

SECTION A-A  
SCALE 1 / 10

36-300 VESSEL DETAILS

**WELD NOTES**  
 1) UNLESS OTHERWISE NOTED ALL WELDS SHOWN ARE "P1 TO P1", PER LEED Q.A. MANUAL, SEC. 8.  
 2) TRANSITION ALL COMPONENT BUTT WELD WALL THICKNESSES DIFFERENCES TO A MINIMUM 3:1 TAPER.  
 3) ALL FILLET WELDS ARE ASSUMED TO BE 3/8" CONTINUOUS, ALL AROUND, UNLESS OTHERWISE NOTED.

**SHOP NOTES**  
 A) FLANGE BOLT HOLES SHALL STRADDLE PRINCIPAL CENTERLINES (2 HOLE).  
 B) DRILL / PUNCH 1/4" DIA. TELLTALE HOLES IN REPADS. (2) HOLES (1 EACH HALF) FOR SPLIT TYPE REPADS.  
 C) IN THE EVENT REPADS ARE TO BE CUT INTO 2 HALVES THEY SHALL BE FIT-UP AND INSPECTED BY THE LEED Q.A.I. TO ENSURE THAT THE SPLIT BUTT WELDS ARE FULL PENETRATION AND THAT THE WELDS DO NOT FUSE INTO THE VESSEL WALL.  
 D) INSIDE NOZZLE NECK EDGES SHALL BE RADIUSED 1/8" MIN. -OR- FOR NOZZLES WITH WALL THICKNESSES THINNER THAN 1/4" THE RADIUS SHALL = 1/2 THE NECK WALL THICKNESS.  
 E) INTERNAL NOZZLE PROJECTIONS SHALL BE AS SPECIFIED ON THE DRAWING. WHEN PROJECTIONS ARE NOT SPECIFIED THE NOZZLE SHALL BE CUT SQUARE, INSERTED THRU THE VESSEL WALL AND ALIGNED WITH THE VESSEL I.D.  
 F) DEBUR AND BREAK ALL SHARP EDGES.

**-FABRICATION TOLERANCES-  
(UNLESS OTHERWISE SPECIFIED)**

SINGLE PART FRACTIONAL DIMENSIONS ±1/16"
ANGLES ±1/2°
<b>-FABRICATION STACK-UP TOLERANCES-</b>
±1/8" FOR THE FIRST 48"
±3/16" OVER 48" THRU 96"
±1/4" OVER 96"
DEBUR AND BREAK ALL SHARP EDGES

REV.	DESCRIPTION	BY	DATE

**LEED FABRICATION SERVICES**  
 12535 WCR#2 PHONE: 303 / 659 - 6801  
 BRIGHTON, CO 80601 FAX: 303 / 659 - 6808

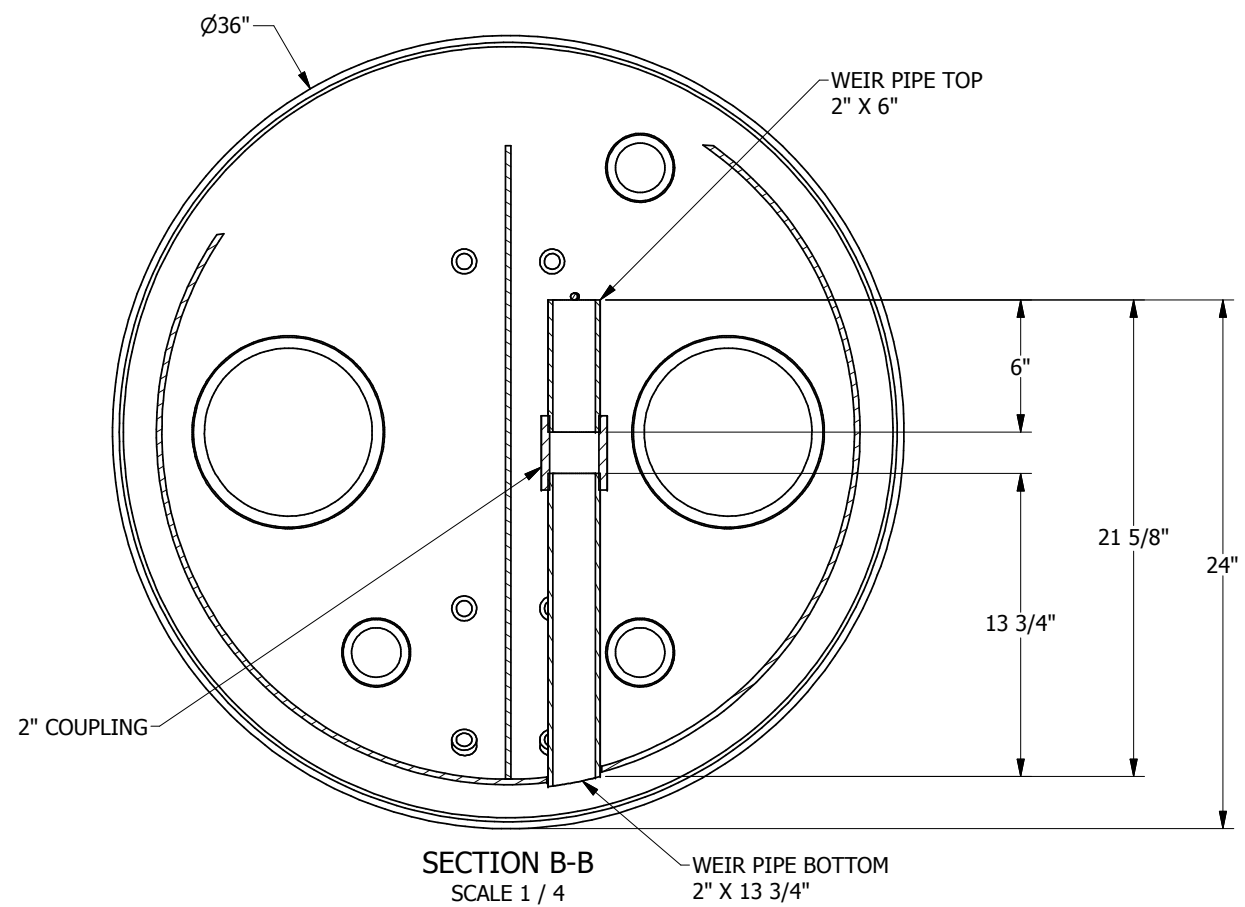
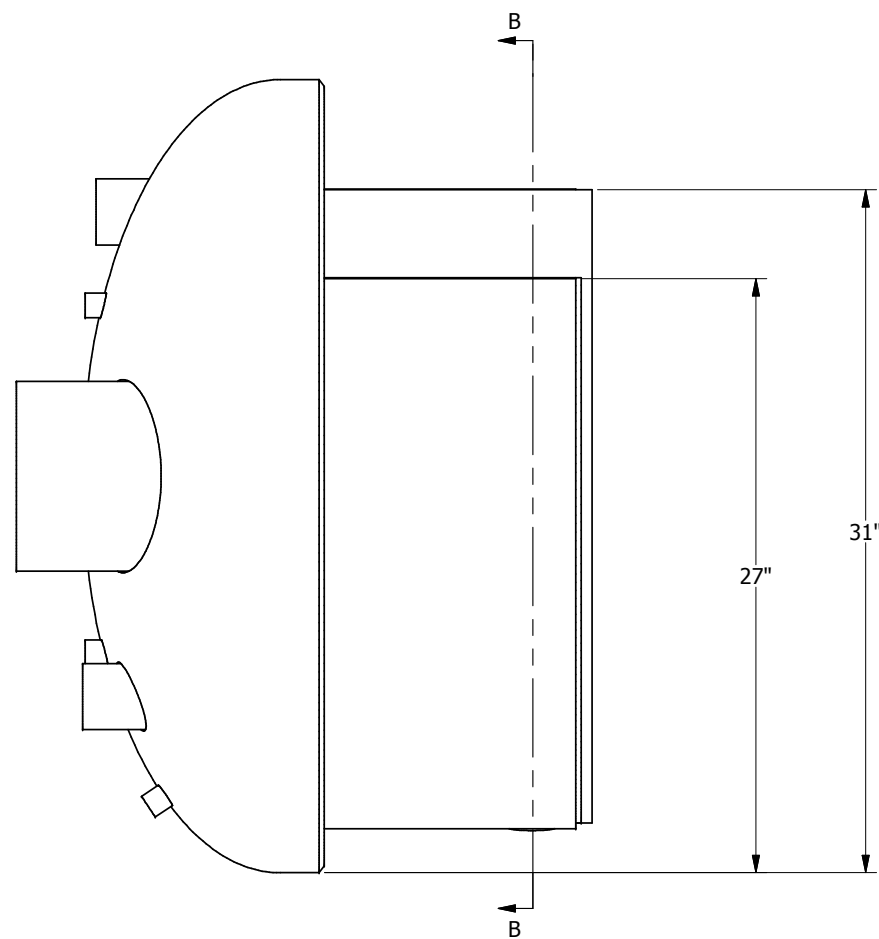
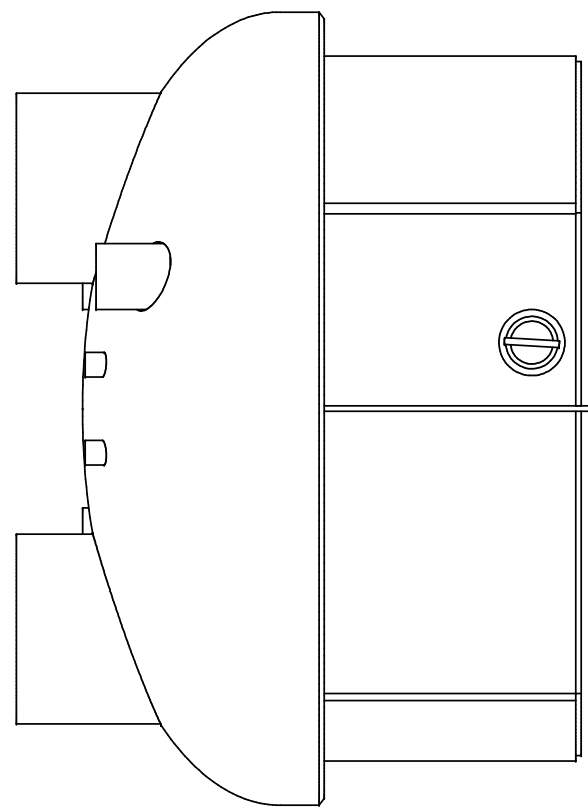
GREELEY OFFICE:  
 527 6TH AVENUE PHONE: 970 / 378 - 1172  
 GREELEY, CO 80631 FAX: 970 / 378 - 1174

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DRAWING APPROVED BY:

CUSTOMER	MECHANICAL ENGINEER	QUALITY ASSURANCE
SIGNATURE		
DATE		

36-300 VESSEL DETAILS		DRAWN / DATE	SCALE	PROJECT NO.	DRAWING NUMBER	REV
		11/29/2010	AS NOTED			
DRAWN BY	ENGINEER	SHEET	OF	36-300 DETAILS		02
BDM	CB	1	2			



REV.	DESCRIPTION	BY	DATE

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DRAWING APPROVED BY:

SIGNATURE	DATE	CUSTOMER	MECHANICAL ENGINEER	QUALITY ASSURANCE

36-300  
 WATER/OIL BOX DETAILS

DRAWN / DATE	SCALE	PROJECT NO.	DRAWING NUMBER	REV
11/29/2010	AS NOTED			

DRAWN BY	ENGINEER	SHEET	OF	36-300 DETAILS	REV
BDM	CB	2	2		02