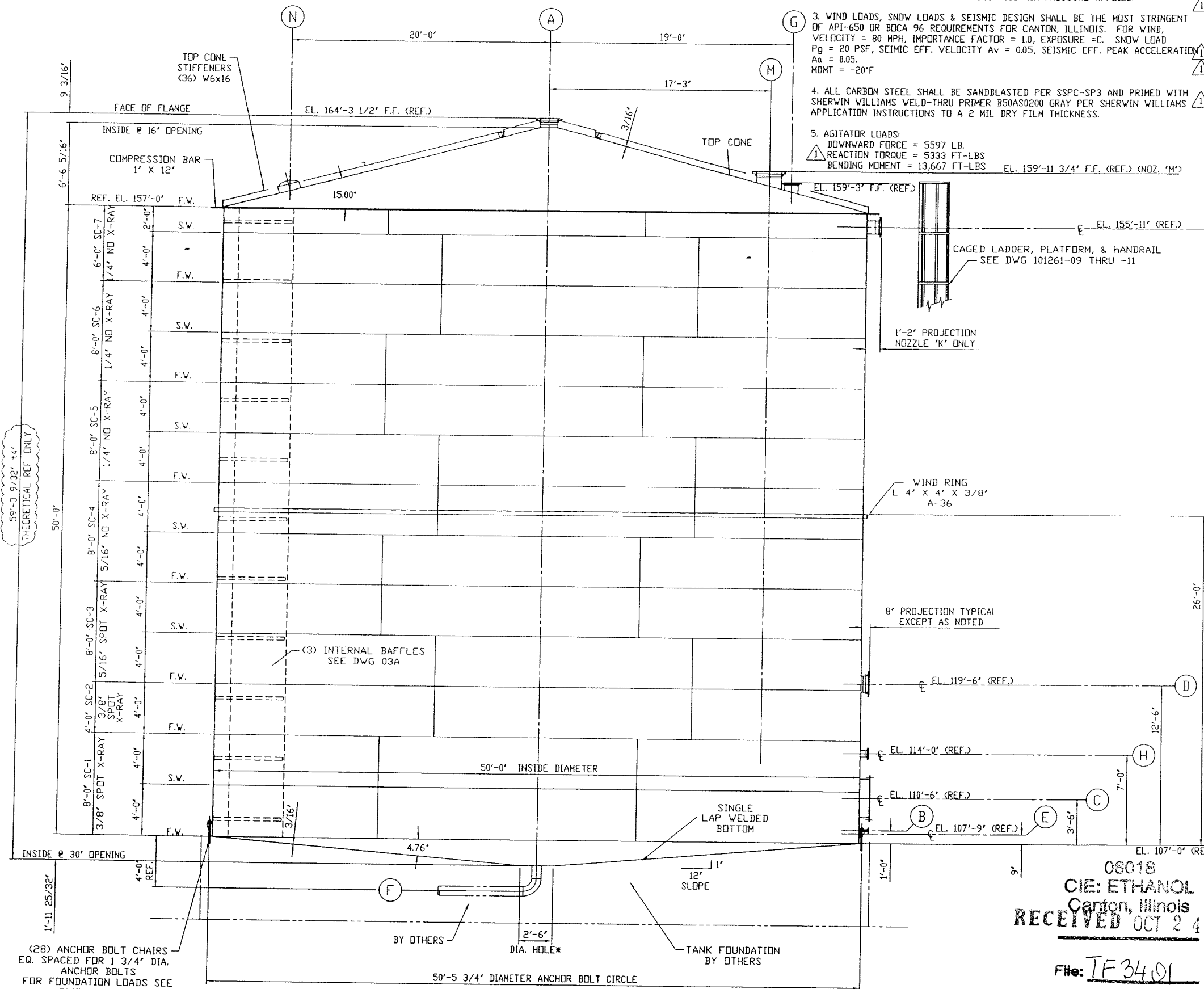


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**GENERAL NOTES**  
 1. TANK IS DESIGNED TO BE FILLED TO THE TOP OF THE STRAIGHT SHELL WITH PRODUCT (SpG=1.05) PLUS 1.45 PSIG GAS PRESSURE IN THE HEAD SPACE. THE OPERATING PRESSURE IS WITH THE TANK FILLED TO THE OVERFLOW NOZZLES WITH PRODUCT (SpG=1.05) PLUS 0.72 PSIG GAS PRESSURE ON THE HEAD SPACE.  
 2. THE TANK HYDROTEST WILL BE WITH THE TANK FILLED TO THE TOP OF THE STRAIGHT SHELL WITH WATER AND 1.81 PSIG AIR PRESSURE APPLIED.  
 3. WIND LOADS, SNOW LOADS & SEISMIC DESIGN SHALL BE THE MOST STRINGENT OF API-650 OR BOCA 96 REQUIREMENTS FOR CANTON, ILLINOIS. FOR WIND, VELOCITY = 80 MPH, IMPORTANCE FACTOR = 1.0, EXPOSURE = C. SNOW LOAD Pg = 20 PSF, SEISMIC EFF. VELOCITY Av = 0.05, SEISMIC EFF. PEAK ACCELERATION Aa = 0.05. MDHT = -20°F  
 4. ALL CARBON STEEL SHALL BE SANDBLASTED PER SSPC-SP3 AND PRIMED WITH SHERWIN WILLIAMS WELD-THRU PRIMER B50AS0200 GRAY PER SHERWIN WILLIAMS APPLICATION INSTRUCTIONS TO A 2 MIL DRY FILM THICKNESS.  
 5. AGITATOR LOADS:  
 DOWNWARD FORCE = 5597 LB.  
 REACTION TORQUE = 5333 FT-LBS  
 BENDING MOMENT = 13,667 FT-LBS

NOZZLE SCHEDULE							
MARK	QTY	SIZE	RATING LBS	FLG/CPLG TYPE	WALL THK	DESCRIPTION	REF DWG
A	1	16"	150#	L.J.S.E.	SCH 40S	AGITATOR	04
B	1	1 1/2"	150#	L.J.S.E.	SCH 80S	TEMP	07
C	1	36"	75#	-	-	SIDE MANWAY - TUBETURN CLASS 75	07
D	1	16"	150#	L.J.S.E.	SCH 40S	INLET	06
E	1	3"	150#	R.F. PAD	-	LEVEL	07
F	1	8"	-	-	-	DISCHARGE W/ EMBED PLATE (BY OTHERS)	06
G	1	12"	150#	L.J.S.E.	SCH 40S	CONSERVATION VENT	07
H	1	6"	150#	L.J.S.E.	SCH 40S	RECIRCULATION	07
K	2	12"	150#	L.J.S.E.	SCH 40S	OVERFLOW	07
M	2	24"	150#	L.J.S.E.	SCH 40S	CO2 VENT	06
N	1	20"	-	-	-	TOP MANWAY - KNAPPCO KS4220	06



SEE DWG 02 FOR TOLERANCE NOTES

QUALITY ASSURANCE REQUIREMENTS	
CODE: API 650	STAMP REQ'D: NO
RADIOGRAPH BUTT WELDS:	
TOP HEADS: NONE	BTH HEADS: NONE
SHELLS: SPOT PER API A-5.3	
FILLET WELD EXAMINATION:	
VESSEL: NONE	
NOZZLES: NONE	
HYDROTEST: YES	PRESSURE: NOTE 2
MAT'L CERTIFICATION REQ'D: YES	
TEST PROCEDURES:	
MATERIAL SPECIFICATIONS	
HEADS: A240-304	
SHELL: A240-304	
SUPPORTS: SA36	
NOZZLE NECKS: SA312-304	
FLANGES: SA182-304	
LAP JOINT FLANGES: C.STL. A181	
NOZZLE REINFC.: SA240-304	
NUTS & BOLTS: SA193 B7 / SA194 2H	
GASKETS: NEOPRENE	
PIPE: SA312-304	

DESIGN CRITERIA	
PRODUCT:	
SPECIFIC GRAVITY:	1.05
CORROSION ALLOWANCE:	0
VESSEL DESIGN PRESS:	NOTE 1 200 PSIG
VESSEL OPERATING PRESS:	NOTE 1 90 PSIG
JACKET/COIL DESIGN PRESS:	N/A
JACKET/COIL TEST PRESS:	N/A
DESIGN VACUUM:	6" OF WATER
CAPACITY:	
NET:	721,354 GALLONS *
GROSS:	778,438 GALLONS
WEIGHT:	
EMPTY:	152,000 LBS.
FULL:	6,584,000 LBS.
SEISMIC:	NOTE 3
OTHER:	NOTE 3
* NET VOLUME IS TO INVERT OF OVERFLOW	

WELD PREPARATION	INTERIOR	EXTERIOR
AS WELDED	NO	NO
WIRE BRUSHED	YES	YES
GRIND SMOOTH ONLY (NOT FLUSH)	NO	NO
GRIND SMOOTH & FLUSH	NO	NO
OTHER:	NO	NO

SURFACE PREPARATION	INTERIOR	EXTERIOR
SANDBLAST (CARBON STEEL)	NO	NOTE 4
PRIME PAINT (CARBON STEEL)	NO	NOTE 4
FINISH PAINT (CARBON STEEL)	NO	NO
REMOVE WELD DISCOLORATION	NO	NO
OTHER:		

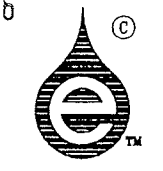
WELD PROCEDURES					
PROCEDURE	REVISION	APPROVED	PROCEDURE	REVISION	APPROVED

REV.	DATE	BY	DESCRIPTION	CHECKED BY	APPROVED BY
1	9/27/2006	MAC	REVISED PER APPROVAL DRAWINGS		
0	8/24/2006	J.PLEAS	FIRST ISSUE		

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**ENERFAB, INC.**  
 CINCINNATI, OHIO

FOR: **LURGI PSI, INC.**  
 CENTRAL ILLINOIS ENERGY  
 CANTON, IL

DRAWING TITLE: **ASSEMBLY ELEVATION**  
 (1) 50'-0" BEER WELL  
 TAG NO. TF-3401

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GENERAL ARRANGEMENT ELEVATION VIEW  
 SEE DWGS 101262-02 FOR PLAN VIEW ORIENTATION