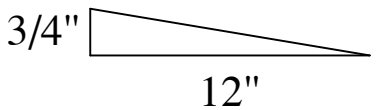


ELEVATION VIEW
(SEE PLAN VIEW FOR TRUE ORIENTATION)

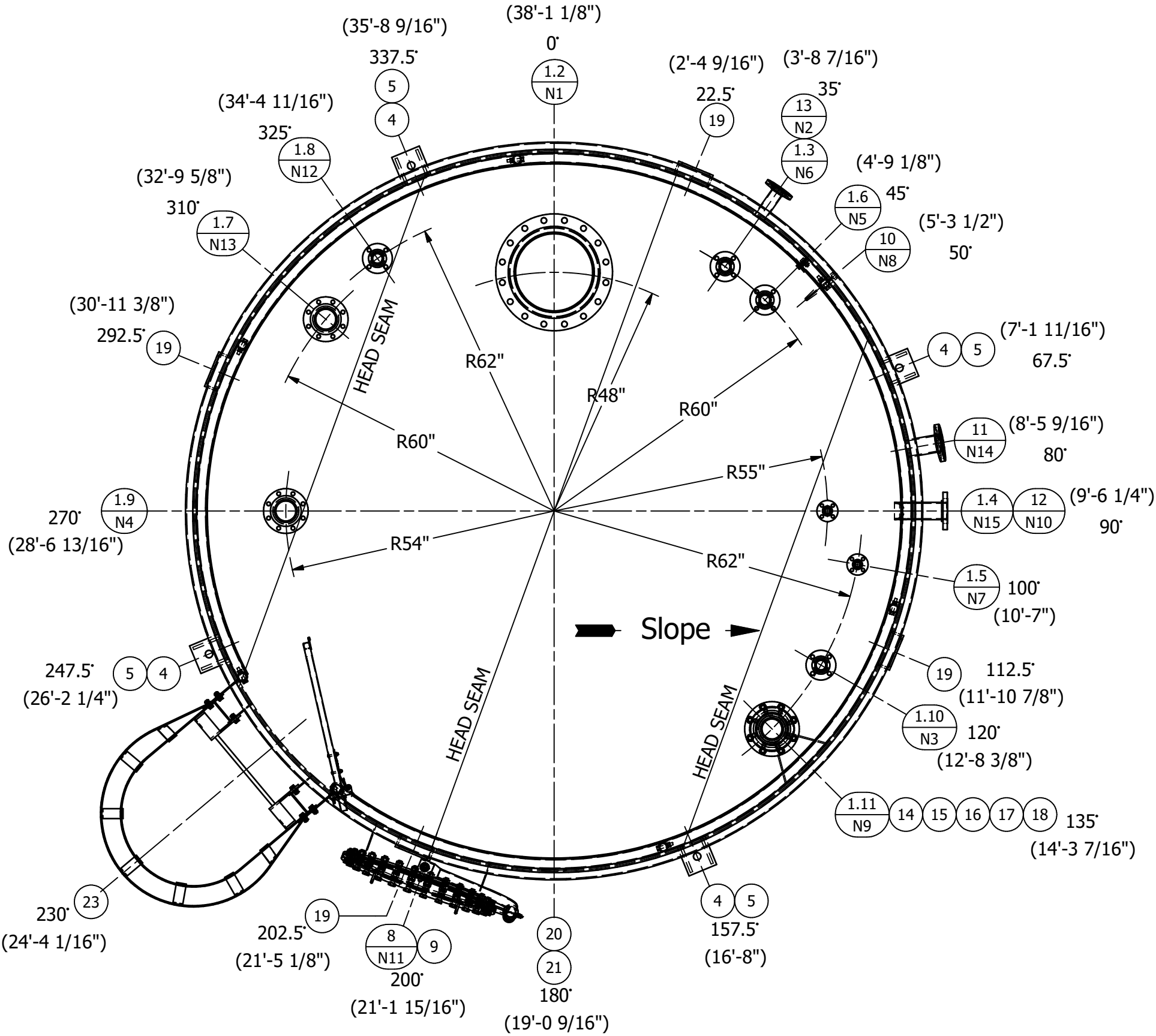


CUSTOMER NOTE:
VESSEL SHALL REQUIRE A PITCHED PAD FOR PLACEMENT

- GENERAL NOTES & SPECIFICATIONS**
- Flange Bolt Holes To Straddle Major Vertical & Horizontal Vessel Center Lines Unless Indicated Otherwise.
 - The Corrosion Resistance Of The Equipment Is Not The Responsibility Of Stainless Fabrication, Inc.
 - Suitable Pressure and/or Vacuum Relief Valve(s) Must Be Installed By Customer For Vessel and/or Heat Transfer Surface Operation.
 - Production To Provide Protection For All Nozzles & Fittings Prior To Shipment. Vessel Must Be Adequately Vented.
 - Weld Seams In Vessel Head & Shell Shall Be Located Where Possible To Avoid Nozzles, Access Openings, & Reinf. Pads.
 - All Reinforcement Pads Must Be Provided With (1) 1/8" Dia. Weephole, Located At Lowest Point When Vessel Is In Its Normal Operating Position. If No Leg Weld Pad Is Required, Drill (1) 3/16" Dia. Weephole In Lowest Point Of Pipe Leg.
 - Dye Penetrant Test All Product Containment Welds.
 - Tolerances Per SFI Standard Dimensional And Fabrication Tolerance Specification QC-800.
 - The Data Plate Shall Include The Customer Purchase Order Number and Tank Tag Number If Listed On This Drawing.
 - Tank Is Designed But Not Marked Per API-650, Annex E, F, J, S, & V
 - All Removable Dip Tubes Shall Have Their Item Number And Associated Nozzle Number Permanently Inscribed On The Tank-Exterior Non-Wetted Surface

M.T.R.'S REQUIRED
(ALL PARTS & WELD WIRE)
(COC'S REQUIRED FOR GASKETS)

Shop Note:
All Arc Length Locations are From 0° Along The Top Head O.D.
For Reference Only. The Shop Is To Verify And Adjust As Required.



PLAN VIEW

**CERTIFIED CORRECT AND
RELEASED FOR FABRICATION**

FABRICATION WILL BE IN ACCORDANCE WITH THIS DRAWING. ANY FURTHER
CHANGES WILL BE REVIEWED FOR COST AND DELIVERY ADJUSTMENTS.

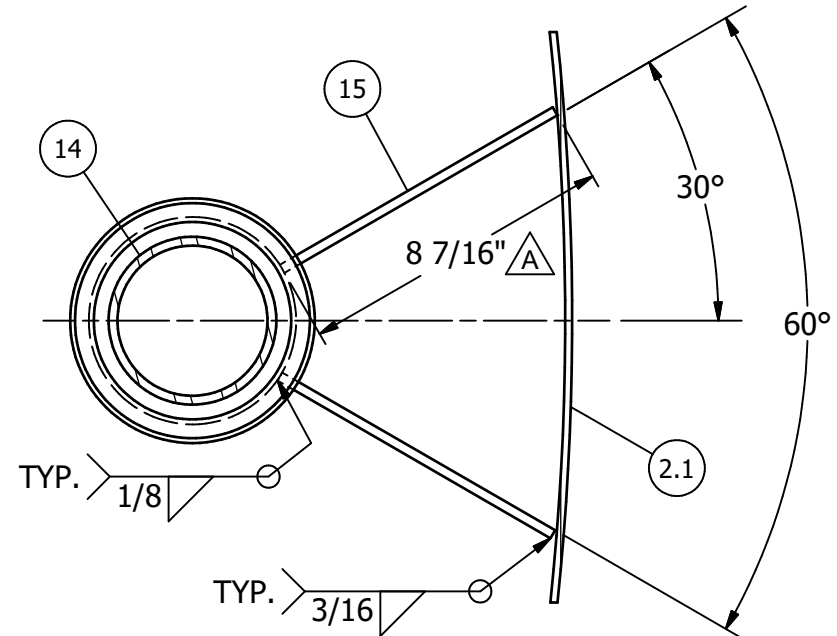
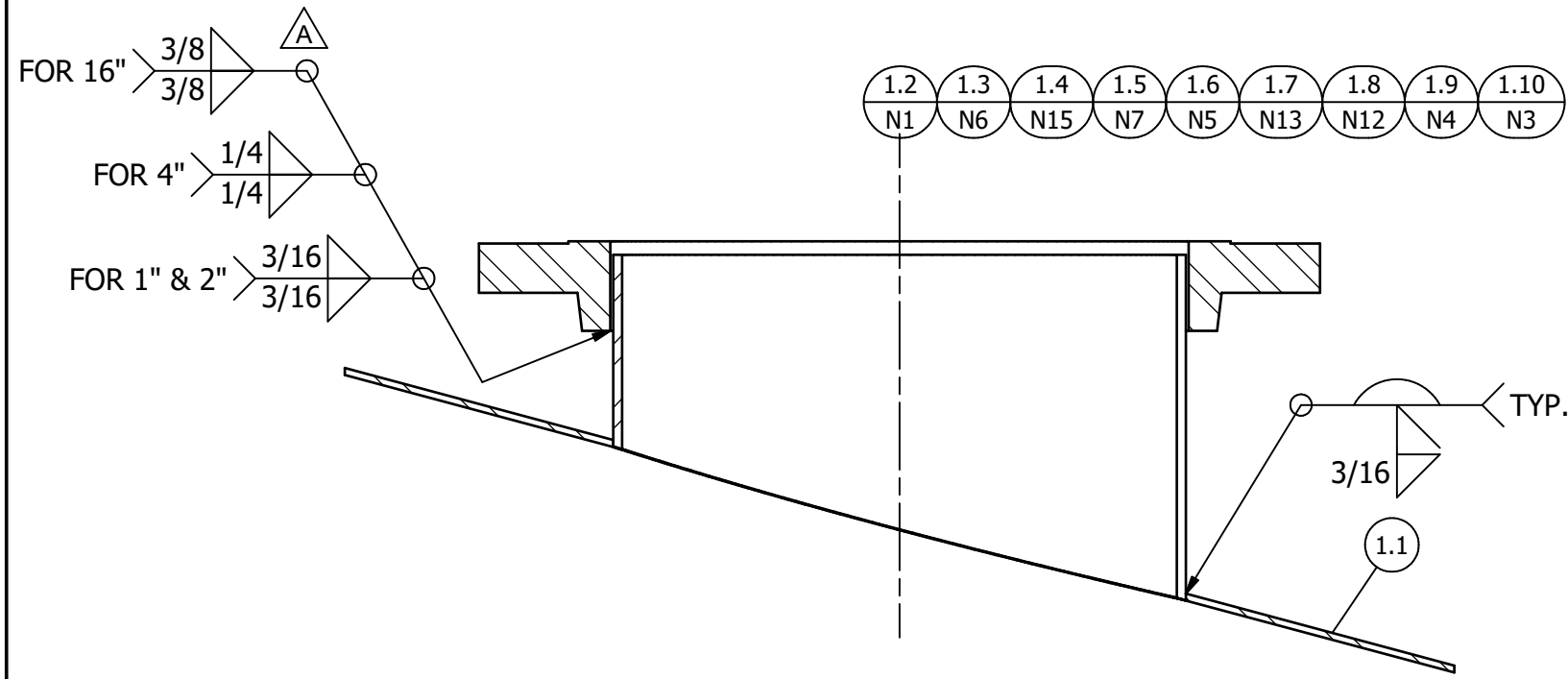
STAINLESS FABRICATION INCORPORATED

A	N4 "PV VENT" (ITEM 1.9) WAS 6"; DIP PIPE GUIDE BRACE (ITEM 15) WAS 12 15/16" LG.; N15 "PILOT SENSING LINE" (ITEM 1.4) WAS AT 13" ELEVATION TO TOP OF RIM ANGLE; REMOVED AUXILIARY ELEVATION VIEWS; ALL NOZZLES ON TOP HEAD AND SIDEWALL ORIENTATIONS AND LOCATIONS UPDATED; ELEVATION AND PLAN VIEW GEOMETRY UPDATED; ESTIMATED EMPTY WEIGHT WAS 10067 LBS.; RELEASED FOR FABRICATION.
REV	DESCRIPTION

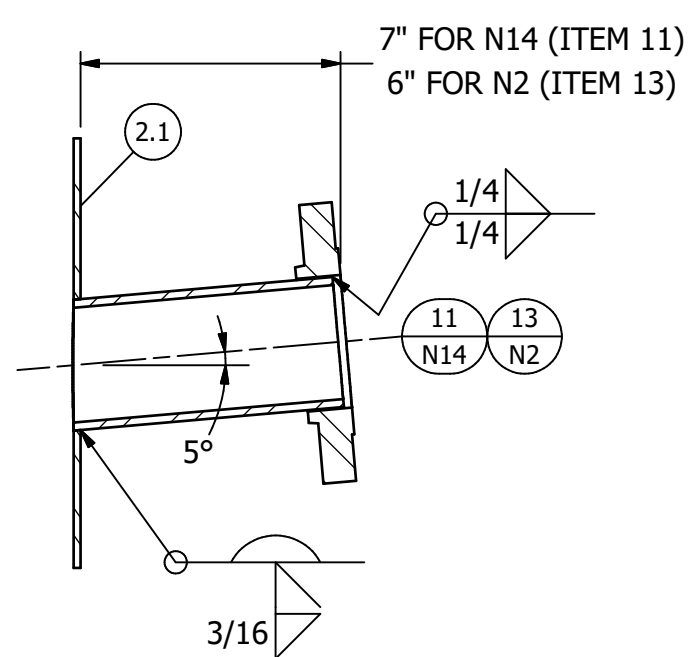
DS	SW	JB	2/3/2021
DESIGNER	CHECKED BY	ENGINEER	DATE

Nzl	SERVICE	ITEM	QTY	PART #	DESCRIPTION	MATERIAL
		1	1		TOP HEAD ASSEMBLY	
		1.1	1		TOP HEAD, 3/16" PL. CONICAL X 145 3/8" I.D. X 150° I.A.	SA240-304/304L
N1	TOP MANWAY// EMERGENCY	1.2	1		16" CLASS 150 ASME B16.5, R.F.S.O. FLANGE w/ SCH. 40S X 11" LG. EXT., 304/304L	
N6	LEVEL SWITCH	1.3	1		2" CLASS 150 ASME B16.5, R.F.S.O. FLANGE w/ SCH. 80S X 9" LG. EXT., 304/304L	
N15	PILOT SENSING LINE	1.4	1		1" CLASS 150 ASME B16.5, R.F.S.O. FLANGE w/ SCH. 80S X 7" LG. EXT., 304/304L	
N7	NITROGEN	1.5	1		1" CLASS 150 ASME B16.5, R.F.S.O. FLANGE w/ SCH. 80S X 9" LG. EXT., 304/304L	
N5	PRESSURE/ LEVEL TRANS	1.6	1		2" CLASS 150 ASME B16.5, R.F.S.O. FLANGE w/ SCH. 80S X 9" LG. EXT., 304/304L	
N13	SPARE	1.7	1		4" CLASS 150 ASME B16.5, R.F.S.O. FLANGE w/ SCH. 40S X 11" LG. EXT., 304/304L	
N12	SPARE	1.8	1		2" CLASS 150 ASME B16.5, R.F.S.O. FLANGE w/ SCH. 80S X 9" LG. EXT., 304/304L	
N4	PV VENT	1.9	1		4" CLASS 150 ASME B16.5, R.F.S.O. FLANGE w/ SCH. 40S X 9" LG. EXT., 304/304L	
N3	VAPOR RECOVERY	1.10	1		2" CLASS 150 ASME B16.5, R.F.S.O. FLANGE w/ SCH. 80S X 11" LG. EXT., 304/304L	
N9	BELOW SURFACE ADDITION	1.11	1		6" CLASS 150 ASME B16.5, R.F.S.O. FLANGE w/ SCH. 40S X 9" LG. EXT., 304/304L	
		2	1		SHELL ASSEMBLY	
		2.1	1		SHELL, 3/16" PL. X 144" I.D. X 239 13/16" S.W.	SA240-304/304L
		3	1		BOTTOM HEAD ASSEMBLY	
		3.1	1		BOTTOM HEAD, 1/4" PL. FLAT & PITCHED X 148 3/8" O.D.	SA240-304/304L
		4	4		TOP PLATE, 1" THK. X 6 1/16" LG. X 6" WD. W/ (1) 1 1/2" DIA. HOLE	SA240-304/304L
		5	8		GUSSET, 1/2" PL. X 5 1/2" WD. X 12" LG. (TRIM A/R)	SA240-304/304L
		6	1		RIM ANGLE, 2" X 2" X 1/4" ANGLE X 144 3/8" I.D. (ROLL LEG OUT)	316/316L
		7	1		VACUUM RING, 2" X 2" X 1/4" ANGLE X 144 3/8" I.D. (ROLL LEG IN)	304/304L
N11	SIDE MANWAY	8	1	MW-API-024-1	MANWAY, 24" API 650 DESIGN SHELL MANWAY w/ 1/8" THK. EPDM GASKET w/ 10" LG. COLLAR, 304/304L	
		9	1	EX-DVT-124	DAVIT ARM ASSEMBLY FOR 24" API-650 DESIGN MANWAY, 304/304L	
N8	TEMP. GAUGE THERMOWELL	10	1		THERMOWELL, 1 1/2" X 7 1/2" STM X 6" INS X .260" BORE (LAG INC) 1 1/2"-260WELD-IN-U6	304/304L
N14	BOTTOM OUTLET SPARE	11	1		3" CLASS 150 ASME B16.5, R.F.S.O. FLANGE w/ SCH. 40S X 9" LG. EXT., 304/304L	
N10	BOTTOM OUTLET	12	1		3" CLASS 150 ASME B16.5 FLANGE ASSEMBLY W/ SCH. 40S X 13" LG. EXT., 304/304L	
N2	LEVEL TRANSMITTER	13	1		2" CLASS 150 ASME B16.5, R.F.S.O. FLANGE w/ SCH. 40S X 11" LG. EXT., 304/304L	
		14	1		DIP TUBE, 4"-150# R.F.S.O. FLANGE W/ SCH. 40S X 240" LG. EXT. MOUNTED IN 6"-150# R.F. BLIND FLANGE, 304/304L	
		15	2		DIP PIPE GUIDE, 5" SCH. 10S PIPE X 4" LG. W/(2) 1/4" FB. 1 1/2" X 8 7/16", 304/304L	
		16	1	FL-82-00600010	6" CLASS 150 FLANGE GASKET	BLACK EPDM
		17	8	FS-61-07532510	BOLT, 3/4"-10UNC HEAVY HEX X 3 1/4" LG.	SA193-B8
		18	8	FS-64-07500030	NUT, 3/4"-10UNC HEAVY HEX	SA194-Gr. 8
		19	4		LIFTING LUG, CHANNEL STYLE FOR 16,000 LB TANK (REF. DWG. NO. EX-LLG-008)	SA240-304/304L
		20	1		NAME PLATE, STD. SFI SHOP NAME PLATE	316/316L
		21	1		DATA PLATE, STD. SFI DATA PLATE	316/316L
		22	1	13759-1-L3	HANDRAIL (REF.)	
		23	1	13759-1-L4	LADDER (REF.)	

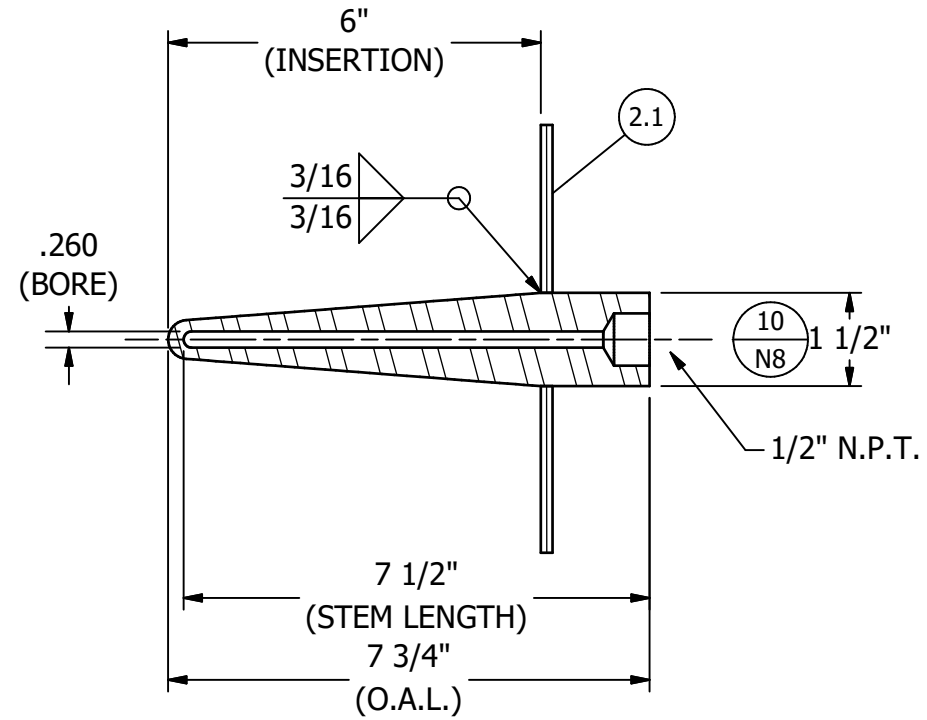
SPECIFICATIONS	VESSEL	HEAT TRANSFER SURFACE	DRAWN	JOSH MATHIS	DATE	12/23/2020
ASME Code, Sec. VIII, div. 1.	NOTE 10		CHECKER	SCOTT WALLACE	DATE	1/13/2021
Inspection & Stamped	NOTE 10		ENGINEER	JEFF BRUNSON	DATE	1/13/2021
Max. Design Temp. °F	200		TITLE			
Max. Design Pressure, PSIG	1		15,000 GALLON SALUS STORAGE TANK			
Corrosion Allowance, Inch	0		TAG NO.: T-116			
Specific Gravity	1.0		SHEET 1 OF 5			
Hydrostatic Test, PSIG	NOTE 7		REF.: JOB #13585-1			
Vacuum Design, PSIG	0.145		QUANTITY (1) ONE			
Radiograph	N/A		EST. EMPTY WEIGHT 10041 lbmass			
HEAT TRANSFER SURFACE	N/A		CUSTOMER EPIC SYSTEMS GROUP LLC			
MATERIAL FINISH			ADDRESS 4142 MERAMEC BOTTOM ROAD			
INTERIOR	MILL	EXTERIOR MILL	ST. LOUIS, MO 63129			
WELD FINISH			SHIP TO ST. LOUIS, MO 63129			
INTERIOR	BF	EXTERIOR BF	CUSTOMER ORDER NO: 56173			
PAINT NONE			This Drawing Is The Property Of Stainless Fabrication, Inc. Do Not Print, Photograph, Copy, Or Use For Any Purpose Other Than That For Which It Is Specifically Furnished			
CHECKED BY			Stainless Fabrication, Incorporated			
ENGINEERED BY			4455 W. Kearney			
			Springfield, MO 65803			
			(417) 865-5696			
			DRAWINGS NO: 13759-1-M1			
			REV A			



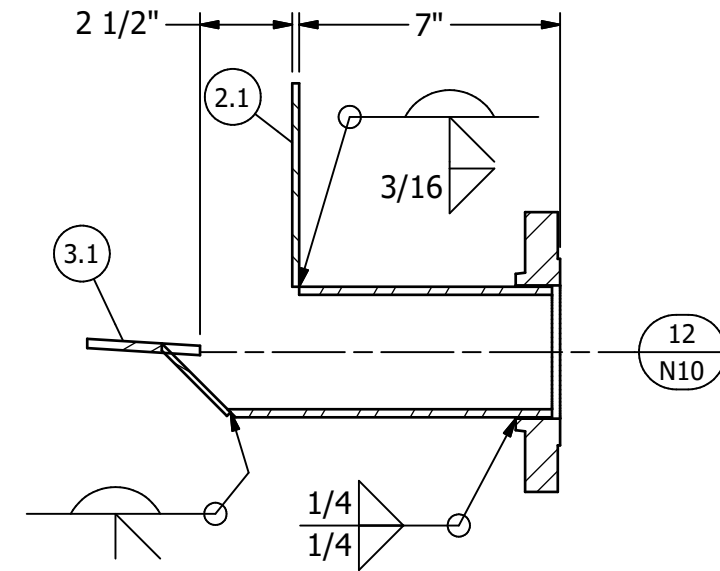
SECTION "B1"-"B1"



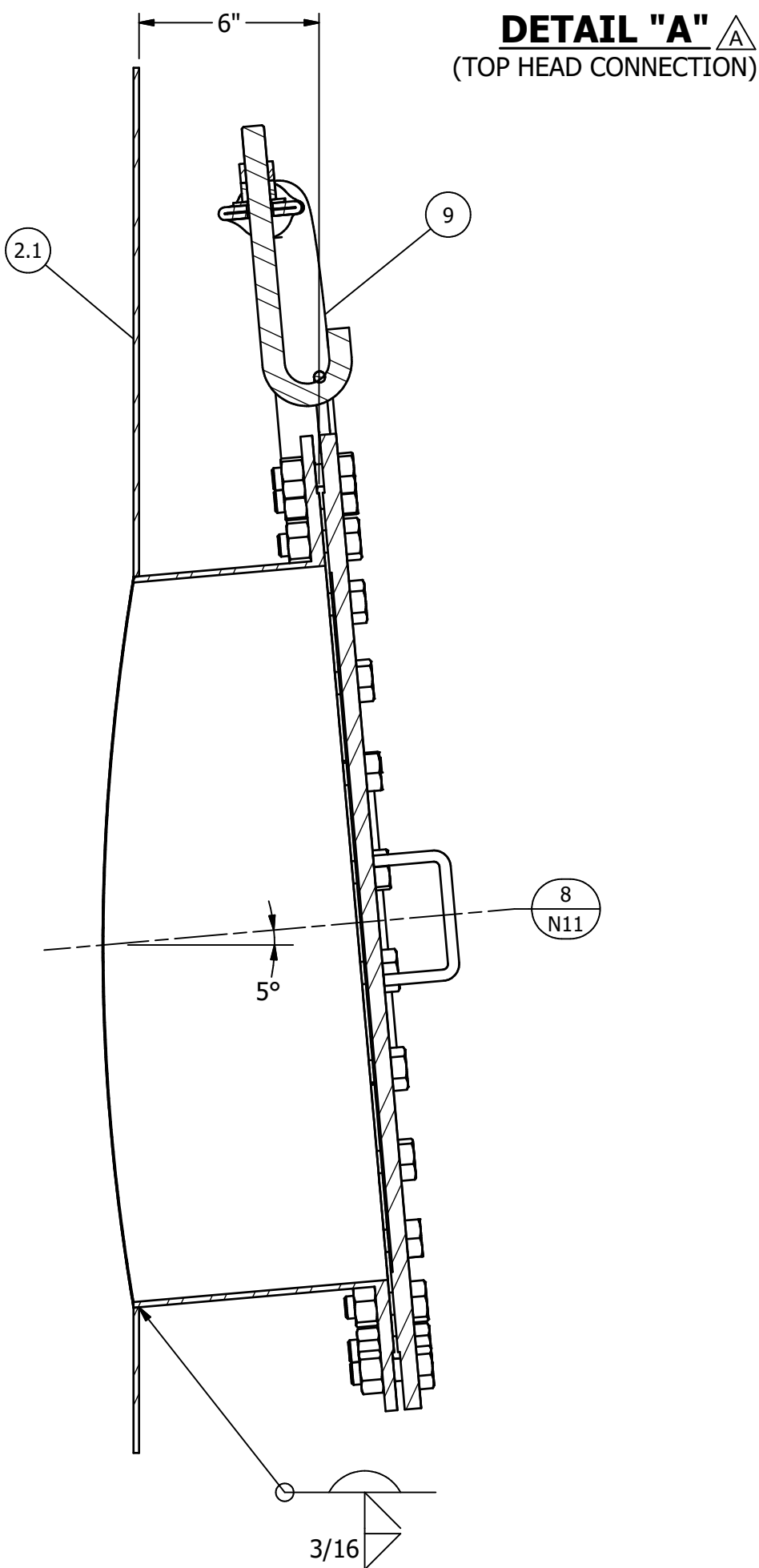
DETAIL "C"
(SIDEWALL CONNECTION)



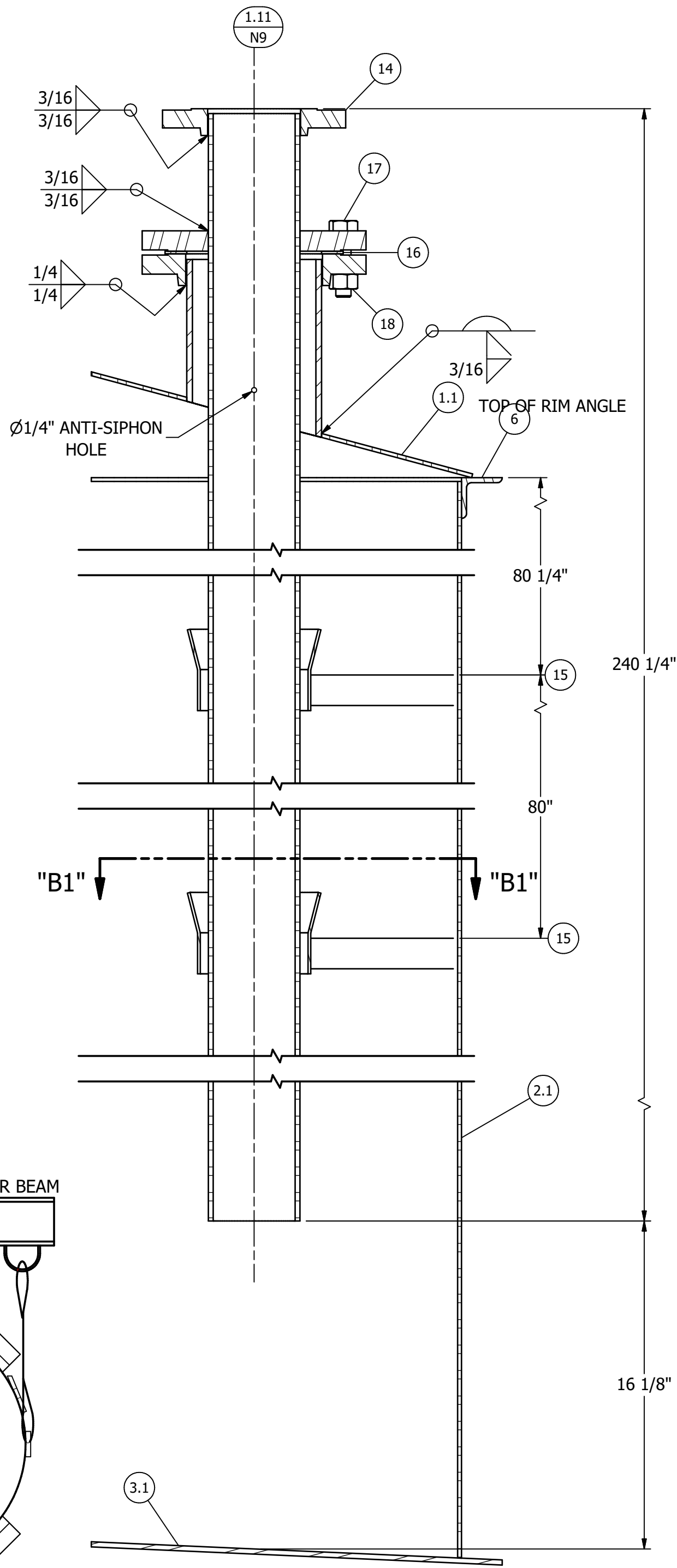
DETAIL "D"
(THERMOWELL)



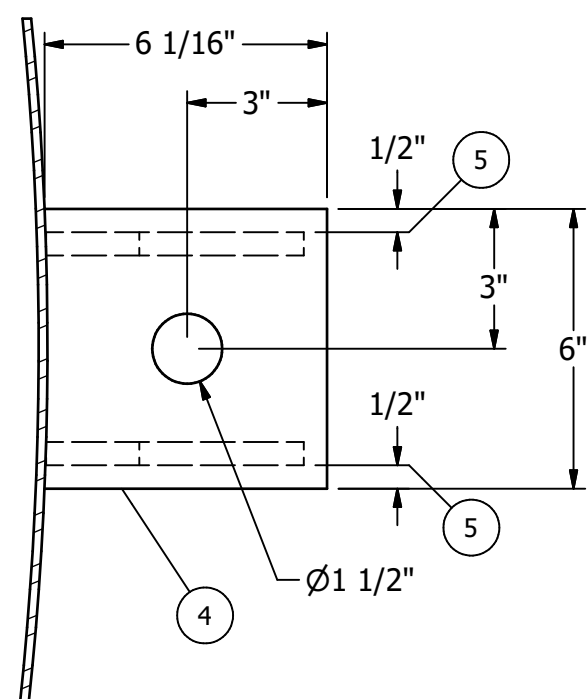
DETAIL "E"
(OUTLET)



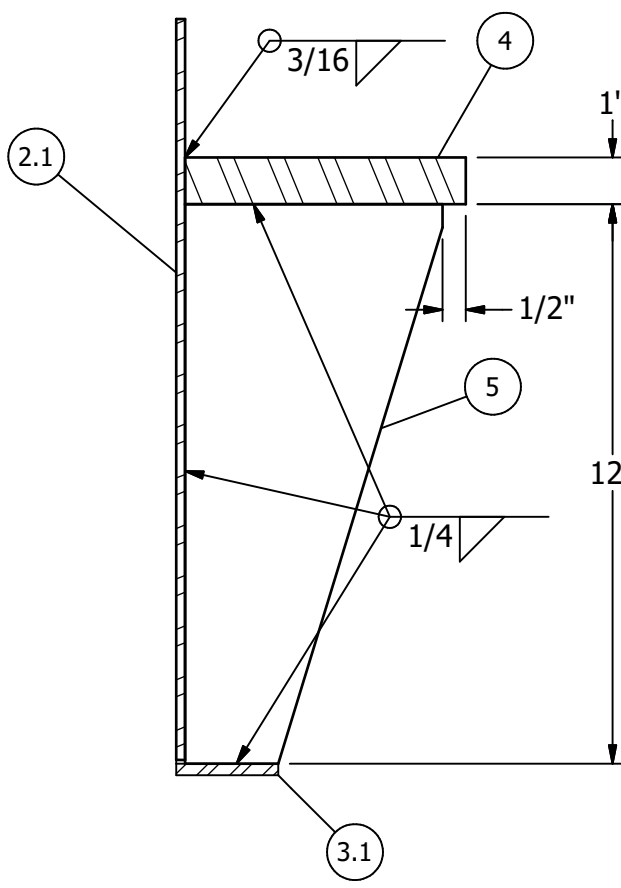
DETAIL "A"
(TOP HEAD CONNECTION)



DETAIL "B"
(DIP TUBE ASS'Y.)



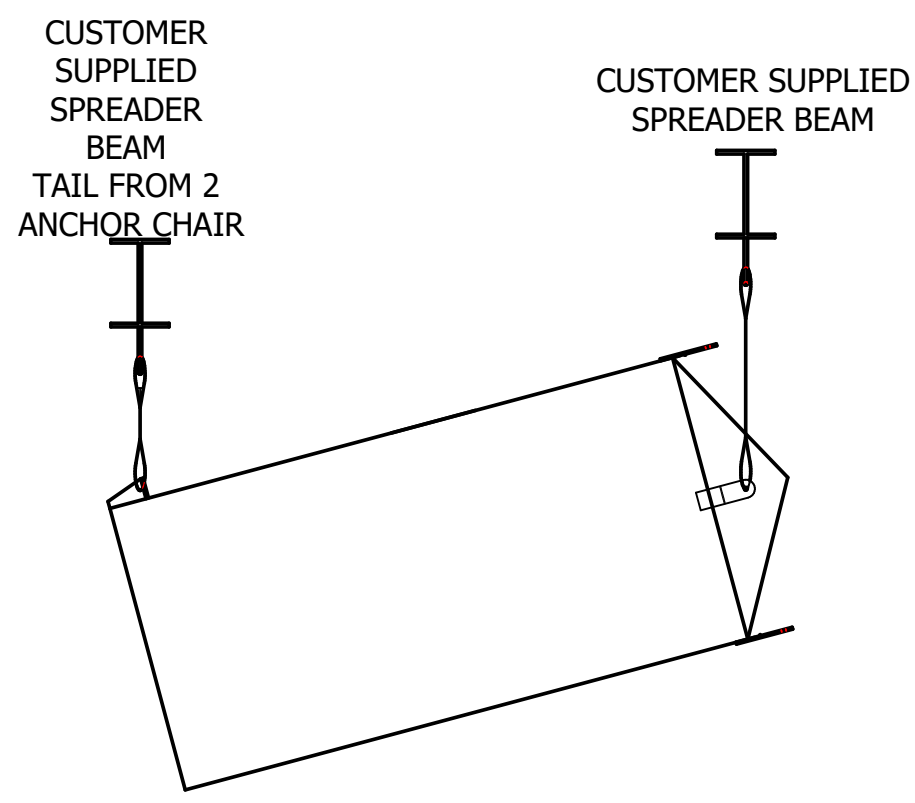
TOP VIEW



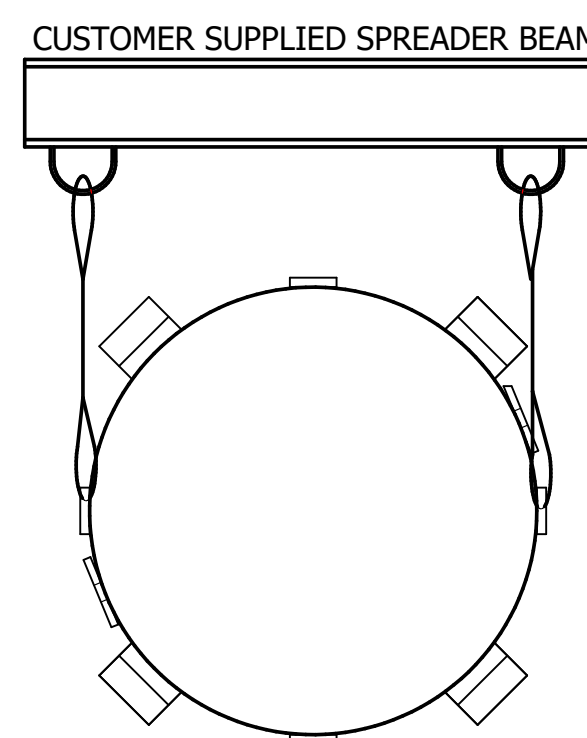
DETAIL "G"
(ANCHOR)

ANCHOR BOLT LOADING		
UPLIFT LOAD CASE (1" DIAMETER MIN BOLT, 36 KIS YIELD, ADD FOR CORROSION)	TENSION (LBF) (PER BOLT)	SHEAR (LBF) (PER BOLT)
ANCHOR ATTACHMENT DESING LOAD Pa (5.12.12)	7384	0
DESIGN PRESSURE	10731	0
TEST PRESSURE	10732	0
WIND LOAD	970	0
SEISMIC LOAD	835	0
DESIGN PRESSURE + WIND	5856	0
DESIGN PRESSURE + SEISMIC	2462	0

VALUES GIVEN FOR NON-SEISMIC CONDITIONS INCLUDE POSSIBLE BOUYANCY



LIFTING ELEVATION
(SPREADER BEAM WITH TAILING LUGS)



LIFTING END VIEW
(SPREADER BEAM USING TWO LUGS)

CERTIFIED CORRECT AND RELEASED FOR FABRICATION

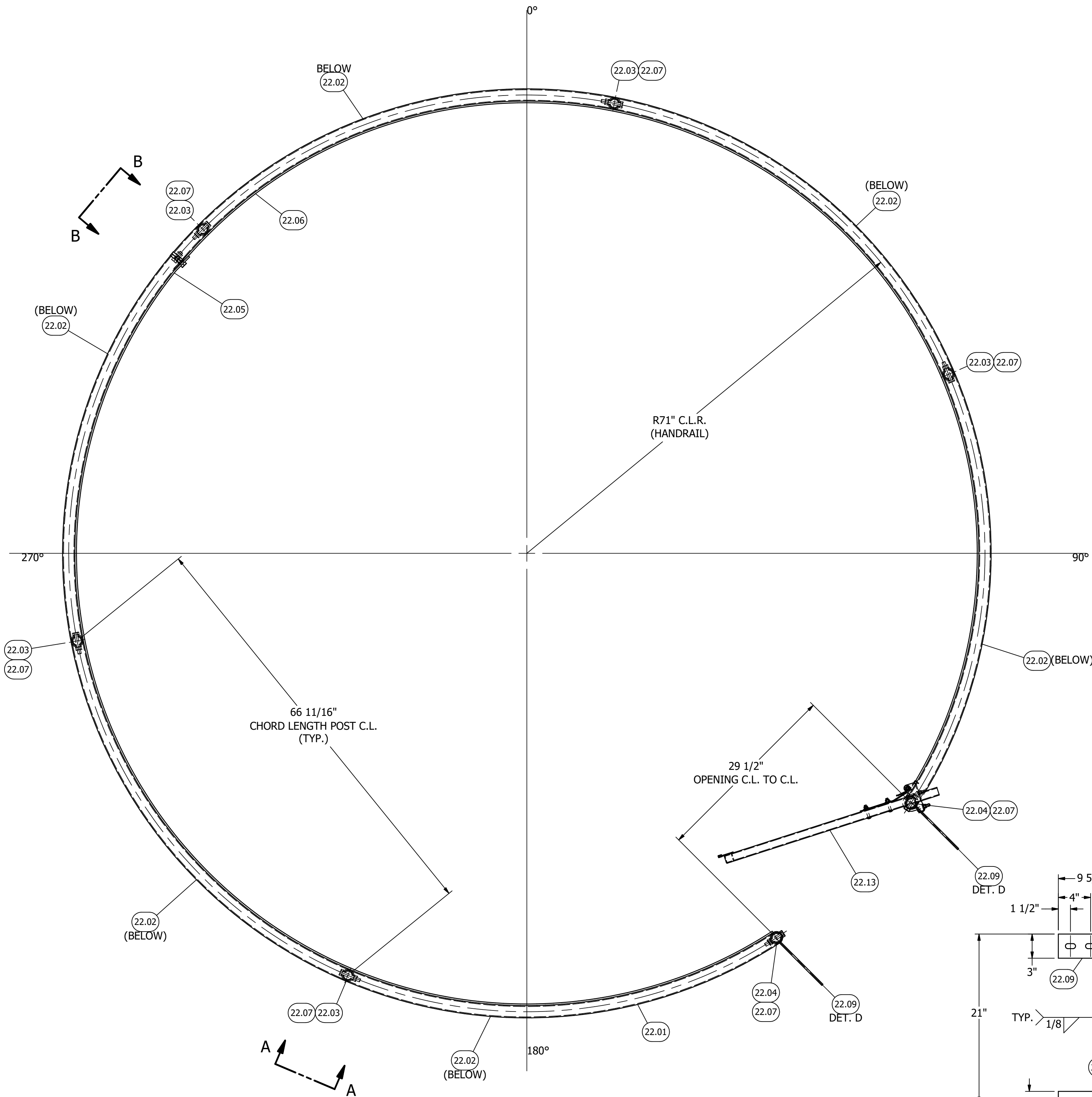
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STAINLESS FABRICATION INCORPORATED

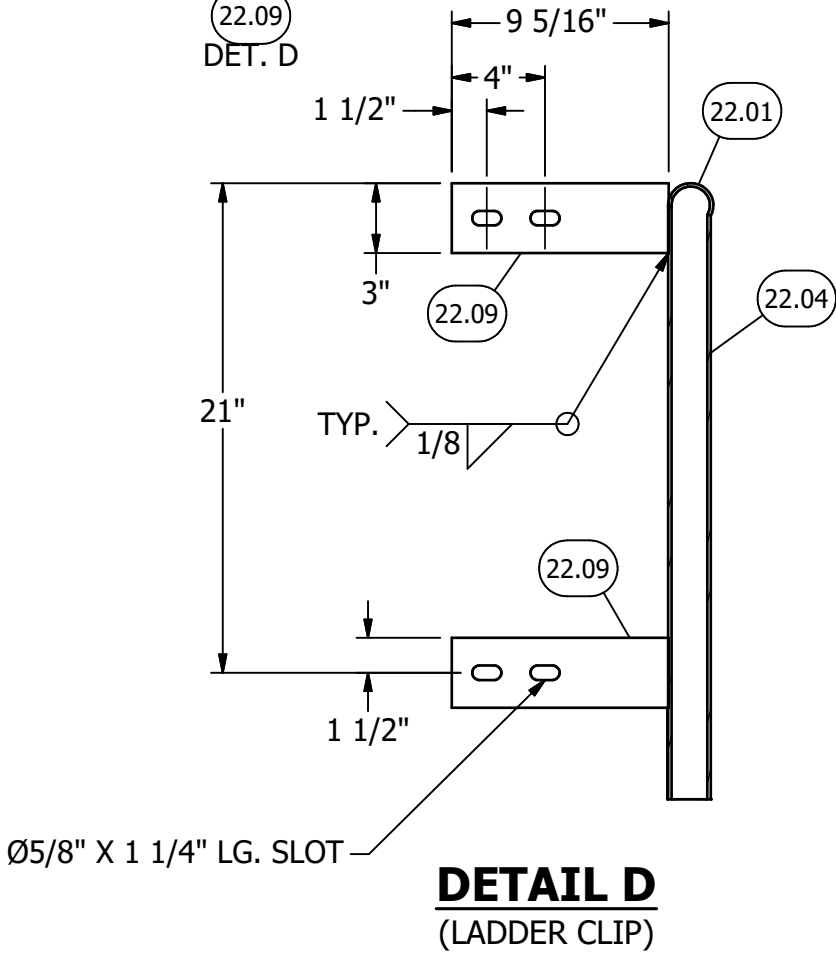
A	REMOVED 6" WELD FROM DETAIL "A"; IN SECTION "B1"-"B1": DIP PIPE GUIDE BRACE WAS 12 15/16" LG. RELEASED FOR FABRICATION.	DS	SW	JB	2/3/2021
REV	DESCRIPTION	DESIGNER	CHECKED BY	ENGINEER	DATE

DRAWN	JOSH MATHIS	DATE	12/23/2020
CHECKED	SCOTT WALLACE	DATE	1/13/2021
DES. ENGR. APPROVED	JEFF BRUNSON	DATE	1/13/2021
DETAILS SHEET 2 OF 5			
This Drawing Is The Property Of Stainless Fabrication, Inc. Do Not Print, Photograph, Copy, Or Use For Any Purpose Other Than That For Which It Is Specifically Furnished			
Stainless Fabrication, Incorporated 4455 W. Kearney Springfield, MO 65803 (417) 865-5696			
CHECKED BY 		ENGINEERED BY 	
DRAWING NO.		13759-1-D2	
		A REVISION	

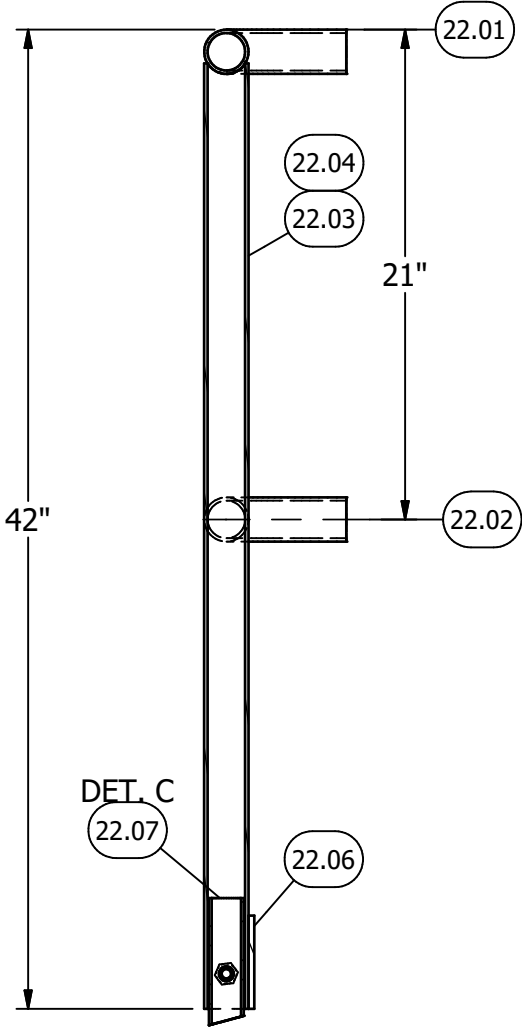
ITEM	QTY	PART #	DESCRIPTION	MATERIAL
22.01	1		TOP RAIL, 1 1/2" SCH. 40S PIPE X 418 5/16" LG. (ROLL TO 71" C.L.R.) (MITERED ENDS)	A500-Gr. B
22.02	6		MID RAIL, 1 1/2" SCH. 40S PIPE X 68 3/8" LG. (ROLL TO 71" C.L.R.) (COPED ENDS)	A500-Gr. B
22.03	5		POST, 1 1/2" SCH. 40S PIPE X 40 9/16" LG. (COPE ONE END)	A500-Gr. B
22.04	2		END POST, 1 1/2" SCH. 40S PIPE X 42" LG. (MITER ONE END)	A500-Gr. B
22.05	1		TOE PLATE, 1/4" X 4" F.B. X 200 7/8" LG. (ROLL TO 69 13/16" I.S.R.)	SA36
22.06	1		TOE PLATE, 1/4" X 4" F.B. X 212 15/16" LG. (ROLL TO 69 13/16" I.S.R.)	SA36
22.07	7		POST STUB, 1 1/2" X 0.120 WALL TUBE X 5 1/2" LG.	SA249-304/304L
22.08	4		HANDRAIL SPLICE CLIP, 3/8" X 2" X 3 1/2" LG. W/ 5/8" DIA. HOLE	SA36
22.09	4		LADDER CLIP, 1/4" THK. X 3" X 9 5/16" W/ (2) 5/8" X 1 1/4" SLOTTED HOLES	SA36
22.10	7	FS-24-05030010	BOLT, 1/2"-13UNC HEAVY HEX X 3" LG.	GALV. A325
22.11	4	FS-24-05015010	BOLT, 1/2"-13UNC HEAVY HEX X 1 1/2" LG.	GALV. A325
22.12	11	FS-24-05000030	NUT, 1/2"-13UNC HEAVY HEX	GALV. A563
22.13	1	LSG-27-PCY	SAFETY GATE KIT, SELF CLOSING FOR 29 1/2" OPENING WIDTH	
22.14	1		SAFETY YELLOW PAINT (1 GAL.)	



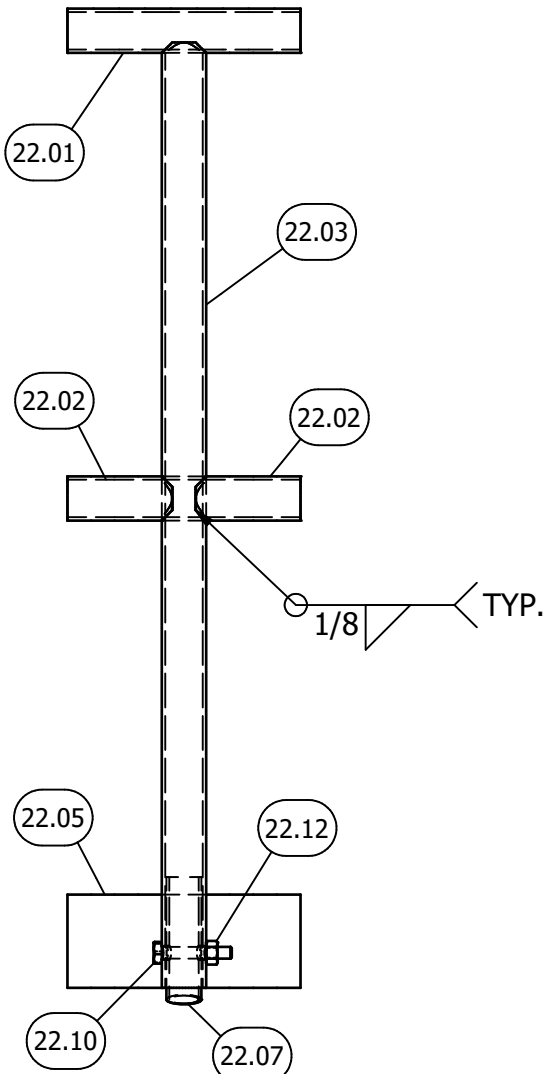
PLAN VIEW
SEE 13759-1-M2 FOR TRUE ORIENTATION



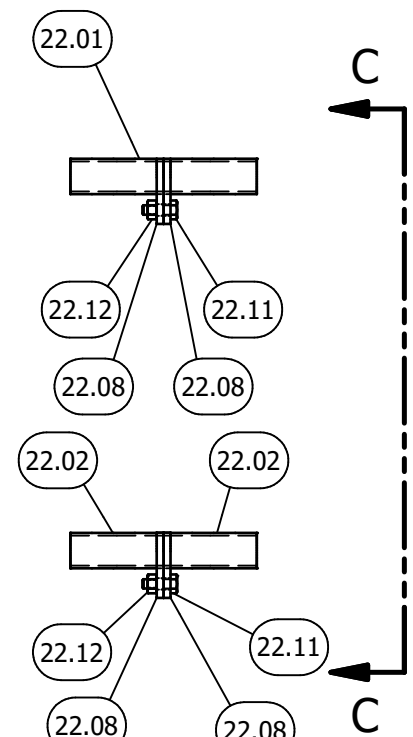
DETAIL D
(LADDER CLIP)



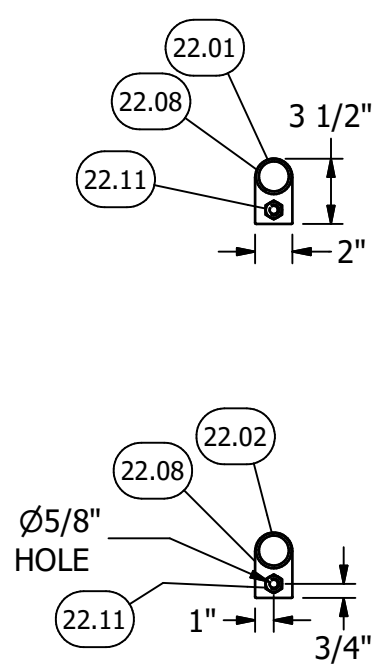
ELEVATION



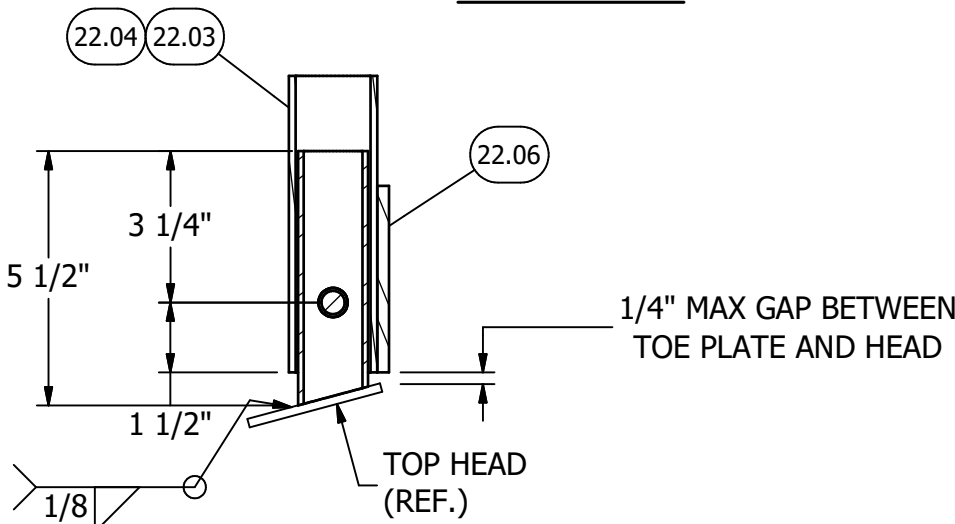
VIEW A-A



VIEW B-B



VIEW C-C



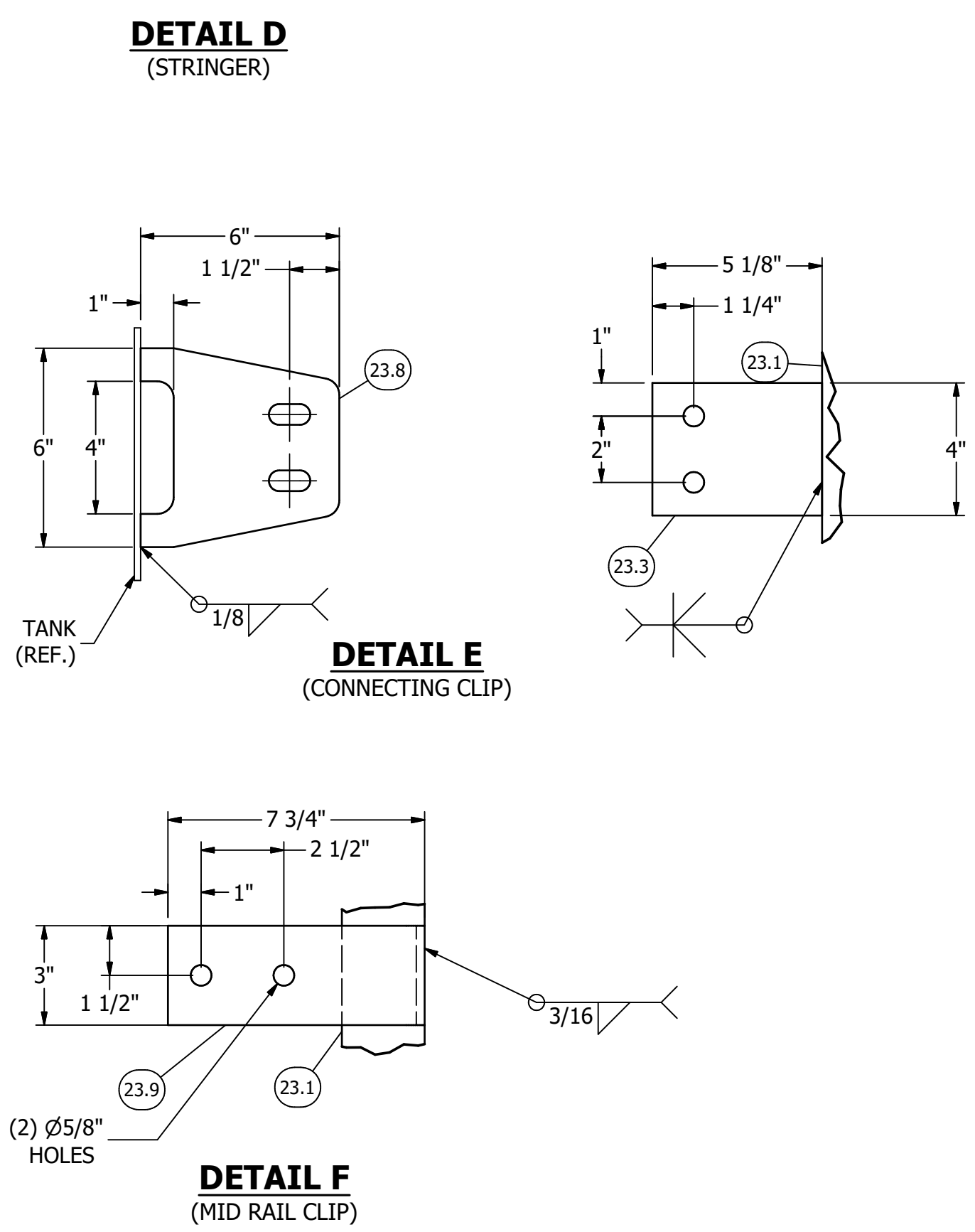
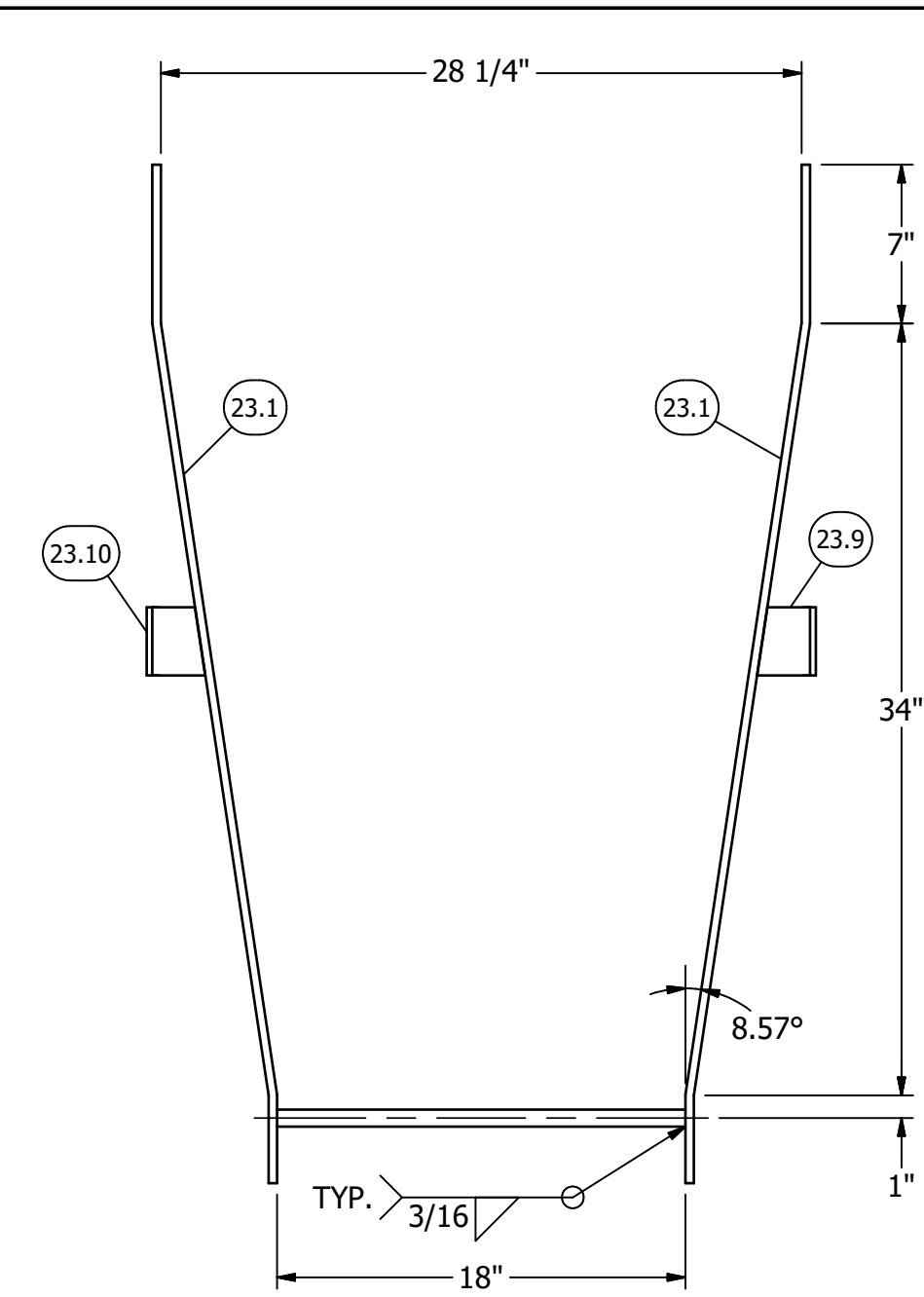
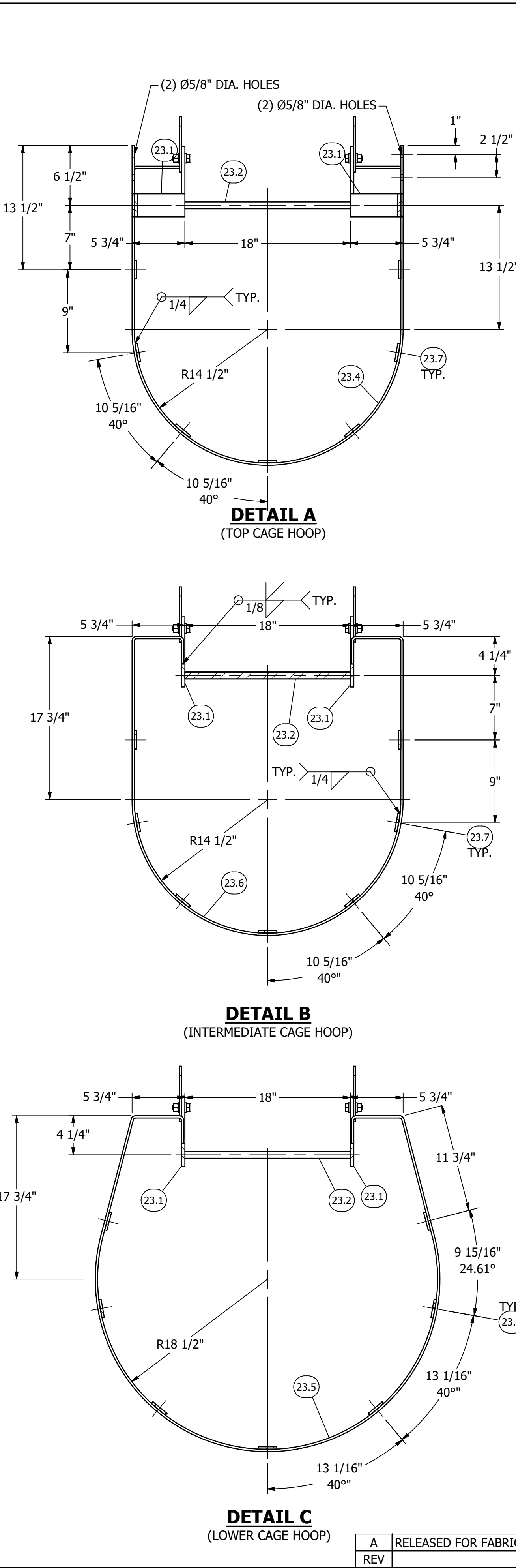
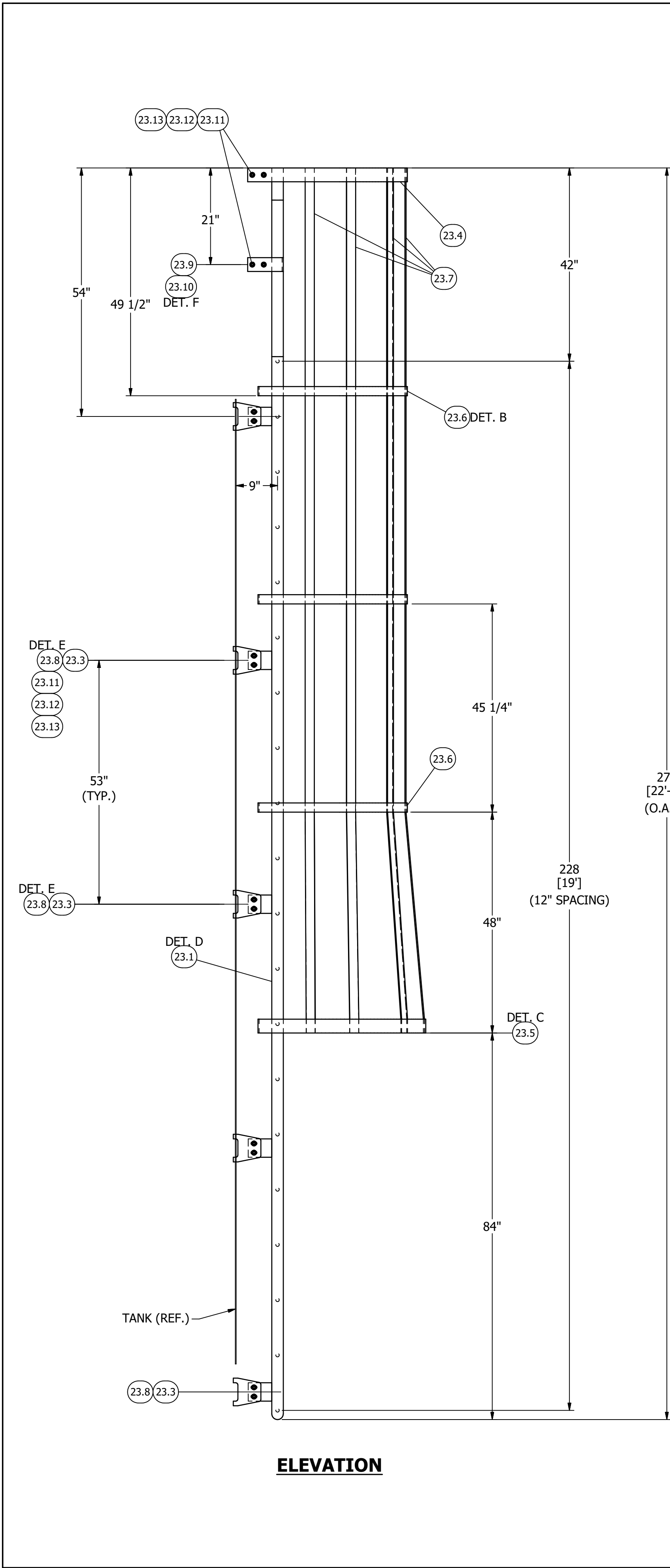
DETAIL C
(POST STUB)

CERTIFIED CORRECT AND RELEASED FOR FABRICATION				
FABRICATION WILL BE IN ACCORDANCE WITH THIS DRAWING. ANY FURTHER CHANGES WILL BE REVIEWED FOR COST AND DELIVERY ADJUSTMENTS.				
STAINLESS FABRICATION INCORPORATED				

MATERIAL FINISH	
EXTERIOR	SB
WELD FINISH	
EXTERIOR	SB
PAINT	
SAFETY YELLOW	

DRAWN	JOSH MATHIS	DATE	12/23/2020
CHECKED	SCOTT WALLACE	DATE	1/13/2021
DES ENGR APPROVED	JEFF BRUNSON	DATE	1/13/2021
HANDRAIL			
SHEET 3 OF 5			
QUANTITY (1) ONE			
Stainless Fabrication, Incorporated			
4455 W. Kearney Springfield, MO 65803 (417) 865-5696			
SFI			
CHECKED BY	APPROVED Josh Mathis - 2/18/2021 2:25:18 PM		
ENGINEERED BY	APPROVED Jeff Brunson - 2/19/2021 2:58:13 PM		
DRAWING NO.	13759-1-L3		
REVISION			A

A	RELEASED FOR FABRICATION.	DS	SW	JB	2/3/2021
REV	DESCRIPTION	DESIGNER	CHECKED BY	ENGINEER	DATE



ITEM	QTY	PART #	DESCRIPTION	MATERIAL
23.1	2		STRINGER, 3/8" X 2 1/2" F.B. X 272 3/8" LG.	SA36
23.2	20		RUNG, 3/4" DIA. R.B. X 17 7/8" LG.	SA36
23.3	10		CONNECTION CLIP, 3/8" THK. X 4" X 5 1/8"	SA36
23.4	1		TOP CAGE HOOP, 1/4" X 3" F.B. X 85 15/16" LG. (FORM AS REQUIRED)	SA36
23.5	1		BOTTOM CAGE HOOP, 1/4" X 3" WD. F.B. X 110 3/4" LG.	SA36
23.6	3		INTERMEDIATE CAGE HOOP, 1/4" X 2" WD. F.B. X 96 11/16" LG.	SA36
23.7	7		VERTICAL CAGE BAR, 1/4" X 2" F.B. X 188 3/16" LG.	SA36
23.8	10		TANK STUB, 7 GA. X 6" X 6" W/ (2) 5/8" X 1 1/4" LG. SLOTTED HOLES	304/304L
23.9	1		LADDER CLIP, 1/4" THK. X 3" X 9 7/8" W/ (2) 5/8" X 1 1/4" SLOTTED HOLES	SA36
23.10	1		LADDER CLIP, 1/4" THK. X 3" X 9 7/8" W/ (2) 5/8" X 1 1/4" SLOTTED HOLES	SA36
23.11	28	FS-24-05015010	BOLT, 1/2"-13UNC HEAVY HEX X 1 1/2" LG.	GALV. A325
23.12	56	FS-24-05000065	WASHER, 1/2" FLAT	GALV. F436
23.13	28	FS-24-05000030	NUT, 1/2"-13UNC HEAVY HEX	GALV. A563
23.14	1		SAFETY YELLOW PAINT (1) GALLON REQ'D	
23.15	1		FALL ARREST SYSTEM (SAF-T CLIMB)	

CERTIFIED CORRECT AND
RELEASED FOR FABRICATION

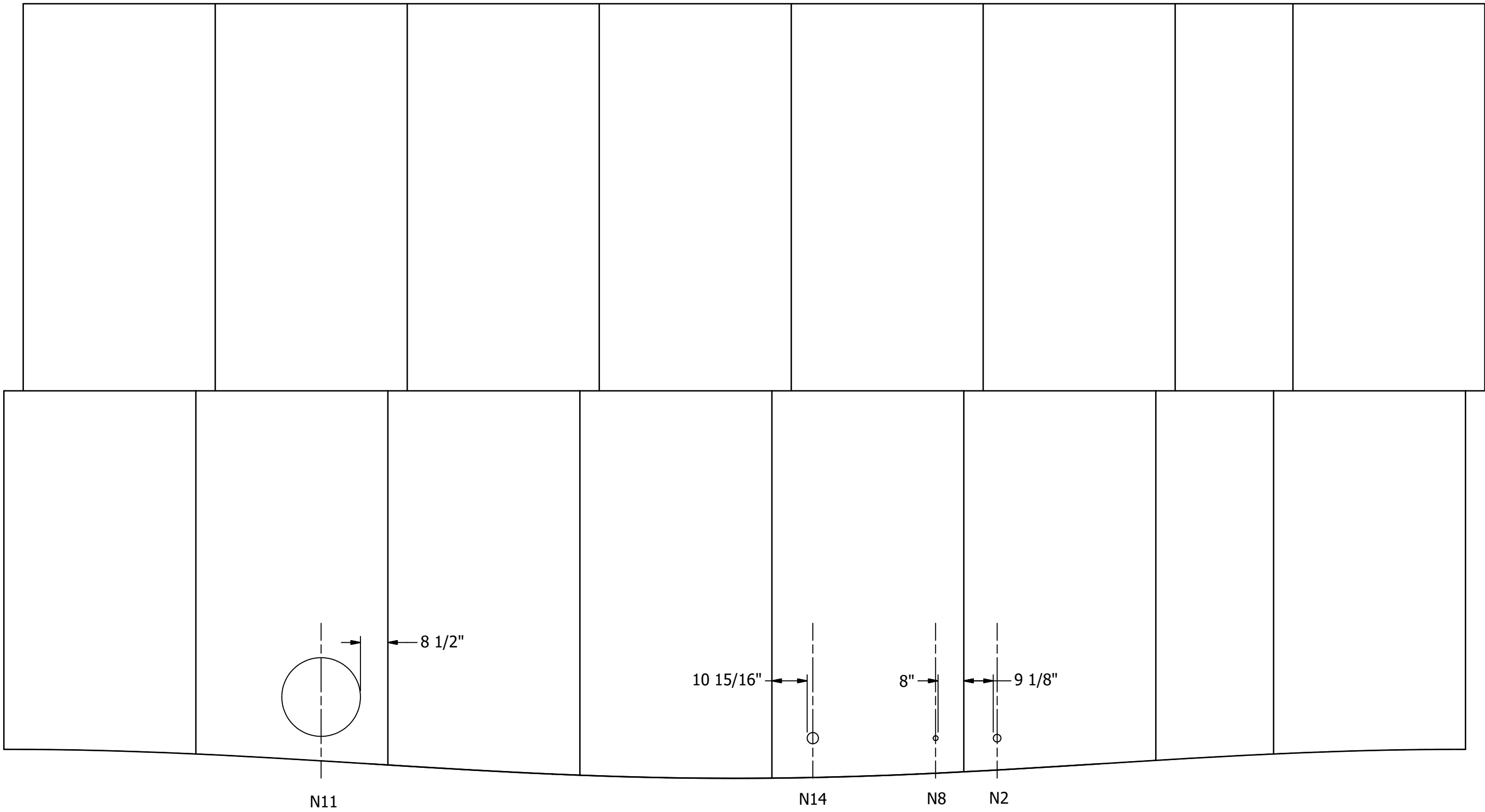
FABRICATION WILL BE IN ACCORDANCE WITH THIS DRAWING. ANY FURTHER
CHANGES WILL BE REVIEWED FOR COST AND DELIVERY ADJUSTMENTS.

STAINLESS FABRICATION INCORPORATED

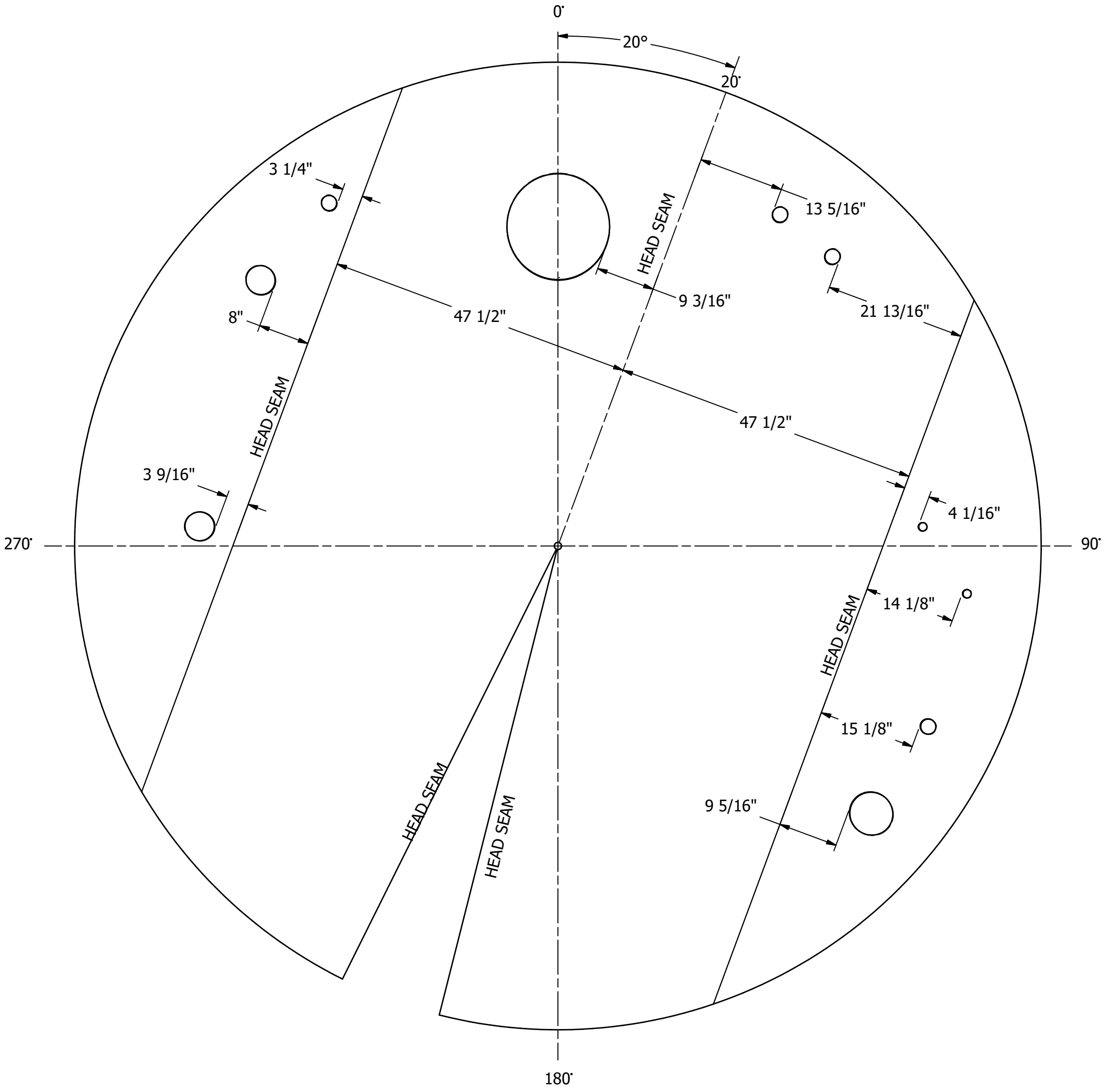
MATERIAL FINISH	
EXTERIOR	SB
WELD FINISH	
EXTERIOR	SB
PAINT	
SAFETY YELLOW	

DRAWN	JOSH MATHIS	DATE	12/23/2020
CHECKED	SCOTT WALLACE	DATE	1/13/2021
DES ENGR	APPROVED JEFF BRUNSON	DATE	1/13/2021
LADDER			
SHEET 4 OF 5			
QUANTITY (1) ONE			
Stainless Fabrication, Incorporated			
4455 W. Kearney Springfield, MO 65803 (417) 865-5696			
CHECKED BY	APPROVED <small>scott wallace, 2/18/2021 2:25:11 PM</small>		
ENGINEERED BY	APPROVED <small>jeff brunson, 2/18/2021 2:58:28 PM</small>		
DRAWING NO.	13759-1-L4		
			REVISION

A	RELEASED FOR FABRICATION.	DS	SW	JB	2/3/2021
REV	DESCRIPTION	DESIGNER	CHECKED BY	ENGINEER	DATE



SIDEWALL FLAT PATTERN
(WITH PENETRATIONS)



TOP HEAD FLAT PATTERN
(WITH PENETRATIONS)

DRAWN	JOSH MATHIS	DATE	12/23/2020
CHECKED	SCOTT WALLACE	DATE	1/13/2021
DES. ENGR. APPROVED	JEFF BRUNSON	DATE	1/13/2021

SHEET 5 OF 5

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Stainless Fabrication, Incorporated
4455 W. Kearney
Springfield, MO 65803
(417) 865-5696



CHECKED BY	APPROVED jmathis 2/13/2021 2:25:55 PM
ENGINEERED BY	APPROVED jbrunson 2/19/2021 2:58:23 PM

DRAWING NO.	13759-1-D5
REVISION	A

CERTIFIED CORRECT AND
RELEASED FOR FABRICATION

FABRICATION WILL BE IN ACCORDANCE WITH THIS DRAWING. ANY FURTHER
CHANGES WILL BE REVIEWED FOR COST AND DELIVERY ADJUSTMENTS.

STAINLESS FABRICATION INCORPORATED

A	ADDED NEW SHEET	DS	SW	JB	2/3/2021
REV	DESCRIPTION	DESIGNER	CHECKED BY	ENGINEER	DATE