

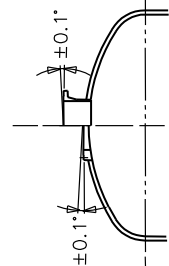
GENERAL NOTES

1. THESE TOLERANCES SUPPLEMENT THE CODE TOLERANCES AND ARE ALSO GOVERNING.
2. TOLERANCES APPLY FOR ALL TYPES OF PRESSURE VESSELS WHEREVER APPLICABLE.
3. SEE SPECIFICATION, REQUISITION OR VESSEL DRAWING FOR ANY EXCEPTION TO THIS STANDARD.
4. DATUM LINE SHALL BE MARKED (INSIDE AND OUTSIDE) WITH REFERENCE POINTS.
5. TOLERANCES ON THE WORKPOINT OF CLIPS IS 6mm ON ORIENTATION AND ELEVATION.
6. MAXIMUM VALUE FOR OUT OF ROUNDNESS OF COLUMN SECTIONS WITH TRAYS IS
 - ON RADIUS $\pm 1.0/400$
 - ON DIAMETER $\pm 1.0/200$
7. DISTANCE BETWEEN REBOILER NOZZLES SHALL BE ± 1.5

VERTICAL VESSELS SHALL BE CHECKED FOR PLUMBNESS. AFTER THE RING SECTIONS HAVE BEEN ASSEMBLED, THE OUTSIDE SURFACE OF THE CYLINDER SHALL NOT VARY FROM A STRAIGHT VERTICAL LINE MORE THAN 1mm IN ANY 1m SHELL LENGTH, NOR MORE THAN 20mm IN THE TOTAL LENGTH

1mm PER 1M LENGTH
MAX. 20mm.

THIS DIMENSION MAY BE ADJUSTED TO MAINTAIN OVERALL HEIGHT OF TOWER.



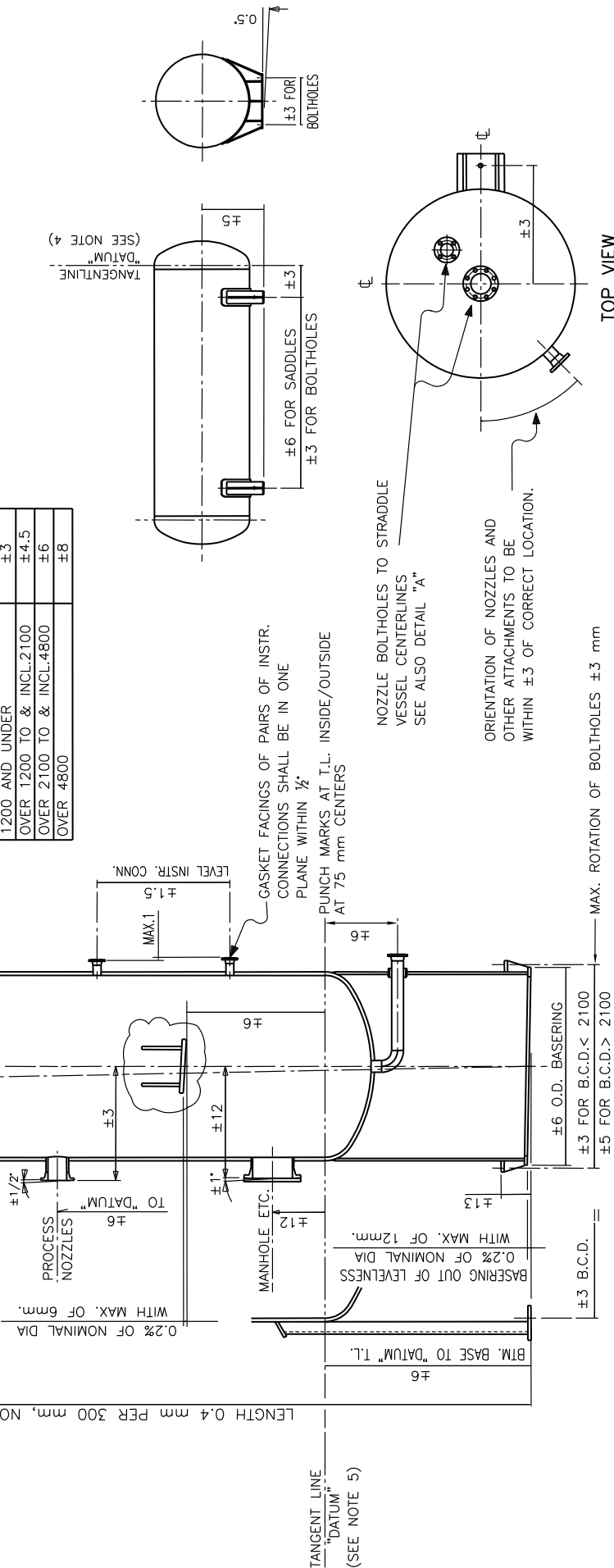
AGITATOR CONN.

LENGTH 0.4 mm PER 300 mm, NOT MORE THAN 13 mm

SHELL TOLERANCES IN ADDITION TO CODE TOLERANCES: DEVIATION FROM SPECIFIED INSIDE DIAMETER AS MEASURED BY EXTERNAL STRAPPING.

DIAMETER SPECIFIED	TOLERANCE
1200 AND UNDER	± 3
OVER 1200 TO & INCL. 2100	± 4.5
OVER 2100 TO & INCL. 4800	± 6
OVER 4800	± 8

FOR COLUMNS WITH TRAYS, SEE ALSO NOTE 6



DETAIL "A"

MAX. ROTATION 1.5mm MEASURED AT BOLTCIRCLE

"DATUM" TANGENTLINE (SEE NOTE 4)

GASKET FACINGS OF PAIRS OF INSTR. CONNECTIONS SHALL BE IN ONE PLANE WITHIN $\frac{1}{2}$ "

PUNCH MARKS AT T.L. INSIDE/OUTSIDE AT 75 mm CENTERS

NOZZLE BOLTHOLES TO STRADDLE VESSEL CENTERLINES SEE ALSO DETAIL "A"

ORIENTATION OF NOZZLES AND OTHER ATTACHMENTS TO BE WITHIN ± 3 OF CORRECT LOCATION.

MAX. ROTATION OF BOLTHOLES ± 3 mm

TOP VIEW

CONSTRUCTION TOLERANCES FOR PRESSURE VESSELS

ISSUE 6
DATE 1 DEC '00
SHEET 1 OF 2

BN-DS-A 3