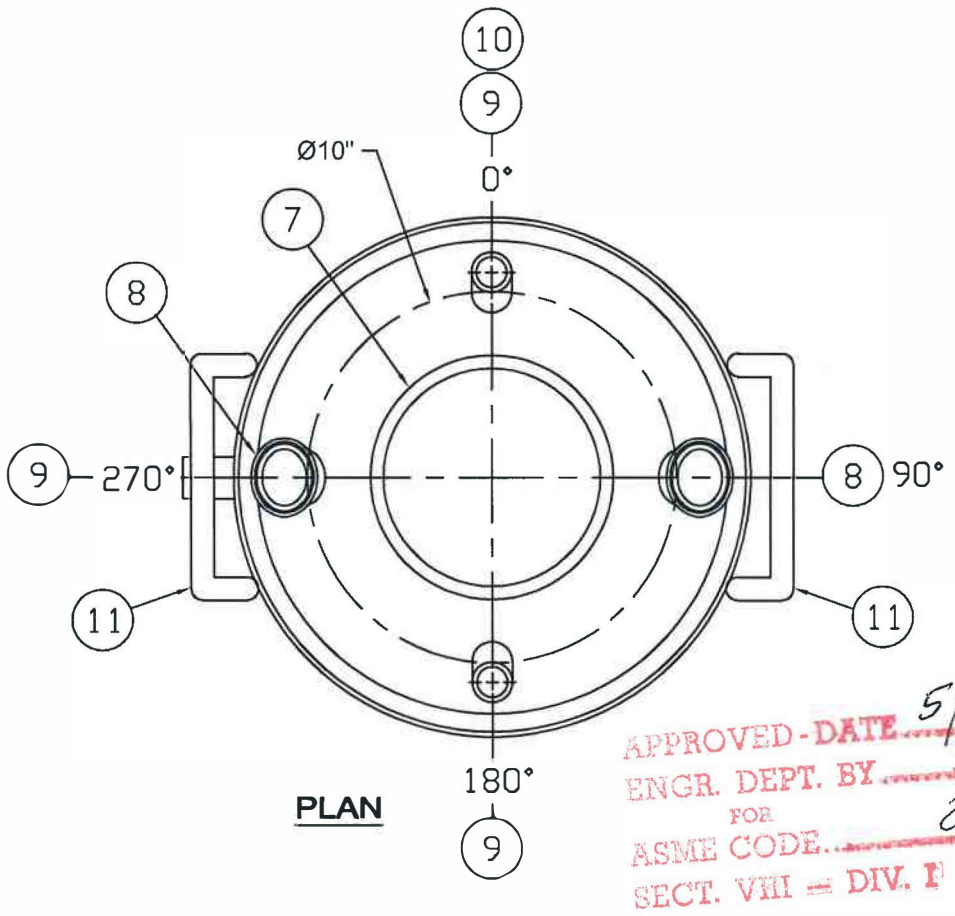
ITEM	QTY.	BILL OF MATERIALS	MATERIAL	PART NO.
1	1	12"–SCH10 (.180" WALL) PIPE 30" LONG	SA-312-TP-304	
2	2	12"–SCH10 (.180" WALL) PIPE CAP	SA-403-WP-304	
3	1	14"–SCH10 (.180" WALL) PIPE CAP	SA-403-WP-304	
4	1	14"–SCH10 (.180" WALL) PIPE 33 3/8" LONG	SA-312-TP-304	
5	1	1/4" PLATE 13 3/4" O.D. X 12.80" I.D.	SA-240-T-304	
7A	2	6" ASME CODE FERRULE x 3 1/2" LONG	SA-182-F-304	
7B	2	6" ASME CODE FERRULE x 3 3/4" LONG	SA-182-F-304	
8	2	1 1/2" ASME CODE FERRULE	SA-182-F-304	
9	4	1/2"–3000# FULL COUPLING	SA-182-F-304	
10	1	ASME CODE BRACKET AND NAMEPLATE	S.S.	
11	2	5/8" HANDLE	S.S.	
12	2	1 1/4"–SCH40 PIPE X 2–1/16" LNG.	SA-312-TP-304	



PLAN

APPROVED - DATE 5/10/19
ENGR. DEPT. BY MH
FOR ASME CODE 2017
SECT. VIII – DIV. 1

DESIGN AND MANUFACTURING REQUIREMENTS

1.0 INNER VESSEL IS DESIGNED, FABRICATED IN ACCORDANCE WITH THE LAST EDITION OF THE ASME BOILER AND PRESSURE VESSEL CODE SECTION VIII DIVISION 1 FOR INTERNAL PRESSURE OF INNER VESSEL 350 PSIG AT 120 °F MAX. AND –20°F MIN. TEMPERATURE (NO PRESSURE IN THE NON STAMPED JACKET).

2.0 TEST:

2.1 VESSEL: 455 PSIG HYDRO.

2.2 JACKET: VACUUM LEAK TEST.

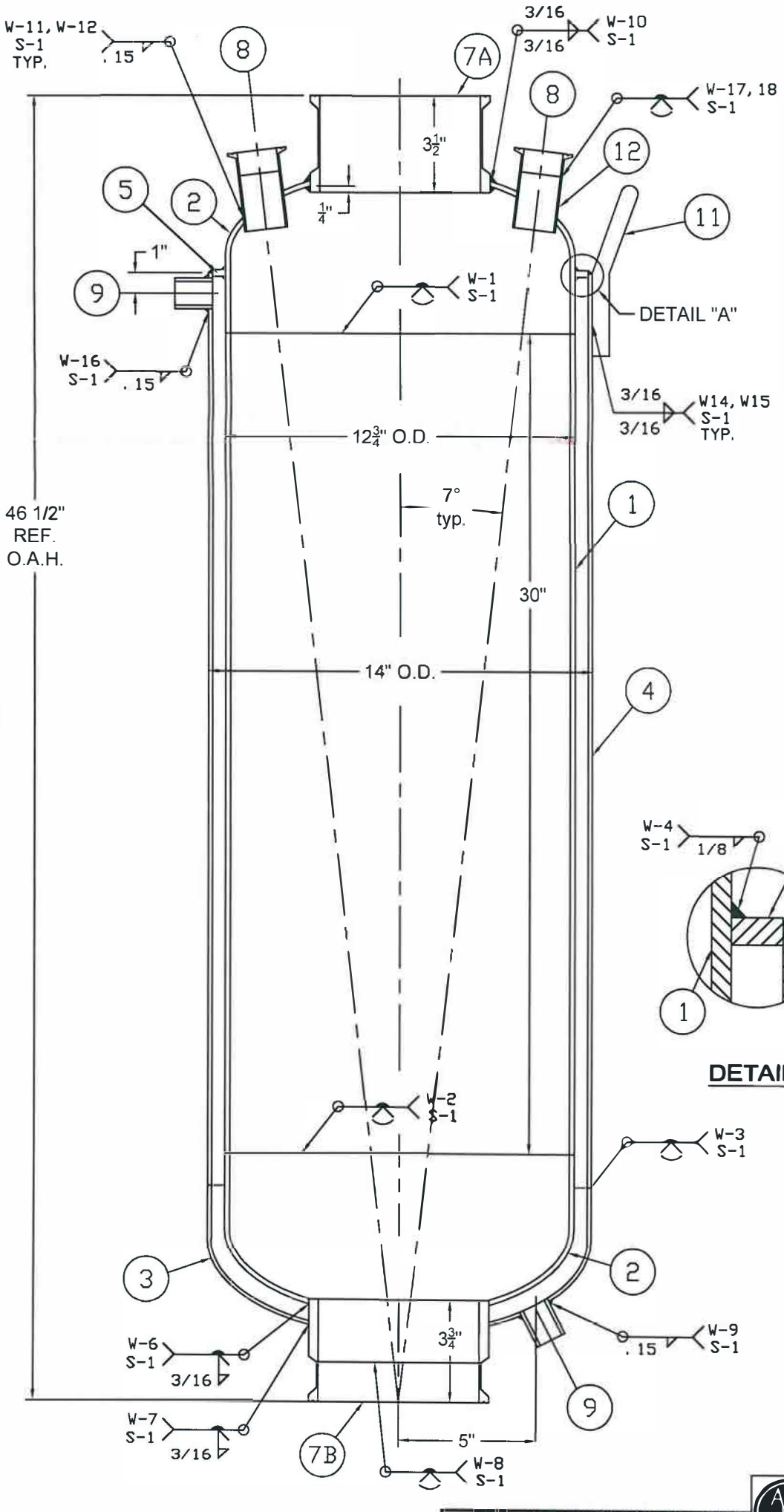
3.0 ALL SURFACES ARE TO BE PRE–CLEANED TO REMOVE GREASE, OIL, PAINT, SOIL, GRIT AND OTHER GROSS CONTAMINATION,

4.0 CALCULATED WEIGHT EMPTY: 186 LBS

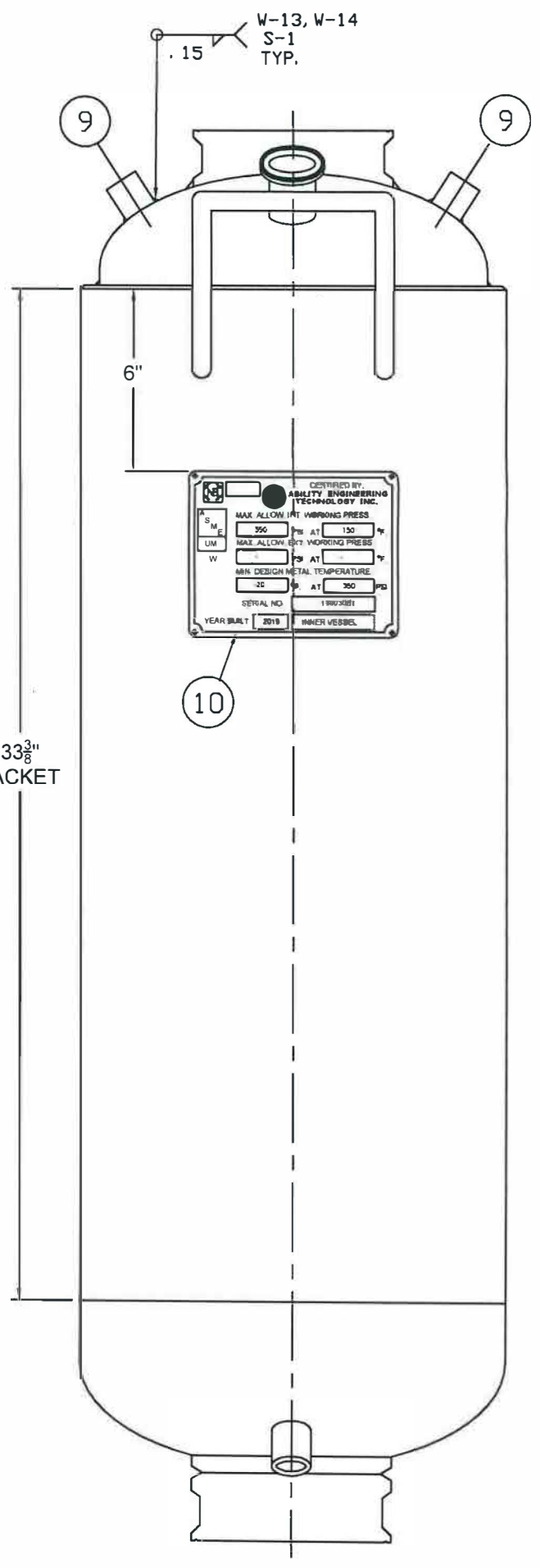
5.0 LARGEST SHIPPING DIM.: 14" DIA. X 46 1/2" O.A.L.

6.0 ASME NAMEPLATE ATTACHED TO INNER TANK, DUPLICATE TO JACKET.

7.0 ELECTROPOLISH INSIDE OF INNER VESSEL



DETAIL "A"



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UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES
UNLESS OTHERWISE SPECIFIED:
1. BREAK ALL SHARP EDGES
2. MACHINED SURFACE FINISH SHALL NOT EXCEED ANSI Y14-1994
DECIMALS
XX.XX ±.010 XX.XXX ±.005

Rev.	Date	BY	Revision Description

ABILITY ENGINEERING TECHNOLOGY
16140 VINCENNES AVENUE SOUTH HOLLAND, IL 60473
Phone No. (708) 331-0025, Fax No. (708) 331-5090

SIZE B | CAD FILE:
CUST P.O.#:

JOB.#: 9030 | QTY: 1

DESCRIPTION: 12 3/4" DIA X 46 1/2" O. A. H. ASME VESSEL
FOR: BEST VALUE
ADDRESS:
DATE: 2/24/17 SCALE: 1=4 DRAWING No.: 9030-6093 REV. 2
DWN BY: MH APPROVED BY: DATE: