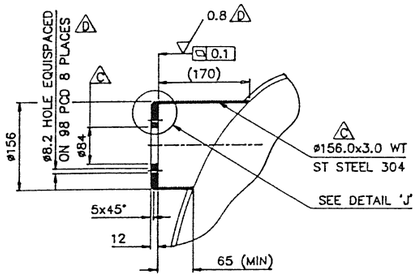
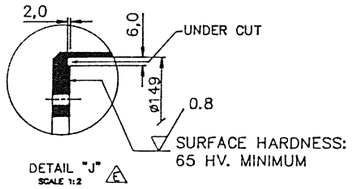
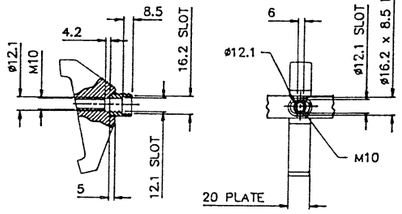
USED ON	N.H.ASSY
VTFM-11000	VTFM-00000



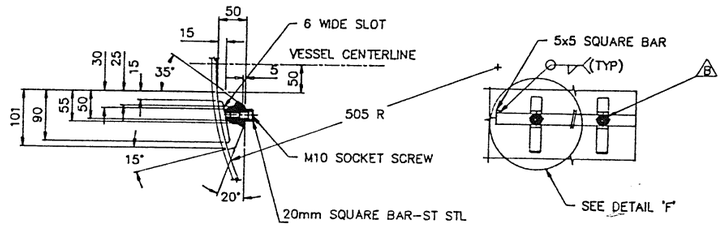
DETAIL "G"
SCALE 1:5

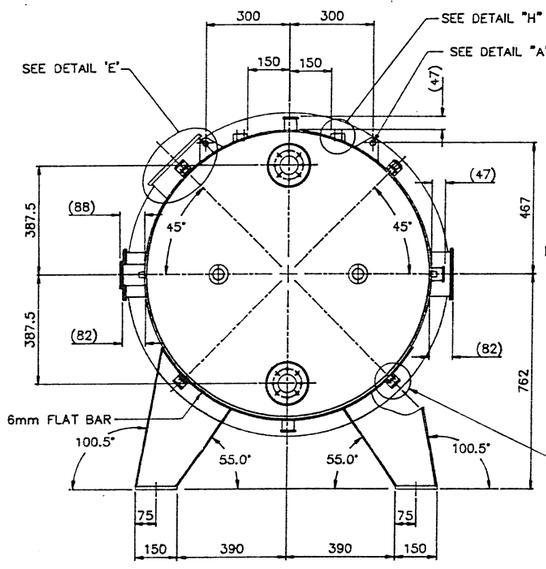


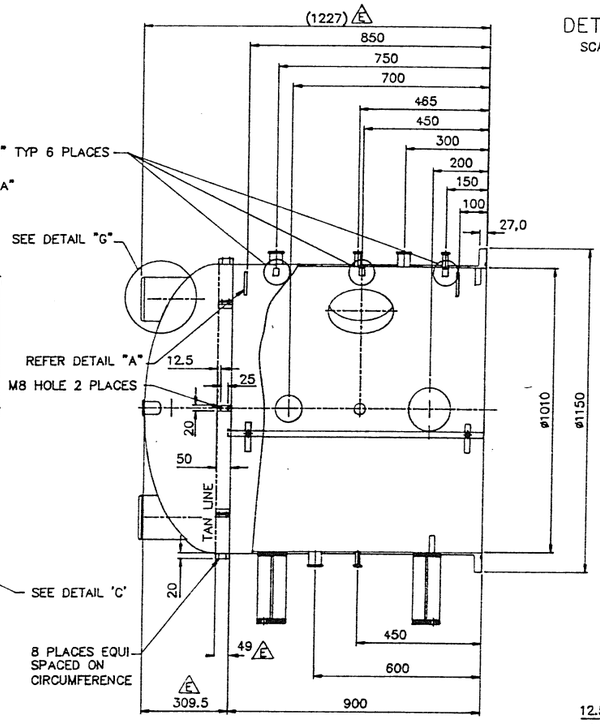
DETAIL "J"
SCALE 1:2

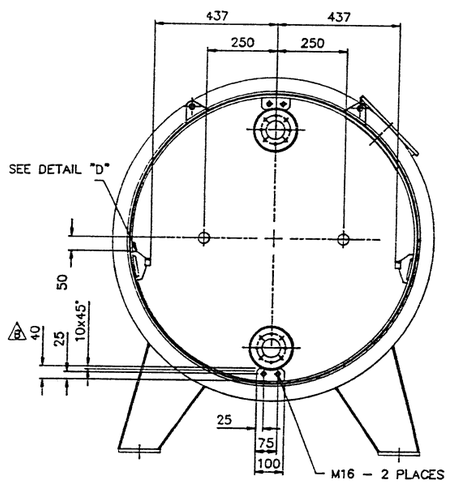


DETAIL "F"
SCALE 1:1

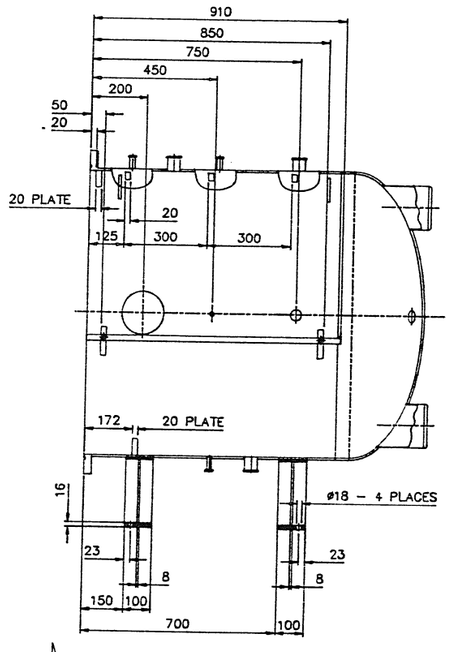


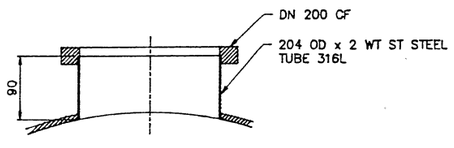




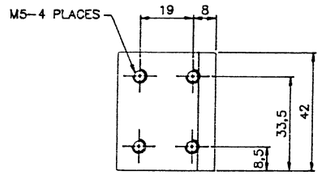


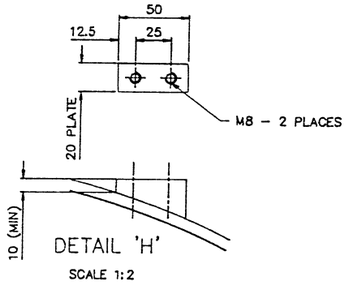
DETAIL "D"
SCALE 1:2
TYPICAL 2 PLACES



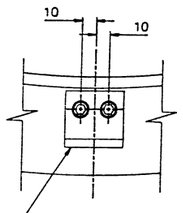


DETAIL "E"
SCALE 1:2.5



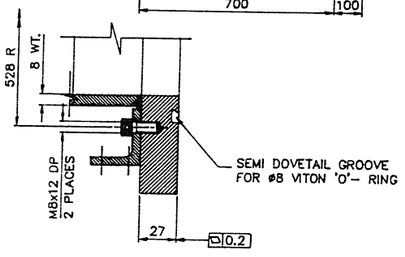


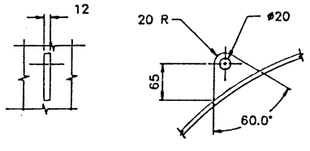
DETAIL 'H'
SCALE 1:2



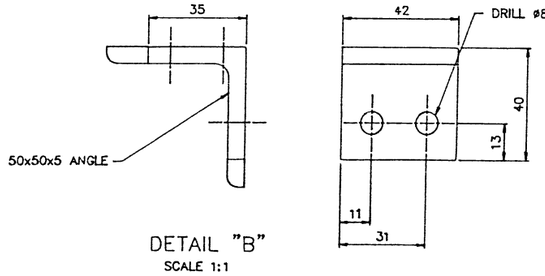
THIS DETAIL TYP 4 PLACES @ 90° SPACED
REFER DETAIL "B" FOR BRACKET DETAIL

DETAIL 'C'
SCALE 1:2





DETAIL "A"
SCALE 1:5
TYPICAL 4 PLACES



DETAIL "B"
SCALE 1:1

IST	DRAWING STATUS	ACTIVE:	SIGN:	DATE:
	INFORMATION ONLY			
	FOR 3rd. PARTY APPROVAL			
	PERMIT MATERIAL ORDER			
	FOR MANUFACTURE			
	AS BUILT			
	SUPERSEDED			

REVISION DETAILS	ISS	C/NOTE	DRAWN	CHECK	APPR	P.OFF.	DATE
UPDATE DETAIL "J"; 280.5-309.5; 1178-1227	E	–	WB				92-05-12
103 PCD – 98 PCD; 0.4 – 0.8	D	–	WB				92-04-29
ø80-ø84, PIPE SIZE +	C	–	WB				92-03-24
RAIL SCREWED-FRONT; 45-40; ø156-ø141.3	B	–	WB				92-02-28
	A	–	WB				92-01-29

DISC NO/FILE NAME: VTFM-06E
TO SABS 0111

NOTES: (UNLESS OTHERWISE STATED)
1) REMOVE ALL BURRS & SHARP EDGES TO 0,5x45° MAX.
2) SCREW THREADS TO ISO 261
3) SURFACE TEXTURE: 3,2 (Ra TO ISO 1302)
4) ALL INTERNAL RADII 0,3 MAX.
5) FOR NOZZLE IDENTIFICATION SEE SHEET 1 OF 2

MATERIAL: STAINLESS STEEL 304

GENERAL TOLERANCES: X ±0,5; XX ±0,2; XXX ±0,05; ANGLES ±1°

IST

TITLE : VESSEL WELD ASSEMBLY

ISSUE: A B C D E

DRG NO : VTFM-11100-122 SHT 2 OF 2

SCALE : 1:10 WHEN PLOTTED ON A1 UNLESS OTHERWISE STATED