

KOCH PROCESS SYSTEMS

PROJECT *SSC*

K.P.S. DWG. NO. *SC1-8-047*

REVIEW BY/DATE

PROJ. ENG.

MECHANICAL *STAR 4/19/91*

STRESS

ELECTRICAL

PROCESS

MFG. ENG.

MANUF.

Q. A. *4/19/91*

DRAFTING *OK*

KOCH PROCESS SYSTEMS

PROJECT *SSC*

K.P.S. DWG. NO. *SC1-8-047*

THIS REVIEW DOES NOT RELIEVE THE SELLER OR CONTRACTOR OF ANY OBLIGATIONS UNDER THE P.O. OR CONTRACT.

FINAL APPROVAL

APPROVED AS NOTED - REVISE & RESUBMIT

APPROVED FOR FABRICATION

NOT APPROVED - REVISE & RESUBMIT

RELEASED FOR PROCUREMENT OF MATERIALS ONLY

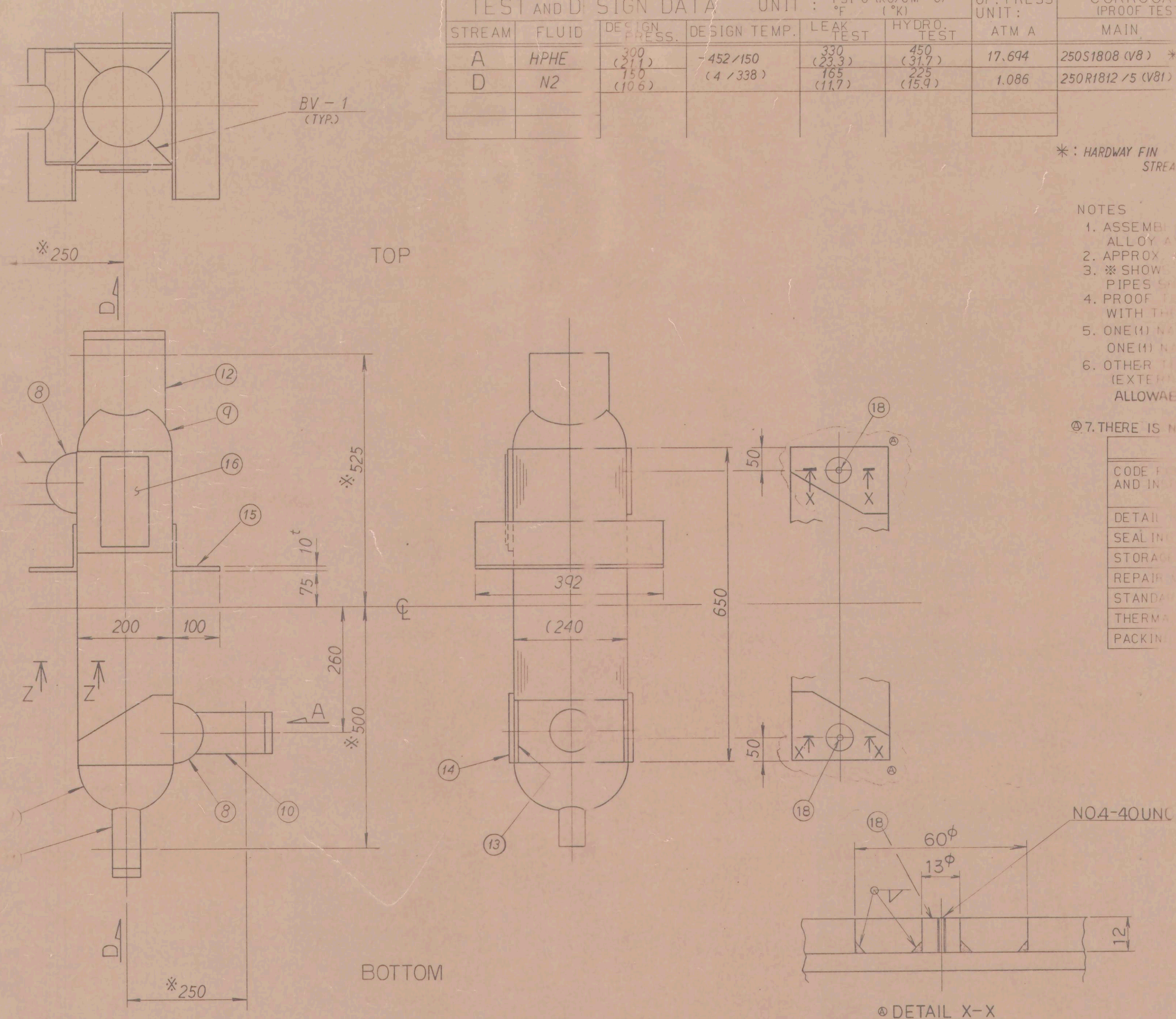
BY *[Signature]* DATE *4/19/91*

TEST AND DESIGN DATA		UNIT : PSI G (KG/CM ² G)	OP. PRESS UNIT :	CORRU GATION CODE (PROOF TEST RECORD NO.)	NO. OF LAYERS	ISSUE	DATE	APPRO.
STREAM	FLUID	DESIGN TEMP.	LEAK TEST	HYDRO. TEST	MAIN DISTRIBUTOR	(A)	7.5	M
A	HPHE	-452/150	330	450	250S1808 (V8) *		MAR.29.91	
D	N2	(4 / 338)	165	225	250R1812 / 5 (V81)		APR. 12.91	
			(10.6)	(11.7)				

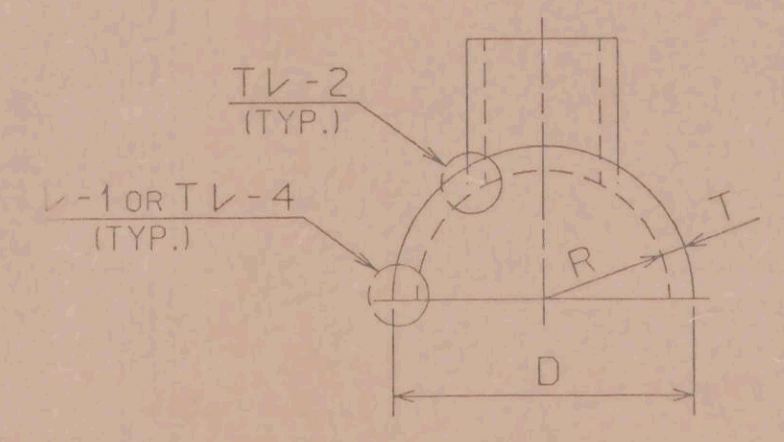
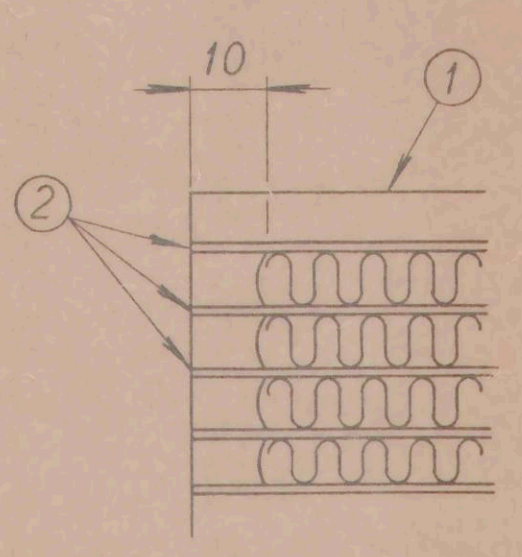
* : HARDWAY FIN
STREAM A : 250R1224/25 (V93) X LENGTH 10mm BOTH END

- NOTES
1. ASSEMBLY MATERIALS OF METAL PARTS ARE ALUMINUM AND ALUMINUM ALLOY AND WELDED BY VAC. BRAZING AND ARGON ARC WELDING.
 2. APPROX. WEIGHT : 55 KG (EMPTY)
 3. * SHOW THE LOCATION AT WHICH HEAT EXCHANGER AND CONNECTION PIPES SHALL BE CONNECTED AT SITE. (INDICATED BY SCRIBE MARKS)
 4. PROOF TEST OF CORRU GATION WAS PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF PARA.UG-101 OF ASME CODE SEC.VIII DIV.1
 5. ONE(1) NAME PLATE IS ATTACHED TO CORE. (ITEM NO. ⑮)
 6. OTHER (1) HELIUM LEAK TEST (EXTERNAL AND ALL INTERPASSAGES, LEAK TEST) ALLOWABLE LEAK RATE : EXTERNAL = 1×10^{-6} mbar - l/s
 7. THERE IS NO ITEM REQUIRED RADIOGRAPHIC INSPECTION.

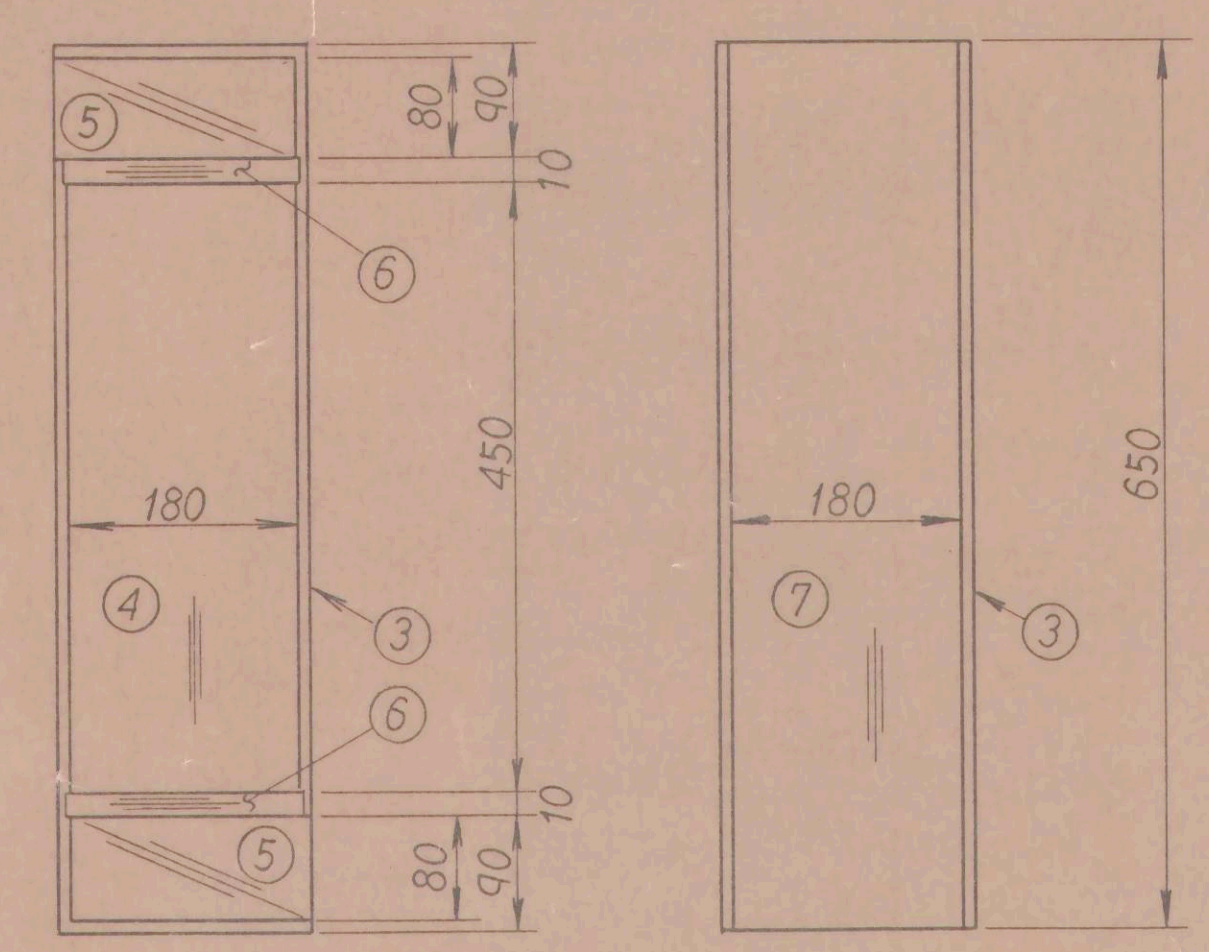
SPECIFICATIONS	
CODE FOR CONSTRUCTION AND INSPECTION	ASME SEC. VIII DIV.1 1989 EDITION AND 1989 ADDENDA
DETAIL FOR INSPECTION	SHS-E-1250
SEALING FOR SHIPPING	SHS-P-452
STORAGE AND INSTALLATION INSTRUCTION	SHS-P-140
REPAIR METHOD OF DEFECTS	SHS-L-0013
STANDARD EDGE PREPARATION	SHS-S-1004
THERMAL PERFORMANCE DATA	STD SH0665 SSR 2829
PACKING INSTRUCTION	SHS-P-1083-G



31	D
30	A
29	D
28	A
27	D
26	A
25	D
24	A
23	D
9	D
8	A
7	D
6	A
5	D
4	A
3	D
2	A
1	D



ITEM NO.	R	T	D
⑧	58	5	126
⑨	95	5	200



ITEM NO.	PART NAME	MATERIAL	DESCRIPTION
⑮	BOSS	SB-221 5083	(SEE DETAIL)
⑮	NAME PLATE	SUS304	1"
⑮	BRACKET	SB-209 3003	3"
⑮	PLATE	SB-221 6063	L=100X100X10"
⑮	END PLATE	SB-209 5083	12"
⑮	PIPE	SB-241 5083	10"
⑮	HEADER TANK	SB-209 5083	168.3"X7.1"
⑮	CORRU GATION	SB-209 3003	60.5"X3.9"
⑮	SPACER BAR	SB-209 3003	89.1"X5.5"
⑮	TUBE PLATE	SB-209 3003	95"X5"
⑮	SIDE PLATE	SB-209 3003	58"X5"
⑮	PART NAME	MATERIAL	DESCRIPTION

APPROVED: *[Signature]* DATE: *4/19/91*

CHECKED: *[Signature]* DATE: *4/19/91*

CUSTOMER: KOCH PROCESS SYSTEMS, INC.

TITLE: MTL/ASST CRYOGENIC SYSTEMS (SSCL)

JOB NO. C502066

REFRIGERATOR / LIQUEFIER HX-1000

SUMITOMO PRECISION PRODUCTS CO., LTD.

1-10, FUSO-CHO AMAGASAKI, JAPAN

UNIT: MM SCALE: 1/6

3RD ANGLE PROJ.

ASH0665-1

APR 18 1991

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