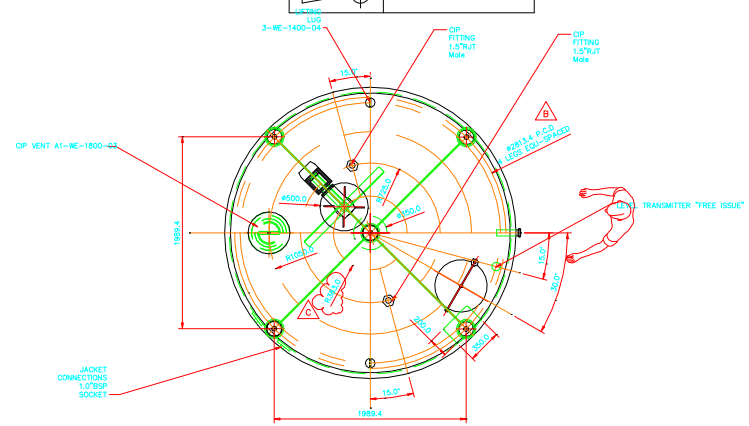
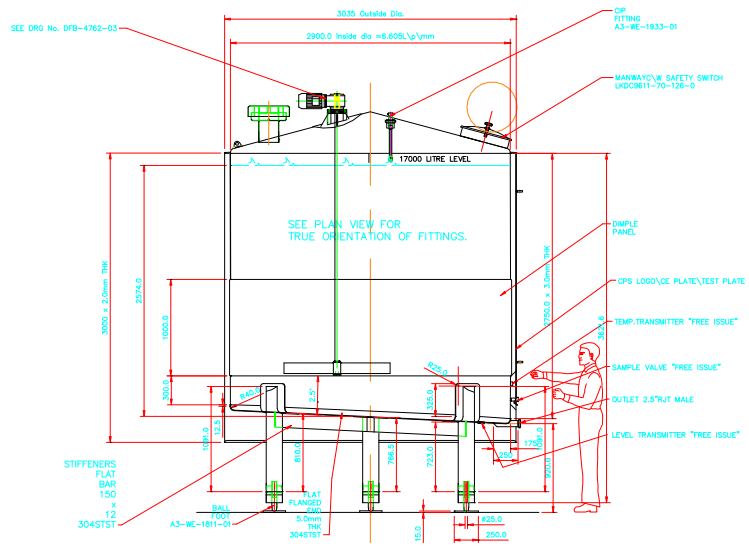
3RD. ANGLE PROJECTION



ACTUAL WEIGHT 2280 KGS



INSPECTION CHECK LIST	
DESCRIPTION	SIGNATURE
AGITATOR RUN	
VESSEL PRESSURE TEST	N/A
JACKET PRESSURE TEST	
VACUUM PRESSURE TEST	N/A
DYE PENETRANT TEST	
WATER FILL	
INTERNAL FINISH	
EXTERNAL FINISH	
DIMENSIONAL CHECK	
ORIENTATION	
TOTAL WEIGHT	

NOTES:–

1. VESSEL TO BE DESIGNED & MANUFACTURED TO SOUND ENGINEERING PRACTICE

FINISH:–

INNER–VESSEL BODY FINISH:–

1. INTERNAL FINISH TO BE 2B△ SHEET, 304 ST.ST. (SIDE 'A' OF SHEET) ALL INTERNAL WELDS GROUND AND POLISHED SMOOTH AND CREVICE FREE.
2. TOP CONE TO BE POLISHED BOTH SIDES

CLADDING FINISH:–

1. EXTERNAL FINISH TO BE DULL POLISHED <1.2 u Ra. SHEET, 304 ST.ST. (SIDE 'A' OF SHEET) ALL SEAM WELDS AS LAID DESCALED.(CUSTOMER TO INSPECT)

FITTINGS/LEGS:–

1. ALL FILLET WELDS TO BE LEFT NEAT AS LAID AND DESCALED
2. ALL BUTT WELDS PURGE & DESCALE
3. LEGS TO BE SCOTCHBRITE FINISH

REF.	DESCRIPTION	MATERIAL/STK No.	QTY
1	TOP CONE DRG.No DFB-4762-02	304STST	1

CPS
Carlisle Process Systems Ltd
Coldharbour Business Park
Sherborne
Dorset DT9 4JW UK
Tel: +44 (0) 01935 818800
Fax: +44 (0) 01935 818818
enquiries@carlisleuk.com
www.carlisleuk.com

CUSTOMER:– A.H.WARREN

TITLE:– LAYOUT 17000L MILK TANK

DRAWN BY:–	DATE:–	SCALE:–
K.G.H	31.01.06	1=20
No.OFF ONE	MACHINING SYMBOLS:–	FINISH:–

DWG.No:– DFB–4762–01 A1 REV:– c

REV.	ALTERATION	DATE	SIG.
C	AGITATOR POSITION CONFIRMED R383.0	22.02.06	K.H
B	LEG P.C.D ADDED.	17.02.06	K.H
A	INTERNAL SHEET FINISH WAS POLISHED.	02.02.06	K.H

LIMITS UNLESS OTHERWISE STATED

MACHINE TOLERANCES			
0.5 – 3.0mm	± 0.1mm	120.0 – 315.0mm	± 0.5mm
3.0 – 6.0mm	± 0.2mm	315.0 – 1000.0mm	± 0.8mm
6.0 – 30.0mm	± 0.3mm	1000.0 – 2000.0mm	± 1.0mm
30.0 – 120.0mm	± 0.5mm		

FABRICATION TOLERANCES	
120mm – 1000mm	± 2mm
1000mm – 2000mm	± 3mm
2000mm – 4000mm	± 4mm
4000mm – 8000mm	± 5mm
8000mm – ————	± 5.0mm

ANGULAR TOLERANCES BENDING		
10mm – 10mm	3°	±
10mm – 50mm	2°	±
50mm – 120mm	1°	±
120mm – 315mm	0.5°	±
315mm – ___mm	0.33°	±

PERPENDICULARITY (SQUARENESS)	
OVER 300mm	3.0mm

PARALLELISM	
OVER 600mm	3.6mm
OVER 1000mm	6.0mm

IF IN DOUBT ASK

REMOVE ALL BURRS & SHARP EDGES

This drawing and it's contents are Carlisle Process Systems Ltd.exclusive property and must not be copied reproduced,transmitted or communicated to any other party,or used for purposes not expressly permitted by us.