FORM U-1 MANUFACTURERS' DATA REPORT FOR UNFIRED PRESSURE VESSELS

As required by the Provisions of the ASME Code Rules, Div. 1

1. Manufactured by RYAN INDUSTRIES, INC. CLEVELAND, OHIO
(Name and address of manufacturer)
2. Manufactured for STOKES Pharmaceutical Inc., ALLENTOWN, PA.)
(Name and address of Purchaser)
3. Type VERTICAL (Horiz. or Vert.) Kind JACKETED (Tank, Jacketed, Heat Exch.) Vessel No. (1514) ( ) (Mfrs. Serial) (State & State No.) Nat'l Bd. No. 1514 Yr. Built 1962

Items 4-9 incl. to be completed for single wall vessels (such as air tanks), jackets of jacketed vessels, or shells of heat exchangers.

4. SHELL: Material ____ T.S. ____ Nominal Thickness ____ In. Corrosion Allowance ____ In. Diam. ____ Ft. ____ In. Length ____ Ft. ____ In.
(Kind and Spec. No.) (Fig. or F B & Spec. Min. T.S.)
5. SEAMS: Long ____ S.R. ____ X.R. ____ Sectioned ____ Efficiency ____ %
(Welded, Dbl., Single, Lap, Butt) (Yes or No) (Spot or Complete) (Yes or No)
Girth ____ S.R. ____ X.R. ____ Sectioned ____ No. of Courses ____
If riveted describe seams fully on reverse side of form
6. HEADS: (a) Material ____ T.S. ____ (b) Material ____ T.S. ____

Location (Top, bottom, ends)	Thickness	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a)								
(b)								

If removable, bolts used ____ Other fastening ____
(Material, Spec. No., T.S., Size, Number) (Describe or Attach Sketch)
7. STAYBOLTS: ____ If hollow ____ Attachment ____ Pitch ____ X ____ Diam. ____
(Material) (Size of Hole) (Threaded, Welded) (Horiz.) (Vert.) (Nominal)
8. JACKET CLOSURE: ____
(Describe as taper & weld bar, etc. If bar give dimensions. If bolted, describe or sketch)
9. Constructed for max. allowable working press.[1] ____ psi. at max. temp. ____ °F. Min. temp. (when less than −20°) ____ °F. Hydrostatic / Pneumatic or Combination Test Press. ____ psi.

Items 10 and 11 to be completed for tube sections.

10. TUBE SHEETS: Stationary. Material ____ Diam. ____ In. Thickness ____ In. Attachment ____
(Kind & Spec. No.) (Subject to Pressure) (Welded, Bolted)
Floating. Material ____ Diam. ____ In. Thickness ____ In. Attachment ____
(Kind & Spec. No.)
11. TUBES: Material ____ O.D. ____ In. Thickness ____ Inches or Gage Number ____ Type ____
(Kind & Spec. No.) (Straight or U)

Items 12-15 incl. to be completed for inner chambers of jacketed vessels, or channels of heat exchangers.

12. SHELL: Material 304 S.S. SA-240 (Kind and Spec. No.) T.S. 75,000 (Fig. or F B & Spec. Min. T.S.) Nominal Thickness 1/4 In. Corrosion Allowance - In. Diam. 3 Ft. - In. Length 6 Ft. 11 1/8 In.
13. SEAMS: Long DBL. BUTT WELD (Welded, Dbl., Single, Lap, Butt) S.R. NO (Yes or No) X.R. COMPLETE (Spot or Complete) Sectioned NO (Yes or No) Efficiency 90 %
Girth DBL. BUTT WELD S.R. NO X.R. COMPLETE Sectioned NO No. of courses 1
If riveted describe seams fully on reverse side of form
14. HEADS: (a) Material 304 S.S. SA-240 T.S. 75,000 (b) Material ____ T.S. ____ (c) Material ____ T.S. ____

Location	Thickness	Crown Radius	Knuckle Radius	Elliptical Ratio	Conical Apex Angle	Hemispherical Radius	Flat Diameter	Side to Pressure (Convex or Concave)
(a) Top, bottom, ends	.212 MIN.			ELLIP.	2:1 RATIO			CONCAVE
(b) Channel								
(c) Floating								

If removable, bolts used (a) ____ (b) ____
(Material, Spec. No., T.S., Size, Number)
(c) ____ Other fastening ____
(Describe or Attach Sketch)
15. Constructed for max. allowable working press.[1] 200 psi. at max. temp. +100 °F. Min. temp. (when less than −20°) −320 °F. Hydrostatic / Pneumatic or Combination Test Press. 327 psi.

Items below to be completed for all vessels where applicable.

16. SAFETY VALVE OUTLETS: Number ____ Size ____ Location ____
17. NOZZLES:

Purpose (Inlet, Outlet, Drain)	Number	Diam. or Size	Type	Material	Thickness	Reinforcement Material	How Attached
	3	3/4"	SA-240	ROD DRILLED		.385 I.D.	WELDED
	3	1-1/8"	SA-240	ROD DRILLED		.885 I.D.	WELDED
	1	1-1/2"	SA-240	ROD DRILLED		1.135 I.D.	WELDED

18. INSPECTION OPENINGS: Manholes, No. ____ Size ____ Location ____
Handholes, No. ____ Size ____ Location ____
Threaded, No. ____ Size ____ Location ____
19. SUPPORTS: Skirt ____ (Yes or No) Lugs ____ (Number) Legs 3 (Number) Other 3 BRACE RODS (Describe) attached LEGS WELDED TO SHELL
20. REMARKS: 36" I.D. LOV VESSEL RODS WELDED TO TOP HEAD
(INNER VESSEL ONLY)

(Brief description of purpose of the vessel, as Air Tank, After Cooler, Jacketed Cooker, etc. State contents of each part.) (Over)

[1] List other internal or external pressures with coincident temperature when applicable.)

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We certify that the statements made in this report are correct and that all details of material, construction, and workmanship of this unfired pressure vessel conform to the ASME Code for Unfired Pressure Vessels

Date NOV 19 1962 19 Signed RYAN INDUSTRIES, INC. By R. J. Meaney Jr.
(Manufacturer)

Certificate of Authorization Expires # 956 12/31/64

CERTIFICATE OF SHOP INSPECTION

Inspection Agency's Serial No. HSB # 1857

VESSEL MADE BY RYAN INDUSTRIES, INC. at CLEVELAND, OHIO

I, the undersigned, holding a Certificate of Competency as an Inspector of Boilers and Unfired Pressure Vessels in THE STATE OF NATIONAL BOARD and employed by HARTFORD STEAM BOILER INSPECTION & INSURANCE CO. of HARTFORD CONN. inspected internally and externally, the vessel described in this report on _____ 19____, and certify that the statements made in this report are correct corresponding with mill test reports of materials furnished by the builders, and measurements made of the vessel and that this vessel is constructed in accordance with the ASME Code for Unfired Pressure vessels.

Date NOV 19 1962 19____

OHIO # 1186
PENNA # WC 982

Inspector's Signature

Commissions N.B. # 3342
State or Nat'l Bd & Number

CERTIFICATE OF FIELD ASSEMBLY INSPECTION

I, the undersigned, holding a Certificate of Competenty as an Inspector of Boilers and Unfired Pressure Vessels in THE STATE OF _____ and employed by _____ of _____, have compared the statements in this manufacturers' data report with the completed vessel, and certify that parts referred to as data items _____ were completed in the field in accordance with the requirements of the ASME Code for Unfired Pressure Vessels. The completed vessel was inspected and subjected to a hydrostatic test of _____ psi.

Date _____ 19____

Inspector's Signature

Commissions _____
State or Nat'l Bd. & Number

Printed in U.S.A. (5/62)