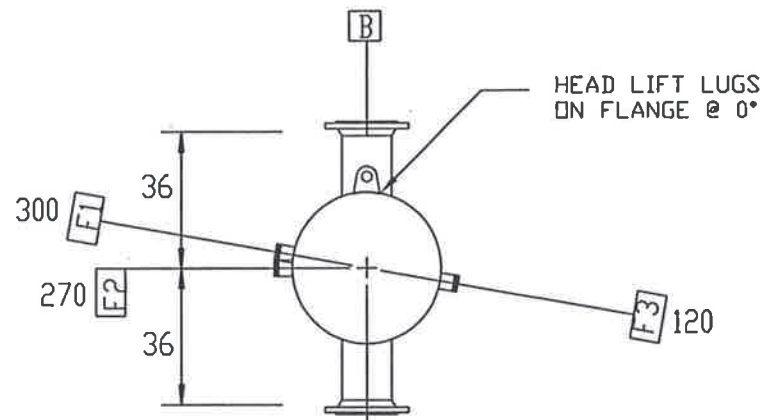
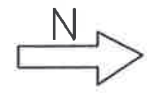
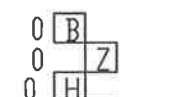


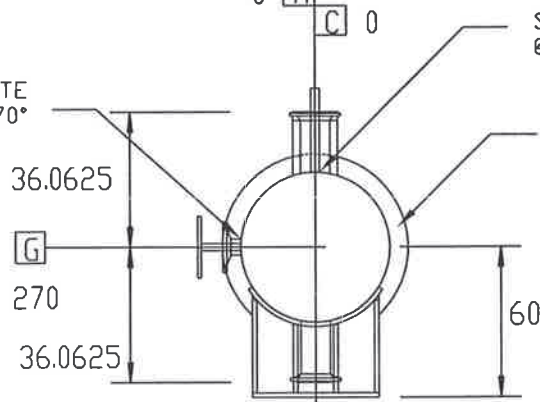
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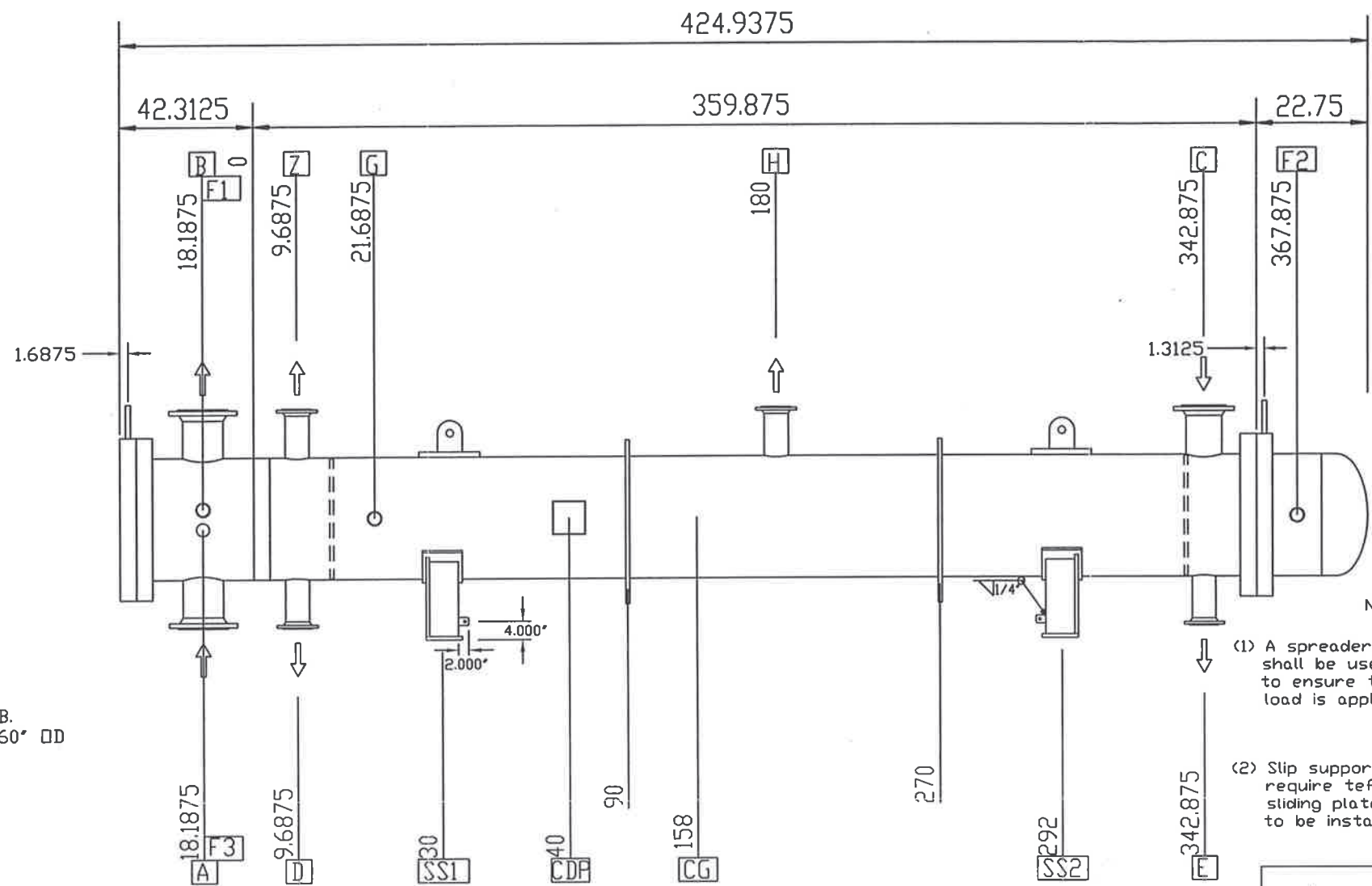
Looking North



CODE DATA PLATE @ 270°

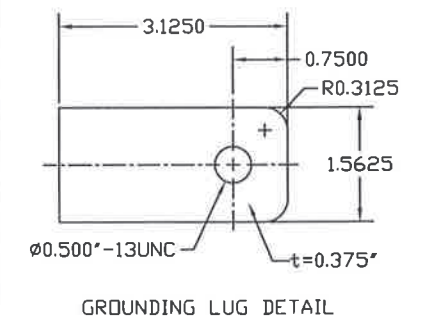
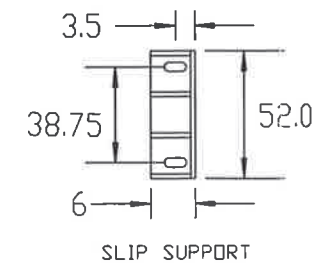
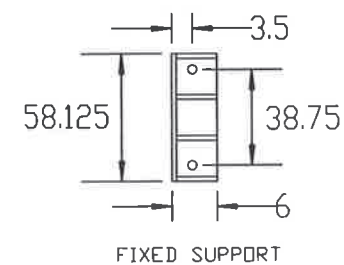


Looking North



NOTES:

- (1) A spreader bar or its equivalent shall be used during lifting operations to ensure that essentially avERTICAL load is applied to the lifting lugs
- (2) Slip supports require teflon sliding plates to be installed



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Nozzles (1)				Couplings / Supports (2)			Design Specifications		Shell	Tube									
Label	Size	Description	Project.	Label	Size	Description	Project.	Design Pressure	psig	150/FV	150/FV								
A	20"	150 # ANSI S.D.R.F	36	F1	0.5	3000 # Half Length	30.9375	Test Pressure	psig	195	213								
B	20"	150 # ANSI S.D.R.F	36	F2	0.5	3000 # Half Length	30.9375	Min. Design Temperature	F	-20	-20								
C	18"	150 # ANSI S.D.R.F	36	F3	0.5	3000 # Half Length	30.9375	Max. Design Temperature	F	400	300								
D	6"	150 # ANSI S.D.R.F	36	G	0.5	3000 # Half Length	30.9375	Number of Passes		1	2								
E	2"	150 # ANSI S.D.R.F	36	SS1	2-1.25	Bolt Holes	60	Corrosion Allowance	in	0.0625	0.0								
H	2"	150 # ANSI S.D.R.F	36	SS2	2-1.25 x 2.5	Slots	60	Radiographing		None	None								
Z	2"	150 # ANSI S.D.R.F	36	CDP		CODE DATA PLATE		Post-Weld Heat Treatment		None	None								
								Wt Empty:	51878	Full:	88794	Bundle:	32867	lb					
								Rev:	4	Date:	12-17-07	Description:	Certified As-Built	Dwg:	AGB	Ckd:	DGB	Appd:	PW

Company: DCR  
Location: Bunge-Ergon  
Beer Column Reboiler  
Item No: E-4101  
Date: Aug 9, 2007 Job No: 7793

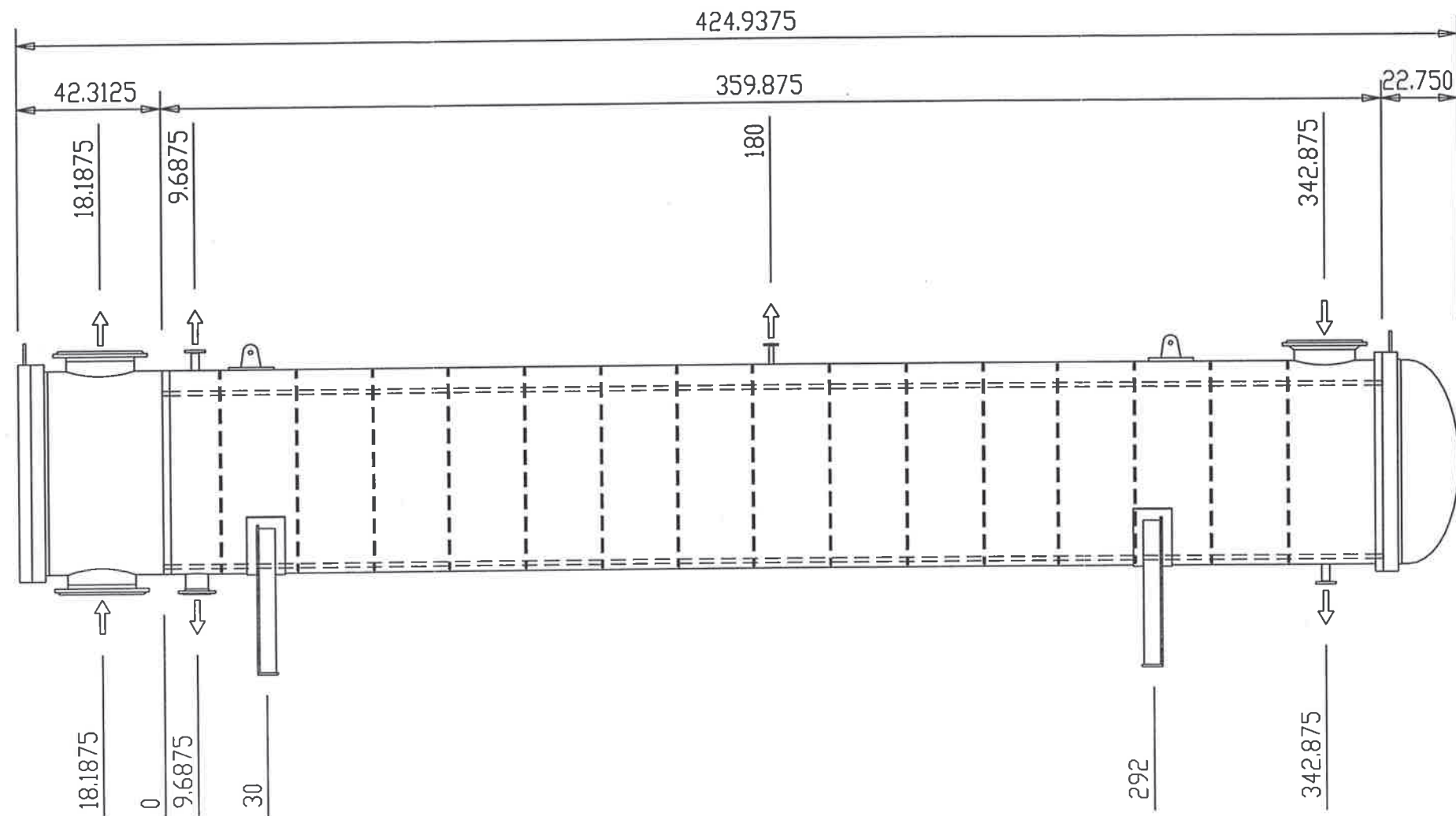
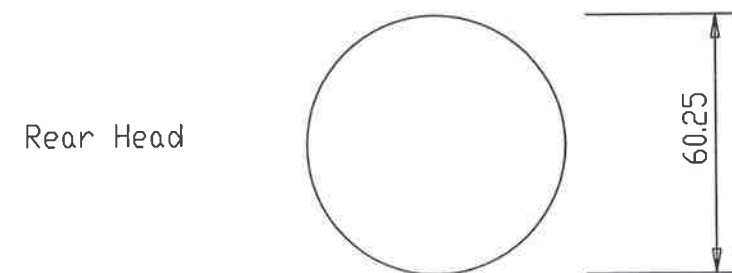
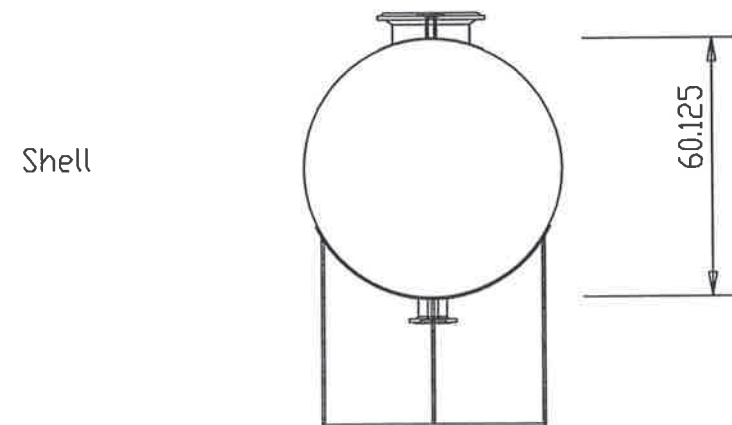
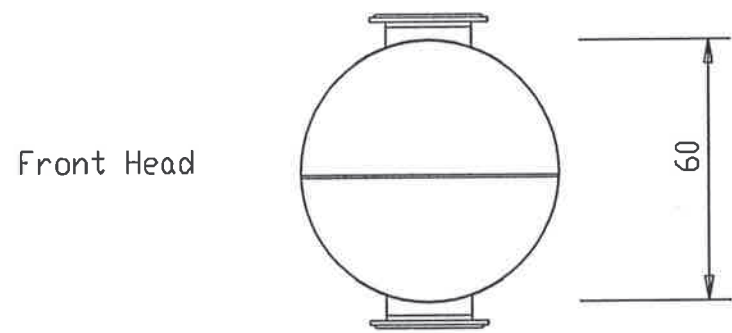
DCR Construction, Inc.  
Lakeland, Florida

Setting Plan

ASME VIII-1 2004 A06  
TEMA Type: NEM  
Size: 59-360  
TEMA Class: C

Dwg No: E-4101 01A  
Rev: 4

Dimensions: in



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Scale: NTS

Nozzles (1)			Couplings / Supports (2)			Design Specifications		Shell	Tube										
Label	Size	Description	Project	Label	Size	Description	Project	Design Pressure	psig										
A	20"	150 # ANSI S.O.R.F	36	F1	0.5	3000 # Half Length	30.9375	Test Pressure	psig										
B	20"	150 # ANSI S.O.R.F	36	F2	0.5	3000 # Half Length	30.9375	Design Temperature	F										
C	18"	150 # ANSI S.O.R.F	36	F3	0.5	3000 # Half Length	30.9375	Number of Passes											
D	6"	150 # ANSI S.O.R.F	36	G	0.5	3000 # Half Length	31	Corrosion Allowance	in										
E	2"	150 # ANSI S.O.R.F	36	SS1	2-1.25	Bolt Holes	60	Radiographing											
H	2"	150 # ANSI S.O.R.F	36	SS2	2-1.25 x 2.5	Slots	60												
Z	2"	150 # ANSI S.O.R.F	36																
								Wt Empty:	51878	Full:	88794	Bundle:	32784	lb					
								Rev:	2	Date:	8-9-07	Description:	General Revisions	Dwg:	JFS	Ckd:	DGB	Appd:	PW
								3	8-31-07	Revised As Noted	KFF	DGB	PW						
								4	12-17-07	Certified As-Built	AGB	DGB	PW						

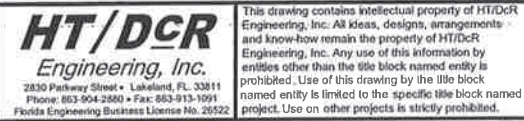
Company: DCR  
Location: Bunge-Ergon  
Beer Column Reboiler  
Item No: E-4101  
Date: Aug 9, 2007 Job No: 7793

DCR Construction, Inc.  
Lakeland, Florida

ASME VIII-1 2004 A06	Setting Plan	Dwg No: E-4101 01B	Rev: 4
TEMA Type: NEM			
Size: 59-360			
TEMA Class: C			

Component	Ø.D.	Thk.	Materials of Construction
Nozzle A Inlet	20.0	.375	150 # ANSI S.D.R.F Flg SA-182 on SA-240 S30400 Grd TP304 Plate
Nozzle B Outlet	20.0	.375	150 # ANSI S.D.R.F Flg SA-182 on SA-240 S30400 Grd TP304 Plate
Nozzle C Inlet	18.0	.5	150 # ANSI S.D.R.F Flg SA-105 on SA-53 K03005 Grd E/B Wld. Pipe
Nozzle D Outlet	6.625	0.562	150 # ANSI S.D.R.F Flg SA-105 on SA-106 K03006 Grd B Smls. pipe
Nozzle E Drain	2.375	0.344	150 # ANSI S.D.R.F Flg SA-105 on SA-106 K03006 Grd B Smls. pipe
Nozzle H Vent	2.375	0.344	150 # ANSI S.D.R.F Flg SA-105 on SA-106 K03006 Grd B Smls. pipe
Nozzle Z Vent	2.375	0.344	150 # ANSI S.D.R.F Flg SA-105 on SA-106 K03006 Grd B Smls. pipe
Coupling F1	0.5		3000 # Half Length SA-182 S30400 Grd F304 Forgings
Coupling F2	0.5		3000 # Half Length SA-182 S30400 Grd F304 Forgings
Coupling F3	0.5		3000 # Half Length SA-182 S30400 Grd F304 Forgings
Coupling G	0.5		3000 # Half Length SA-105 K03504 Forgings
Nozzle A Inlet Pad	22.5	0.25	SA-240 S30400 Grd 304 Plate (G5)
Nozzle B Outlet Pad	22.5	0.25	SA-240 S30400 Grd 304 Plate (G5)
Nozzle C Inlet Pad	23.125	0.313	SA-516 N02700 Grd 70 Plate
Shell Cylinder	60.125	0.5	SA-516 K02700 Grd 70 Plate
Fr Hd Cylinder	60	0.50	SA-240 S30400 Grd 304 Plate (G5)
Fr Hd Cover	64.125	4.0	SA-516 K02700 Grd 70 Plate (Flat Cover)
FlnG Cover Faceplate	64.125	.375	SA-240 S30400 Grd 304 Plate
Re Hd Cover	64.125	0.375	SA-240 S30400 Grd 304 Plate (Ellipsoidal Cover)
Front TubSh	60	2.1875	SA-240 S30400 Grd 304 Plate
Rear TubSh	64.5	2.1875	SA-240 S30400 Grd 304 Plate
Re Hd Flng TubSh	64.5	4.5	SA-240 S30400 Grd 304 Plate
Fr Hd Flng Cover	64.125	3.9375	SA-240 S30400 Grd 304 Plate
Re Hd Gskt TubSh	61.625	0.125	Solid Teflon 1/8in Thickness (Periph. Width 1.0625 in)
Fr Hd Gskt Cover	61.25	0.125	Solid Teflon 1/8in Thickness (Periph. Width 1.0625 in)
Re Hd Blts TubSh	.625		SA-193 G41400 Grd B7 Bolt (108 Bolts on 62.6875 in B.C.)
Fr Hd Blts Cover	.625		SA-193 G41400 Grd B7 Bolt (108 Bolts on 62.5 in B.C.)
Tubes	1.25	0.065	SA-249 S30400 Grd TP304 Wld. tube(G5) (Plain Tubes)
Baffles	58.813	0.5	SA-516 K02700 Grd 70 Plate
Shell Supports			SA-516 K02700 Grd 70 Plate
Nameplate		0.1046	SA-240 S30400 Grd 304 Plate
Nameplate Bracket		0.25	SA-516 K02700 Grd 70 Plate
Head Lift Lugs		0.500	SA-240 S30400 Grd 304 Plate
Shell Lift Lugs		1.50	SA-36 K02600 Plate
Shell Lift Lugs Repad		1.000	SA-516 K02700 Grd 70 Plate

Dimensions: in



Design Specifications

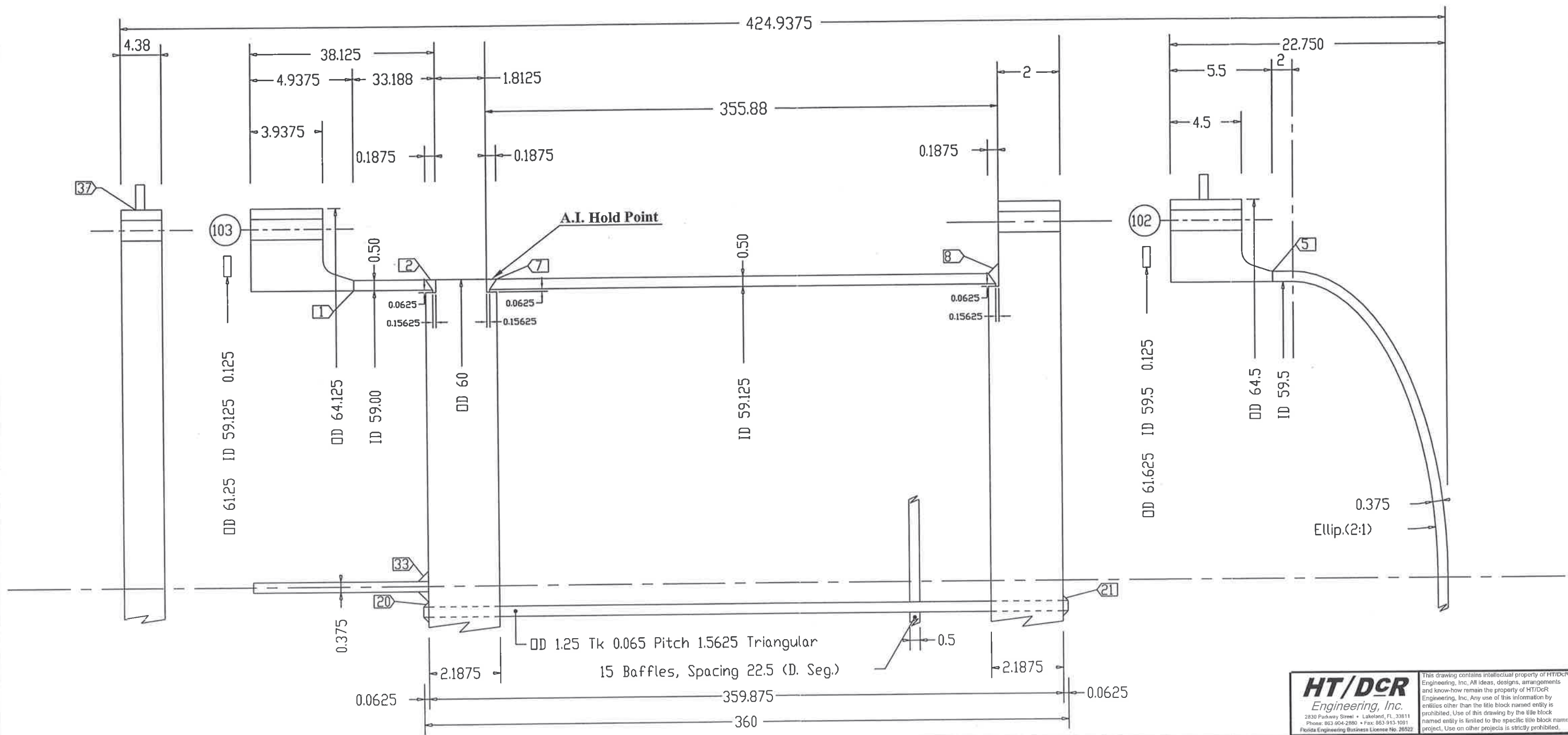
	Shell Side	Tube Side
Design Pressure	150/FV	150/FV
Test Pressure	195	195
Design Temperature	400	300
Number of Passes	1	2
Corrosion Allowance	0.0625	0.0
Radiographing	None	None
TEMA Type: NEM	Size: 59-360	Area: 11202
Tube Type: Plain	# Holes: 1141	Length: 360 in
Layout: 1.5625 in (30)	Tube-Ts Joint: Strength Wld	
Baffle Type: Double Seg.	Cut: 32% V	No: 15
Baffle Spacing (C-C): 22.5	Inlet: 23.5 in	
Impingement Protection: None		
Code: ASME VIII-1 2004 A06	TEMA Class: C	
Wt Empty: 51878	Full: 88794	Bundle: 32784 lb
Drawn By: JFS	Ckd By: DGB	Apvd By: PW
Dwg No.: E4101 02	Rev: 3	Date: 12-17-07

Company: DCR  
Location: Bunge-Ergon  
Beer Column Reboiler  
Item No.: E-4101  
Date: August 9, 2007 Job No.: 7793

DCR Construction, Inc.  
Lakeland, Florida

Rev No.: 3	Bill of Material
Certified As-Built	
Dwg No.: E-4101 02	Rev: 3

All Dimensions  
In Inches



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Notes:  
All Dimensions In Inches  
Bolt holes to straddle centerlines  
Weld joint details per drawing 20

Company: DCR  
Location: Bunge-Ergon  
Beer Column Reboiler  
Item No: E-4101  
Date: Aug 9, 2007 Job No: 7793

DCR Construction, Inc.  
Lakeland, Florida

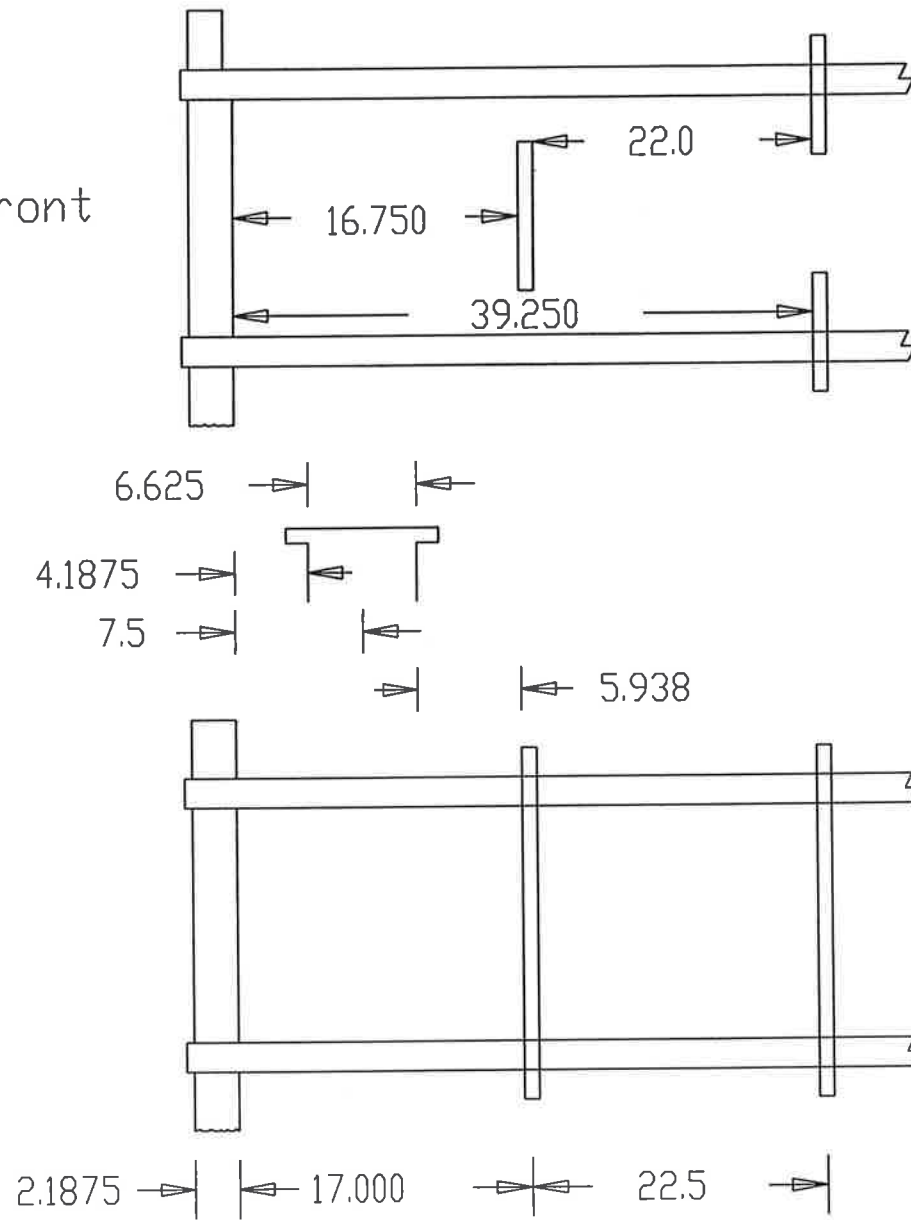
Scale: N.T.S.

Ref	No	Bolt Dia.	Bolt Length	Bolt Circle	Bolt Hole
103	108	.625	11	62.5	0.875
102	108	.625	9	62.875	0.875
Bolting					

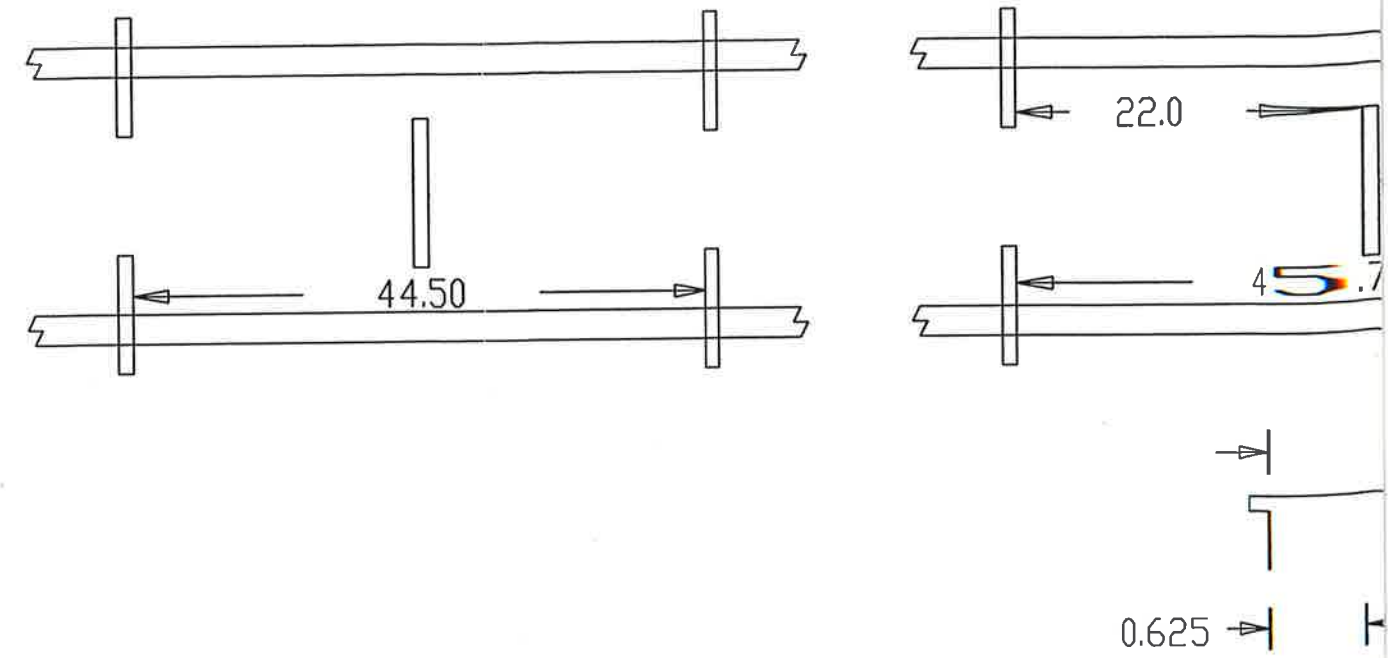
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2	8-9-07	General Revisions	JFS	DGR	PW	TEMA Type: NEM			
3	8-31-07	Revised as Noted	KFF	DGB	PW	Size: 59-360			
4	12-17-07	Certified As-Built	AGB	DGB	PW	TEMA Class: C			

Dimensions: in

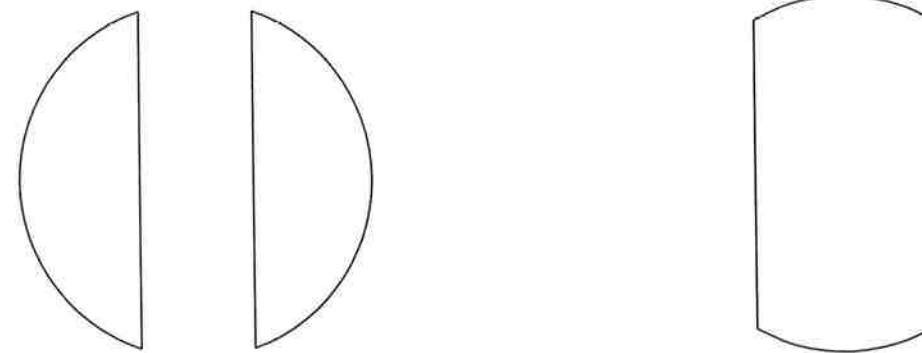
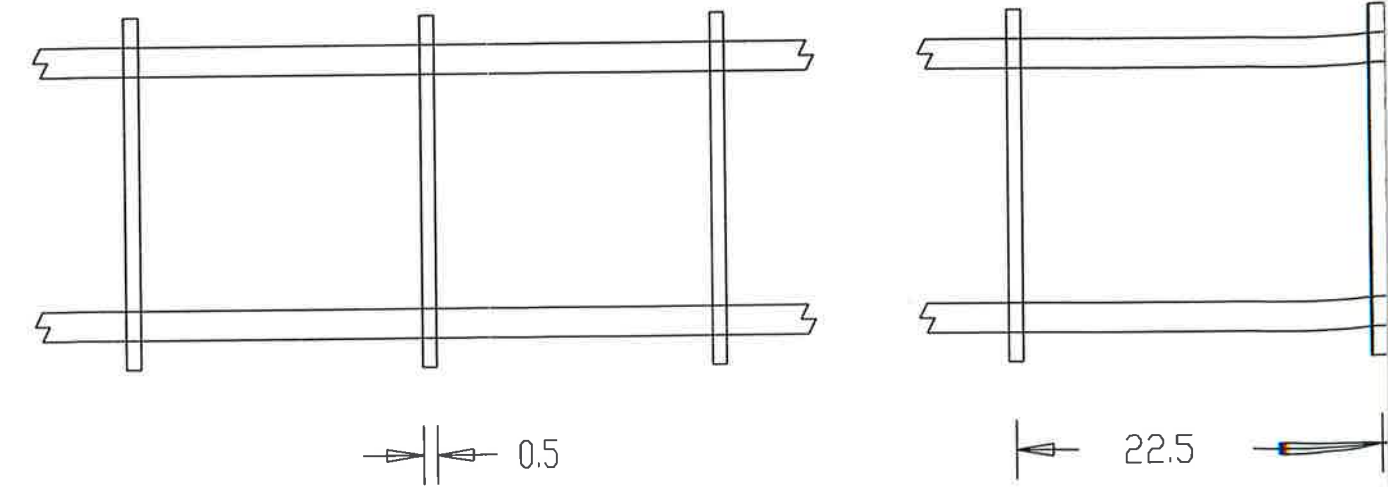
Front



Top View



Side View



Baffles

Notes:  
 All Dimensions In Inches  
 Bolt holes to straddle centerlines  
 Weld joint details per drawing 20

Company: D  
 Location: B  
 Beer Col: 4  
 Item No.: E  
 Date: Aug 2007

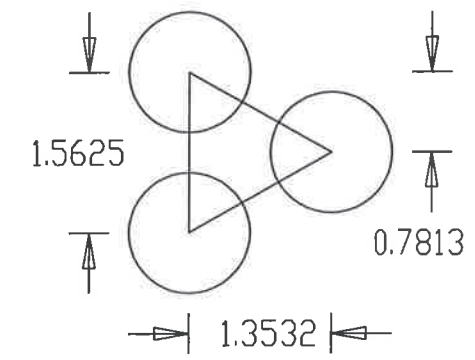
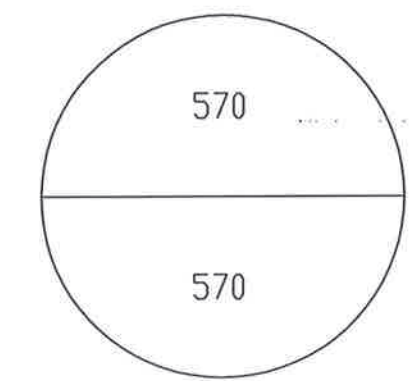
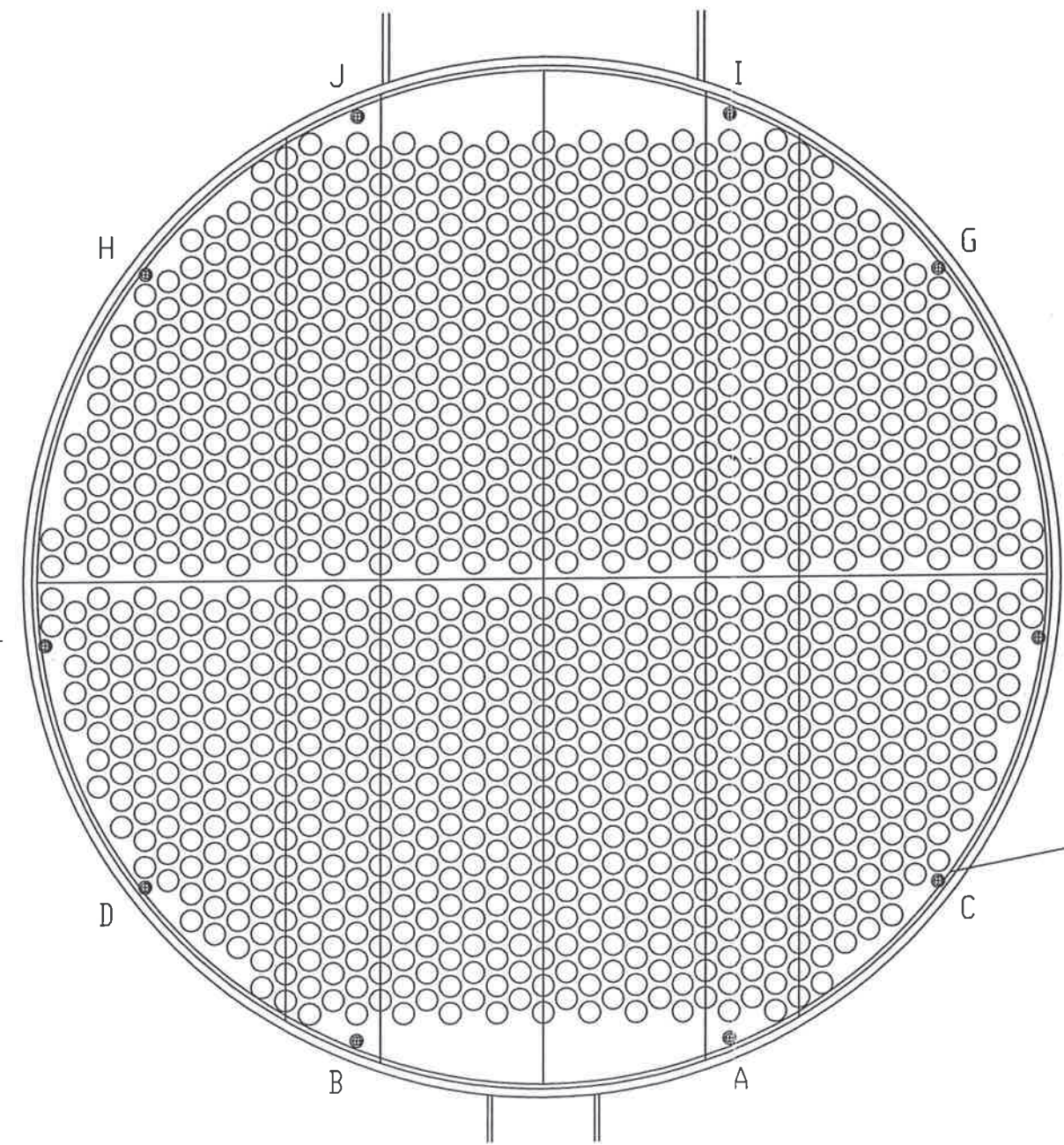
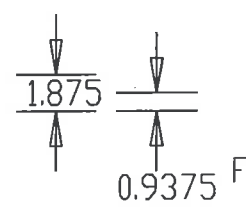
DC R

Scale: N.T.S.

Rev:	Date:	Description	Dwg	Ckd	Appd	ASME VIII-1
1	8-9-07	General Revisions	JFS	DGB	PW	TEMA Type: NE
2	8-31-07	Revised As Noted	KFF	DGB	PW	Size: 59-360
3	12-17-07	Certified As-Built	AGB	DGB	PW	TEMA Class: C

Shell ID 59.125 in  
 O.T.L. 58.563 in  
 Baffle cut to C/L 9.472 in  
 14.885 in

Row	Holes
64	11
63	12
62	13
61	12
60	13
59	14
58	15
57	16
56	15
55	16
54	17
53	18
52	17
51	18
50	19
49	18
48	19
47	20
46	19
45	20
44	19
43	20
42	21
41	20
40	21
39	20
38	21
37	21
36	21
35	22
34	21
33	22
32	22
31	21
30	22
29	21
28	20
27	21
26	20
25	21
24	20
23	21
22	20
21	19
20	20
19	19
18	20
17	19
16	18
15	19
14	18
13	17
12	18
11	17
10	16
9	15
8	16
7	15
6	14
5	13
4	12
3	13
2	12
1	11



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1140

1.120

Design Specifications		Tie Rod Locations	
Number of Tube Holes	1140	A	9.9527 -27.2719
Tube Outside Diameter	1.25 in	B	-9.9527 -27.2719
Tube Pitch	1.5625 in	C	23.3054 -17.311
Tube Pattern	Triangular	D	-23.3054 -17.311
Tube Passes	2	E	28.6298 -4.811
Number of Tie Rods	10	F	-28.6298 -4.811
Tie Rod Diameter	0.5 in	G	23.2566 17.3765
Baffle Diameter	58.8125 in	H	-23.2566 17.3765
Baffle Type	Double Segmental	I	12.6432 26.1336
Baffle Cut	32%	J	-12.6432 26.1336
Tube Thickness	0.065 in		

Notes:  
 All Dimensions In Inches  
 Bolt holes to straddle centerlines  
 Weld joint details per drawing 20

Scale:

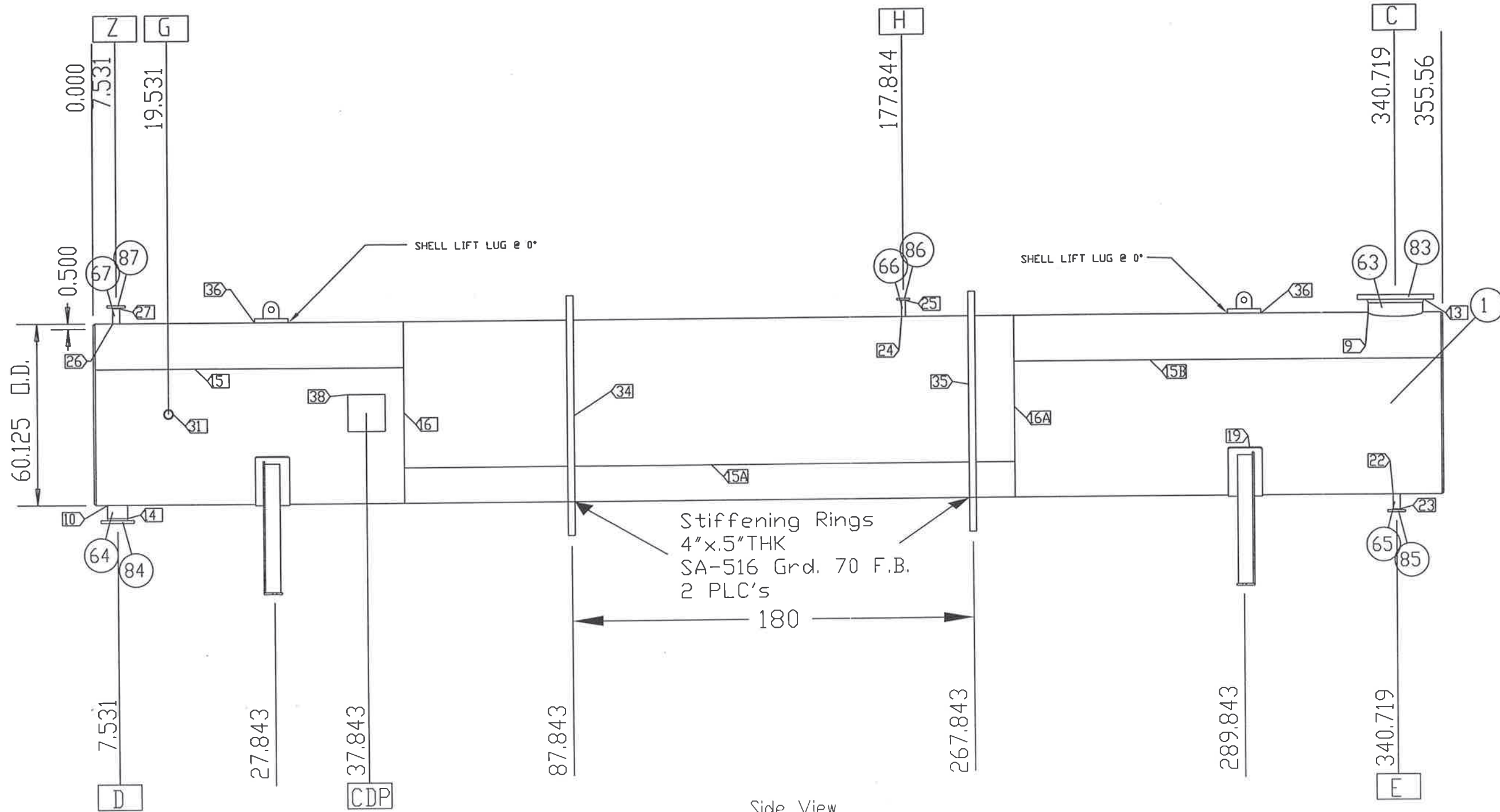
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1	8-9-07	General Revision	JFS	DGB	PW
2	12-17-07	Certified As-Built	AGB	DGB	PW

Company: DCR  
 Location: Bunge-Ergon  
 Beer Column Reboiler  
 Item No.: E4101  
 Date: Aug 9, 2007 Job No.: 7793

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 NEM Lakeland, Florida

ASME VIII-1 2004 A06	Tube Layout
TEMA Type: NEM	
Size: 59-360	
TEMA Class: C	

Dwg No.: E-4101 05	Rev: 2
--------------------	--------



Side View

Notes:  
 All Dimensions In Inches  
 Bolt holes to straddle centerlines  
 Weld joint details per drawing 20

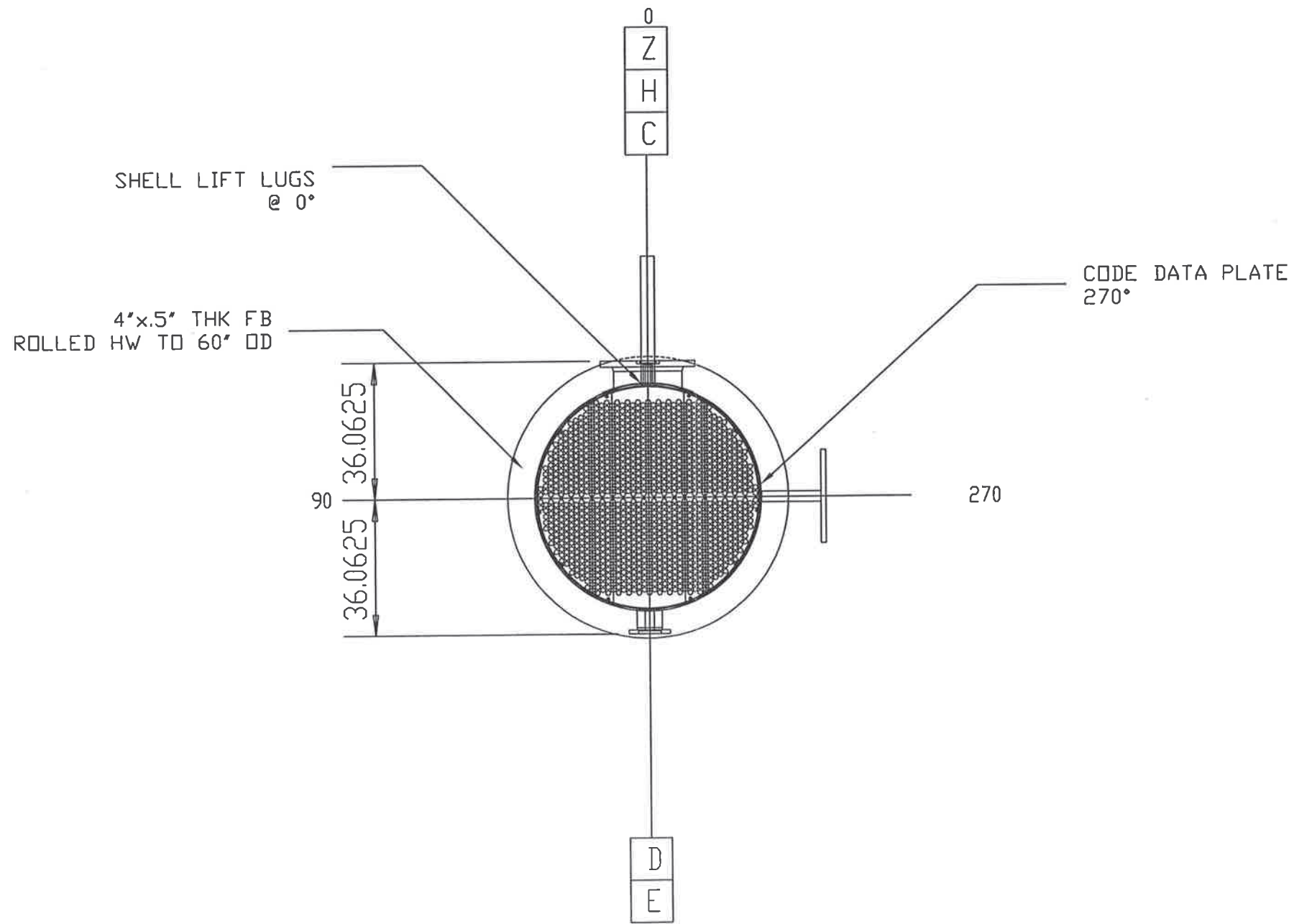
Company: DCR  
 Location: Bunge-Ergon  
 Beer Column Reboiler  
 Item No.: E-4101  
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 Lakeland, Florida

Scale: 1: NTS						ASME VIII-1 2004 A06		Shell Detail	
Rev:	Date:	Description	Dwg	Ckd	Appd	TEMA Type: NEM			
1	8-9-07	General Revision	JFS	DGB	PW	Size: 59-360		Dwg No.: E-4101 06A	Rev: 3
2	8-31-07	Revised As Noted	KFF	DGB	PW	TEMA Class: C			
3	12-17-07	Certified As-Built	AGB	DGB	PW				



180  
Front End View Looking South

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Notes:  
All Dimensions In Inches  
Bolt holes to straddle centerlines  
Weld joint details per drawing 20

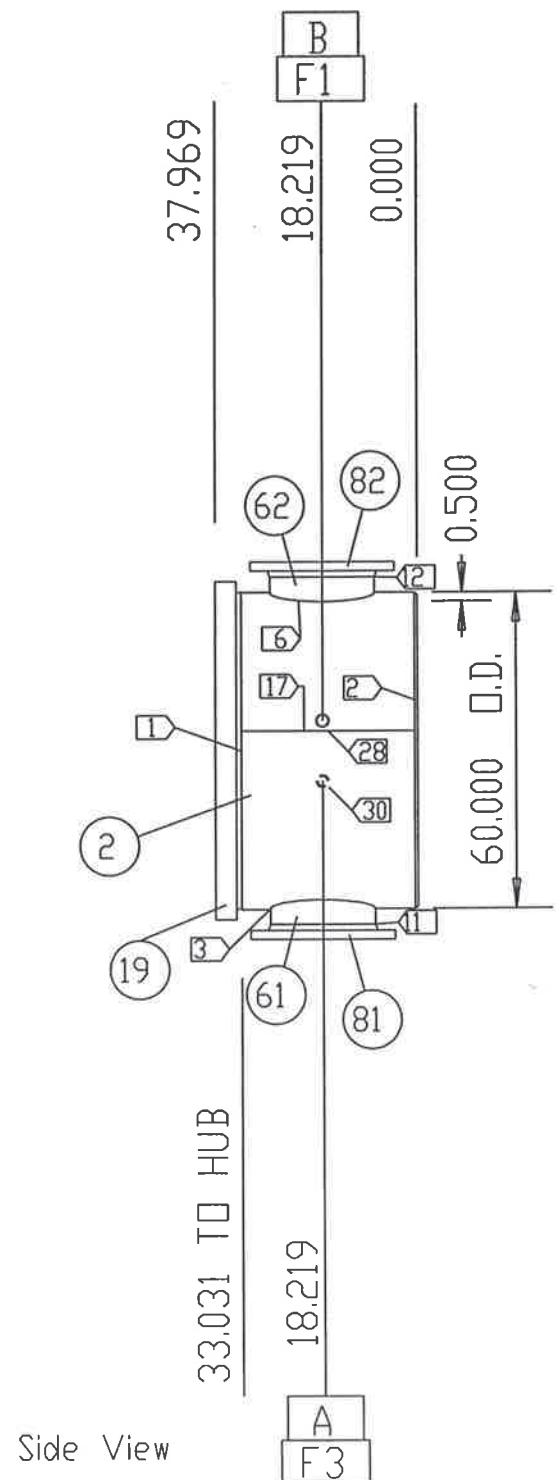
Company: DCR  
Location: Bunge-Ergon  
Beer Column Reboiler  
Item No: E-4101  
Date: August 9, 2007 Job No: 7793

DCR Construction, Inc.  
Lakeland, Florida

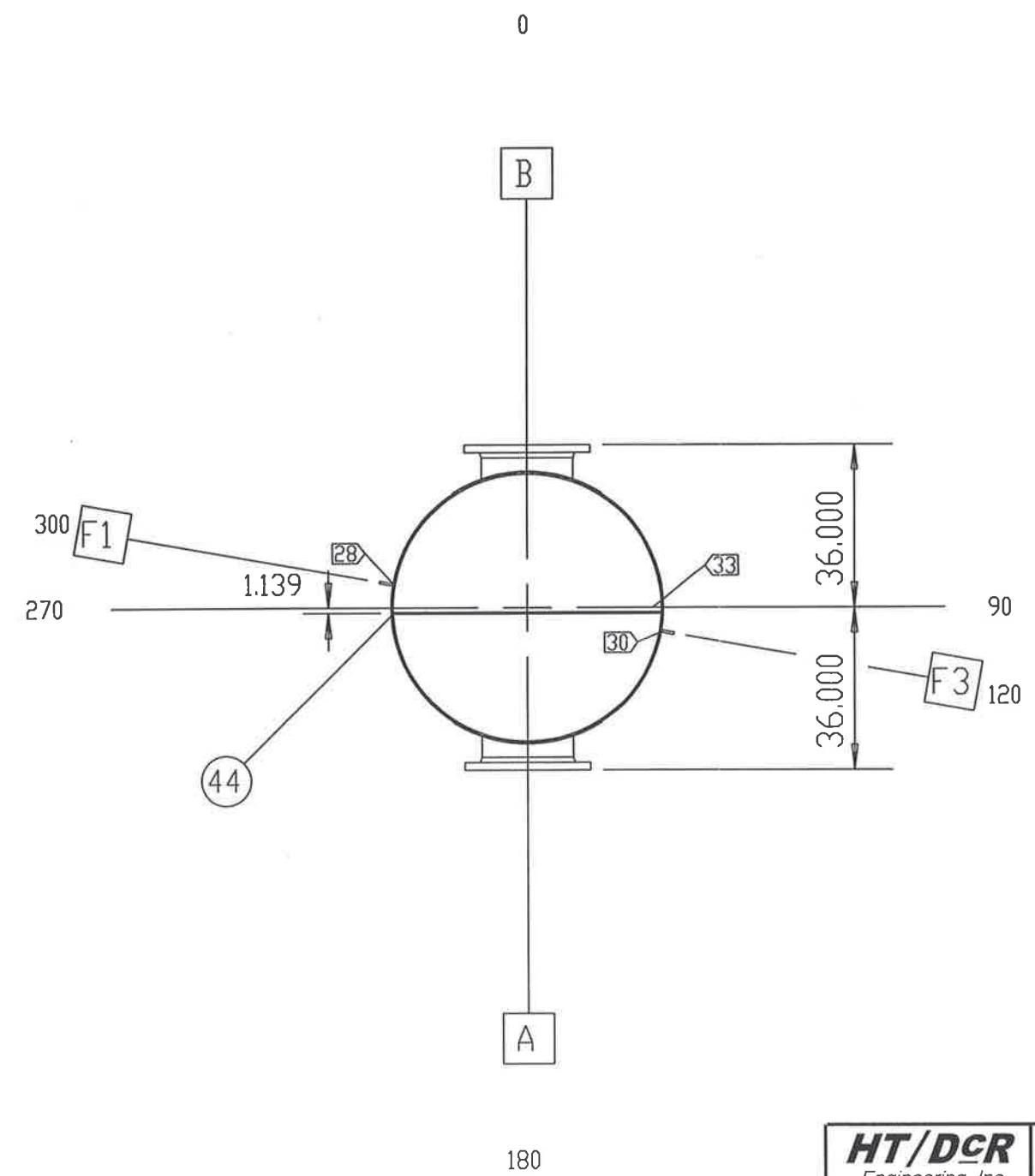
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Rev:	Date:	Description	Dwg	Ckd	Appd	ASME VIII-1 2004 A06	Shell Detail	Dwg No: E-4101 06B	Rev: 2
1	8-9-07	General Revision	JFS	DGB	PW	TEMA Type: NEM			
2	12-17-07	Certified As-Built	AGB	DGB	PW	Size: 59-360 TEMA Class: C			





Side View



Rear End View (Looking South)

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Notes:  
All Dimensions In Inches  
Bolt holes to straddle centerlines  
Weld joint details per drawing 20

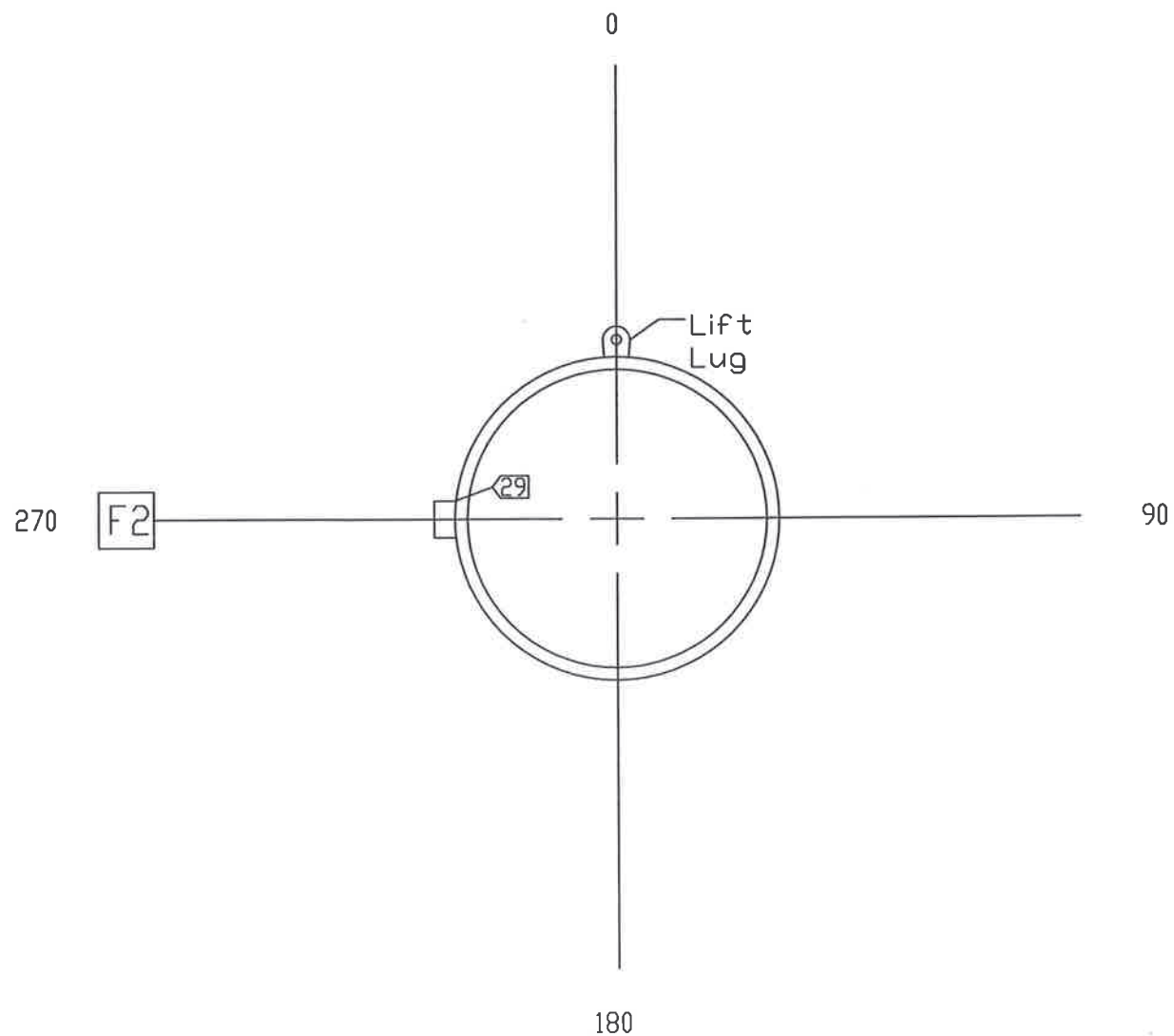
Company: DCR  
Location: Bunge-Ergon  
Beer Column Reboiler  
Item No: E-4101  
Date: August 9, 2007 Job No: 7793

DCR Construction, Inc.  
Lakeland, Florida

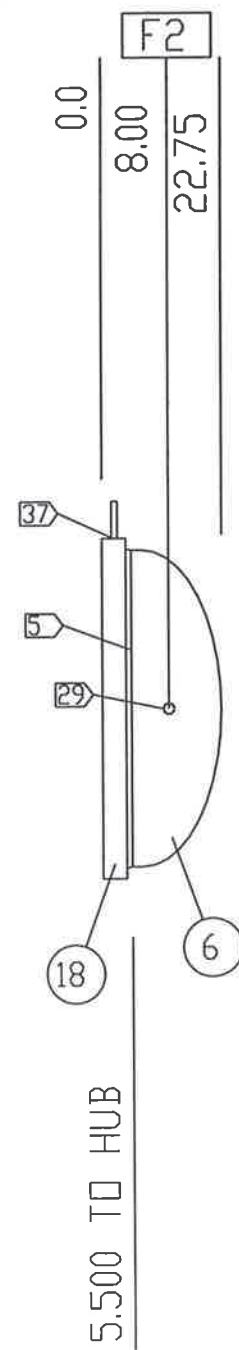
Scale: NTS

Rev:	Date:	Description	Dwg	Ckd	Appd
1	8-9-07	General Revision	JFS	DGB	PW
2	8-31-07	Revised As Noted	KFF	DGB	PW
3	12-17-07	Certified As-Built	AGB	DGB	PW

ASME VIII-1 2004 A06	Front Head Detail
TEMA Type: NEM	
Size: 59-360	
TEMA Class: C	Dwg No: E-4101 08
	Rev: 3



Front End View (Looking North)



Side View

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Florida Engineering Business License No. 26522

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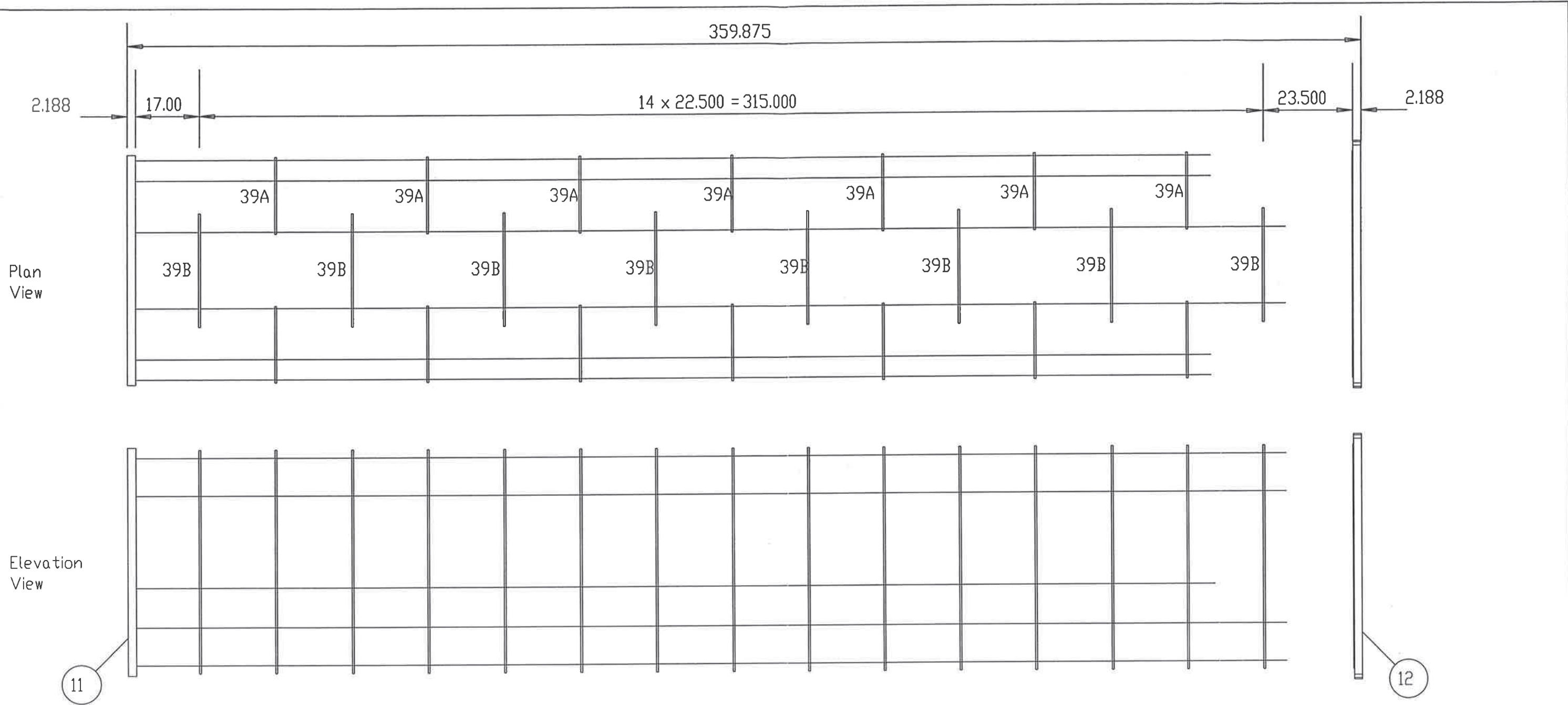
Notes:  
All Dimensions In Inches  
Bolt holes to straddle centerlines  
Weld joint details per drawing 20

Company: DCR  
Location: Bunge-Ergon  
Beer Column Reboiler  
Item No: E-4101  
Date: August 9, 2007 Job No: 7793

DCR Construction, Inc.  
Lakeland, Florida

Scale: 1: NTS

Rev:	Date:	Description	Dwg	Ckd	Appd	ASME VIII-1 2004 A06	Rear Head Detail	
1	8-9-07	General Revision	JFS	DGB	PW	TEMA Type: NEM	Dwg No: E-4101 09	Rev: 3
2	8-31-07	Revised As Noted	KFF	DGB	PW	Size: 59-360		
3	12-17-07	Certified As-Built	AGB	DGB	PW	TEMA Class: C		



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For Spacers:  
 Use  $\frac{3}{4}$ " (.109" wall) SA-214  
 K01807 Wld. Tube

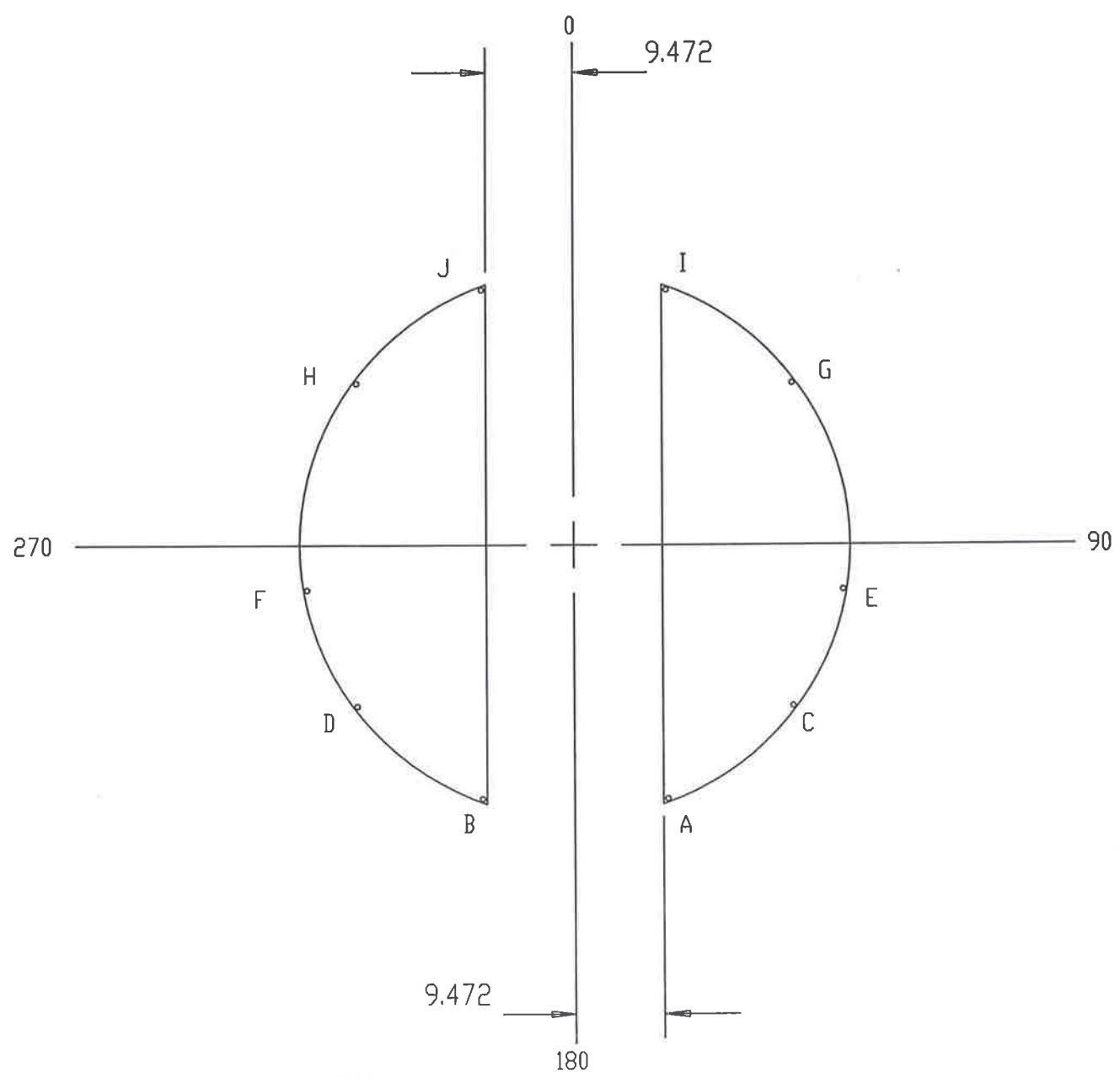
# of Spacers	Length (in.)
4	16.625
6	39.125
42	44.5
56	22

Notes:  
 All Dimensions In Inches  
 Bolt holes to straddle centerlines  
 Weld joint details per drawing 20

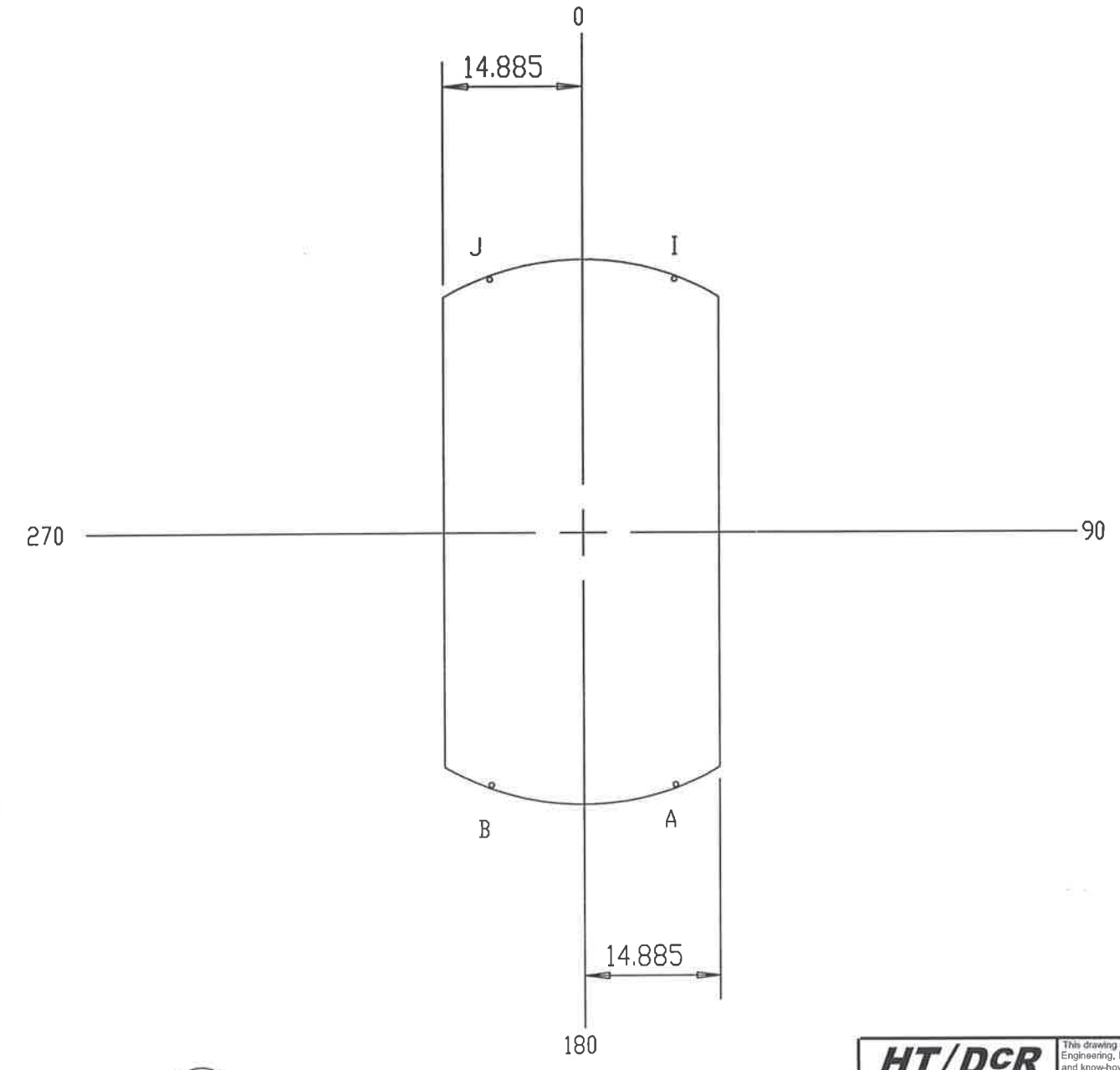
Company: DCR  
 Location: Bunge-Ergon  
 Beer Column Reboiler  
 Item No.: E-4101  
 Date: August 9, 2007 Job No.: 7793

DCR Construction, Inc.  
 Lakeland, Florida

Scale: 1: NTS							ASME VIII-1 2004 A06	Bundle Detail	Dwg No.: E-4101 11	Rev: 3
Rev:	Date:	Description	Dwg	Ckd	Appd	TEMA Type: NEM				
1	8-9-07	General Revision	JFS	DGB	PW	Size: 59-360				
2	8-31-07	Revised As Noted	KFF	DGB	PW	TEMA Class: C				
3	12-17-07	Certified As-Built	AGB	DGB	PW					



39 A 7 Baffles 58.813 O.D. 0.500 Tk



39 B 8 Baffles 58.813 O.D. 0.500 Tk

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Phone: 863-904-2880 • Fax: 863-915-1091  
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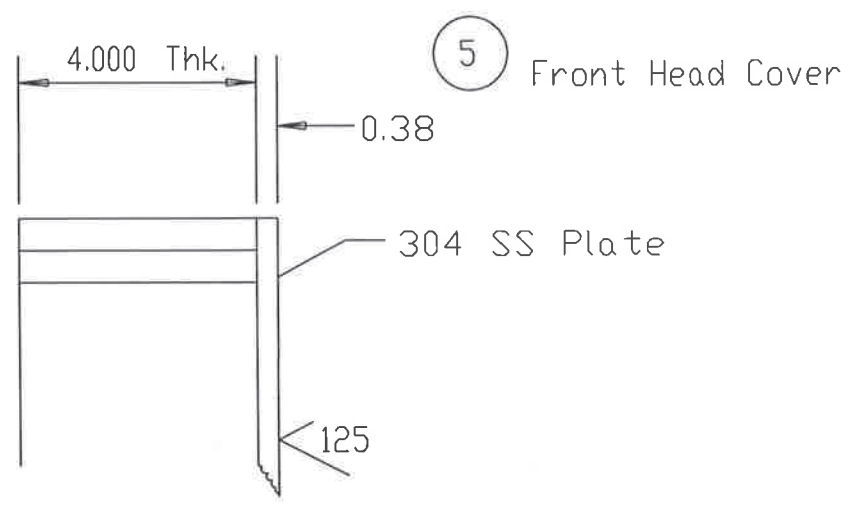
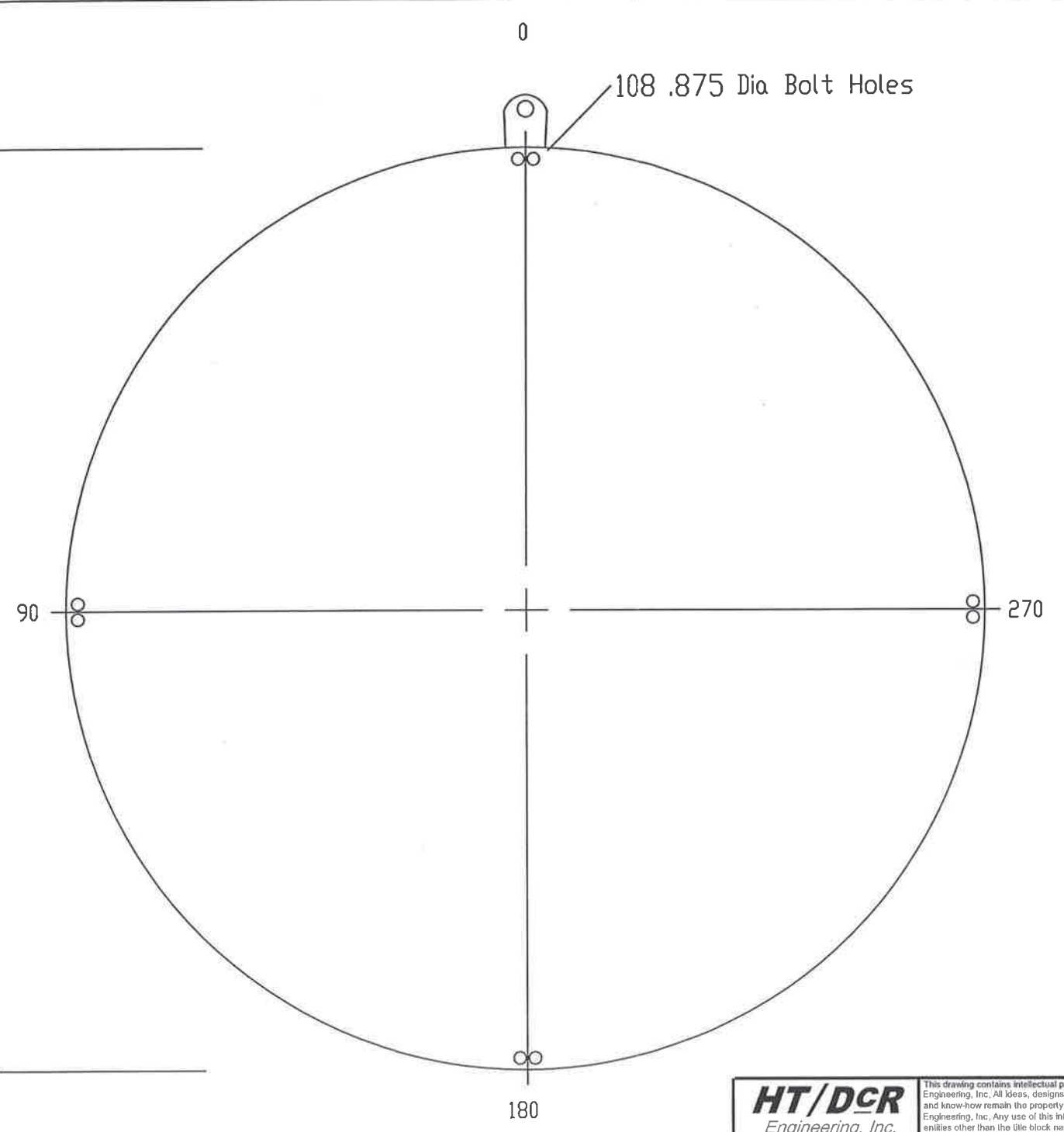
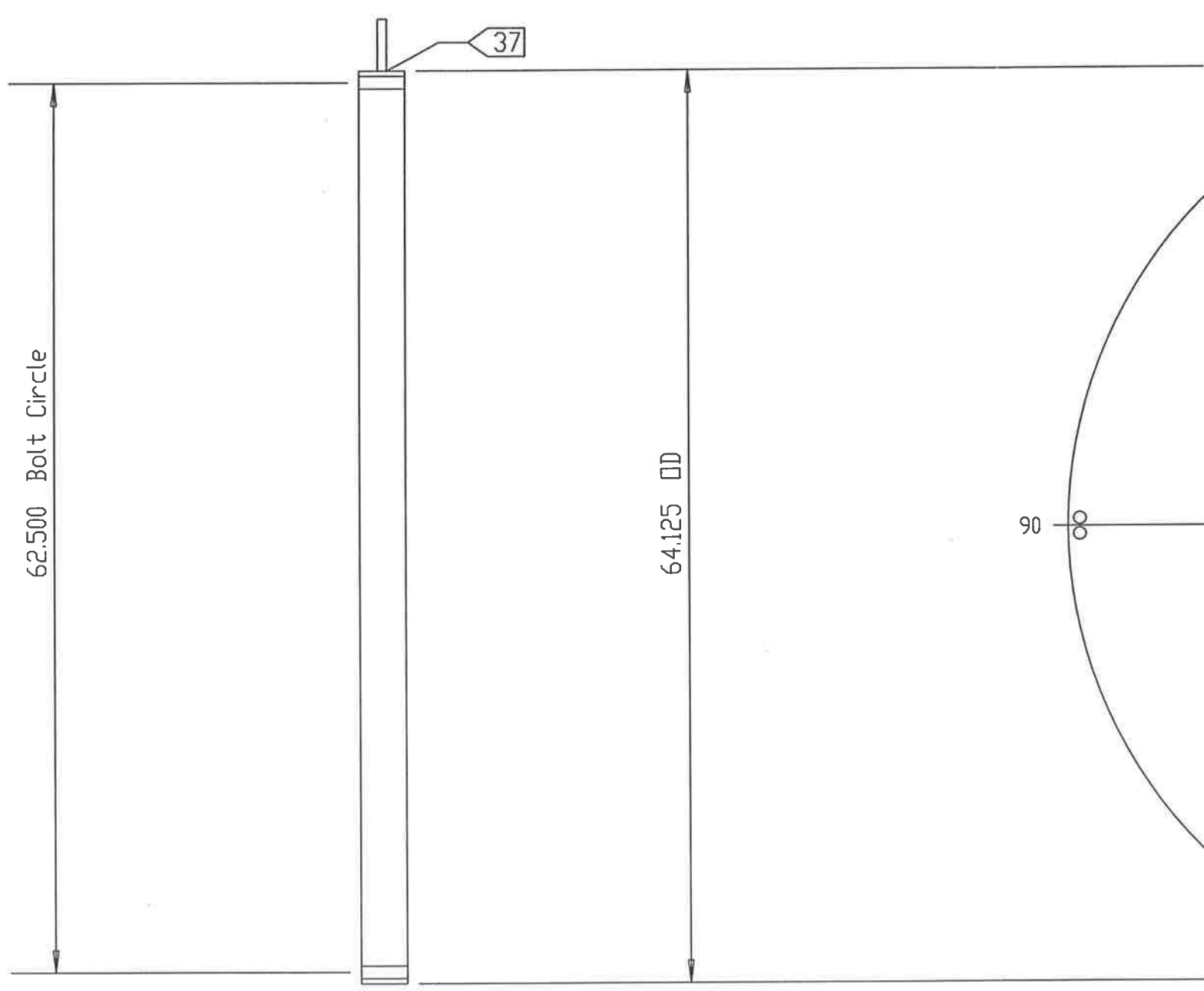
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Notes:  
All Dimensions In Inches  
Weld joint details per drawing 20

Company: DCR  
Location: Bunge-Ergon  
Beer Column Reboiler  
Item No: E-4101  
Date: August 9, 2007 Job No: 7793

DCR Construction, Inc.  
Lakeland, Florida

Scale: 1: NTS							ASME VIII-1 2004 A06	Baffle Detail
Rev:	Date:	Description	Dwg	Ckd	Appd	TEMA Type: NEM		
1	8-9-07	General Revisions	JFS	DGB	PW	Size: 59-360	Dwg No: E-4101 12	
2	12-17-07	Certified As-Built	AGB	DGB	PW	TEMA Class: C		
							Rev:	2



5 Front Head Cover

Rear End View (Looking South)

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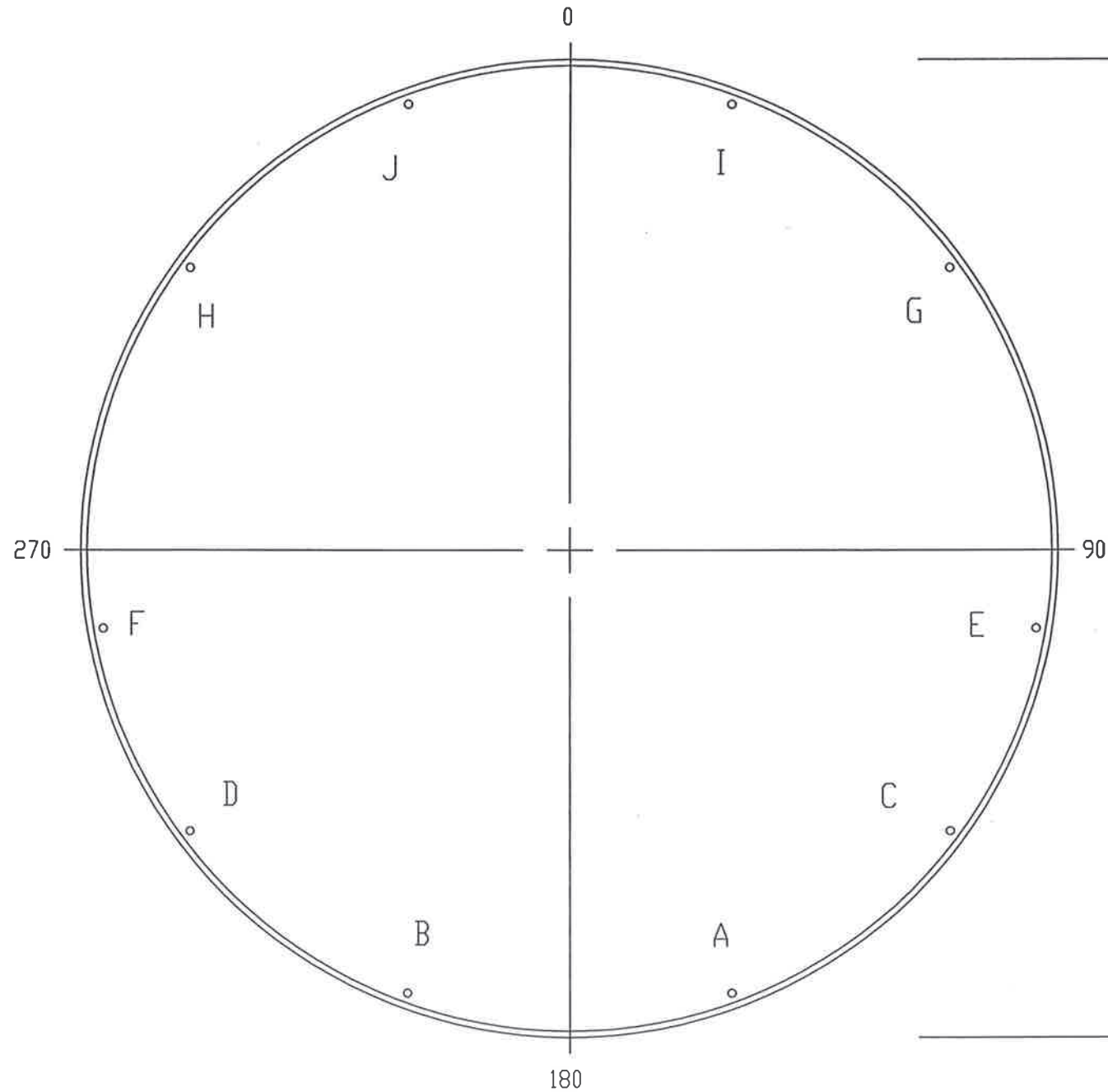
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Notes:  
All Dimensions In Inches  
Bolt holes to straddle centerlines

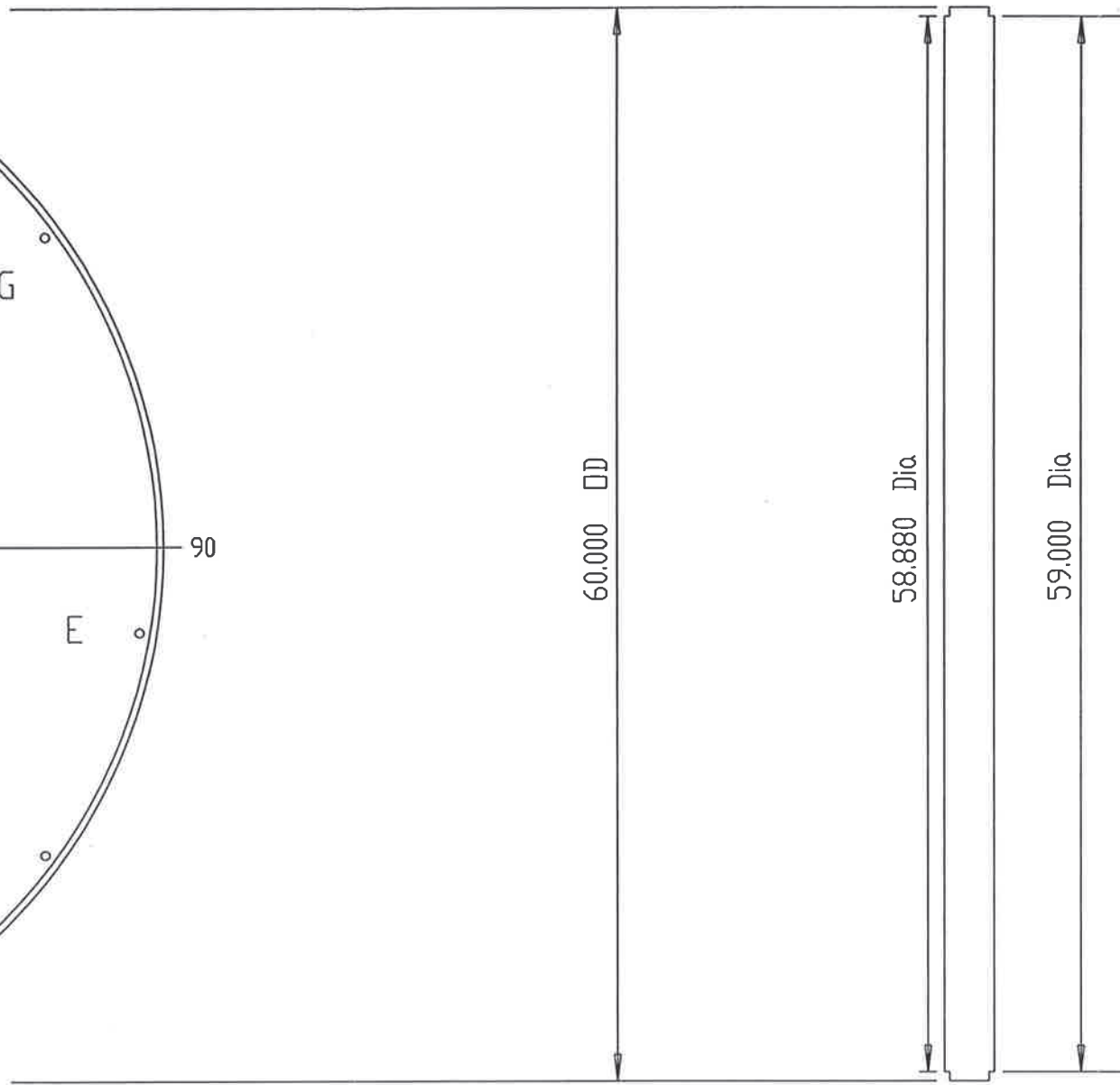
Company: DCR  
Location: Bunge-Ergon  
Beer Column Reboiler  
Item No.: E-4101  
Date: August 9, 2007 Job No.: 7793

DCR Construction, Inc.  
Lakeland, Florida

Scale: 1: NTS						ASME VIII-1 2004 A06	Flat Cover Detail	Dwg No: E-4101 13	Rev: 3
Rev:	Date:	Description	Dwg	Ckd	Appd	TEMA Type: NEM			
1	8-9-07	General Revisions	JFS	DGB	PW	Size: 59-360			
2	8-31-07	General Revisions	JFS	DGB	PW	TEMA Class: C			
3	12-17-07	Certified As-Built	AGB	DGB	PW				



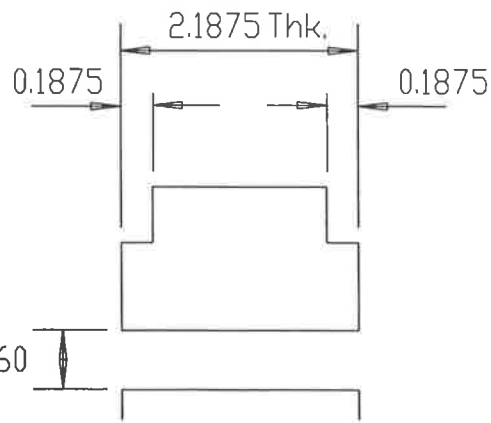
Front End View  
(Looking North)



11 Front TubSh

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2838 Parkway Street • Lakeland, FL 33811  
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Notes:  
All Dimensions In Inches  
Bolt holes to straddle centerlines

Company: DCR  
Location: Bunge-Ergon  
Beer Column Reboiler  
Item No.: E-4101  
Date: August 9, 2007 Job No.: 7793

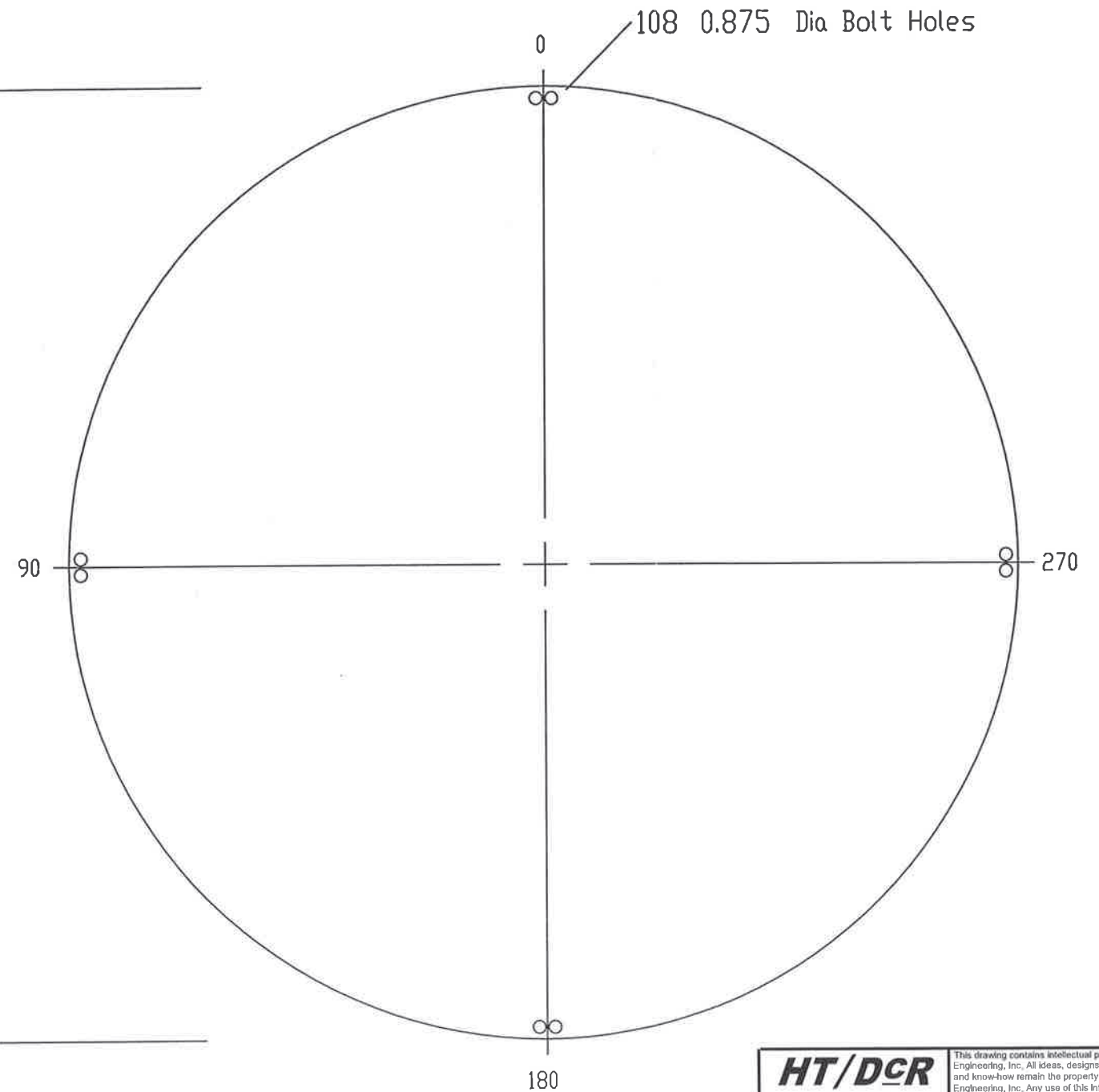
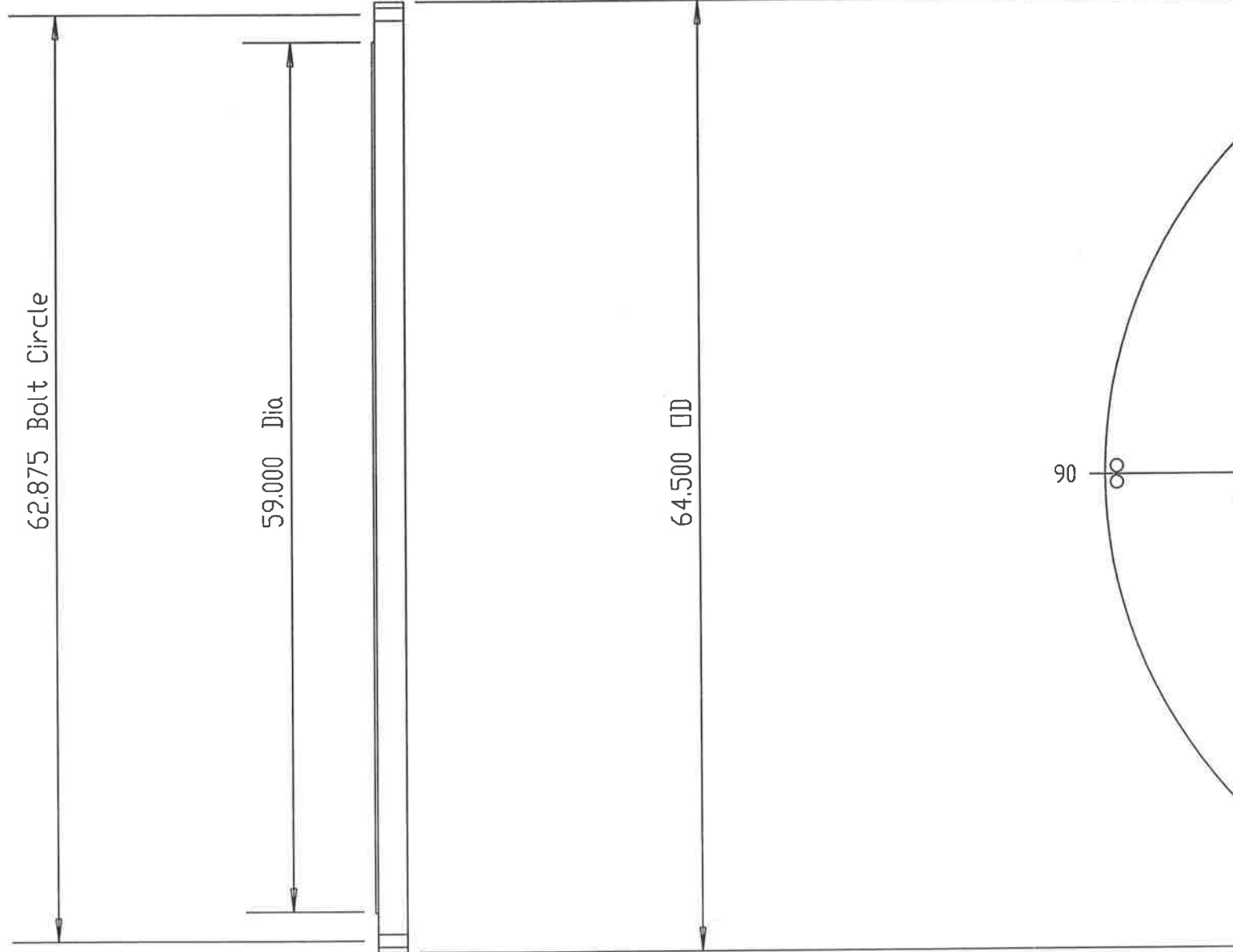
DCR Construction, Inc.  
Lakeland, Florida

Scale: NTS

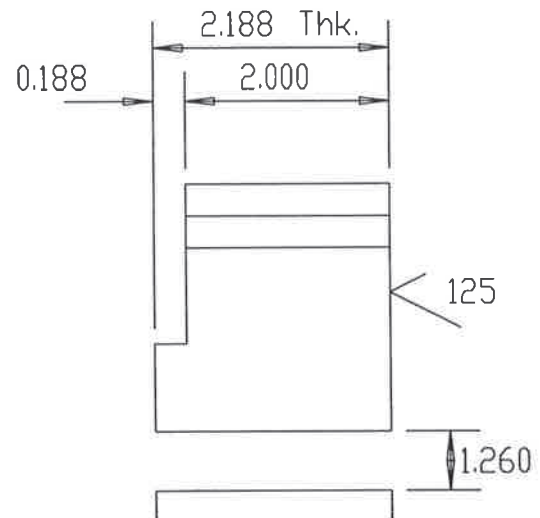
Rev:	Date:	Description	Dwg	Ckd	Appd
1	8/09/07	General Revision	JFS	DGB	PW
2	12/17/07	Certified As-Built	AGB	DGB	PW

ASME VIII-1 2004 A06  
TEMA Type: NEM  
Size: 59-360  
TEMA Class: C

Tubesheet Detail  
Dwg No.: E-4101 14  
Rev: 2



12 Rear TubSh



180 Rear End View

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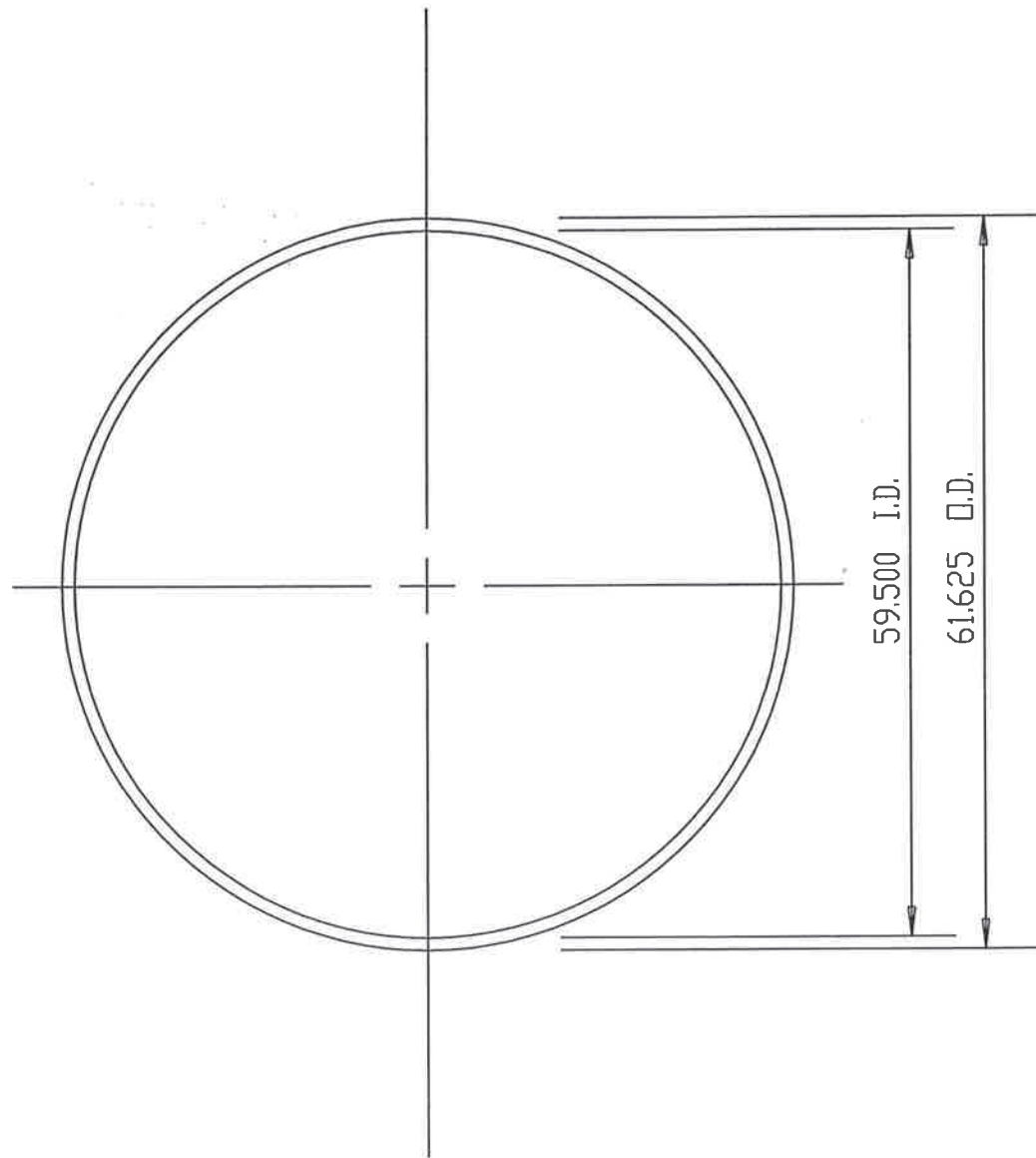
Notes:  
All Dimensions In Inches  
Bolt holes to straddle centerlines

Company: DCR  
Location: Bunge-Ergon  
Beer Column Reboiler  
Item No: E-4101  
Date: August 9, 2007 Job No: 7793

DCR Construction, Inc.  
Lakeland, Florida

Scale: NTS

Rev:	Date:	Description	Dwg	Ckd	Appd	ASME VIII-1 2004 A06	Tubesheet Detail	Rev:
1	8/9/07	General Revisions	JFS	DGB	PW	TEMA Type: NEM	Dwg No: E-4101 15	2
2	12/17/07	Certified As-Built	AGB	DGB	PW	Size: 59-360 TEMA Class: C		



32 RearHead Gaskets at Tbshts

0.125 Thk.

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Notes:  
All Dimensions In Inches  
Bolt holes to straddle centerlines

Company: DCR  
Location: Bunge-Ergon  
Beer Column Reboiler  
Item No.: E-4101  
Date: August 9, 2007 Job No.: 7793

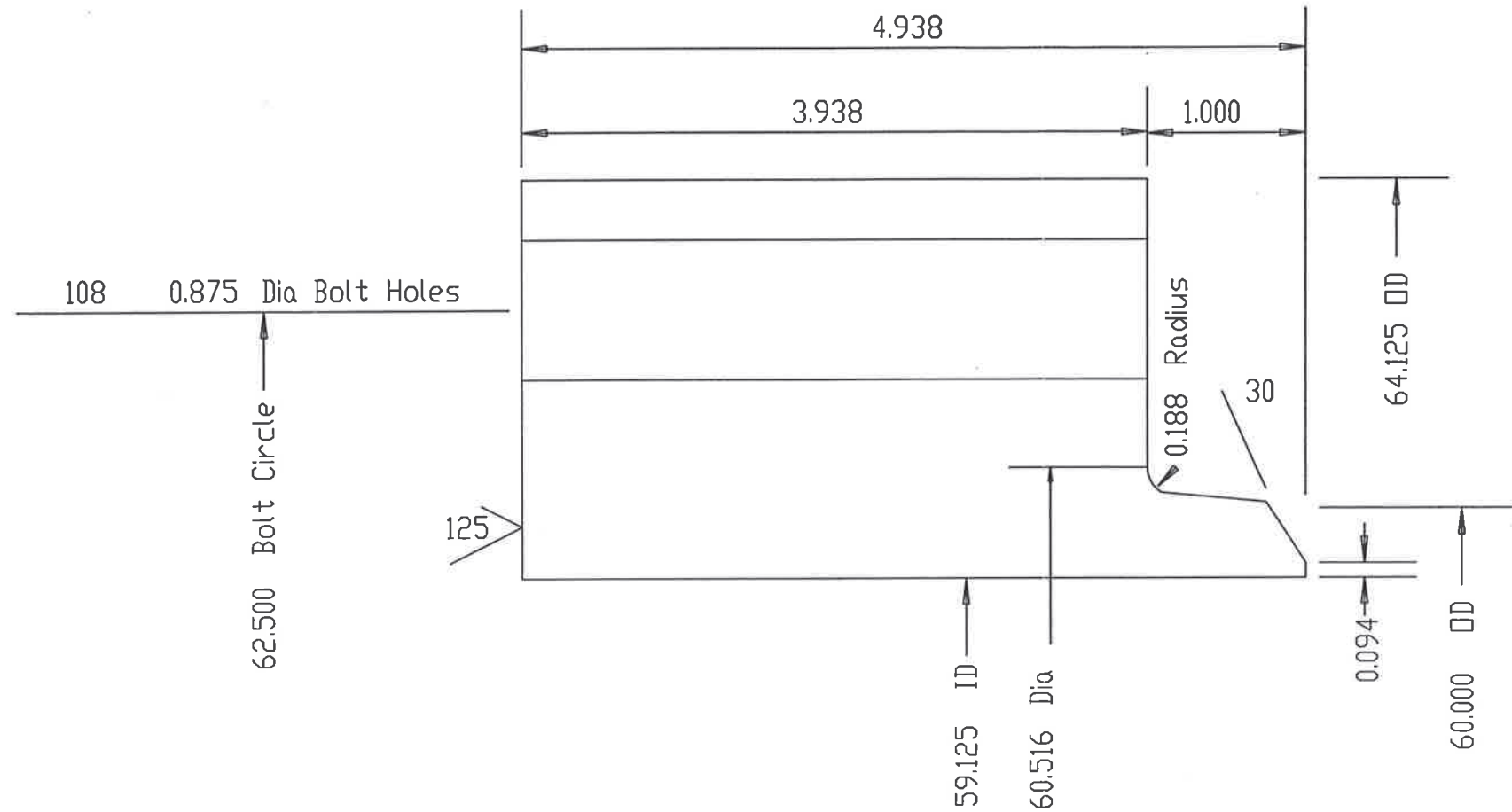
DCR Construction, Inc.  
Lakeland, Florida

Scale: NTS

Rev:	Date:	Description	Dwg	Ckd	Appd	ASME VIII-1 2004 A06	Gasket Detail	Dwg No: E-4101 17B	Rev: 2
1	8/9/07	General Revisions	JFS	DGB	PW	TEMA Type: NEM			
2	12/17/07	Certified As-Built	AGB	DGB	PW	Size: 59-360 TEMA Class: C			







19

Fr Hd Flng Cover

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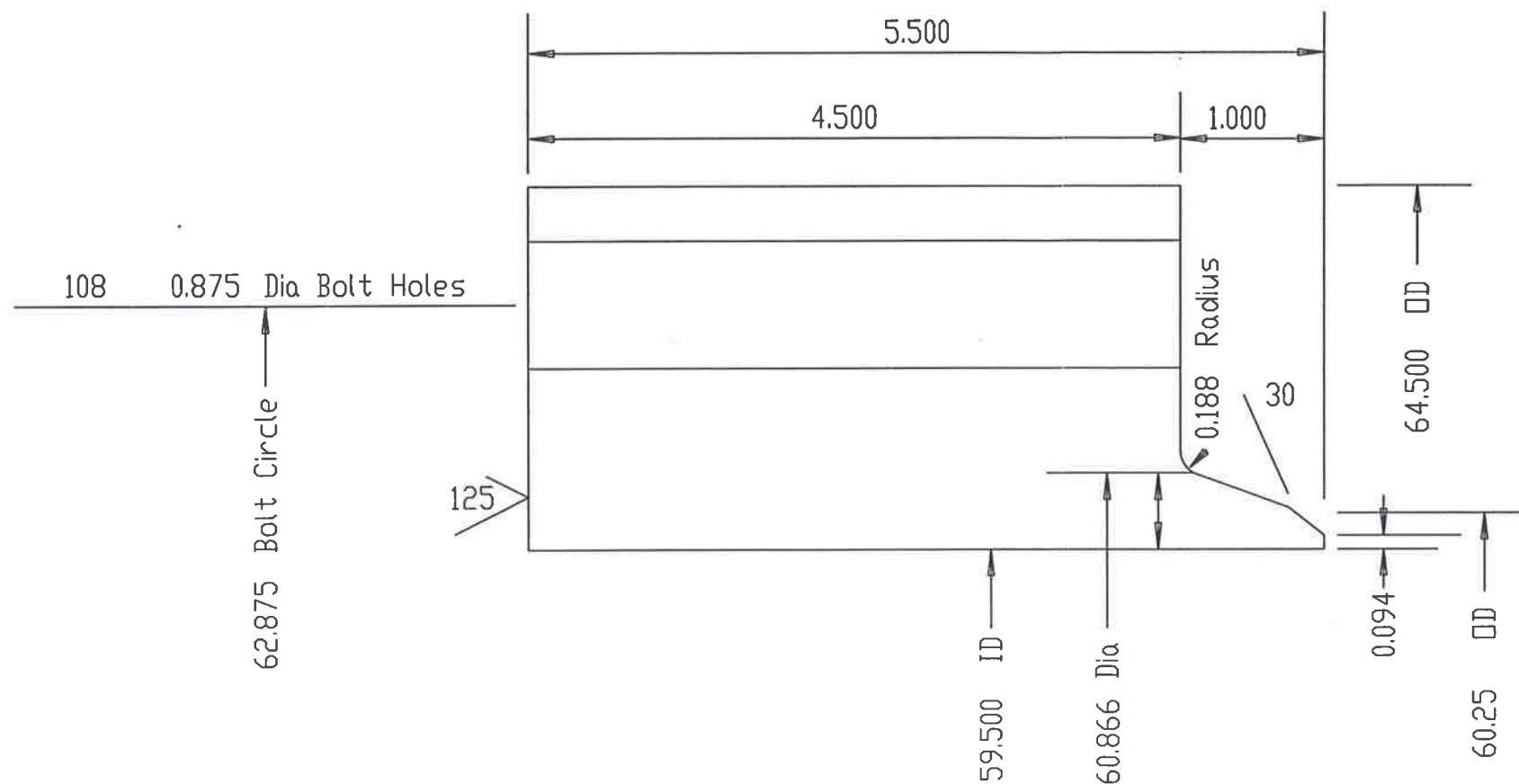
Notes:  
All Dimensions In Inches  
Bolt holes to straddle centerlines

Company: DCR  
Location: Bunge-Ergon  
Beer Column Reboiler  
Item No.: E-4101  
Date: August 9, 2007 Job No.: 7793

DCR Construction, Inc.  
Lakeland, Florida

Scale: NTS

Rev:	Date:	Description	Dwg	Ckd	Appd	ASME VIII-1 2004 A06	Flange Detail	Rev:
2	8/19/07	General Revisions	JFS	DGB	PW	TEMA Type: NEM	Dwg No.: E-4101 18A	4
3	8/31/07	Revised as Noted	JFS	DGB	PW	Size: 59-360		
4	12/17/07	Certified As-Built	AGB	DGB	PW	TEMA Class: C		



18 Re Hd Flng TubSh

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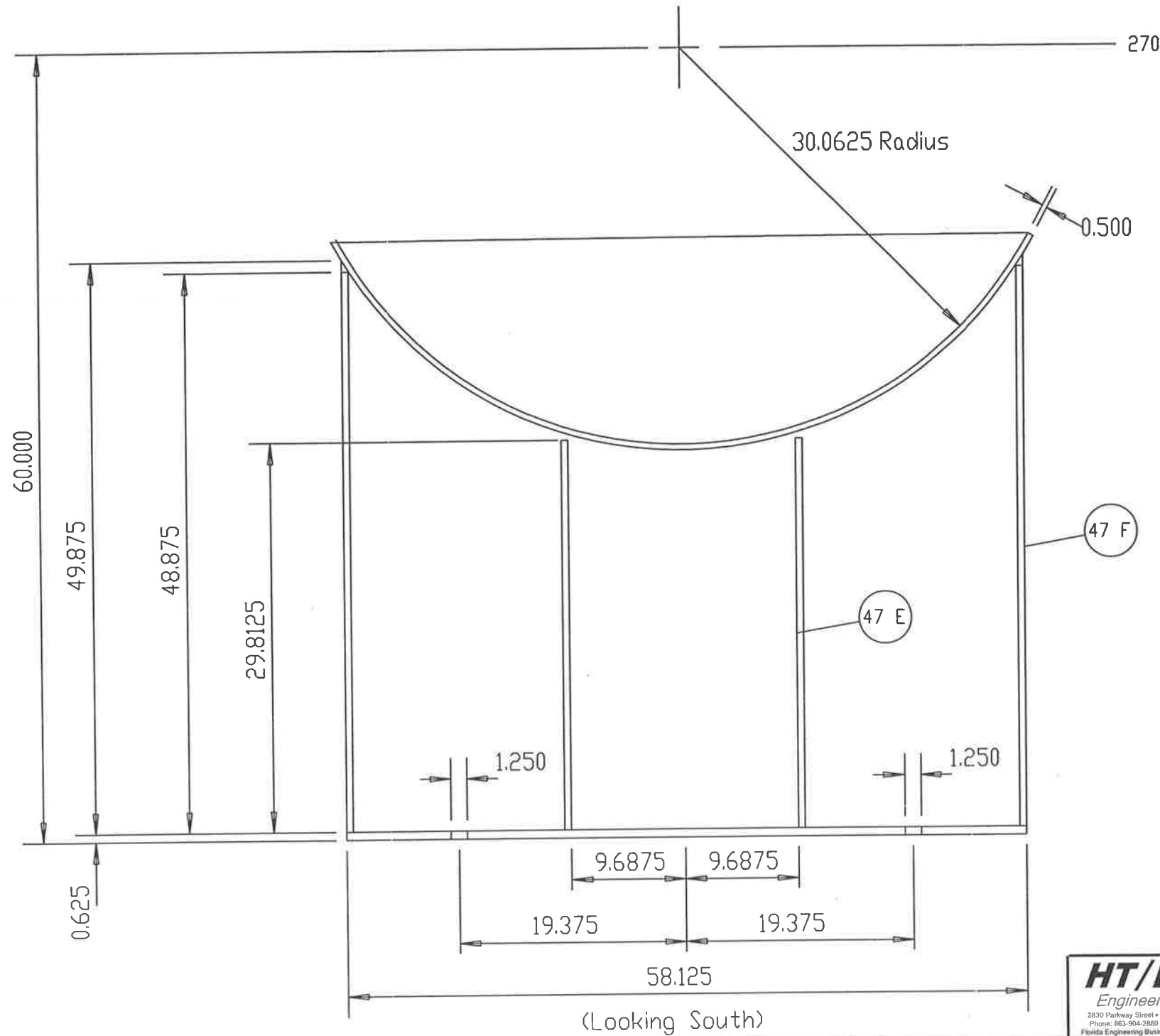
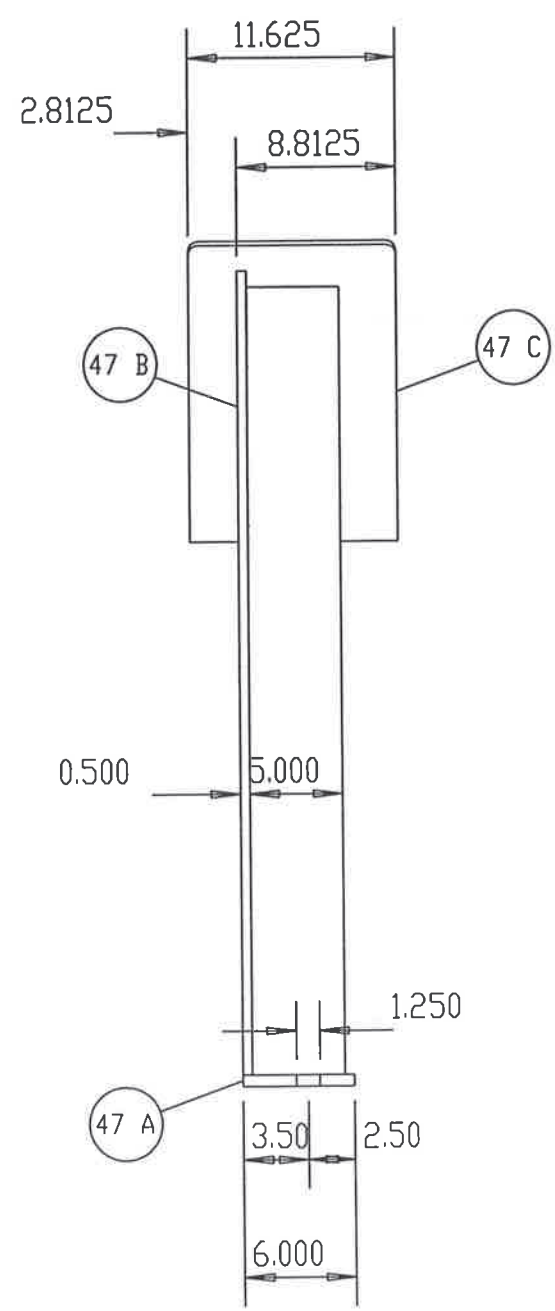
Notes:  
All Dimensions In Inches  
Bolt holes to straddle centerlines

Company: DCR  
Location: Bunge-Ergon  
Beer Column Reboiler  
Item No: E-4101  
Date: August 9, 2007 Job No: 7793

DCR Construction, Inc.  
Lakeland, Florida

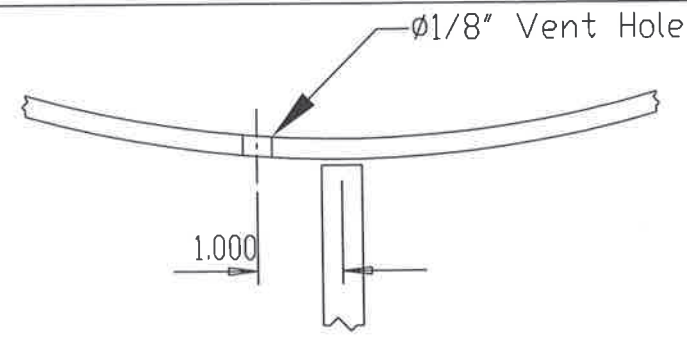
Scale: NTS

Rev:	Date:	Description	Dwg	Ckd	Appd	ASME VIII-1 2004 A06	Flange Detail	Rev:
2	8/19/07	General Revisions	JFS	DGB	PW	TEMA Type: NEM	Dwg No: E-4101 18B	4
3	8/31/07	Revised as Noted	JFS	DGB	PW	Size: 59-360		
4	12/17/07	Certified As-Built	AGB	DGB	PW	TEMA Class: C		

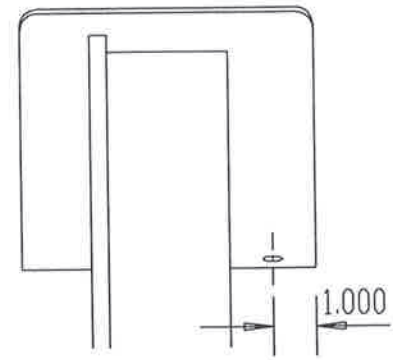


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Front View  
Vent Hole Detail (Not to Scale)



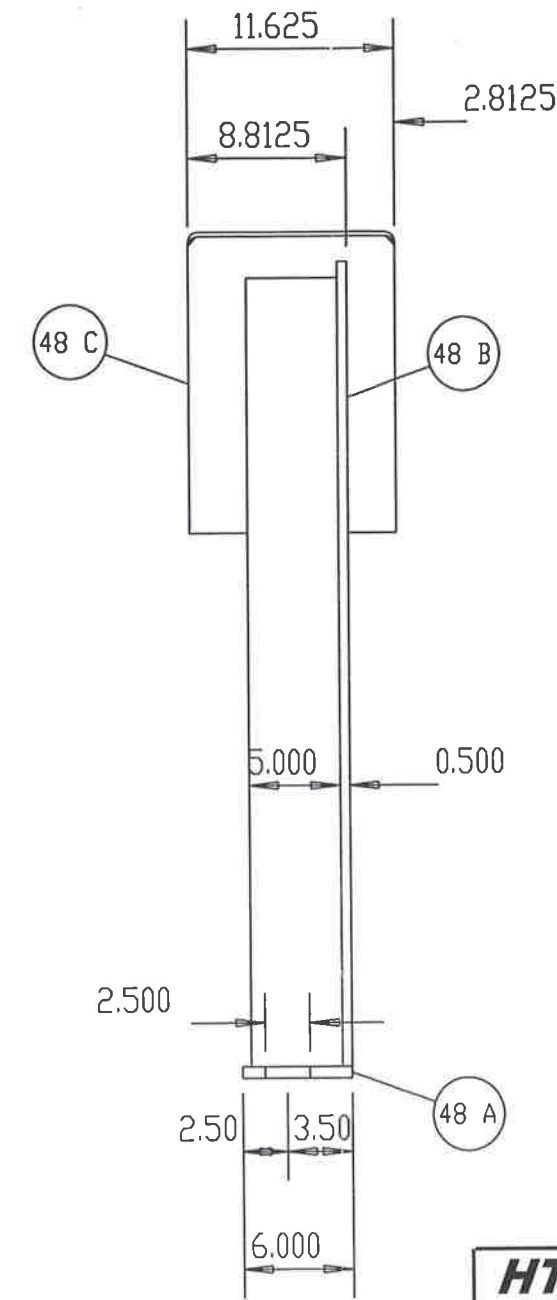
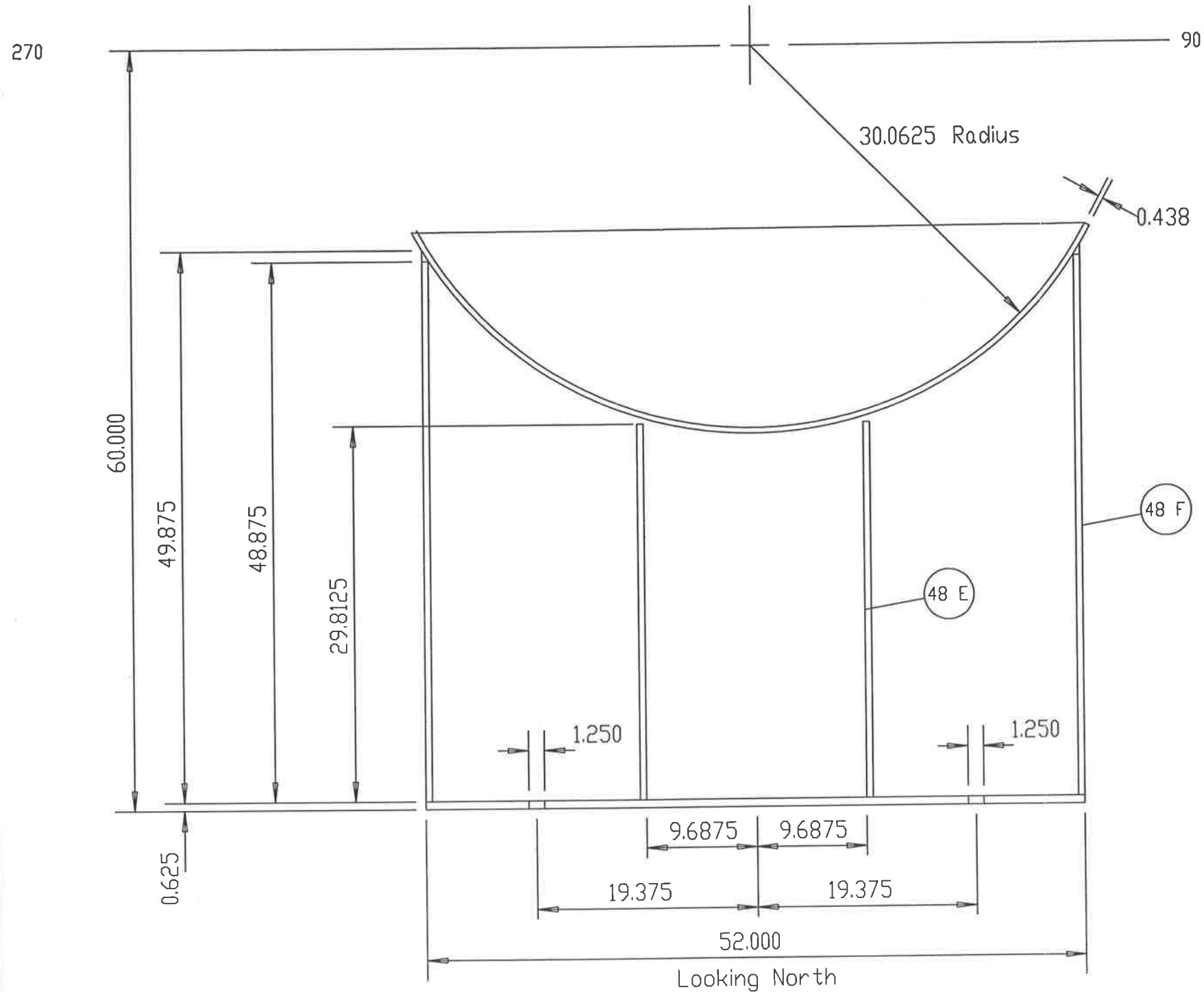
Side View

Notes:  
All Dimensions In Inches

Company: DCR  
Location: Bunge-Ergon  
Beer Column Reboiler  
Item No.: E-4101  
Date: February 26, 2007 Job No.: 7793

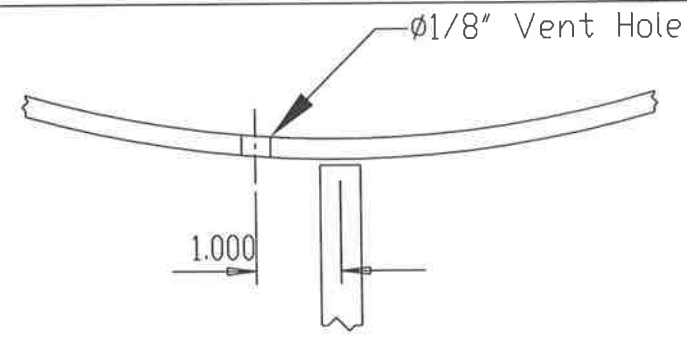
DCR Construction, Inc.  
Lakeland, Florida

Scale: NTS						ASME VIII-1 2004 A06		Front Support Detail	
Rev:	Date:	Description	Dwg	Ckd	Appd	TEMA Type: NEM		Dwg No.: E-4101 19A	
1	8/9/07	General Revisions	JFS	DGB	PW	Size: 59-360			
2	12/17/07	Certified As-Built	AGB	DGB	PW	TEMA Class: C		Rev: 2	

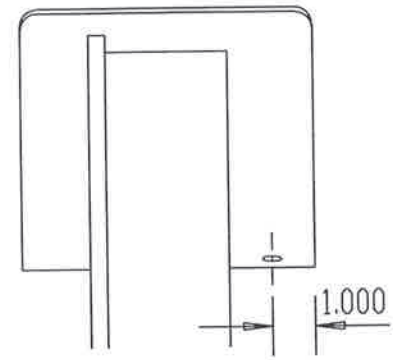


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Front View  
Vent Hole Detail (Not to Scale)



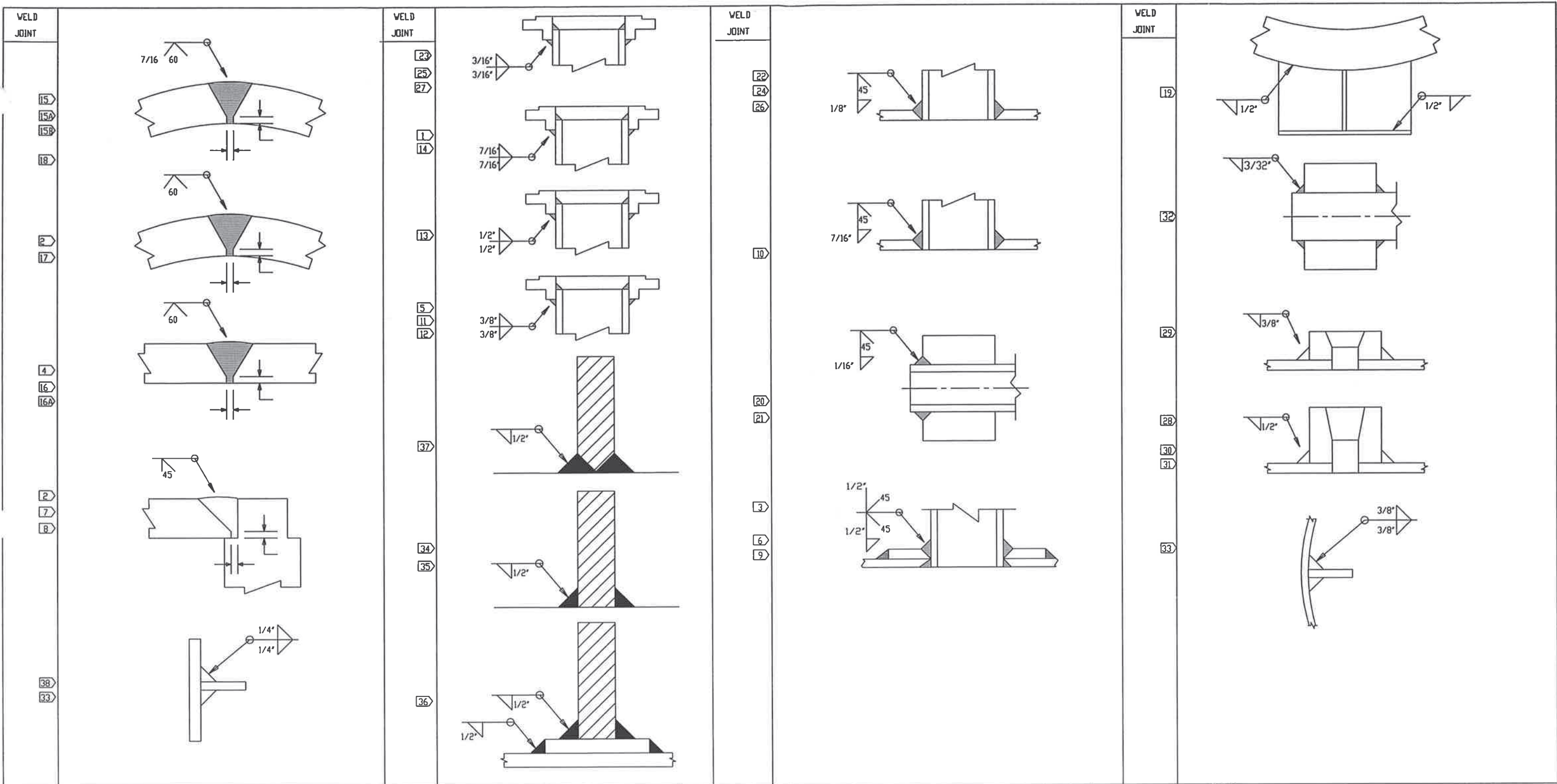
Side View

Notes:  
All Dimensions In Inches

Company: DCR  
Location: Bunge-Ergon  
Beer Column Reboiler  
Item No: E-4101  
Date: August 9, 2007 Job No: 7793

DCR Construction, Inc.  
Lakeland, Florida

Scale: NTS						ASME VIII-1 2004 A06		Rear Support Detail	
Rev:	Date:	Description	Dwg	Ckd	Appd	TEMA Type: NEM			
1	8/9/07	General Revision	JFS	DGB	PW	Size: 59-360	Dwg No:		Rev:
2	12/17/07	Certified As-Built	AGB	DGB	PW	TEMA Class: C	E-4101 19B		2



Notes:  
 All Dimensions In Inches  
 Welding in accordance with Code

Company: DCR  
 Location: Bunge-Ergon  
 Beer Column Reboiler  
 Item No: E-4101  
 Date: August 9, 2007 Job No: 7793

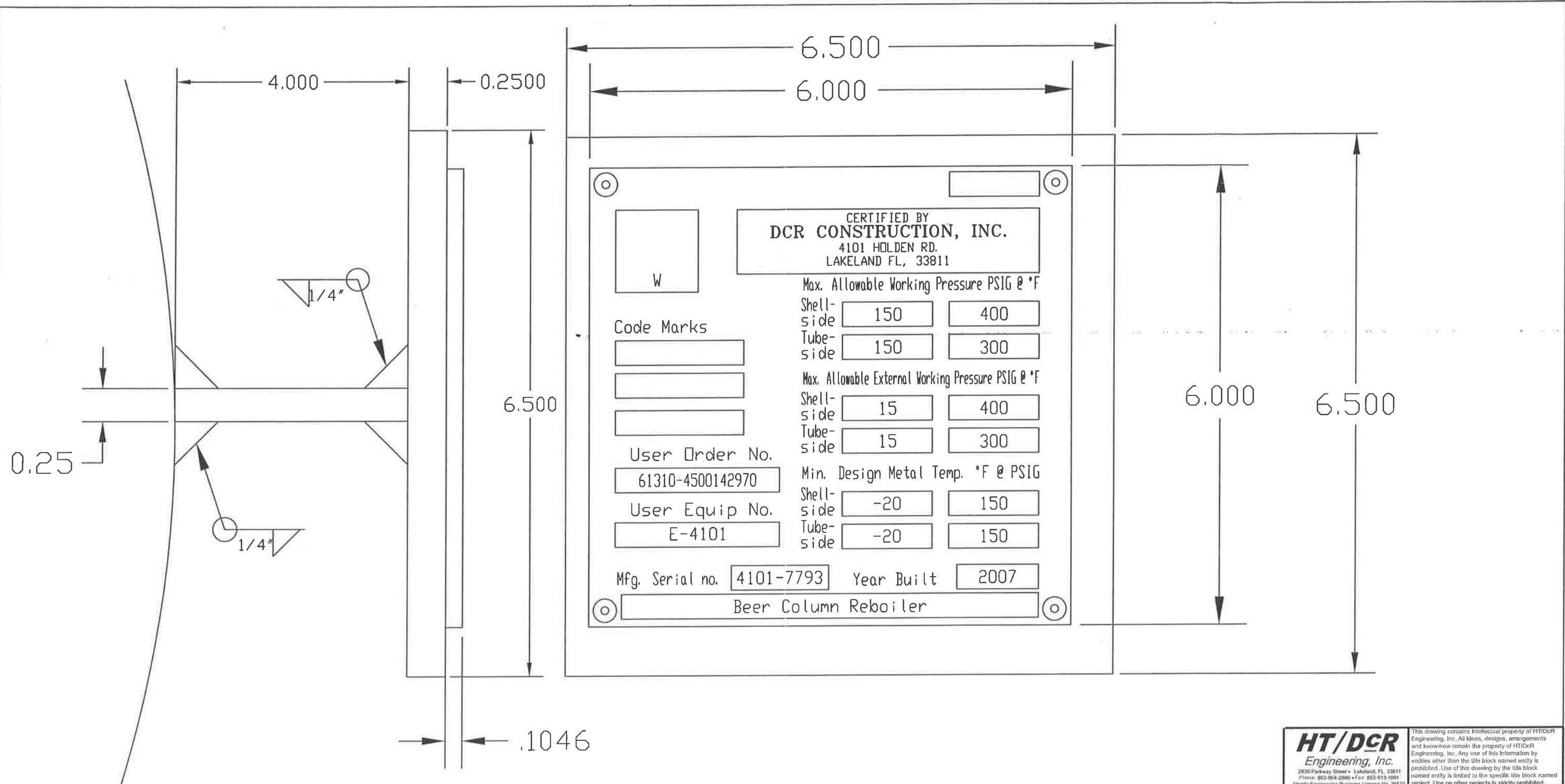
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 Lakeland, Florida

Scale: NTS

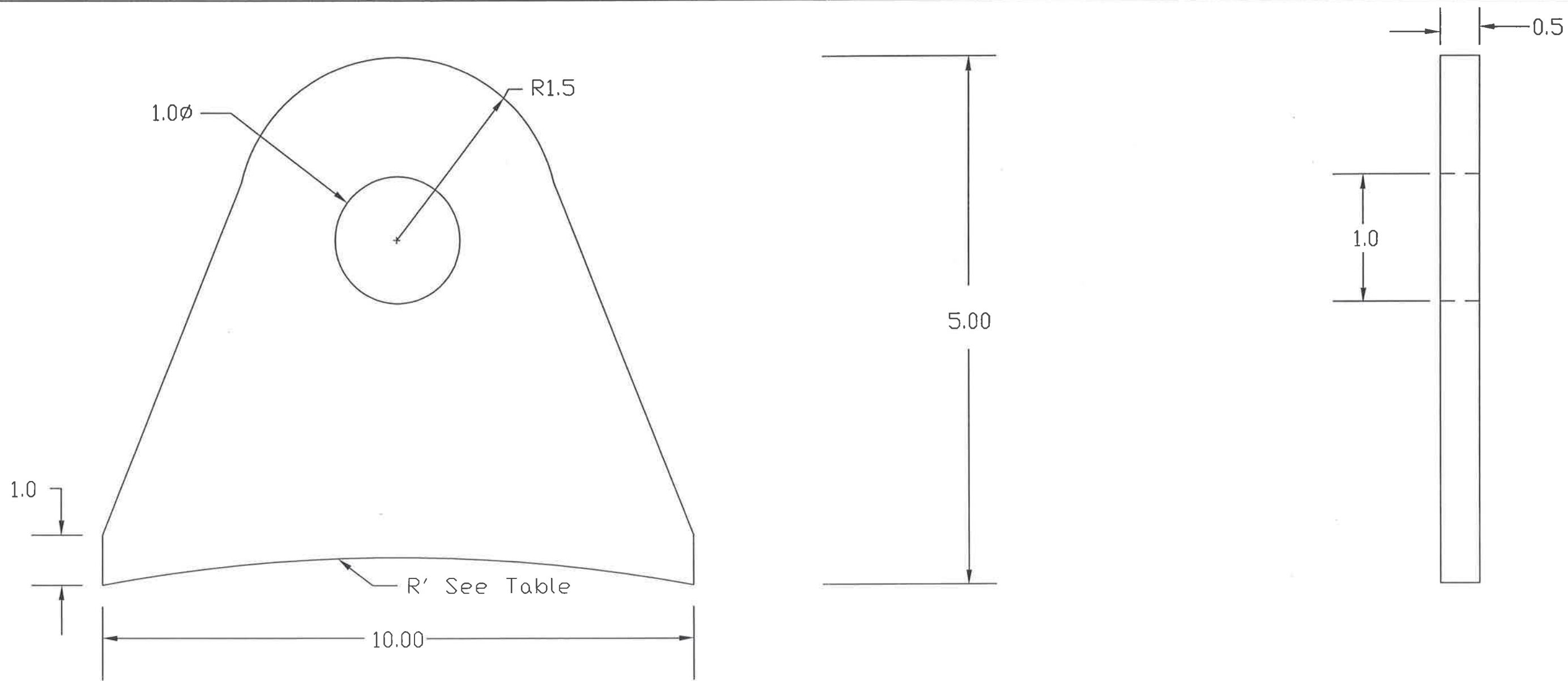
Rev:	Date:	Description	Dwg	Ckd	Appd	ASME VIII-1 2004 A06	Weld Joint Detail	
2	8-19-07	General Revisions	JFS	DGB	PW	TEMA Type: NEM	Dwg No: E-4101 20	Rev: 4
3	8-20-07	Deleted WPS Info	BJG	DGB	PW	Size: 59-360		
4	12-17-07	Certified As-Built	AGB	DGB	PW	TEMA Class: C		



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Notes: All Dimensions In Inches						Company: DCR Location: Bunge-Ergon Beer Column Reboiler Item No: E-4101 Date: August 6, 2007 Job No: 7793	
						DCR Construction, Inc Lakeland, FL	
Scale: NTS						ASME VIII-1 2004 A05	
Rev:	Date:	Description	Dwg	Ckd	Appd	TEMA Type: NEM	
1	8/6/07	General Revision	JFS	DGB	PW	Size: 59-360	
2	12/17/07	Certified As-Built	AGB	DGB	PW	TEMA Class: C	
						Dwg No: E-4101 22	
						Rev: 2	



R'	Location	Ref DWG.
32.06	Front Head Cover Glf. (DWG E-4101 13 & 18A)	
32.25	Rear Head Cover Glf. (DWG E-4101 09 & 18B)	

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FLAT COVER AND HEAD  
LIFTING LUG  
2 REQUIRED

Notes:  
All Dimensions In Inches

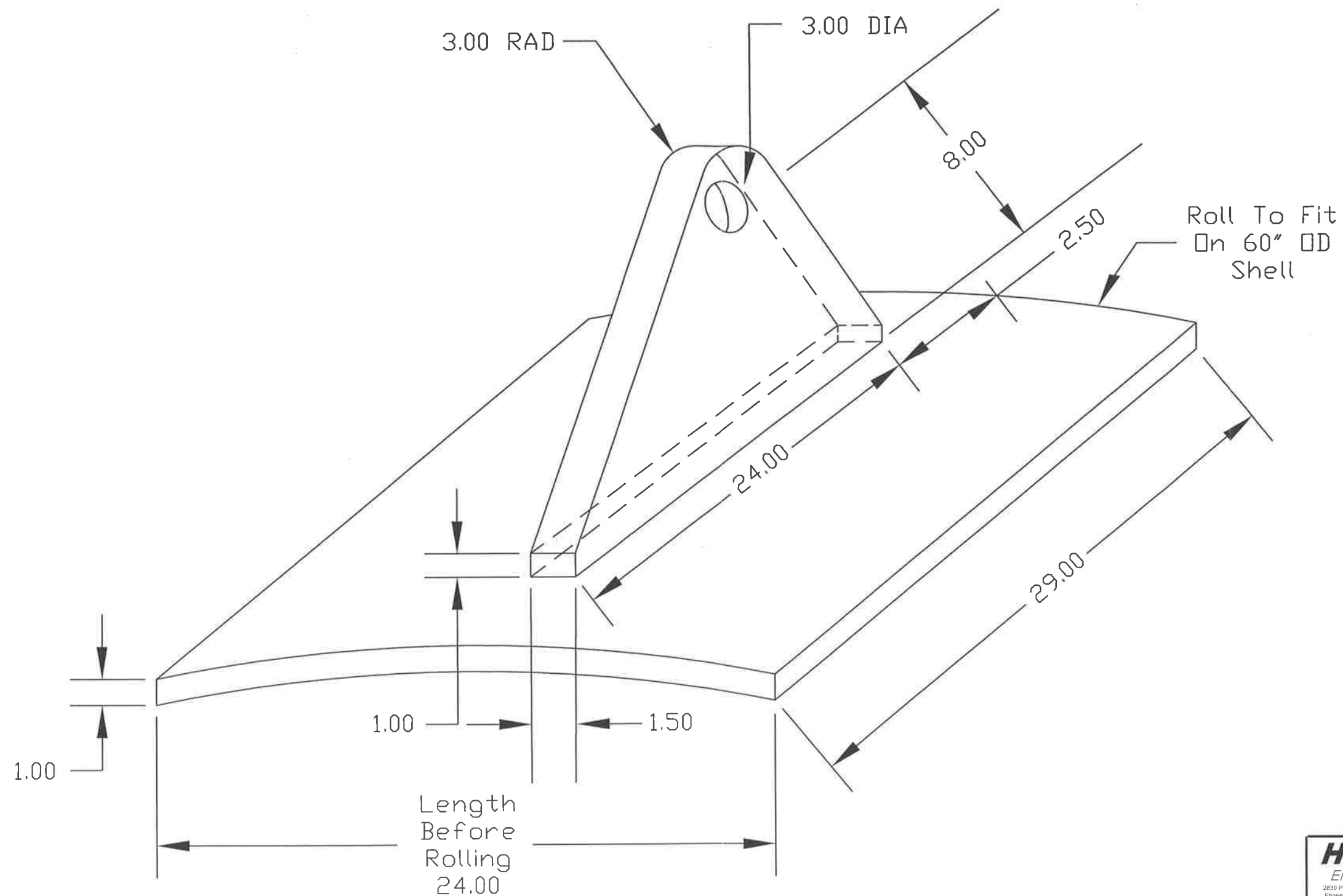
Company: DCR  
Location: Bunge-Ergon  
Beer Column Reboiler  
Item No: E-4101  
Date: August 9, 2007 Job No: 7793

DCR Construction, Inc  
Lakeland, FL

Scale: NTS

Rev:	Date:	Description	Dwg	Ckd	Appd	ASME VIII-1 2004 A06	Lifting Lug Detail
1	8-31-07	General Revision	JFS	DGB	PW	TEMA Type: NEM	
2	12-17-07	Certified As-Built	AGB	DGB	PW	Size: 59-360	Dwg No: E-4101 23A
						TEMA Class: C	Rev: 2





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FLAT COVER AND HEAD  
 LIFTING LUG  
 2 REQUIRED

Notes:  
 All Dimensions In Inches

Company: DCR  
 Location: Bunge-Ergon  
 Beer Column Reboiler  
 Item No: E-4101  
 Date: August 9, 2007 Job No: 7793

DCR Construction, Inc  
 Lakeland, FL

Scale: NTS

Rev:	Date:	Description	Dwg	Ckd	Appd	ASME VIII-1 2004 A06	Lifting Lug Detail	
1	8-31-07	General Revision	JFS	DGB	PW	TEMA Type: NEM	Dwg No: E-4101 23B	Rev: 2
2	12-17-07	Certified As-Built	AGB	DGB	PW	Size: 59-360 TEMA Class: C		

ID	Task Name	Start	Finish	% Complete	July 2007							August 2007							September 2007																
					9	12	15	18	21	24	27	30	3	6	9	12	15	18	21	24	27	30	2	5	8	11	14	17	20	23	26	29	1	4	7
1	Bunge-Ergon #4500142848 (DCR in KY)	Mon 6/25/07	Wed 9/19/07	58%																															
2	E-4501 1st Effect Evaporator	Fri 6/29/07	Wed 9/19/07	59%																															
3	E-4502 2nd Effect Evaporator	Wed 6/27/07	Mon 9/17/07	62%																															
4	E-4503 3rd Effect Evaporator	Mon 6/25/07	Fri 9/14/07	66%																															
5	E-4504 Evaporator Condenser	Tue 8/28/07	Tue 9/11/07	0%																															
6	Bunge-Ergon #4500142848- Change Order #1	Mon 4/23/07	Mon 4/23/07	100%																															
7	Ladders and Platforms	Mon 4/23/07	Mon 4/23/07	100%																															
8	Bunge-Ergon #4500142970 (DCR in TX)	Thu 5/31/07	Fri 9/14/07	55%																															
9	E-2101 Slurry Mix Tank Vent Condenser	Thu 5/31/07	Mon 8/20/07	100%																															
10	E-4101 Beer Column Reboiler	Thu 5/31/07	Wed 8/29/07	25%																															
11	E-4102 Beer Column Vent Condenser	Tue 7/3/07	Thu 8/23/07	10%																															
12	E-4103 Beer Column Feed Heater	Mon 6/18/07	Mon 8/20/07	100%																															
13	E-4201 Reflux Condenser	Tue 7/3/07	Fri 9/14/07	5%																															
14	E-4202 Stripper Column Reboiler	Thu 5/31/07	Mon 8/20/07	100%																															
15	E-4203 Reflux Vent Condenser	Thu 5/31/07	Mon 8/20/07	100%																															
16	E-4301 Superheater	Thu 5/31/07	Mon 8/20/07	100%																															
17	E-4303 Regen Vacuum Condenser	Tue 7/3/07	Sat 9/1/07	5%																															
18	E-4304 Regen Preheater	Fri 6/8/07	Mon 8/20/07	100%																															
19	E-4305 DD&E Condensate Preheater	Thu 5/31/07	Mon 8/20/07	100%																															
20	E-4401 Product Condenser	Fri 6/8/07	Sat 9/1/07	5%																															
21	E-7201 Flash Recovery Condenser	Mon 6/25/07	Thu 8/23/07	20%																															
22	E-7601 Process Condensate Heater	Thu 5/31/07	Mon 8/20/07	100%																															
23	E-7602 Dilute Caustic Heater	Thu 5/31/07	Mon 8/20/07	100%																															