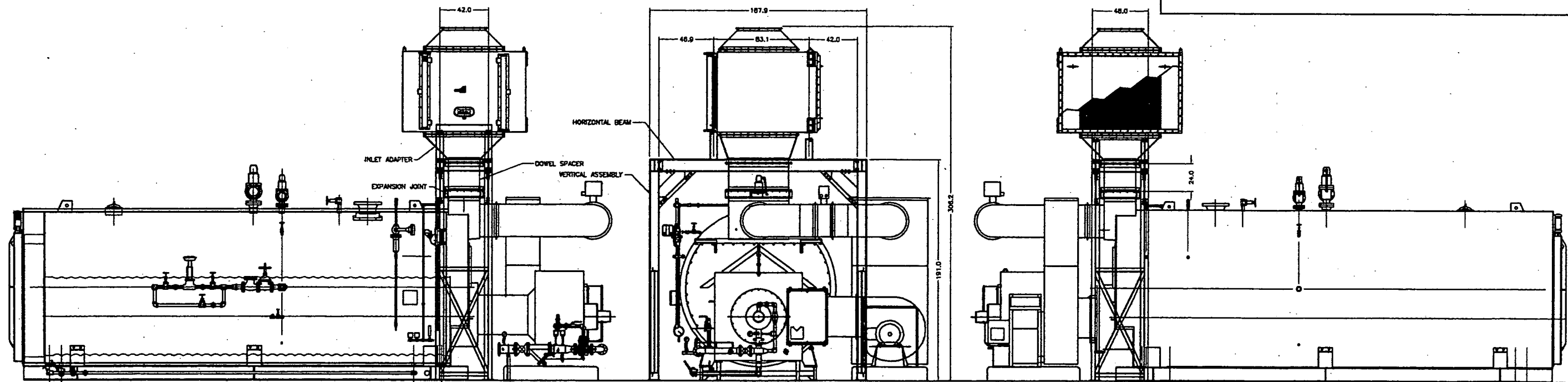
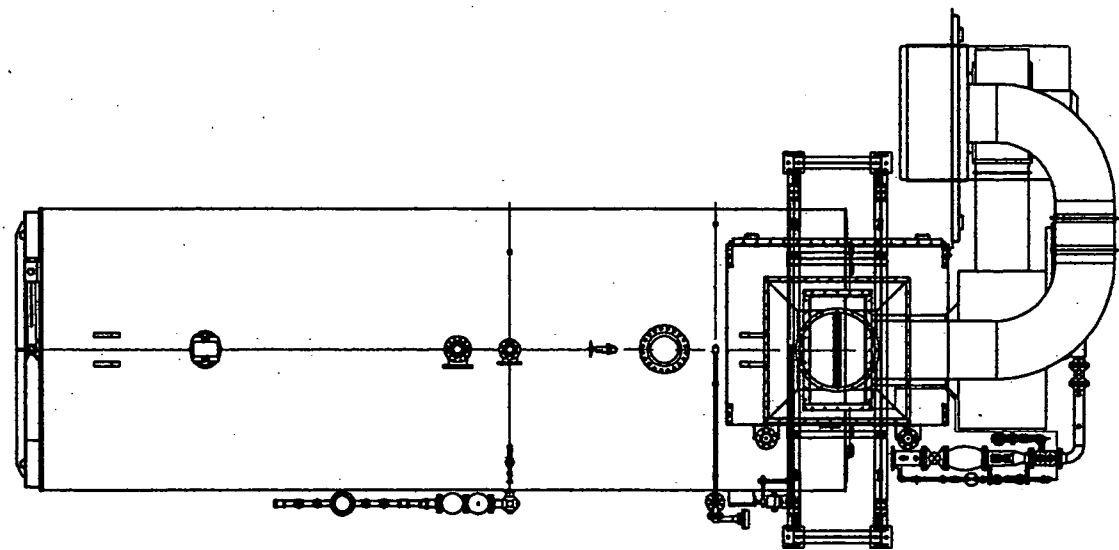


ASSEMBLY PROCEDURE

- STAND THE (2) VERTICAL ASSEMBLIES INTO POSITION AS SHOWN IN DRAWING #41289
- USING THE 5/8" BOLT ASSEMBLIES PROVIDED, LOOSELY BOLT THE (2) HORIZONTAL BEAMS TO THE VERTICAL ASSEMBLIES (NOTE THE MARKINGS ON THE GUSSETS THAT IDENTIFY THE CORRECT ORIENTATION, SEE EXPLODED VIEW)
- LOOSELY BOLT THE (4) ANGLE IRON CORNER SUPPORTS IN PLACE (5/8" BOLTS)
- CHECK THAT THE OVERALL LENGTH AT THE BOTTOM MATCHES THE OVERALL LENGTH AT THE TOP
- TIGHTEN ALL BOLT ASSEMBLIES INSTALLED SO FAR
- PLACE THE ECONOMIZER ON THE STAND AND LOOSELY BOLT THE BEAMS ON THE ECONOMIZER TO THE SHORT VERTICAL BEAMS THAT ARE WELDED TO THE TOP OF THE STAND (5/8" BOLTS)
- LOOSELY BOLT THE BOILER EXHAUST OUTLET/ECONOMIZER INLET ADAPTER TO THE ECONOMIZER USING THE 3/8" BOLT ASSEMBLIES PROVIDED
- REMOVE PROTECTIVE PARTICLE BOARD SHEET FROM DOWEL SPACER/EXPANSION JOINT ASSEMBLY
- BOLT THE DOWEL SPACER/EXPANSION JOINT ASSEMBLY TO THE BOILER EXHAUST OUTLET AND THE INLET ADAPTER (3/8" BOLTS ON THE ECONOMIZER SIDE, 1/2" BOLTS ON THE EXPANSION JOINT SIDE)
- IF A HEIGHT ADJUSTMENT NEEDS TO BE MADE, CUT THE TACKWELDS HOLDING THE 3" ANGLE IRON FLANGE ON THE DOWEL SPACER THAT THE EXPANSION JOINT IS CONNECTED TO AND RAISE OR LOWER FLANGE TO PROPER HEIGHT AS NEEDED
- ONCE THE DOWEL SPACER AND EXPANSION JOINT ARE TIGHTLY SECURED TO THE BOILER EXHAUST OUTLET AND THE INLET ADAPTER SECURE THE STAND MOUNTING PADS TO THE FLOOR
- TIGHTEN ALL REMAINING BOLT ASSEMBLIES
- CONTINUOUSLY WELD THE 3" ANGLE FLANGE ON THE DOWEL SPACER THAT CONNECTS TO THE EXPANSION JOINT

FOR: BUNGE-ERGON VICKSBURG LLC		DRWG: 35499	REV: 0	SCALE: NONE
C/D: CAMPBELL-SEVEY				
S.O.: 8596	P.O.: 067881	DRW: JMB	TOLERANCES: -	
REF: 99453	WGT: 4800#	APP:	DATE: 120506	
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ASSEMBLY PROCEDURE

- STAND THE (2) VERTICAL ASSEMBLIES INTO POSITION AS SHOWN IN DRAWING #41289
- USING THE 5/8" BOLT ASSEMBLIES PROVIDED, LOOSELY BOLT THE (2) HORIZONTAL BEAMS TO THE VERTICAL ASSEMBLIES (NOTE THE MARKINGS ON THE GUSSETS THAT IDENTIFY THE CORRECT ORIENTATION, SEE EXPLODED VIEW)
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- TIGHTEN ALL REMAINING BOLT ASSEMBLIES
- CONTINUOUSLY WELD THE 3" ANGLE FLANGE ON THE DOWEL SPACER THAT CONNECTS TO THE EXPANSION JOINT

FOR: BUNGE-ERGON VICKSBURG LLC				DRWG: 35499	REV: 0	SCALE: NONE
C/D: CAMPBELL-SEVEY						
S.D.: 8596	P.D.: 06781	DRW: JMB	TOLERANCES: -	RTR-166K26ALS SUPPORT STAND LH ASSEMBLY		
REV: 98453	REV: 4800#	APP:	DATE: 120506			
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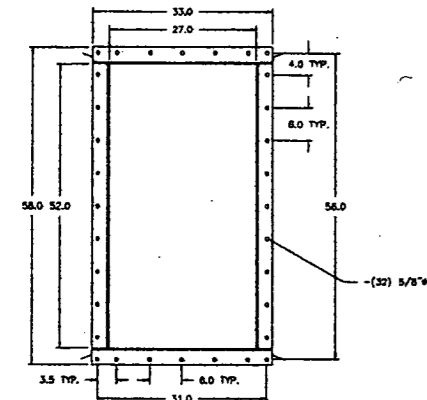


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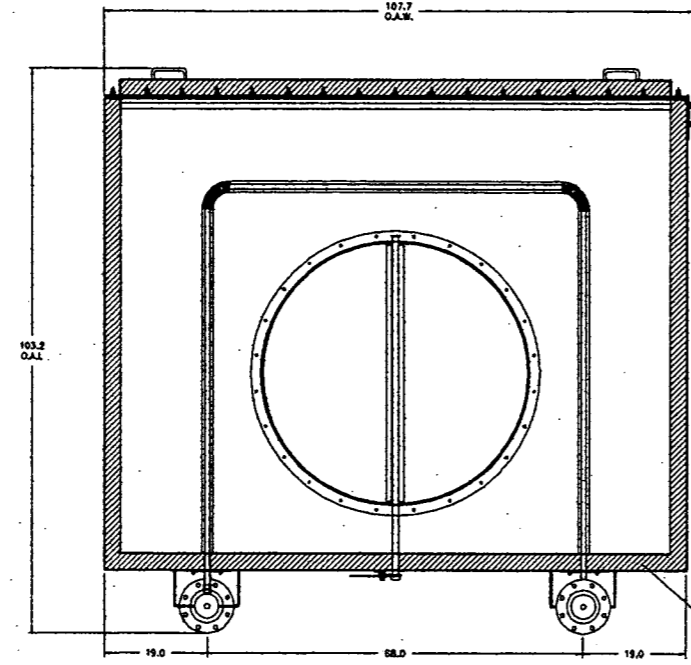
005.	LIFTING LUG (QTY. 4)
010.	STAINLESS STEEL INTERIOR LINER
015.	STAINLESS STEEL DAMPER ASSEMBLY (SHOWN IN THE BYPASS POSITION)
020.	COMPRESSION FITTING, FINITUBE TO HEADER
025.	4" 300# CARBON STEEL FLANGED LIQUID INLET CONNECTION
030.	3/4" NPT VENT/SAFETY VALVE CONNECTION
040.	CR# LOGO AND SERIAL NO. ID.
042.	3" U" STAMP: 300 PSIG (SEC. VIII DIV. I)
045.	4" 300# CARBON STEEL FLANGED LIQUID OUTLET CONNECTION
050.	1" NPT DRAIN CONNECTION
055.	3" THKS. FACTORY INSULATION
060.	STAINLESS STEEL DAMPER SHAFT
065.	STACK ADAPTER INLET: 27" x 52" ID FLANGE (SEE DETAIL)
070.	STACK ADAPTER OUTLET: 38.125" ID RING 2" x 2" x 0.1875" ANGLE W/ (18) 0.4375" HOLES ON A 38.375" B.C.
075.	HINGE ACCESS DOOR
080.	DOOR HANDLE (QTY. 4)
085.	HINGED INSPECTION DOOR ASSY: CLEANOUT-FINITUBE REMOVAL
095.	10 GA. CARBON STEEL EXTERIOR
100.	FINITUBING ASSY.: 1.0 OD x .065W TP316 SA 249 STAINLESS STEEL TUBE W/ ALFUSE FIN BRAZE/WELDED TO THE TUBE.

NOTES: (UNIT QUANTITY:1)

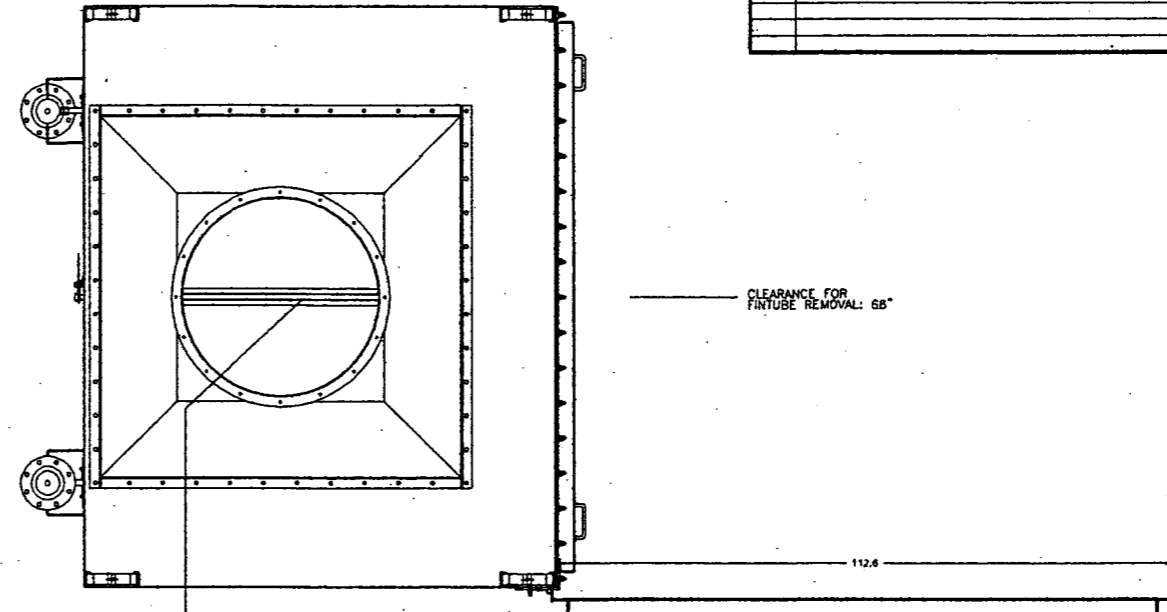
A.	DOUBLE COAT PRIMED AND PAINTED BLACK SATIN
B.	MAXIMUM INLET EXHAUST TEMPERATURE: 750° F
C.	ASME "U" STAMPED @ 300 PSIG; SEC. VIII DIV. 1
D.	OTHER COMPONENTS SUPPLIED PER ECONOMIZER BUT NOT SHOWN: -(1) 3/4" NPT RELIEF VALVE: SET @ 300 PSIG -(2) EXHAUST GAS THERMOMETERS, 150-750°F., 5" DIAL, ADJUSTABLE ANGLE -(2) LIQUID THERMOMETERS, 50-500°F., 3" DIAL, ADJUSTABLE ANGLE WITH WELL -(2) 80" x 68" MATING FLANGE GASKETS -(1) EXPANSION JOINT 27" x 52" ID
E.	PIPING INSULATED BY OTHERS AS REQUIRED.



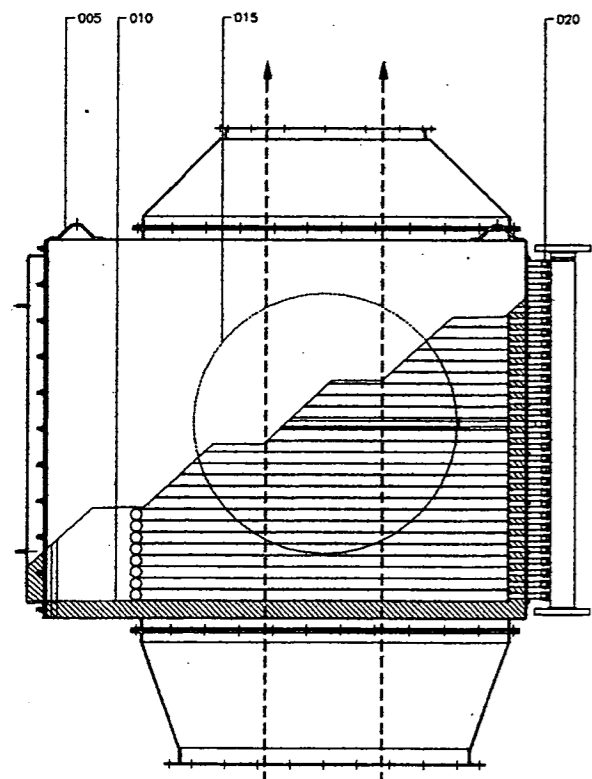
ADAPTER INLET FLANGE DETAIL



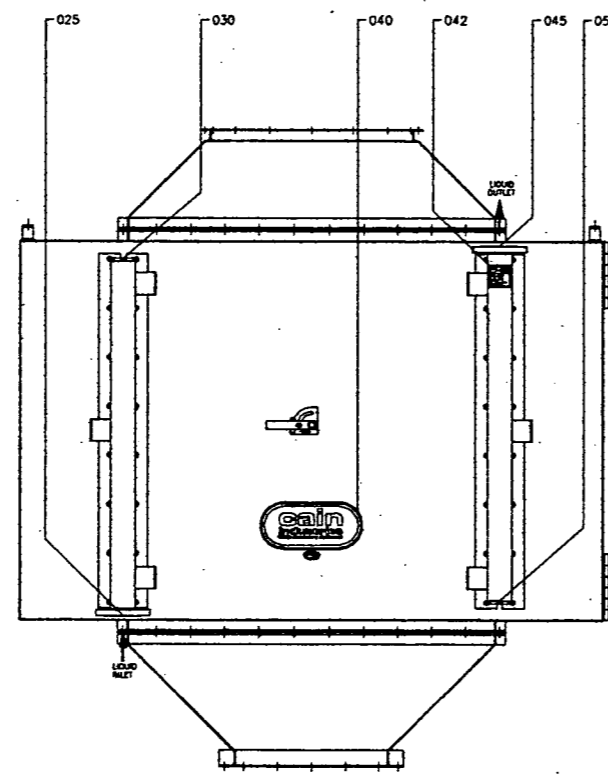
**TOP VIEW
CUT AWAY**



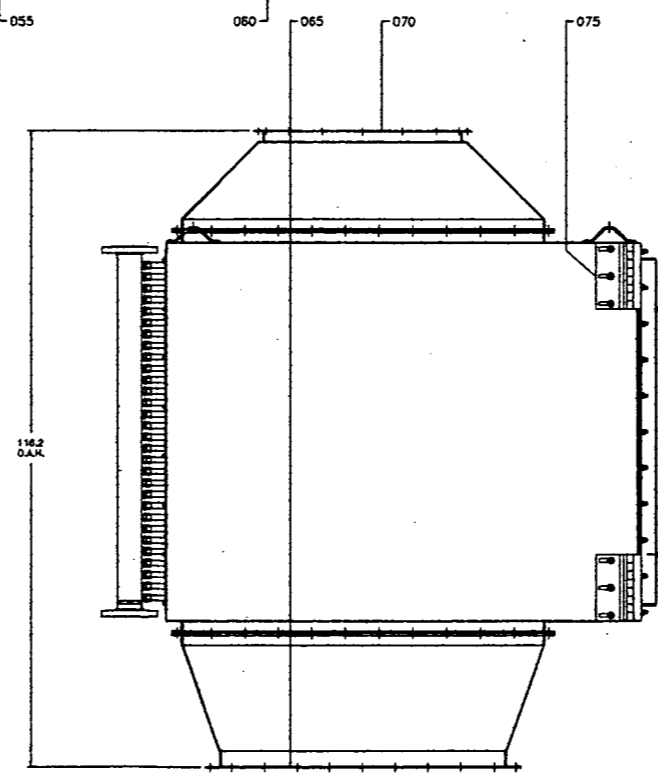
TOP VIEW



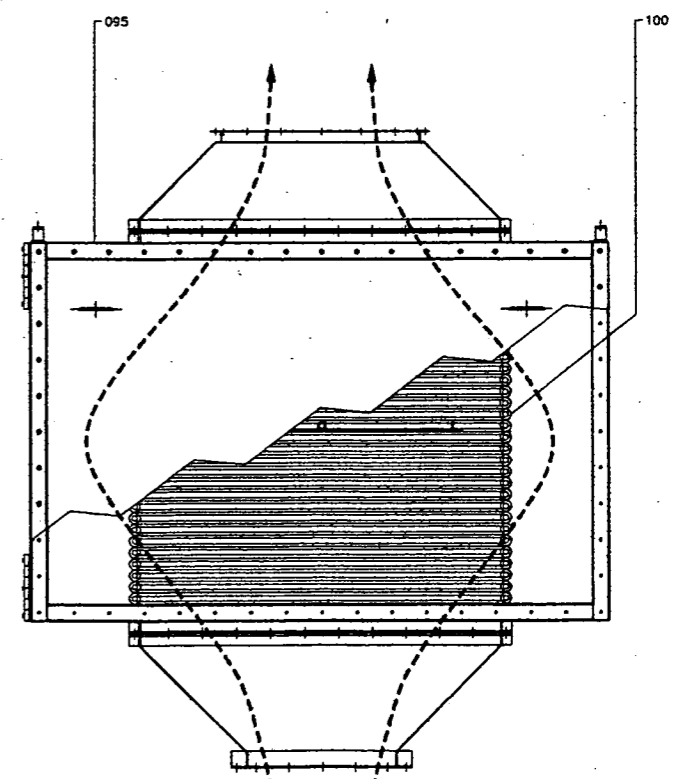
LEFT SIDE VIEW



HEADER VIEW



RIGHT SIDE VIEW



DOOR VIEW

OPTIONAL EQUIPMENT AVAILABLE:

THE FOLLOWING IS A PARTIAL LIST OF OPTIONAL INSTALLATION COMPONENTS. PLEASE CONTACT SALES FOR PRICE & DELIVERY.

- EXHAUST PIPING
- EXHAUST ELBOWS & TEES
- EXPANSION JOINTS: CLOTH TYPE AND STAINLESS BELLOWS
- STRUCTURAL SUPPORT STANDS
- INSULATION BLANKETS FOR ELBOWS AND PIPING

FOR: BUNGE-ERGON VICKSBURG LLC DWG#: 35499 REV: 0 SCALE: 1/16"=1"

C/O: CAMPBELL-SEVEY			
S.O.: 8596	P.O.: 067891	DRN: JMB	TOLERANCES: -
REF: 99453	WGT: 4800#	APP:	DATE: 120506

RTR-166K26ALS
BOILER ECONOMIZER
RH UNIT



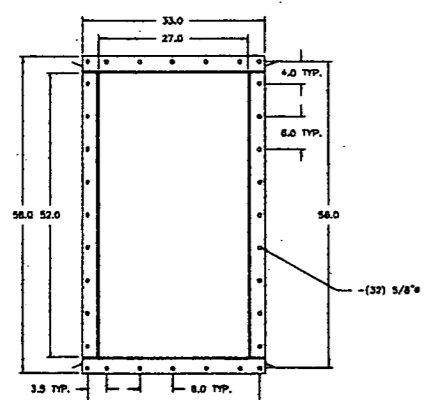
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NOMENCLATURE:

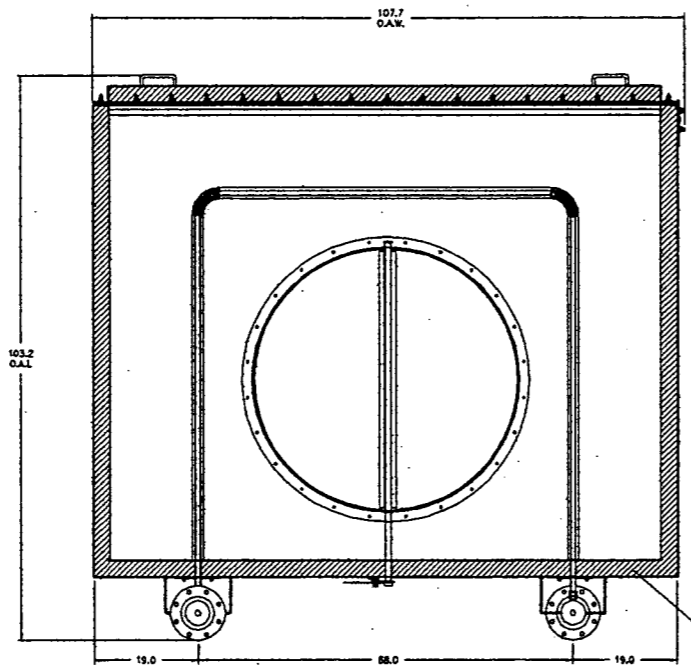
005.	LIFTING LUG (QTY. 4)
010.	STAINLESS STEEL INTERIOR LINER
015.	STAINLESS STEEL DAMPER ASSEMBLY (SHOWN IN THE BYPASS POSITION)
020.	COMPRESSION FITTING, FINITUBE TO HEADER
025.	3/4" NPT DRAIN CONNECTION
030.	4" 300# CARBON STEEL FLANGED LIQUID OUTLET CONNECTION
035.	ASME "U" STAMP, 300 PSIG (SEC. VIII DIV. I)
040.	CAIN LOGO AND SERIAL NO. ID.
045.	3/4" NPT VENT/SAFETY VALVE CONNECTION
050.	4" 300# CARBON STEEL FLANGED LIQUID INLET CONNECTION
055.	3" THKS. FACTORY INSULATION
060.	STAINLESS STEEL DAMPER SHAFT
065.	STACK ADAPTER INLET: 27" x 52" ID FLANGE (SEE DETAIL)
070.	STACK ADAPTER OUTLET: 36.125" ID RING 2" x 2" x 0.1875" ANGLE W/ (16) 0.4375" HOLES ON A 38.375" B.C.
075.	HINGE, ACCESS DOOR
080.	DOOR HANDLE (QTY. 4)
085.	HINGED INSPECTION DOOR ASSY: CLEANOUT-FINITUBE REMOVAL
095.	10 GA. CARBON STEEL EXTERIOR
100.	FINITUBING ASSY: 1.0 OD x .065W TP316 SA 249 STAINLESS STEEL TUBE W/ ALFUSE FIN BRAZE/WELDED TO THE TUBE.

NOTES: (UNIT QUANTITY:1)

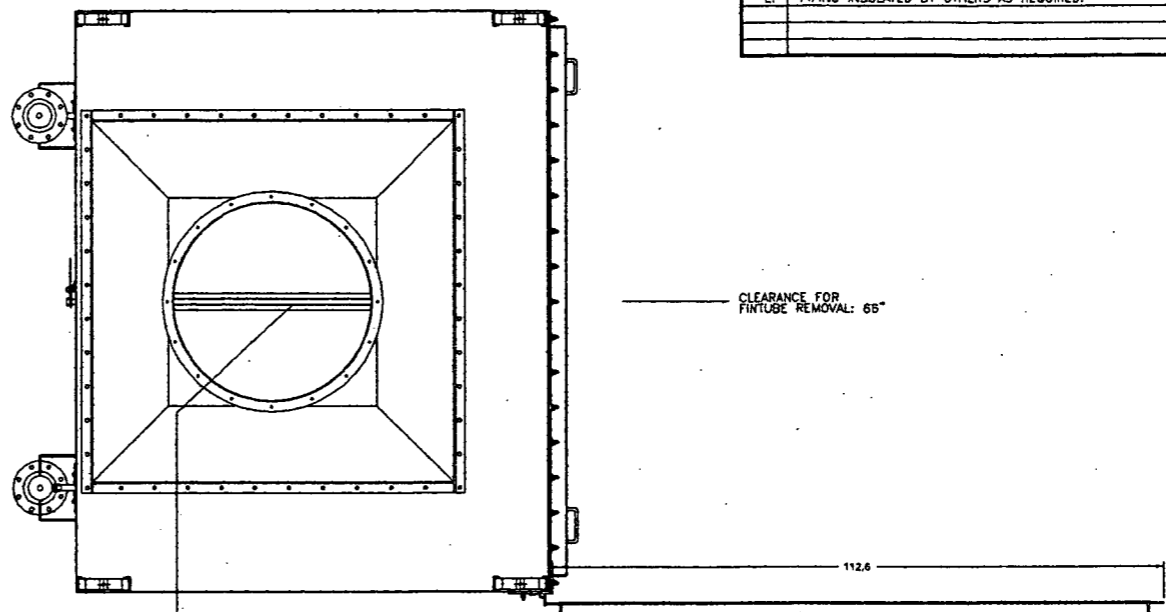
A.	DOUBLE COAT PRIMED AND PAINTED BLACK SATIN
B.	MAXIMUM INLET EXHAUST TEMPERATURE: 750° F
C.	ASME "U" STAMPED @ 300 PSIG, SEC. VIII DIV. I
D.	OTHER COMPONENTS SUPPLIED PER ECONOMIZER BUT NOT SHOWN: - (1) 3/4" NPT RELIEF VALVE: SET @ 300 PSIG - (2) EXHAUST GAS THERMOMETERS, 150-750°F., 5" DIAL, ADJUSTABLE ANGLE - (2) LIQUID THERMOMETERS, 50-500°F., 3" DIAL, ADJUSTABLE ANGLE WITH WELL - (2) 66" x 66" MATING FLANGE GASKETS - (1) EXPANSION JOINT 27" x 52" ID
E.	PIPING INSULATED BY OTHERS AS REQUIRED.



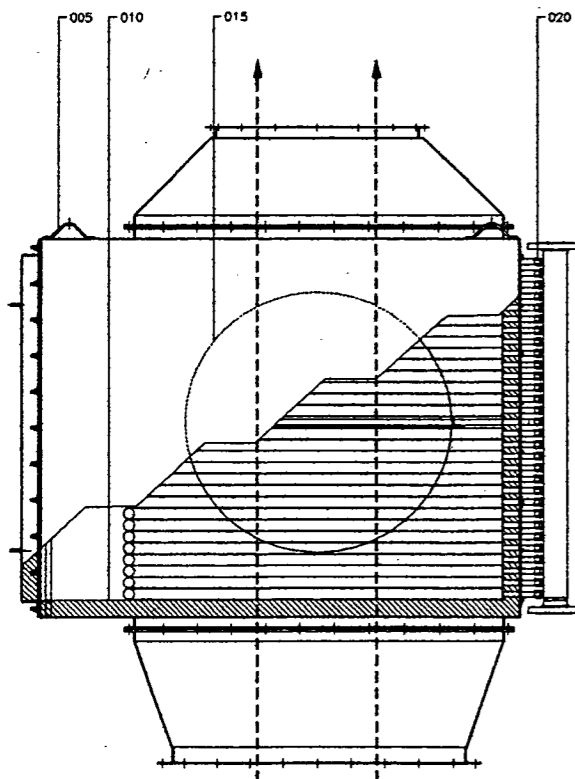
ADAPTER INLET FLANGE DETAIL



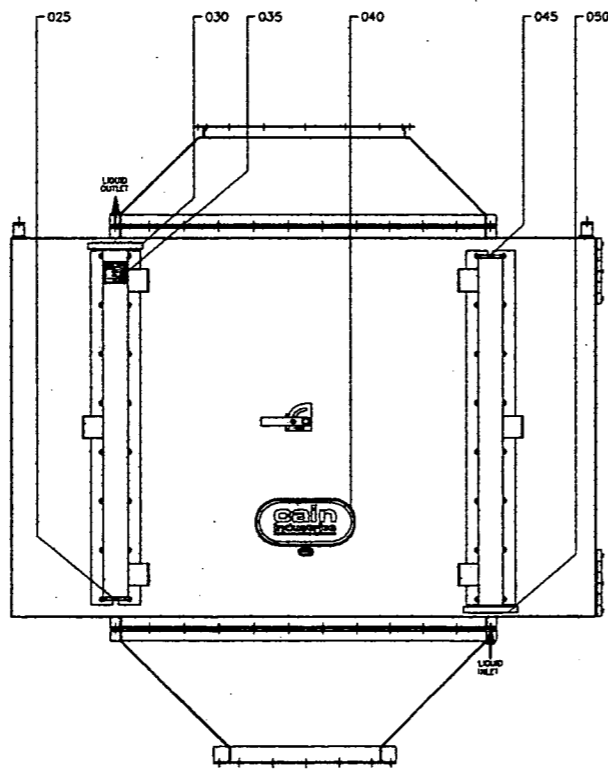
**TOP VIEW
CUT AWAY**



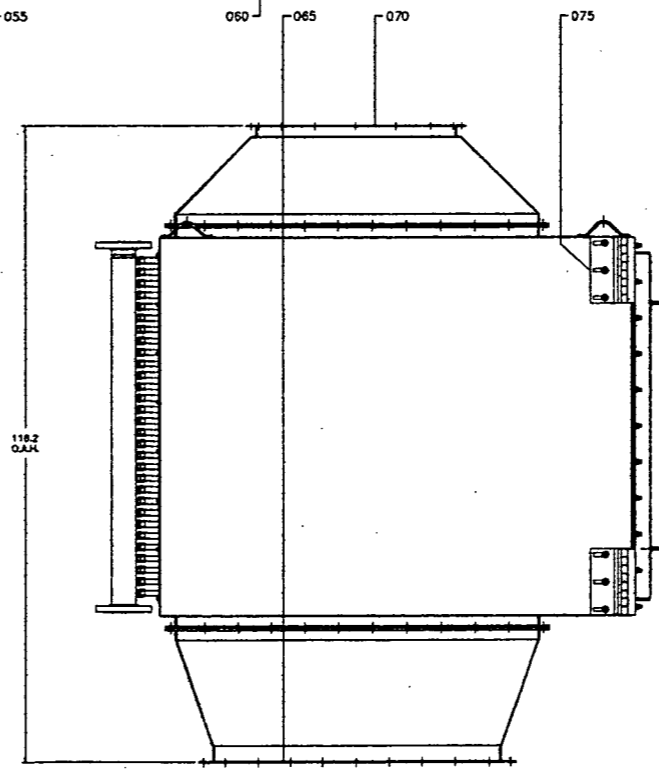
TOP VIEW



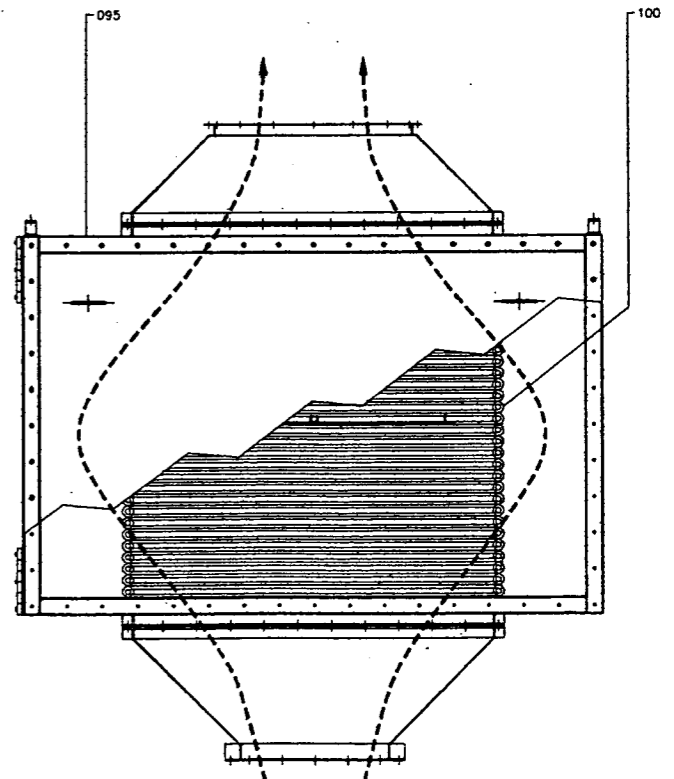
LEFT SIDE VIEW



HEADER VIEW



RIGHT SIDE VIEW




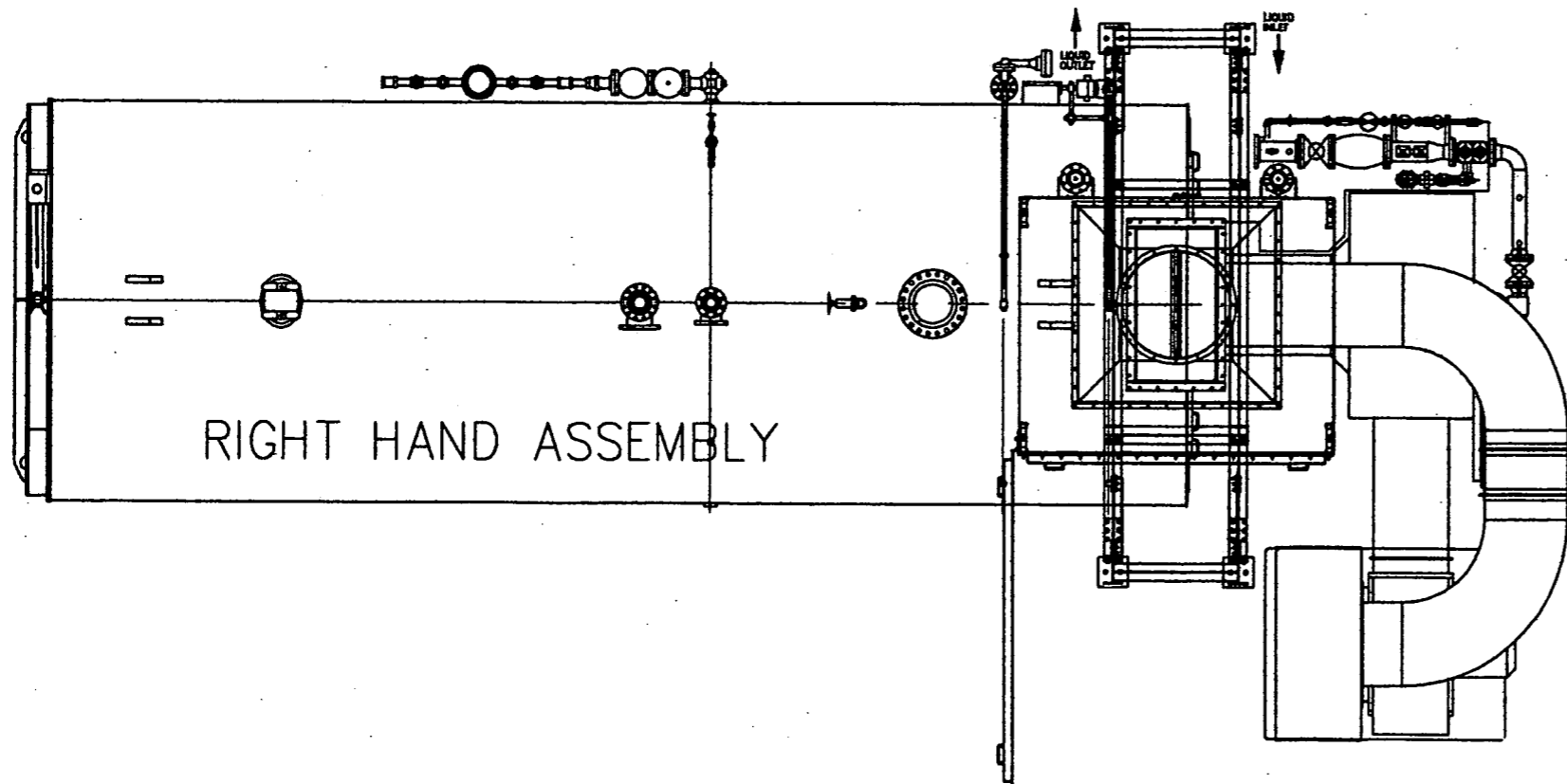
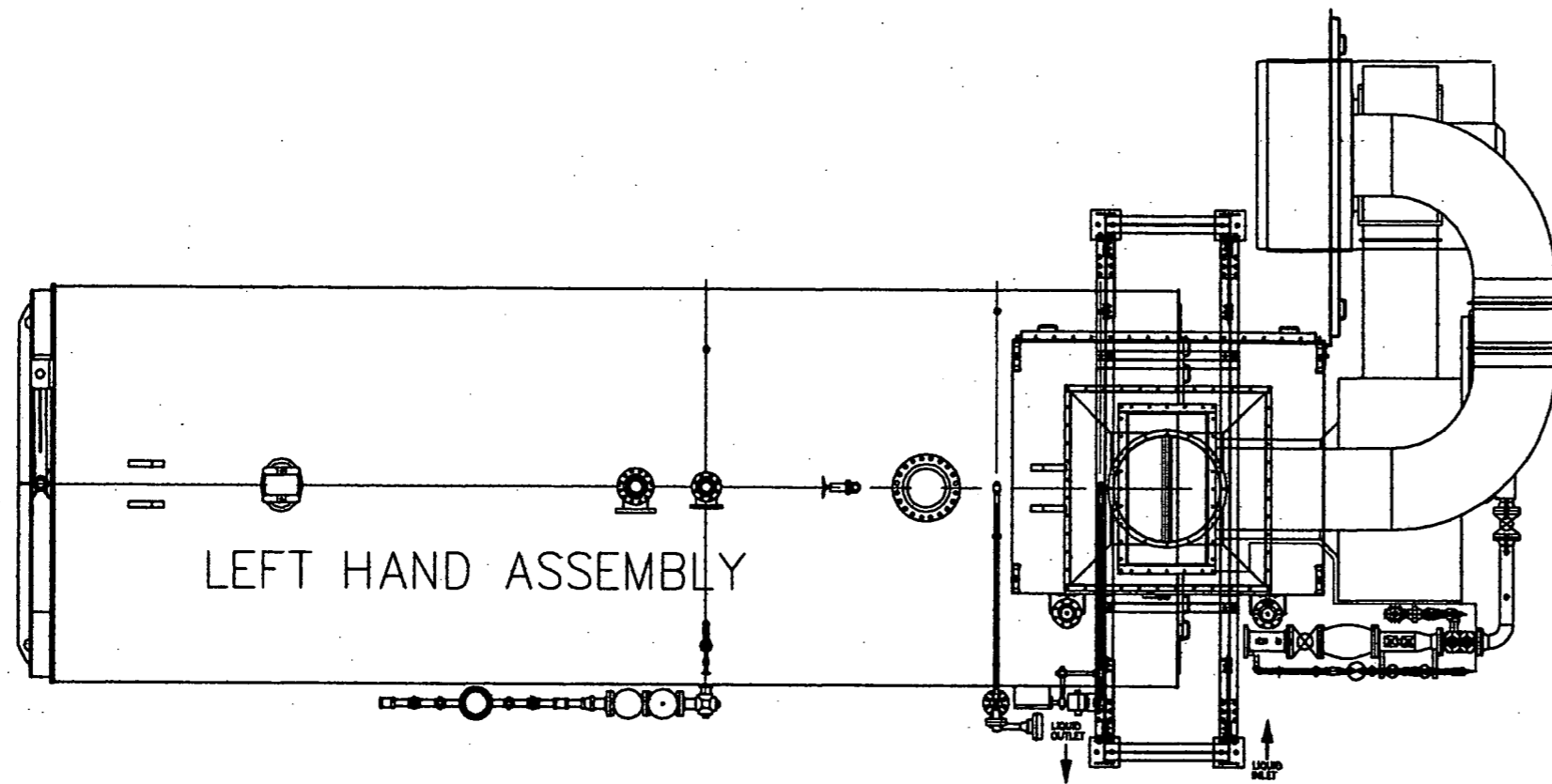
DOOR VIEW

OPTIONAL EQUIPMENT AVAILABLE:
THE FOLLOWING IS A PARTIAL LIST OF OPTIONAL INSTALLATION COMPONENTS. PLEASE CONTACT SALES FOR PRICE & DELIVERY.

-	EXHAUST PIPING
-	EXHAUST ELBOWS & TEES
-	EXPANSION JOINTS: CLOTH TYPE AND STAINLESS BELLOWS
-	STRUCTURAL SUPPORT STANDS
-	INSULATION BLANKETS FOR ELBOWS AND PIPING


FOR: BUNGE-ERCON VICKSBURG LLC		DRWG: 35499	REV: 0	SCALE: 1/16"=1"
C/O: CAMPBELL-SEVEY				
S.O.: 8596	P.O.: D87881	DRW: JMB	TOLERANCES: -	
REF: 99453	WGT: 4800#	APP:	DATE: 120506	
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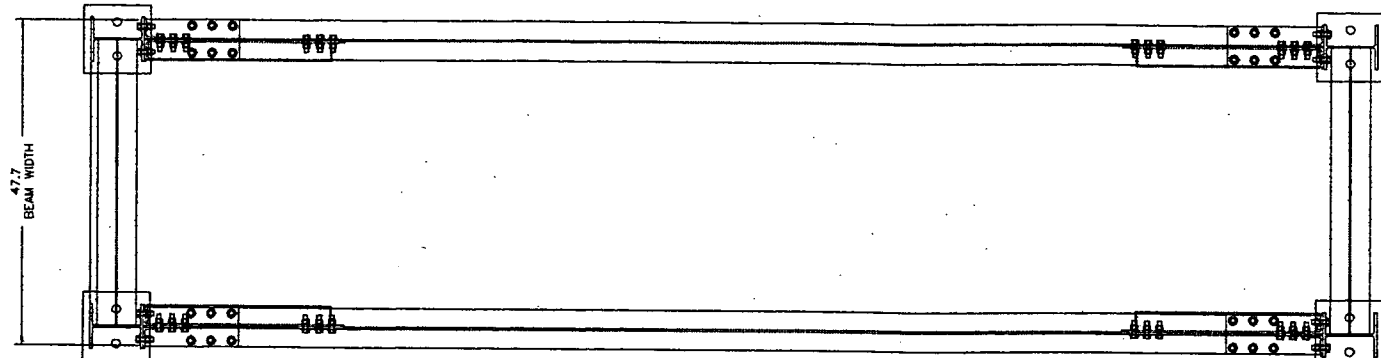




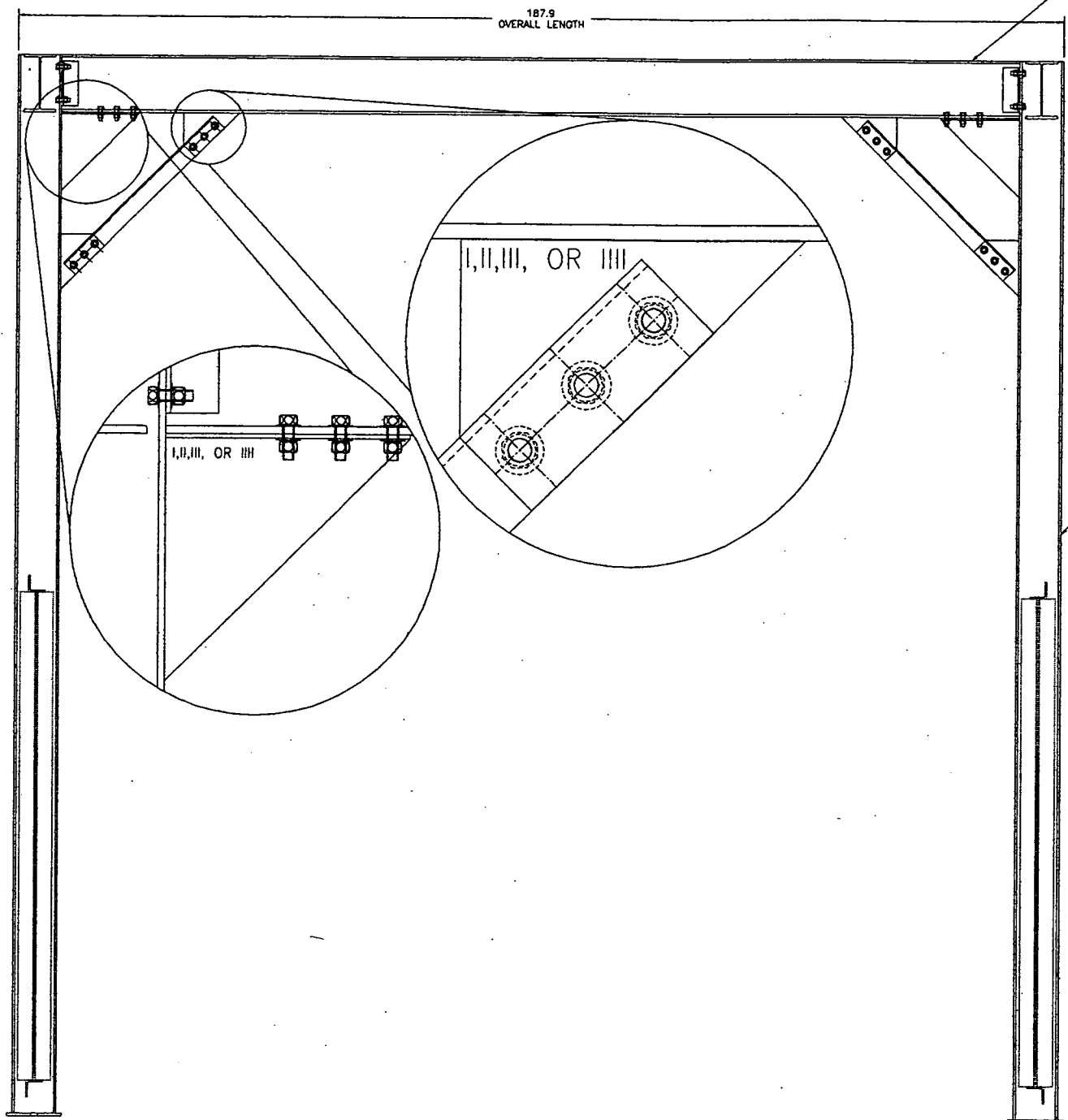
ASSEMBLY PROCEDURE

- STAND THE (2) VERTICAL ASSEMBLIES INTO POSITION AS SHOWN IN DRAWING #41289
- USING THE 5/8" BOLT ASSEMBLIES PROVIDED, LOOSELY BOLT THE (2) HORIZONTAL BEAMS TO THE VERTICAL ASSEMBLIES (NOTE THE MARKINGS ON THE GUSSETS THAT IDENTIFY THE CORRECT ORIENTATION, SEE EXPLODED VIEW)
- LOOSELY BOLT THE (4) ANGLE IRON CORNER SUPPORTS IN PLACE (5/8" BOLTS)
- CHECK THAT THE OVERALL LENGTH AT THE BOTTOM MATCHES THE OVERALL LENGTH AT THE TOP
- TIGHTEN ALL BOLT ASSEMBLIES INSTALLED SO FAR
- PLACE THE ECONOMIZER ON THE STAND AND LOOSELY BOLT THE BEAMS ON THE ECONOMIZER TO THE SHORT VERTICAL BEAMS THAT ARE WELDED TO THE TOP OF THE STAND (5/8" BOLTS)
- LOOSELY BOLT THE BOILER EXHAUST OUTLET/ECONOMIZER INLET ADAPTER TO THE ECONOMIZER USING THE 3/8" BOLT ASSEMBLIES PROVIDED
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- TIGHTEN ALL REMAINING BOLT ASSEMBLIES
- CONTINUOUSLY WELD THE 3" ANGLE FLANGE ON THE DOWEL SPACER THAT CONNECTS TO THE EXPANSION JOINT

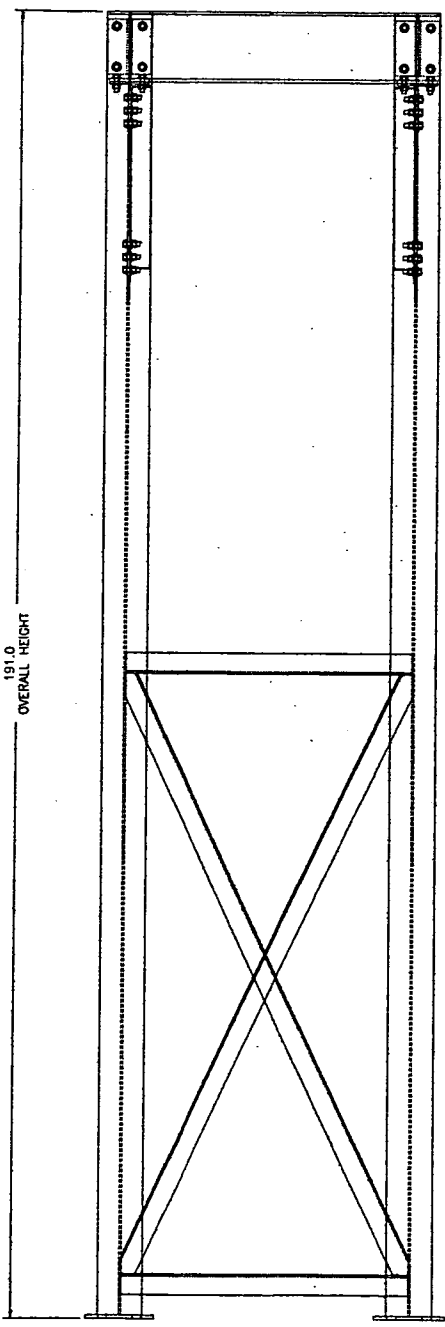
FOR: BUNGE-ERGON VICKSBURG LLC		DRW: 35499	REV: 0	SCALE: NONE
C/D: CAMPBELL-SEVEY				
S.O.: 8596	P.O.: 08789	DRG: JMB	TOLERANCES: -	
REF: 98453	WGT: 4800#	APP:	DWD: 120506	
RTR-166K26ALS		SUPPORT STAND		
LH/RH ASSEMBLY				
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TOP VIEW



FRONT VIEW



SIDE VIEW

ASSEMBLY PROCEDURE

- STAND THE (2) VERTICAL ASSEMBLIES INTO POSITION AS SHOWN IN DRAWING #51289
- USING THE 5/8" BOLT ASSEMBLIES PROVIDED, LOOSELY BOLT THE (2) HORIZONTAL BEAMS TO THE VERTICAL ASSEMBLIES (NOTE THE MARKINGS ON THE GUSSETS THAT IDENTIFY THE CORRECT ORIENTATION, SEE EXPLODED VIEW)
- LOOSELY BOLT THE (4) ANGLE IRON CORNER SUPPORTS IN PLACE (5/8" BOLTS)
- CHECK THAT THE OVERALL LENGTH AT THE BOTTOM MATCHES THE OVERALL LENGTH AT THE TOP
- TIGHTEN ALL BOLT ASSEMBLIES INSTALLED SO FAR
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- TIGHTEN ALL REMAINING BOLT ASSEMBLIES
- CONTINUOUSLY WELD THE 3" ANGLE FLANGE ON THE DOWEL SPACER THAT CONNECTS TO THE EXPANSION JOINT

FOR: BUNGE-ERGON VICKSBURG LLC				DRWG: 35499	REV: 0	SCALE: 5/64"=1"
C/D: CAMPBELL-SEVEY						
S.O.: 8596	P.O.: 087881	DRN: JMB	TOLERANCES: -	RTR-166K26ALS SUPPORT STAND		
REF: 99453	WGT: 4800#	APP:	DATE: 120506			



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