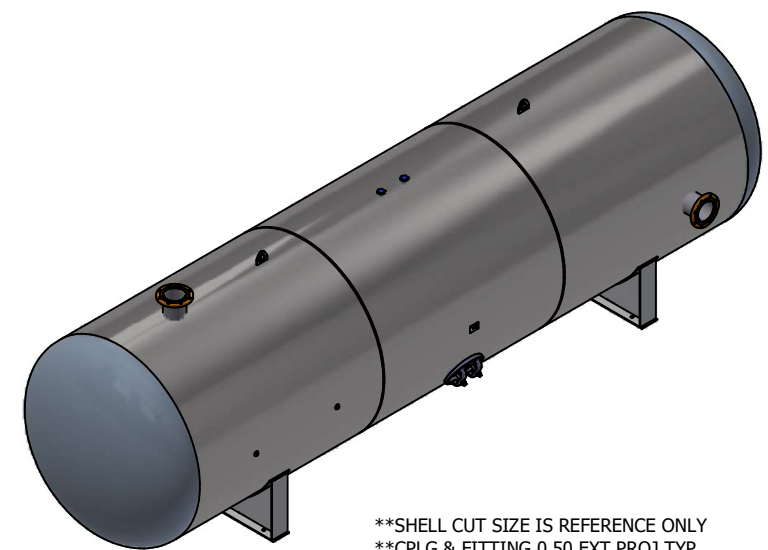


FRONT VIEW

ITEM	P/N	LEGACY_PART_ID	DESCRIPTION	QTY
1	115603	H84375P	HEAD 84.00 OD 0.313M/0.375N SA516-70 SE 2:1 PLAIN 2.000 SF BEVELED	2
2	237318	N/A	SHELL 0.375 X 95.25 X 84.00 OD SA516 GR 70	1
3	237319	N/A	SHELL 0.375 X 93.75 X 84.00 OD SA516 GR 70	1
4	237320	N/A	SHELL 0.375 X 95.25 X 84.00 OD SA516 GR 70	1
5	115849	S100343-S (0)	MANWAY 12.000 X 16.000 X 1.000 X 4.00 SA106 GR C 300#	1
6	139582	S103935	RFSO ASY, 8" 150# S80 (.500 WALL) 10.25 LG SA105N ANSI B16.5/SA106-B	2
7	114426	F602000	CPLG 2.000 NPT SA105 3000# B16.11 FULL	1
8	107211	F602000H	CPLG 2.000 NPT SA105 3000# B16.11 HALF	1
9	110552	F4020PL	PLUG 2.000 NPT CAST IRON PLAIN B16.4 250# HEX HD COMPLETE O-RING	2
10	113249	F102000	WELD FLG 2.000 NPT SA181 CL 70 FLAT 398	1
11	113238	F101000	WELD FLG 1.000 NPT SA181 CL 70 FLAT 255	2
12	129279	15-768	SADDLE ASY FOR 84" TANK 0.375 A36 SILVAN	2
13	139042	LL2889	LUG 0.625 X 5.125 X 4.625 A36 LIFT FOR 66OD- 84OD (18000# MAX)	2
14	115907	S100001	NAMEPLATE 0.060 A1011 GR B 4.50 X 3.00	1



**SHELL CUT SIZE IS REFERENCE ONLY
 **CPLG & FITTING 0.50 EXT PROJ TYP
 **HEAD THICKNESS SHOWN IS SPECIFIED MINIMUM
 **RADIUS INSIDE PROJECTED EDGES OF NOZZLES 1/8" MIN
 **SEE PAGE 2 FOR FINISH
 **FLANGE BOLT HOLES STRADDLE TANK C/L EXCEPT AS NOTED
 **ALL DIMS IN INCHES UNLESS NOTED OTHERWISE
 **IMPACT TEST EXEMPT PER UG 20(f)

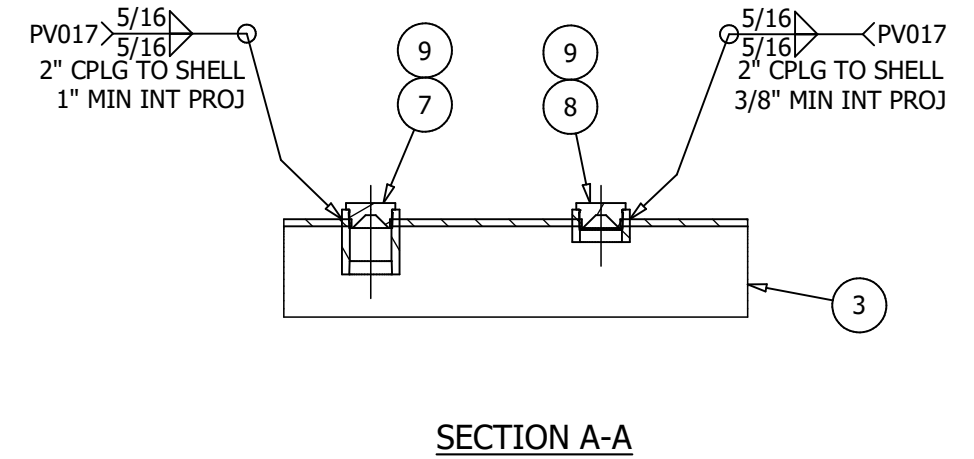
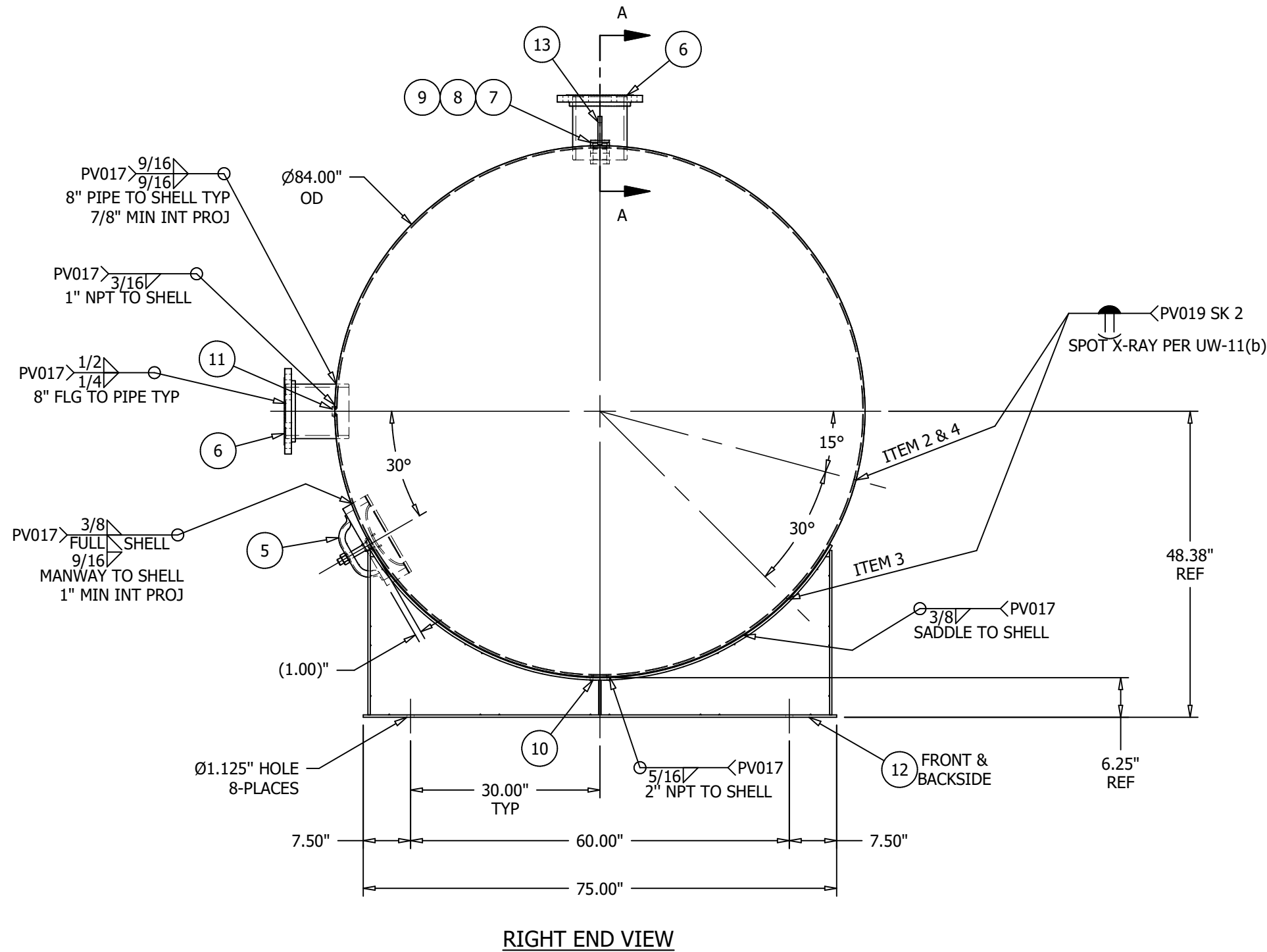
84" X 327.88" 150# VERTICAL AIR RECEIVER
 NOTES

TRAVELER REQUIRED Yes FIXTURE REQUIRED No IF YES THEN FIXTURE # _____

RELEASED TO PRODUCTION		TOLERANCES ARE PER EN1370 SPVG STANDARD TOLERANCES UNLESS OTHERWISE SPECIFIED		DESIGN & CALCULATIONS COMPLY WITH ASME CODE SECTION VIII, DIV1. LATEST EDITION	
SALES ORDER#		QTY:		CATALOG	
RELEASE DATE:		NB/SERIAL#		ENG. APP'L / DATE KG - 9/16/2011	
HEAD THK: <u>.313</u> " MIN C.A.: - MAT'L <u>SA516-70</u> EFF <u>100</u> %		SHELL THK: <u>.375</u> " NOM C.A.: - MAT'L <u>SA516-70</u> EFF <u>85</u> %		JP-9/19/2011	
NAT'L BD: YES STAMP " U "		VOLUME: 7500 APPROX GAL		A.I. VERIFICATION / DATE BQ-9/20/2011	
MAYP <u>150</u> PSI AT <u>450</u> °F		MDMT <u>-20</u> °F AT <u>150</u> PSI		SAMUEL PRESSURE VESSEL GROUP	
SHIPPING WEIGHT: 11500 LBS		TEST: HYDRO AT <u>195</u> PSI		OAKVILLE, ONT LEBANON, VA	
CRN: NONE		TEST: PNEU AT --- PSI		DRAWN BY: <u>SAB</u> P/N <u>237317</u> PAGE 1 OF 3	
		DATE: 9/2/2011		LEGACY PART NO <u>131-872SF</u> REV. 1	

REV	DATE	DESCRIPTION	ENG	AI/DATE
1	2/5/25	REDRAWN IN INVENTOR	IDV/MG	

ITEM	P/N	LEGACY_PART_ID	DESCRIPTION	QTY
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ENG APP'L	KG	SAMUEL PRESSURE VESSEL GROUP			
		OAKVILLE, ONT.		ABINGDON, VA.	
DATE:	9/16/2011	DRAWN BY: SAB	P/N 237317	PAGE 2 OF 3	REV. 1
		DATE: 9/2/2011	LEGACY PART NO 131-872SF		

FINISH SPECIFICATION

ALL TANKS REQUIRE:
 INTERIOR AND EXTERIOR TO BE FREE OF WELD
 SPATTER, DRY INTERIOR AFTER HYDROTEST, VACUUM
 INTERIOR FREE OF LOOSE PARTICLES, CLEAN & WASH
 EXTERIOR FOR FINISHING

PRE-ASSEMBLY SURFACE PREP:

POST-ASSEMBLY SURFACE PREP:

EXTERIOR FINISH:

INTERIOR FINISH:

** DO NOT PAINT SEALING SURFACES OF FLANGES **
 ** DO NOT PAINT STAINLESS STEEL NAMEPLATES **

ADDITIONAL NOTES:

OUTSIDE SERVICE VERIFICATION

WHEN PRODUCT IS SHIPPED DIRECT TO CUSTOMER FROM VENDOR,
 OUTSIDE VENDOR SHALL SIGN OFF INDICATING ACCEPTANCE OF
 ALL CRITERIA ON FINISH SPECIFICATIONS. FINISH SPECIFICATIONS
 SHALL BE SIGNED BY VENDOR & RETURNED TO STEEL FAB AFTER
 JOB IS COMPLETE.

SIGNED _____ DATE _____

SHIPPING AND PACKAGING

GENERAL NOTES

PLUG ALL UNPLUGGED OPENINGS WITH PLASTIC PLUGS AFTER PAINTING
 BUILD SKID SO THAT TANK DOES NOT EXTEND BEYOND EDGES OF SKID
 USE FOAM UNDER BANDS. SHRINK WRAP 8" PLASTIC PLUGS TO NOZZLES.

REFER TO SHOP ORDER - SHIPPING WORK GUIDELINES, FOR ADDITIONAL
 INSTRUCTIONS (IF APPLICABLE)

PACKAGING MATERIALS

REFER TO PALLET DRAWING _____

PALLET SIZE ___ X ___ COLOR CODE: _____

STACK PER PALLET DRAWING USING CARDBOARD, BANDS, FOAM, AND
 SHRINK WRAP AS APPLICABLE

ADDITIONAL SHIPPING INSTRUCTIONS

DOCUMENTATION

WELD JOINT DETAILS

DESIGN & CALCULATIONS COMPLY WITH ASME CODE SECTION VIII, DIV1. LATEST EDITION			
CATALOG	ENG. APP'L / DATE KG - 9/16/2011		
	A.I. VERIFICATION / DATE BQ-9/20/2011		
SAMUEL PRESSURE VESSEL GROUP			
OAKVILLE, ONT.		LEBANON, VA	
DRAWN BY: SAB	P/N 237317	PAGE	REV.
DATE: 9/2/2011	LEGACY PART NO 131-872SF	3 OF 3	1