

06018
 CIE: ETHANOL
 Canton, Illinois
 01.22.07

File: ME-3503

018 0017 007

FIELD FILE

*- this dwg being Resubmitted for Approval
 otherwise All Corrections
 are corrected as per
 TRS Method 4.1.2-182*

FOUNDATION DESIGN LOADS		
DEAD LOAD OF STACK (ON)	7	KIPS
DEAD LOAD OF STACK (OFF)	9.5	KIPS
WIND SHEAR AT BASE OF STACK	4	KIPS
WIND MOMENT AT BASE OF STACK	120	KIP-FT.
WIND CODE	ASCE	7-02
WIND SPEED	100	MPH
IMPORTANCE FACTOR	1.0	
EXPOSURE CATEGORY	LB	
SEISMIC LOAD	DO NOT CONTROL	

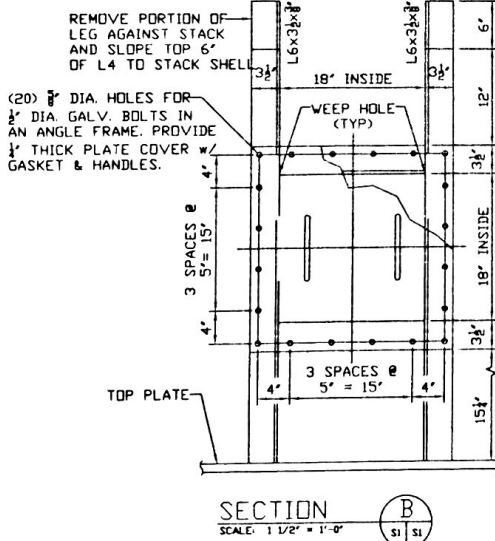
REV	BY	DATE	DESCRIPTION	CHKD
01	E.J.	1/18/07		
02	J.Z.	1/18/07		

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CLIENT: CENTRAL ILLINOIS ENERGY CANTON ILLINOIS
 TITLE: DETAIL DRAWING STACK ELEVATION & DETAILS
 DRAWING NUMBER: DC07-4956-03-1
 REVISION: 0

GENERAL NOTES

- MATERIAL**
 A. 3" AOR SHELL PLATES AND ALL INTERNAL & EXTERNAL COMPONENT PARTS SUCH AS FALSE BOTTOM, TEST PORTS, AND INLET FLANGE SHALL CONFORM TO ASTM A240 TYPE 304L STAINLESS STEEL UNLESS NOTED OTHERWISE.
 B. ALL FASTENERS FOR TEST PORTS, FIELD SPLICES AND ANY OTHER WELDING REQUIREMENTS SHALL BE 304 STAINLESS STEEL FASTENERS UNLESS NOTED OTHERWISE.
- FABRICATION**
 ALL WORK SHALL BE FABRICATED IN ACCORDANCE WITH AISC 'SPECIFICATIONS FOR STRUCTURAL STEEL BUILDINGS', LATEST EDITION. ALL WELDS SHALL BE MADE ONLY BY WELDING OPERATORS WHO HAVE BEEN PREVIOUSLY QUALIFIED BY TESTS AS PRESCRIBED IN THE AWS 'STRUCTURAL WELDING CODE' OR BY THE ASME WELDING CODE TO PERFORM THE TYPE WORK REQUIRED. ALL BUTT WELDS SHALL BE PRE-QUALIFIED. FULL PENETRATION WELDS SHALL BE DEVELOPED TO THE FULL STRENGTH OF THE SECTION. SHELL, GIRTH AND VERTICAL SEAMS SHALL BE COMPLETE PENETRATION BUTT GROOVE WELDS AND TOTALLY WELDED EITHER AUTOMATICALLY OR SEMI-AUTOMATICALLY BY THE SUBMERGED ARC WELDING PROCESS. ALL WELDING ELECTRODES AND FLUX SHALL CONFORM TO THE AWS CODE AND BE EQUIVALENT TO THE BASE METAL IN STRENGTH AND CORROSION RESISTANCE.
- TOLERANCES**
 A. BASE RING AND SPLICES MUST BE PERPENDICULAR TO THE STACK CENTERLINE SUCH THAT THE DIRECTION OF THE STACK CAN BE PLUMBED TO WITHIN A MAXIMUM DEVIATION OF 1" PER 100' OF HEIGHT.
 B. MAXIMUM OUT-OF-ROUNDNESS OF ANY SECTION - DIFFERENCE BETWEEN MINIMUM AND MAXIMUM DIAMETER - LESS THAN 1% OF THE NOMINAL DIAMETER.
 C. MAXIMUM MISALIGNMENT OF PLATES AT ANY JOINT SHALL NOT EXCEED 25% OF THE NOMINAL THICKNESS OR 1/8", WHICHEVER IS LESS.
 D. ALL JOINING PLATE SECTIONS SHALL BE PAIRED FOR FULL 100% DEVELOPMENT.
 E. SPACING OF VERTICAL JOINTS SHALL NOT EXCEED 1/4" AS MEASURED FROM THE TRUE RADIUS OF THE STACK.
 F. TEST PORT FLANGES SHALL BE PERPENDICULAR TO THE CENTERLINE TO WITHIN 1/2 DEGREE. FIELD SPLICE FLANGES MUST BE PERPENDICULAR TO THE STACK SHELL WITHIN 1/8".
 G. STRUCTURAL PLATES ARE TO BE PURCHASED OF SUFFICIENT LENGTH TO ALLOW FOR ONLY ONE VERTICAL SEAM PER GIRTH. VERTICAL SEAMS ON ADJACENT SECTIONS WILL BE OFFSET BY 90 DEGREES. IN SPECIAL CASES, A MAXIMUM OF TWO VERTICAL SEAMS WILL BE OFFSET AT LEAST BY 90 DEGREES.
 H. ALL APPURTENANCES SHALL BE SHIP ATTACHED TO ENSURE A GOOD FIT. ALL FIELD CONNECTIONS ARE TO BE CLEARLY MARKED.
- INSPECTION AND TESTING**
 MATERIAL TEST REPORTS FOR ALL MATERIAL UTILIZED FOR MAJOR COMPONENTS AND FASTENERS SHALL BE SUBMITTED TO WARREN. THE MATERIAL TEST REPORTS ARE TO BE REQUESTED WHEN THE MATERIAL IS ORDERED AND FORWARDED TO WARREN IMMEDIATELY UPON RECEIPT. THE MSDS SHEETS ON THE TOUCH-UP PAINTS, THINNERS AND ANY OTHER HAZARDOUS MATERIAL IS TO BE INCLUDED WITH THE SHIPMENT OF THE ITEMS.
- SURFACE PREPARATION**
 A. ALL SHARP PROJECTIONS SHALL BE GROUND SMOOTH.
 B. ALL WELD FLUX AND SPLATTER SHALL BE REMOVED BY POWER TOOL CLEANING.
 C. ALL EXTERIOR SURFACES ARE TO BE ACID PASSIVATED.
- LOADING AND SHIPPING**
 THE STACK WILL BE LOADED AND SECURED ON TRUCKS SUCH THAT PLATES ARE NOT DEFORMED. STACK LOADS ARE TO BE DISTRIBUTED TO AVOID POINT LOADS ON PLATES ARE TO BE AVOIDED. TIMBERS USED TO SECURE LOADS ARE TO BE PLACED LONGITUDINALLY, SPANNING AT LEAST TWO STIFFENERS. THE ERECTOR IS TO REMOVE ALL TEMPORARY SPACERS AND BRACES BEFORE COMPLETING THE ERECTION.
- FIT-UP**
 NORMAL ERECTION PROCEDURES INCLUDE THE CORRECTION OF MINOR MISFITS BY MODERATE AMOUNTS OF STRAIGHTENING, SHIMMING, REAMING, CUTTING AND/OR GRINDING FOR PROPER FIT-UP. MISFITS WHICH CANNOT BE CORRECTED BY THESE MEANS OR WHICH REQUIRE MAJOR CHANGES IN THE EQUIPMENT ARE TO BE REPORTED TO WARREN ENVIRONMENT IMMEDIATELY. THE ERECTOR WILL PROVIDE INFORMATION AS REQUIRED TO EITHER CORRECT THE MISFIT OR PRESCRIBE THE MOST EFFICIENT AND ECONOMIC METHOD TO CORRECT THE MISFIT.



DETAIL 1
 SCALE: 3" = 1'-0"

SECTION A
 SCALE: 1 1/2" = 1'-0"

SECTION B
 SCALE: 1 1/2" = 1'-0"

STACK ELEVATION
 SCALE: 1/2" = 1'-0"