

NOTES:

1. ALL WELDING AND HORIZ. FILLETS PER WPS 3-039, 7-032, 7-048 OR 7-054. FOR ALL POSITION WELDS AND WELDS OF CONNS. TO SHELL (UNDER 2 NOM. PIPE SIZE), WELD PER WPS 3-015 UNLESS OTHERWISE INDICATED.
2. MINIMUM CLEARANCE OF 3/8 MUST BE MAINTAINED BETWEEN ANY RAW EDGE AND TUBES, AND MINIMUM CLEARANCE OF 1/4 BETWEEN ANY FLAT SURFACE AND TUBES.
3. TUBES TO BE APPROXIMATELY CENTERED BETWEEN TUBE HEADS BEFORE EXPANSION. TUBE EXTENSION TO BE FLUSH TO HALF O.D. OF TUBE BEYOND TUBE HEAD FACE, EACH END OF SHELL.
4. EXPAND AND SEAL THE TUBES INTO THE TUBE HEADS AND ALL TUBE SUPPORTS PER M-950. TUBES SHALL BE EXPANDED INTO THE TUBE HEAD TO A DEPTH OF 1-1/2".
5. APPLY FEL-PRO C5-A COMPOUND (013-01690) TO SPOTFACE & THREAD SURFACES BEFORE TIGHTENING. CHANNEL BOX GASKET JOINT THREAD FASTENERS SHALL BE TIGHTENED EVENLY IN GRADUAL TORQUE INCREMENTS, DIAMETRICALLY BY QUADRANTS UNTIL THE DESIRED TORQUE OF 169 FT. LBS. ±10% IS REACHED. TO ASSURE PROPER APPLIED GASKET LOADING, TIGHTENING SHALL NEVER BE ACCOMPLISHED PROGRESSIVELY.
6. ADD LABELS, ITEMS 63 AND 64 AFTER PAINTING.
7. BEFORE INSTALLATION OF STUDS, APPLY SEALER (013-01671-000) PER PROCESS SPEC. M-365.
8. ITEM 70 IS THE MAXIMUM QTY. OF EXTRA TUBES TO BE SHIPPED WITH THE SHELL. SOME OF THIS QTY. MAY HAVE BEEN USED IN MANUFACTURING.
9. FOR BOLTING TORQUE AND INSTRUCTIONS, SEE DWG. 077-10989-000.
10. NOZZLE REINFORCING PADS ARE TO BE SOAP TESTED FOR LEAKS AT 100 P.S.I. PRIOR TO HYDROSTATIC TEST.
11. COMPLETE ALL WELDING BEFORE HYDROSTATIC TEST.
12. AFTER ALL TESTING AND CLEANING HAS BEEN COMPLETED. ADD CLOSURES WHERE INDICATED AND CHARGE SHELL SIDE PER M-405. DRY AND PURGE TUBE SIDE PER M-532 AND CHARGE WITH 5 PSI NITROGEN.
13. PAINT PER INSTRUCTIONS ON SALES ORDER.
14. ALL COUPLINGS WELDED INTO SHELL PER DETAIL V UNLESS OTHERWISE INDICATED.
15. FOR REFRIGERANT THREADED JOINTS UP TO 1/2", USE SEALANT 013-03089-000 (RED, LOCTITE 554) AND FOR REFRIGERANT JOINTS 1/2" TO 3" USE SEALANT 013-03056-000 (RED, LOCTITE 277) PER PROCESS SPEC. M-365.
16. FOR WATER THREADED JOINTS UP TO 3", USE SEALANT 013-02023-000 OR 013-03090-000 (WHITE, LOCTITE 565) PER PROCESS SPEC. M-365.
17. CERTIFICATION AND CLASSIFICATION PER M-139. YORK CLASS B VESSEL. SHELL CHAMBER TEST PER M-382, PARA. 5.7 (BEFORE TUBING), 5.9 TUBE CHAMBER TEST PER M-382, PARA. 5.7
18. DATA NAMEPLATE STAMPING AS FOLLOWS:

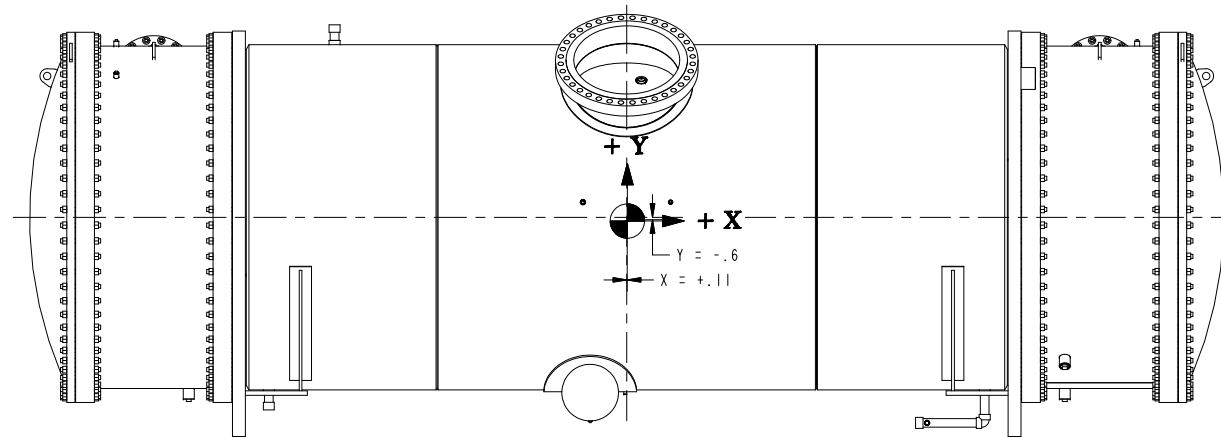
W	(by Q.C.) (National Board Serial Number)
CERTIFIED BY	
(Name of Manufacturer)	
SHELL CHAMBER	
300 psi at +10° TO +175° F (Max Allowable Working Pressure)	
+10° F at 300 psi (Min. Design Metal Temperature)	
()	
TUBE CHAMBERS	
180 psi at +30° TO +160° F (Max. Allowable Working Pressure)	
+30° F at 180 psi (Min. Design Metal Temperature)	
()	
(by Q.C.) (Manufacturer's Serial Number)	(by Q.C.) (Year Built)

DRY WEIGHT AS FOLLOWS:
 A) SHELL WITH TUBE HEADS = 48,985 LBS.
 B) A + WATER NOZZLES AND BOXES = 63,900 LBS.
 C) B + COVERS = 76,440 LBS.
 D) C + TUBES = 105,460 LBS.

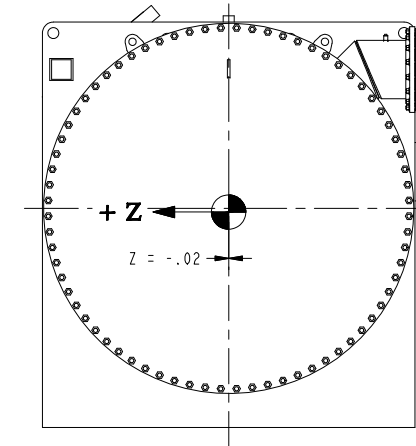
HYDRO. WEIGHT AS FOLLOWS:
 A) WATER BOXES AND SHELL FILLED WITH WATER = 161,000 LBS.

OPERATING WEIGHT (LESS REFRIGERANT) = 136,125 LBS.

= CENTER OF GRAVITY



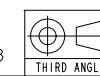
CENTER OF GRAVITY
 W/O TUBES AND NOZZLE CLOSURES



19. CLEAN VESSEL IN ACCORDANCE WITH ENG. STD. M-90.
- 20.
21. INSERT FILTER CLOTH, ITEM 44, AFTER HYDROSTATIC TEST.

S.O. 0J060251-03 THRU 18

YC10-057



YORK INTERNATIONAL CORPORATION
 YORK, PA 17405

THIS VESSEL CONFORMS TO THE REQUIREMENTS OF THE ASME PRESSURE VESSEL CODE SECTION VIII, DIVISION I, LATEST EDITION AND ADDENDA.

REV.	DATE	EC. NO.	DR.	CHK.	ENG.
G	02-APR-2011	CS11-0206	MJV	MJV	
SHT. 2: REVISED WELDING AT LOC. C-5.					
SHT. 3: REVISED ITEMS 7, 8 AND 9 IN SECT. B-B; ADDED (2) ITEM 73 IN SECT. B-B.					

CONTINUED

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DIMENSIONS ARE IN INCHES DO NOT SCALE TOLERANCES PER ENG. STD. M-282		DWG-EVAPORATOR 92 10 X 18 LG Y CL B 3 PASS, 3948 TUBES 300/180 DWP TITAN		MATERIAL ENG. STD. PART NO. CUT SIZE	
DRAWN M. J. VANBUREN	15-SEP-2010	CAGE NUMBER	DRAWING NUMBER	REVISION	6
MODELER M. J. VANBUREN	03-SEP-2010	D	077-31990-000	VERSION	9
CHKD M. J. VANBUREN	24-SEP-2010	66935	9	SHEET 1 OF 5	RELEASED
ENG	SCALE: .012	WEIGHT:	ORIG. NO.: 077-28921D REV. A		