT22				
CONDUIT SS		DISCONNECT CONDUIT SS & 4S17 (CABLE 3) AND ROLL UP & TAPE TO EVAP SEE FACTORY NOTE 2	NO DISASSEMBLY REQUIRED	INSTALL CONDUIT SS TO ENERGY VALVE (4B11) & CBBN CABLE 3 (4S17) TO BPI SW. SEE DETAIL 'F'
4S17		DISCONNECT CONDUIT VS AND ROLL UP & TAPE TO EVAP, SEE FACTORY NOTE 2		INSTALL CONDUIT VS TO PRESS SW (4S18), SEE DETAIL 'D'
CONDUITS E & AL		DISCONNECT CONDUIT E, AL, 4RT11 & 4S16 AT 4JB9 AND ROLL UP & TAPE TO EVAP SEE FACTORY NOTE 2		INSTALL CONDUIT E, AL 4RT11 & 4S16 INTO 4JB9 SEE DETAIL 'C'
4RT11				
4S16				

FACTORY NOTES:

1. PREPARE UNIT FOR SHIPPING, PER SALES ORDER REQUIREMENTS.
UNIT MAY BE SHIPPED AS AN ASSEMBLED UNIT FOR FIELD 2 OR 3 PIECE DISASSEMBLY
& REASSEMBLY OR AS A 2 OR 3 PIECE DISASSEMBLED UNIT FOR FIELD REASSEMBLY.
SEE TABLE FOR INSTRUCTIONS
2. AFTER TESTING UNIT, DISCONNECT ELECTRICAL CONNECTIONS AND SENSORS AS
INDICATED IN TABLES. TAG END OF ALL CONDUITS & SENSOR CABLES WITH
PROPER IDENTIFICATION. COVER ALL CONDUITS & SENSOR ENDS WITH A
PLASTIC BAG AND SECURE TO ENDS WITH TAPE.
3. FOR UNITS THAT SHIP ASSEMBLED (DAUF, EAUF, DAGF, EAGF), IDENTIFY ALL
BREAK APART PIPING JOINTS AS DEFINED IN TABLE BY APPLYING TAPE AROUND
THE WHOLE JOINT, (CODE X39001214-01) SEE DETAIL 'E' BELOW.



DETAIL 'F'
STEAM ENERGY VALVE STEPPER
2 & 3-PIECE SPLIT

# IF TOLERANCED, TRIM STD EN120902 UNLESS OTHERWISE SPECIFIED		DATE	THEIR TRADE NAME OR AMERICAN EQUIVALENT	PC
— ± —	— ± —	PCP T 1 PCP T 1	THE DRAWING IS NOT TO BE USED AS A SIZE OR POSITION TOLERANCE	
— ± —	— ± —	PCP T 1 PCP T 1	THE DRAWING IS NOT TO BE USED AS A SIZE OR POSITION TOLERANCE	
— ± —	— ± —	PCP T 1 PCP T 1	THE DRAWING IS NOT TO BE USED AS A SIZE OR POSITION TOLERANCE	
FINISH ✓		THE DRAWING IS NOT TO BE USED AS A SIZE OR POSITION TOLERANCE		
ANGLES = ± * HOLE DIA = ±		THE DRAWING IS NOT TO BE USED AS A SIZE OR POSITION TOLERANCE		
REF. ANSI Y14.5M-1962		THE DRAWING IS NOT TO BE USED AS A SIZE OR POSITION TOLERANCE		

CONTRACTOR NOTES:

1. UNITS THAT SHIP ASSEMBLED
CONTRACTOR MUST FIRST BREAK VACUUM THEN DISASSEMBLE AND REASSEMBLE. ALL PIPE JOINTS TO BE BROKEN ARE IDENTIFIED WITH WHITE TAPE INDICATING THE WELD TO BE REMOVED. SEE DETAIL 'E' BELOW.

UNITS THAT SHIP DISASSEMBLED (2 OR 3 PIECE)
CONTRACTOR TO REASSEMBLE UNIT.

2. REFER TO THIS DRAWING (SHEETS 1 & 2) FOR GENERAL INFORMATION.
REFER TO UNIT INSTALLATION MANUAL FOR SPECIFIC STEP BY STEP
INSTRUCTIONS.

3. USE FOUR POINT LIFT ON EACH SECTION.

4. ALL PIPING WELDS MUST BE COMPLETED BY AN ASME OR AWS CERTIFIED WELDER TO INSURE A VACUUM TIGHT SEAL.

5. WELD NOTES

a. RECOMMENDED WELDING - STICK USING E7018 FILLER ROD OR TIG (GTAW) USING ER70S-6 ELECTRODE.

b. ALL GROOVE WELDS: - CARBON STEEL PIPE, ALL AROUND, FULL PENETRATION

c. ALL FILLET WELDS: - CARBON STEEL PIPE, ALL AROUND

- 1/2" THRU 1 1/2" NPS = .10 FILLET
- 2" THRU 4" NPS = .20 FILLET
- GREATER THAN 4" NPS = .25 FILLET

d. CARE MUST BE TAKEN DURING WELD REMOVAL AND REWELDING TO INSURE THAT INTERIOR OF PIPING IS KEPT AS CLEAN AS POSSIBLE. ALSO CARE MUST BE TAKEN TO PROTECT SENSOR WIRING AND ELECTRICAL CONDUIT FROM GRINDING AND WELDING DAMAGE.

e. LEAK TEST USING 10 PSI NITROGEN AND A LEAK DETECTOR TO CONFIRM WELDS.

IF UNLAWFUL TO REMOVE, DO NOT REMOVE		QND	THE THREE COMPANY
WELDING SPECIFICATIONS		QND	2630-1526
ASME SECTION VIII		QND	1
CLASS 1		SCALE	1
1/2" = 1'		TYPE	1
1/4" = 1/2'		DATE	10-1-95
1/8" = 1/4'		FINISH	✓
ASME # 1 HOLE DIA = 6		APLIES TO	REF. ASME VIII-2M-1987
1/2" = 1'		SECTION	ASME VIII-2
1/4" = 1/2'		REVISION	1
1/8" = 1/4'		EXPIRATION	10-10-96
1/2" = 1'		RELEASER	1

REMOVE TEST WELD
FOR DISASSEMBLY &
SEE CONTRACTOR
NOTE 5 FOR
REASSEMBLY
(TYPE BF WELD)



DETAIL 'A'

REMOVE TEST WELD
FOR DISASSEMBLY &
SEE CONTRACTOR
NOTE 5 FOR
REASSEMBLY
(TYPE 4F WELD)



DETAIL 'B'

CONTRACTOR BREAK APART PIPING JOINTS

