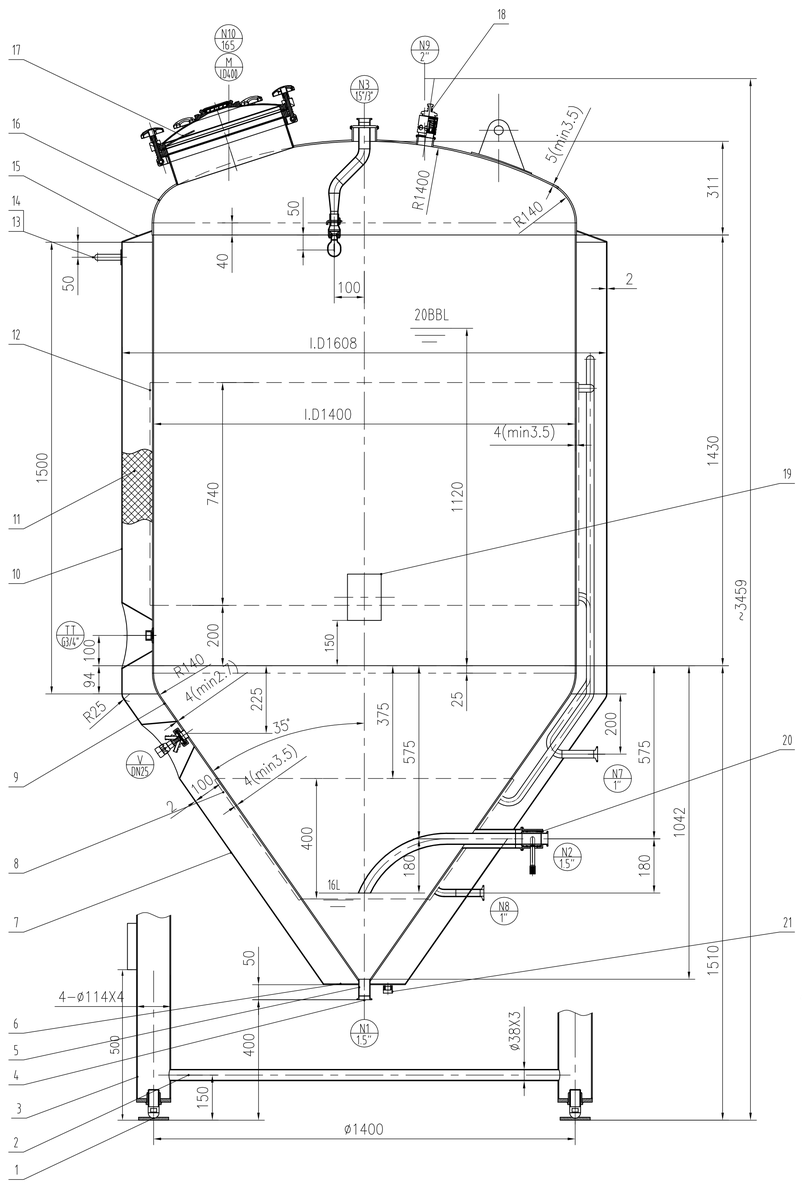
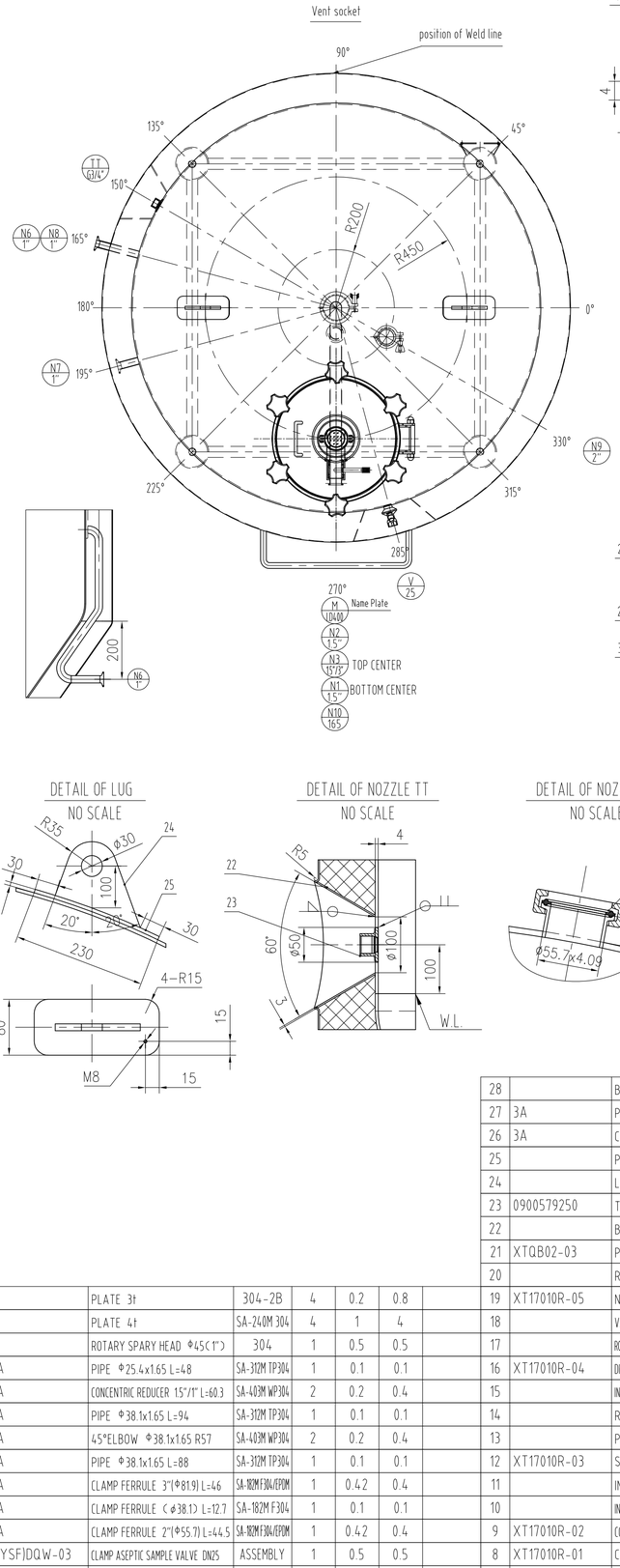
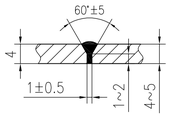
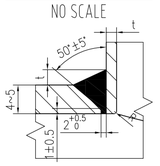




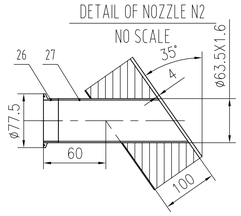
WELDING DETAIL OF MAIN BODY
NO SCALE



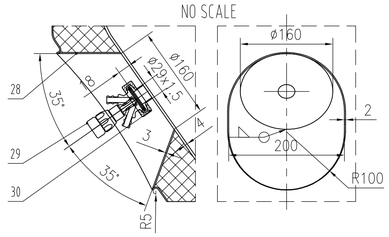
WELDING DETAIL OF MAIN BODY
NO SCALE



DETAIL OF NOZZLE N2
NO SCALE



DETAIL OF NOZZLE V
NO SCALE

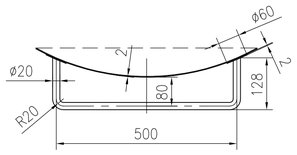


DETAIL OF LUG
NO SCALE

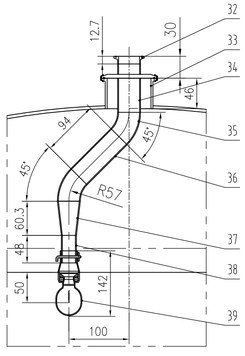
DETAIL OF NOZZLE TT
NO SCALE

DETAIL OF NOZZLE N9
NO SCALE

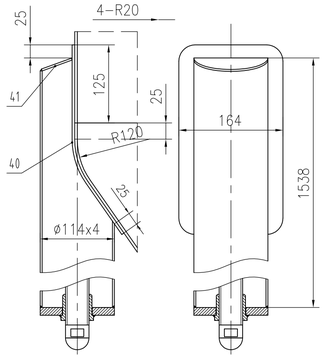
DETAIL OF LADDER HANGING
NO SCALE



DETAIL OF NOZZLE N3
NO SCALE



DETAIL OF LEG
NO SCALE



DESIGN DATA TABLE					
DESIGN PARAMETER				DESIGN、FABRICATION AND INSPECTION STANDARD	
CERTIFICATION MARK WITH THE U DESIGNATOR	YES/NO	YES		1.ASME BOILER AND PRESSURE VESSEL CODE, SECT.VIII DIV.1, 2015ED	
NB REGISTRATION REQUIRED	YES/NO	YES			
PARAMETER NAME		SHELL	JACKET		
DESIGN PRESSURE	bar	2	6	FABRICATION AND INSPECTION REQUIREMENTS	
WORK PRESSURE	bar	2	3	WELDING MATERIAL	FILLER METALS HAVE CHEMICAL COMPOSITIONS、MECHANICAL PROPERTIES MATCHED WITH THOSE OF THE BASE METALS, FOR DETAIL OF WELDING MATERIAL TYPE、SEE WPS.
MAWP	bar	2 AT 40°C	6 AT 40°C		
DESIGN TEMPERATURE	°C	-10/40	-10/40		
WORK TEMPERATURE	°C	-4/40	-4/40	NDE	WELDED JOINTS CATEGORY / TEST RATIO / TEST MEANS / GRADE
MDMT	°C	-10 AT 2bar	-10 AT 6bar		SHELL SIDE A SHELL: SPOT / RT / UW-52
MEDIUM NAME		BEER	GLYCOL WATER		SHELL SIDE A HEAD: FULL / RT / UW-51
MEDIUM CHARACTERISTIC		NON-LETHAL	NON-LETHAL		SHELL SIDE B: SPOT / RT / UW-52
MEDIUM GROUP		/	/		SHELL SIDE C NOZZLE NPS>10 or t>29mm: / / /
MEDIUM DENSITY	kg/m ³	1040	950		SHELL SIDE C OTHER、D: / / /
MAIN PRESSURE PART MATERIAL		SA-240M 304	SA-240M 304		JACKET A SHELL: / / /
CORROSION ALLOWANCE	mm	0	0		JACKET A HEAD: / / /
JOINT EFFICIENCY	SHELL/HEAD	0.85	0.8		JACKET B: / / /
CAPACITY	m³	3.15	/		JACKET C NOZZLE NPS>10 or t>29mm: / / /
HEAT TRANSFER AREA	m²	4.6			JACKET C OTHER、D: / / /
INSULATION MATERIAL		PU 40~50kg/m3		TEST	TEST TYPE / SHELL / JACKET
INSULATION THINCKNESS	mm	100			HYDRAULIC TESTING PRESSURE(V) bar: 2.6 / 7.8
EQUIPMENT NET WEIGHT	kg	943			LEAKAGE TESTING PRESSURE bar: / /
WEIGHT FULL OF WATER	kg	4093		IMPACT TEST YES/NO	EXEMPT ACCORDING TO UHA-51
OPERATION WEIGHT	kg	/		HEAT TREATMENT YES/NO	EXEMPT ACCORDING TO UHA-32

TECHNIQUE REQUIRED;

1. THE EQUIPMENT MANUFACTURING HAS BEEN COMPLETED, THE INNER SURFACE HAS NO WELDING GAP AND THE OUTER SURFACE HAS NO SCRATCHES.
2.BOLT HOLES IN FLANGES SHALL BE STRADLE THE PRINCIPAL CENTER LINES OF VESSLE.
3.UNLESS OTHERWISE SPECIFIED,DIMENTIONS SHOULD BE IN MILIMETER.AND THE FABRICATON TOLERANCE SHALL BE AS GRADE C OF GB/T 19804-2005.
4.AFTER FULL WATER TEST,THE WATER SHOULD BE CLEANED.IF CAN NOT MEET THE REQUIREMENTS, THE CHLORIDEION OF WATER SHOULD BE NO MORE THAN 25MG/L
5.WHEN ONLY ONE SIDE OF FILLET WELD LEG IS SPECIFIED.THE OTHER SIDE SHALL BE CONSIDERED EQUAL.HOWEVER,WHEN THE FILLET WELD IS BUILT UP ON GROOVE WELD. THE LEG SIZE OF THIS SIDE MAY BE EQUAL TO GROOVE OPENING WHEN THE GROOVE OPENING IS NOT LESS THAN THE LEG SIZE.
6.THE INNER SURFACE OF EQUIPMENT INCLUDING ATTACHMENTS ARE POLISHED TO RA≤0.6㎛ EXCEPT 2B PLATE.
THE OUTER SURFACE OF EQUIPMENT ARE POLISHED TO RA≤0.8㎛ EXCEPT DRAWING PLATE..
7.ALL RIGHT ANGLES OF INTERIOR EQUIPMENT SHOULD BE ROUNDED REQUIRED.
8.HOUSING WELD INSPECTION AFTER PASSING THE PACKAGE HOUSING;
9.STAINLESS STEEL OUTER SURFACE FOR THE INSULATION LAYER BEFORE COATED WITH EPOXY 522 PAINT TO.(KUNSHAN SECRETARY SIGMAKALON PRODUCTION)
PAINT TO.7420 SIGMACOVER 522),A TOTAL OF PAINTED TWO-STORY,EACH LAYER THICKNESS OF 80MM
10.THE ORIENTATION OF THE NOZZLES IS ACCORDING TO TOP VIEW .
11. INSIDE OF JACKET HAS TAKEN TO PREVENT SHORT-CIRCUITING .
12.ALL WELDS IN PRESSURT RETAINING PARTS SHALL BE FULL PENETRATION WELDS .

NOZZLE SCHEDULE

MARK	NPS(DN)	CONNECTIONS SIZES STANDARDS	TYPE & FACE	SERVICE	REMARK
N1	1.5"	3A ø38.1x1.65	CLAMP	OUTLET	/
N2	1.5"	3A ø38.1x1.65	CLAMP	OUTLET	/
N3	1.5"/3"	3A ø38.1x1.65	CLAMP	CIP	/
N6	1"	3A ø25.4x1.65	CLAMP	JACKET INLET	/
N7	1"	3A ø25.4x1.65	CLAMP	JACKET OUTLET	/
N8	1"	3A ø25.4x1.65	CLAMP	JACKET INLET	/
N9	2"	3A ø50.8x1.65	CLAMP	VACUUM/PRESSURE COMBINED VALVE	/
N10	165	/	FLANGE	SIGHT GLASS	/
TT	G3/4"	/	SCREW	TEMPERATURE TRANSMITTER	/
V	25	/	WELDING	SAMPLING VALVE	/
M	I.D400	/	/	MAN HOLE	/

NO.	DRAWING NO. OR STANDARD	TITLE	MATERIAL	QUANT.	UNIT MASS.(kg)	TOTAL MASS.(kg)	REMARK
41		PLATE 3t	304-2B	4	0.2	0.8	
40		PLATE 4t	SA-240M 304	4	1	4	
39		ROTARY SPARY HEAD Φ45(1")	304	1	0.5	0.5	
38	3A	PIPE Φ25.4x1.65 L=48	SA-312M TP304	1	0.1	0.1	
37	3A	CONCENTRIC REDUCER 1.5"/1" L=60.3	SA-403M WP304	2	0.2	0.4	
36	3A	PIPE Φ38.1x1.65 L=94	SA-312M TP304	1	0.1	0.1	
35	3A	45°ELBOW Φ38.1x1.65 R57	SA-403M WP304	2	0.2	0.4	
34	3A	PIPE Φ38.1x1.65 L=88	SA-312M TP304	1	0.1	0.1	
33	3A	CLAMP FERRULE 3"(Φ81.9) L=46	SA-182M F304/EPDM	1	0.42	0.4	
32	3A	CLAMP FERRULE (ø38.1) L=12.7	SA-182M F304	1	0.1	0.1	
31	3A	CLAMP FERRULE 2"(Φ55.7) L=44.5	SA-182M F304/EPDM	1	0.42	0.4	
30	(LYSF)DQW-03	CLAMP ASEPTIC SAMPLE VALVE DN25	ASSEMBLY	1	0.5	0.5	
29	DIN11851	CLAMP FERRULE Φ29	SA-182M F304/EPDM	1	0.42	0.4	
28		BOWL 3t	304-2B	1	0.5	0.5	
27	3A	PIPE Φ63.5x1.65 L=190	SA-312M TP304	1	0.2	0.2	
26	3A	CLAMP FERRULE 2.5"	SA-182M F304	1	0.6	0.6	
25		PLATE 80x230x5t	SA-240M 304	2	0.5	1	
24		LUG 12t	304	2	1	2	
23	0900579250	TT G3/4"	SA-182M F316L	1	0.5	0.5	
22		BOWL 3t	304-2B	1	0.5	0.5	
21	XTQB02-03	PLUG	304	1	0.5	0.5	
20		ROTARY VALVE DN40-180°	304/EPDM	1	3	3	
19	XT17010R-05	NAMEPLATE ASSEMBLY	304-2B	1	0.5	0.5	
18		VACUUM/PRESSURE COMBINED VALVE 2"	ASSEMBLY	1			
17		ROUND MANWAY WITH SIGHT GLASS ID.400x4 H=125	SA-240M 304/EPDM	1	20	20	
16	XT17010R-04	DISHED HEAD ID.1400x5(35) R1400 r140 h40	SA-240M 304	1	152	152	
15		INSULATION PLATE I.D.1608/I.D.1400x3 α=70°	304	1	10	10	
14		ROUND STEEL Φ20 L=800	304	1	2	2	
13		PLATE Φ60x2t	304-2B	2	0.1	0.2	
12	XT17010R-03	SHELL&JACKET	SA-240M 304	1	234	234	
11		INSULATION 100t	PU	1	80	80	1.02m³
10		INSULTATION SHELL I.D.1608/I.D.246x21 H=1500	304	1	120	120	
9	XT17010R-02	CONE HEAD ID1400/ID1077	SA-240M 304	1	41	41	
8	XT17010R-01	CONE&JACKET	SA-240M 304	1	93.4	93.4	
7		INSTULATION CONE I.D.1608/I.D.246x21 α=35° H=25	304	1	55	55	
6		PLATE Φ246/Φ39x3t	304-2B	1	1	1	
5	3A	PIPE ø38.1x1.65 L=57	SA-312M TP304	1	0.1	0.1	
4	3A	CLAMP FERRULE 1.5"(ø38.1) L=12.7	SA-182M F304	1	0.1	0.1	
3		PIPE Φ114x4 L=1538	304	4	16.9	67.6	
2		PIPE Φ38x3 L=883	304	4	2.3	9.2	
1	XTQB01-02	ADJUST FEET D=Φ114	304	4	10	40	

Cedarstone Industry, LLC
7432 Fairbanks North Houston Road
Houston, Texas 77040

DRAW		USA-CDS-FMT-1	VER. No.	1
DESN			ITEM. No.	
CHKD		FERMENTATION TANK ASSEMBLY DWG		
APPD				
SER.No.	XT17-035~044			
DWG.No.	XT17010R-00	SCALE 1:10	DRAW	

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