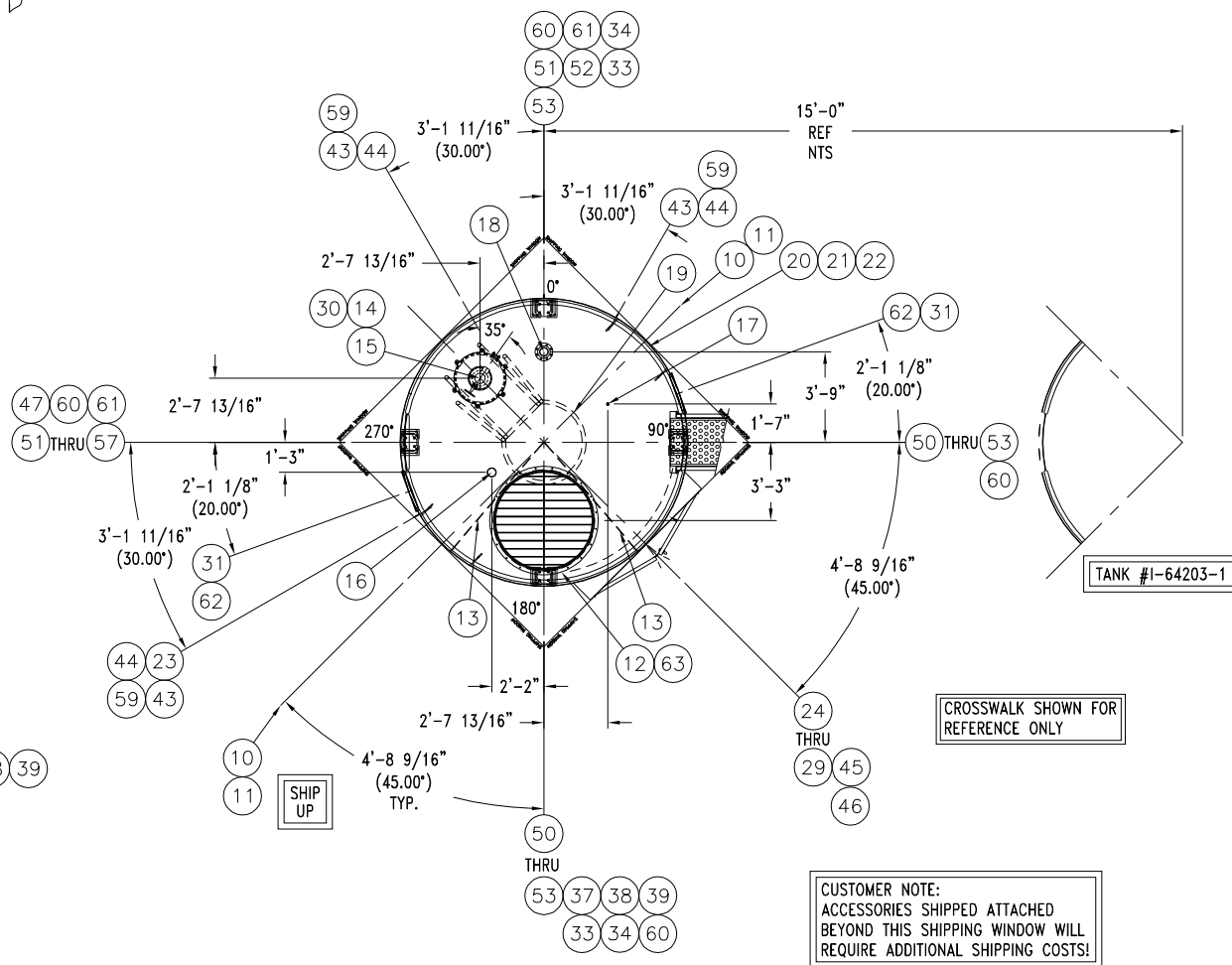
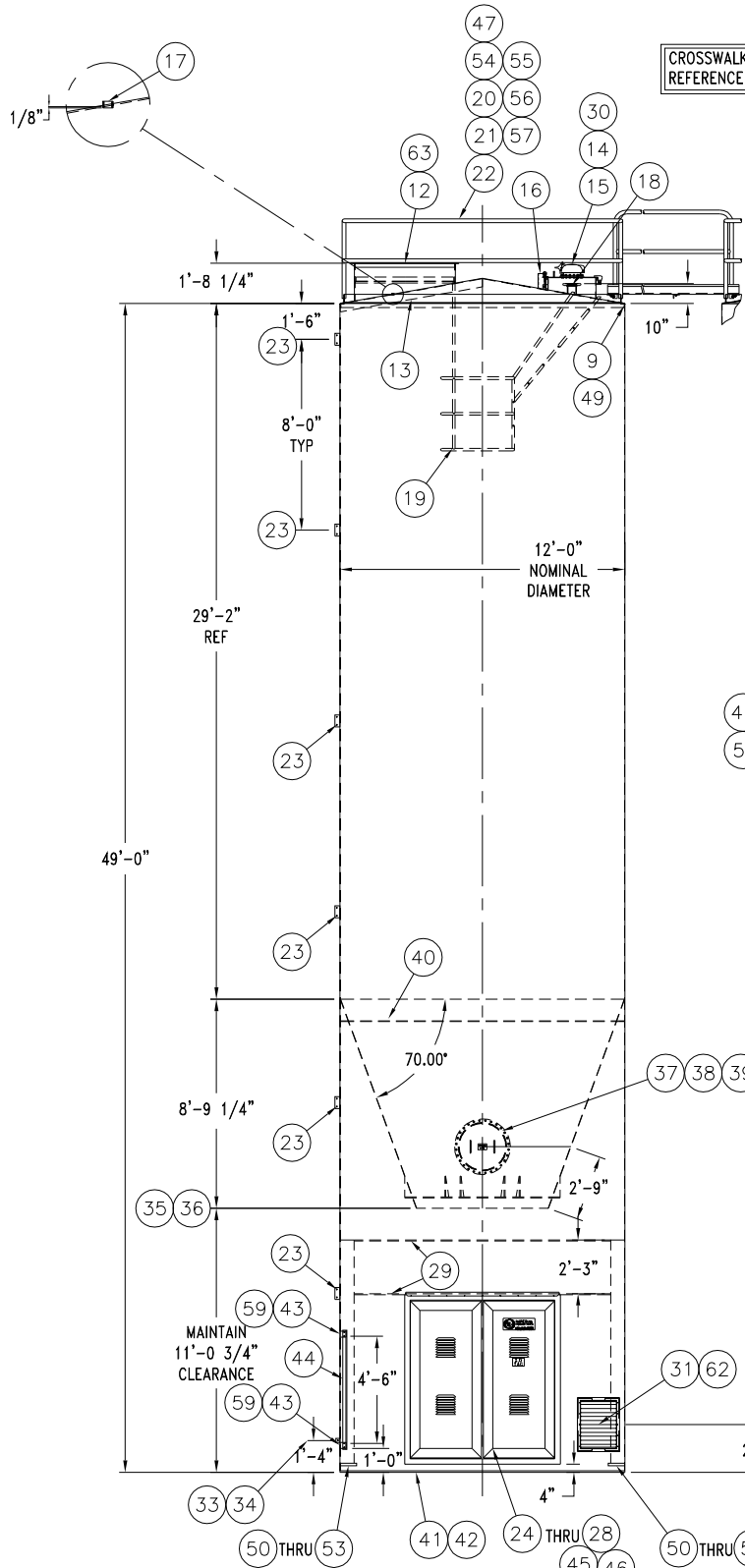


BILL OF MATERIALS					SUFFIX: 000	
R. SEQ.	QTY	UM	PART NUMBER	AT LO SC	DESCRIPTION	CODE
45	1.00	EA	901.0039.P	X	I.D. TAG, ALUMINUM (FOR INDUSTRIAL TANKS)	ALUM
46	1.00	EA	901.0042	X	NAME TAG,IMPERIAL INDUSTRIES 6"x16"x.025 ALUM. WITH SELF	MISC
47	1.00	EA	102.1009.1.2	X	HANDRAIL OPENING BOLT-IN RAIL	6061
49	3.00	EA	800.0006	X	CAULK, SILICONE (FDA) TUBES CLEAR,GE IS-808	
50	4.00	EA	164204-1/50	X	LOAD CELL SUPPORT BEAM-1/2" X 7" PL 9'-4 5/8" LG (304)Ø DOOR	
51	4.00	EA	164204-3/51	X	LOAD CELL BASE PLATE - SEE DETAIL "A3" (304SS)	
52	4.00	EA	223.3102.3	X	LOAD CELL SKIRT OPENING, A=2 1/2" B=1'-4 3/4" C=8" D=3 3/8"	304
53	4.00	EA	223.3103.12	X	BASE RING SUPPORT - TEMPORARY 12'-0" DIA TANK (FB 3/4 X 3)	HRS
54	4.00	EA	103962	X	HHCS,3/8-16NC X 4 1/2" LG. 316	MISC
55	8.00	EA	103616	X	WASHER,FLAT 3/8" 316SS	MISC
56	4.00	EA	103118	X	WASHER,SPRING LOCK 3/8" 316SS	MISC
57	4.00	EA	103956	X	NUT,LOCK HEX 3/8-16UNC 316	MISC
58	2.00	EA	223.0124.3	X	BANDING BRACKET, (FOR SHIPPING) 3/4"	304
59	12.00	EA	151.0606.2.1.1	X	BOLT BAG,3/8" HHCS X 1 1/2" LGW/ 2 FLAT, 1 LOCK, 1 NUT	316
60	16.00	EA	150.1212.2.1.1	X	BOLT BAG,3/4" HHCS X 3" LG W/ 2 FLAT, 1 LOCK, 1 NUT	ZP
61	4.00	EA	164204-1/61	X	LOAD CELL SUPPORT BEAM-1/2X7PL 6'-6" LG(304)OPPOSITE OF DOOR	
62	2.00	EA	202.2504.2	X	LOUVER 18"x24"W/BUG SCREEN,AL.	
63	1.00	EA	202.2508.2	X	FILTER FLANGE,REMOVABLE GRATING ASSY (FOR 50 1/8" ID FLANGE)	304

BOLT-IN RAIL HDWE
CONDUIT BRACKET HDWE
TEMP BASE RING HDWE

BILL OF MATERIALS					SUFFIX: 000	
R. SEQ.	QTY	UM	PART NUMBER	AT LO SC	DESCRIPTION	CODE
1	133.00	F2	118027	X	ROOF DECK - PL 3/16 60 X 152 304SS A&P (2.10 SHEETS)	304
2	391.00	F2	108292	X	HOPPER - SH10 GA 60 X 152 304SS #2B (6.17 SHEETS)	304
3	5.00	EA	118557	X	CYLINDERS 1-5 - SH10 GA 60 X 455 304SS, #2B	304
4	4.00	EA	164204-1/4	X	CYLINDERS 6-9 - PL 3/16 60 X 455 304SS	
5	148.51	F2	118102	X	CYLINDER 10 - PL 3/16 48 X 152 304SS A&P (3.00 SHEETS)	
9	1.00	EA	202.0025.12.3	X	EXPLOSION RELIEF ROOF DECK 12' WEAK SEAM ANGLE (304)	304
10	2.00	EA	223.0064	X	LIFT LUG,LARGE RH (304 SS)	304
11	2.00	EA	223.0065	X	LIFT LUG,LARGE LH (304SS)	304
12	1.00	EA	164204-5/12	X	X FILTER FLANGE - SEE DRAWING I-64204-5 (304)	
13	2.00	EA	223.0200.0.1.73	X	ROOF STIFFENER,1/4" X 4" SS 6'-1" LONG	304
14	1.00	EA	104.5050	X	MANWAY,24"DIA. W/ HOLE FOR 8" PVR VALVE-6" MIN PROJ 304SS	304
15	1.00	EA	104.5129.4	X	BOLT BAG,8" PVR (ALUM/WHY/SS) W/ 8 OZ.(PRES) & 0.4 OZ.(VAC.)	MISC
16	1.00	EA	105.2201	X	X TUBE STUB, 4"OD.X 14 GA. 304SS X 9" LG.(7 1/2" = MIN. PROJ.)	304
17	1.00	EA	109546	X	X COUPLING,3/4" NPT HALF (FLUSH TO INTERIOR) 304	304
18	1.00	EA	135.3040.3	X	X FLANGE,4"-150# RFSS (RAISED FACE SLIP ON) + A= 10" PROJ	304
19	1.00	EA	202.0010.3	X	CLEANING PLATFORM, FOR 10 DEGREE ROOF DECKS	304
20	24.00	EA	103907	X	WELD STUD,1/2-13NC,1 1/2 304SSFULL THREAD WITH FERRULE	MISC
21	1.00	EA	102.8212.180	X	HANDRAIL,12" DIA,(2) OPENING 1 1/2" SCH 40 PIPE	ALUM
22	1.00	EA	911.0012.3	X	BOLT BAG,12'-0" DIA HANDRAIL ASSY, (STL/SS)	316
23	6.00	EA	202.2535.3	X	FILL LINE,CLIP 1/4 X 6 FB W/ (2) 1/2" DIA. HOLES	304
24	1.00	EA	164204-6/24	X	DOOR FRAME - SEE DRAWING I-64204-6 (304) DOUBLE DOOR	
25	1.00	EA	213.1037	X	DOOR,3'-0" X 6'-8" (LH) W/ (2) LOUVERS AND LATCH (ALUM)	ALUM
26	1.00	EA	213.1038	X	DOOR,3'-0" X 6'-8" (RH) W/(2) LOUVERS & ASTRAGAL (ALUM)	ALUM
27	8.00	EA	213.1044	X	DOOR HINGE SHIM (10 GA.)	GALV
28	1.00	EA	223.0053.3	X	DOOR FRAME, RAIN GUTTER (DBL) 304 SS	304
29	2.00	EA	164204-2/29	X	HORIZONTAL DOOR STIFFENER - SEE DETAIL "C2" (304SS)	
30	1.00	EA	124.5009	X	GASKET,24" DIA. 1/8" (WHT) 6 HOLDDOWN MANWAY	WNED
31	2.00	EA	164204-4.1/31	X	LOUVER - SEE DRAWING I-64204-4 (304) FRAME ASSEMBLY	
33	2.00	EA	223.0049	X	GROUNDING LUG, SS (304)	304
34	2.00	EA	900.1767	X	DECAL,DANGER,GROUNDING LUG "DO NOT USE FOR LIFTING"(2 1/2X4)	MISC
35	1.00	EA	164204-2/35	X	DISCHARGE FLANGE - CUSTOMER SUPPLIED	
36	16.00	EA	164204-2/36	X	DISCHARGE FLANGE GUSSET - SEE DETAIL "B2" (304)	
37	1.00	EA	104.5057.1	X	FLANGE ASS'Y - 24 DIA. (304SS)	
38	1.00	EA	104.5057.2	X	COVER, 24" DIA. MANWAY (304) (PLUG TYPE)	
39	1.00	EA	113.1009	X	BOLT BAG, 20" MANWAY(28)SS,WHT	316
40	1.00	EA	164204-1/40	X	COMPRESSION RING,1/4" X 4" FOR 12" DIA TANK (304SS)	
41	1.00	EA	164204-1/41	X	BASE RING, FB-3/4" X 3" ROLL FOR 12" DIA TANK (304SS)	
42	16.00	EA	164204-9/42	X	BASE RING GUSSET FOR 3" RING (304SS)	
43	6.00	EA	202.2536.3	X	CONDUIT CLIP,1/4 X 3 FB X 3" LG. (SUPPORTS BRACKET 202.2537)	304
44	3.00	EA	202.2537.3	X	CONDUIT BRACKET,L2 X 2 X 3/8" X 5'-0"LG. (FITS 202.2536)	304



EXTERIOR NOTES: (HRS) ONLY

GRINDING CLASS #1
WELD SPATTER AND SLAG REMOVED USING A WIRE BRUSH. EXCESSIVE WELD CROWN AT STARTS AND STOPS REMOVED.

CLEANING/BLASTING CLASS #1
POWER WASH USING A SPRAY WASHER AND CLEANING SOLUTION. WAUSAU CHEMICAL LIQUI-SOLVE REMOVE DIRT, DEBRIS, OIL, WELD SMOKE AND CHEMICAL CONTAMINATION.

INSPECTION CLASS #1
VISUAL 100% TEST PROCEDURE PER IMP#111

INTERIOR NOTES:

GRINDING CLASS #1
WELD SPATTER AND SLAG REMOVED USING A WIRE BRUSH. EXCESSIVE WELD CROWN AT STARTS AND STOPS REMOVED.

CLEANING/BLASTING CLASS #6
POWER WASH USING A SPRAY WASHER AND CLEANING SOLUTION. WAUSAU CHEMICAL LIQUI-SOLVE REMOVE DIRT, DEBRIS, OIL, WELD SMOKE AND CHEMICAL CONTAMINATION.

INSPECTION CLASS #1
VISUAL 100% TEST PROCEDURE PER IMP#111

EXTERIOR FINISH: (PLAIN)
SEE CLEANING NOTE.

EXTERIOR FINISH: (PLAIN)
SEE CLEANING NOTE.

EXTERIOR FINISH: (FOR CARBON STEEL MATERIALS)

COATS	MFG.	PRODUCT DESCRIPTION	COLOR	MILS D.F.T. PER COAT	MILS D.F.T. TOTAL
1	SHERWIN WILLIAMS	2.8 V.O.C. CATALYZED EPOXY PRIMER	WHITE	1.8 TO 2.2	1.8 TO 2.2
1	SHERWIN WILLIAMS	6.61W284-5497/V66V82 POLANE H.S PLUS POLYURETHANE ENAMEL	SLATE GRAY 1.25 TO 1.5	1.25 TO 1.5	1.25 TO 1.5
		F63JXA1062-3301/V66V55 - SW 4026			3.05 TO 3.7

DESIGN NOTES:

IBC-2009
0.2 SECOND SPECTRAL RESPONSE 31.83 %
1 SECOND SPECTRAL RESPONSE 7.46 %
SEISMIC SITE CLASS SD
SEISMIC IMP. FACTOR 1.00
ANALYSIS PROCEDURE EQUIVALENT LATERAL FORCE (ELFP)
MAX. WIND SPEED 90 MPH (EXP. C)
WIND IMPORTANCE FACTOR 1.00
MAX. DECK LIVE LOAD 30 PSF
MAX. MATERIAL DENSITY 50 LBS/FT³
MAX. INTERNAL PRESSURE 0.50 PSI
MAX. INTERNAL VACUUM 0.03 PSI
CAPACITY 3,522 CUBIC FOOT
SHIPPING WEIGHT 22,600 LBS
OPERATING WEIGHT 181,500 LBS
TEMPERATURE AMBIENT °F

FOUNDATION LOADS:

	681,300 FT-LBS.
OVERTURN MOMENT	
HORIZONTAL SHEAR	22,000 LBS.
MAXIMUM LOAD PER COLUMN	92,100 LBS.
MAXIMUM UPLIFT PER COLUMN	17,900 LBS.
RECOMMENDED BOLT DIA.	3/4" SAE J429
TANK TO LOAD CELL	
RECOMMENDED BOLT DIA.	3/4" SAE J429
LOAD CELL TO SUB PLATE	
RECOMMENDED BOLT DIA.	3/4" A-36
SUB PLATE TO FOUNDATION	

SHIPPING NOTE:
COVER ALL FLANGE OPENINGS WITH 1/2" PLYWOOD SHIPPING COVERS. ALL NON-FLANGED TO BE COVERED WITH PLASTIC. CAUTION: DO NOT SEAL TANK COMPLETELY, CHANGE IN TEMP OR ATMOSPHERIC PRESSURE MAY CAUSE DAMAGE TO TANK.

TANK GAUGE SCHEDULE

	3/16"	304SS	L. RAD. 5'-11 11/16"	S. RAD. 0'-0"	CIRC. 36'-11 11/16"
TOP DECK (10')					
BOTTOM CONE (70')	10 GA	304SS	L. RAD. 17'-5 3/16"	S. RAD. 8'-1 3/16"	CIRC. 37'-5 1/2"
1ST. CYL. 60"	OF 10 GA	304SS			
2ND. CYL. 60"	OF 10 GA	304SS			
3RD. CYL. 60"	OF 10 GA	304SS			
4TH. CYL. 60"	OF 10 GA	304SS			
5TH. CYL. 60"	OF 10 GA	304SS			
6TH. CYL. 60"	OF 3/16"	304SS			
7TH. CYL. 60"	OF 3/16"	304SS			
8TH. CYL. 60"	OF 3/16"	304SS			
9TH. CYL. 60"	OF 3/16"	304SS			
10TH. CYL. 47"	OF 3/16"	304SS			

CUTTING SCHEDULE

	3/16"	304SS	L. RAD. 5'-11 11/16"	S. RAD. 0'-0"	CIRC. 36'-11 11/16"
TOP DECK (10')					
BOTTOM CONE (70')	10 GA	304SS	L. RAD. 17'-5 3/16"	S. RAD. 8'-1 3/16"	CIRC. 37'-5 1/2"
1ST. CYL. 60"	OF 10 GA	304SS			
2ND. CYL. 60"	OF 10 GA	304SS			
3RD. CYL. 60"	OF 10 GA	304SS			
4TH. CYL. 60"	OF 10 GA	304SS			
5TH. CYL. 60"	OF 10 GA	304SS			
6TH. CYL. 60"	OF 3/16"	304SS			
7TH. CYL. 60"	OF 3/16"	304SS			
8TH. CYL. 60"	OF 3/16"	304SS			
9TH. CYL. 60"	OF 3/16"	304SS			
10TH. CYL. 47"	OF 3/16"	304SS			

INSTALLATION/CONTRACTOR NOTES:

1.) DAMAGE TO EXTERIOR PROTECTIVE COATINGS MAY OCCUR DURING SHIPPING. IMPERIAL-CALUMET INDUSTRIES INC. SUPPLIES TOUCH-UP PAINT TO REPAIR THE FINAL COAT. SURFACE PREPARATION AND APPLICATION IS THE RESPONSIBILITY OF THE INSTALLATION CONTRACTOR.

2.) FUDGE MARKED IN THE BILL OF MATERIALS "Q" COLUMN INDICATE THAT THESE ITEMS ARE SHIPPED LOOSE. ATTACHMENT TO THE TANK IS RESPONSIBILITY OF THE INSTALLATION CONTRACTOR.

3.) BACK CHARGES FOR REWORK OR CORRECTIONS WILL BE ACCEPTED WITHOUT PRIOR AUTHORIZATION FROM THE MANUFACTURER.

TYPICAL WELD DETAIL #2

CONTINUOUS

MANUFACTURING TOLERANCES PER ES531

QUOTE #: 022-71131-08

MATERIAL TYPE: GRANULATED SUGAR

FOR ANCHOR BOLT LAYOUT SEE DRAWING NO.: I-64204-3

FIELD NOTE: ALIGNMENT MARK IS INSIDE OF SKIRT @ 0° CENTERLINE.

TANK #I-64203-1

TANK #I-64204-1

ZEPPELIN TAG NO. 40136-08002-002

IMPERIAL INDUSTRIES INCORPORATED

IMPERIAL-CALUMET DIVISION OF WAUSAU TILE, INC.

DRAWN BY: T. MCBRIDE DATE: 8-8-12 SCALE: 1/4" = 1'-0"

CHECKED BY: S. NENSTIEL DATE: 9-27-12 REVISION: 2

PRODUCTION: B. FEIT DATE: 10-2-12

DRAWING NAME: TANK ASSEMBLY DRAWING

SOLD TO: ZEPPELIN SYSTEMS USA / ODESSA, FL

SHIP TO: MULLER QUAKER DAIRY LLC / BATAVIA, NY

REV BY DATE DESCRIPTION

2 MMS 10-3-12 REVISED PER IMPERIAL DESIGN CHECK

1 MMS 9-24-12 REVISED PER CUSTOMER APPROVAL