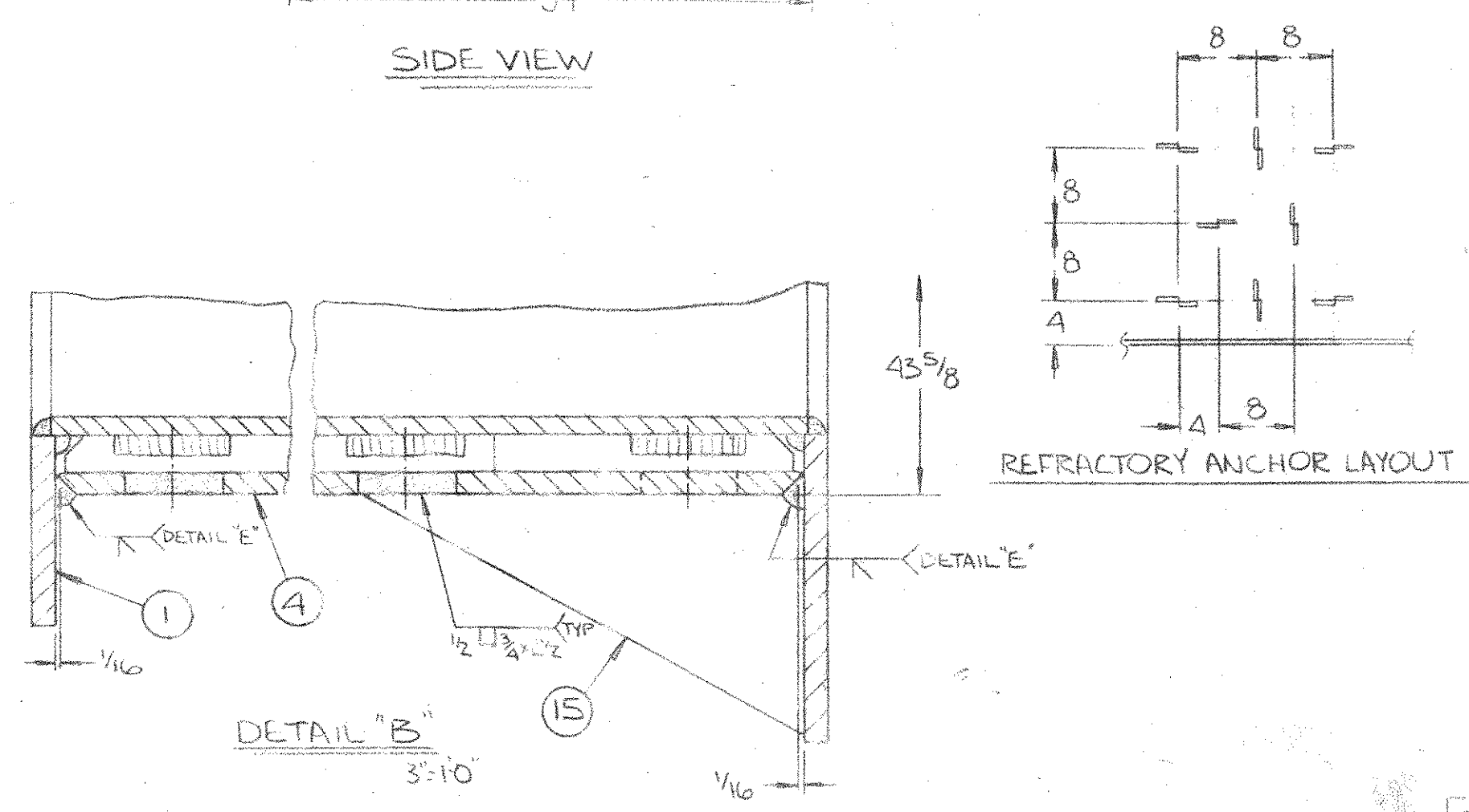
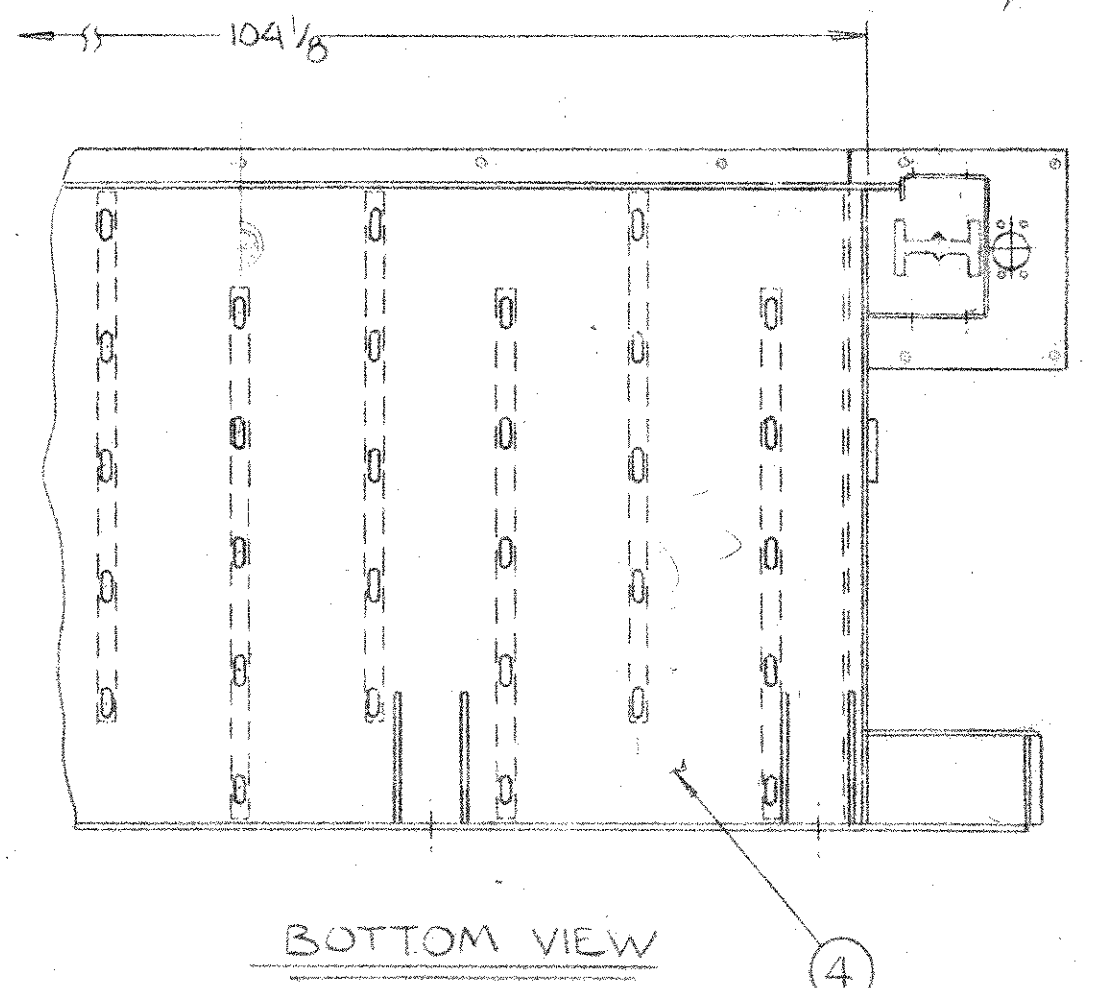
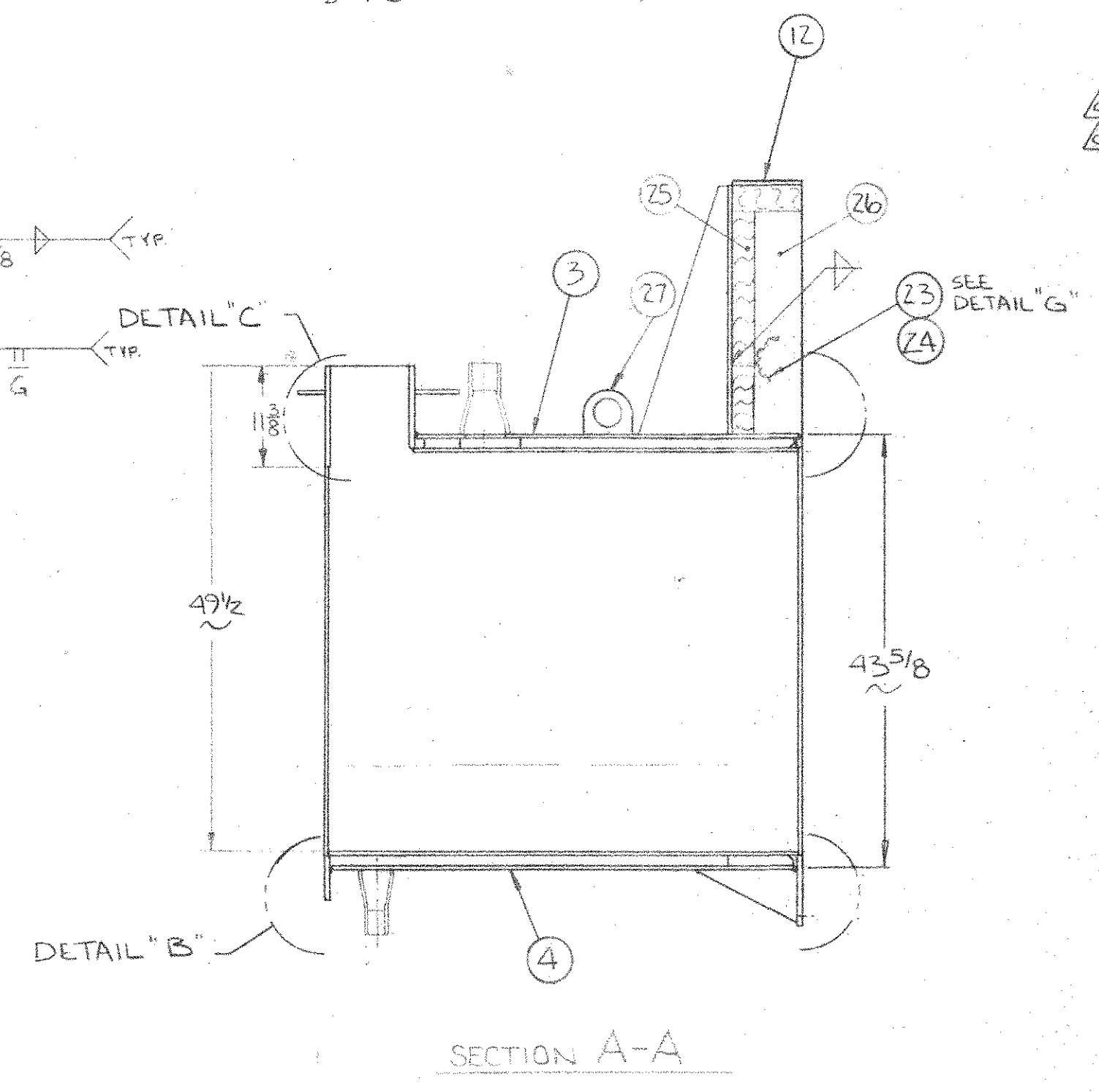
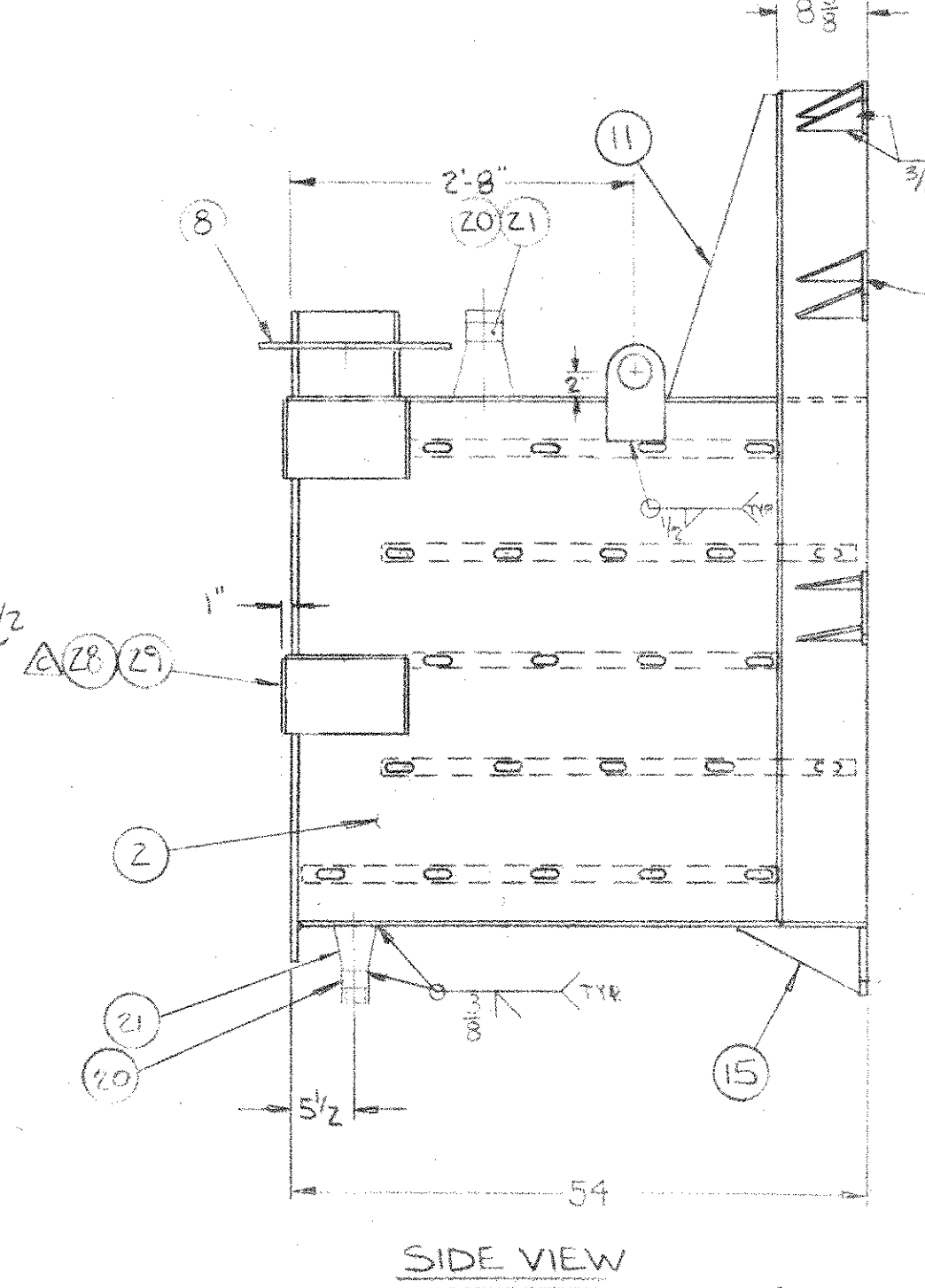
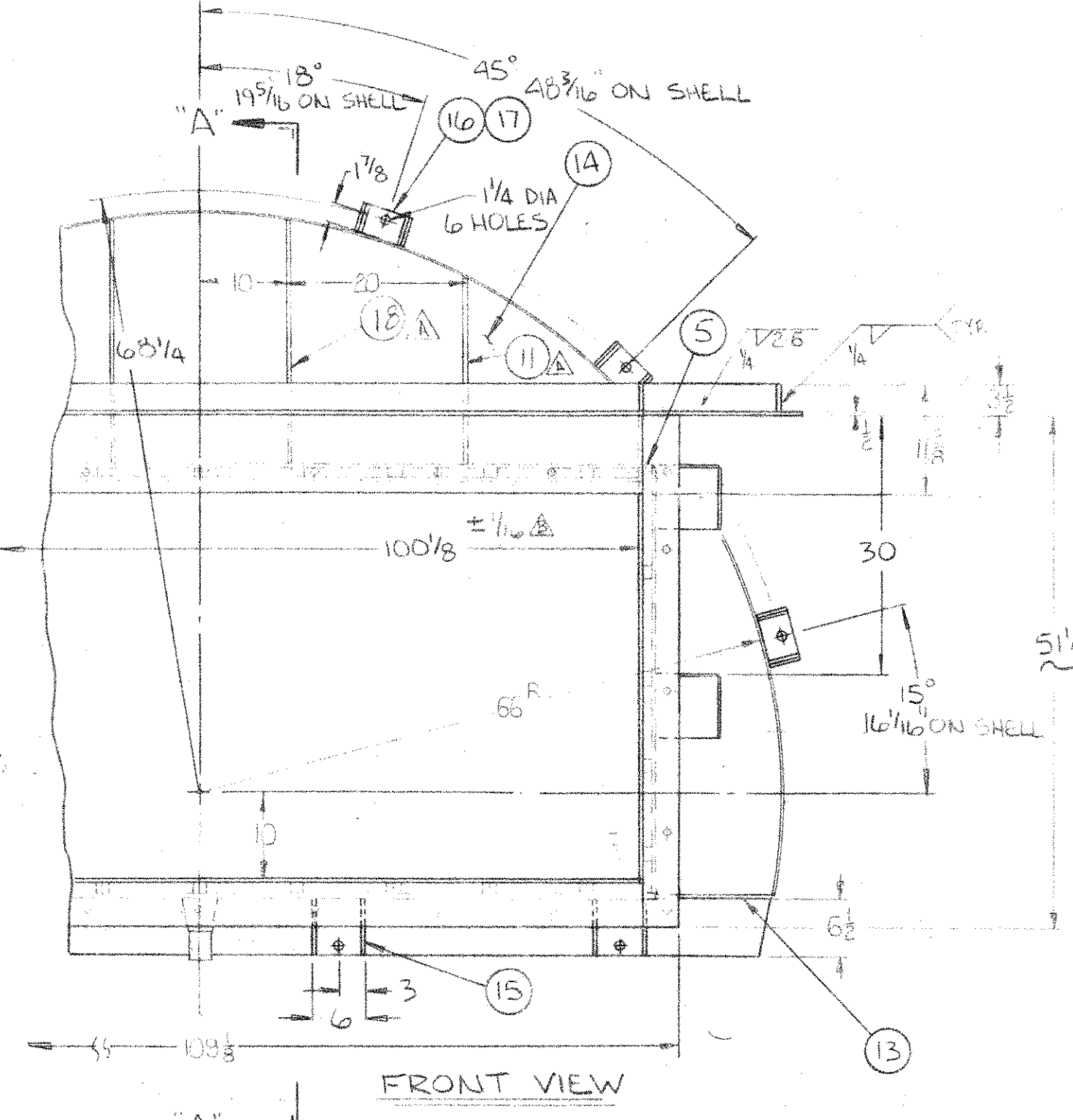


WELDING SEQUENCE
 1- ITEMS 2,3,4,5 -
 - CUT, FIT, LOCATE & TACK - INSPECT
 - ROOT PASS & INSPECT
 - WELD COMPLETE & INSPECT



DETAIL 'G'
 ANCHORS TO BE WELDED WITH SS. ELECTRODE 30415 OR BETTER.
 ANCHOR PRONGS TO BE SPREAD 45° FROM C AS SHOWN AFTER INSULATION IS INSTALLED.
 ANCHORS TO BE COATED WITH ITEM 24 BEFORE CASTING REFRACTORY.

| GROUP | | | PARTS LIST | | DESCRIPTION |
|-------|------|------|---------------|--|--------------------------------|
| Q2 | Q1 | ITEM | PART | | |
| | 1 | 1 | D14F-0031-G01 | | 100 x 38 TAP-IN SHELL SUB-ASSY |
| | 2 | 2 | A14-0100-G01 | | WATER COOLED SIDE PLATE |
| | 1 | 3 | B14-0101-G01 | | WATER COOLED TOP PLATE |
| | 1 | 4 | B14-0102-G01 | | WATER COOLED BOTTOM PLATE |
| | 2 | 5 | A14-0103-G01 | | WATER COOLED TOP PLATE |
| | 1 | 6 | A14-0104-P01 | | FLANGE SEGMENT |
| | 1 | 7 | A14-0104-P02 | | FLANGE SEGMENT |
| | Z | 8 | A14-0105-G01 | | FLANGE PLATE |
| | 4 | 9 | | | 1/2 x 3 FB x 15 A 36 |
| | Z | 10 | | | 1/2 x 3 FB x 8 7/8 A 36 |
| | 2 | 11 | A14-0107-P01 | | GUSSET |
| | 1 | 12 | | | 3/8 x 8 FB x 2 3/4 A 36 |
| | Z | 13 | | | 3/8 PLT 7 3/8 x 12 15/16 A 285 |
| | 1 | 14 | B14-0106-G01 | | FACE PLATE |
| | 8 | 15 | | | 3/8 PLT 6 1/4 x 11 1/4 A 285 |
| | 6 | 16 | | | 3/8 PLT 3 5/8 x 6 A 285 |
| | 12 | 17 | | | 3/8 PLT 3 3/4 x 6 1/2 A 285 |
| | 2 | 18 | A14-0107-P02 | | GUSSET |
| | | 19 | | | |
| | 2 | 20 | | | 5 x 3 SCH 40 REDUCER |
| | 2 | 21 | | | 3 SCH 40 PIPE x 3 TOL |
| | | 22 | | | |
| | 65 | 23 | | | 7 REFRACTORY ANCHOR |
| | 1 | 24 | | | LOPPERS NO 50 BITUMASTIC 5/16 |
| | 56FT | 25 | | | 2 1/2" MONOBLOCK INJS |
| | 13CW | 26 | | | PULCAST STEEL MIX REFRACTORY |
| | 2 | 27 | B-14-0079-G01 | | LIFTING LUG |
| | Z | 28 | C14E-0002-G01 | | GUIDE WHEEL BOX |
| | Z | 29 | C14E-0002-G02 | | GUIDE WHEEL BOX |
| | | 30 | | | |
| | | 31 | | | |
| | | 32 | | | |
| | | 33 | | | |
| | | 34 | | | |
| | | 35 | | | |
| | | 36 | | | |
| | | 37 | | | |
| | | 38 | | | |
| | | 39 | | | |
| | | 40 | | | |

NOTES:
 ▽ HYDROSTATIC TEST AT 135 PSI.
 ▽ ITEM 8 MUST SET FLUSH AND LEVEL WITH ITEMS 6 & 7 TO INSURE A GOOD SEAL WITH DOOR COVER.
 3 - THE FOLLOWING IS THE WELD ROD TO BE USED FOR FABRICATION OF THE TAP-IN E-7108 WELDING RODS MUST BE STORED IN AN ELECTRODE OVEN 24 HOURS PRIOR TO USE.

| | | | | | |
|---|---|---------------------------|-----------|--------------|------------------|
| HARFORD | P4805 | 01 | 4466 3714 | C-15L-0062 | |
| CSI PROCESS SPEC | NUMBER | GROUP | B/M | D/L | NEXT HIGHER ASSY |
| 100 x 38 TAP-IN HOUSING CS-3000E | | | | | |
| Consumat Systems, Inc. | | RICHMOND, VIRGINIA U.S.A. | | | |
| D | ADD Q.D. TOLERANCES | 9-19-86 | DMH | | |
| C | REVISE ITEM 8 TO FIT NEW U-FRAME. REMOVE ITEM 11, ROLLER SUPPORT. ADD ITEMS 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40. | 09-12-86 | COTT | | |
| B | ADD Q.D. TOLERANCES | 5-11-86 | DMH | | |
| A | CHANGE 2 X 2 TUB SIZE. ADDED HAND-DRAWING | 7-15-84 | DMH | | |
| NO. | REVISION | DATE | BY | DO NOT SCALE | |

TOLERANCES:
 NORMAL ± 1/8" EXCEPT AS NOTED. TOLERANCES APPLY PARTICULARLY TO OVER-ALL DIMENSIONS AND MUST NOT BE ACCUMULATIVE. HOLE LOCATION DIMENSIONS MUST BE HELD TO ± 1/32".

| | | | | | | | |
|-------|----------|-------|--------------|-------|----------|-------------|-----------|
| DRAWN | COTT | SCALE | 3/4" = 1'-0" | DRAWN | COTT | DRAWING NO. | D-14-0099 |
| DATE | 07-15-86 | CHK'D | DMH | DATE | 07-15-86 | SHEET | OF 2 |