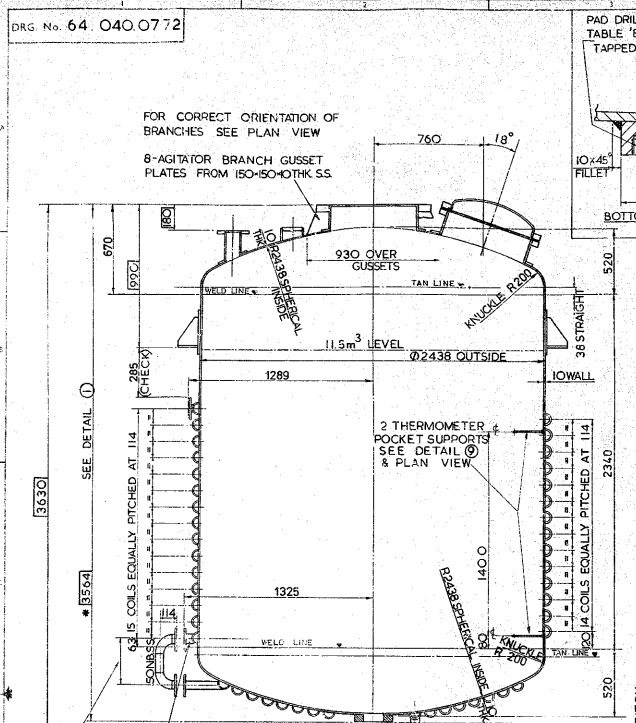
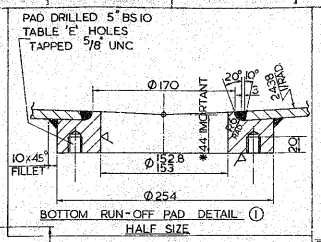
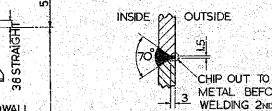
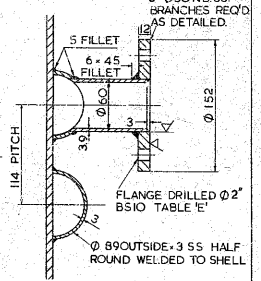
DRG No. 64.040.0772

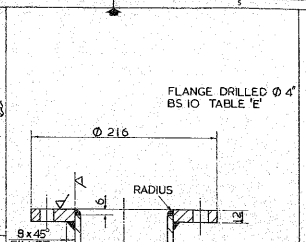


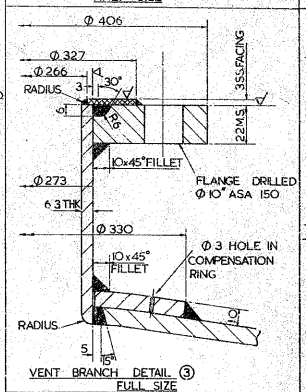


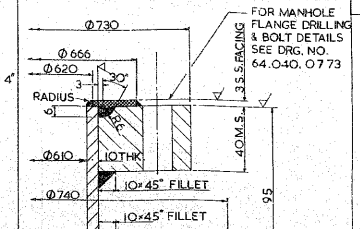


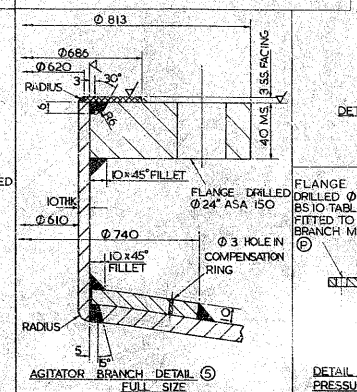


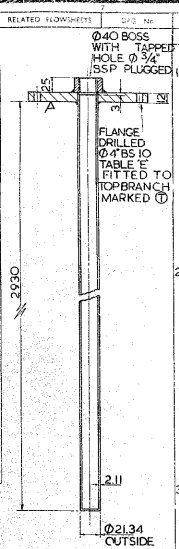


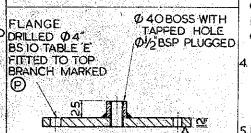


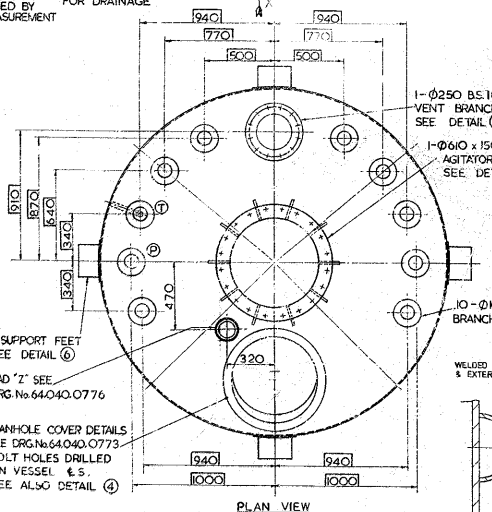


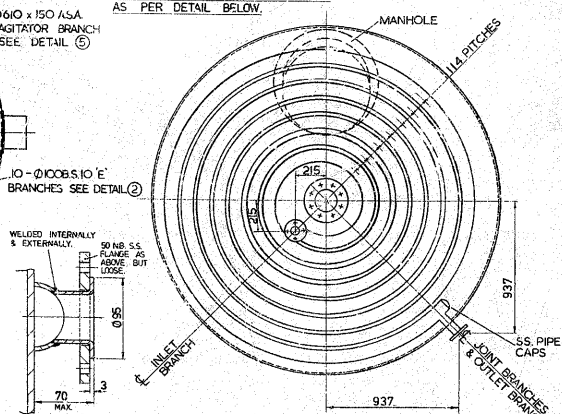


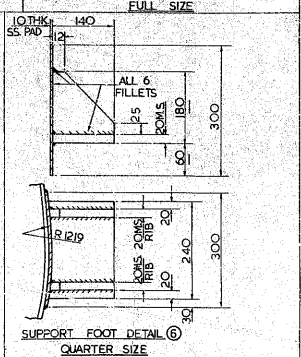


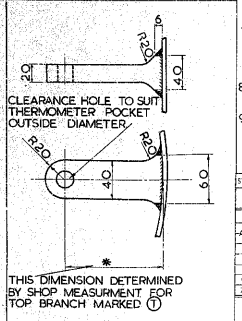












1. MATERIAL:-
SHELL AND END PLATES TO BE STAINLESS STEEL TO BS.1501-821 GR 11 OR Nb.
PAD NOZZLES AND S.S. FLANGES MADE FROM PLATE TO THE PREVIOUS SPECIFICATION MILD STEEL FLANGES, SUPPORT FEET ETC. MADE FROM MILD STEEL PLATE TO BS.1501-151 GRD 28A.
DISHED ENDS TO BE TO BSS 1966 TABLE 5 WHERE KNUCKLE RADIUS = 0.06 SPHERICAL RADIUS
FLANGES TO BE DRILLED AS SPECIFIED.
DRILLING TO BE OFF CRS. TO CENTRE LINES OF VESSEL. BOLTS TO BE GEIGY STANDARD 25.110
GASKETS TO BE GEIGY STANDARD 24.700

2. CONSTRUCTION:-
VESSEL TO BE OF ALL WELDED CONSTRUCTION AND ALL SEAMS TO BE WELDED INSIDE AND OUTSIDE.
ALL WELDS TO BE FREE FROM FLAWS AND POROSITY.
ALL CORNERS TO BE RADIUSED.
INTERNAL SURFACES OF ALL PLATES, SEAMS AND WELDS TO BE DRESSED AND POLISH FINISHED.
TEST PIECE TO BE PREPARED BY FABRICATOR AND ACCEPTED BY CIBA-GEIGY (UK) LTD. BEFORE CONSTRUCTION
SEE NOTE 6 FOR EXTERNAL FINISH.

3. DESIGN TO A.S.M.E. 1974 SECTION VIII
CORROSION ALLOWANCE - NIL
DESIGN PRESSURE - 2.4 BAR G AND FULL VAC.
COIL 5.2 BAR G.
DESIGN TEMPERATURE 50°C. COIL - 50°C
TEST PRESSURE (HYDRAULIC) 3.6 BAR G.
COIL - 9.3 BAR G
TESTING AND INSPECTION AOTC CLASS III SERVICE 'B'
ALL TO BE CARRIED OUT TO THE SATISFACTION OF CIBA-GEIGY (U.K) LTD PIGMENTS DIVISION, INSPECTION ENGINEER DURING ALL STAGES OF CONSTRUCTION.

4. APPROX. WEIGHTS:-

VESSEL	CONTENTS FULL	AGITATOR
3.6 TONNES	18 TONNES	

5. MACHINE FINISH 250 ALL OVER.

6. VESSEL EXTERNAL FINISH:- TOP DISHED END ONLY ABOVE WELD LINE TO BE GROUND SMOOTH AND POLISHED TO THE SAME DEGREE AS THE INTERNAL SURFACES BUT ADDITIONALLY GROUND AND MOP POLISHED TO GIVE A PLEASING AND ATTRACTIVE APPEARANCE.
THE REMAINDER OF THE EXTERIOR TO BE FINISHED IN A GOOD WORKMANLIKE MANNER.

7. ALL FLANGES OTHER THAN THOSE FOR MANHOLE AND AGITATOR TO BE FITTED WITH BLANK S.S. COMPANION FLANGES.

8. DIMENSIONS INDICATED THUS [ ] TO BE WITHIN THE TOLERANCE OF ±3

9. SHELL TOLERANCE IN ACCORDANCE WITH A.S.M.E. STANDARD.

PREVIOUS DRG No. 64.040.0618 METRICATED

SYMBOL	DESCRIPTION	
	VALVE LIST	
A&B	E	VARIOUS DIMENSIONS & UPPER CONN. ON COIL MODIFIED.
A&B	D	SSP ISSUES 123 INCORPORATED
A&B	C	EQUIVALENT TO BS 1501-821 ACCEPTED
A&B	B	SUPPORT FEET WAS BS 4360-43A
C-B	A	A.S.M.E CODE UPDATED
ZONE	ISSUE	REVISION

CIBA-GEIGY (UK) LTD.
ENGINEERING

DETAIL OF 11.5m³ STAINLESS STEEL VESSEL WITH EXTERNAL HEMI-COILS

SCALE	1:12	PROJECT No.	5209
DRAWN	T.I.L. 28-1-75	S.R. CODE	413-24.
TRACED	10-8-75	LOCATION	PAISLEY
CHECKED		DRG. No.	64.040.0772
APPROVED	11-3-75	ISSUE	A B C D E

ISSUE	MAT'L SPEC'N	ISSUE	DISHED END DIMENSIONS	ISSUE	LIMPET COIL
1	MODIFIED AS	2	MODIFIED	3	NOZZLE STAND
18.7.75	REQUESTED	22.8.75		28.11.75	-OUT MODIFIED
AH	BY SSP	AH		AH	

ALL DIMENSIONS IN MILLIMETERS UNLESS OTHERWISE STATED

S.S.	STAINLESS STEEL	64.040.0774	DETAIL OF Ø 660 MANHOLE CHARGE BASKET.
M.S.	MILD STEEL	64.040.0773	DETAIL OF Ø 610 MANHOLE COVER.
		64.040.0775	ARRGT. OF DAVIT ASSEMBLY

CODE | MATERIAL | DRG. No. | TITLE
PIPE IDENTIFICATION CODE | RELATED DRAWINGS

T.R. McPHERSON (MICROFILM SERVICES) LIMITED
BLACKHALL HOUSE BLACKHALL LANE RALEIGH PA4 0EA SCOTLAND TELEPHONE 041-886 2266