



NO.	REV.	PER. CUST. COMMENTS	APP.	DRWN.	DATE	REVISION
1		REV. PER CUST. COMMENTS ADDED PIPE SUPPORTS	RAM	RAM	5/22/07	
2		PER COMMENTS REV. PROU NOZ. F & G. RELOC. NOZ. J	RAM	RAM	6/1/07	
3		REV. EXTERNAL RAFTERS TO HOT-DIPPED GALVANIZED	RAM	RAM	6/18/07	
4		REV. AGITATOR NOZ. TO 18" DIA., REV. LENGTH ITEMS	RAM	RAM	6/29/07	
5		REV. PROU NOZS E & M. ADDED 360° HR. & CROSS-WALKS	RAM	RAM	7/9/07	
6		REV. NOZ. "N" FROM 12" TO 10" DIA.	RAM	RAM	7/24/07	
7		REV. EXT. RAFTER SIZE ITEM 14, REV. ELEV. ITEM 13	RAM	RAM	8/16/07	
8		REV. ROOF NOZ. PROU. E. & "N". ADDED MSC. DIMS	RAM	RAM	8/24/07	

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ITEM NO.	DESCRIPTION	QTY.	SERVICE
13	BOTTOM 1/4" x 72" x 360" PLATE (26" REF. RADUS)	13	304 SS (D-13459)
6	1st. SHELL RING 5/16" X 71 1/2" X 325 1/4" LG.	6	304 SS (D-13461)
6	2nd. SHELL RING 5/16" X 71 1/2" X 325 1/4" LG.	6	304 SS
6	3rd. SHELL RING 1/4" X 71 1/2" X 325 1/4" LG.	6	304 SS
6	4th. SHELL RING 1/4" X 71 1/2" X 325 1/4" LG.	6	304 SS
6	5th. SHELL RING 1/4" X 71 1/2" X 325 1/4" LG.	6	304 SS
6	6th. SHELL RING 1/4" X 71 1/2" X 325 1/4" LG.	6	304 SS
6	7th. SHELL RING 1/4" X 71 1/2" X 325 1/4" LG.	6	304 SS
6	8th. SHELL RING 1/4" X 71 1/2" X 325 1/4" LG.	6	304 SS
9	SHELL RING EXTENSION 1/4" X 3 1/2" F.B. X 20" PL.	9	304 SS
14	DECK 3/16" X 72" X 360" LG. PLATE (26" R. 1/2" CUT RADUS)	14	304 SS (D-13459)
9	INSIDE CHIME 2 1/2" X 2 1/2" X 1/4" X 20" LG. (LEG AN.)	9	304 SS
27	VACUUM RINGS 3" X 2" X 1/4" X 20" LG. (LEG AN.)	27	304 SS
26	EXTERNAL RAFTER 5" X 3" X 3/8" X 22'8" LG.	26	SA-36 (SEE DETAIL)
8	INSTALLED 5" "LEG DOWN" & HOT-DIPPED GALVANIZED	8	304 SS (SEE DETAIL)
1	STIFF. RING 1/2" X 8" F.B. X 25'-3" LG. (ROLL. 8' ID.)	1	304 SS (SEE DETAIL)
16	STIFFENING GUSSET 1/2" X 6" F.B. X 3'-5" 3/8" LG.	16	304 SS (SEE DETAIL)
30	ANCHOR CHAIR 12" HT. X 1/2" PLATE	30	304 SS (SEE DETAIL)
17	BAFFLE 1/4" PL. X 52" WD. W/ 4" X 3/8" ANGLE BRACES	30	304SS (C-13463)
19	GALV. 360° HANDBAILS & CROSS-WALKWAYS	3	SA-36 (C-13465)
20	STEADY BEARING SUPPORT 2 1/2" PL. X 28" DIA.	1	B-13545
A	24" API 650 SHELL M.W. W/ 5/16" TMSB. REPAD & N.P. BKRT.	1	B-13451, B-10366
B	20" API 650 ROOF MANWAY 304 SS	1	B-11984
C	NOZ. 18" 150# RFRSD. M.W. PIPES X 1 1/4" LG. W/ 1/4" PLATE	1	
D	NOZ. 20" 150# RFRSD. M.W. PIPES X 3'-9" LG. W/ 20" XH PIPE	1	RECIRCULATION
E	CAR. 5/16" HALF TMSB. REPAD & 1/4" BOT. REPAD. X 42" O.D.	1	MASH OUTLET (B-13460)
F	18" 150# RFRSD. NOZ. W/ STD. PIPE X 20' 1/2" LG. W/ 1/4" PL.	1	
G	NOZ. 2" 150# RFRSD. 5/80 PIPE X 7 1/4" LG. W/ 5/16" TMSB. REPAD	1	COZ. OUTLET
H	NOZ. 2" 150# RFRSD. 5/80 PIPE X 7 1/4" LG. W/ 5/16" TMSB. REPAD	1	LEVEL TRANSMITTER
I	3/4" 3000# COUPLING 304 SS	1	LEVEL SWITCH
J	3/4" 3000# COUPLING 304 SS	1	T.E.
K	NOZ. 2" 150# RFRSD. 5/80 PIPE X 7 1/4" LG.	1	STEAM INLET
L	8" 150# RFRSD. NOZ. W/ STD. PIPE X 28" LG. W/ 1/4" PL.	3	CIP INLET
M	10" 150# RFRSD. NOZ. W/ STD. PIPE X 14" LG. W/ 1/4" PL.	1	AGITATOR
N	18" 150# RFRSD. NOZ. W/ STD. PIPE X 14 1/2" LG. W/ 1/4" PL.	1	PSV-VENT
P	24" X 8" ROOF HATCH W/ BOULDED COVER PLATE	1	B-13462
Q	PIPE SUPPORT PS-VESB (REF. 4,324 LBS) DETAIL "B"	1	C-13469
R	PIPE SUPPORT PS-VESB (REF. 420 LBS) DETAIL "A"	1	C-13469
S	PIPE SUPPORT PS-VESB (REF. 420 LBS) DETAIL "A"	1	C-13469
T	PIPE SUPPORT PS-VESB (REF. 4,485 LBS) DETAIL "B"	1	C-13469

WELDING PROCEDURES			
WELDED JOINT	PROCEDURE	MATERIAL	
LONG SEAM	29, 37	181-2nd = 5/16"	304 SS TYP.
ROUND SEAM	29, 37	3rd THRU 8th = 1/4"	304 SS TYP.
BOTTOM LAP JOINTS	29, 37		
CONNECTIONS	29, 37		
INTERVALS	29, 37		
TOLERANCE	+/- 1/4" LINEAR +/- 1° ANGULAR		

API 650			
APPENDIX	S	YEAR COMPLETED	2007
EDITION	10	REVISION NUMBER	4
NOMINAL DIAMETER	51'-9"	NOMINAL HEIGHT	48'-0"
NOMINAL CAPACITY (BU)	17,998	DESIGN LIQUID LEVEL	48'-0"
DESIGN SPECIFIC GRAVITY	1.06	MAXIMUM OPERATING TEMP.	200°F
DESIGN PRESSURE PSIG	0.5	PARTIAL STRESS RELIEF	200°F
MANUFACTURER'S SERIAL NO.	07234	PURCHASER'S TANK NO.	TK-3107
FABRICATED BY	BAKER TANK COMPANY		
ERECTED BY	BAKER TANK COMPANY		

BAKER TANK CO. DIVISION OF JUSTSSOIL COMPANY

51'-9" I.D. X 48'-0" HT. FERMENTER # 4 STORAGE TANK

SCALE: 3/16"=1'-0"

DRAWN BY: **ML** JOB NO.: 07234 DRAWING NO.: **D-13439** REV.: 8

DATE: 4/29/07