



- NOTES**
- 1 - 1" ON CIRC. = 0.31416"
 - 2 - ALL DIMENSIONS ARE IN INCHES [MILLIMETRES IN BRACKETS] TOLERANCE: COUPLING LOCATION +/- 1/16" FLANGE LOCATION +/- 1/8" HOLD DIMENSION +/- 1/16"
 - 3 - M.D.M.I. -20F. @ 100 PSI IMPACT TESTING IS EXEMPT PER US-20(1).
 - 4 - THIS VESSEL IS DESIGNED WITH SUPERIMPOSED STATIC, DYNAMIC, OR CYCLIC REACTIONS DUE TO EQUIPMENT OR MECHANICAL LOADING, OR PRESSURE OR THERMAL VARIATIONS = 0 LBS.
 - 5 - THIS VESSEL IS DESIGNED WITH THERMAL, MECHANICAL, CYCLICAL, PRESSURE, OR FLUID SHOCK LOADINGS = 0 LBS.
 - 6 - LUGS/SUPPORT MATERIAL: G40.21-44W.
 - 7 - WELDING PROCEDURE: CIL-WP-1.
 - 8 - MANWAY C.R.N.: #0H7379.5C
 - 9 - PIPE CAP MATERIAL: SA-234-WPB TO B16.9
 - 10 - COUPLING MATERIAL FOR "C20" TO BE SA-182-F304 TO B16.11
 - 11 - THIS VESSEL IS DESIGNED TO CONTAIN A NON-LETHAL GAS VAPOUR OR A NON-LETHAL LIQUID

DESIGN SPECIFICATIONS	
PRESSURE:	100 psi 689 kPa
TEMPERATURE:	650°F 343°C
PRESSURE (EXTERNAL):	0.0 psi
HYDROTEST PRESSURE:	130 psi 896 kPa
SHELL:	
MATERIAL:	SA-516-70
ALLOW. STRESS:	18800 psi
JOINT EFF.:	0.70
CRSN. ALLOW.:	0.125"
NOM. THKS.:	0.375"
HEAD:	
TYPE:	F&D
DISH. RAD:	30"
I.K.R.:	2-5/16"
MATERIAL:	SA-516-70
ALLOW. STRESS:	18800 psi
HEAD EFF.:	0.85
CRSN. ALLOW.:	0.125"
NOM. THKS.:	7/16"
MIN. THKS.:	0.375"
RADIOGRAPH:	NO
P.W.H.T.:	NO
AUTH. INSPECTOR:	YES
ASME SEC. VIII, DIV. 1:	2007
HEAT No. REQ'D:	YES
O.I./SER. No.:	
C.R.N.:	

DESIGN SPECIFICATIONS				BILL OF MATERIALS			
MANHOLE COVER:	SA-516-70	KEY	ITEM NO.	QTY	DESCRIPTION	DWG. NO.	
MANHOLE COLLAR:	SA-106-C	1		2	Head: 36" O.D. Flanged & Dished		
PIPE:	SA-106-B	2		1	Shell: 36" O.D. x 33-3/4" Wide		
COUPLING:	SA-105	A		1	Pipe: 10" Std. c/w (2) 10" Std. Pipe Cap		See Note 9
FLANGE:	SA-105	A.1		1	Pipe: 1-1/2" Sch.160 c/w M.N.P.T.		
REINF. PLATE:	N/A	C05		1	Coupling: 1" F.N.P.T. 3000# Half		
BOLT:	N/A	C08		1	Coupling: 2" F.N.P.T. 3000# Half		
STUD:	N/A	C16		1	Coupling: 3/4" F.N.P.T. 6000# Full		
NUT:	N/A	C20		2	Coupling: 2" F.N.P.T. 3000# Full (S.S.)		See Note 10
GASKET:	RED RUBBER	N03		1	Pipe: 3" Sch.80 c/w 150# R.F.W.N. Flange		
CAPACITIES		N04		1	Pipe: 4" Sch.80 c/w 150# R.F.W.N. Flange		Vent
VOLUME:	150 l.g.	LD		1	Pipe: 4" Sch.80 c/w 150# R.F.W.N. Flange		Loop Drain
	681 lts.	LL2		2	Lift Lug: 1/2" Thk.		
WEIGHT:	900 lbs. Empty	LG3		1	Skirt c/w Qty. 3, Base Plates		
	409 kg. Empty	M01		1	Manway c/w 600# Cover, Gasket & Yoke		
FINISH		NP		2	Nameplate		
INTERIOR:	AS WELDED						
EXTERIOR:	RED PRIMER						
TOLERANCES							
U.N.O.							
X"	± 1/2"						
X 1/2"	± 1/4"						
X 1/4"	± 1/8"						
X 1/8"	± 1/16"						
X 1/16"	± 1/16"						
MATERIAL SPECIFICATIONS							
Reference:							
This drawing supersedes drawing PB4694							
See drawing PA4820 for Base Layout							
REVISIONS							
MK	DESCRIPTION	BY	DATE				

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Clemmer PV
Pressure Vessel

A DIVISION OF CLEMMER STEELCRAFT TECHNOLOGIES INC., WATERLOO, ONTARIO

DESCRIPTION: 36" O.D. Vert. Blowdown Tank

CUSTOMER: Utilities Optimized

PROJECT:

ITEM NO.: BHR-36HM DRN.: RG Dec 03/07 SCALE: 1:15

JOB NO.: DWG. NO.: PB4817