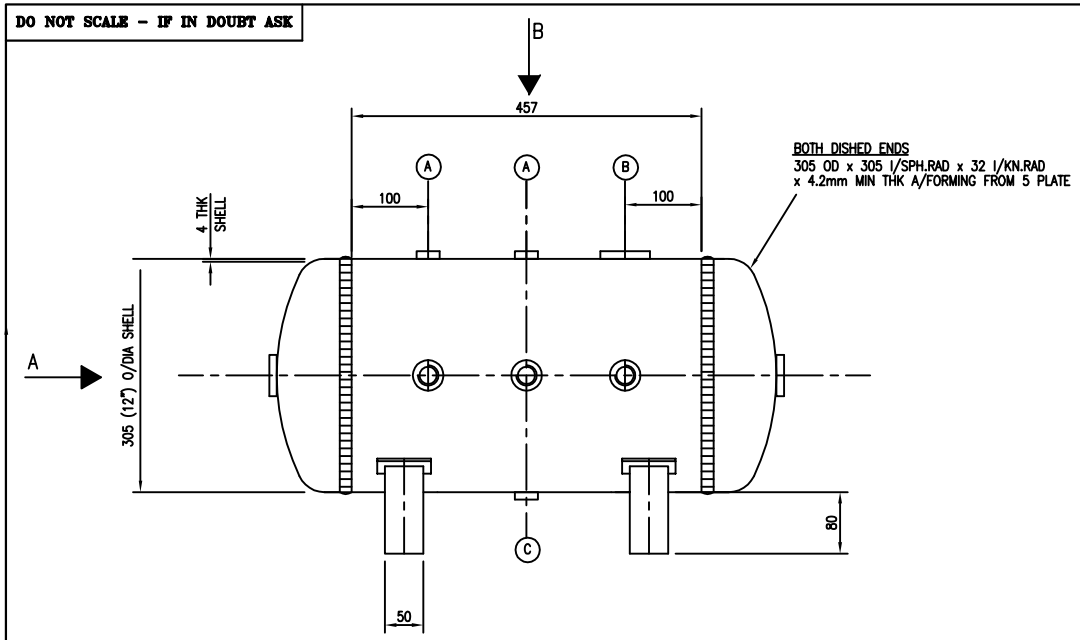
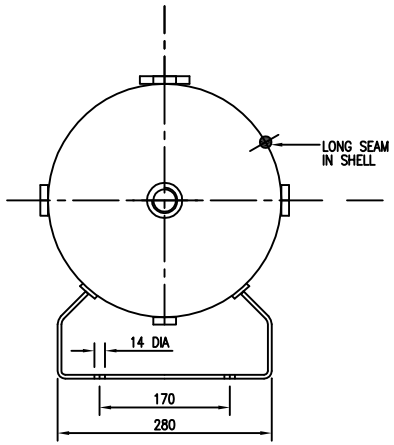
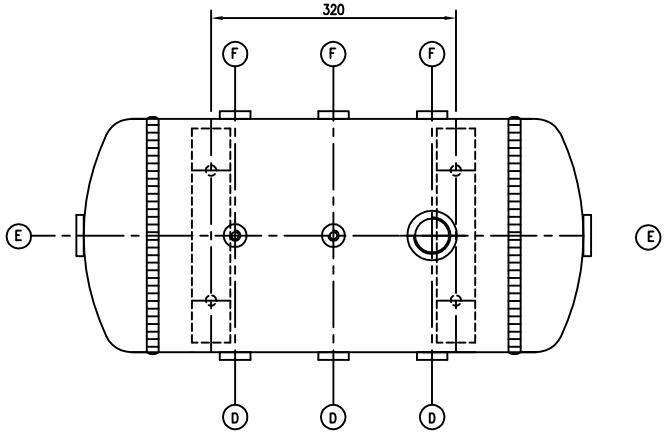
DO NOT SCALE - IF IN DOUBT ASK



FRONT ELEVATION



END VIEW ON ARROW A



PLAN VIEW ON ARROW B

!! NOTE !! ABERDEEN TOOL RENTAL AND ENERMECH HAVE 2 NAMEPLATE BRACKETS

!! NOTE !! POSITION OF NOZZLES MAY BE MOVED TO MEET CLIENT REASONABLE REQUIREMENTS PROVIDING THERE IS A MINIMUM OF 6x THE CALCULATED THK OF SHELL / HEAD BETWEEN WELDS AND THAT ALL OTHER CODE REQUIREMENTS ARE MET.

DESIGN DATA

DESIGN CODE		EN286-1:1998
DESIGN PRESSURE	Barg	12
DESIGN TEMPERATURE	°C	-10 to +85
MAX WORKING PRESSURE	Barg	12
WORKING TEMPERATURE	°C	-10 to +85
CORROSION ALLOWANCE	mm	0.5
JOINT EFFICIENCY		N/A N/A
HYDRO TEST PRESSURE	Barg	18
CAPACITY	Litres	40
WEIGHT - EMPTY	Kg	35
WEIGHT - FULL OF WATER	Kg	75
PSV	Bar.Litres	480
ADDITIONAL LOADS (FATIGUE)		N/A
FLUID GROUP		LIQUID : N/A GAS : GROUP 2
RISK CATEGORY		N/A
CONFORMITY ASSESSMENT MODULE		N/A
RADIOGRAPHY		NONE
PWHT		NO
WELD TESTS (M/C WELDS ONLY)		EVERY 50M OF WELD
INSPECTION		AJ METAL PRODUCTS LTD

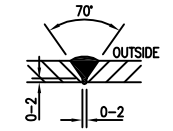
MATERIAL SPECIFICATIONS

SHELL / DISHED ENDS AND MISC BACKING PLATES	BSEN 10207 SPH265 (ALT) BS.1501-151-430A
COUPLINGS & PLUGS (SCREWED)	070M20
NOZZLE NECKS (PIPE)	N/A
PIPE FITTINGS	N/A
FLANGES	N/A
SUPPORT LEGS	BSEN.10025-S275JR (OR EQUAL)
ELECTRODES	SEE WELD PROCEDURES
MAXIMUM CARBON CONTENT OF ALL ASTM MATERIALS TO BE 0.25%	

GENERAL NOTES

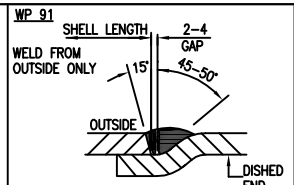
1. ALL DIMENSIONS ARE IN MILLIMETRES UNLESS STATED OTHERWISE
2. FOR TRUE ORIENTATION OF FITTINGS SEE END & PLAN VIEWS
3. TEMPERATURE OF TEST WATER AMBIENT.
4. THK OF PRESSURE COMPONENTS ARE JUSTIFIED USING EN286-1 1998
5. THIS PRESSURE VESSEL MUST BE PROTECTED AGAINST OVER PRESSURISATION BY MEANS OF A RELIEF VALVE.
6. NOZZLE OPENINGS TO BE PLUGGED / BLANKED FOR TRANSIT PROT'N.
7. DESIGN CALCULATIONS REFERENCE DOCUMENT No. 50-11/CALC.

WP 107
1st SIDE WELD INSIDE
GRIND BACK FROM OUTSIDE
2nd SIDE WELD OUTSIDE



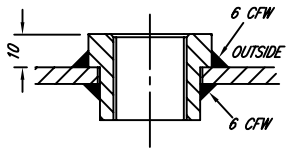
DETAILS OF SHELL LONG SEAM

WP 91



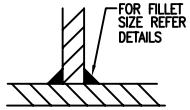
DETAILS OF D/END TO SHELL CIRC SEAMS

WELD PROCEDURE WPS 82A/103B



WELD DETAIL FOR NOZZLES A, B, C, D, & E

WP 82/108



WELD DETAIL MISCELLANEOUS FILLET WELDS

NOZZLE SCHEDULE

REF	SIZE	QTY	THREAD	SERVICE	COMMENTS
A	1/4"	1	BSPP	PRV/GAUGE	
B	1.1/2"	1	NPT	INLET	
C	3/8"	1	BSPP	DRAIN	HALF COUPLING
D	3/4"	3	NPT	OUTLETS	
E	1.1/4"	2	BSPP	INSPECTION	COMP WITH PLUGS
F	3/4"	3	NPT	OUTLETS	

REV	DATE	BY	DESCRIPTION
1	18/08/08	GLH	FIRST ISSUE FOR REVIEW

RECEIVER FINISH

INSIDE : CLEAN & DRY - LEFT SELF COLOUR
OUTSIDE : PAINT ONE COAT OF GREY PRIMER

REFERENCE DRAWINGS

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BEVAN ROAD,
BRIERLEY HILL,
WEST MIDLANDS.
DY5 3TF
TEL: 01384 74301
FAX: 01384 485772
EMAIL:

CLIENT: AJ METAL PRODUCTS LIMITED

TITLE: GENERAL ARRANGEMENT & DETAILS OF STANDARD 40 LITRE NOMINAL CAPACITY HORIZONTAL AIR PIG

CLIENTS ORDER/ CONTRACT No.:

VESSEL REF. No.:

DRAWN	CHKD	DAG	DATE	SCALE
GLH			18/08/08	1:5

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DRG No. 154

ISSUE 1 REV 1