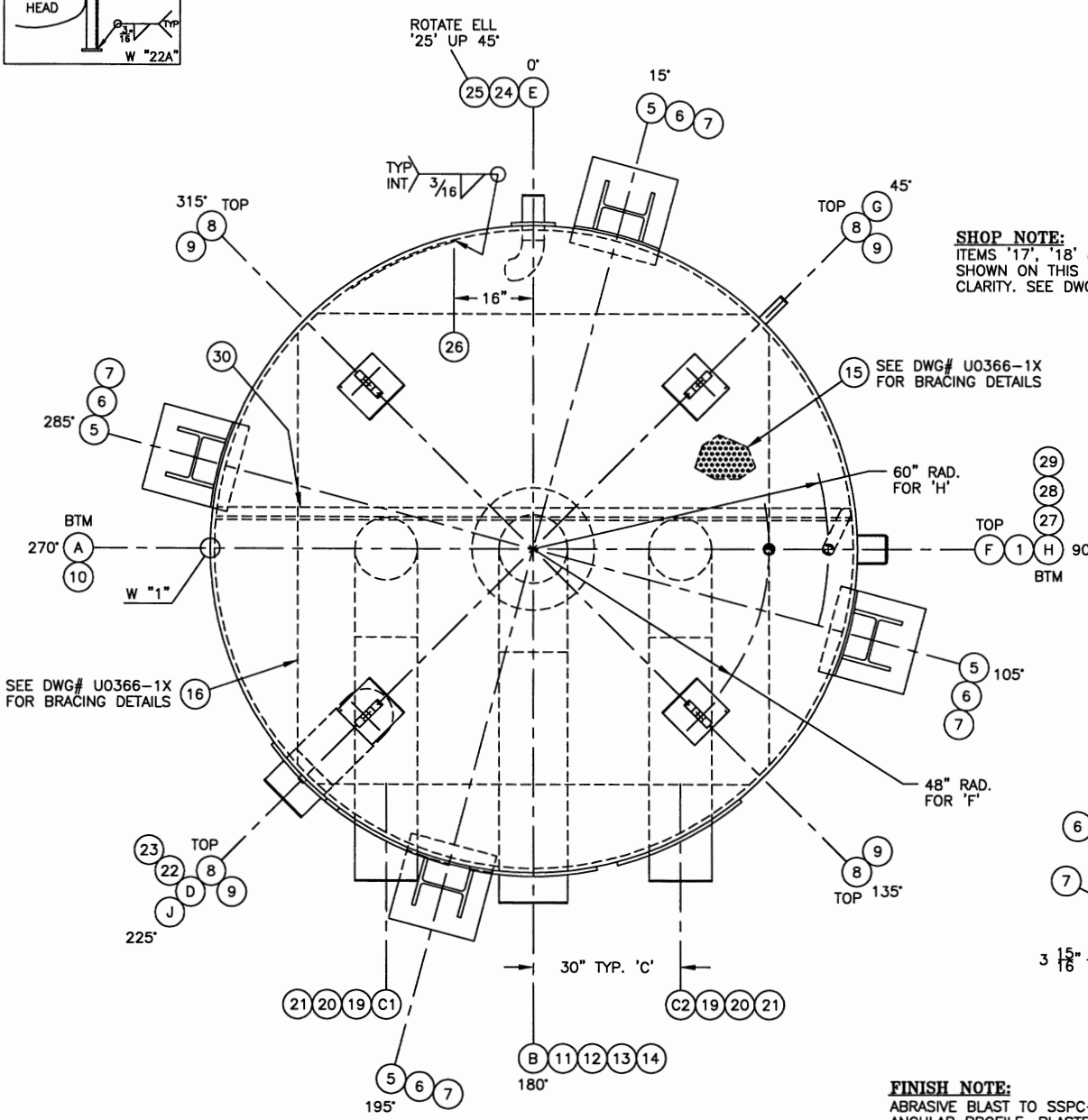
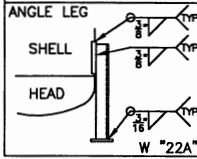
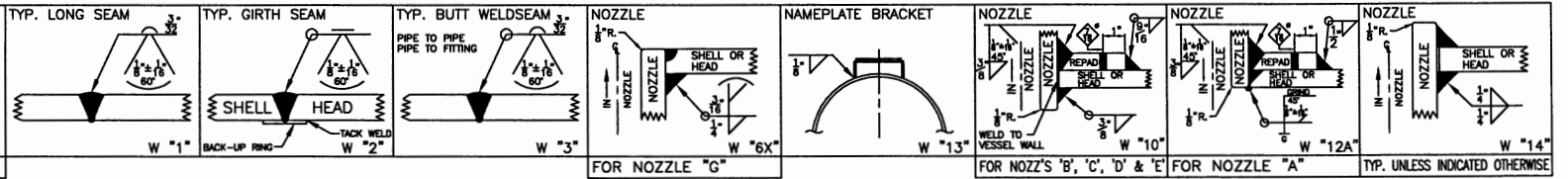
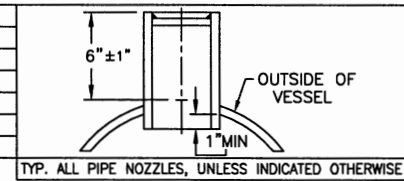


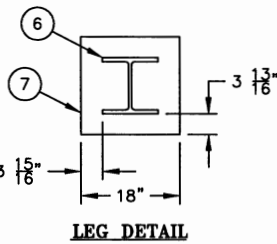
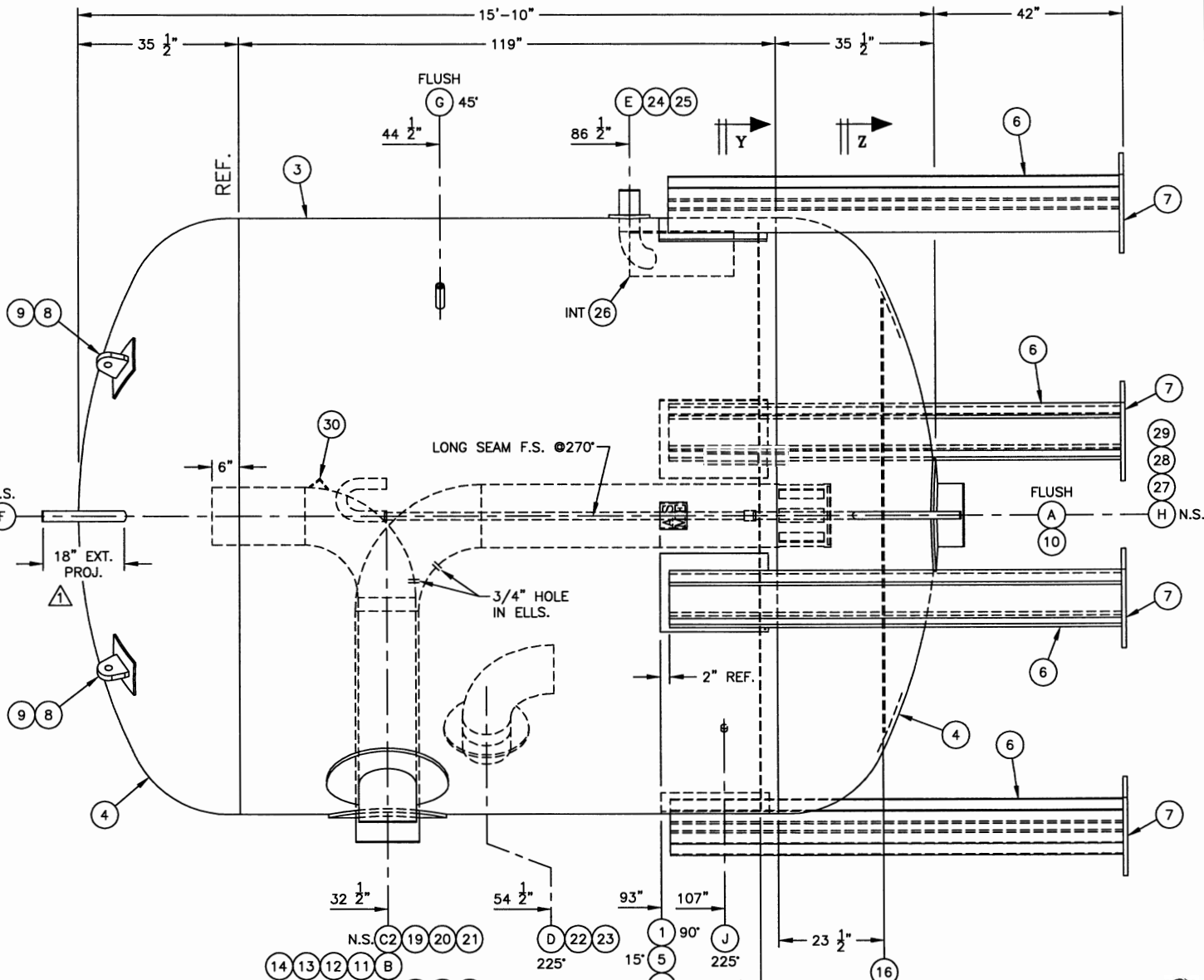
- GENERAL NOTES**
- 1) SA53B SMLS PIPE MAY BE SUBSTITUTED FOR SA106B SMLS PIPE.
 - 2) SA516-70 PLATE MAY BE SUBSTITUTED FOR SA36 PLATE.
 - 3) FABRICATION TOLERANCES PER RVS SHOP PROCEDURE NO. T-701.
 - 4) ALL BOLT HOLES STRADDLE CENTERLINE UNLESS INDICATED OTHERWISE.
 - 5) ALL CPLGS EXTEND INSIDE FOR WELDING UNLESS INDICATED OTHERWISE.

ALL WELDS UNLESS INDICATED OTHERWISE		
PROCESS	WPS NO.	ELECTRODE
GTAW	109	ER70S-2
SMAW	1002	E7018
FCAW	1005	E71T-1
GMAW-S	2002	ER70S-3
SAW	5005	L61 WIRE/960 FLUX



SHOP NOTE:
ITEMS '17', '18' & '31' ARE NOT SHOWN ON THIS DRAWING FOR CLARITY. SEE DWG# U0366-1X

FINISH NOTE:
ABRASIVE BLAST TO SSPC-SP6 TO ACHIEVE A 2 TO 3 MIL ANGULAR PROFILE, BLASTED SURFACE WILL BE COATED SAME DAY AS IT IS BLASTED OR BEFORE RUST BLOOM OR CONTAMINATION CAN OCCUR ON BLASTED SURFACE.
APPLY 5 TO 6 MIL D.F.T. OF PLY-MASTIC EPOXY COATING ALUMINUM. COATING WILL BE HOLIDAY TESTED USING A LOW VOLTAGE HOLIDAY TESTER. ALL HOLIDAYS WILL BE REPAIRED USING PLY-MASTIC EPOXY. FINISH COAT WILL BE APPLIED WITH IN RECOAT WINDOW, IF FINISH COAT CANNOT BE APPLIED WITH IN THIS PERIOD SURFACE WILL BE SANDED TO PROVIDE A GOOD MECHANICAL BOND WITH FINISH COAT.



ITEM	QTY	SIZE	DESCRIPTION	RATING	MATERIAL	LENGTH
31	2	3" X 3"	ANGLE (SEE U0366-1X FOR ORIENT.)	1/4"	SA36	63 1/2"
30	1	3" X 3"	ANGLE (BRACE) (53 lbs)	1/4"	SA36	129 1/2"
29	1	2"	"U" BEND PIPE	S/40	SA53A-F	1/2"
28	1	1 1/4"	PIPE	S/80	SA106B	80"
27	1	1 1/4"	CPLG	3000#	SA105	
26	1	23" X 23"	PLATE (W/ 1/4" WEEP HOLE)	3/8"	SA36	56 lbs
25	1	4"	90° B.W. ELBOW	S/40	SA234-WPB	L.R.
24	1	9"OD X 4 7/8"ID	PLATE (REPAD)	3/4"	SA516-70	for 'E'
23	1	10"	90° B.W. ELBOW (88 lbs)	S/40	SA234-WPB	L.R.
22	1	19"OD X 11"ID	PLATE (REPAD)	3/4"	SA516-70	for 'D'
21	2	12"	PIPE (85 lbs EA.)	S/STD	SA53B-ERW	20 1/2"
20	2	12"	90° B.W. ELBOW (125 lbs EA.)	S/STD	SA234-WPB	L.R.
19	2	7" ALL AROUND	PLATE (REPAD) (95 lbs EA.)	3/4"	SA516-70	for 'C'
18	6	3" X 3"	ANGLE (SEE U0366-1X FOR ORIENT.)	3/8"	SA36	58"
17	1	3" X 3"	ANGLE (SEE U0366-1X FOR ORIENT.)	3/8"	SA36	130"

Rev.	DATE	DESCRIPTION	APRV'D / DATE
1	8/10/00	REVISED SPLASH PL DESIGN / ENG. CHANGES / RELEASED FOR FAB.	CCS-8/10/00
1	8/10/00	NOZZ. 'F' WAS 6" EXT. PROJ. / NOZZ. 'H' WAS 8" EXT. PROJ.	
0	8/7/00	SENT FOR APPROVAL	CCS-8/7/00

NATIONAL BOARD NO. _____
U
W
RT2
MWP: 250 PSI AT 300°F
MONT: -20°F AT MWP 250 PSI
S/N: S008669 YEAR: 2000
SHELL THK: _____ in HEAD THK: _____ in U.S. GAL. _____ SQ.FT. SURF. _____

TEST WITH WATER

HYDRO NOTES:
1) ESTIMATED VOLUME: 9,580 GAL.
2) TEST WITH NOZZ. 'G' ON BTM.

ITEM	QTY	SIZE	TYPE	RATING	MATERIAL	SERVICE	LENGTH
J	1	3/4"	CPLG	3000#	SA105	TEST VENT	
H	1	1 1/4"	PIPE	S/80	SA106B	EQ. (DTL ON U0366-1X)	46"
G	1	1 1/2"	PIPE	S/80	SA106B	LEVEL COLUMN	7 1/2"
F	1	2"	PIPE	S/40	SA106B	RELIEF	20 1/2"
E	1	4"	PIPE	S/40	SA106B	LIQUID MAKE-UP	9"
D	1	10"	PIPE	S/40	SA106B	SUCTION IN	9"
C	2	12"	PIPE	S/STD	SA53B-ERW	SUCTION OUT (204 lbs EA.)	49 1/2"
B	1	14"	PIPE	S/STD	SA53B-ERW	BOOSTER DISCH. (211 lbs)	46 1/2"
A	1	14"	PIPE	S/STD	SA53B-ERW	LIQUID OUTLET	7 1/2"

BILL of MATERIALS

ITEM	QTY	SIZE	DESCRIPTION	RATING	MATERIAL	LENGTH
16	1	96" X 96"	PLATE (SEE DTL ON U0366-1X)	3/8"	SA36	
15	1	129 3/4"OD X 14 1/4"ID	47% OPEN PERFL. PLATE (330 lbs)	3/16"	SA36	
14	1	13 1/8" O.D.	PLATE (END CAP)	1/2"	SA36	
13	1	14"	PIPE (DTL ON U0366-1X) (132 lbs)	S/STD	SA53B-ERW	77 1/2"
12	1	14"	90° B.W. ELBOW (180 lbs)	S/STD	SA234-WPB	L.R.
11	1	26"ODx14 1/4"ID	PLATE (REPAD) (79 lbs)	3/4"	SA516-70	for 'B'
10	1	25"ODx14 1/4"ID	PLATE (REPAD) (59 lbs)	5/8"	SA516-70	for 'A'
9	4	6"	HVY LIFT LUG	1 1/4"	SA36	6"
8	4	10"	FLAT (W/ 1/4" HOLE NEAR A CRNR)	1 1/2"	SA36	10"
7	4	18" X 18"	PLATE (92 lbs EA.)	1"	SA36	
6	4	10"	WIDE FLANGE (6,834 lbs EA.)	6#	SA36	100 1/2"
5	4	18" X 24"	PLATE (W/ 1/4" HOLE NEAR A CRNR)	1 1/2"	SA516-70	61 lbs EA.
4	2	132" O.D.	2:1 ELLIP. HEAD (5,527 lbs EA.)	1"	SA516-70	
3	1	132" O.D.	ROLLED SHELL (12,139 lbs)	7/8"	SA516-70	119"
2	2	1 1/2"	BACKING STRIP	1/8"	SA36	415"
1	1	6" TALL	STD NAMEPLATE BRACKET		SA36	6"

CUSTOMER TROPICANA / T.S.G. P.O. 60001537-03

VESSEL DESIGN SPECIFICATIONS
DESIGN & CONSTRUCTION IN ACCORDANCE WITH SECTION VIII DIV. 1 ASME CODE FOR PRESSURE VESSELS 1998 EDITION & ADDENDA TO 1999
SHELL: SA516-70 7/8" (.821" MIN.) CA: 0
HEADS: SA516-70 1" (.816" MIN.) 2:1 CA: 0
M.A.W.P.: 250 P.S.I. HYDROTEST: 325 P.S.I.
-20 °F To 300 °F
RT: LONG: FULL / GIRTH: SPOT RT: NONE
PAINT: SEE FINISH NOTE

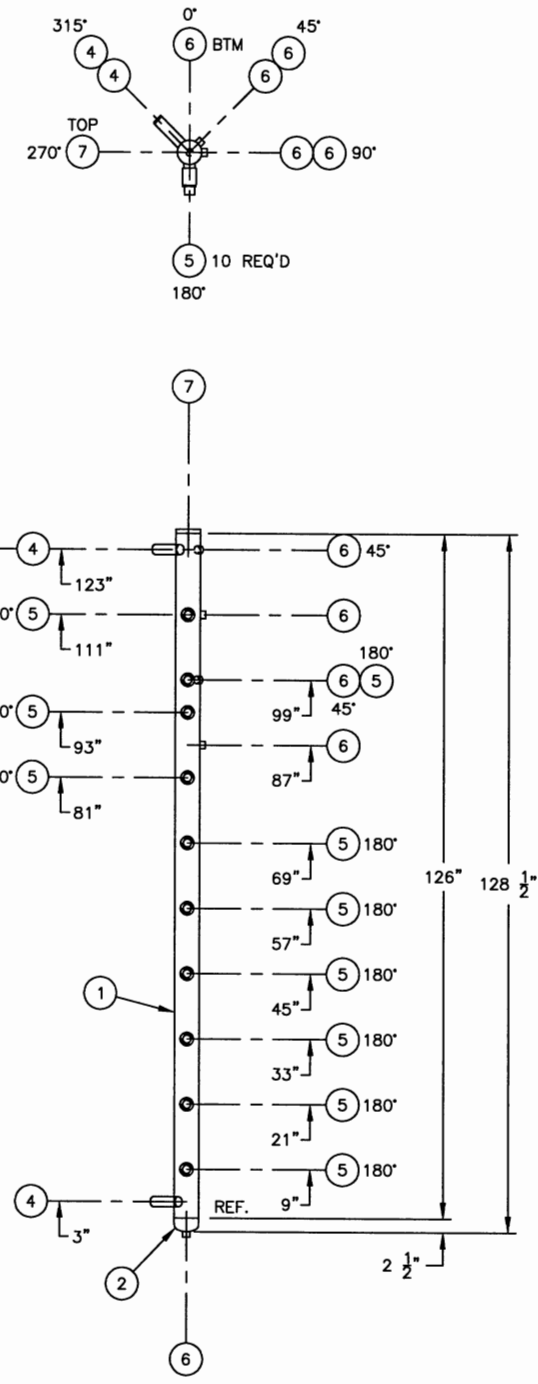
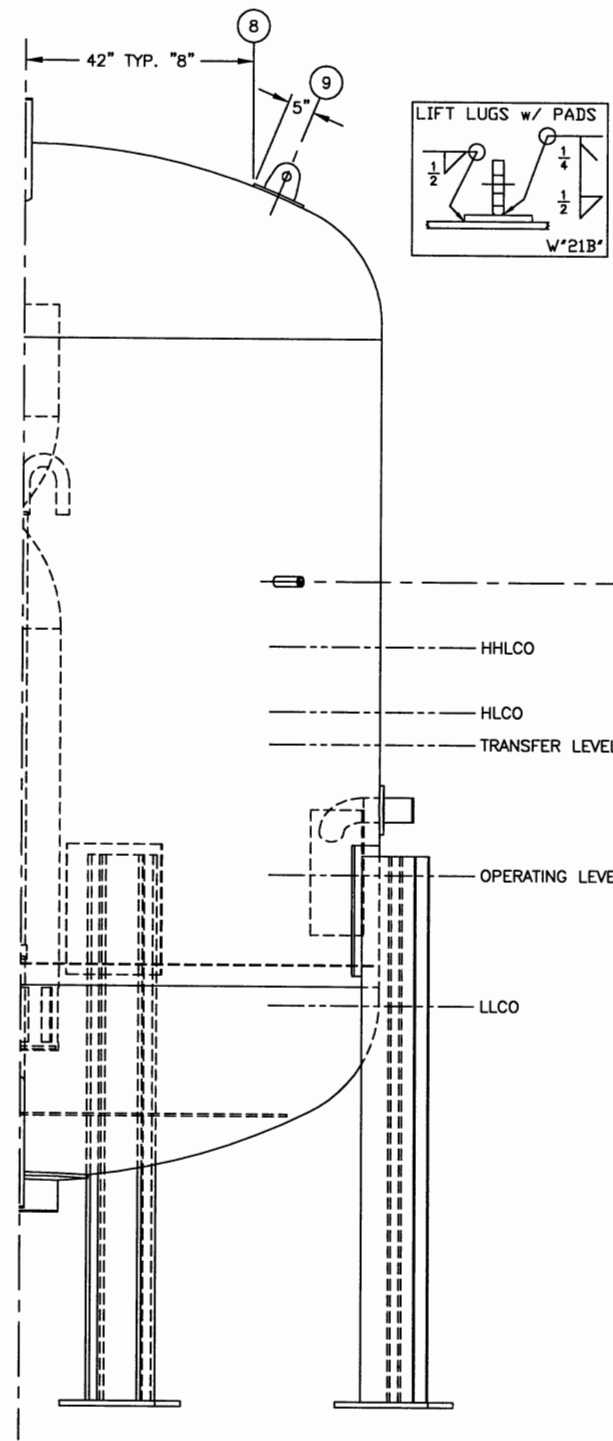
PRESSURE VESSELS and PACKAGED RECIRCULATION SYSTEMS

REPERATION VALVES and SYSTEMS CORPORATION
1630 CROSSWIND DRIVE, BRYAN, TX 77808

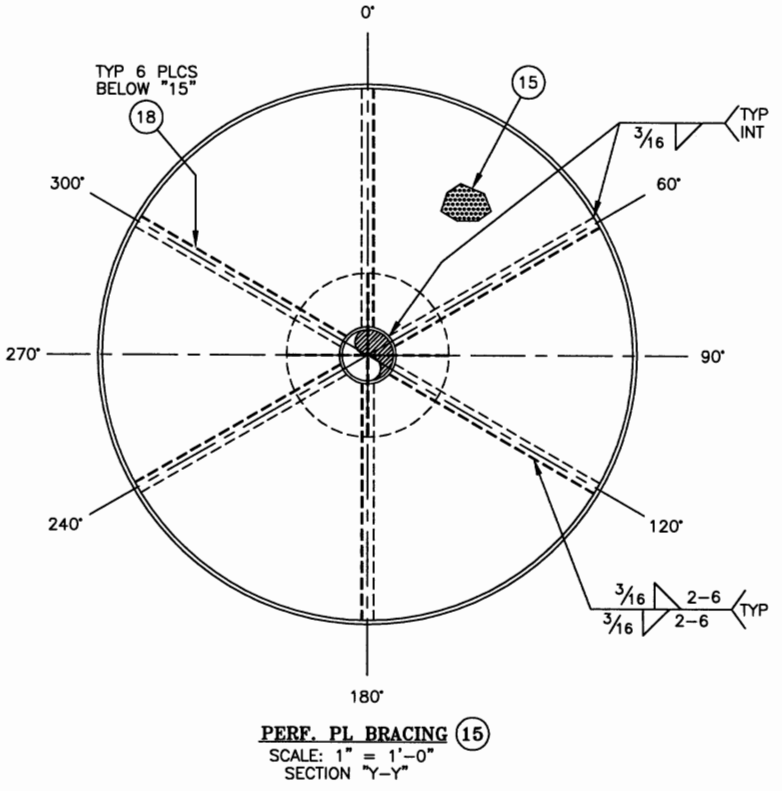
EVA PCO, INC.
P.O. BOX 1300, WESTMINSTER, MD. 21156

TITLE 132" O.D. X 15'-10" ASME 250# VERT. INTERCOOLER
DRAWN CCS-8/4/00 **CHK'D** CCS-8/4/00 **S/N:** S008669 **DWG No.** U0366-1 **REV.** 1
BY: CCS-8/10/00 **SCALE:** 3/4" = 1'-0" **THRU**





#10 LEVEL COLUMN
SHIP LOOSE



PERF. PL BRACING (15)
SCALE: 1" = 1'-0"
SECTION "Y-Y"

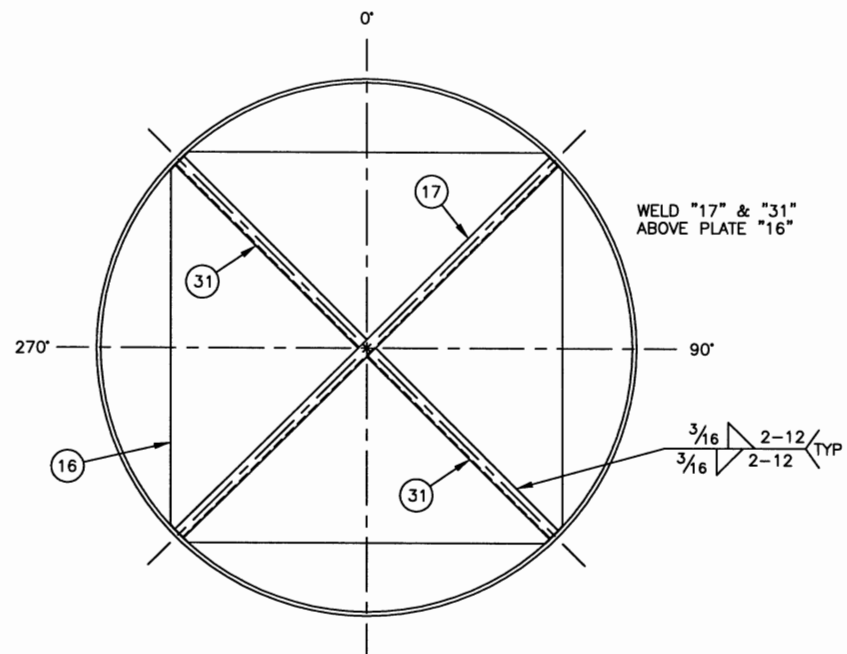
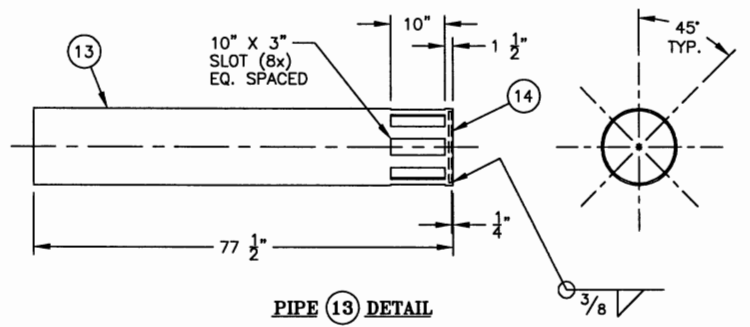
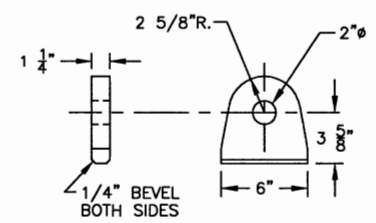


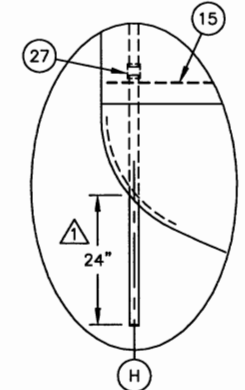
PLATE BRACING (16) Δ
SCALE: 1" = 1'-0"
SECTION "Z-Z"



PIPE (13) DETAIL



LIFT LUG BEVEL DETAIL (9)
N.T.S.



PIPE (H) DETAIL

CERTIFIED

BILL of MATERIALS									
SHELL, HEADS, INTERNALS, & SUPPORTS					SHELL, HEADS, INTERNALS, & SUPPORTS				
ITEM	QTY	SIZE	TYPE	RATING	MATERIAL	LENGTH	ITEM	QTY	SIZE
							7	1	4 1/2" O.D.
							8	5	3/4"
							5	10	LI-4F
							4	2	1 1/2"
							3	1	4"
							2	1	4"
							1	1	4"

CUSTOMER		TROPICANA / T.S.G.		P.O. 60001537-03																																											
<table border="1"> <thead> <tr> <th colspan="6">REVISIONS</th> </tr> <tr> <th>REV #</th> <th>DATE</th> <th>BY</th> <th>DESCRIPTION</th> <th>APR'D</th> <th></th> </tr> </thead> <tbody> <tr> <td>0</td> <td>8/7/00</td> <td>CCS</td> <td>SENT FOR APPROVAL</td> <td>CCS</td> <td></td> </tr> <tr> <td>1</td> <td>8/10/00</td> <td>CCS</td> <td>SEE REV. DESC. ON U0366-1</td> <td>CCS</td> <td></td> </tr> <tr> <td>1</td> <td>8/10/00</td> <td>CCS</td> <td>RELEASED FOR FABRICATION</td> <td>CCS</td> <td></td> </tr> </tbody> </table>						REVISIONS						REV #	DATE	BY	DESCRIPTION	APR'D		0	8/7/00	CCS	SENT FOR APPROVAL	CCS		1	8/10/00	CCS	SEE REV. DESC. ON U0366-1	CCS		1	8/10/00	CCS	RELEASED FOR FABRICATION	CCS													
REVISIONS																																															
REV #	DATE	BY	DESCRIPTION	APR'D																																											
0	8/7/00	CCS	SENT FOR APPROVAL	CCS																																											
1	8/10/00	CCS	SEE REV. DESC. ON U0366-1	CCS																																											
1	8/10/00	CCS	RELEASED FOR FABRICATION	CCS																																											
<table border="1"> <thead> <tr> <th colspan="6">TITLE</th> </tr> <tr> <th colspan="6">#10 LEVEL COL. & DETAILS FOR S/N S008669 VERT. INTERCOOLER</th> </tr> </thead> <tbody> <tr> <td>DRAWN BY:</td> <td>CCS-8/4/00</td> <td>CHK'D BY:</td> <td>CCS-8/4/00</td> <td>S/N:</td> <td>S008669</td> </tr> <tr> <td>APR'D BY:</td> <td>CCS-8/10/00</td> <td>SCALE:</td> <td>3/4" = 1'-0"</td> <td>Thru:</td> <td></td> </tr> </tbody> </table>						TITLE						#10 LEVEL COL. & DETAILS FOR S/N S008669 VERT. INTERCOOLER						DRAWN BY:	CCS-8/4/00	CHK'D BY:	CCS-8/4/00	S/N:	S008669	APR'D BY:	CCS-8/10/00	SCALE:	3/4" = 1'-0"	Thru:																			
TITLE																																															
#10 LEVEL COL. & DETAILS FOR S/N S008669 VERT. INTERCOOLER																																															
DRAWN BY:	CCS-8/4/00	CHK'D BY:	CCS-8/4/00	S/N:	S008669																																										
APR'D BY:	CCS-8/10/00	SCALE:	3/4" = 1'-0"	Thru:																																											
<table border="1"> <thead> <tr> <th colspan="6">PRESSURE VESSELS and PACKAGED RECIRCULATION SYSTEMS</th> </tr> <tr> <th colspan="6"> </th> </tr> <tr> <th colspan="6"> REGENERATION VALVES and SYSTEMS CORPORATION 1500 CROSSROAD DRIVE, DRYDEN, TX 77908 </th> </tr> <tr> <th colspan="6"> </th> </tr> <tr> <td colspan="4">EVAPCO, INC.</td> <td colspan="2">P.O. BOX 1300, WESTMINSTER, MD. 21156</td> </tr> </thead> <tbody> <tr> <td colspan="4">DWG No.</td> <td colspan="2">U0366-1X</td> </tr> <tr> <td colspan="4">REV.</td> <td colspan="2">1</td> </tr> </tbody> </table>						PRESSURE VESSELS and PACKAGED RECIRCULATION SYSTEMS												REGENERATION VALVES and SYSTEMS CORPORATION 1500 CROSSROAD DRIVE, DRYDEN, TX 77908												EVAPCO, INC.				P.O. BOX 1300, WESTMINSTER, MD. 21156		DWG No.				U0366-1X		REV.				1	
PRESSURE VESSELS and PACKAGED RECIRCULATION SYSTEMS																																															
REGENERATION VALVES and SYSTEMS CORPORATION 1500 CROSSROAD DRIVE, DRYDEN, TX 77908																																															
EVAPCO, INC.				P.O. BOX 1300, WESTMINSTER, MD. 21156																																											
DWG No.				U0366-1X																																											
REV.				1																																											

FORM U-1 MANUFACTURER'S DATA REPORT FOR PRESSURE VESSELS
As Required by the Provisions of the ASME Code Rules, Section VIII, Division 1

1. Manufactured and certified by REFRIGERATION VALVES AND SYSTEMS, CORPORATION, 1520 CROSSWIND DR., BRYAN, TX 77808
2. Manufactured for THE STELLAR GROUP, 2900 HARTLEY RD., JACKSONVILLE, FL. 32257
3. Location of installation TROPICANA PRODUCTS INC., 1275 26TH AVE.EAST, BRADENTON, FL.
4. Type VERT. 132"X15'10" INTERCOOLER S008669
5. ASME Code, Section VIII, Div. 1 1998 1999

6. Shell (a) No. of course(s): 1 (b) Overall length (ft. & in.): 9'11"

Table with columns: Course(s), Material, Thickness, Long. Joint (Cat. A), Circum. Joint (Cat. A, B & C), Heat Treatment. Row 1: 1, 132, 9'11", SA516-70, .875, 0, 1, FULL, 100, 2, SPOT, 80, --, --

7. Heads: (a) SA516-70 NONE (b) SAME

Table with columns: Location (Top, Bottom, Ends), Thickness, Radius, Elliptical Ratio, Conical Apex Angle, Hemispherical Radius, Flat Diameter, Side to Pressure, Category A. Rows for TOP and BOT.

If removable, bolts used (describe other fastening) --- (Mat'l Spec. No., Grade, Size No.)

8. Type of jacket --- Jacket closure --- (describe as ogee & weld, bar, etc.)

If bar, give dimensions --- If bolted, describe or sketch.

9. MAWP 250 (internal) --- (external) psi at max. temp. +300 (internal) --- (external) °F Min. design, metal temp. -20 °F at 250 psi.

10. Impact test NO UG-20-f

11. Hydro. test press 325 (Indicate yes or no and the component(s) impact tested) Proof test ---

Items 12 and 13 to be completed for tube sections

12. Tubesheet Stationary (Mat'l Spec. No.) --- Dia. in. (subject to press.) --- Nom. thk. in. --- Corr. Allow., in. --- Attachment (welded or bolted)

13. Tubes: Mat'l Spec. No., Grade or Type --- O.D., in. --- Nom. thk. in. or gauge --- Number --- Type (Straight or U)

Items 14-18 to be completed for inner chambers of jacketed vessels or channels of heat exchangers.

14. Shell (a) No. of course(s): --- (b) Overall length (ft. & in.): ---

Table with columns: Course(s), Material, Thickness, Long. Joint (Cat. A), Circum. Joint (Cat. A, B & C), Heat Treatment. Row 1: ---, ---, ---, ---, ---, ---, ---, ---, ---, ---, ---, ---, ---, ---

15. Heads: (a) --- (b) ---

Table with columns: Location (Top, Bottom, Ends), Thickness, Radius, Elliptical Ratio, Conical Apex Angle, Hemispherical Radius, Flat Diameter, Side to Pressure, Category A. Rows for (a) and (b).

If removable, bolts used (describe other fastening) --- (Mat'l Spec. No., Grade, Size No.)

FORM U-1 (Back)

16. MAWP psi at max. temp °F Min. design. metal temp. °F at psi.
(internal) (external) (internal) (external)

17. Impact test
(Indicate yes or no and the component(s) impact tested)

18. Hydro., pneu., or comb. test press. Proof test

19. Nozzles, inspection, and safety valve openings:

Purpose (Inlet, Outlet, Drain, etc.)	No.	Diameter or Size	Flange Type	Material		Nozzle Thickness		Reinforcement Material	How Attached		Location (Insp. Open.)
				Nozzle	Flange	Nom.	Corr.		Nozzle	Flange	
MISC.	2,2	14,12	--	SA53B	--	.375	0	SA516-70	WELDED	---	
MISC.	1,1	10,4	--	SA106B	--	S/40	0	SA516-70	WELDED	---	
RELIEF	1	2	--	SA106B	--	S/40	0	INHERENT	WELDED	---	
COLUMN	1	1-1/2	--	SA106B	--	S/80	0	INHERENT	WELDED	---	
EQ.	1	1-1/4	--	SA106B	--	S/80	0	INHERENT	WELDED	---	
TEST	1	3/4	--	SA105	--	3000#	0	INHERENT	WELDED	---	

20. Supports: Skirt NO Lugs 0 Legs 4 Others NONE Attached WELDED TO 4 PADS WELDED TO SHELL.
(Yes or no) (No.) (No.) (Describe) (Where and how)

21. Manufacturer's Partial Data Reports properly identified and signed by Commissioned Inspectors have been furnished for the following items of the report:
 (List the name of part, item number, mfg's. name and identifying number)
N/A

22. Remarks: PRESSURE RELIEF DEVICE SUPPLIED BY OTHERS.
FOR NON-LETHAL, NON-CORROSIVE SERVICE.

CERTIFICATE OF SHOP COMPLIANCE

We certify that the statements made in this report are correct and that all details of design, material, construction, and workmanship of this vessel conform to the ASME Code for Pressure Vessels, Section VIII, Division 1.

U Certificate of Authorization No. 18912 Expires Oct. 10, 2001

Date 9-25-00 Name REFRIGERATION VALVES AND SYSTEMS CORPORATION Signed [Signature]
(Manufacturer) (Representative)

CERTIFICATE OF SHOP INSPECTION

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of TEXAS and employed by COMMERCIAL UNION INSURANCE COMPANY of BOSTON, MA have inspected the pressure vessel described in this Manufacturer's Data Report on SEPT 21, 2000, and state that, to the best of my knowledge and belief, the Manufacturer has constructed this pressure vessel in accordance with ASME Code, Section VIII, Division 1. By signing this certificate neither the Inspector nor his employer makes any warranty, expressed or implied, concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury, property damage or a loss of any kind arising from or connected with this inspection.

Date 9-25-00 Signed [Signature] Commissions NB# 9757 "A" TX1317
(Authorized Inspector) (Nat'l Board incl. endorsement, State, Province and No.)

CERTIFICATE OF FIELD ASSEMBLY COMPLIANCE

We certify that the statements on this report are correct and that the field assembly construction of all parts of this vessel conforms with the requirements of ASME Code, Section VIII, Division 1.

U Certificate of Authorization No. Expires , 20

Date Name Signed
(Assembler) (Representative)

CERTIFICATE OF FIELD ASSEMBLY INSPECTION

I the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of and employed by of have compared the statements in this Manufacturer's Data Report with the described pressure vessel and state that the parts referred to as data items , not included in the certificate of shop inspection, have been inspected by me and to the best of my knowledge and belief, the Manufacturer has constructed and assembled this pressure vessel in accordance with ASME Code, Section VIII, Division 1. The described vessel was inspected and subjected to a hydrostatic test of psi. By signing this certificate neither the Inspector nor his employer makes any warranty, express or implied, concerning the pressure vessel described in this Manufacturer's Data Report. Furthermore, neither the Inspector or his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.

Date Signed Commissions
(Authorized Inspector) (Nat'l Board incl. endorsement, State, Province and No.)