

WORK REQUISITION
TO : MAINTENANCE PLANNER
PLANT #6 Crude Unit

EQUIP. NO. OR DESCRIPTION Debut Reboiler E-1622

EQUIP. READY Yes

JOB No. 16-400		ENGR. JWS	
REQ No.	TYPE	COST CENTER	JOB No. ITEM No.
JW	101-0116-		-280

MATERIAL ORDERED ON RDBM 8135, 8136, 8137

PAGE 1 of 2

REQUIRED COMPLETION DATE

INSTRUCTIONS: THE DEBUT REBOILER, E-1622, WILL BE REMOVED FROM SERVICE TO REPAIR A SUSPECTED FLOATING HEAD LEAK. NEW MATERIALS HAVE BEEN ORDERED TO DO THIS WORK. NEW BELLVILLE WASHERS, B-16 STUDS AND SS CLADDED ASBESTOS GASKETS. AN EXTENSIVE CHECK OF FLANGE DIMENSIONS AND GASKET SURFACES WILL BE NECESSARY BEFORE THE NEW MATS ARE USED AND THE FOLLOWING SEQUENCE OF WORK WILL HELP INSURE THE RECOMMENDED INSTALLATION. PLEASE COMPLETE THE FOLLOWING.

- ① REMOVE E-1622 FROM SERVICE AND HAUL TO MACHINE SHOP.
- ② Loosen shell cover and check each Floating head stud bolt for looseness.
- ③ IF ALL BOLTS ARE TIGHT, A TUBE SIDE TEST SHOULD BE DONE TO DETERMINE IF ANY TUBES ARE LEAKING. (TEST TO 285 PSIG)
- ④ REMOVE all floating head studs, floating head and pull bundle from shell. Notify Drafting to also check.
- ⑤ MEASURE DIMENSIONS SHOWN ON ATTACHED DWGS AND INSPECT FLANGES FOR ANY WIRE DRAWING OR PITTING. PLEASE NOTE ACTUAL DIMENSIONS AND MARK THEM ON DWG.

DISTRIBUTION : MAINTENANCE PLANNER - 4, OPERATIONS - 2 *JWS*
INSPECTION - 1 (CWW) LEAD ENGR. - 1 (RAB.),
ENGR - 1 *JWS*, OTHERS, *DLNance*

APPROVALS:
LEAD ENGR. *CRP 1/10/80*
OPERATIONS *JWS 1/10/80*
CHIEF ENGR. _____

ENGR *JW Jones* PHONE 225 DATE 1/9/80

**WORK REQUISITION
TO MAINTENANCE PLANNER**

PLANT # 6 Crude Unit

EQUIP. NO. OR DESCRIPTION Detrit Reboiler E-1622

EQUIP. READY YES

JWJ

JOB No.	16-400	ENGR.	JW JONES
REQ No.		TYPE	COST CENTER
	JWJ.01-0		116-00-280

MATERIAL ORDERED ON RDBM'S 8135, 8136, 8137

COMPLETE PAGE 2 OF 2
REQUIRED COMPLETION DATE TO BE SCHEDULED

INSTRUCTIONS: (6) IF ANY DIMENSIONS DO NOT CHECK OR IF ANY GASKET SURFACES ARE FOUND IN NEED OF WORK, THE REPAIR PROCEDURE WILL BE DECIDED ON AT THAT TIME.

(7) THE NEW SS CLAD ASBESTOS GASKET, ITEM 1 ON RDBM-8135, STUDS AND BELLVILLE WASHERS WILL THEN BE INSTALLED AS SHOWN ON ATTACHED DWG. (Sketch #2) USE THE ATTACHED PROCEDURE FOR APPLICATION OF BOLT TORQUE ON FLANGED JOINTS. TORQUE EACH BOLT TO A MAXIMUM OF 106 FOOT- LBS.

THE GAP BETWEEN FLANGES (Floating Head and Tube Sheet) should now be even ALL AROUND AND THE BELLVILLE WASHERS COMPRESSED TO APPROXIMATELY 50% OF THEIR DEFLECTION. THIS DIMENSION IS SHOWN ON ATTACHED DWG AND EQUALS 0.928". USE heavy grease to hold gasket in place and heavy OIL with graphite on all studs, nuts and bellville washers to reduce friction when tightening.

(8) Test tube side to 285 PSIG - check for leaks.
Return to service

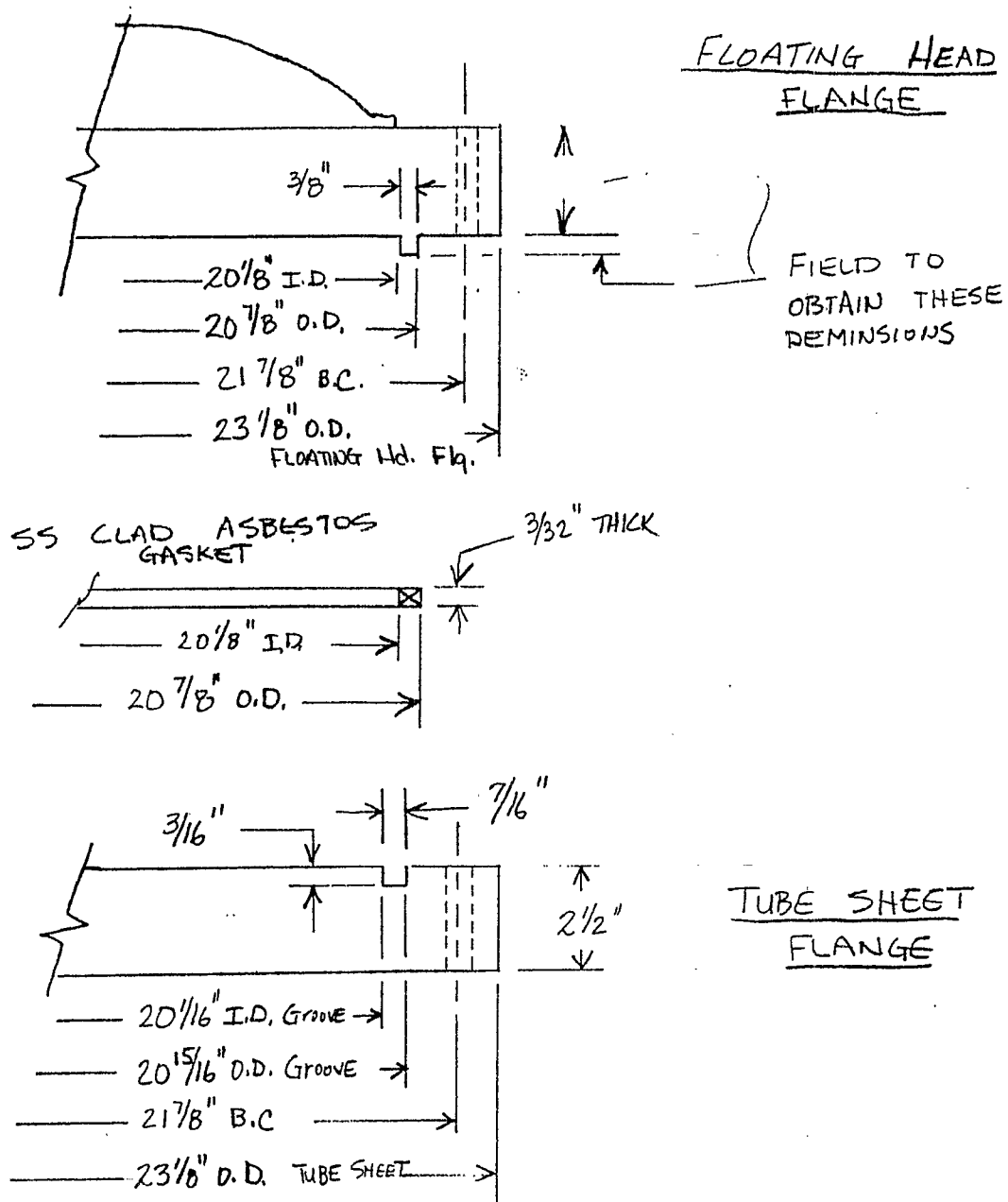
NOTE: THE Flange GAP should not have to be closed to get the test to hold. If it is the flanges are not properly fitted and should be rechecked.
Check Flange Run Out with dial indicator

DISTRIBUTION: MAINTENANCE PLANNER - 4, OPERATIONS - etc
INSPECTION - 1 (CWW) LEAD ENGR. - 1 (RAB.),
ENGR - 1, OTHERS, _____

APPROVALS:
LEAD ENGR. CRP 1/9/80
OPERATIONS _____
CHIEF ENGR. _____

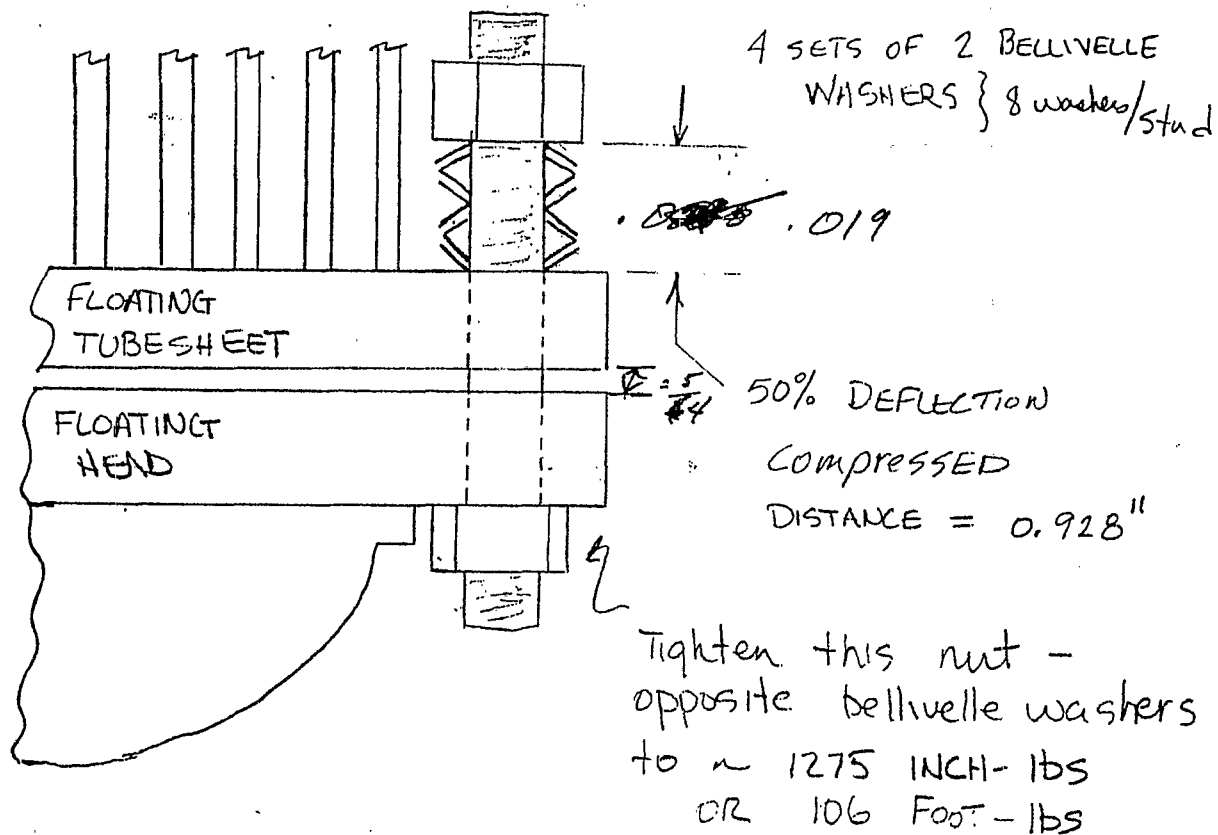
ENGR. JW Jones PHONE 225 DATE 1/9/80

E-1622 DETAILS



July 11/9/80

E-1622 BOLT UP PROCEDURE



NOTE: ALL STUDS & WASHERS (BELLIVELLE) TO BE WELL LUBRICATED WITH HEAVY OIL & GRAPHITE TO REDUCE FRICTION

FLANGES GAP = $\frac{5}{64}$ "

SKETCH 2

CHEV B8 6048

July 1/9/80

WORK REQUISITION
TO : MAINTENANCE PLANNER
PLANT #6 Crude Unit

JOB No. 16-400	ENGR. JWJ			
REQ No.	TYPE	COST CENTER	JOB No.	ITEM No.
JWJ01-0116				-280

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MATERIAL ORDERED ON RDBM 8135, 8136, 8137

EQUIP. READY Yes

REQUIRED COMPLETION DATE

PAGE 1 of 2

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DISTRIBUTION : MAINTENANCE PLANNER-4, OPERATIONS-2, JWC
INSPECTION-1 (CWW) LEAD ENGR.-1 (RAB.),
ENGR -1 JWJ, OTHERS, BLNance

APPROVALS:

LEAD ENGR. CRP 11/10/80
OPERATIONS JWC 11/10/80
CHIEF ENGR.

ENGR. JWJONES PHONE 225 DATE 1/9/80

WORK REQUISITION

TO : MAINTENANCE PLANNER

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EQUIP. READY YES

JOB No. <u>16-400</u>		ENGR. <u>JW Jones</u>	
REQ No.	TYPE	COST CENTER	JOB No. ITEM No.
<u>1</u>	<u>W</u>	<u>01-0</u>	<u>116-00-280</u>

MATERIAL ORDERED ON RDBM'S 8135, 8136, 8137

COMPLETE PAGE 2 OF 2
REQUIRED COMPLETION DATE TO BE SCHEDULED

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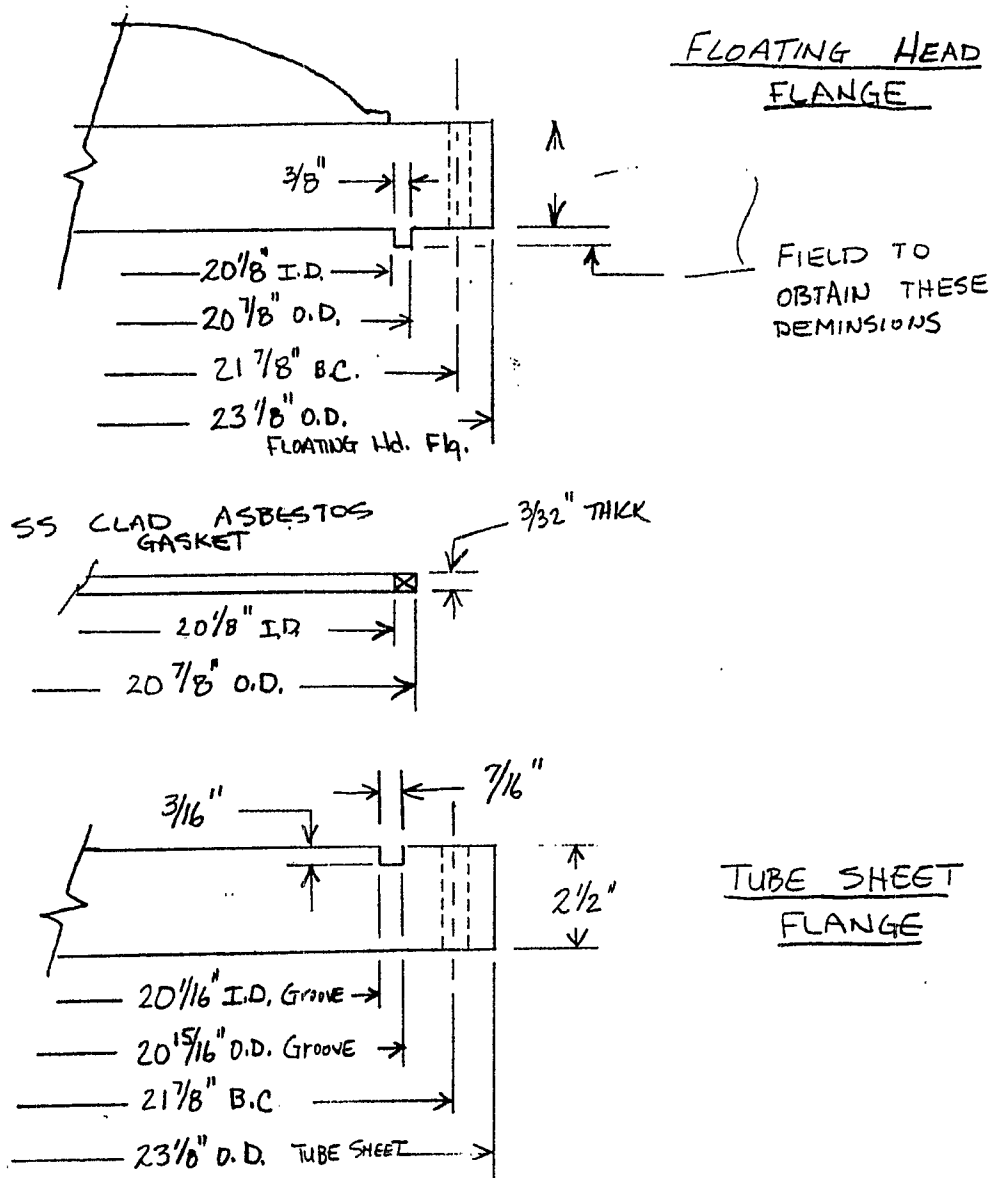
COMPLETE Check Flange Run Out with dial indicator

DISTRIBUTION : MAINTENANCE PLANNER - 4, OPERATIONS - 4
INSPECTION - 1 (CWW) LEAD ENGR. - 1 (RAB),
ENGR - 1, OTHERS, _____

APPROVALS:
LEAD ENGR. CRP 1/9/80
OPERATIONS _____
CHIEF ENGR. _____

ENGR. JW Jones PHONE 225 DATE 1/9/80

E-1622 DETAILS



SKETCH 1

CHEV B8 6047

JUD 1/9/80