

1. REMOVE ALL SHIPPING BRACES (PAINTED YELLOW) FROM STRUCTURE.
2. PLACE THE BASE SUPPORT STRUCTURE ONTO THE CUSTOMER SUPPLIED PEDESTALS.  
CUT OFF LIFTING LUGS AND GRIND FLUSH.
3. CREATE A FIXED POINT BY WELDING THE UPSTREAM PEDESTAL, LOCATED AT THE CENTERLINE OF THE UNIT, TO THE BASE SUPPORT

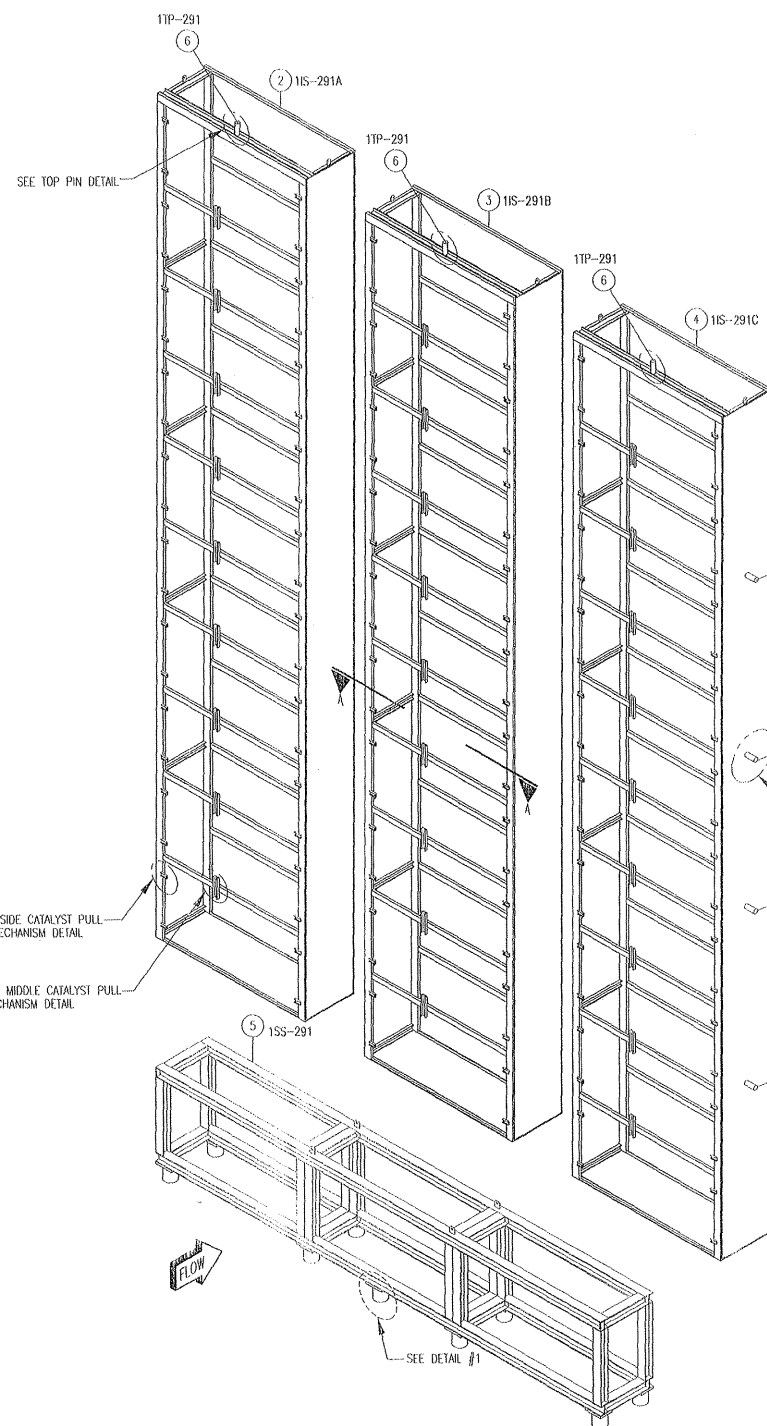
NOTE: TO ALLOW FOR THERMAL GROWTH, ONLY THIS PEDESTAL SHALL BE FIXED.

4. A. DUE TO THE LIMITED SPACE BETWEEN THE SIDE WALLS AND INTERNAL STRUCTURE, THE OUTER BAY NEEDS TO BE INSTALLED FIRST. THIS WILL ALLOW WELDING ACCESS TO THE SUPPORT STRUCTURE/INTERNAL STRUCTURE BAY INTERFACE.
- B. UTILIZING THE LIFTING LUGS ON INTERNAL STRUCTURE BAY 15S-291A OR 15S-291C, LIFT THE BAY TO AN UPRIGHT POSITION. LOWER THE BAY INTO THE HOUSING AND REST IT ON THE CATALYST SUPPORT STRUCTURE. ONCE IN PLACE, CUT OFF LIFTING LUGS.
5. LOWER THE REMAINING OUTER BAY FOLLOWED BY THE MIDDLE BAY, INTO PLACE. ONCE POSITIONED, CUT OFF THE LIFTING LUGS AND PROCEED TO WELD THE BAYS TO THE CATALYST SUPPORT STRUCTURE ACCORDINGLY (REFER TO PWC DMC: D2000093 ASSEMBLY V4).
6. USING A CONTINUOUS WELD, WELD THE BAYS TO EACH OTHER (SEE SECTION 7.4.4).
7. USING THE PIN RESTRAINTS LOCATED ON THE CRANE WALL AS A REFERENCE, INSERT THE TOP AND SIDE PINS INTO EACH RESPECTIVE BAY.
8. ONCE POSITIONED, PROCEED TO WELD THE PINS TO THE STRUCTURE (SEE TOP PIN DETAIL & SIDE PIN DETAIL).

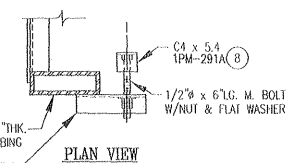
1. ONCE A CATALYST MODULE IS LOWERED INTO THE BAY, INSTALL THE ANCHOR MECHANISMS AS FOLLOWS (REFER TO CATALYST PULL MECHANISM DETAIL).
2. ALIGN ANCHOR CHANNEL (1P1MR-291A) WITH ANCHOR TABS ON CATALYST MODULES, AND TIGHTEN TO INTERNAL STRUCTURE.
3. INSTALL "T-SHAPED" ANCHORS (1P1MR-291A) INTO THE TABS ON THE CATALYST SO THAT THE THREADED SECTION PROTRUDES THROUGH THE NOTCH IN THE ANCHOR CHANNEL (1P1MR-291A).
4. INSTALL WASHER AND NUT ONTO THREADED STUB.
5. TIGHTEN UNTIL CATALYST MODULE IS SNUG AGAINST THE INTERNAL STRUCTURE AND THE WASHER BEGINS TO BEND.
6. INSTALL JAM NUT TIGHT AGAINST FIRST NUT.

1. ALIGN CHANNEL (1PMR-291B) WITH ANCHOR TABS ON CATALYST MODULE (ABOVE & BELOW) AND WELD TO  $1\frac{1}{2}$  X 2 X  $\frac{1}{4}$ " MEMBER.
2. INSTALL "SHAPED" ANCHORS (1PMR-291B) INTO TAB ON CATALYST SO THAT THE THREADED SECTION PROTRUDES THROUGH THE NOTCH IN THE CHANNEL (1PMR-291B).
3. INSTALL WASHER AND NUT ONTO THREADED STUD.
4. TIGHTEN UNTIL HORIZONTAL STRUCTURAL TUBING ( $1\frac{1}{2}$  X 2" X  $\frac{1}{4}$ ") IS SNUG AGAINST THE CATALYST MODULE.

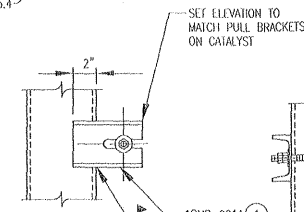
- SEAL PLATES ARE SUPPLIED AS PRE-CUT (REFER TO PMC DWG. 02000903).
- 1. FOR THE TOP SEAL PLATES, INSERT SEAL PLATE INTO RECIPIER (PROVIDED BY CASING MANUFACTURER), WITH A MINIMUM 1/4" INSERTION DEPTH, WELD THE SEAL PLATE TO THE T56x21/4" STRUCTURAL TUBING (SEE SECTION "A-A").
- 2. FOR THE SIDE SEAL PLATES, INSERT SEAL PLATE INTO SLOT LOCATED IN LNER/INSULATION WITH A MINIMUM 1" INSERTION, WELD THE SEAL PLATE TO THE T56x21/4" STRUCTURAL TUBING (SEE SECTION "B-B").
- 3. FOR BOTTOM SEAL PLATES, WELD EACH SEAL PLATE TO THE CATALYST SUPPORT WELDING 1/8" MINIMUM 1" GAP (SEE SECTION "C-C") A BAFFLE BRACKET WILL BE INSTALLED BY FIELD ERECTOR TO PROVIDE ADEQUATE SEALING.
- 4. BUTT WELD SEAL PLATES (TOP & SIDES TOGETHER).



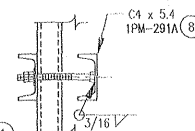
ASSEMBLY VIEW  
NOT TO SCALE



**PLAN VIEW**

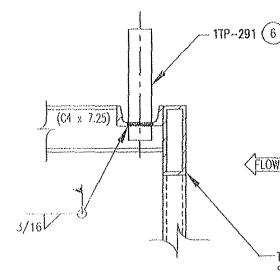


ELEVATION VIEW

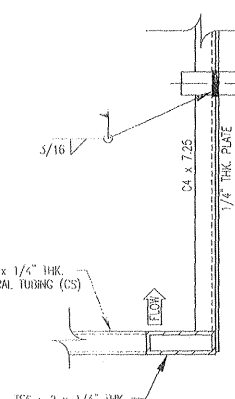


SIDE VIEW

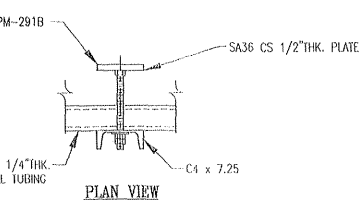
SIDE CATALYST PULL MECHANISM DETAIL  
(120 REQ'D)



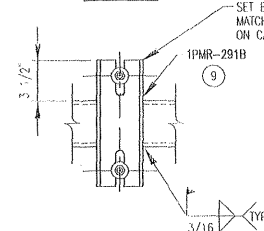
TOP PIN DETAIL  
(3 TYP.)



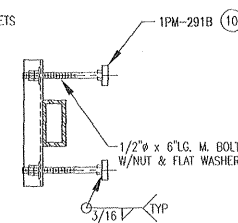
**SIDE PIN DETAIL**  
(TYP. 8 PLC'S.)



PLAN VIEW



ELEVATION VIEW



SIDE VIEW

MIDDLE CATALYST PULL MECHANISM DETAIL  
(27 REQ'D)

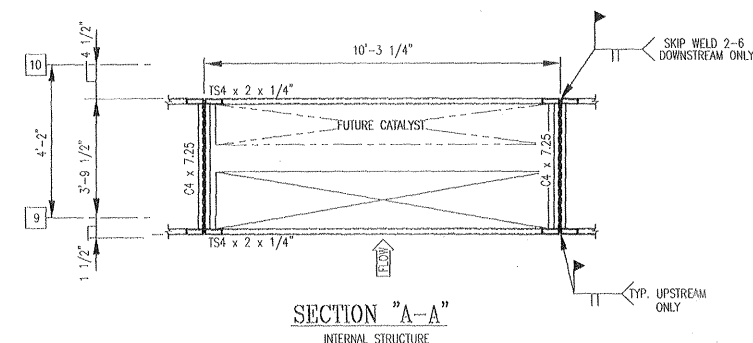
BILL OF MATERIAL		
ITEM	QTY	DESCRIPTION
1	120	702919-02000302 SIDE CATALYST ANCHOR RECEIVER (1PMR-291)
2	1	702919-02000301 INTERNAL STRUCTURE (LEFT) (1IS-291A)
3	1	702919-02000301 INTERNAL STRUCTURE (MIDDLE) (1IS-291B)
4	1	702919-02000301 INTERNAL STRUCTURE (RIGHT) (1IS-291C)
5	1	702919-02001001 CATALYST SUPPORT STRUCTURE (1SS-291)
6	3	702919-02000301 TOP PINS (1TP-291)
7	8	702919-02000301 SIDE PINS (1SP-291)
8	120	702919-02000302 SIDE CATALYST PULL MECHANISM (1PM-291A)
9	27	702919-02000302 MIDDLE CATALYST ANCHOR RECEIVER (1PMR-291B)
10	54	702919-02000302 MIDDLE CATALYST PULL MECHANISM (1PM-291B)

Review does not relieve contractor from responsibility for errors or deviations from contract requirements

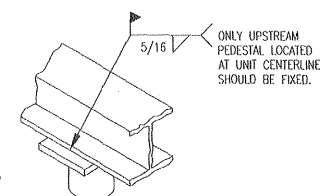
## UTILITY ENGINEERING

MRAM

- ☒ NO EXCEPTIONS NOTED  
Release for manufacture
- ☐ EXCEPTIONS NOTED  
Release for manufacture  
Revise and resubmit for distribution
- ☐ RETURNED FOR CORRECTION  
Do not proceed  
Revise and resubmit for authorization



## SECTION "A-A"



DETAIL #1

8/5/2002

**M010322-541A001 RA**  
**JEA BRANDY BRANCH**

NOTES:

1. FIELD WELD, BETWEEN EACH BAY AND CATALYST SUPPORT TO BE CONTINUOUS ALONG ENTIRE JOINT.

NOOTER/ERIKSEN INC. VENDOR SUBMITTAL REVIEW					
REVIEW OF VENDOR DRAWINGS DOES NOT RELIEVE THE VENDOR OF RESPONSIBILITIES FOR ACCURACY OF DIMENSIONS AND COMPLIANCE TO CODES, NOOTER/ERIKSEN SPECIFICATIONS AND P.O. REQUIREMENTS					
<input checked="" type="checkbox"/>	A. REVIEWED AND ACCEPTED				
<input type="checkbox"/>	B. REVIEWED WITH COMMENTS (WORK MAY PROCEED)				
<input type="checkbox"/>	C. REVERSE AND RESUBMIT (WORK MAY NOT PROCEED)				
<input type="checkbox"/>	D. REVIEWED FOR INFORMATION ONLY				
RELEASE DATE: <b>7-29-02</b>			REVIEWERS INITIALS: <b>JK</b> <b>RV</b>		
PROJECT: <b>JEAN BRANDY</b>		<b>JOB NO</b>	<b>CODE</b>	<b>SHT</b>	<b>REV</b>
<b>AE</b> <b>DRAWING NO.</b>		<b>014139-SC-305</b>	<b>A</b>	<b>X</b>	

[illegible]