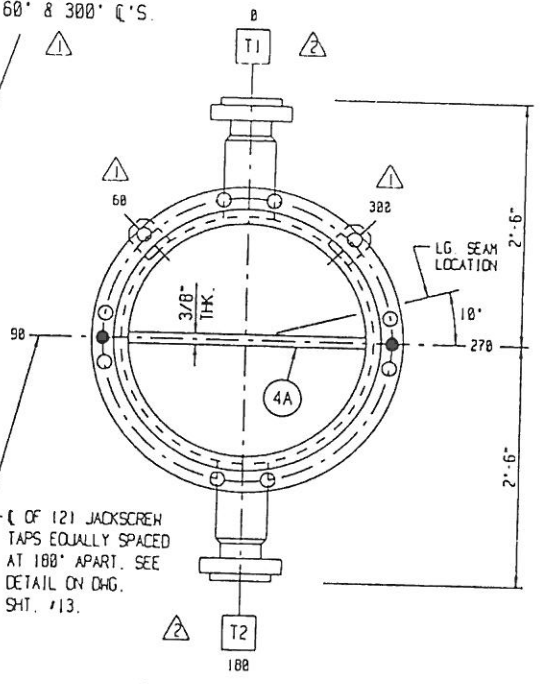


CHANNEL SIDE VIEW

\* MACHINE GASKET FACING AFTER ALL WELDING.  
FOR FLANGE DETAILS SEE DHG. SHT. #13.

LIFT LUG PER DHG. SHEET NO. 11 (IN S. 1 & IF S. 1) AT 60' & 300' C'S.



CHANNEL END VIEW

C OF 121 JACKSCREW TAPS EQUALLY SPACED AT 188' APART. SEE DETAIL ON DHG. SHT. #13.

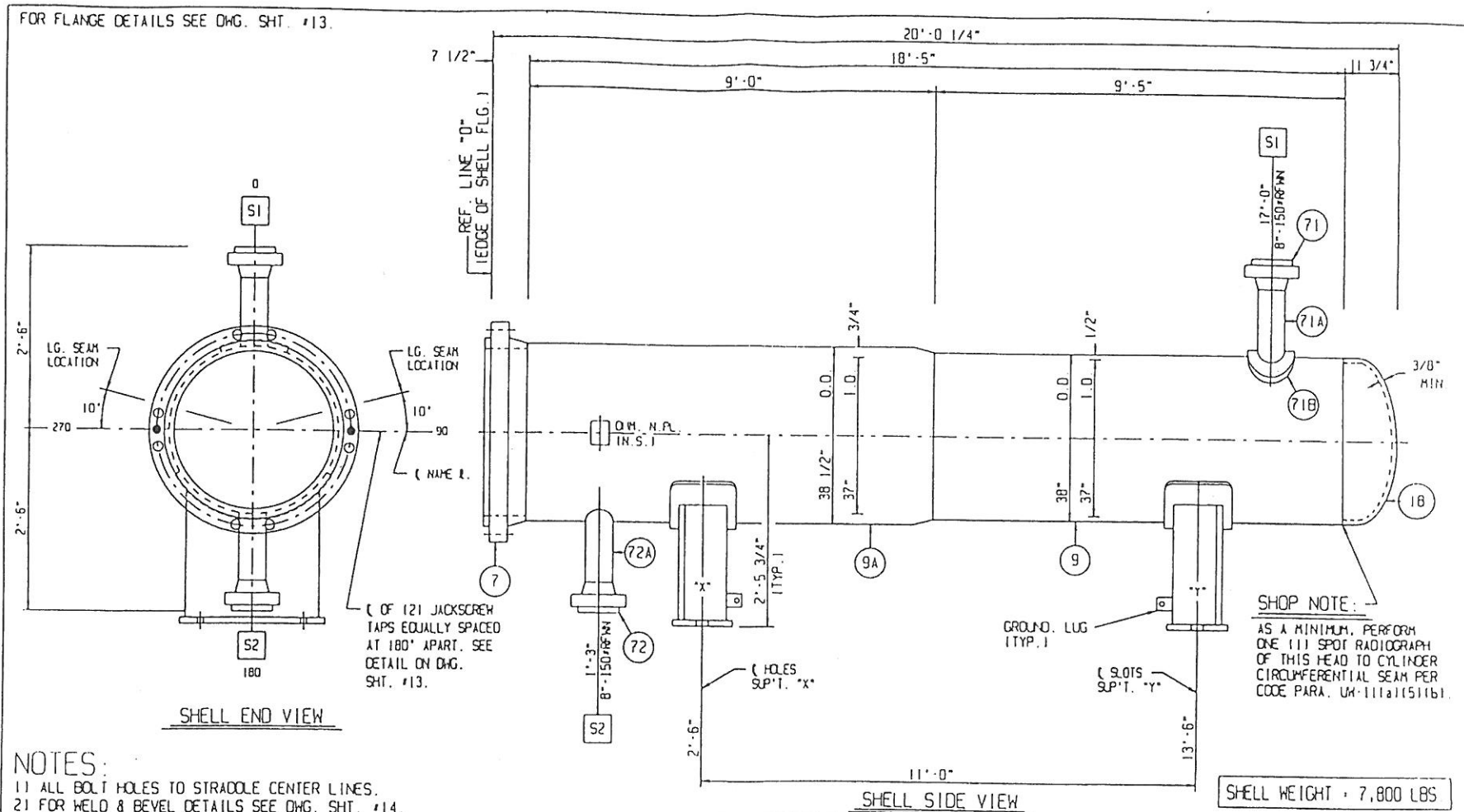
FRONT CHANNEL WEIGHT = 7,200 LBS

- NOTES:
- 1) ALL BOLT HOLES TO STRADDLE CENTER LINES.
  - 2) FOR WELD & BEVEL DETAILS SEE DHG. SHT. #14.
  - 3) FULL RADIOGRAPHY

NO.	REVISIONS	BY	OK.	DATE CHK.
2	REVISED AS NOTED	MS	DC	4-3-97
1	RELEASE FOR FABRICATION	MS	DC	3-5-97
0	FOR CUSTOMER APPROVAL	JUSS	DC	2-5-97

CUSTOMER: PETROSIN  
OHMSTEDE JOB NO.: 658312 121 UNITS REQ'D  
P.O. NO.: P181/0002  
ITEM NO.: 10-E-100 & 20-E-100  
SERVICE: INLET GAS COOLER / HEATER

FRONT CHANNEL DETAILS		
OHMSTEDE	DRAWING NO. 658312	SHEET NO. 3 REV. 2



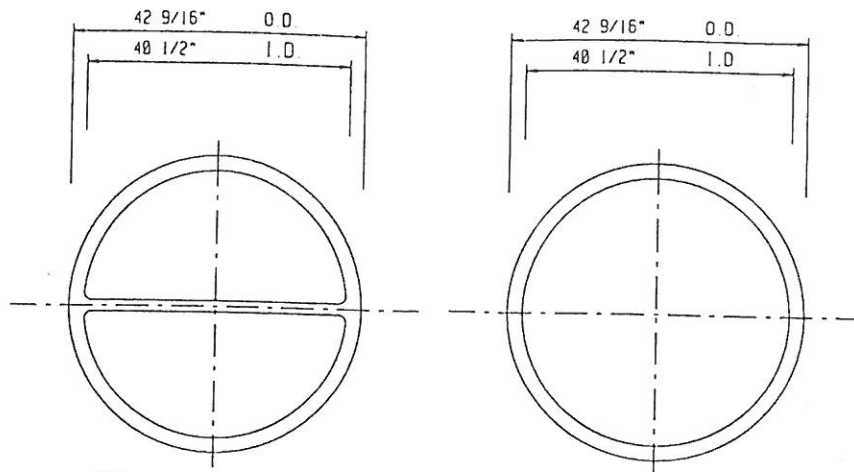
- NOTES:**
- 1) ALL BOLT HOLES TO STRADDLE CENTER LINES.
  - 2) FOR WELD & BEVEL DETAILS SEE DWG. SHT. #14.
  - 3) GRIND ALL INSIDE WELDS FLUSH.
  - 4) SPOT RADIOGRAPHY.
  - 5) POST-WELD HEAT TREAT SHELL:
    - A) HEAT FROM 800 deg. F TO 1150 deg. F AT 400 deg. F PER HOUR
    - B) HOLD AT 1150 deg. F FOR 1.00 HOUR (MIN).
    - C) COOL FROM 1150 deg. F TO 800 deg. F AT 500 deg. F PER HOUR
    - D) FURTHER COOLING MAY BE IN STILL AIR.
    - E) AN OVEN RECORDING CHART IS REQUIRED.

NO.	REVISIONS	BY	CHK.	DATE
1	RELEASE FOR FABRICATION	MS	OC	3-5-97
0	FOR CUSTOMER APPROVAL	JLS	OC	2-5-97
		ST	OK	DATE OK

CUSTOMER: PETROSIN  
 OHMSTEDE JOB NO.: 658312  
 P.O. NO.: P181/0002  
 ITEM NO.: 10-E-100 & 20-E-100  
 SERVICE: INLET GAS COOLER / HEATER

(2) UNITS REQ'D.

SHIELD DETAILS		
DRAWING NO.	SHEET NO.	REV.
OHMSTEDE 658312	4	1

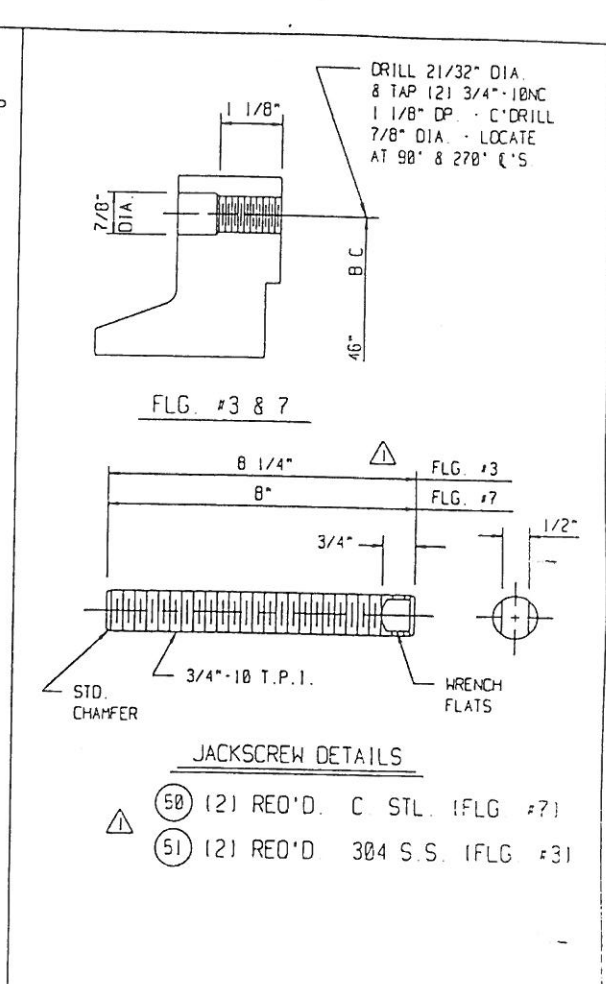
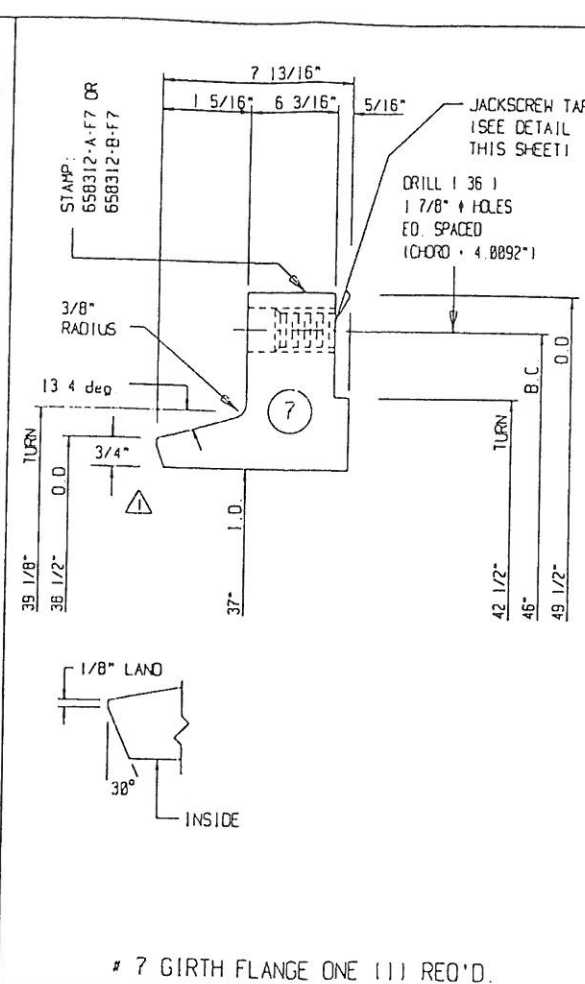
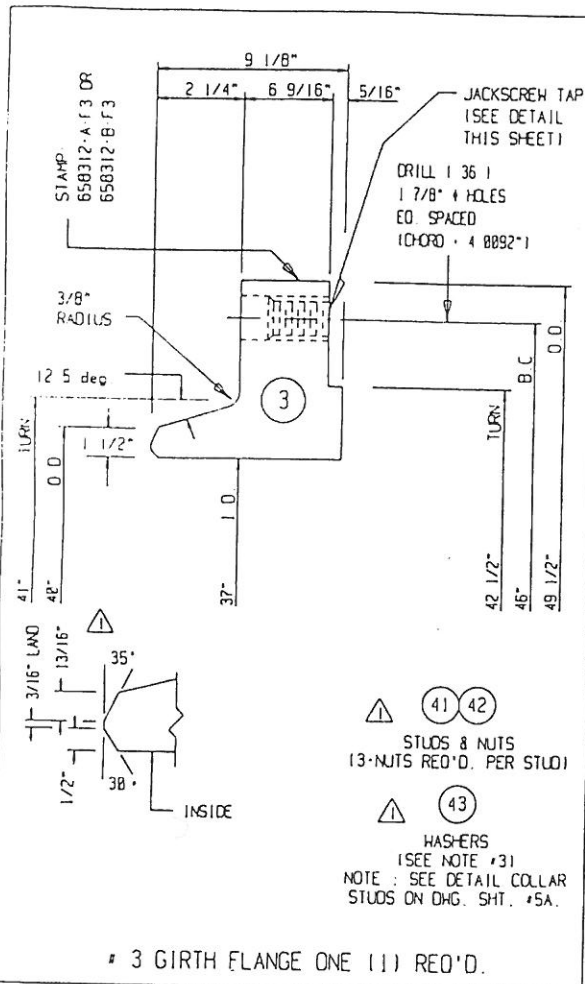


④①  
 ONE (1) - REQUIRED  
 FRONT CHANNEL GASKET  
 1/8" THK. 304L S S DOUBLE JACKETED  
 W/ FLEXIBLE GRAPHITE FILLER,  
 LAMONS STYLE 300-XL  
 RIB WIDTH TO BE 7/16"

④①  
 ONE (1) - REQUIRED  
 SHELL GASKET  
 1/8" THK. C.S. DOUBLE JACKETED  
 W/ FLEXIBLE GRAPHITE FILLER,

- NOTES:
- 1) QUANTITIES SHOWN FOR ONE (1) SET  
 THREE (3) SETS REQUIRED TOTAL  
 ONE (1) SET OF GASKETS TO BE USED IN EXCH. AND  
 TWO (2) SETS TO BE BOXED, MARKED WITH  
 P.O. & ITEM NO. & SHIPPED WITH EXCHANGER
  - 2) ALL RADII TO BE 1/4"
  - 3) ALL JACKETED GASKETS TO HAVE  
 LAP OF GASKET NEAR SIDE

					CUSTOMER: PETROSIN			
					OHMSTEDE JOB NO : 658312 (2) UNITS REQ'D			
					P.O. NO.: P181/0002			
					ITEM NO.: 10-E-100 & 20-E-100			
					SERVICE : INLET GAS COOLER / HEATER			
1	RELEASE FOR FABRICATION	MS	DC	3-5-97	GASKET DETAILS			
0	FOR CUSTOMER APPROVAL	JGS	DC	2-5-97				
NO	REVISIONS	BY	CHK	DATE CHK	OHMSTEDE	DRAWING NO 658312	SHEET NO 12	REV 1



NOTES:

1) MACHINE ALL GASKET SURFACES TO 125 - 250 AARH.

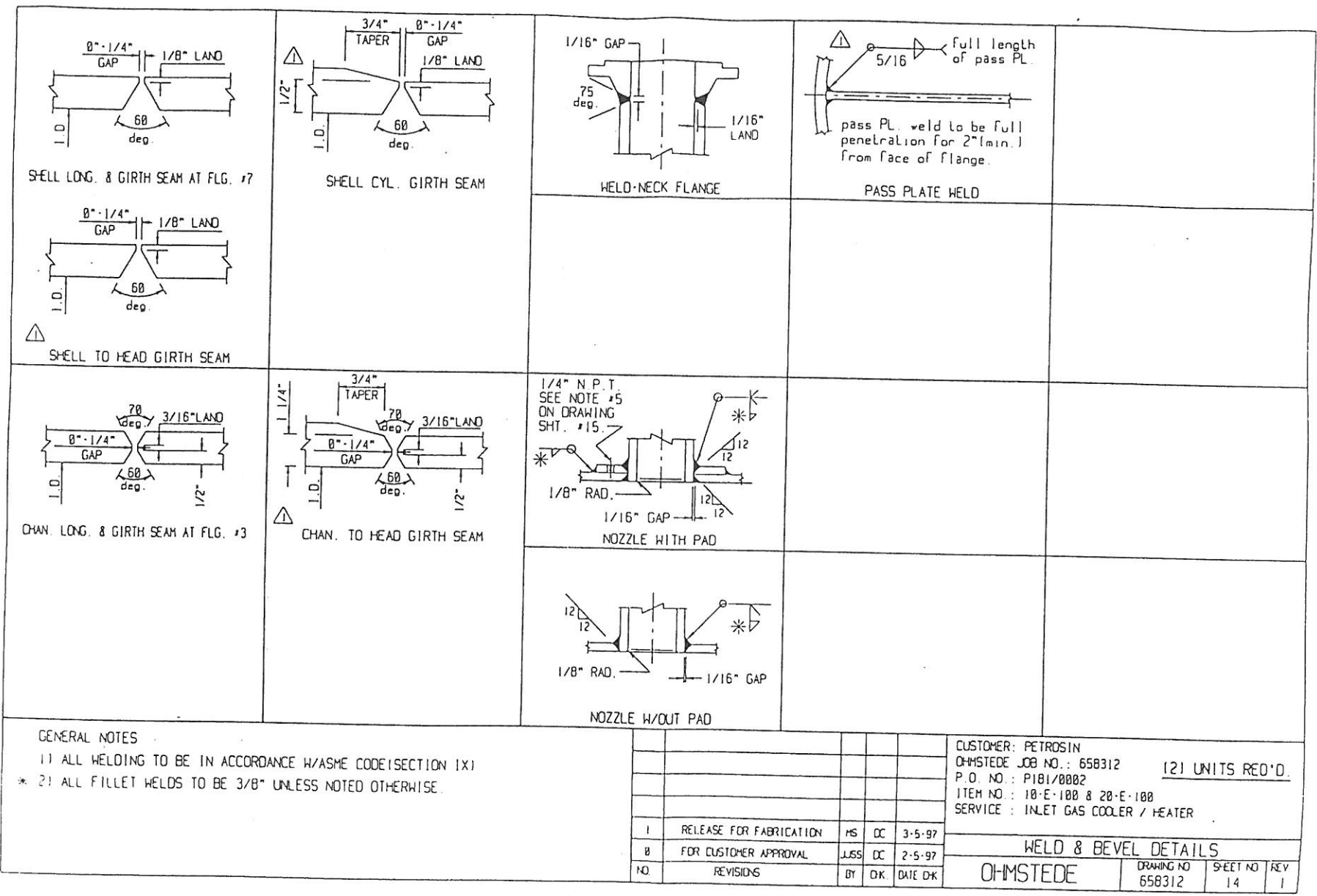
2) ALL BOLT HOLES TO STRADDLE NATURAL CENTER LINES.

3) INSTALL (2) HARDENED WASHERS (ONE EACH END) PER STUD

4) CHANNEL SIDE END OF STUDS TO HAVE TWO NUTS.

NO	REVISIONS	BY	CHK	DATE CHK
1	RELEASE FOR FABRICATION	MS	DC	3-5-97
8	FOR CUSTOMER APPROVAL	JESS	DC	2-5-97

CUSTOMER: PETROSIN			
OHMSTEDE JOB NO: 658312		121 UNITS REQ'D	
P.O. NO: P181/0002			
ITEM NO: 10-E-100 & 20-E-100			
SERVICE: INLET GAS COOLER / HEATER			
GIRTH FLANGES			
OHMSTEDE	DRAWING NO 658312	SHEET NO 13	REV 1



GENERAL NOTES  
 1) ALL WELDING TO BE IN ACCORDANCE W/ASME CODE SECTION IX  
 \* 2) ALL FILLET WELDS TO BE 3/8" UNLESS NOTED OTHERWISE.

NO.	REVISIONS	BY	CHK	DATE
1	RELEASE FOR FABRICATION	MS	DC	3-5-97
2	FOR CUSTOMER APPROVAL	JSS	DC	2-5-97

CUSTOMER: PETROSIN  
 OHMSTEDE JOB NO.: 658312 (2) UNITS REQ'D.  
 P.O. NO.: P181/0002  
 ITEM NO.: 18-E-100 & 20-E-100  
 SERVICE: INLET GAS COOLER / HEATER

WELD & BEVEL DETAILS		
OHMSTEDE	DRAWING NO 658312	SHEET NO 14
	REV 1	