

ALL TAILED DIMS ARE FROM WORK LINE UNLESS OTHERWISE NOTED

NOT TRUE ORIENTATION

IN ACCORDANCE WITH ASME CODE - SEC. VIII, DIV. 1, 2001 EDITION; N/A ADDENDA.  
 CODE STAMP REQ'D: YES NATL BD NO. REQ'D: YES OUTSIDE INSP REQ'D: NO  
 ADD'L SPECS: NONE

DESIGN PRESS: 50 PSI AT DESIGN TEMP: 250° F  
 MAWP (INT): 50 PSI AT MAX TEMP: 250° F  
 MAWP (EXT): - AT MAX TEMP: -  
 LIMITED BY: DESIGN  
 MDMT: -20° F AT: 50 PSI  
 JOINT EFFICIENCY (HEAD): 70% JOINT EFFICIENCY (SHELL): 70%  
 RADIOGRAPHY: NONE STRESS RELIEVE: NONE  
 HYDRO TEST PRESS: 75 PSI BASED ON: MIN BY ITS  
 CORROSION ALLOWANCE: NONE LETHAL SERVICE: NO  
 ADD'L NDE/NDT:

MATERIAL: (DOMESTIC OR FOREIGN) MILL TEST REPORTS REQ'D: PRESS. RETAIN'G MTL  
 SHELL: SA516-70N (HIC RESISTANT) FLG/CPL: SA105N  
 HEADS: SA516-70N (HIC RESISTANT) PIPE: SA106-B SMLS  
 HEAD TYPE: 2:1 ELLIP EXT ATTACH.: SA516-70/SA36  
 FITTINGS: SA234-WPB (NORMALIZED) INT ATTACH.: SA516-70  
 STUDS/NUTS: SA193-B7/SA194-2H INSULATION: NONE  
 GASKETS: SPIR WD 316SS/GRAFOIL SUPPORTS: SA516-70/SA36

PAINTING:  
 EXTERNAL:  
 SURFACE PREP: PER SSPC-SP10  
 COAT 1: ZINC PRIMER, 2-3 MILS DFT  
 COAT 2: H.B. POLYAMIDE EPOXY, 4-6 MILS DFT  
 COAT 3: ALIPHATIC POLYURETHANE, 2-3 MILS DFT  
 INTERNAL: NONE

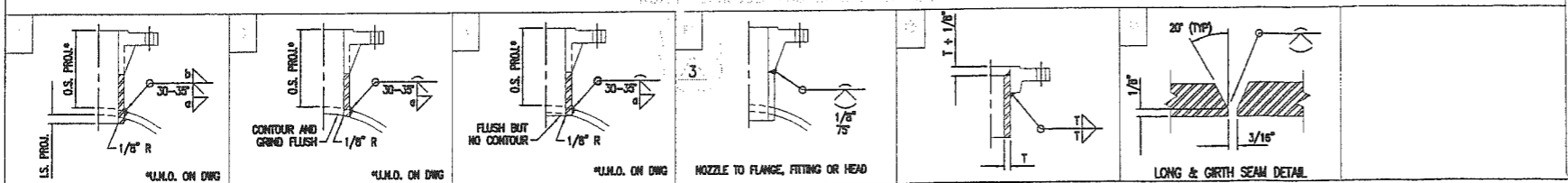
SHIPPING WT: 1,900 LBS WT FULL OF WATER: 6,000 LBS

- NOTICE TO THE BUYER:
- WELD PER ASSIGNED PROJECT WELDING LIST-1695.
  - GRIND ALL ROUGH EDGES & CORNERS. RADIUS ALL NOZZLES 1/8" MINIMUM RADIUS.
  - FLANGED BOLT HOLES TO STRADDLE NORMAL CENTER LINES.
  - NO INTERNAL PROJECTION SHOWN IN ACCORDANCE WITH CALCULATIONS, HOWEVER, MINIMAL NOZZLE PROJECTION IS ALLOWED FOR SHOP FIT-UP.

- SLEEVING NOTES:
- ALL EXPOSED NOZZLE FACES TO BE FITTED W/ APPROPRIATE PLASTIC NOZZLE PROTECTORS.

V-450

MARK	REQD	DESCRIPTION	SERVICE	NECK	SCH	OS	IS	REINFORCING PAD SIZE	WELDING DETAIL NO.	WELD SIZE	REMARKS	BOM ITEMS
N12	1	2"-150# RF LWN FLG	WATER RECYCLE INLET	3 1/16"	-	6"	5/8"	SEE NOTE 4	1	3/8" 3/16"		11
N11A/B	2	3"-150# RF LWN FLG	INSPECTION OPENINGS W/ BLIND	4 1/4"	-	6"	5/8"	SEE NOTE 4	1	3/8" 3/16"		9, 13, 17, 18, 19
N10	1	2"-150# RF LWN FLG	PSV CONN	3 1/16"	-	PER DWG	0"		3	3/8" -		10
N9	1	2"-150# RF LWN FLG	PRESSURE TRANSMITTER CONN	3 1/16"	-	6"	5/8"	SEE NOTE 4	1	3/8" 3/16"		11
N8	1	2"-150# RF LWN FLG	TEMPERATURE TRANSMITTER CONN	3 1/16"	-	6"	5/8"	SEE NOTE 4	1	3/8" 3/16"		11
N7	1	3"-150# RF LWN FLG	SPARE W/ BLIND	4 1/4"	-	6"	5/8"	SEE NOTE 4	1	3/8" 3/8"		9, 13, 17, 18, 19
N6A/B/C	3	2"-150# RF LWN FLG	LC CONNS (BRIDLE 3-PHASE)	3 1/16"	-	6"	5/8"	SEE NOTE 4	1	3/8" 3/16"		11
N4	1	2"-150# RF WN FLG	WATER OUTLET W/ VORTEX BREAKER	2 3/8"	160	PER DWG	0"		5, F1	3/8" -		25, 15, 16
N3	1	2"-150# RF LWN FLG	OIL OUTLET W/ VORTEX BREAKER	3 1/16"	-	6"	5/8"	SEE NOTE 4	1	3/8" 3/16"		11
N2	1	8"-150# RF LWN FLG	GAS OUTLET	9 3/4"	-	PER DWG	0"		5	3/8" -		7
N1	1	8"-150# RF SO FLG	INLET W/ DIVERTER	8 5/8"	STD	7 3/4"	0"		5, F2	3/8" -		8, 14



NAT'L BD. NO. (LATER)

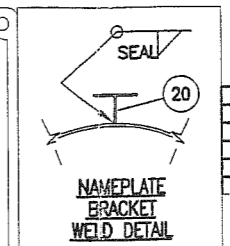
CERTIFIED BY:  
**ITS** ITS Engineered Systems, Inc.

50 PSI @ 250° F MAWP  
 36" ID X 8'-0" S/S SIZE

-20° F @ 50 PSI MDMT  
 50 PSI DESIGN PRESS

1695 JOB#  
 1695-2 SERIAL#  
 2002 YEAR BUILT

BUILT FOR:  
 ITS ENSYN LLC  
 RECYCLE GAS SEPARATOR, V-450  
 P.O. NO. 114026-003P  
 CRN # (LATER)



TOLERANCES UNLESS SPECIFIED OTHERWISE

PIPING AND STRUCTURAL DIMENSIONS ± 1/4"

MACHINING ± .010"

CONCENTRICITY .010" TIR

FINISH 250

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REV.	DATE	DESCRIPTION	DWN	CHK
3		REV. TO ADD CRND. LUG ORIENT. IN (ITEM 25) FROM WAS REFO (ITEM 12), ADDED FI	EN	MH
2	12/06/02	REV. M1 PROJECTION DIMS 2" OS, 3/4" IS; REVISED ITEM 22 & HOLD ON ORIENT.	EN	MH
1	18NOV02	REVISED TO ADD NOTE 4; ADDED SUPPLY LEG	DID	EN
0	10-26-02	ISSUED FOR FABRICATION	DID	MH
X	10-21-02	ISSUED FOR APPROVAL	DID	MH

ITS ENGINEERED SYSTEMS, INC.  
 a subsidiary of OFFSHORE TOOL & ENERGY CORPORATION

RECYCLE GAS SEPARATOR, V-450  
 RTP DEMONSTRATION PLANT  
 ITS ENSYN LLC

APP. BY T. COOK DATE: 10-20-02 SCALE: 1:16  
 JOB No. ACCT. No. DRAWING No. SHT. REV.  
 1695 800,831 1 OF 2 3