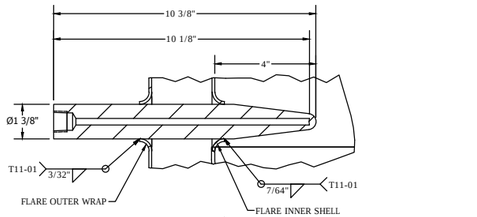
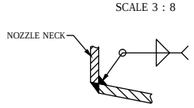
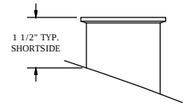


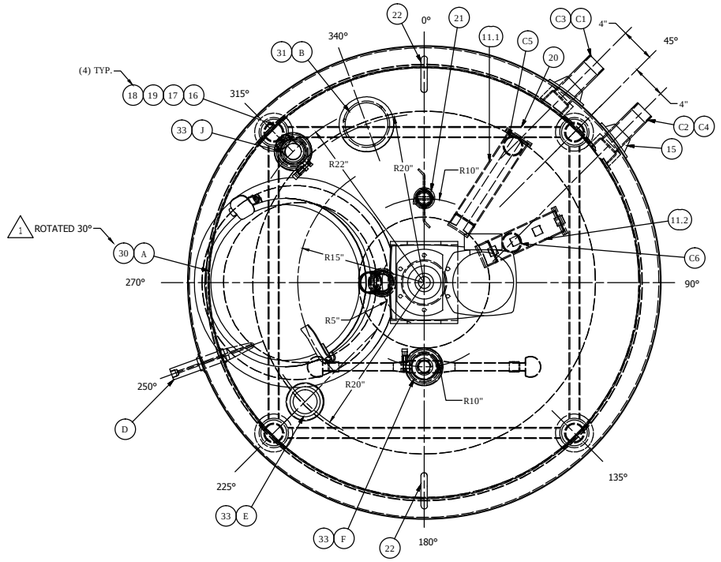
THERMOWELL DETAIL
SCALE 3 : 8 (1)



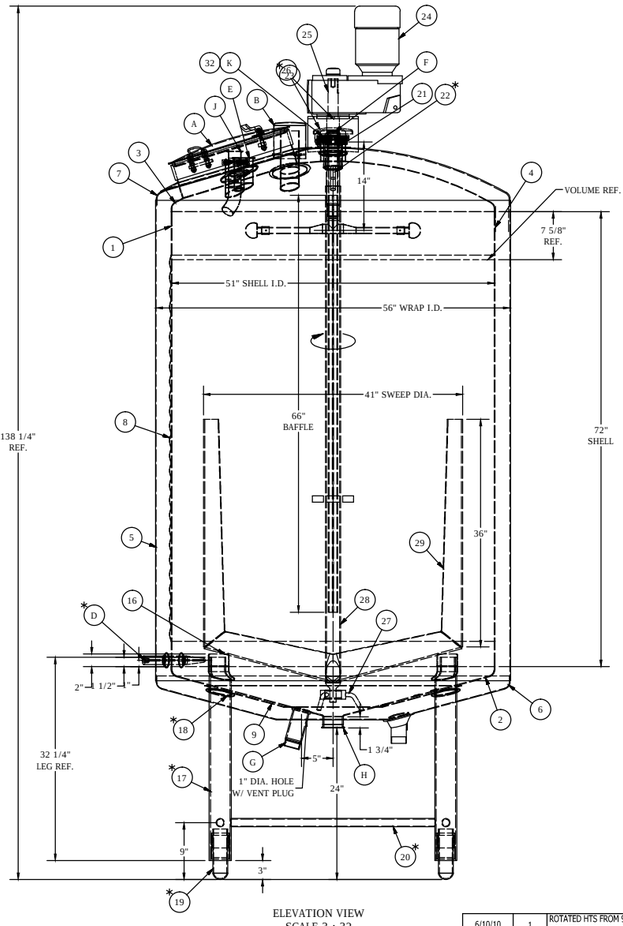
WELD DETAIL TYP.
ALL TOP HEAD FITTINGS
SCALE NONE



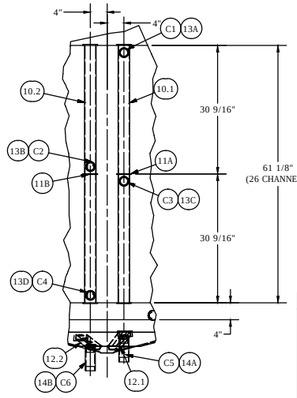
DETAIL TYP. ALL T.C. FERRULES
ON TOP HEAD
SCALE NONE



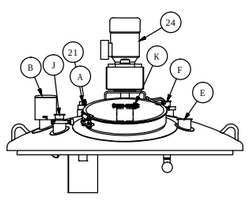
PLAN VIEW
SCALE 1 : 8 (1)



ELEVATION VIEW
SCALE 3 : 32



HTS DETAIL
SCALE 1 : 16



LEFT SIDE TOP HEAD
SCALE 1 : 16

REV. DATE	ISSUE	REVISION DESCRIPTION	APP'D BY
6/10/10	1	ROTATED HTS FROM 90°, "E" FROM 120°, "J" FROM 90°, FITTING "D" WAS #1300 THERMOWELL, ROTATED MANWAY HINGE, MOVED LAYOUT FOR WEP-83573-1 TO DRAWING WEP-83573-1B	MJG

WARRANTY

Walker Stainless Equipment Co. warrants new tanks or equipment manufactured by us to be free from defects in material and workmanship under normal use and service for a period of 1 year after shipment from the factory.

For breach of warranty of any kind, the measure of damages to be recoverable from Walker Stainless Equipment Co. shall be limited to repair or replacement of the part or equipment which examination discloses to be the satisfaction of seller to be defective, or the payment of the price or making such repair or replacement, at the option of the seller.

This warranty is expressly in lieu of all other warranties, expressed or implied, and all other obligations and liabilities on our part. Any warranty of merchantability is expressly excluded. We neither assume nor authorize any other persons to assume for us any liability in connection with the sale of our products, and no other warranty will be honored unless in writing and signed by an officer of the corporation. This warranty shall not apply to any product of our manufacture which has been repaired or altered outside our factory, or which in our opinion, has been subject to misuse, negligence or accident. Seller will not assume any charges for liability or responsibility for transportation to and from repair point, nor any loss of time due to repair. This warranty does not cover components of other manufacturers beyond such warranty as is made by such manufacturer.

Any action for breach of warranty shall be commenced within one (1) year of said breach or be forever barred.

All information including design details and dimensions contained hereon are confidential and proprietary and must not be reproduced, disclosed to others, or used in the production of parts shown, unless authorized in writing by Walker Stainless Equipment Company.

NOTES:

1. Dimensions, unless otherwise indicated are nominal and standard shop tolerances are to be expected. Measurements for any field attachments should be verified on site by others before fabrication of the attachments.

2. If used in contact with materials containing salt, chlorides or other corrosive materials, the corrosion resistance of this equipment is not the responsibility of Walker Stainless Equipment Company.

SPECIAL NOTES:

1. ALL WELDS TO BE CONTINUOUS & FULL PENETRATION UNLESS SHOWN OTHERWISE.
2. EXPOSED INSIDE EDGES OF NOZZLES OR MANHOLES SHALL BE SMOOTH & CORNERS SHALL BE CHAMFERED OR ROUNDED.
3. IT IS THE RESPONSIBILITY OF THE USER TO INSURE THAT THE VESSEL IS ADEQUATELY VENTED TO PREVENT PRESSURE AND OR VACUUM BUILDUP EXCEEDING DESIGN CONDITIONS
4. 1/4" DIA. WEEP HOLE IN ALL SECTIONS OF REINFORCING COLLARS.
5. UNLESS OTHERWISE NOTED ON DRAWING, NOTIFY ENGINEERING IF A NOZZLE 3" PIPE SIZE OR SMALLER CROSSED OR IS WITHIN 1/2" OF A WELD SEAM.

MATERIAL SCHEDULE

ITEM #	QTY.	SIZE / THICK	MATERIAL	SA #	DESCRIPTION
1	1	12 GA.	316L S.S.	240	INNER SHELL
2	1	10 GA.	316L S.S.	240	INNER BOTTOM HEAD, 15 deg CONE W/ 1.00 in K.R., & 0.50 in S.F.
3	1	12 GA.	316L S.S.	"	INNER TOP HEAD (F&D) W/ 51.00 in D.R., 1.00 in K.R., & 0.50 in S.F. - 8.02 in HEAD DEPTH
4	1	2"	TBW	"	THERMO WOOL INSULATION (SIDES, TOP & BOTTOM)
5	1	12 GA.	304 S.S.	"	OUTER WRAP
6	1	12 GA.	304 S.S.	"	OUTER BOTTOM HEAD, 15.00 deg SPUN CONE W/ 1.00 in K.R., & 1.00 in S.F. (APPROX. 18.00 in DIA. FLAT)
7	1	10 GA.	304 S.S.	"	OUTER TOP HEAD (F&D) W/ 56.00 in D.R., 1.00 in K.R., & 1.00 in S.F. - 9.14 in HEAD DEPTH
8	1	16 GA.	304 S.S.	240	HEAT EXCHANGE SURFACE (SIDE WALL CHANNEL)
9	1	14 GA.	201LN S.S.	240	HEAT EXCHANGE SURFACE (BOTTOM HEAD DIMPLE)
10	2	10 GA.	304 S.S.	240	SIDE WALL HEADERS
11	2	3/16" THK.	304 S.S.	240	HEADER BAFFLE
12	2	10 GA.	304 S.S.	240	BOTTOM HEAD HEADERS
13	4	2" 11 GA.	304 S.S.	249	INTERNAL H.T.S. WELD SLEEVE
14	2	2" 11 GA.	304 S.S.	249	INTERNAL H.T.S. WELD SLEEVE
15	6	2"	"	"	PIPETITE EXPANSION RING & BOOT FOR HTS FITTING
16	4	10 GA.	304 S.S.	"	LEG TO SHELL PADS
17	4	3" SCH. 40	304 S.S.	"	LEG
18	4	12 GA.	304 S.S.	"	LEG ESCUTCHEON
19	4	"	"	"	ADJUSTABLE BALL FOOT ASSEMBLY
20	4	1" SCH. 10	304 S.S.	"	LEG BRACING
21	1	7 GA.		"	STANDARD DUTY BAFFLE ASSEMBLY (ADJUSTABLE & REMOVABLE)
22	2	3/4" RD.	304 S.S.	"	LIFT LUG
23	1	3/8" THK.	304 S.S.	"	FORMED MOTOR MOUNT PLATE
24	1	1 1/2 H.P.	"	"	NORD SINGLE SPEED CLINCHER HELICAL GEARMOTOR, 1 1/2 H.P., 24 R.P.M., 230/460 VOLT, 3 PHASE, 60 HERTZ, TEFC, FRAME SK3282 AZ-BH 90SH/4, 1 5/8" HOLLOW BORE WITH 3/8" X 1/4" KEY, B14 FLANGE, M4 MOUNTING POSITION, S.S. PAINT
25	1	2 1/8" RD.	316L S.S.	"	MOTOR SHAFT ADAPTOR
26	1	6"	NEOPRENE	"	RUBBER DUST SHIELD - 1 7/8" I.D. HOLE
27	1	"	"	"	GUIDE BEARING ASSEMBLY (316L S.S. & HYDEX 4101 - 220° F. MAX. SERVICE TEMP)
28	1	2" SCH. 40	316L S.S.	"	CENTER SHAFT
29	1	"	304 S.S.		SIDE & BOTTOM SWEEP ASSEMBLY
30	1	12 GA.	304 S.S.	"	OUTER TOP HEAD ESCUTCHEON - MANWAY
31	1	12 GA.	304 S.S.	"	OUTER TOP HEAD ESCUTCHEON
32	1	12 GA.	304 S.S.	"	OUTER TOP HEAD ESCUTCHEON
33	3	12 GA.	304 S.S.	"	OUTER TOP HEAD ESCUTCHEON

NOZZLE SCHEDULE

ITEM #	QTY.	STUB MTL	STUB SA #	FLANGE MTL	FLANGE SA #	SIZE / THICK	RATE	DESCRIPTION
A	1	10 GA. 316L S.S.	"	316L S.S.	"	19"	"	CAMLATCH MANWAY W/ WHITE SILICONE GASKET
B	1	316L S.S.	"	--	"	3" 11 GA.	"	3" X 11 GA. TUBE STUB W/ 5" 304 S.S. TWIST PIN MOUNTED BAYONET VENT ASEEMBLY
C	6	SCH. 40 304 S.S.	312	--	"	2"	"	JACKET THREADED PIPE NIPPLE
D	1	316L S.S.	"	--	"	1/2" NPT	"	PYROMATION THERMOWELL - W81-28
E	1	16 GA. 316L S.S.	"	316L S.S.	"	3"	"	14 WLMP TRI-CLAMP FERRULE
F	1	316L S.S.	"	--	"	3"	"	14 MPHT TRI-CLAMP FERRULE W/ ECOLAB SB-18-3, 316L S.S. 2 1/2" DIA. DOUBLE SPRAYBALL W/ 1 1/2" TRI-CLAMP END (80 GPM AT 20 PSIG)
G	1	316L S.S.	"	--	"	"	"	ANDERSON LEVEL SHELL 71060A0003
H	1	316L S.S.	"	--	"	3"	"	#14 MPW TRI-CLAMP FERRULE
J	1	16 GA. 316L S.S.	"	--	"	3" X 2"	"	14 WLMP TRI-CLAMP FERRULE W/ REMOVABLE NO-FOAM INLET
K	1	304 S.S.	"	--	"	4" X 2"	"	14 WLMP TRI-CLAMP FERRULE W/ POLYPROPYLENE SPLIT SHAFT SEAL & (1) O-RING - (2) SPARE O-RINGS INSTALLED ON SHAFT ABOVE SPLIT SHAFT SEAL

T11-01 SEAL

CERTIFIED BY
WALKER STAINLESS EQUIPMENT COMPANY LLC

VESSEL	---	PSIG MAWP AT	---	°F.	
MIN. DESIGN METAL TEMP.	---	°F. AT	---	PSI	
JACKET	75	PSIG MAWP AT	320	°F.	
MIN. DESIGN METAL TEMP.	-20	°F. AT	75	PSI	
SERIAL NO.	WEP-83573-2	YEAR			
CAPACITY	600 GAL.	MAT'L	--		
MODEL	PZ-CB	DWG.	WEP-83573-1A.dwg		
TANK 25					

WALKER ENGINEERED PRODUCTS

LABEL SCHEDULE

ITEM	PART #	QTY.	DESCRIPTION	LOCATION
L1		1	ASME NAME TAG	3" BELOW MANWAY ON WRAP
L2		1	WALKER DECAL	NEAR NAME TAG
L18	GF991-18	1	AIR OUT TANK	ON MANWAY
L27	H0991-27	1	HOT SURFACES	NEAR HTS FITTINGS
L29	R9991-29	1	ROTATING PARTS	ON MANWAY
L30	CP991-30	1	MANHOLE C.L.P.	ON MANWAY

STANDARD INFORMATION

ASME: YES PER SECTION VII, DIV. 1- 2007, ADDENDUM 2009 - JACKET ONLY	
DESIGN PRESSURE & TEMP.:	VESSEL: ATMOSPHERIC PRESSURE AT 200°F. - NON CODE JACKET: RATED FOR 75 PSIG AT 320°F. / -20°F. - UM CODE STAMPED
HYDRO TEST AMBIENT:	VESSEL: N/A JACKET: 250 PISG
CORROSION ALLOWANCE: NONE	
PASSIVATION REQ'D: NO	
SHOP TOLERANCE: ±1/8" , ±2° FOR LOCATION, & ±1/2° FOR LEVELNESS	
RADIOGRAPH: NO	
N.D.E.:	LIQUID PENETRANT LEAK TEST OF ALL VESSEL WELDS IN PRODUCT CONTACT AREAS
P.W.H.T.: NO	
TANK CONTENTS: UNKNOWN	VISCOSITY: 3000 CPS
SP. GR.: 1.3	DEGREE OF AGITATION: GENTLE
APPROX. EMPTY WEIGHT: N/A	
FINISH: INTERIOR: SURFACES - #4 SANITARY FINISH (3A STANDARD - Ra RANGE 23-32) WELDS - GROUND & POLISHED - (3A STANDARD - Ra RANGE 23-32) EXTERIOR: SURFACES - #4 INDUSTRIAL FINISH (Ra RANGE 33-43) WELDS - GROUND & POLISHED - INDUSTRIAL FINISH (Ra RANGE 33-43) ✱ EXTERIOR: WELDS - STRIPE BUFFED DENOTES THE WELD FINISH FOR THE AREAS MARKED WITH AN ASTERISK	

CRATING INSTRUCTIONS: LAYDOWN SKID

REFERENCE DRAWINGS:

NO. REQ'D 1

(1) SERIAL NO WEP-83573-2 TANK #25

WEP-83573-MJG

APPROVED FOR CONSTRUCTION

BY_____ DATE _____

UM A.S.M.E.

ROUTING
FILE
FABRICATOR
QUALITY CONTROL
PARTS DEPT.
HEAD DEPT.
PLASMA & BRAKE
MACHINE SHOP
CARPENTER
GRIND ROOM

WALKER ENGINEERED PRODUCTS

WALKER STAINLESS EQUIPMENT CO. LLC

SCALE:	CHECKED BY:	DRAWN BY: RCURTIS
DATE: 4/9/2010	APPROVED BY:	REVISION: 1

TANK #25

600 GALLON PZ-CB JACKETED CONE BOTTOM PROCESSOR

JOB: FOREMOST FARMS USA
BARABOO, WI

DRAWING NUMBER: WEP-83573-1A.dwg

NOTE! DO NOT SCALE THIS DRAWING!