

GE Infrastructure
Water & Process Technologies
 11113 NE 33RD PLACE BELLEVUE, WA 98004 USA (425) 828-2400 WWW.GEWATER.COM

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REV	DATE	DESCRIPTION	BY	CHKD
E	06/08/07	REVISED FOR DESIGN	L. ABEN	G. BJORKEDAL
D	02/16/07	REVISED TO MATCH P&IDs	L. ABEN	G. BJORKEDAL
C	12/20/06	UPDATED PER CONTRACT RELEASE	A. SPEER	G. BJORKEDAL
B	11/30/06	REVISED AS NOTED	A. SPEER	G. BJORKEDAL
ORIG	10/10/06	ISSUED FOR COMMENTS	L. ABEN	G. BJORKEDAL

DRAWN BY:	L. ABEN	10/10/06
CHECKED BY:	M. WOOLLEY	12/20/06
PROJECT ENG:	G. BJORKEDAL	12/20/06
APPROVED:	D. KANENAGA	12/20/06
PROJECT MGR:	G. BJORKEDAL	12/20/06

VeraSun
 Verasun Energy, LLC
Verasun Ethanol Site Design
 Welcome, Minnesota

PROCESS FLOW DIAGRAM
CRYSTALLIZER
 GE-RCC # A054-M3-1 REV. E

0 1" 2" FILENAME SHEET

STREAM#	1	2	3	4	5	6	7	8	9	10	11	12	13
STREAM IDENTITY	Blended Waste Stream to Feed Heat Exchanger	Heated Feed to Deaerator	Vent from Deaerator	Deaerated Feed to Recirculation Pump	Recirculating Brine to Crystallizer Heater	Heated Recirc. Brine to Crystallizer	Vapor to Atmosphere	Steam Supply	Steam to Deaerator	Vent from Condensate Tank	Condensate from Condensate Tank	Condensate after Heat Exchanger	Slurry to Bin
MASS FLOW, LBS/HR	11030	11030	220.6	11068	4147000	4147000	10310	10750	258.4	110.3	10697	10697	749
VOLUME FLOW, GPM/ACFM	21.5	22.38	60.6	22.5	6000.5	6006.1	4834.2	3302.6	71.0	30.3	22.5	21.5	1.0
TEMPERATURE, OF	60	209.5	212.6	212.6	222.5	226.5	220.5	297.0	212.6	212.6	240.2	86.4	222.5
PRESSURE, PSIA			14.52				14.3	64.05	24.5	24.5			
DENSITY, LBS/FT3	64.03	61.43	0.06	61.30	86.16	86.08	0.04	0.15	0.06	0.06	59.37	62.05	86.18
TOTAL DISSOLVED SOLIDS, mg/kg	33000	33000		33000	327953	327953							
SUSPENDED SOLIDS, mg/kg					278000	278000							
NOTES			2		5								

STREAM#	14	15	16	17	18	19	20	21	22	23
STREAM IDENTITY	Antifoam to Crystallizer	Caustic to Crystallizer	Steam to Crystallizer Heater	Antifoam to Deaerator Pump Suction						
MASS FLOW, LBS/HR			10750							
VOLUME FLOW, GPM/ACFM			1792							
TEMPERATURE, OF	70	70	297							
PRESSURE, PSIA			25							
DENSITY, LBS/FT3	54.6	50wt%	0.10							
TOTAL DISSOLVED SOLIDS, mg/l										
SUSPENDED SOLIDS, mg/l										
NOTES	6	4		3						

- Notes:
1. Barometer = 14.05 psia
 2. Size vent piping for 2"
 3. Estimated flow, size pump for a typical 0.6 gph
 4. Size pump for 0.001 gph
 5. Use sg = 1.6 for sizing Recirculation Pump
 6. 30 gph, used only during foaming events



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Verasun Energy, LLC
Verasun Ethanol Site Design

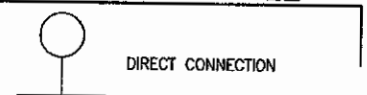
PROCESS FLOW DIAGRAM
MASS BALANCE
GE-RCC # A054-M3-1 REV. E

INSTRUMENTS

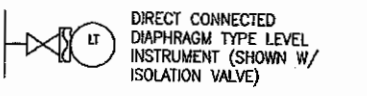
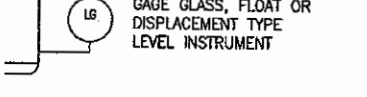
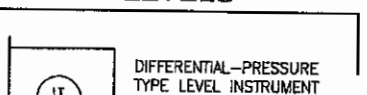
INSTRUMENTS

- LOCAL INSTRUMENT INCLUDING TRANSMITTER FOR SINGLE MEASURED VARIABLE
 - LOCAL INSTRUMENT FOR TWO MEASURED VARIABLES OR MORE THAN ONE FUNCTION
 - (with dash line) PANEL MOUNTED INSTRUMENT FOR SINGLE MEASURED VARIABLE
 - (with dash line) PANEL MOUNTED INSTRUMENT FOR TWO MEASURED VARIABLES OR MORE THAN ONE FUNCTION
 - (with dash line) PANEL MOUNTED INSTRUMENT LOCATED ON FACE OF LOCAL CONTROL PANEL
 - (with dash line) INDICATING LIGHT
 - (with dash line) DISPLAY NORMALLY
 - (with dash line) COMPUTATION NOT NORMALLY ACCESSIBLE TO OPERATOR
 - ◇ (with dash line) GENERAL SYMBOL FOR UNDEFINED INTERCONNECTING LOGIC
- DASH LINE INDICATES BEHIND PANEL MOUNTINGS

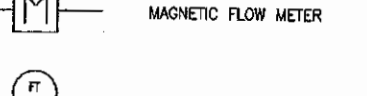
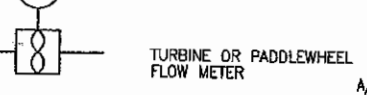
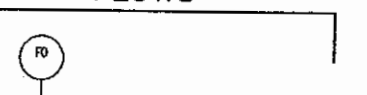
TYPICAL CONNECTION ANY VARIABLE



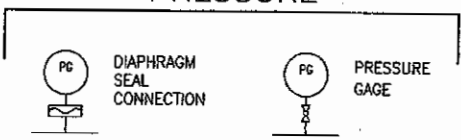
LEVELS



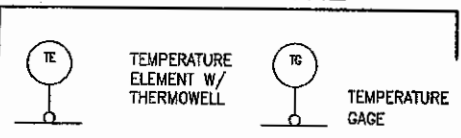
FLAWS



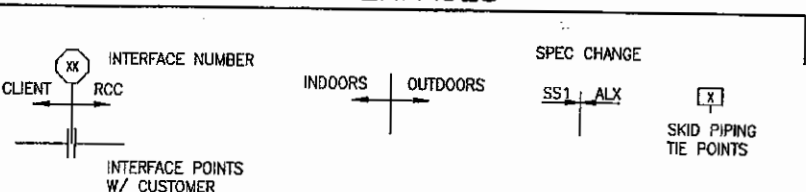
PRESSURE



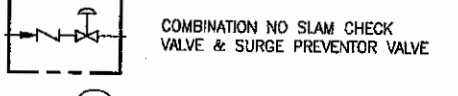
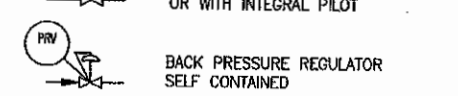
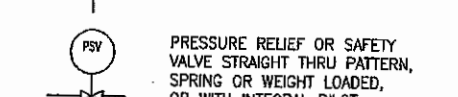
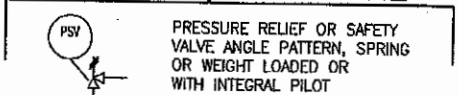
TEMPERATURE



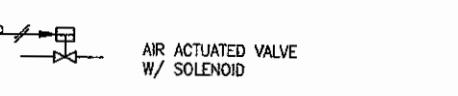
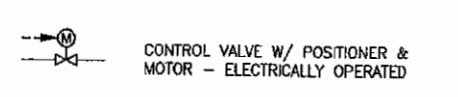
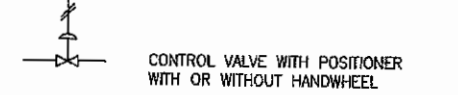
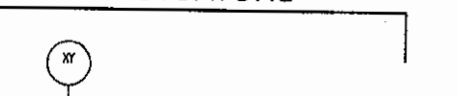
INTERFACES



SELF ACTUATED DEVICES, PRESSURE



ACTUATORS



LINES

- ELECTRICAL SIGNAL
- CONNECTION TO PROCESS, MECHANICAL LINK OR INSTRUMENT INPUT
- PNEUMATIC SIGNAL
- CAPILLARY TUBING (FILLED SYSTEM)
- SOFTWARE LINK

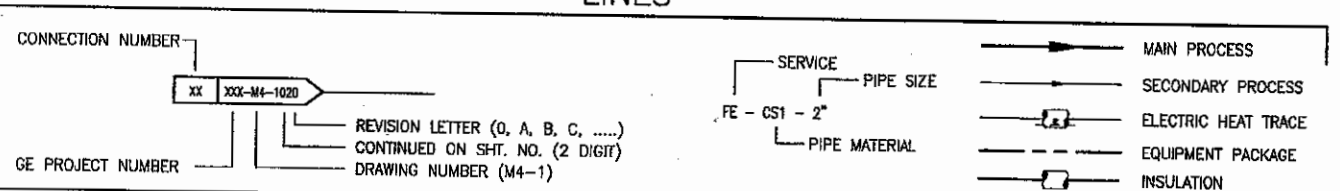
PIPING & VALVES

PIPING SYMBOLS

- OPEN DRAIN & FUNNEL CONNECTED TO DRAINAGE SYSTEM TO SUMP
- EJECTOR OR EDUCTOR
- INCREASER, REDUCER
- SCREWED CAP
- QUICK CONNECT HOSE COUPLING
- HOSE CONNECTION
- THREDOLET W/PLUG
- BLIND FLANGE
- BREAK FLANGES
- FRYPAN BLIND PLATE INSTALLED BETWEEN FLANGES
- FLEXIBLE CONNECTION
- EXPANSION JOINT
- SIGHT GLASS
- TANK/VESSEL INSULATION
- EQUIP. DRAIN (NOT CONN. TO DRAINAGE SYSTEM)
- STEAM TRAP
- WYE STRAINER
- BASKET STRAINER (SIMPLEX)
- BASKET STRAINER (DUPLEX)
- MUFFLER (SILENCER)
- FLOW STRAIGHTENING VANES
- SPECTACLE BLIND INSTALLED OPEN
- SPECTACLE BLIND INSTALLED CLOSED
- ATMOSPHERIC VENT
- SEAL WATER SUPPLY
- SEAL WATER RETURN
- SLOPE
- STARTUP STRAINER

VALVE SYMBOLS

- GATE VALVE (OPEN)
- GATE VALVE (CLOSED)
- KNIFE GATE VALVE
- GLOBE VALVE (OPEN)
- GLOBE VALVE (CLOSED)
- NEEDLE VALVE
- CHECK VALVE
- PINCH VALVE (OPEN)
- BUTTERFLY VALVE (OPEN)
- BUTTERFLY VALVE (CLOSED)
- PLUG VALVE (OPEN)
- PLUG VALVE (CLOSED)
- BALL VALVE (OPEN)
- BALL VALVE (CLOSED)
- DIAPHRAGM VALVE
- CHOKE VALVE
- CONTROL VALVE W/ ELECTRIC MOTOR
- THREE-WAY VALVE
- FOUR-WAY VALVE
- TWO WAY SOLENOID
- THREE-WAY SOLENOID VALVE
- FOUR-WAY SOLENOID VALVE
- COCK VALVE
- ANGLE VALVE
- BALL CHECK VALVE (CHEMICAL INSERTION)
- Y VALVE



ABBREVIATIONS & MISCELLANEOUS

PIPING SERVICE & ABBREVIATION LEGEND

- | | | | |
|---|-------------------------------------|--|--|
| AC: AIR CLOSURES | AF: ANTIFOAM | PC: PRIME CONDENSATE | NOTES |
| AD: AIR OPENS | ALM: ALUM | PCD: PROCESS CONDENSATE | 1. ALL INSTRUMENTATION SYMBOLS & IDENTIFICATION ARE PER THE INSTRUMENT SOCIETY OF AMERICA (I.S.A.) STANDARD-LATEST REVISION ANSI Y32.20. |
| A/S: INSTRUMENT AIR SUPPLY | AS: AUXILIARY STEAM | POL: POLYMER | 2. PIPING MATERIAL: |
| C.C: CORROSION COUPON POINT | BI: BIOCIDE | PP: POWER PLANT WASTE | A20: ALLOY 20 (150#) |
| CO: CHAIN OPERATED | CA: COMPRESSED AIR | PPC: POWER PLANT WASTE/CONCENTRATE MIX | ALX: AL6XN/254 SMD (150#) |
| CS: CHANGE SPECIFICATION | CC: CALCIUM CHLORIDE | PPPO: PP CLARIFIER OVERFLOW | CPVC: CHLORINATED POLYVINYLCHLORIDE |
| D: TEST DRAIN, PLUGGED | CIP: RO CLEAN IN PLACE SOLUTION | PPS: PP CLARIFIER SLUDGE | CS1: CARBON STEEL (150#) |
| FC: FAIL CLOSE ON AIR SUPPLY LOSS | CD: STEAM CONDENSATE | PS: PLANT STEAM | CU: COPPER |
| FD: FLOOR DRAINAGE SYSTEM | DCL: DAF CLARATE | PW: POTABLE WATER | PVC: POLYVINYLCHLORIDE |
| FO: FAIL OPEN | DR: DRAIN | ROC: REVERSE OSMOSIS CONCENTRATE | PVDF: POLYVINYLIDENE FLUORIDE |
| N: NEW EQUIPMENT INSTRUMENTS & VALVES USED WHERE REQUIRED | DS: DAF SLUDGE | ROF: REVERSE OSMOSIS FEED | RUB: RUBBER HOSE |
| NC: NORMALLY CLOSED | DW: DEAERATOR WATER | ROP: REVERSE OSMOSIS PERMEATE | SP1: FABRICATED 6X MOLY DUCT |
| NO: NORMALLY OPEN | EC: EVAPORATOR CONCENTRATE | SSS: SODIUM BISULFITE | SS1: 316L STAINLESS STEEL PIPE (150#) |
| P/S: PURGE WATER SUPPLY | EP: EVAPORATOR PRODUCT (DISTILLATE) | SEW: SEAL WATER | SS2: 304L STAINLESS STEEL PIPE (150#) |
| RTD: RESISTANCE TEMPERATURE DETECTOR | ER: EVAPORATOR RECIRCULATION | SHC: SODIUM HYPOCHLORITE | SS5: 316L STAINLESS STEEL TUBING |
| SP: SPECIFIED PIPING ITEM | EV: EVAPORATOR VAPOR | SI: SCALE INHIBITOR | |
| SV: SAMPLE VALVE (1/2" SIZE UNLESS OTHERWISE NOTED) | FCL: FERRIC CHLORIDE | SS: SODIUM SULFATE | |
| T/C: THERMOCOUPLE | FE: FEED WATER | SW: SERVICE WATER | |
| TDS: TOTAL DISSOLVED SOLIDS | FG: FUEL GAS | VT: VENT | |
| TP: TEST POINT | HCl: HYDROCHLORIC ACID | WW: WASTE WATER | |
| TS: TOTAL SOLIDS | HS: SULFURIC ACID | | |
| TSS: TOTAL SUSPENDED SOLIDS | HW: HOT WATER | | |
| V: TEST VENT, PLUGGED | IA: INSTRUMENT AIR | | |
| W/S: WATER SUPPLY | KS: CAUSTIC (NaOH) | | |
| | LO: LUBE OIL | | |
| | MSO: MAGNESIUM SULFATE | | |
| | PA: PLANT AIR | | |

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E	10/10/07	ISSUED FOR CONSTRUCTION	A. SPEER	G. BJORKEDAL
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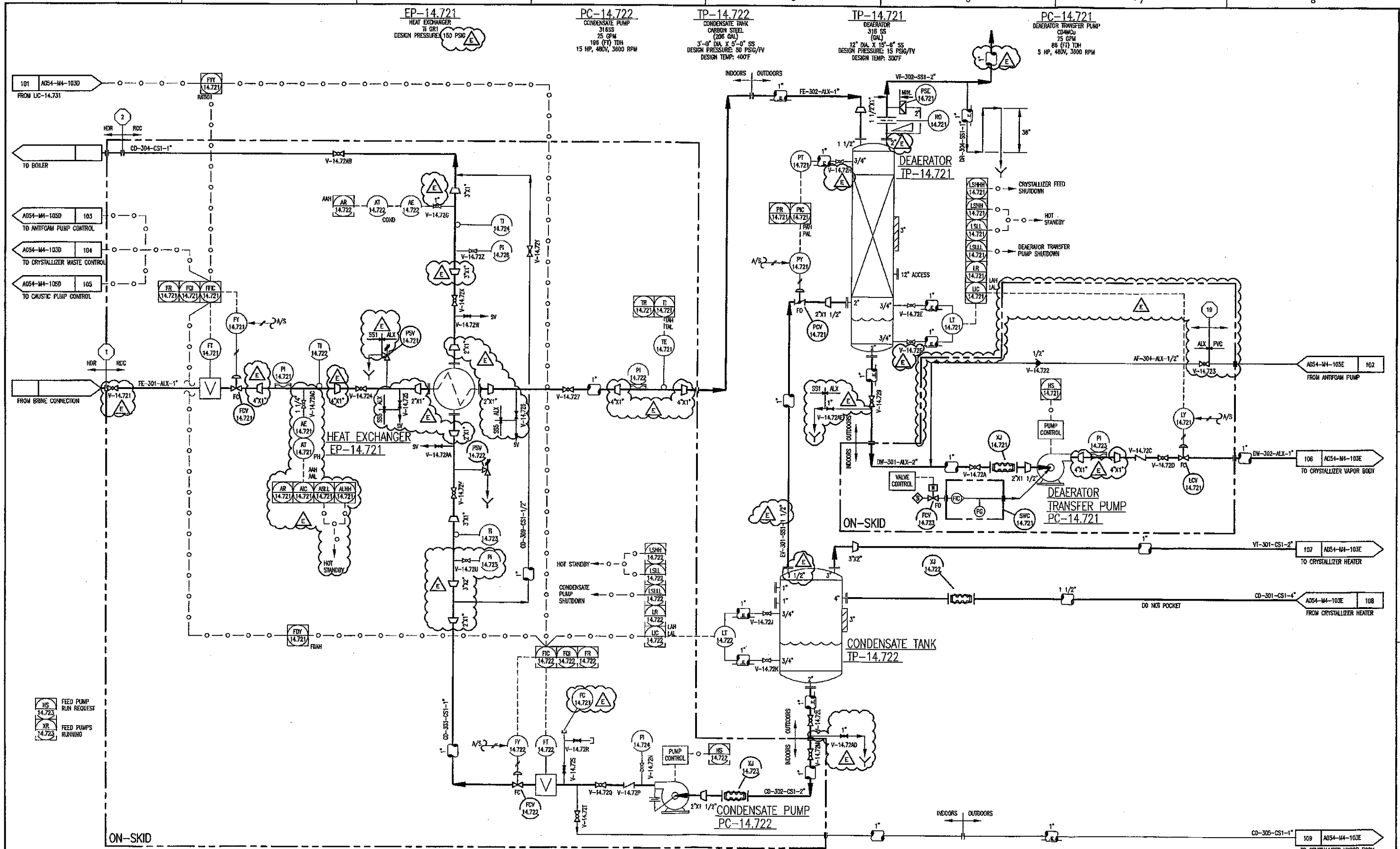


Verasun Energy, LLC
Verasun Ethanol Site Design
Welcome, Minnesota

P. & I.D. LEGEND
GE-RCC # A054-M4-1 REV. E

SCALE: 1" = 2'
FILENAME: 14,710
SHEET: 1 OF 6

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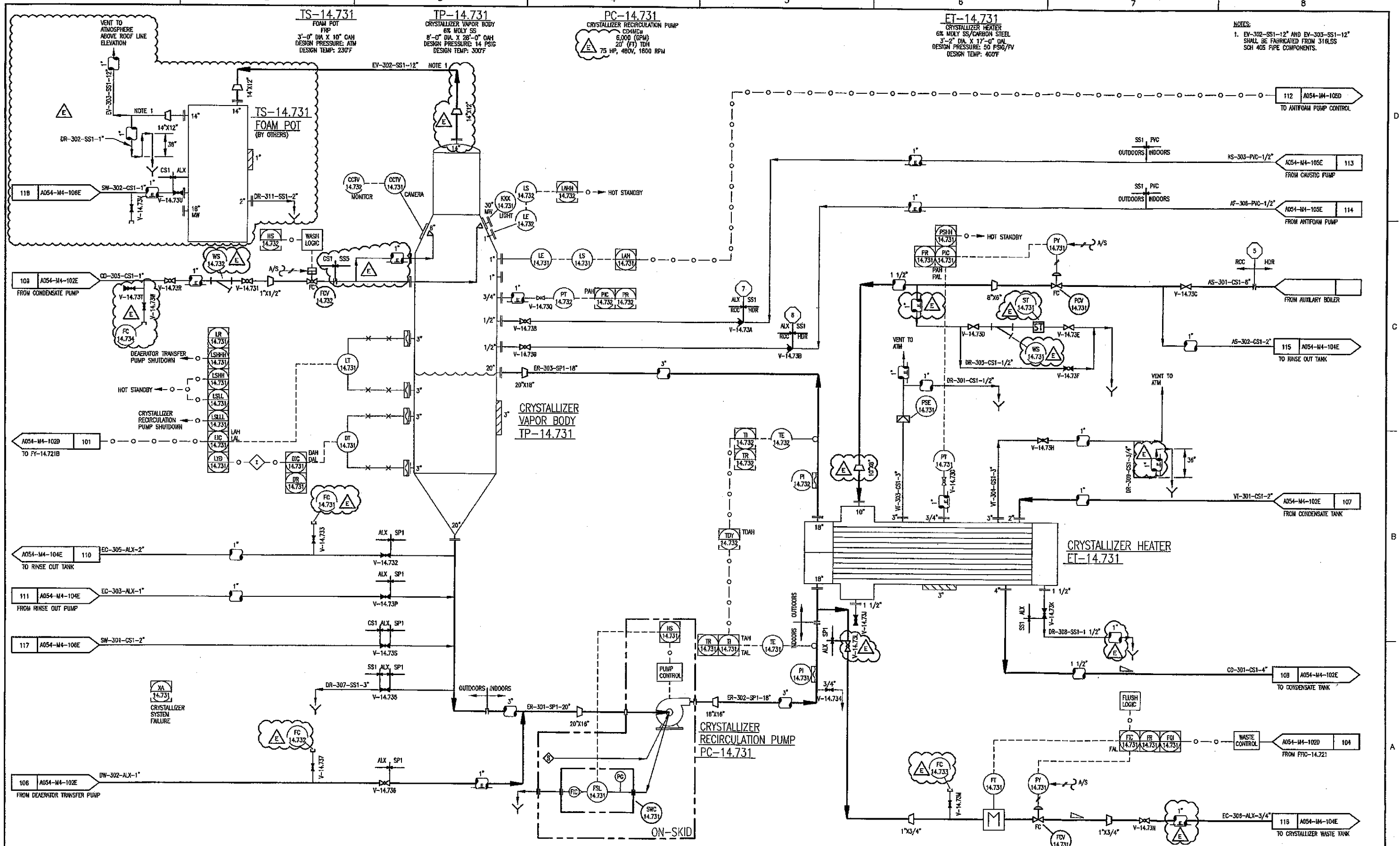
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VeraSun
 Verasun Energy, LLC
Verasun Ethanol Site Design
 Welcome, Minnesota

P. & I.D.
DEAERATOR/DISTILLATE SYSTEM
GE-RCC # A054-M4-1 REV. E

0 1" 2"
 FILENAME: 14.720
 SCALE: -
 SHEET: 2



NOTES:
 1. EV-302-SS1-12" AND EV-303-SS1-12" SHALL BE FABRICATED FROM 316LSS SCH 40S PIPE COMPONENTS.

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P. & I.D. VAPOR BODY
 GE-RCC # A054-M4-1 REV. E

FILENAME: 14.730
 SCALE: -
 SHEET: 3

PC-14.742
CRYSTALLIZER WASTE PUMP
CD4MCU
30 GPM
70(FIT) TDH
7.5 HP, 480V, 1800 RPM

TS-14.742
CRYSTALLIZER WASTE TANK
COATED CARBON STEEL
500 GAL.
4'-0" DIA. X 7'-8" SS
DESIGN PRESSURE: 9" H₂O
DESIGN TEMP: 300F

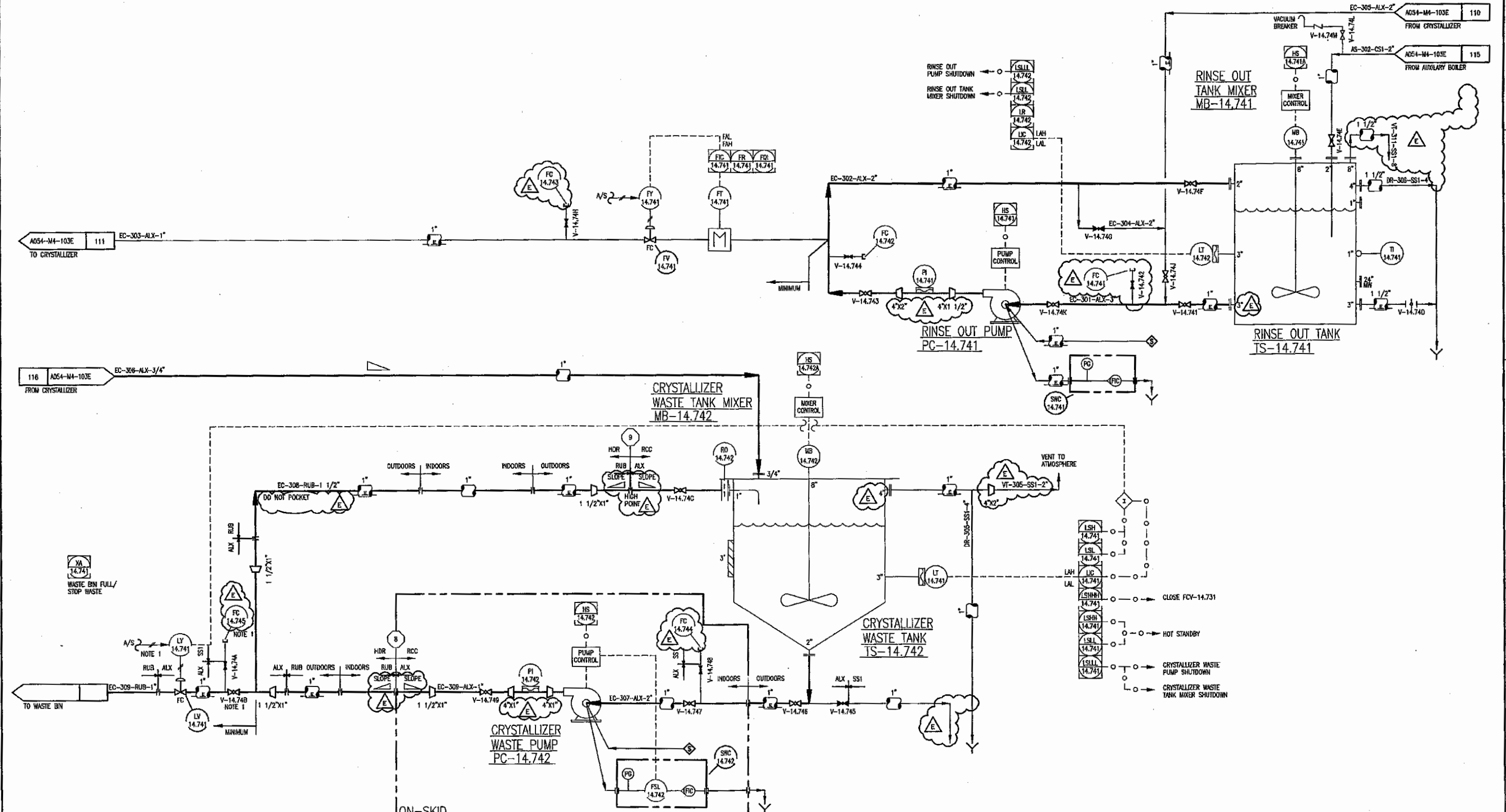
MB-14.742
CRYSTALLIZER WASTE TANK MIXER
C-276
1.5 HP

PC-14.741
RINSE OUT PUMP
CD4MCU
80 GPM
63 (FIT) TDH
7.5 HP, 480V, 1800 RPM

MB-14.741
RINSE OUT TANK MIXER
C-276
3 HP

TS-14.741
RINSE OUT TANK
COATED CARBON STEEL
7,000 GAL.
10'-0" DIA. X 13'-8" SS
DESIGN PRESSURE: 9" H₂O
DESIGN TEMP: 300F

NOTES:
1. SUPPLIED BY RCC



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ISSUE	DATE	DESCRIPTION	BY	CHECKED
E	10/10/07	ISSUED FOR CONSTRUCTION	A. SPEER	G. BJORKEDAL
D	5/30/07	REVISED FOR DESIGN	L. ABEN	G. BJORKEDAL
C	2/18/07	REVISED TAGS	L. ABEN	G. BJORKEDAL
B	12/21/06	REVISED PER CLIENT COMMENTS	L. ABEN	G. BJORKEDAL
A	12/06/06	REVISED PER CLIENT COMMENTS	L. ABEN	G. BJORKEDAL
ORIG	11/03/06	ISSUED FOR COMMENTS	L. ABEN	G. BJORKEDAL

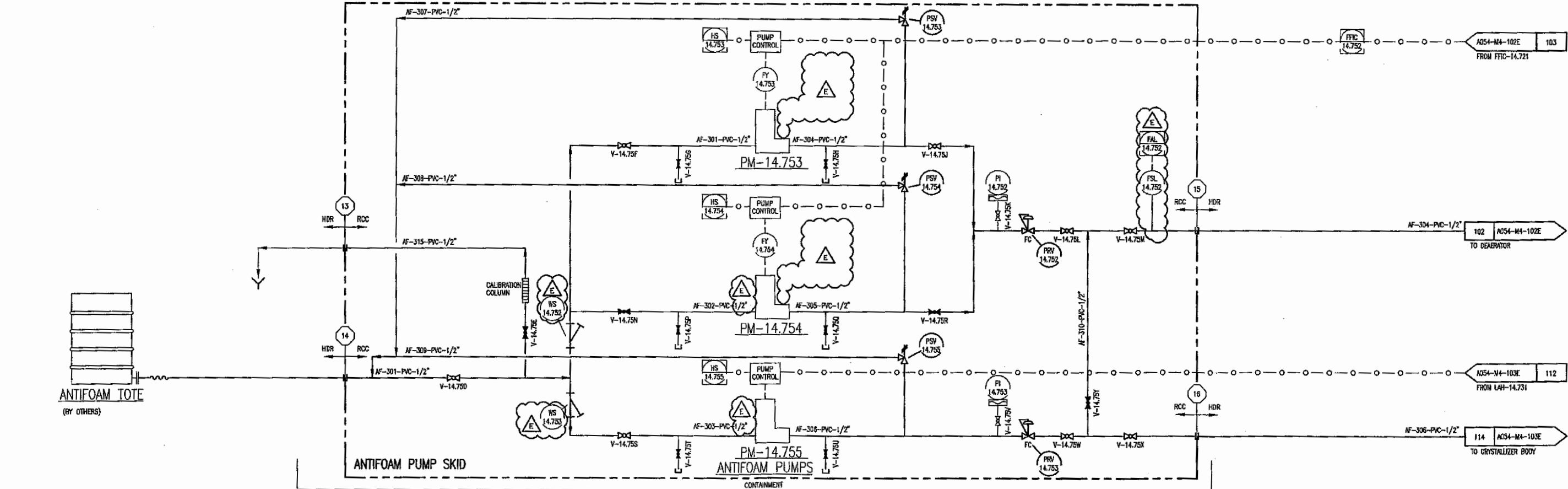
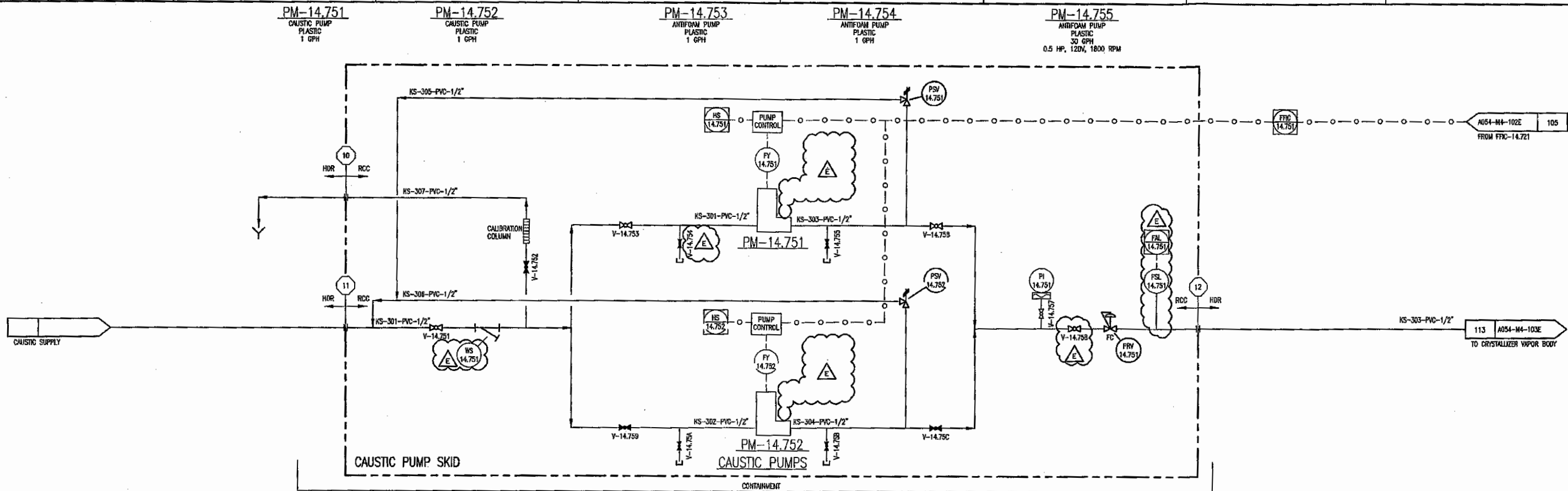
DRAWN BY:	L. ABEN	10/25/06
CHECKED BY:	M. WOOLLEY	11/03/06
PROJECT ENG:	G. BJORKEDAL	11/03/06
APPROVED:	D. KANENAGA	11/03/06
PROJECT MGR:	G. BJORKEDAL	11/03/06

VeraSun
Verasun Energy, LLC
Verasun Ethanol Site Design
Welcome, Minnesota

P. & I.D. FEED SYSTEM
GE-RCC # A054-M4-1 REV. E

0 1" 2"

FILENAME	14.740	SHEET	4
SCALE	-		



GE Infrastructure
Water & Process Technologies
 11113 NE 33RD PLACE BELLEVUE, WA 98004 USA (425) 828-2400 WWW.GEWATER.COM

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ORIG	DATE	DESCRIPTION
E	10/10/07	ISSUED FOR CONSTRUCTION
D	5/30/07	REVISED FOR DESIGN
C	2/16/07	REVISED TAGS
B	12/21/06	REVISED PER CLIENT COMMENTS
A	12/06/06	REVISED PER CLIENT COMMENTS
ORIG	11/03/06	ISSUED FOR COMMENTS
ISSUE		DATE

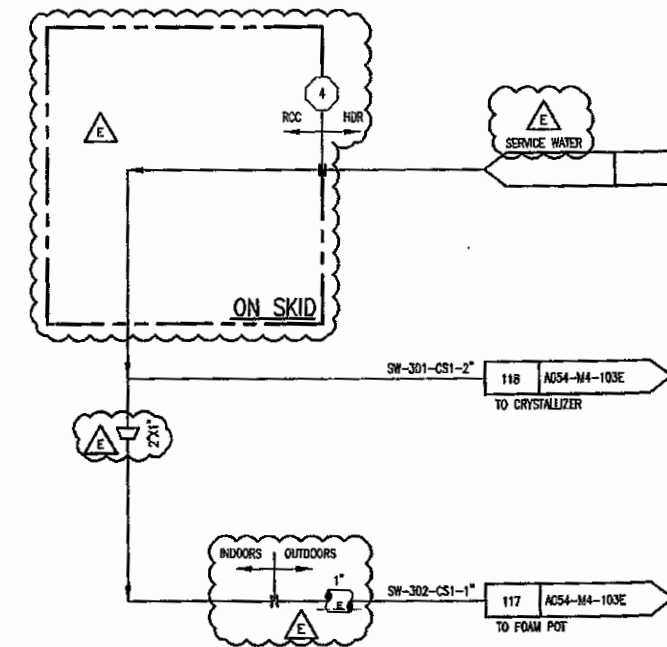
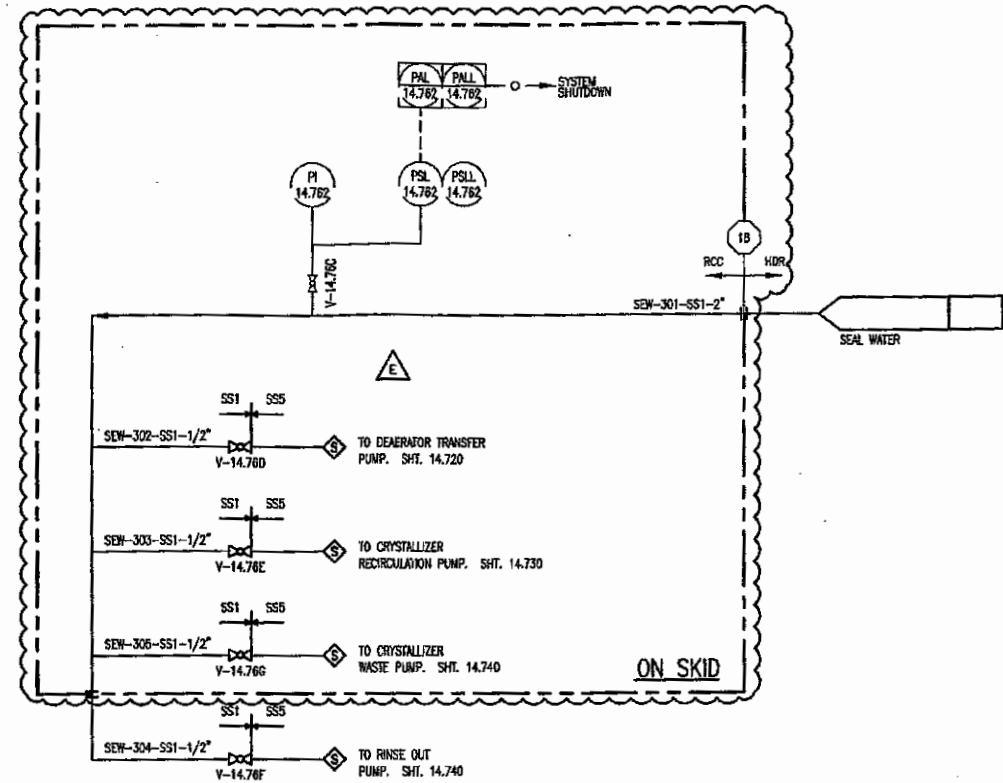
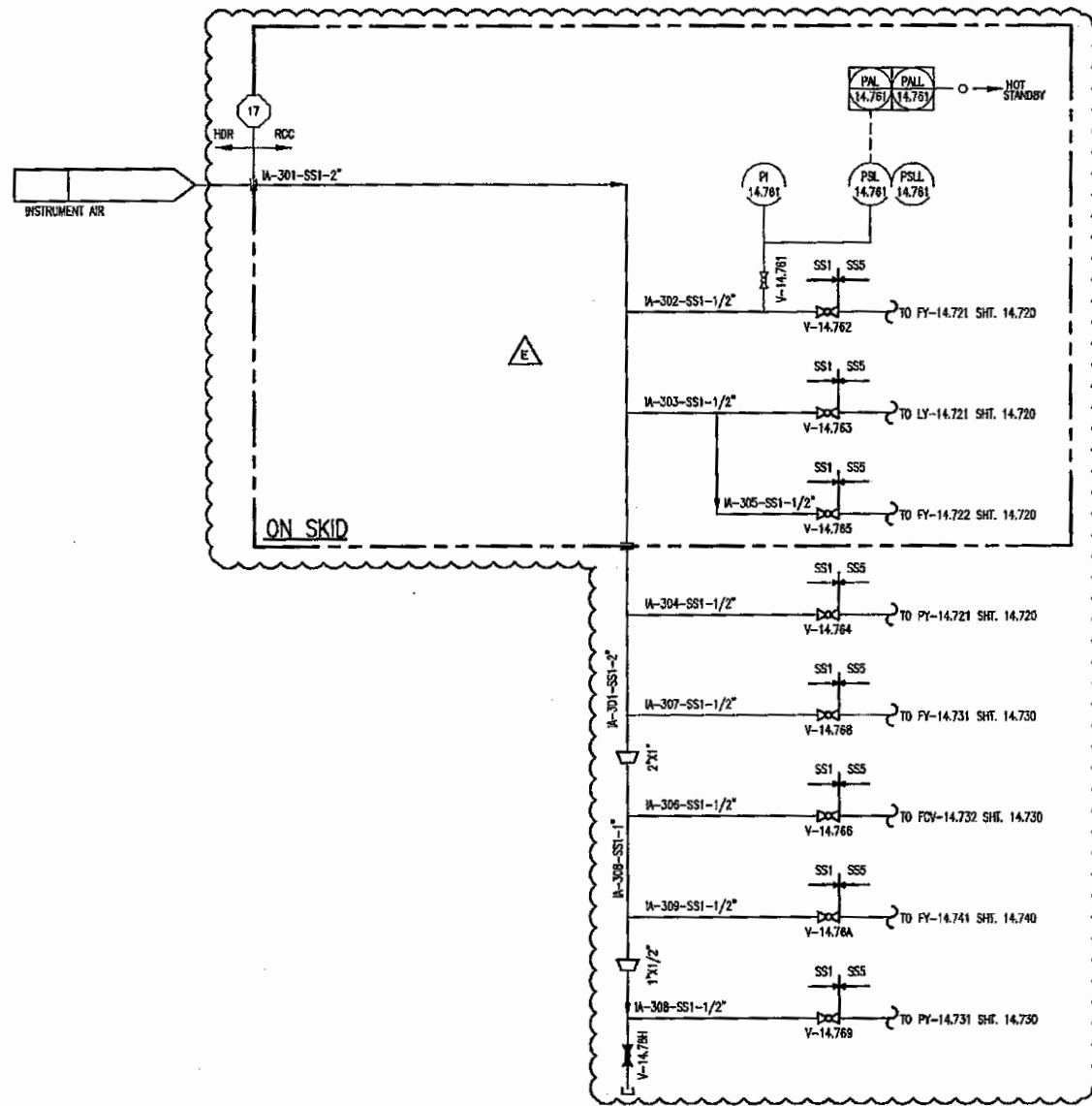
BY	CHECKED
L. ABEN	G. BJORKEDAL
L. ABEN	G. BJORKEDAL
L. ABEN	G. BJORKEDAL
L. ABEN	G. BJORKEDAL
L. ABEN	G. BJORKEDAL
L. ABEN	G. BJORKEDAL
L. ABEN	G. BJORKEDAL

DRAWN BY:	L. ABEN	10/31/06
CHECKED BY:	M. WOOLLEY	11/03/06
PROJECT ENG:	G. BJORKEDAL	11/03/06
APPROVED:	D. KANENAGA	11/03/06
PROJECT MGR:	G. BJORKEDAL	11/03/06

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P. & I.D.
CHEMICAL FEEDS
GE-RCC # A054-M4-1 REV. E

0 1" 2"
 FILENAME: 14.750
 SCALE: -
 SHEET: 5



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ISSUE	DATE	DESCRIPTION
E	10/10/07	ISSUED FOR CONSTRUCTION
D	5/30/07	REVISED FOR DESIGN
C	2/16/07	NEW SHEET

BY	CHECKED
A. SPEER	G. BJORKEDAL
L. ABEN	G. BJORKEDAL
L. ABEN	G. BJORKEDAL

DRAWN BY:	L. ABEN	01/17/07
CHECKED BY:	G. BJORKEDAL	01/18/07
PROJECT ENG:	G. BJORKEDAL	01/18/07
APPROVED:	D. KANENAGA	01/18/07
PROJECT MGR:	G. BJORKEDAL	01/18/07

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P. & I.D.
INSTRUMENT AIR/SEAL WATER
GE-RCC # A054-M4-1 REV. E

0 1" 2"

FILENAME	14.760	SHEET
SCALE	-	6