



DESIGN DATA		UNIT	SHELL
DESIGN CODE			EN13445-3/PED
CONTENT			WATER
CLASSIFICATION OF CONTENT			HARMLESS (2)
CATEGORY ACCORDING TO PED			III
LOCATION			INDOORS
DENSITY OF CONTENT		kg/m ³	1000
DESIGN TEMP. MIN/MAX		°C	+50
OPERATING TEMP. MIN/MAX		°C	+50
DESIGN PRESSURE MIN/MAX		MPa(g)	0 / 0.2
OPERATING PRESSURE		MPa(g)	0 / 0.2
HYDROSTATIC PRESSURE		MPa(g)	0.058
TEST PRESSURE		MPa(g)	0.286
JOINT EFFICIENCY			0.85, HEADS 1.0
CORROSION ALLOWANCE		mm	-
PLATE TOLERANCE		mm	0.15
VOLUME GROSS/NET		m ³	49.9/44.1
WEIGHT EMPTY/FULL		kg	4200/54100

MATERIALS	
PARTS, CONTACT WITH CONTENT	SFS-EN10028-7/EN10027/EN10222-5/EN10272, EN1.4301, 1.4307
HEATING/COOLING JACKET	-
CLADDING	-
NOZZLES	SFS-EN10028-7/EN10027/EN10222-5/EN10272, EN1.4301, 1.4307
PARTS, OUTSIDE THE TANK	SFS-EN10028-7, EN1.4301, 1.4307
GASKETS	NBR (FOOD INDUSTRY QUALITY)
SCREWS AND NUTS	A2-70/A4-70
INSULATION	ARMAFLEX 13mm
COVERING OF INSULATION	-

FINISHING	
SURFACE ROUGHNESS IN	2B, HEADS 1D
OUT	2B, HEADS 1D
WELDS IN	PICKLING
OUT	PICKLING

INSPECTIONS	
MODULE ACCORDING TO PED	G-MODULE
X-RAY	ACC. EN13445-5 TEST GROUP 3b
LIQUID PENETRANT TEST	ACC. EN13445-5 TEST GROUP 3b
WITNESS HYDR./PRESSURE TEST	PRESSURE TEST 2.86 bar
CHECKING OF DIMENSIONS	YES

NOZZLE SCHEDULE					
ID	SIZE	NOZZLE	DIRECT LENGTH	STANDARD	REMARKS
N1	DN350		270°	DIN2632	
N2	DN350		90°	DIN2632	
N3	DN350		90°	DIN2632	
N6	DN25	SAFETY VALVE	270°	R3/4" MUFF	
N7	DN25	AIR VENT	CENTER	R3/4" MUFF	
N8	DN50	VACUUM VALVE	90°	R2" MUFF	
N9	DN600	MANHOLE	180°	TANKKI	
N10	DN20	THERMOMETER	135°	R1/2" MUFF	
N11	DN20	THERMOMETER	135°	R1/2" MUFF	
N13	DN20	THERMOMETER	135°	R1/2" MUFF	
N14	DN20	THERMOMETER	135°	R1/2" MUFF	
N15	DN20	LEVEL SWITCH	120°	R1/2" MUFF	
N16	DN20	THERMOMETER	135°	R1/2" MUFF	
N17	DN50	BOTTOM OUTLET	180°	DIN2633	

THE VESSEL HAS NOT DESIGNED TO TAKE ANY UNDERPRESSURE

SÄILIÖ EI OLE SUUNNITELTU KESTÄMÄÄN ALIPAINETTA

SERIAL No / VALM. NRO 2343/06

FOR APPROVAL

Part No.	Drawing No.	Description	Dimensions	Qt.	Material	Remarks
25	p_31352	PLS/PIPE DN350	PLS	3	EN1.4301	
24		FLANGE/KAULUSL. DN350, PN10	DN350, DIN2632, PN10	3	EN1.4301	
23	250033120	PIPE/PUTKI 33.7x2.0	120	2	EN 1.4307	
22	304026010	MUFFLE/MUHVI R3/4		2	SS 2343	
21	250060120	PIPE/PUTKI 60.3x3.0	110	1	1.4301	
20	304060010	MUFFLE/MUHVI R 2		1	SS 2343	
19	p_31352	PLS	REINFORCEMENT PLAT	1	EN1.4301	
18	p_9205500	LIFT LUG/NOSTOK. 7700KG DIN2808		2	SS 2333	
17	651000160	ARMAFLEX/SOLIKUMI 13x100x8000		1		
16	p_31336	NAMEPLATE/NIMIKILPI PED		1	EN1.4307	
15	93010000	NAMEPLATE HOLDER/KILPITELINE		1	EN1.4307	
14	251026020	PIPE/PUTKI 26.9x2.6	105	1	SS 2343-23	
13	251026020	PIPE/PUTKI 26.9x2.6	102	5	SS 2343-23	
12	304021010	MUFFLE/MUHVI R1/2		6	SS 2343	
11	250060010	PIPE/PUTKI 60.3x2.0	1800	1	EN 1.4307	
10		CURVE/RÄYRÄ 60.3x2.0		1	EN1.4307	
9	250060010	PIPE/PUTKI 60.3x2.0	53	1	EN 1.4307	
8	501050110	FLANGE/KAULUSL. DN50 2633 PN16		1	316L	
7	p_31320	MANHOLE DN600 WITH DAVID	DN600	1	EN1.4301	
6	p_31352	PL10		1	1.4301	
5	350100110	FLAT BAR/LATTATANKO 6x100	1590	1	1.4301	
4	200060010	#PL 6.0x1500x3000 2B	1143x10977	1	EN 1.4307	
3		BOTTOM SS482, D=3500, S=8	D=3500, S=8	1	EN1.4301	
2		COVER SS482, D=3500, S=6	D=3500, S=6	1	EN1.4301	
1	p_31333	PLS	PLS	1	EN1.4307	

WELDING PROCESS : TIG-WELDING No 141
 FILLER MATERIAL : ESAB TIGROD 16.30
 GAS, SHIELDING : ARGON S (Ar 99.99%)
 GAS, BACKING : FORMIER AGAMIX NH12 (N2+12%H2)

WELDING PROCESS : PLASMA-WELDING No 15
 FILLER MATERIAL : ESAB AUTROD 16.32
 GAS, SHIELDING : ARGON S (Ar 99.99%)
 GAS, BACKING : AGAMIX H5 (Ar + 5%H2)
 GAS, BACKING : ARGON S (Ar 99.99%)

Mark	Field	Modification	Date	Des'd	App'd
B		ADDED NOZZLE N15 AND 12 PCS HOLES TO RING	2006-02-15	MS	

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Customer: ARLA FOODS AB VIMMERBY
 Scale: 1:20
 Des'd: MS
 App'd: [Signature]
 Date: 2006-02-07
 Drawing No: 060012
 Title: KALT VATTENTANK 50m³, POS.1
 Drawing No: A1- 31310
 Rev: B
 Work no: 060012/1