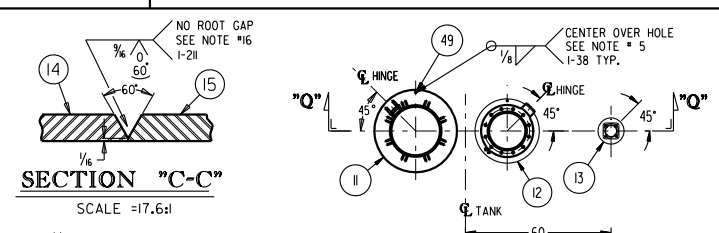
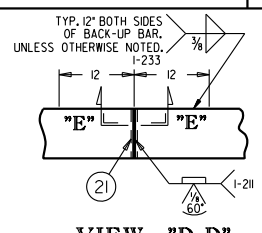


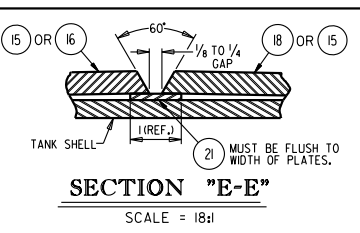
VIEW "A-A"
SCALE = 4:1



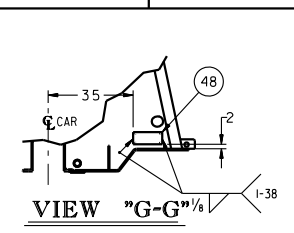
SECTION "C-C"
SCALE = 17.6:1



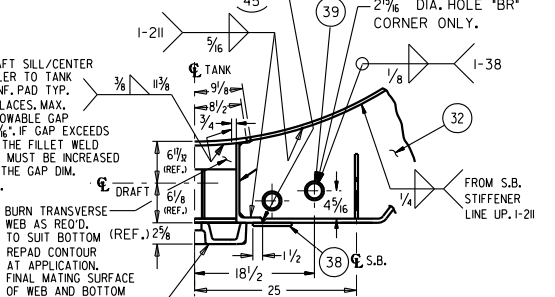
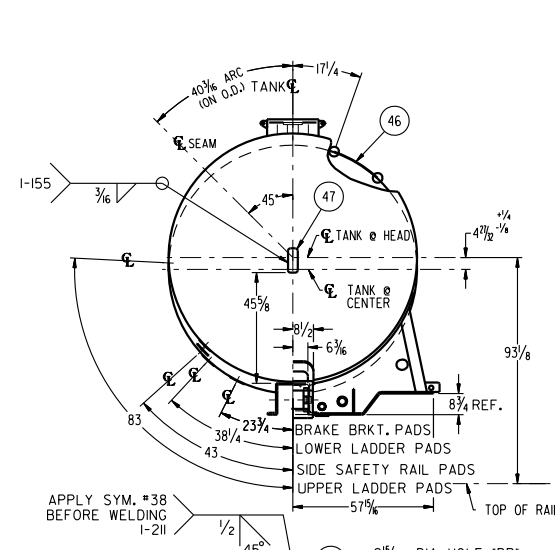
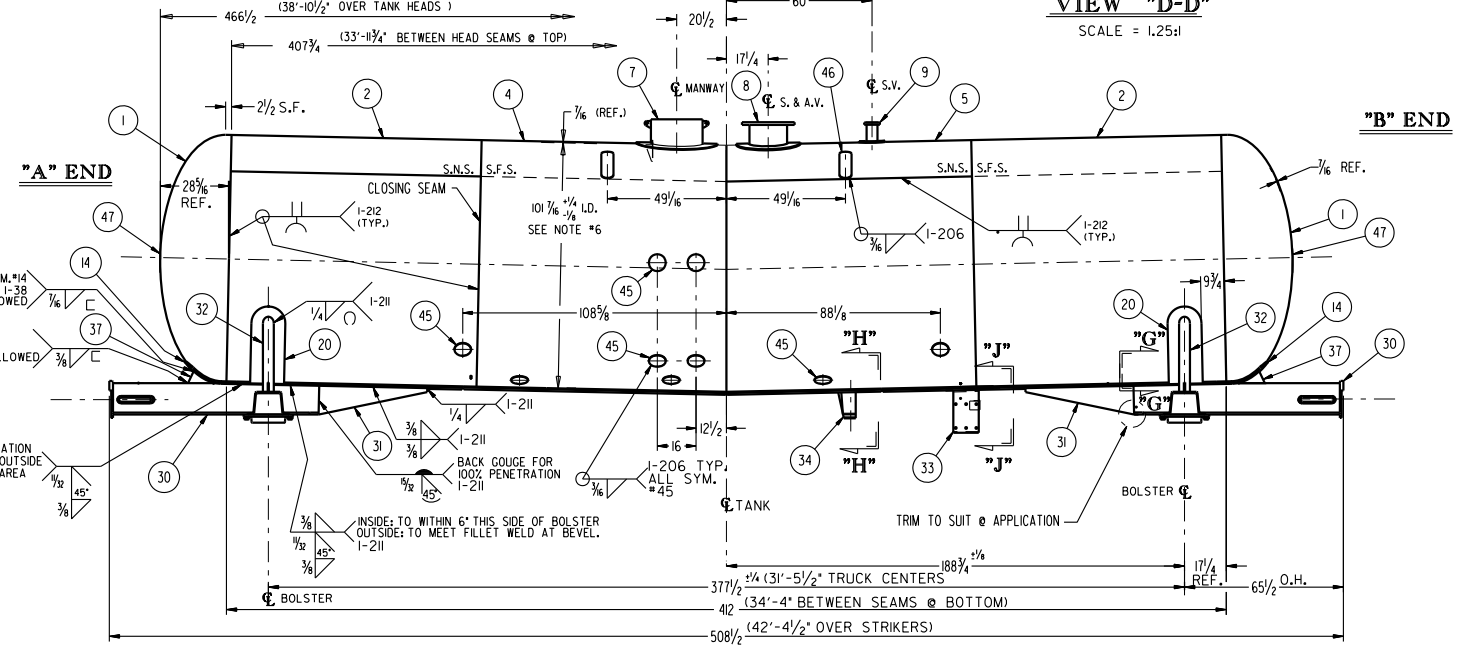
VIEW "D-D"
SCALE = 1.25:1



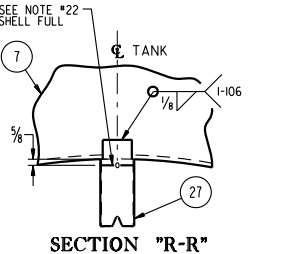
SECTION "E-E"
SCALE = 18:1



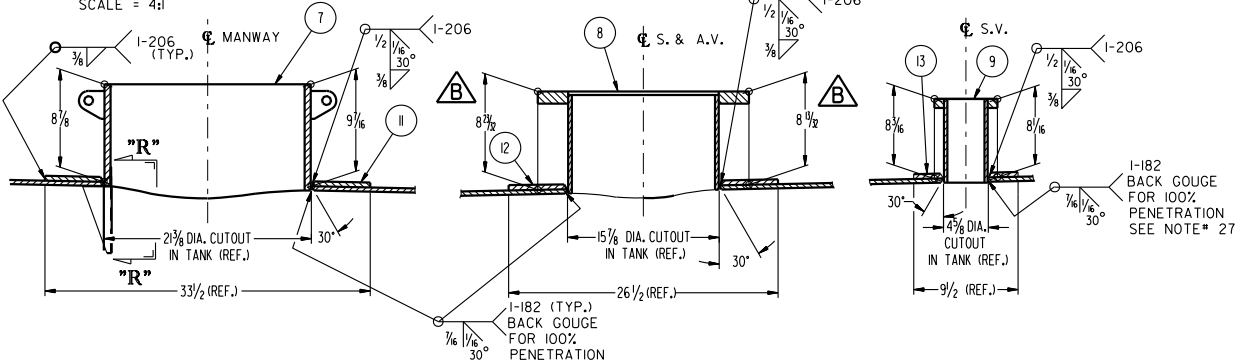
VIEW "G-G"
SCALE = 1/2:1



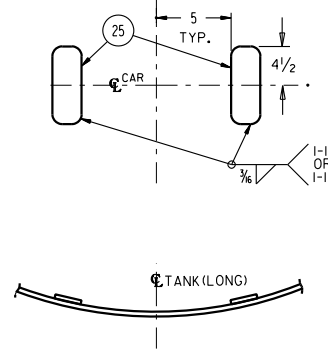
HALF SECTION AT BOLSTER
SCALE = 2.66:1



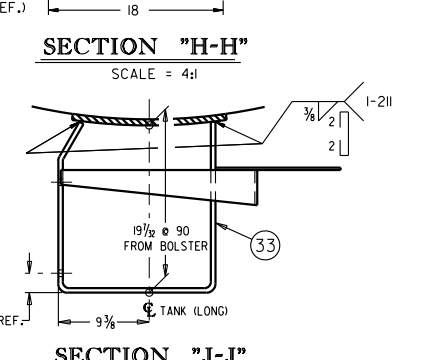
SECTION "R-R"
SCALE = 4:1



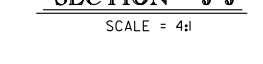
SECTION "Q-Q"
SCALE = 4:1



SECTION "K-K"
SCALE = 4:1



SECTION "H-H"
SCALE = 4:1



SECTION "J-J"
SCALE = 4:1

BILL OF MATERIAL					
SYM.	PART NO.	REQ.	DESCRIPTION	MAT'L.	WT.(LBS.)
1	104883-01	2	TANK HEAD, 21 ELLIPTICAL, 2 1/2" S.F., 1/4" MIN.	316L	3180
2	103108-04	2	SHELL PLATE	316L	8538
3					
4	105247-01	1	SHELL PLATE	316L	4178
5	105248-01	1	SHELL PLATE	316L	4197
6					
7	97969-01	1	NOZZLE S/A, MANWAY 20"	SEE S/A	134.3
8	97971-01	1	NOZZLE S/A, SIPHON & AIR VENT, 18 1/2" B.C.	SEE S/A	106.38
9	95281-02	1	NOZZLE S/A, SAFETY VALVE, 6 1/4" B.C.	SEE S/A	18.3
10					
11	23256-29	1	REINF. PLATE, MANWAY	A56-70	72.83
12	23256-30	1	REINF. PLATE, SIPHON & AIR VENT	A56-70	49.65
13	23256-24	1	REINF. PLATE, SAFETY VALVE NOZZLE	A56-70	6.9
14	104873-02	2	REINF. PLATE @ TANK HEAD	GA02-SOW	122
15	104149-03	2	REINF. PLATE @ DRAFT SILL	GA02-SOW	544
16	100323-19	1	REINF. PLATE @ INTERMEDIATE 'A' END	GA02-SOW	252.7
17					
18	100323-20	1	REINF. PLATE @ INTERMEDIATE 'B' END	GA02-SOW	239.1
19					
20	102299-05	4	BOLSTER SADDLE	A36	448
21	20718-83	3	RECTANGULAR SHAPE, BACK-UP BAR	A569	1.5
22					
23					
24					
25	25238-07	2	RECTANGULAR SHAPE, W/RADIUSED CORNERS	316L	5.04
26					
27	105250-01	1	GAUGE BAR, VISUAL	316L	1.64
28					
29					
30	96966-02	2	DRAFT SILL S/A	SEE S/A	1864
31	21688-09	4	DRAFT SILL EXTENSIONS	GA02-SOW	188
32	87365-01	4	BOLSTER S/A	SEE S/A	182
33	96291-06	1	BRAKE CYLINDER SUPPORT S/A	A36	85.97
34	93489-10	1	BRAKE LEVER SUPPORT S/A	A36	36.64
35	26404-05	1	RECTANGULAR SHAPE, W/RADIUSED CORNERS	A56-70	6.1
36	103594-01	2	ANGLE COCK SUPPORT	A36	3.46
37	102870-01	2	REINF. PLATE, BULL HORN	A283-B	29
38	26063-01	4	TRAPEZOIDAL SHAPE	A56-70	56
39	18635-42	1	PIPE, 2 1/2" O.D. x 0' - 3 1/2" L.G. SCH. 80	A53-F	2.2
40					
41					
42					
43					
44					
45	08812-30	15	ROUND SHAPE, ROLLED	A36	40.5
46	10823-40	4	RECT. SHAPE W/RADIUSED CORNERS ROLLED	A36	28.77
47	10823-36	2	RECT. SHAPE W/RADIUSED CORNERS ROLLED	A36	5.6
48	10986-01	1	BRACKET, BADGE PLATE	A569	2.3
49	213-1499	2	HALF COUPLING, 1/2" 3000"	A105	.26
50					

- NOTES:
- TANK TO BE BUILT IN ACCORDANCE WITH AND MEET ALL REQUIREMENTS OF SPECIFICATION DOT 11A100W6 AND ALL WELDING AND RADIOGRAPHY TO BE IN ACCORDANCE WITH A.A.R. APPENDIX "W" UNLESS OTHERWISE NOTED BELOW.
 - NO POST WELD HEAT TREATMENT REQUIRED ON TANK, DRAFT SILLS TO BE POST WELD HEAT TREATED BEFORE APPLICATION TO TANK, AS CALLED FOR ON DRAWING FOR SYM.#30.
 - TO BE STAMPED IN THE CENTER OF BOTH ENDS WITH 3/8" (MIN.) HIGH LETTERS: TANK SPECIFICATION DOT 11A100W6 MATERIAL ASTM A240-316L TANK BUILDERS INITIALS DATE OF ORIGINAL TEST (MO. & YR.) WATER CAPACITY 0000 US GALS.
 - REINFORCEMENT CALCULATIONS PER DRAWING #S: 105257 FOR MANWAY NOZZLE, 105258 FOR LOAD/UNLOAD NOZZLE & 105259 FOR SAFETY VALVE NOZZLE.
 - PRESSURE TEST ALL NOZZLE REINFORCEMENT PLATES WITH APPROXIMATELY 15 TO 20 PSIA AIR PRESSURE AND SOAP SUDS OR OTHER SUITABLE LIQUIDS TO DETECT LEAKS.
 - TANK ROUNDNESS TOLERANCE IS ± 1% OF TANK I.D.
 - CENTER PLATE MOUNTING SURFACES TO BE PARALLEL WITHIN .1".
 - NOZZLE LEVELNESS TOLERANCE IS ± .1".
 - TRIMMING OF DRAFT SILL TO BE IN COMPLIANCE WITH GEN. E.C.O. 89-84.
 - ALL LOCATING DIMENSIONS FOR PADS, BRACKETS ETC., ARE TO BE MEASURED ALONG A LINE PARALLEL TO THE LONGITUDINAL CENTERLINE OF THE TANK UNLESS NOTED OTHERWISE. LOCATING DIMENSIONS FOR NOZZLES ARE TO BE MEASURED ALONG A LINE PARALLEL TO THE TOP OF RAIL.
 - BOLSTER SADDLE (SYM.#20) TO BE PARALLEL TO HEAD SEAM.
 - HOLD SYM.# 34 PARALLEL TO RAIL AS SHOWN.
 - REMOVE TANK SEAM REINFORCEMENT FOR APPLICATION OF SYM.#S 14 & 16.
 - GIRTH SEAM WELDS (TANK & HEADS) TO BE GROUND FLUSH WITH THE SHELL PLATE ON INSIDE OF TANK, 6" WIDE ON BOTTOM CENTERLINE OF TANK.
 - FILLET WELDS FOR BOTTOM REINFORCEMENT PLATES TO USE THE BACK-STEP TECHNIQUE TO FILL CRATERS.
 - GROOVE WELDS FOR ROOT PASS AND 3/8" DIA. (MAX.) FOR FILL PASSES (STRINGERS).
 - 1/4" FILLET WELD TO BEGIN AT TRANSITION TO 3/8" PLATE.
 - PREPARE TANK INTERIOR AND INTERNALS PER ES 41-19A, S53.
 - TANK TO BE DEGREASED, PICKLED, PASSIVATED AND FERROXYL TESTED PER PES-K-3, PES-K-4, PES-K-5 & PES-K-6.
 - WATER GAUGE TO THIS LEVEL WHICH CORRESPONDS TO SHELL FULL AT CENTERLINE OF FUNNEL FLOW TANK.
 - TANK TO BE ACOUSTIC EMISSION TESTED FOR ONE IN FIVE.
 - WELD TO BE X-RAYED PER ES 41-9, SEC. IV, PARA. 'C' OR ULTRASONICALLY INSPECTED PER ES 41-62 SEC. 'C'.

PROCOR PROCOR LIMITED
200 STEPHENSON AVE.
LANSING, MICHIGAN 48206

TANK ASSEMBLY
DOT 11A100W6 15,500 GAL.
102 3/8" O.D., 1/4" FT. F.F.

B	06.12.95	RD	SECT. 0-0" NOZZLE DIMS 8 1/2" AND 8 1/2" WERE 8 1/2" AND 9 3/16."	BMC	DRAWN BY: B.MEGHEE	DATE: 04-04-95
A	05.04.95	MG	SYM.#13 PART NO. WAS 23256-22	BMC	CHECKED BY: P.YOUNG	DATE: 04-21-95
REV	DATE	BY	DESCRIPTION	CHK	APPROVED: G.STEPHANIAN	DATE: 04-21-95

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40250 APPRO. 97994 B

SCALE: 3/4"=1'-0" WEIGHT: 25555#

FIRST USED WITH 97993 REPRO. OF 96094 SEQUENCE NO. 9310