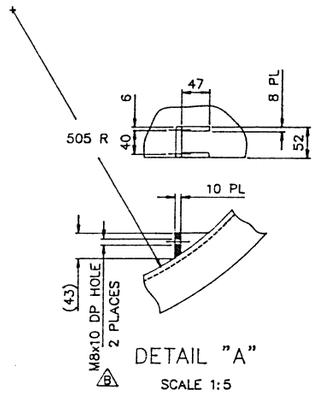
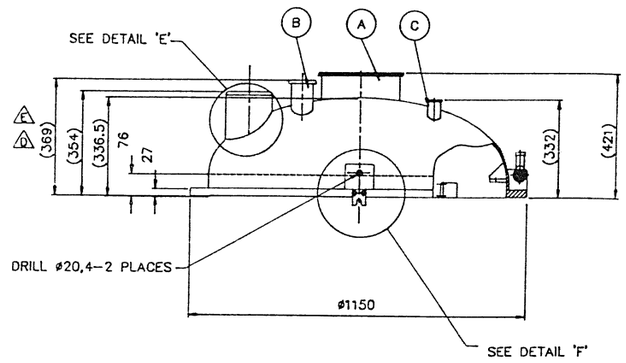
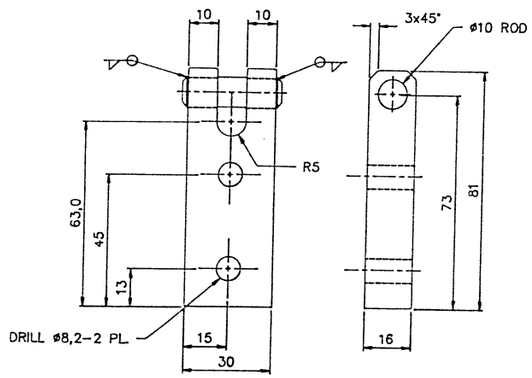
USED ON	N.H.ASSY
VTFM-12000	VTFM-00000

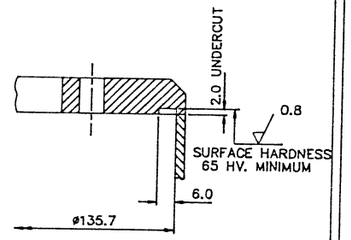


DETAIL "A"
SCALE 1:5

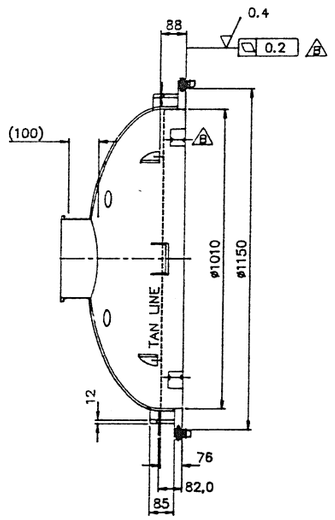


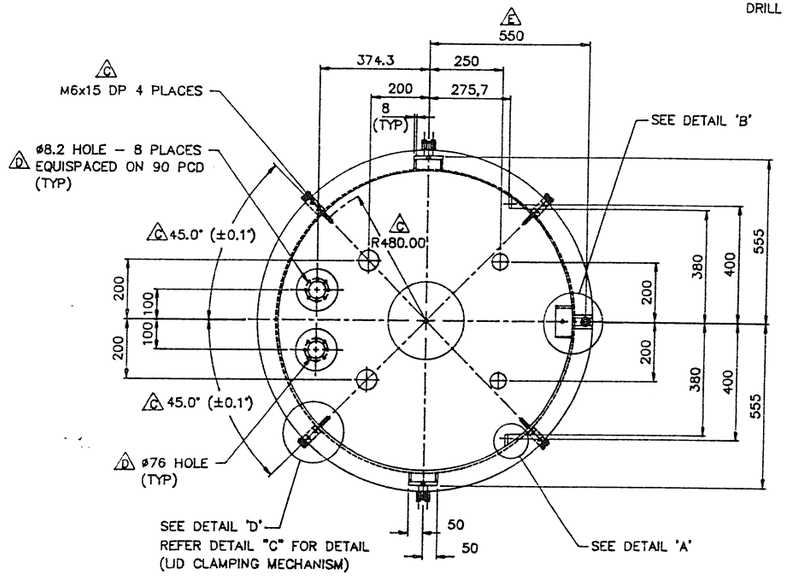


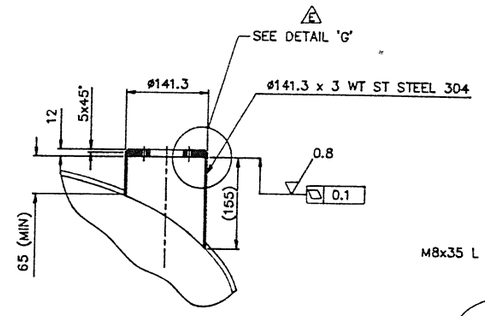
DETAIL "C"
SCALE 1:1



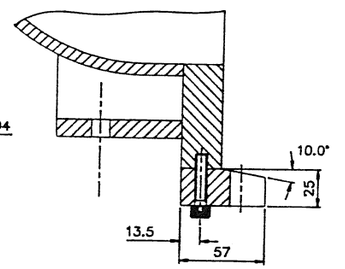
DETAIL "G" E
SCALE 1:1

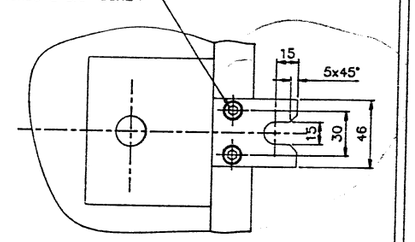




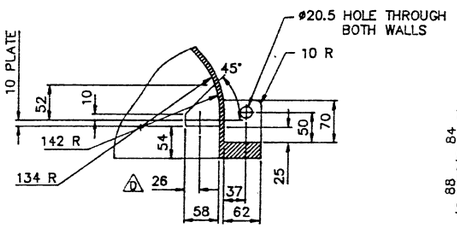


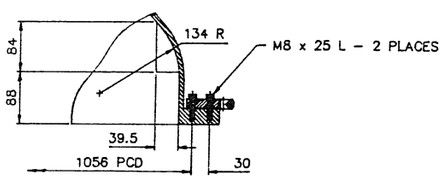
DETAIL "E"
SCALE 1:5

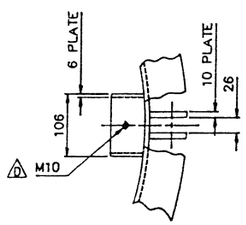




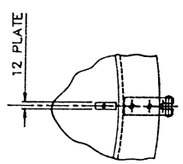
DETAIL "F"
SCALE 1:2







DETAIL "B"
SCALE 1:5



DETAIL "D"
SCALE 1:5

CODE	NUMBER	QTY
A	DN 250 ISO-K	1
B	DN 63 ISO-K	2
C	DN 40 KF	2

NOTE:
1) ENSURE ALL PRESSURE WELDS ARE FULL PENETRATION.
2) REFER TO ELCA QCP. E 12484 FOR MANUFACTURING AND VACUUM TESTING SPECIFICATIONS AND NDT. DETAIL.
3) 'O'-RING SEATING SURFACES ON SHELL & COVER MAIN FLANGES TO HAVE a SURFACE FINISH OF √N6.
4) REMOVE SHARP CORNERS AT 'O'-RING SEALING EDGES OF SHELL & COVER MAIN FLANGES.
5) SEALING FACES OF SHELL & COVER MAIN FLANGES TO HAVE a SURFACE FLATNESS OF 0,2 mm.
6) ENSURE THERE ARE NO RADIAL SCRATCH MARKS ON SEALING SURFACES OF SHELL & COVER MAIN FLANGES.

DESIGN - DATA		
DESIGN CODE:- ASME SECT. VIII DIV.1 1989 ADDENDA 1990		
OPERATING PRESSURE	(m bar ABS)	1 x 10-6
DESIGN PRESSURE	(m bar ABS)	1 x 10-6
OPERATING TEMPERATURE (MIN/MAX)	(°C)	10 / 30
DESIGN TEMPERATURE	(°C)	35
VACUUM SHOP TEST PRESSURE	(m bar ABS)	1 x 10-7
VACUUM FIELD TEST PRESSURE	(m bar ABS)	1 x 10-7
MIN. DESIGN METAL TEMPERATURE	(°C)	16
RADIOGRAPHY		FULL
STRESS RELIEF		NONE
JOINT EFFICIENCY		100%
CORROSION ALLOWANCE	(mm)	0
LEAK RATE	(Pa l/s)	1 x 10-8
WEIGHT EMPTY	(kg)	

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

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.

MATERIAL: STAINLESS STEEL 304

GENERAL TOLERANCES:
X +-0,5
X,X +-0,2
X,XX +-0,05
ANGLES +-1°

REVISION DETAILS	ISS	C/NOTE	DRAWN	CHECK	APPR	P.OFF.	DATE
DETAIL 'G' +; DISH 24mm LONGER; DIM +	E	-	WB				92-04-30
370-345, 78 PCD-90 PCD, ø58-ø76	D	-	WB				92-03-18
M6 HOLE ADDED	C	-	WB				92-03-06
FLATNESS +, ø10 - 2xM8 HOLE	B	-	WB				92-02-28
	A	-	WB				92-02-03

TO SABS 0111
DISC NO/FILE NAME: VTFM-16E

IST

TITLE : LID - WELD ASSEMBLY

ISSUE: A B C D E

DRG NO : VTFM-12100-122 SHT 1 OF 1

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