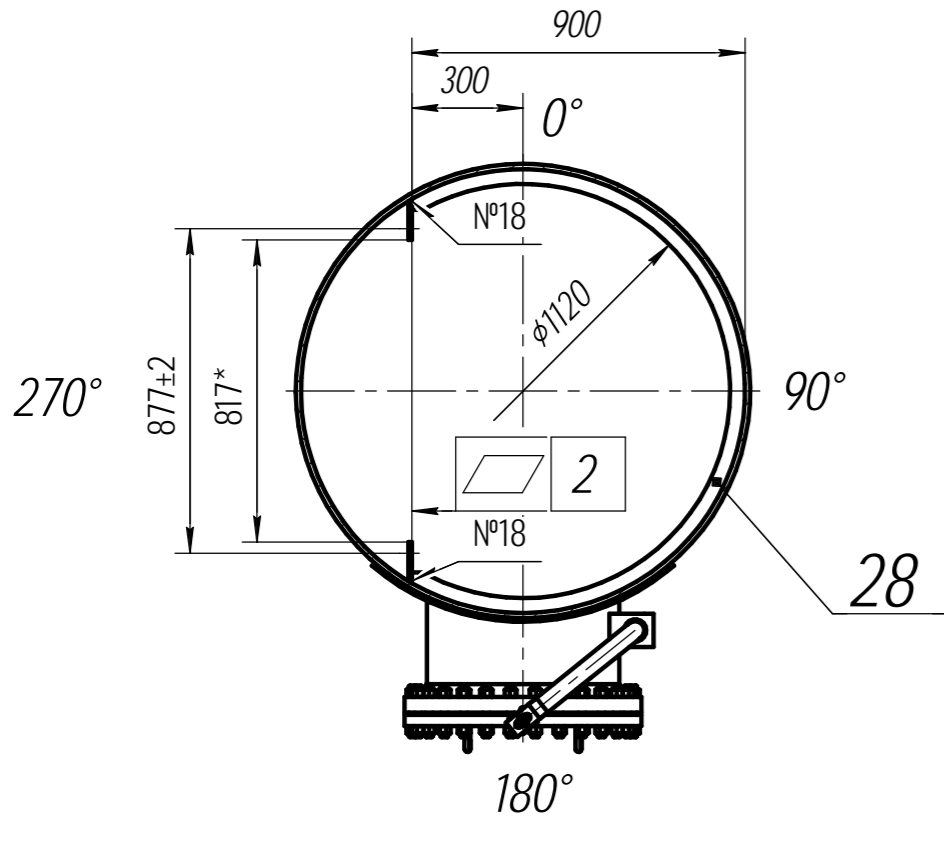
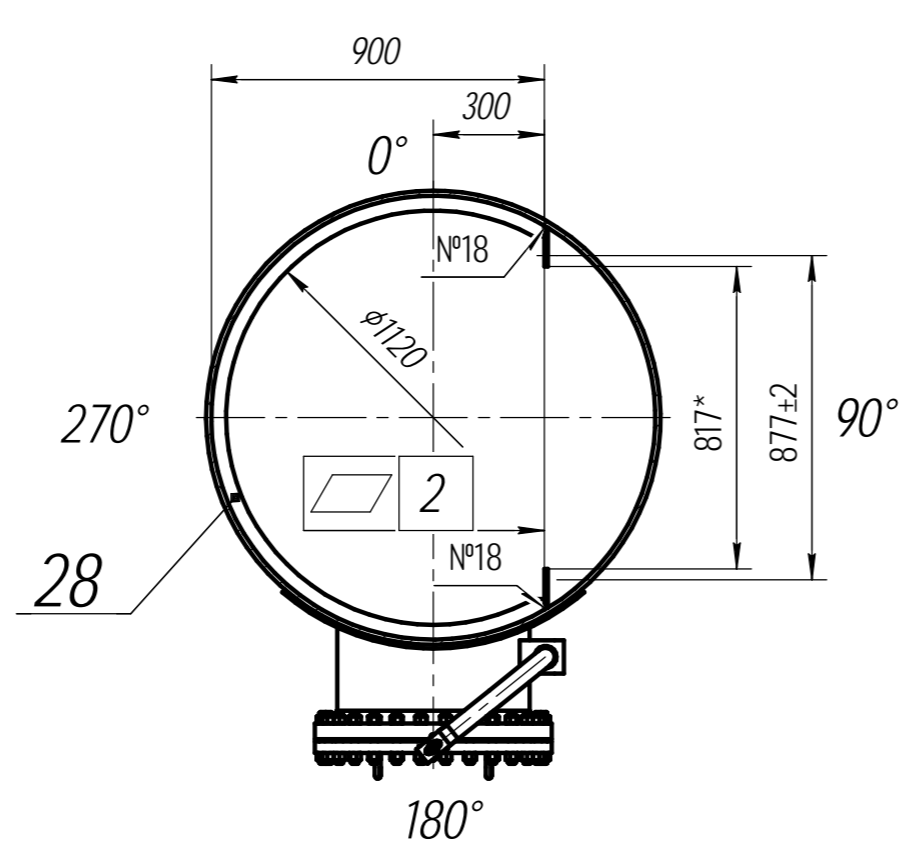


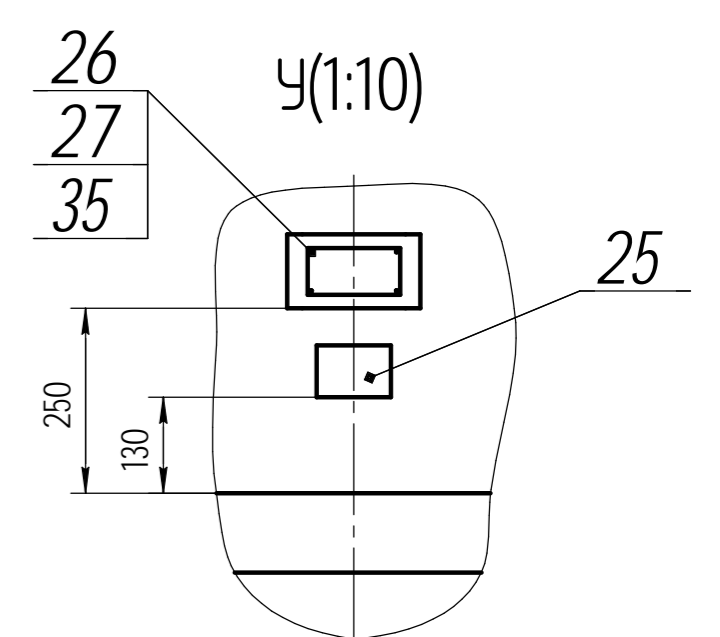
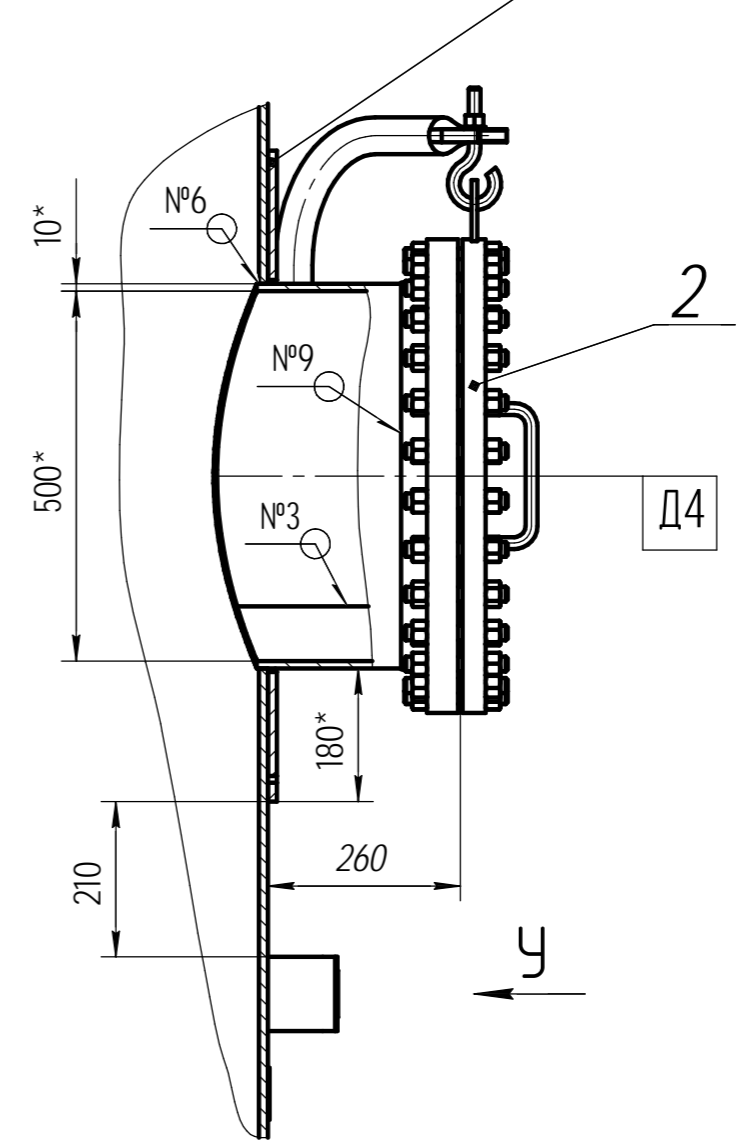
К-К(1:20)(1)
Location of supports for even trays



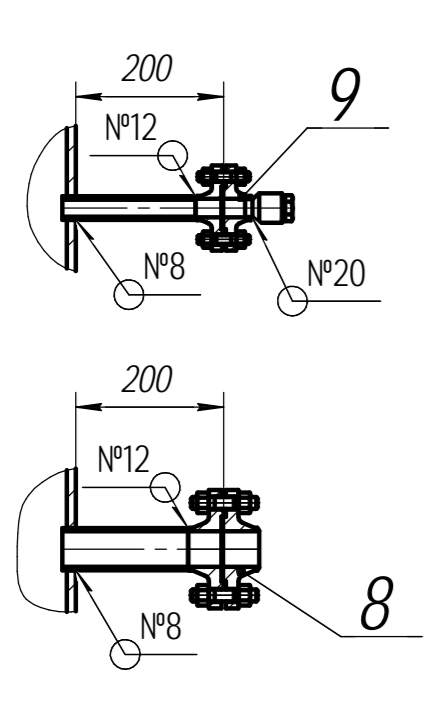
Л-Л(1:20)(1)
Location of supports for odd trays



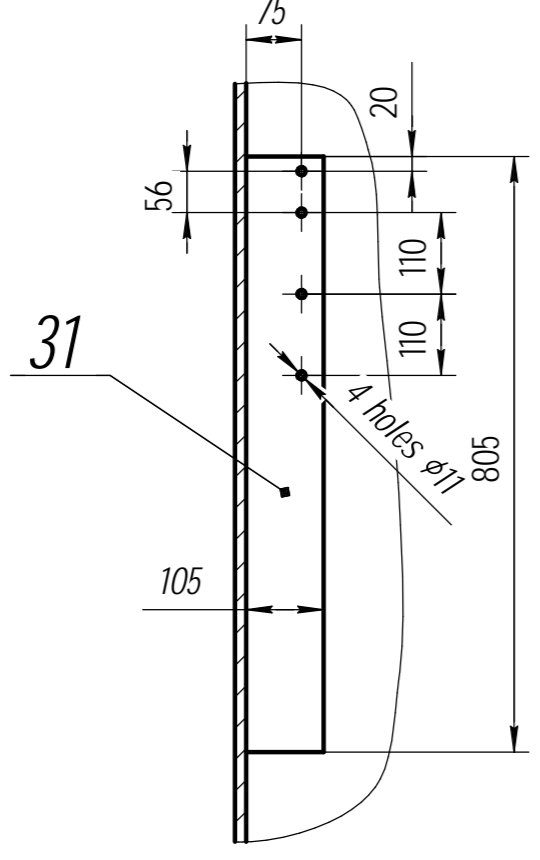
Т-Т(1:10)(1)
(attaching the manway Д4)



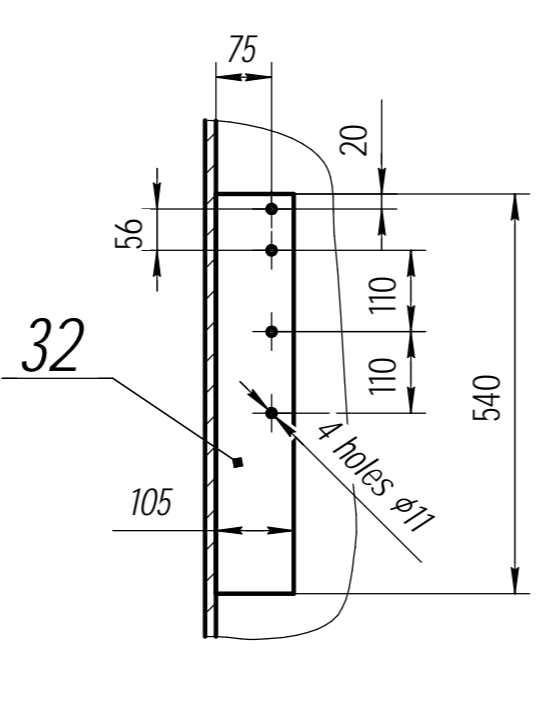
М-М(1:10)(1)



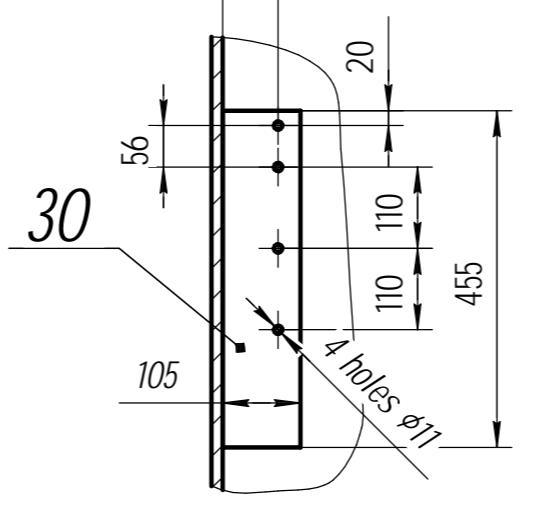
Н(1:10)(1)
(for trays №12, №24)



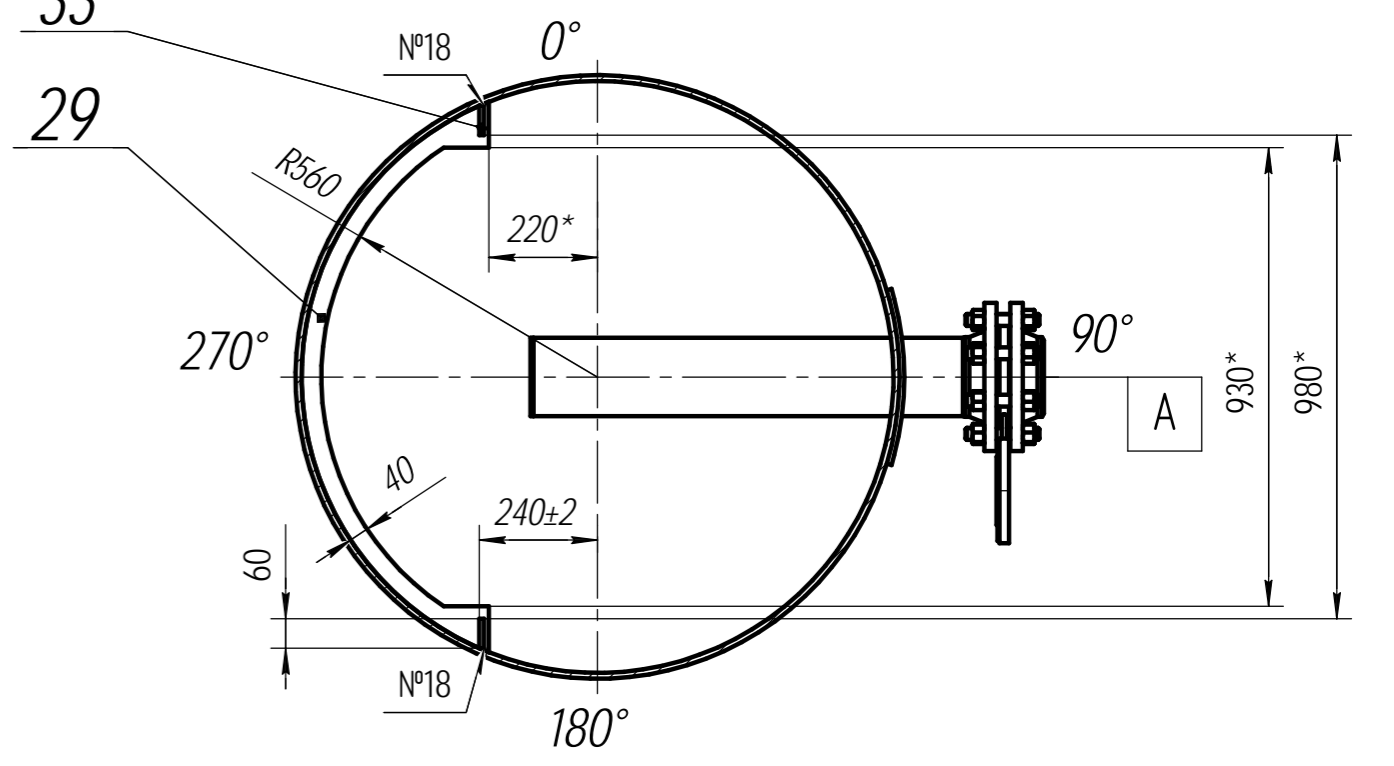
П(1:10)
(for tray №34)



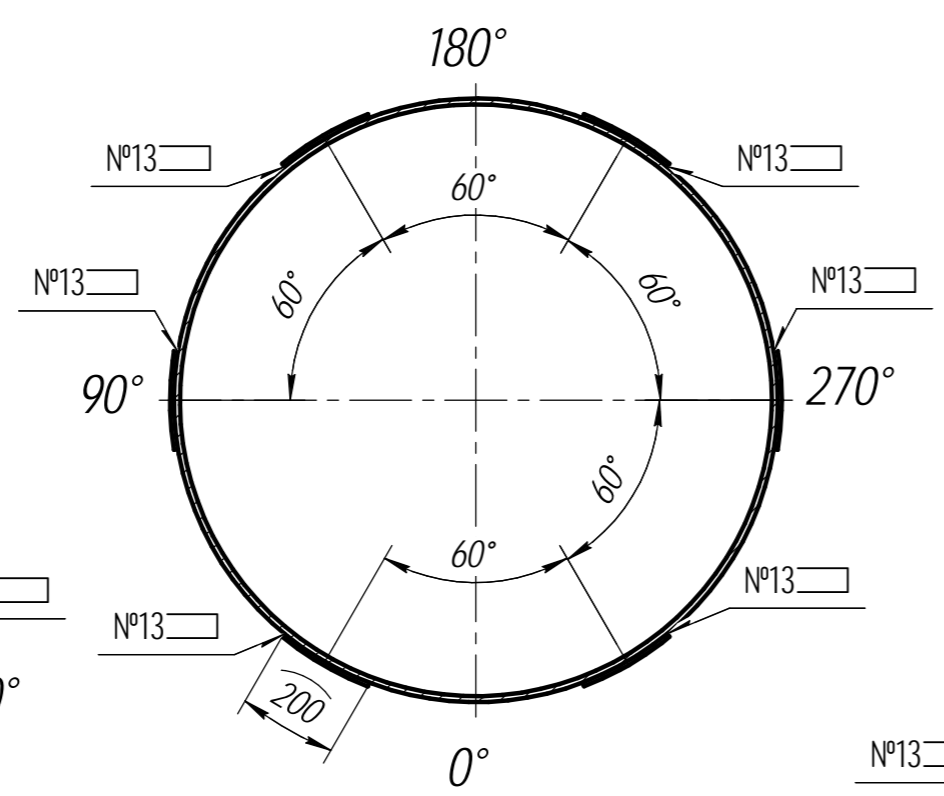
Р(1:10)



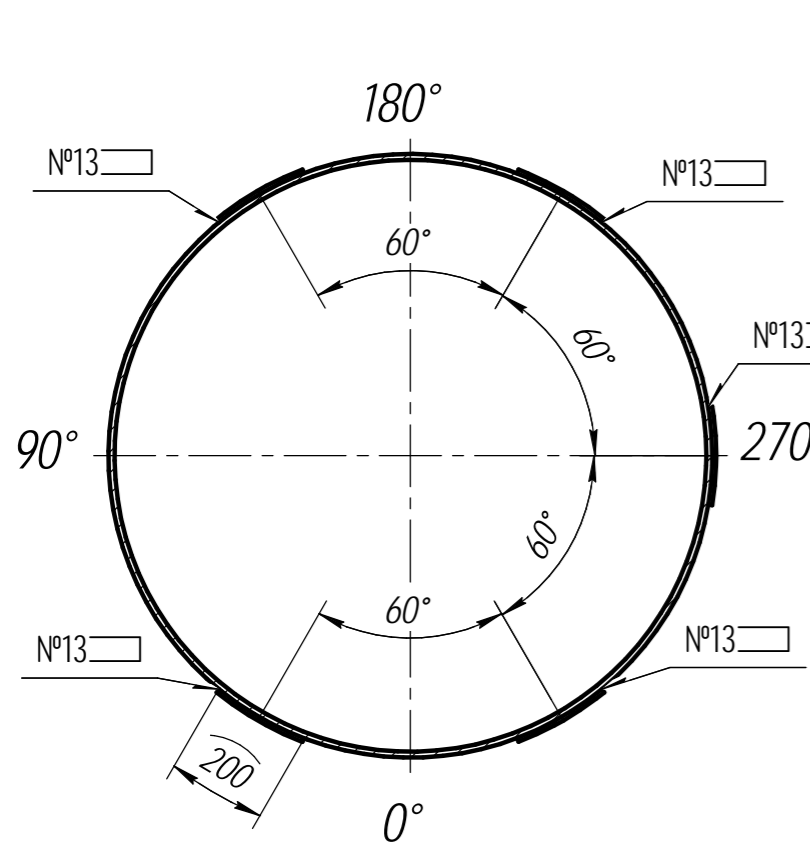
Ц-Ц(1:15)



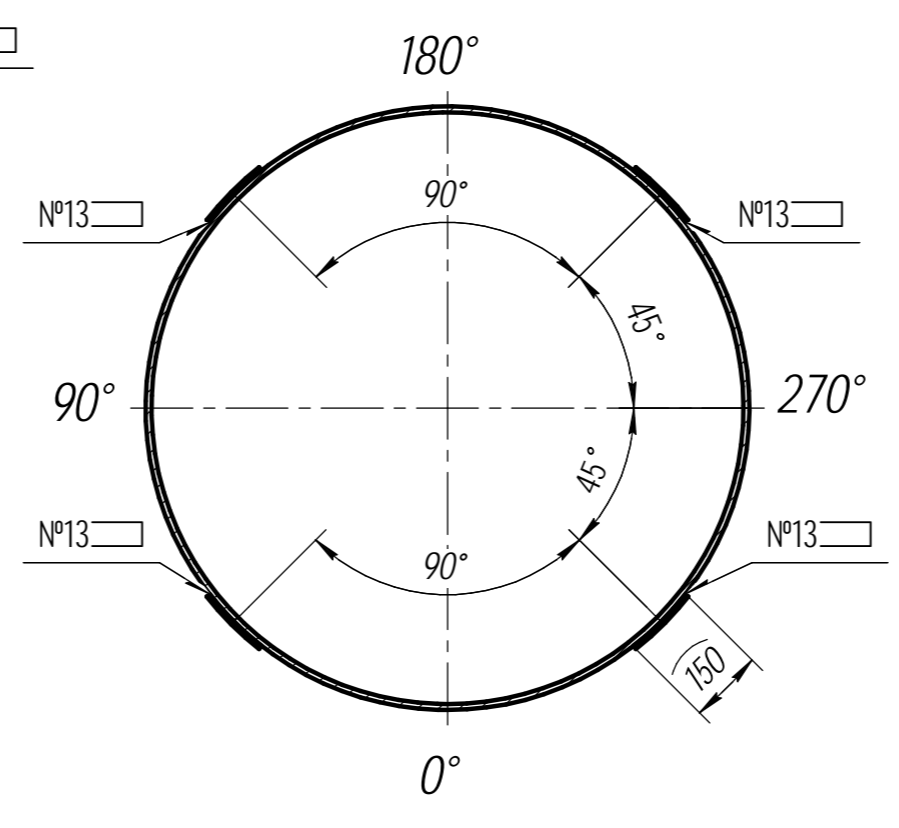
Э-Э(1:15)(1)
layout of pads at EL. +7.500, +10.500, +13.500, +16.500, +18.900
(for platforms at EL. +7.400, +10.400, +13.400, +16.400, +18.800)



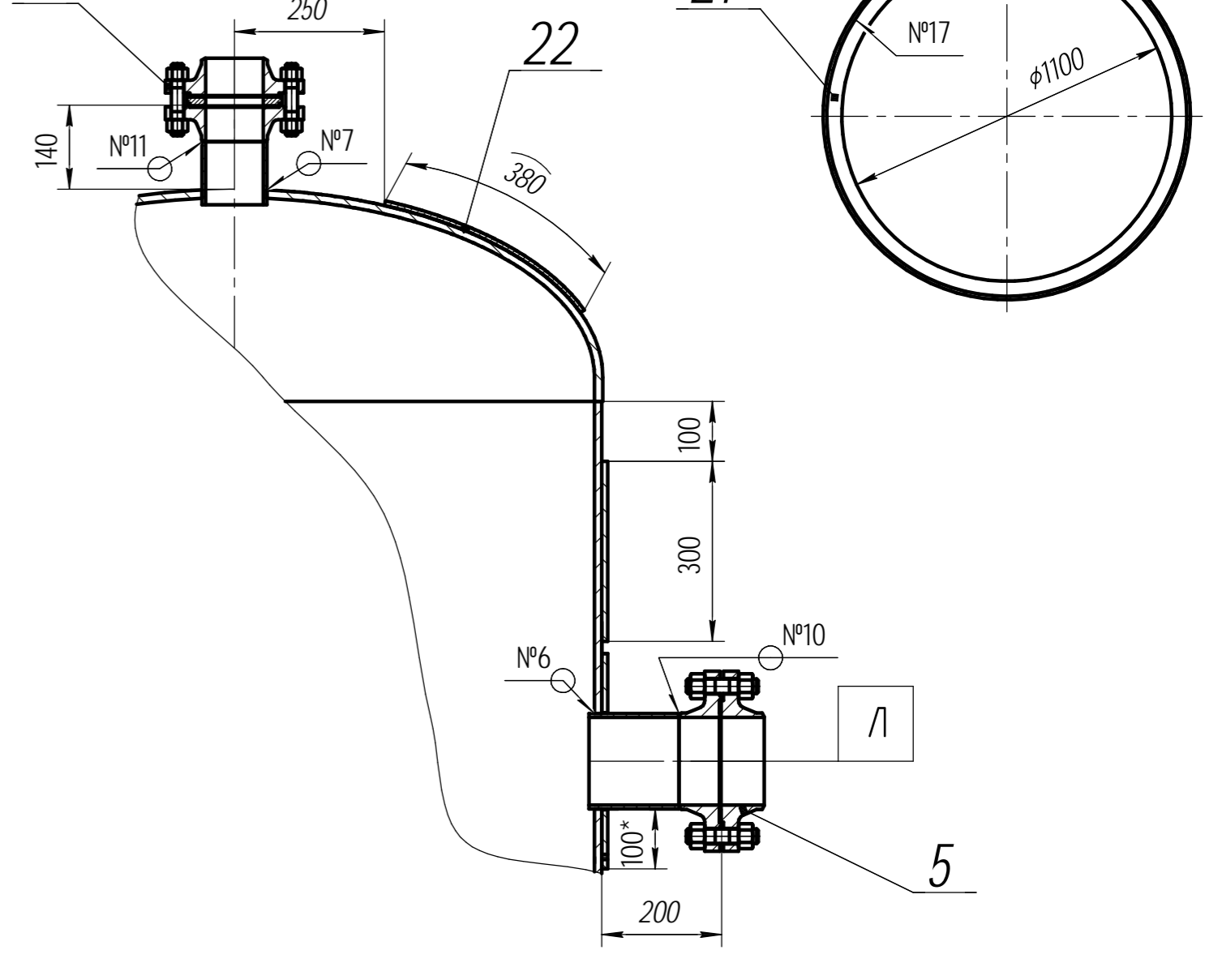
Щ-Щ(1:15)(1)
layout of pads at EL. +4.500
(for a platform at EL. +4.400)



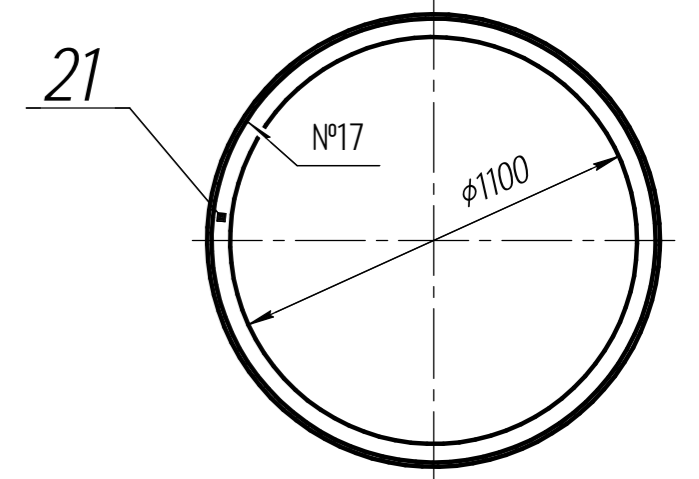
Ю-Ю(1:15)(1)
layout of pads at EL. +20.400



Ф-Ф(1:10)(1)

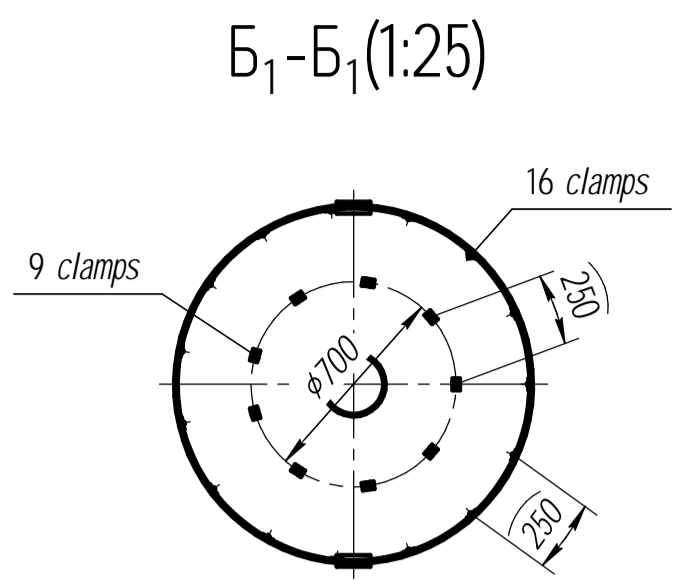
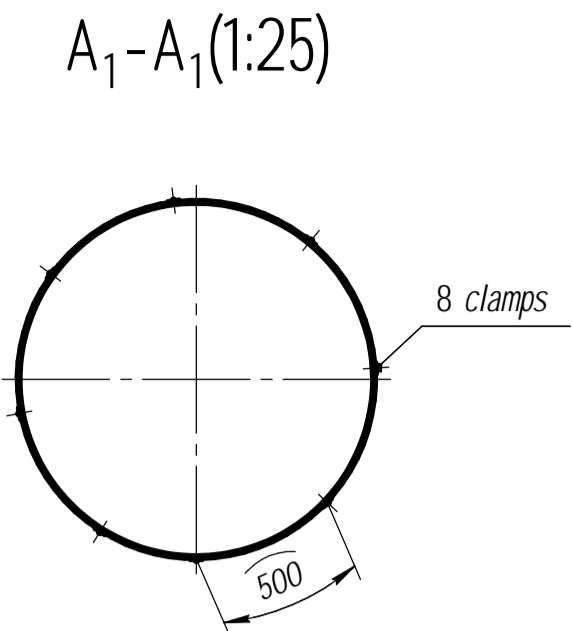
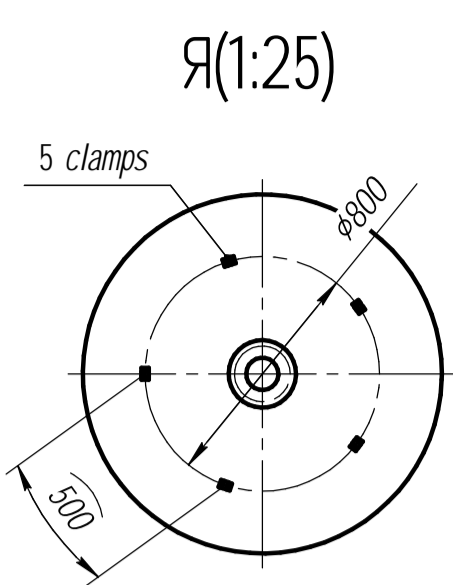
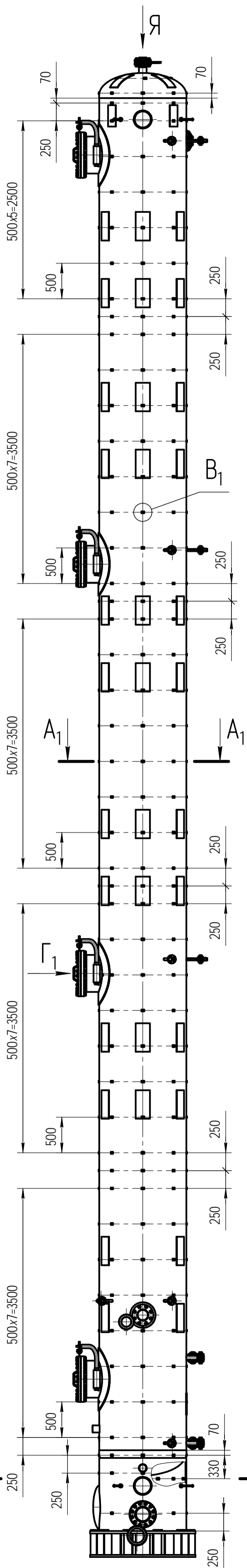


Ш-Ш(1:20)(1)



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Allocation of clamps for mounting the thermal insulation



Layout of installing a pin Ш1/100

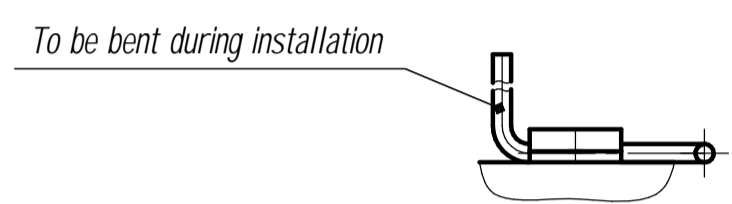
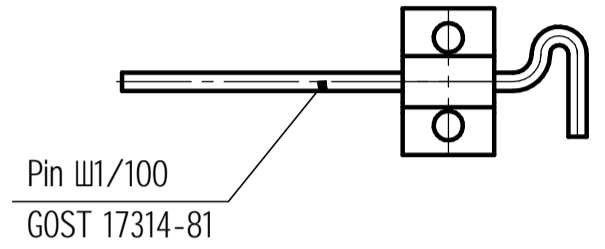
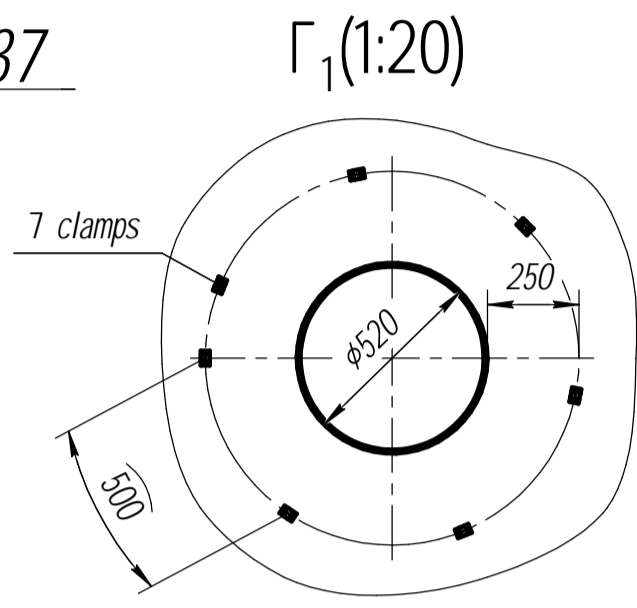
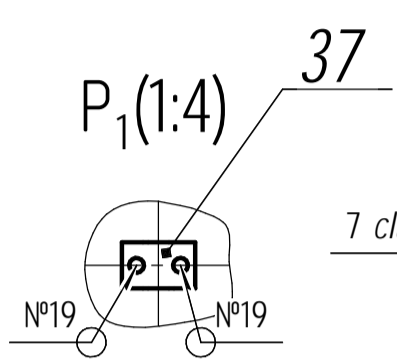
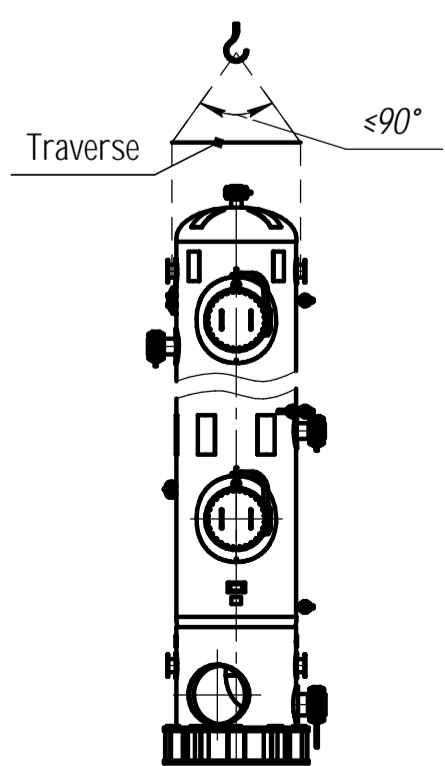


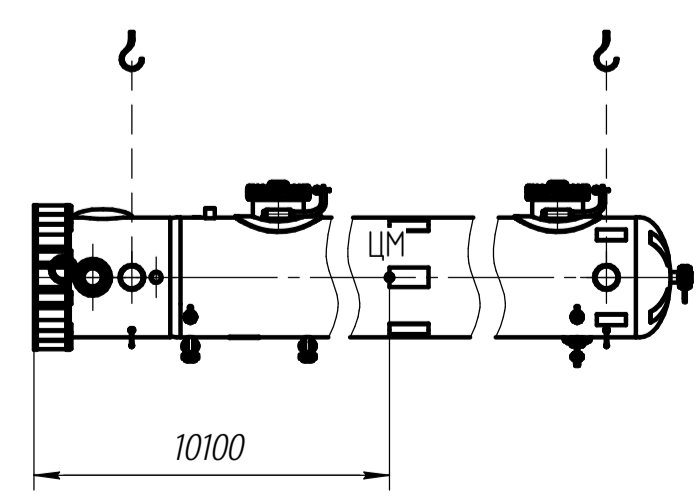
Table 4

Table of delivery blocks						
Delivery block No.	Designation	Name of delivery block	Overall dimensions of delivery block not more than, mm	Weight of delivery block not more than, kg	Qty of delivery blocks	Designation and name of packing and stacking place
1	ABCD.000000.000	Column	21072x1815x1803	10460	1	ABCD.000000.000 PD
2	ABCD.000000.000	Washer	100x100x16	1,0	10	
3		Pin			4	
		Disk	106x30x30	0,33	4	
		Nut M12-6H5 GOST 5915-70			4	
4		Pin Ш1/100 ГOCT 17314-81	180x30x5	0,032	430	
5		Nuts per OST 26-2041-96				
		M12.7H.25.019	22x19x12	0,019	8	
		M16.7H.25.019	27x24x16	0,039	4	
		M20.7H.25.019	34x30x20	0,077	28	
		M24.7H.25.019	42x36x24	0,133	10	
6		Stud-bolts per OST 26-2040-96				
		1-M12-8gx70.35.019	70x12x12	0,054	4	
		1-M16-8gx90.35.019	90x16x16	0,125	2	
		1-M20-8gx120.35.019	120x20x20	0,263	2	
		1-M20-8gx140.35.019	140x20x20	0,311	12	
		1-M24-8gx120.35.019	120x24x24	0,371	2	
7		1-M24-8gx150.35.019	150x24x24	0,476	3	
		Gasket per GOST 15180-80				
		paronite PMB-1 per GOST 481-80				
		Б-25-40	φ57x2,0	0,008	18	
		Б-50-40	φ87x2,0	0,014	10	
8		Б-150-25	φ149x2,0	0,035	2	
		Б-200-25	φ203x2,0	0,049	6	
		Б-259-25	φ259x2,0	0,066	2	
		Gasket 1-500-2,5				
		GOST 28759.6-90	φ563x2,0	0,086	8	
		PMB-1 per GOST 481-80				

Column slinging scheme in the vertical position



Column slinging scheme in the horizontal position



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Table of welding seams

Seam No.	Designation of standard for welding seam	Sketch of seam	Qty of seams	Electrode, welding wire, shielding gas (GOST, TU, type, grade, diameter)	Weight of weld metal, kg	Seam length, m	Welding method	Control methods								
								Radiographic 100% GOST 7512-82 or ultrasonic 100% GOST R 55724-2013 STU 00220256-005-2005	Dye penetrant method GOST 18442-80	Layer-by-layer visual inspection and measuring RD 03-606-03	Visual inspection and measuring RD 03-606-03	Mechanical testing GOST R 52630-2012	Hydraulic test with luminescent indicator cover. OST 26260.14-2001	Metallographic test RD 24.200.04-90	Pneumatic test 0.6 MPa	
1			10		18,15	19,0		+	-	+	-	+	-	+	-	
2	GOST 8713-79 -C7		10	OK Autrod 12.22 (ESAB) OK Flux 10.71 TU 5929-002-55224353-2004	36,73	38,46	SAW	+	-	+	-	-	-	-	-	
3			4		0,75	0,96		+	-	+	-	+	-	+	-	
4	GOST 8713-79 -C7		1	5 - OK Autrod 12.22 (ESAB) OK Flux 10.71 TU 5929-002-55224353-2004 A,B - OK Aristorod 12.50 (ESAB), Ar+20%CO2 TU 2114-002-05015259-97	4,09	3,86	SAW+ GMAW	+	-	+	-	-	-	-	-	
5, 6	RD 26-18-8-89 У19		A		27,89			8,84	-	+	+	-	-	+	-	-
			B					8,84	-	+	+	-	-	+	-	-
			B					8,84	-	+	+	-	-	-	-	+
			Г					14,39	-	+	+	-	-	-	-	+
7	RD 26-18-8-89 У12		1	OK Aristorod 12.50 (ESAB), Ar+20%CO2 TU 2114-002-05015259-97	0,47	0,36	GMAW	+	-	+	-	-	-	-	-	
8	RD 26-18-8-89 У12		14		2,81	2,17		-	+	+	-	-	+	-	-	
9	GOST 16037-70 С56		4	OK Autrod 12.22 (ESAB) OK Flux 10.71 TU 5929-002-55224353-2004	8,7	6,54	SAW+ GMAW	+	-	+	-	-	-	-	-	
10	GOST 16037-70 С56		4		2,93	2,2		+	-	+	-	-	-	-	-	
11	GOST 16037-70 С17		3		1,34	1,74		+	-	+	-	-	-	-	-	
12	GOST 16037-70 С17		14		0,45	1,88		+	-	+	-	-	-	-	-	
13	GOST 14771-76 -Н1-ИП-Δ8		86		31,08	97,12		-	-	+	-	-	-	-	-	
14	GOST 14771-76 -Н1-ИП-Δ10		4		4,3	3,21		-	-	+	-	-	-	-	-	
15	GOST 23518-79 -Т1-ИП		1	OK Aristorod 12.50 (ESAB), Ar+20%CO2 TU 2114-002-05015259-97	1,54	3,81	GMAW	-	-	+	-	-	-	-	-	
16	GOST 14771-76 -Т1-ИП-Δ3		8		4,2	1,13		-	-	+	-	-	-	-	-	
17	GOST 14771-76 -Т6-ИП		109		0,07	92,92		-	-	+	-	-	-	-	-	
18	GOST 23518-79 -Т1-ИП		72		51,11	33,53		-	-	+	-	-	-	-	-	
19	GOST 14776-79 -Н1-ПП		430		25,15	10,75		-	-	-	+	-	-	-	-	
20	GOST 23518-79 -Т1-ИП		9		0,22	0,85		-	-	-	+	-	+	-	-	

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Sheet 4

Size	Zone	Pos.	Designation	Name	Qty	Remarks		
<u>Documentation</u>								
*)			ABCD.000000.000 AD	Assembly drawing	4	*)A2x3, A1, A2		
A2			ABCD.000000.000 PD	Packaging drawing				
A3			ABCD.0000.00.000 LP	List of purchased items				
A4			ABCD.0000.00.000 SC	Strength calculation				
A4			ABCD.0000.00.000 OM	Operating manual				
A4			ABCD.0000.00.000 IM	Assembly, running, management manual				
A4			ABCD.0000.00.000 PS	Equipment passport of vessel				
<u>Assembly units</u>								
*)	1		ABCD.0000.01.000	Support	1	*)A4x3		
A2	2		ABCD.0000.02.000	Manway DN500 PN2,5	2			
*)	3		ABCD.0000.03.000	Nozzle DN200 PN2,5	1	*)A4x3		
A4	4		ABCD.0000.04.000	Nozzle DN150 PN2,5	1			
A4	5		ABCD.0000.05.000	Nozzle DN150 PN2,5	1			
A3	6		ABCD.0000.06.000	Nozzle DN150 PN2,5	1			
A4	7		ABCD.0000.07.000	Nozzle DN100 PN2,5	1			
A4	8		ABCD.0000.08.000	Nozzle DN50 PN4,0	5			
A4	9		ABCD.0000.09.000	Nozzle DN25 PN4,0	9			
ABCD.000000.000								
			Mod.	Sheet	Docum.No.	Signature	Date	
Orig. Inv.No	Designed							
	Checked							
	Examined							
Approved								
				Column ϕ 1200		Rev.Let.	Sheet	Sheets ttl.
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A4

Size	Zone	Pos.	Designation	Name	Qty.	Remarks
A4		10	ABCD.0000.10.000	Alignment device	4	
A4		11	ABCD.0000.12.000	Grounding unit	2	
		12				
				<u>Parts</u>		
A2		13	ABCD.0000.00.001	Shell	1	
A4		14	ABCD.0000.00.002	Bottom	1	
A4		15	ABCD.0000.00.003	Bottom	1	
A4		16	ABCD.0000.00.004	Ring	4	
A4		17	ABCD.0000.00.005	Ring	1	
A4		18	ABCD.0000.00.006	Ring	3	
VD		19	ABCD.0000.00.007	Pad	6	
				Sheet Б-ПН-О-8 GOST 19903-2015 09Г2С-8 GOST 5520-2017		
				300h14 x 150h14		
VD		20	ABCD.0000.00.008	Pad	70	
				Sheet Б-ПН-О-8 GOST 19903-2015 09Г2С-8 GOST 5520-2017		
				200h14 x 400h14		
A3		21	ABCD.0000.00.009	Support ring for demister	1	
VD		22	ABCD.0000.00.010	Pad	4	roll-up accordingly to the bottom
				Sheet Б-ПН-О-8 GOST 19903-2015 09Г2С-8 GOST 5520-2017		
				150h14 x 380h14		

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Size	Zone	Pos.	Designation	Name	Qty.	Remarks
A4		23	ABCD.0000.00.011	Support segment	1	
A4		24	ABCD.0000.00.012	Plate	2	
WD		25	ABCD.0000.00.013	Bar	1	
				Sheet Б-ПН-0-8 GOST 19903-2015 09Г2С-8 GOST 5520-2017		
				100h14 x 70h14		
A3		26	ABCD.0000.00.014	Clamp	1	
A3		27	ABCD.0000.00.015	Nameplate	1	
A4		28	ABCD.0000.00.016	Support segment	34	
A4		29	ABCD.0000.00.017	Support segment	1	
A4		30	ABCD.0000.00.018	Plate	62	
A4		31	ABCD.0000.00.019	Plate	4	
A4		32	ABCD.0000.00.020	Plate	2	
A4		33	ABCD.0000.00.021	Plate	2	
A4		34				
				<u>Standard items</u>		
		35		Rivet 3x6.10.019 GOST 10300-80	4	
		36		Grounding sign 40-3 GOST 21130-75	2	
		37		Clamp C2 GOST 17314-81	430	
		38		Lifting Lug 4-1-8-750-09Г2С-8 GOST 13716-73	4	

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Size	Zone	Pos.	Designation	Name	Qty.	Remarks
				<u>Kits</u>		
				<u>Installation kit</u>		
A4			ABCD.0000.00.022	Pin Ш1/100 GOST 17314-81	430	
				<u>Spare parts kit</u>		
				Gaskets GOST 15180-80 Paronite PMB-1 GOST 481-80:		
				Б-25-63	18	
				Б-50-63	10	
				Б-100-63	2	
				Б-150-63	6	
				Б-200-63	2	
				Gasket 1-500-2,5 GOST 28759.6-90 PMB-1 GOST 481-80	8	
				Nuts per OST 26-2041-96:		
				M12.7H.25.019	8	
				M16.7H.25.019	4	
				M20.7H.25.019	28	
				M24.7H.25.019	10	

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Size	Zone	Pos.	Designation	Name	Qty.	Remarks
				Stud-bolts per OST 26-2040-96:		
				1-M12-8g•70.35.019	4	
				1-M16-8g•90.35.019	2	
				1-M20-8g•120.35.019	2	
				1-M20-8g•140.35.019	12	
				1-M24-8g•120.35.019	2	
				1-M24-8g•150.35.019	3	
				<u>Tare kit</u>		
				According to the packaging drawing		
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