Rev A

KOCH PROCESS SYSTEMS

PROJECT SSC
K.P.S. DWG. NO. 501-8-046
REVIEW BY/DATE
- ☐ PROJ. ENG.
- ☒ MECHANICAL 4/19/91
- ☐ STRESS
- ☐ ELECTRICAL
- ☐ PROCESS
- ☐ MFG. ENG.
- ☐ MANUF.
- ☐ Q. A.
- ☒ DRAFTING 4/19/91
- ☐

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

- ☒ FINAL APPROVAL
- ☐ APP'D. AS NOTED - REVISE & RESUBMIT
- ☐ APPROVED FOR FABRICATION
- ☐ NOT APPROVED - REVISE & RESUBMIT
- ☐ RELEASED FOR PROCUREMENT OF MATERIALS ONLY

BY _____ DATE 4/19/91

TEST AND DESIGN DATA

UNIT : PSI G (KG/CM² G) (°F) (°K)

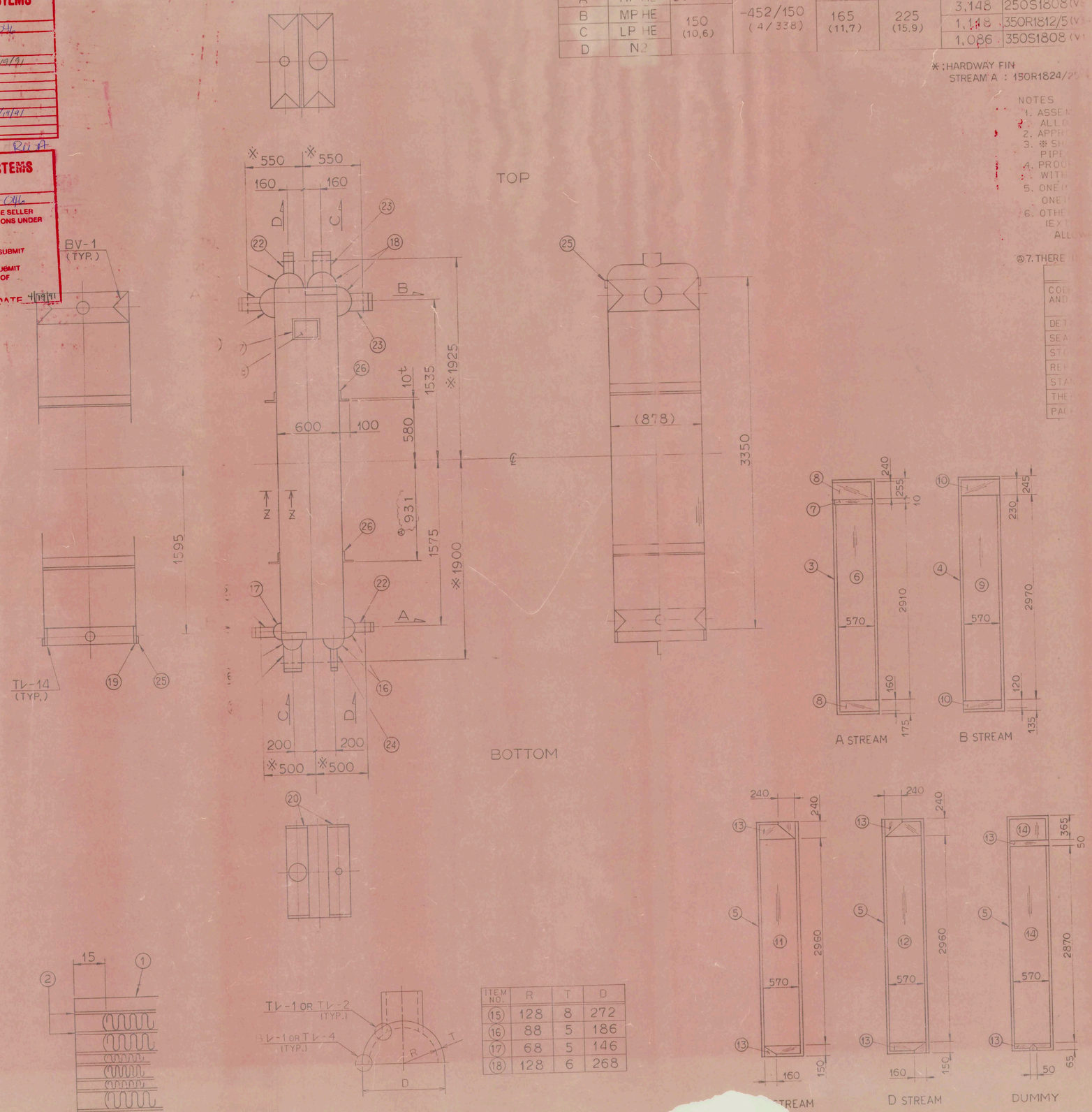
STREAM	FLUID	DESIGN PRESS.	DESIGN TEMP.	LEAK TEST	HYDRO. TEST	OP. PRESS UNIT: ATM A	CORRUGATION (PROOF TEST) MAIN	CODE (STD NO.) DISTRIBUTOR	NO. OF LAYERS
A	HP HE	300(21,1)	-452/150 (4/338)	330(23,3)	450(31,7)	17.990	*150S1808(V1)	1 R1412/5(V15)	40
B	MP HE	150 (10,6)		165 (11,7)	225 (15,9)	3.148	250S1808(V)	2 R0624/5(V7)	20
C	LP HE					1.118	350R1812/5(V)	3 R0624/5(V6)	40
D	N2					1.086	350S1808(V)		10

ISSUE	DATE	APPRD.
(A)	FEB 25 '91	APR. 4. '91

*: HARDWAY FIN
STREAM A : 150R1824/25 LENGTH 10mm WARM END

NOTES
1. ASSEM... ERIALS OF METAL PARTS ARE ALUMINUM AND ALUMINUM
2. ALL ... DED BY VAC. BRAZING AND ARGON ARC WELDING.
2. APPR... : 2000 KG (EMPTY)
3. ※ SH... CATION AT WHICH HEAT EXCHANGER AND CONNECTION PIPE... CONNECTED AT SITE.(INDICATED BY SCRIBE MARKS)
4. PROC... CORRUGATION WAS PERFORMED IN ACCORDANCE WIT... REMENTS OF PARA.UG-101 OF ASME CODE SEC.VIII DIV.1
5. ONE ... TE IS ATTACHED TO CORE. (ITEM NO. 28)
ONE ... TE SHALL BE SHIPPED LOOSE. (ITEM NO. 29)
6. OTHE... HELIUM LEAK TEST.
(EX... ALL INTERPASSAGES LEAK TEST)
ALL... AK RATE : EXTERNAL = 1x10⁻⁶ mbar-ℓ/s
INTER PASSAGE = 1x10⁻⁴ mbar-ℓ/s
7. THERE ... REQUIRED RADIOGRAPHIC INSPECTION.

CODE AND ...	...RUCTION	ASME SEC. VIII DIV.1 1989 EDITION AND 1989 ADDENDA
DET...	... INSPECTION	SHS-E-1250
SEA...	... FOR SHIPPING	SHS-P-152
STO...	...TALLATION INSTRUCTION	SHS-P-140
REP...	...F DEFECTS	SHS-L-0013
STA...	...E PREPARATION	SHS-S-1004
THE...	...MANCE DATA	STD SH0664 SSR 2828
PAC...	...ICATION	SHS-P-1083-G



ITEM NO.	R	T	D
(15)	128	8	272
(16)	88	5	186
(17)	68	5	146
(18)	128	6	268

(29)	NAME PLATE	SUS304	1t
(28)			1t
(27)	PLATE	SB-209 5083	6t
(26)	BRACKET	SB-221 6063	L=100x100x10t
(25)	PLATE	SB-209 5083	10t
(24)	PIPE	SB-241 5083	60.5Φ x 3.9t
(23)			168.3Φ x 7.1t
(22)			89.1Φ x 5.5t
(21)			114.3Φ x 6.0t
(20)	END PLATE	SB-209 5083	10t
(19)			8t
(18)	HEADER TANK		128R x 6t
(17)			68R x 5t
(16)			88R x 5t
(15)			128R x 8t
(14)	CORRUGATION	SB-209 3003	0.61t (350P0624)
(13)			0.61t (350R0624/5)
(12)			0.20t (350S1808)
(11)			0.31t (350R1812/5)
(10)			0.61t (250R0624/5)
(9)			0.20t (250S1808)
(8)			0.31t (150R1412/5)
(7)			0.61t (150R1824/25)
(6)			0.20t (150S1808)
(5)	SPACER BAR	SB-209 3003 OR SB-221 3003	8.89H x 15W
(4)			6.35H x 15W
(3)			3.81H x 15W
(2)	TUBE PLATE	SFA-5.8/SB-209 BA1S1-7/3003	1.2t
(1)	SIDE PLATE	SB-209 3003	6.5t
ITEM NO.	PART NAME	MATERIAL	DESCRIPTION

APPROVED Feb 27 '91	CUSTOMER	KOCH PROCESS SYSTEMS, INC.
	TITLE	MTL/ASST CRYOGENIC SYSTEMS ISSC JOB NO. C502066
CHECKED Feb 27 '91		REFRIGERATOR/LIQUEFIER HX-1001
		SUMITOMO PRECISION PRODUCTS CO., LTD. 1-10, FUSO-CHO AMAGASAKI, JAPAN
DRAWN Feb. 25, '91 K. YOSHIMURA	UNIT MM / SCALE 1/20 / 3RD ANGLE PROJ.	ASH0664-1 (A)

APR 18 1990

ITEM NO.	QTY	MATERIAL
56	C	57
55	A	58
54	D	59
53	B	60
52	A	61
51	C	62
50	C	63
49	A	64
48	B	65
47	A	66
46	C	67
45	C	68
44	A	69
43	D	70
42	B	71
41	A	72
40	C	73
39	C	74
38	A	75
37	B	76
36	A	77
35	C	78
34	C	79
33	A	80
32	D	81
31	B	82
30	A	83
29	C	84
28	C	85
27	A	86
26	B	87
25	A	88
24	C	89
23	C	90
22	A	91
21	D	92
20	B	93
19	A	94
18	C	95
17	C	96
16	A	97
15	B	98
14	A	99
13	C	100
12	C	101
11	A	102
10	D	103
9	B	104
8	A	105
7	C	106
6	C	107
5	A	108
4	B	109
3	A	110
2	C	111
1	DUMMY	112

STACKING ARRANGEMENT