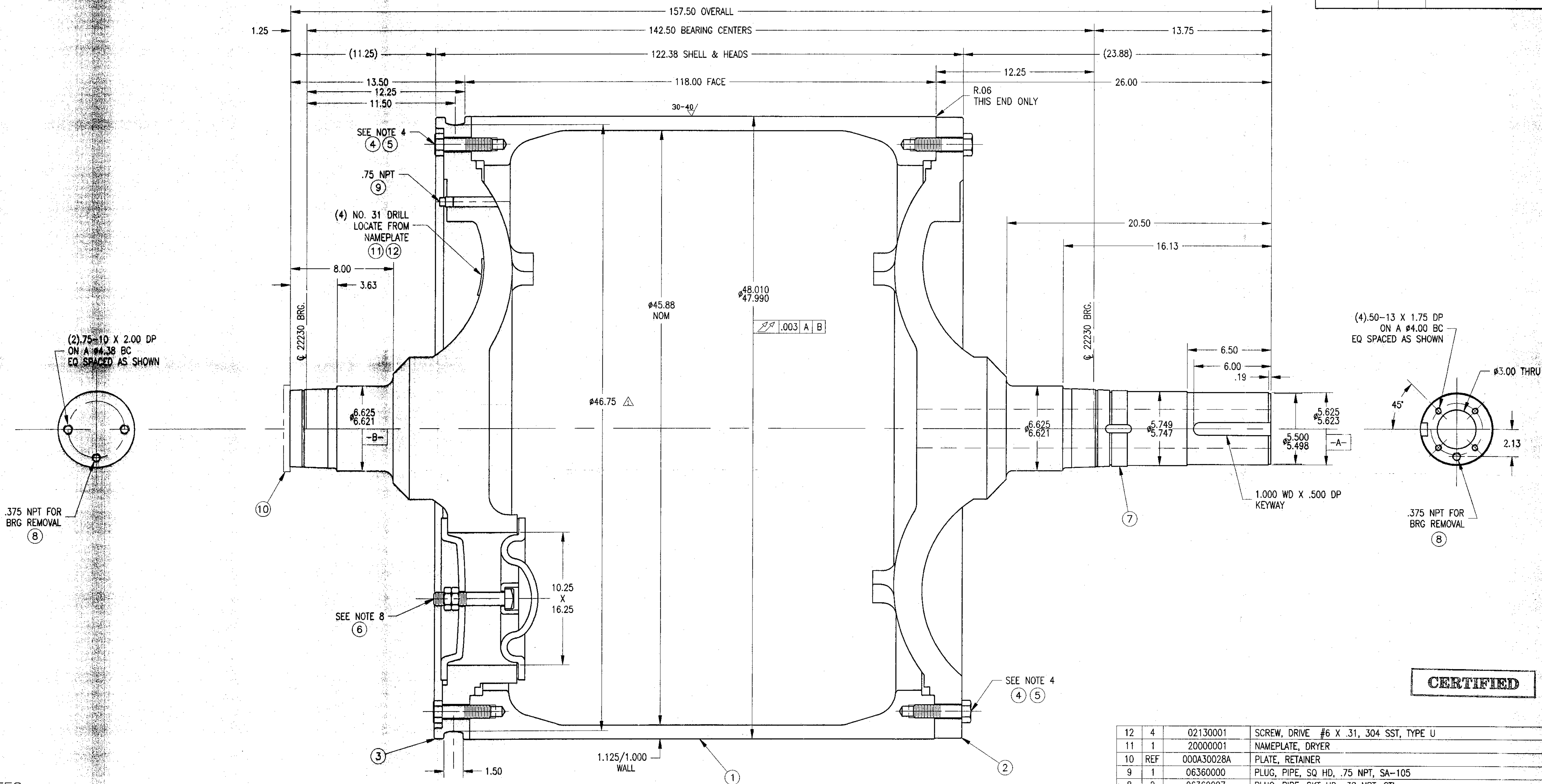


JOB #	DATE	NEXT ASSEMBLY	GROUP
C990801	5-24-99	MUNKSJO DECOR, FITCHBURG, MA	A



NOTES:

- ASSEMBLY TO BE BUILT AND TESTED IN ACCORDANCE WITH CURRENT EDITION AND ADDENDA OF THE ASME CODE SECTION VIII, DIVISION I.
- MAXIMUM OPERATING TEMPERATURE OF 450° F AT MAWP OF 150 PSI. TEST TO 300 PSIG HYDROSTATIC.
- MINIMUM DESIGN METAL TEMPERATURE OF 32° F AT 0 PSI.
- 1.00-8 BOLTS TO BE LUBRICATED WITH THRED-GARD OR SUITABLE SUBSTITUTE AND TIGHTENED WITH A TORQUE WRENCH TO 550-650 FOOT-LBS. .75-10 SET SCREWS TO BE SILICONED AND TIGHTENED TO APPROXIMATELY 5-10 FOOT-LBS.
- INSTALL HEADS TO SHELL USING PERMATAX SEALANT OR A SUITABLE SUBSTITUTE ON MATING SURFACES.
- DYNAMIC BALANCE TO 1250 FPM (100 RPM) PER ISO 1940 T/C QUALITY GRADE 6.3. MAXIMUM RESIDUAL STATIC UNBALANCE OF 4 LBS AT OD.
- COAT MACHINED DRYER FACE WITH RUST-VETO 344 (BROWN COLOR) OR A SUITABLE SUBSTITUTE.
- MANHOLE COVER BOLTS MUST BE RETIGHTENED AFTER HEAT HAS BEEN APPLIED TO DRYER.

CERTIFIED

JUN 01 1999

ITEM	QTY	DESCRIPTION
12	4	02130001 SCREW, DRIVE #6 X .31, 304 SST, TYPE U
11	1	20000001 NAMEPLATE, DRYER
10	REF	000A30028A PLATE, RETAINER
9	1	06360000 PLUG, PIPE, SQ HD, .75 NPT, SA-105
8	2	06360007 PLUG, PIPE, SKT HD, .38 NPT, STL
7	REF	17030011 LOCKNUT, BRG, AN-30
6	1	14020000 COVER, MH, ASSY, 10 X 16
5	8	02530000 SCREW, SKT SET, CUP PT, .75-10 X .75, STL
4	72	02050007 SCREW, HX HD CAP, 1.00-8 X 3.75, SA-193-B7
3	1	000D12652A HEAD, DRYER, 48 DIA, TS, A-7056 SA-278 CL 40
2	1	000D12651A HEAD, DRYER, 48 DIA, DS, A-7055, SA-278 CL 40
1	1	000D12650A SHELL, DRYER, 48.00 X 117.50, SA-278 CL 40

STANDARD TOLERANCES				DESCRIPTION			
UNLESS OTHERWISE NOTED				UNLESS OTHERWISE NOTED			
FUNCTION	MACHINING	WELDMENT	CASTING	SHEET METAL	DATE	BC	5-24-99
2 PLACE	0" - .24"	± .010	± .08	± .06	± .03	CK.	JPD
DECIMAL	OVER .24"	± .010	± .10	± .12	± .05	DATE	6-4-99
3 PLACE	0" - .24"	± .005				APP'D	JPD
DECIMAL	OVER .24"	± .005				DATE	6-4-99
ANGULAR		± .50°	± 1°	± 1°	± .5°	SCALE	1 : 4
ALL FINISHES ARE DESIGNATED BY A.S.A. STANDARDS IN MICRO-INCHES				EST. WEIGHT 8790 LBS			
REFERENCE DWG.				CODE ACCEPTANCE 48-40			
SUPERSEDES DWG.				SHT. OF 1			
REV. ECD# DESCRIPTION BY DATE APP'D				DWC. NO. 131D00773 REV. 1			