

NOTES:

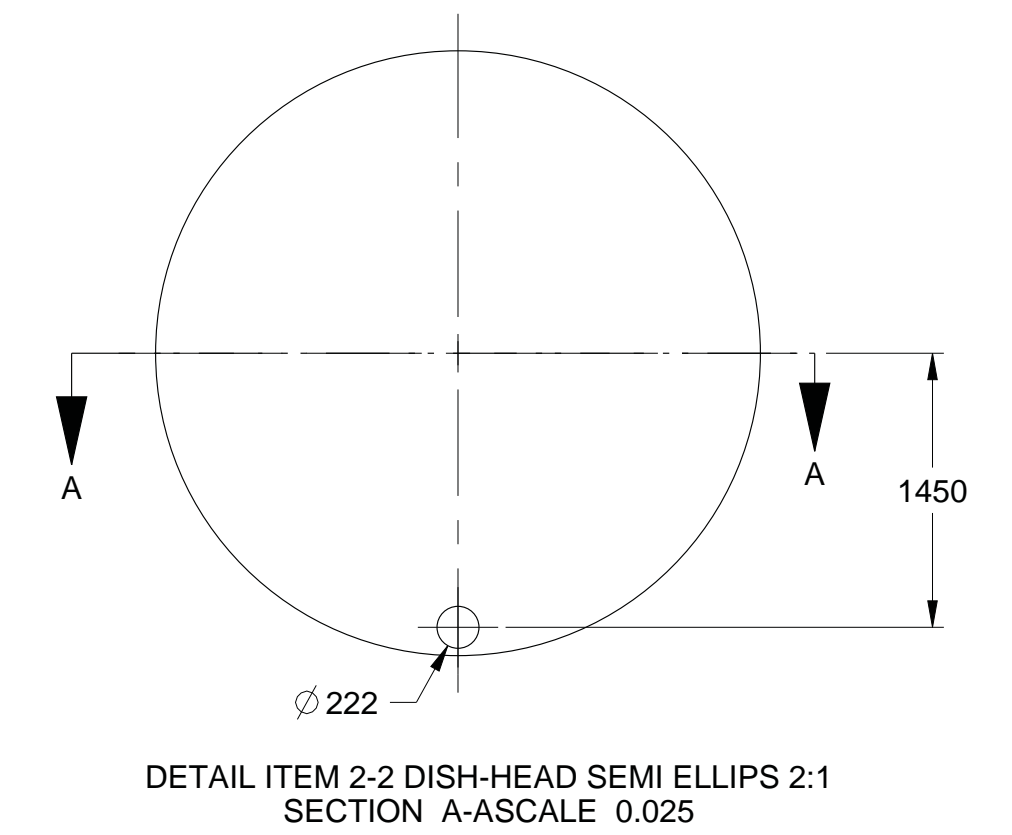
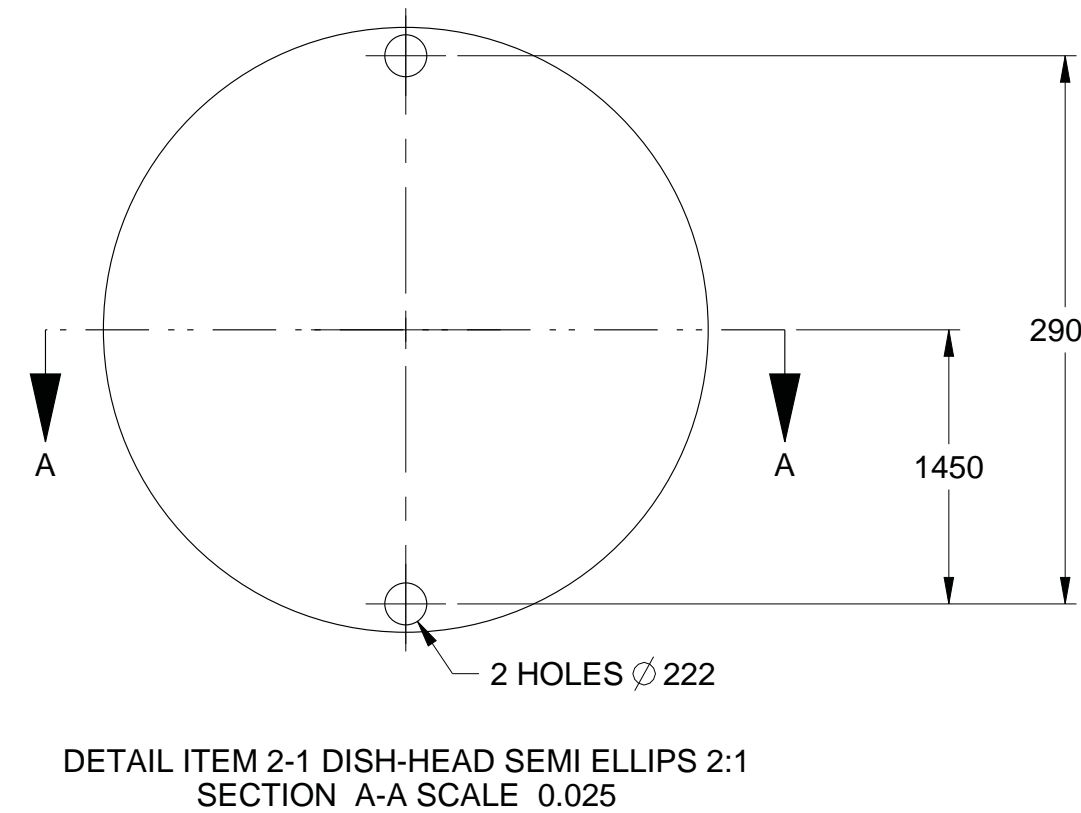
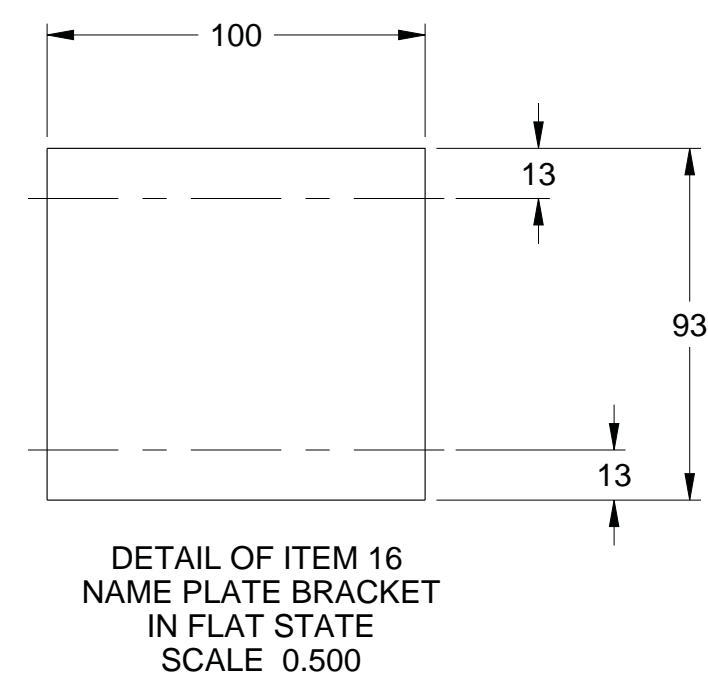
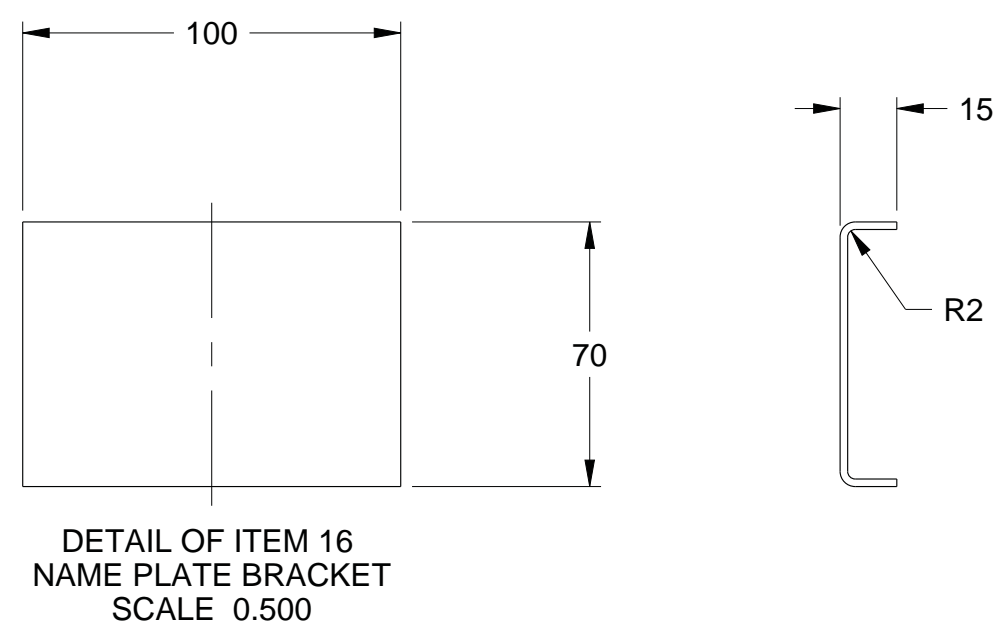
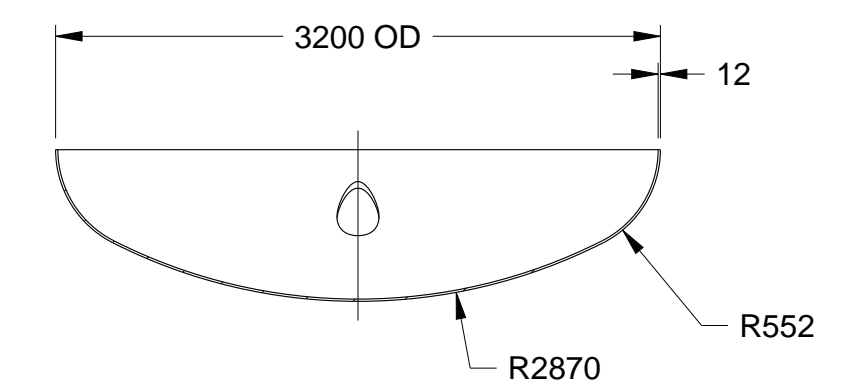
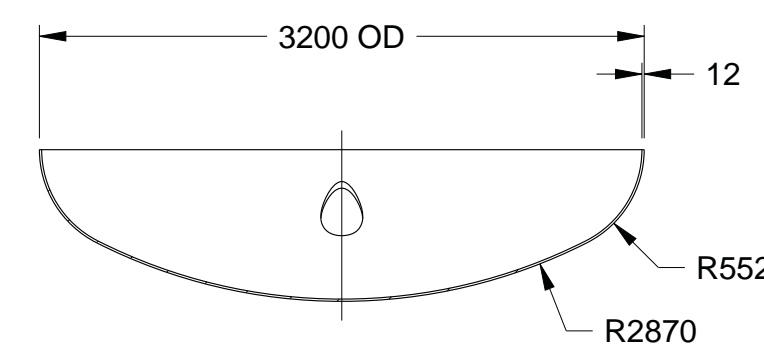
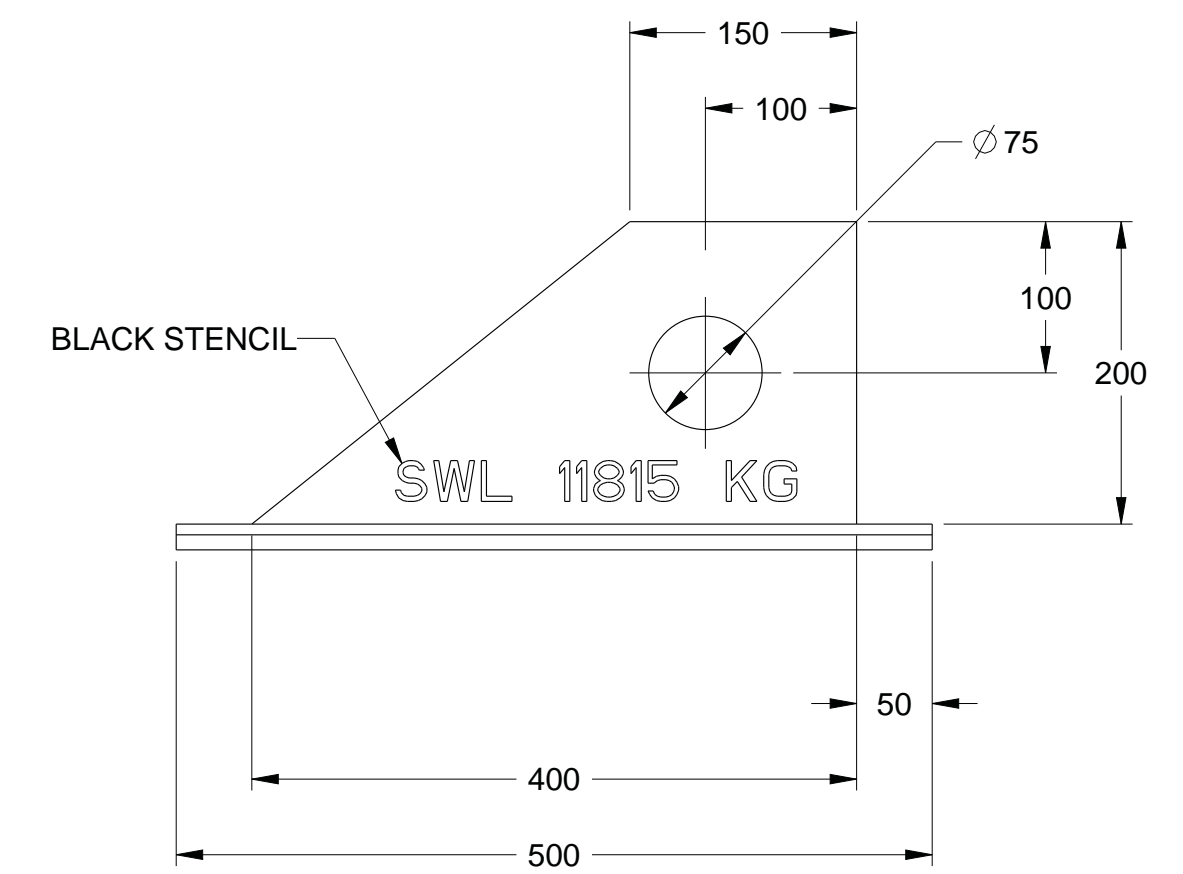
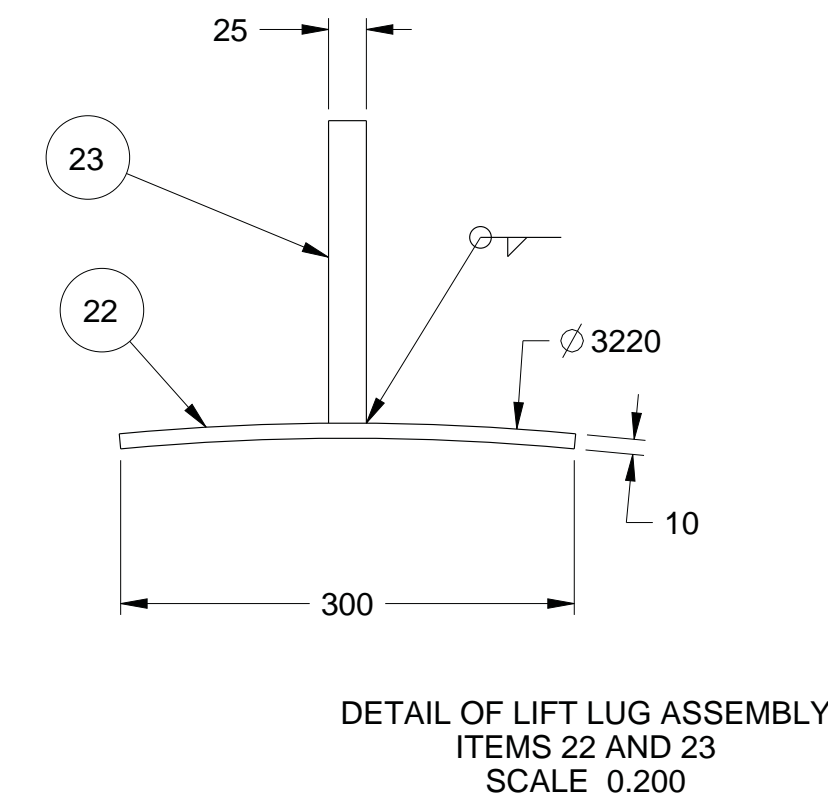
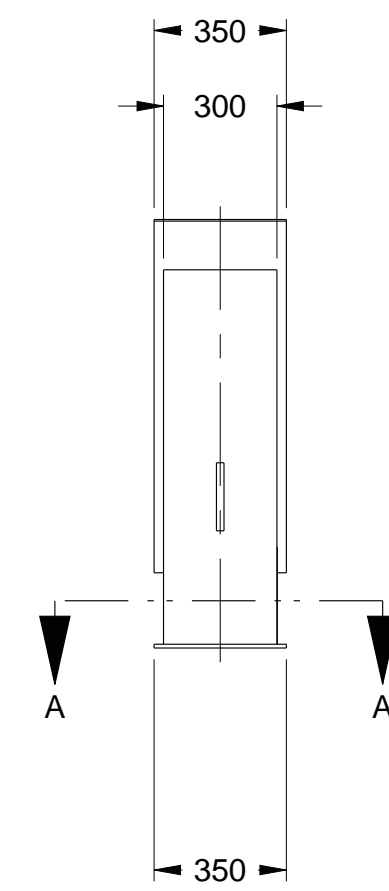
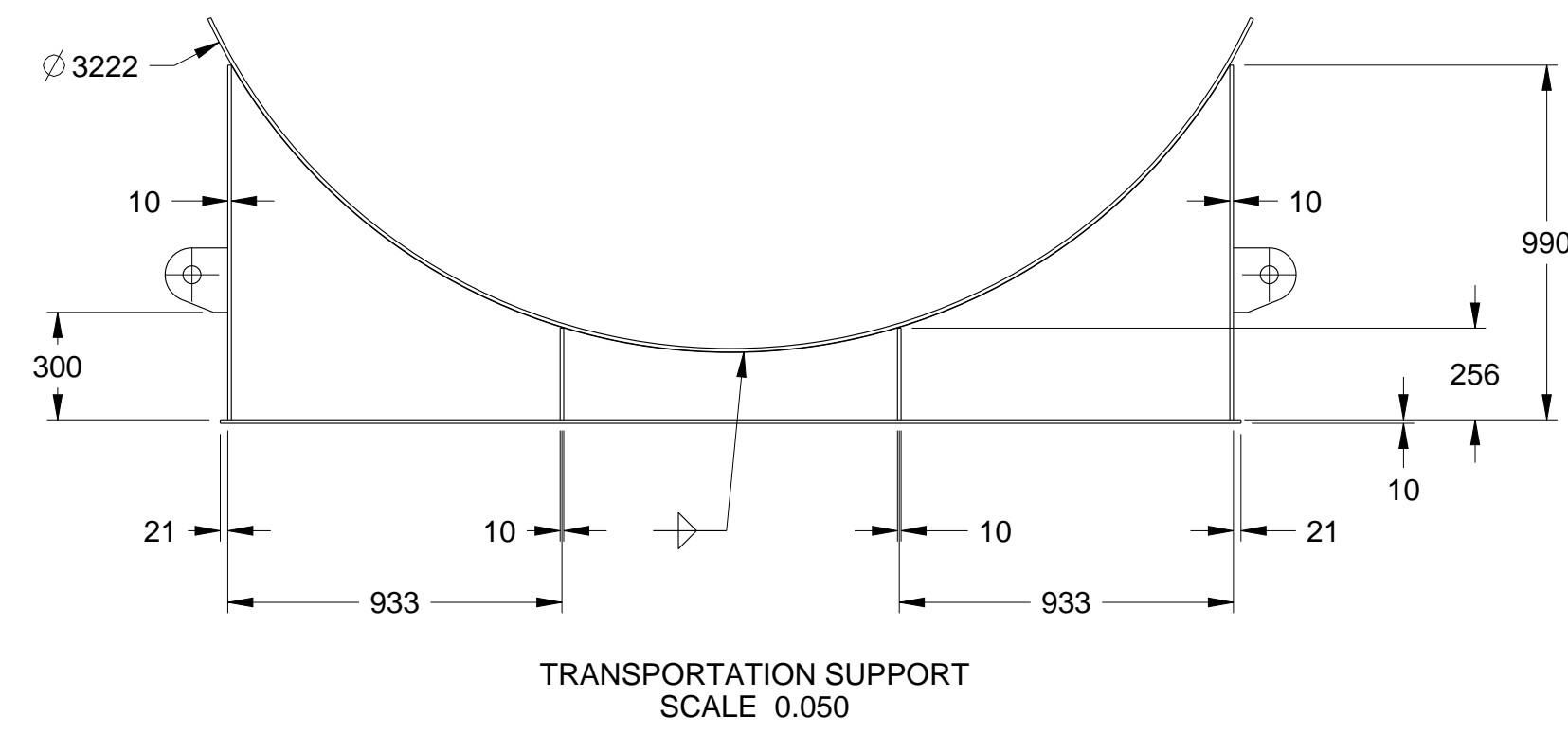
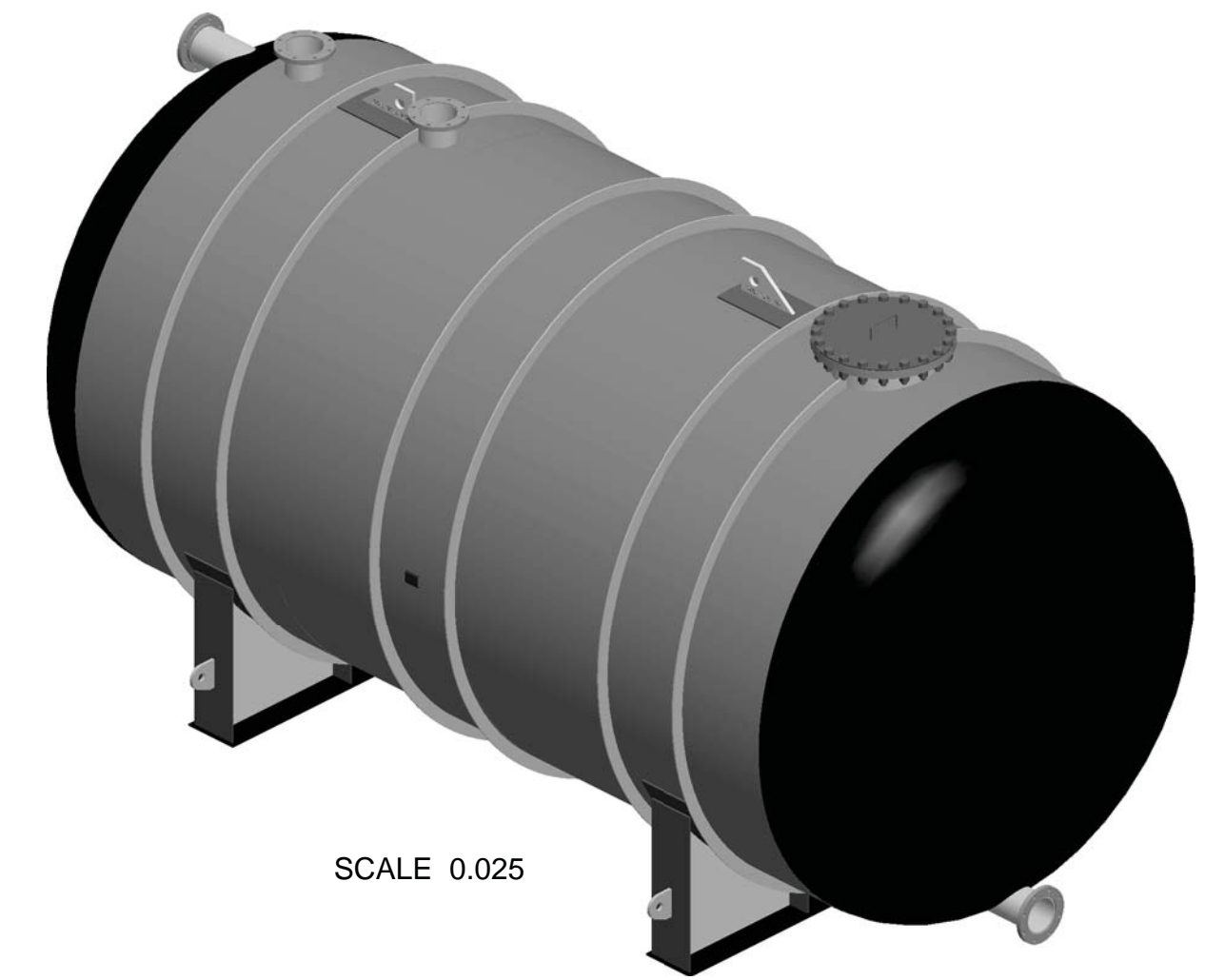
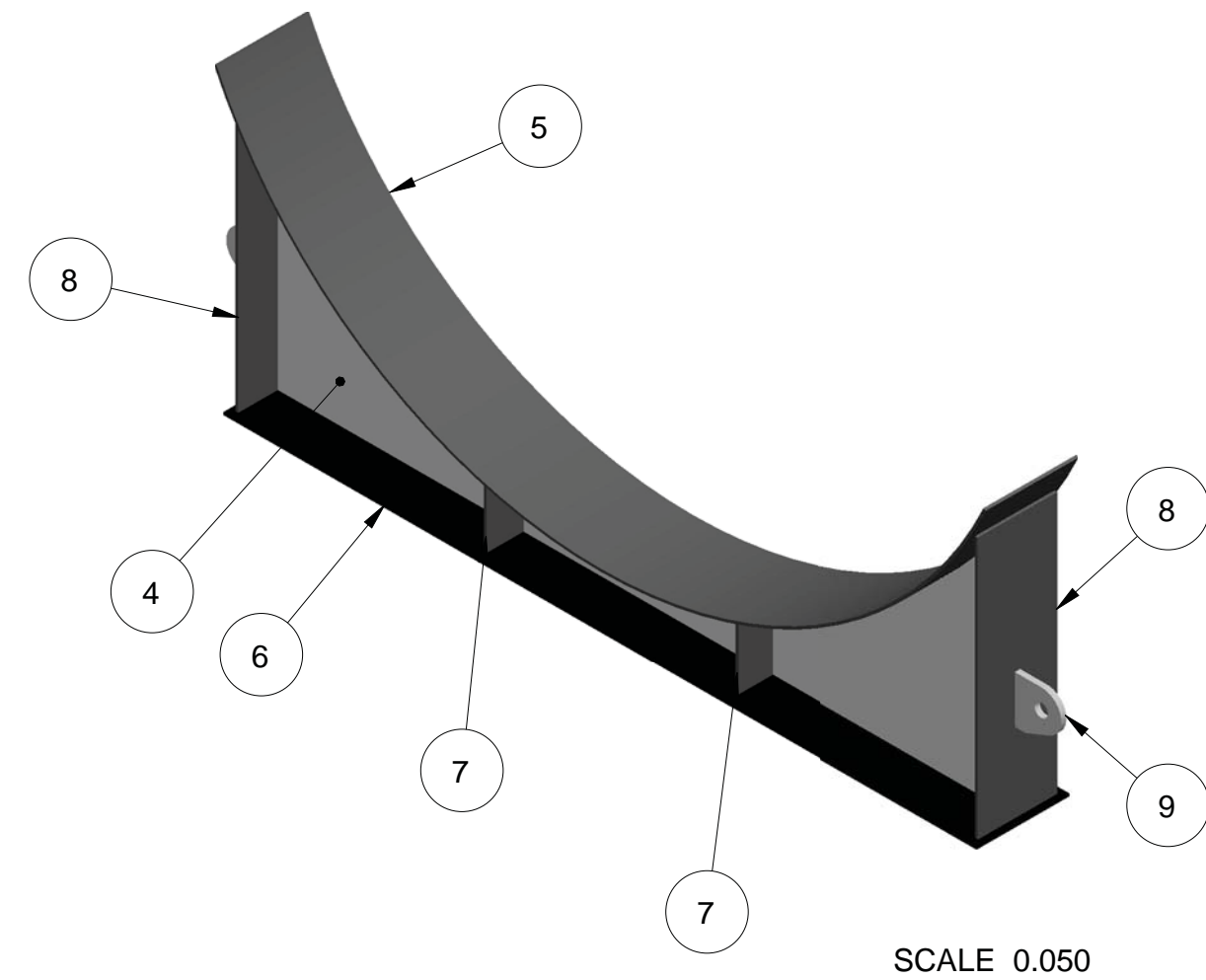
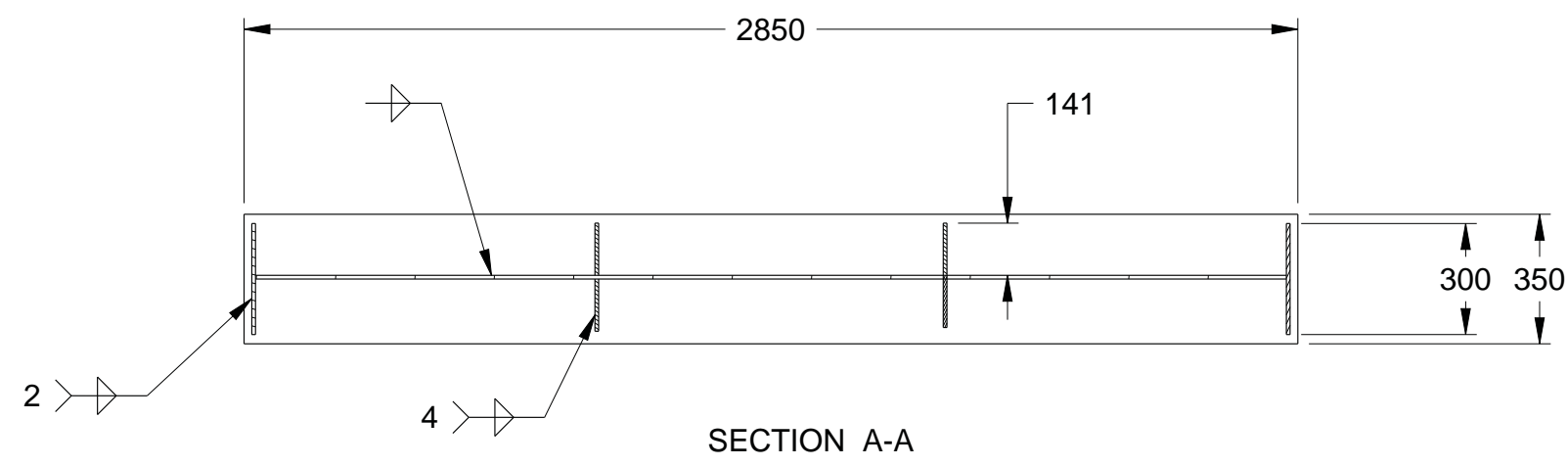
- ADJACENT SHELL COURSE LONGITUDINAL SEAMS SHALL BE OFFSET BY A DISTANCE OF AT LEAST 100 mm.
- ALL LONGITUDINAL AND CIRCUMFERENTIAL SHELL/HEADS WELDS SHALL BE COMPLETE JOINT PENETRATION (CJP).
- FINISH: FOR EXTERNAL WELDS REMOVE SMOKE STAINS AND STAINLESS STEEL WELD DISCOLORATION. FOR INTERNAL WELDS REMOVE SMOKE STAINS.
- MACHINED SURFACES OF ALL FLANGES TO BE PROTECTED FOR SHIPPING.
- ALL WELDING MUST BE TO ASME CODE SECTION 9 AND PERFORMED BY WELDERS QUALIFIED TO WELDING PROCEDURES APPROVED BY UNIVERSAL AET.
- ATTACH NAMEPLATE (ITEM 17) TO NAMEPLATE BRACKET (ITEM 16), WITH STAINLESS STEEL SCREWS.
- CLEANING - UNLESS OTHERWISE STATED, TO A MINIMUM OF SPECIFICATION 88-0161
- EXTERNAL WELD CLEANING - WELD HEAT AFFECTED ZONES ARE TO BE CLEANED USING ACID CLEANER AND PASSIVATION, OR BY HAND RUBBING USING AN AUTOMOBILE RUBBING COMPOUND OR EQUIVALENT. SCOTCH-BRITE PADS OR OTHER CONSUMABLES MUST BE NEW OR HAVE ONLY BEEN USED ON STAINLESS STEEL
- STAINLESS STEEL WELDING WIRE TO BE USED ON ALL STAINLESS STEEL PARTS, INCLUDING ST.ST. TO MILD STEEL PARTS EXCEPT WHEN WELDING MILD STEEL TO MILD STEEL. ALL ST. ST. WELDS TO BE THOROUGHLY CLEANED AND ACID ETCHED.
- DISHED HEADS IF MANUFACTURED IN SEGMENTED PIECES, TO BE QUALIFIED TO TFLOW PROCEDURE RQP/18A REV. NO.03
- NDT TESTING FOR DISHED HEAD, LIFTING LUGS AND SADDLES
- THE OIL TANK TO BE HYDROSTATIC TEST AT 0.6MPa (87 PSI). (SPEC 88-1098 CURRENT REV, RECORD 94-1061)
- DO NOT USE LOCKING LUGS ON SADDLE FOR LIFTING THE OIL TANK.
- MATERIAL:
OIL TANK AND SADDLE PAD IN ST.ST. 304L
THE REST OF THE SADDLE STRUCTURE IN MILD STEEL
- FINISH. TANK: SELF COLOUR
SADDLES: PRIMER COAT INTERZINC 22
- SADDLES FOR TRANSPORTATION PURPOSES ONLY NOT TO BE WELDED TO TANK
- TANK WEIGHT: 7030 Kg
2X SADDLES WEIGHT: 675 Kg
TOTAL WEIGHT: 7705 Kg

ITEM	DESCRIPTION	MATERIAL	MM	CUTTING SIZE	QTY	NOTES
23	LIFT LUG	ST.ST. 304 L	25	400 X 200	2	--
22	LIFT LUG REPAD	ST.ST. 304 L	10	500 X 300	2	ROLL TO 3220 OD
21	HEX NUT	ST.ST. 304 L	--	M33	20	--
20	SPRING WASHER	ST.ST. 304 L	--	M33 NOM	20	--
19	PLAIN WASHER	ST.ST. 304 L	--	M33 NOM	40	--
18	HEX BOLT	ST.ST. 304 L	--	M33 X 120 LG	20	--
17	NAME PLATE	ALUMINIUM	0,9	PART NO. 00/124	1	--
16	NAME BRACKET	ST.ST. 304 L	2	100 X 93	1	--
15	STUB	ST.ST. 304 L	8	225 X 1908 CIRC	1	ROLL TO 612 OD
14	STUB	ST.ST. 304 L	8	525 X 682 CIRC	5	ROLL TO 220 OD
13	COVER	ST.ST. 304 L	10	813 OD	1	--
12	GASKET	FERROFLEX SPAF-II	1.2	PART NO. G600/315	1	--
11	CONNECTING FLANGE	ST.ST. 304 L	--	200 (8") NOMINAL BORE	5	SPEC. 88-1141
10	CONNECTING FLANGE	ST.ST. 304 L	--	600 (24") NOMINAL BORE	1	SPEC. 88-1141
9	LOCKING LUG	M.S.	20	180 X 175	4	--
8	TRANSPORTATION SADDLE	M.S.	10	141 X 256	8	--
7	TRANSPORTATION SADDLE	M.S.	10	300 X 990	4	--
6	TRANSPORTATION SADDLE	M.S.	10	350 X 2850	2	--
5	TRANSPORTATION SADDLE	ST.ST. 304 L	10	350 X 3653 CIRC	2	--
4	TRANSPORTATION SADDLE	M.S.	10	990 X 2789	2	--
3	STIFFENER RING	ST.ST. 304 L	10	3350 OD X 3200 ID	6	--
2-1	DISH-HEAD SEMI ELLIPS 2:1	ST.ST. 304 L	12	3180 O/D	1	SEE DETAIL
2-1	DISH-HEAD SEMI ELLIPS 2:1	ST.ST. 304 L	12	3180 O/D	1	SEE DETAIL
1	CASE	ST.ST. 304 L	10	5370 X 10022 CIRC	1	ROLL TO 3200 OD

TOLERANCES UNLESS STATED - SEE FULL SPEC. 88-0075			
(mm)	US customary (")	(mm)	US customary (")
0-300	0-12	±1.6	±1/16
>300-600	>12-24	±3	±1/8
>600-900	>24-36	±5	±3/16
>900-6000	>36-240	±6	±1/4
>6000	>240	±12	±1/2

APPROX. WT. SEE NOTE		MATERIAL SEE NOTE	
FINISH SEE NOTE			

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This Document and the information contained herein constitutes proprietary property, and shall not be copied or used or disclosed without the express written consent of Universal Acoustic & Emission Technologies Inc.		SCALE: DO NOT SCALE
DESCRIPTION: OIL TANK		
THIRD ANGLE PROJECTION	FABRICATION DWG. NO: 47914-Z	SHEET 1 OF 2
		REV. 1



TOLERANCES UNLESS STATED - SEE FULL SPEC. 88-0075			
(mm)	US customary (")	(mm)	US customary (")
0-300	0-12	±1.6	±1/16
>300-600	>12-24	±3	±1/8
>600-900	>24-36	±5	±3/16
>900-6000	>36-240	±6	±1/4
>6000	>240	±12	±1/2

APPROX. WT.	SEE NOTE	MATERIAL	SEE NOTE
FINISH	SEE NOTE		

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DESCRIPTION		OIL TANK	
THIRD ANGLE PROJECTION	FABRICATION DWG. NO:	SHEET	REV.
	47914-Z	2 OF 2	1
NAME	DATE		
DRAWN AH	26-MAY-2016		
CHECKED HPS	07-JUN-2016		

NO.	CHANGE DESCRIPTION	DRAWN	APPD
REVISION RECORD			
VARIATIONS			
CLEANING			