



No. 4 PICKLE TANK NOTES:

- ALL TANK AND DRIP PAN MATERIAL IS HIGH IMPACT, STRESS RELIEVED, VIRGIN, HEAT STABILIZED, GRAY COLOR COPOLYMER POLYPROPYLENE UNLESS NOTED OTHERWISE. THE TANK BODY, ENDWALLS, AND RIM ARE 40 mm THICK. THE RIBS ARE 25 AND 40 mm THICK. THE DRIP PAN IS 20 mm THICK. STEEL TANK REINFORCEMENTS ARE HOLLOW STRUCTURAL SECTIONS (HSS) IN ACCORDANCE WITH ASTM A500 GR B, OR EQUAL. ALL COVER MATERIAL IS GRAY PPS SOLID FLAME RETARDANT POLYPROPYLENE UNLESS NOTED OTHERWISE. THE COVER DECKS ARE 20 mm THICK AND RIBS ARE 25 mm THICK.
 - SERVICE CONDITIONS: STEEL STRIP PICKLING WITH HYDROCHLORIC ACID @ 95°C (203°F) MAXIMUM. TURBULENT SPRAY AND SPRAY BAR PRESSURE TO BE 3 BAR (40 PSIG) MAXIMUM.
 - APPROXIMATE TANK VOLUME = 26m³
 - APPROXIMATE WEIGHTS: No. 4 PICKLE TANK = 14,170 kgs. (31,230 lbs.). (EMPTY AND EXCLUDING COVERS AND GRANITES). COVER WEIGHTS ARE AS NOTED.
 - CAP ALL EXTRUSION WELDED CORNER JOINTS WITH 40 mm SQUARE CORNER REINFORCEMENTS.
 - SOME HIDDEN LINES WERE OMITTED FOR CLARITY.
 - ALL DIMENSIONS SHOWN APPLY TO A MANUFACTURING TEMPERATURE OF 20°C (68°F) AMBIENT (NON-EXPANDED) UNLESS NOTED OTHERWISE.
 - FULL BOTTOM SUPPORT IS REQUIRED FOR THIS TANK.
-
- USE A LIFT BEAM TO LIFT TANK TO ENSURE VERTICAL LIFT AT PICK-UP POINTS. NON-VERTICAL LIFTING AT PICK-UP POINTS IS NOT RECOMMENDED.
 - SHAPE TECHNOLOGY SUPERNOZZLES AND ALL PIPE FLANGE CONNECTIONS TO BE IN ACCORDANCE WITH DIN 2501 PN10 FLAT FACE TYPE, UNLESS NOTED. ALL BOLT HOLES ARE TO BE SYMMETRICALLY STRADDLE THE FLANGE CENTERLINES, UNLESS NOTED.
 - DUE TO THERMAL EXPANSION, ALL PIPING CONNECTIONS TO POLYPROPYLENE TANKS REQUIRE EXPANSION JOINTS OR EXPANSION LOOPS. EXPANSION JOINTS ARE NOT SUPPLIED BY SHAPE TECHNOLOGY. VALVES AND PIPING SHOULD NOT BE SUPPORTED BY POLYPROPYLENE EQUIPMENT UNLESS APPROVED BY SHAPE TECHNOLOGY ENGINEERING DEPARTMENT. MAXIMUM ALLOWABLE NOZZLE LOADINGS ARE SHOWN IN THE TABLE.
 - WELD THE CENTER (6) TANK RIBS TO THE DRIP PAN WHERE POSSIBLE WITH 6HB OR 6BE.

DIN 2501 PN 10 CLASS-FLANGE TABLE					
DN SIZE	OUTSIDE DIAMETER	FLANGE THICKNESS	DIA BOLT CIRCLE	QTY. OF BOLT HOLES	DIA OF BOLT HOLE
DN15	95	16	65	4	14
DN25	115	16	85	4	14
DN32	140	20	100	4	18
DN40	150	20	110	4	18
DN50	165	20	125	4	18
DN80	200	25	160	8	18
DN100	220	30	180	8	18
DN125	250	32	210	8	18
DN150	285	32	240	8	22
DN200	340	38	295	8	22
DN250	395	38	350	12	22
DN300	445	38	400	12	22
DN350	505	38	460	16	22
DN400	565	38	515	16	26

NOTE: FLANGE O.D. FOR SHAPE TECHNOLOGY STANDARD NOZZLE
BLANKS MAY DIFFER FROM ABOVE TO ACCOMMODATE
ANSI, DIN AND JIS DRILLING PATTERNS.

3	CHG PICKLE TANK EXIT SECTION (200-4866A)	2007-MAY-07	TWK	
2	CHG STEERING ROLLS TO 1900 CTR'S & ELIMINATE ROLL STAGGER	2007-MAY-03	RBG	
1	DELETE NOTE 9 & ADD GRANITE SHIM MK No's	2006-DEC-05	RBG	
Revision	Drawn by	Modification contents	Date	Prepared by
2	RBG	2006-DEC-05	RBG	2006-DEC-05
The contents of this sheet is copyright property of VSEI-ALPINE Industrietechnik GmbH & Co. The sheet was handed over to the receiver for personal use only and without written permission of VSEI-ALPINE Industrietechnik GmbH & Co. it must not be reproduced or made available to any third parties. Any infringement will be prosecuted.				
Содержание данного листа является интеллектуальной собственностью фирмы ВЕСТ-АЛЬПИНЕ. Лист передан получателю только для личного пользования. Без письменного разрешения от фирмы ВЕСТ-АЛЬПИНЕ воспроизведение, копирование, распространение и использование в любых целях без разрешения фирмы ВЕСТ-АЛЬПИНЕ является нарушением. Любое нарушение будет преследоваться.				
Title: CONTIN. PICKLING LINE / АГРЕГАТ НЕПРЕРЫВНОГО ТРАВЛЕНИЯ				
Machine: GA-PICKLE TANK No. 4				
Equipment subgroup: GA-ВАННА ТРАВЛЕНИЯ No. 4				
ZPL.KC14.256114-M1000/ZSZ				
Scale: 1:50				
Material: VAI				
Sheet: 1 of 2				
Customer: ZSZ				