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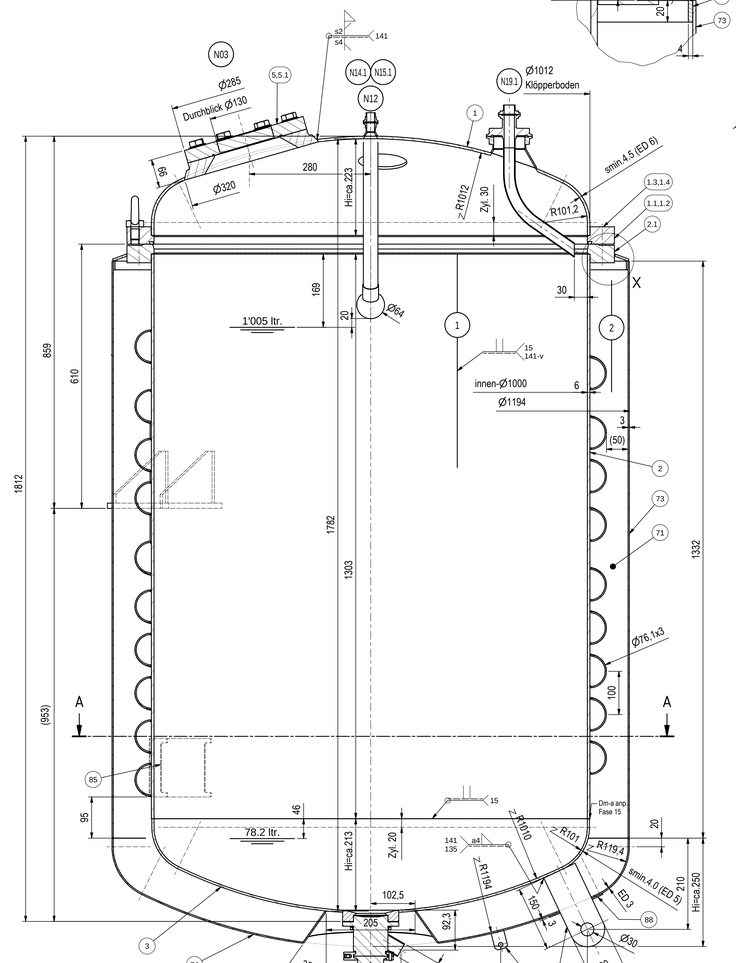
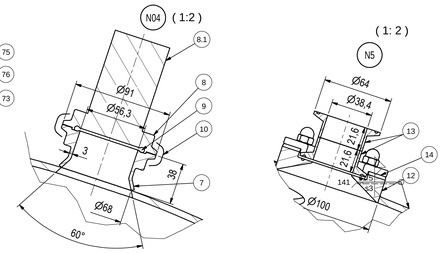
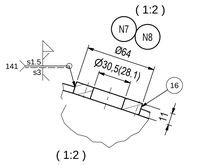
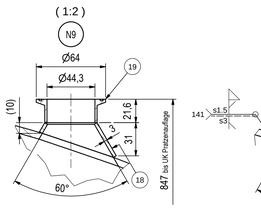
Pratzen- und Stutzenstellung nach Grundriss

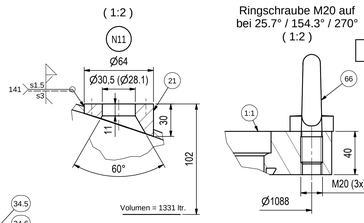
Stückliste / Parts list	027606
Benennung / Name	Nummer / Number
Dazugehörige Unterlagen / Additional Documents	

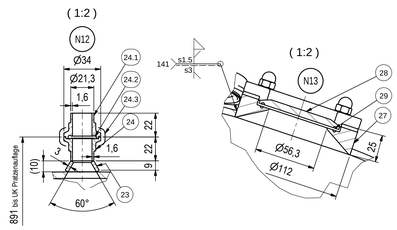


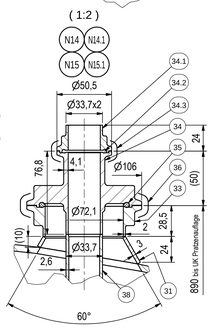


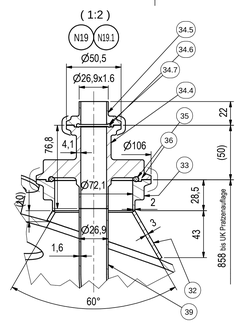


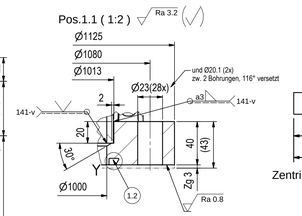


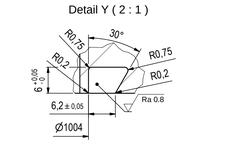


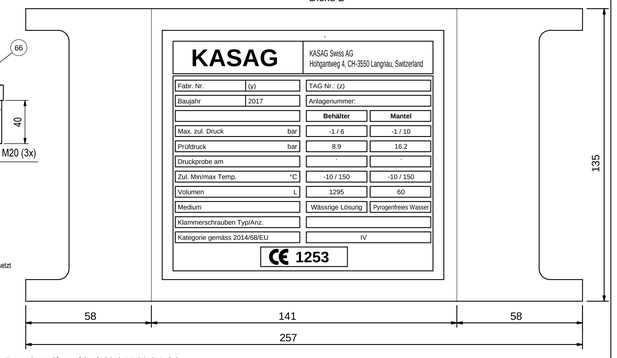


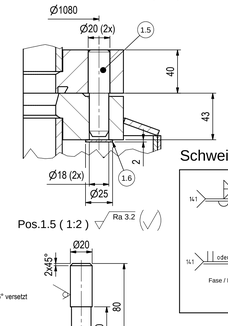












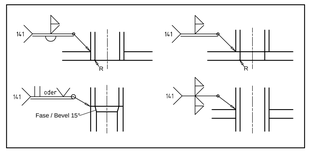
	y =	z =
	A102663-303	1B4300
	A102663-503	1B4600
	A102663-703	1B4910

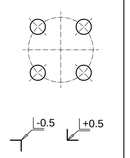
Schweissangaben:
Zusatzwerkstoffe:
- Produktberührt CN 20/25 und am Produkt- Mantel / Kl. Böden angeschw. Teile
- Alle übrigen Thermanit GE316L
- Nicht bezeichnete Schweissnähte 141

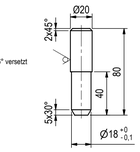
Ferritgehalt: produktberührt
- Grundwerkstoff <3%
- Schweissnähte <3%

Schweissnähte Stutzen / Weld seams nozzle

Achsen lochfrei!







Havariegewicht = 1990 kg

		innen / inside	aussen / outside
Schweissnähte	Welding seams	geschliffen Ra < 0.6 µm	gemäss Blatt: Oberfläche der Schweissnähte aussen
Blech	Sheet	geschliffen Ra < 0.6 µm	geschliffen Ra < 1.2 µm
Beizen / Passivieren	Pickling / Passivate	Nein	Nur die Schweissnähte
C-Teile	Unalloyed parts		

Oberfläche / Surface

Behälter	Vessels	DIN 28005-1
Schweisskonstruktionen	Welded constructions	EN ISO 13920-BH
Mechanisch bearbeitete Teile	Machined parts	ISO 2768-mK
Längenmasse für Halbzeuge	Linear measurements for semi-finished material	ISO 2768-C

Toleranzen / Tolerances

Auslegungs- und Betriebsdaten / Design and operating data

Berechnungsvorschrift / Regelwerk	Calculation regulation / code		AD-2000 / SIA 261 Erdbebenzone 1	
Entwurfsprüfung	Design test		Swiss TS	
Bau- und Druckprüfung	Construction- and pressure test		Swiss TS	
Schweissnahtvorbereitung	Preparation of welds		EN 1708-1	
Qualitätsstufe nach EN ISO 5817	Quality level according EN ISO 5817		Standard B	
Aufstellungsland	Installation country		Schweiz	
Raum	Chamber	Innen / In der Rohren / Inside / In the pipes	Aussen / Um die Rohre / Outside / Around the pipes	
Medium	Medium	Aqueous solution	Pyrogen free water	
Mediumeigenschaft 1=gefährlich 2=andere	Properties of fluid 1=dangerous 2=others	1	2	
Mediumzustand 1=gasförmig oder flüssig 2=flüssig	Condition of fluid 1=gaseous or liquid 2=liquid	1	1	
Volumen brutto	Volume gross	ltr.	1295	60
Min./ max. zulässige Temperatur	Min./ max. permissible temperature	°C	-10 / 150	-10 / 150
Berechnungstemperatur	Design temperature	°C	-10 / 150	-10 / 150
Min./ max. zulässiger Druck	Min./ max. permissible pressure	bar	-1 / 6	-1 / 10
Berechnungsdruck	Design pressure	bar	-1 / 6	-1 / 10
Prüfdruck	Test pressure	bar	8.9	16.2
Dichte	Density	kg/m³	1200	1000
Druckgeräterichtlinie 2014/68/EU	Pressure Equipment Directive 2014/68/EU			
Kategorie I II III IV	Category I II III IV		IV	
Modul A A2 B+F; B+C2 B+F; G	Modul A A2 B+F; B+C2 B+F; G		B+F	
Korrosionszuschlag	Corrosions allowance	mm	0	
Schweissnahtfaktor	Welding seam factor		0.85	
Nicht bemasste Kehlnähte	Non- dimensioned fillet welds	mm	a = 0.7 x s min; a min = 2 mm	
Gewicht Druckbehälter (leer)	Weight of pressure vessel (empty)	kg	720	
Lastspielzahl	Load cycles		≤ 32'000 (-1 bis 2.1 bar bei 0 bis 135°C)	
Werkstoff	Material			
Produktberührte Teile	Product contacted parts		1.4539 / 2.4602 / EPDM	
Doppelmantel	Jacket		1.4404 / 1.4435	
Übrige Teile	Other parts		1.4301 / 1.4404	
Isoliermaterial	Insulating material		Mineralwolle (Fabrikat ISOVER) gemäss AGI Q132	

ZFP / NDT Stichprobenprüfung / Random inspection

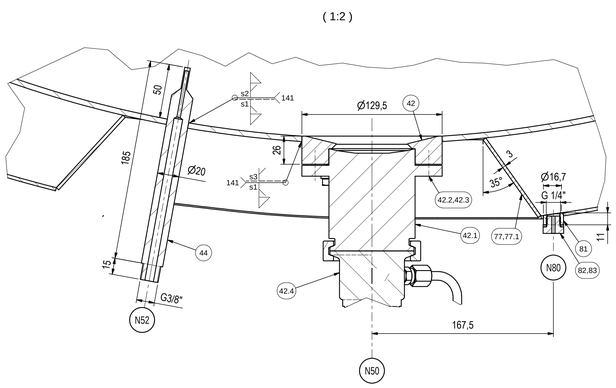
Prüfungsart	Test type	RT / x-ray	PT	VT	Fermt
Längsnähte	Longitudinal weld seams	% 100	10	100	-
Rundnähte	Circumferential weld seams	% 25	10	100	-
Stosssteden	Butt joint seams	% 100	-	100	-
Stutzennähte	Nozzle weld seams	% -	10	100	-
Kehlnähte	Fillet weld seams	% -	10	100	-
Grundmaterial	Basic material	%			

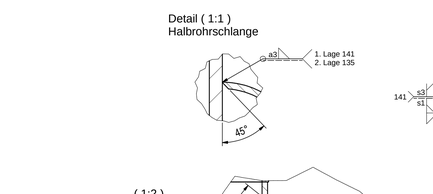
Technische Daten / Technical data

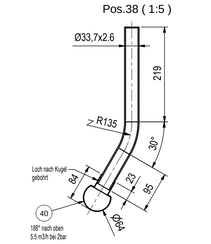
N80	1	G 1/4"	-	-	Test socket insulation	S-E-AT 0149
N65	1	20 (ISO)	40	EN 1092-1, 11, B1	Inlet tempering media	WN-Flange
N64	1	20 (ISO)	40	EN 1092-1, 11, B1	Outlet tempering media	WN-Flange
N59	1	B50	-	BioControl	Spare (Conductivity)	S-E-AT 0142
N58	1	G1 1/4"	-	Ingold Ø25 H7	Spare (pH)	S-E-AT 0330
N55	1	40 (ISO)	-	TC-Connect, ISO 2852	Sampling (9 port)	S-E-AT 0304
N52	1	G 3/8"	-	Thermowell TM411	Temperature measurement	S-E-AT 0352
N50.1	1	25 (ISO)	-	DIN 11866-B	Product outlet	S-E-AT 0318
N50	1	25	6	Südmo SVP A386 D-E 30°	Bottom outlet	S-E-AT 0318
N19.1	1	20 (ISO)	40	DIN 11864-3-A (BKS)	Inlet pipe (J-tube)	S-E-AT 0349
N19	1	65 (ISO)	16	DIN 11864-3-A (BKS)	Inlet pipe (Vessel connection)	S-E-AT 0349
N15.1	1	25 (ISO)	40	DIN 11864-3-A (BKS)	CIP 2	S-E-AT 0350
N15	1	65 (ISO)	16	DIN 11864-3-A (BKS)	CIP 2 (Vessel connection)	S-E-AT 0350
N14.1	1	25 (ISO)	40	DIN 11864-3-A (BKS)	CIP 1	S-E-AT 0350
N14	1	65 (ISO)	16	DIN 11864-3-A (BKS)	CIP 1 (Vessel connection)	S-E-AT 0350
N13	1	50 (ISO)	-	TC-Connect, ISO 2852	Spare port	-
N12	1	15 (ISO)	40	DIN 11864-3-A (BKS)	Ventilation	-
N11	1	B25	-	BioControl	Level switch	S-E-AT 0142
N09	1	40 (ISO)	16	DIN 32676	Filling level	-
N08	1	B25	-	BioControl	Pressure probe	S-E-AT 0143
N07	1	B25	-	BioControl	Pressure gauge	S-E-AT 0143
N05	1	32 (ISO)	-	TC-Connect, ISO 2852	Rupture disc	S-E-AT 0125
N04	1	50 (ISO)	25	DIN 11864-3-A (BKS)	Sight glass with light	S-E-AT 0348
N03	1	150	16	Aseptic block flange	Sight glass	S-E-AT 0106
N01						

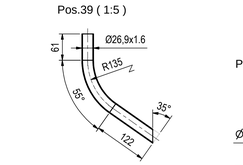
Kennz. Index	Anz. Quant.	DN	PN	Typ Type	Benennung Name	Bemerkung Remarks

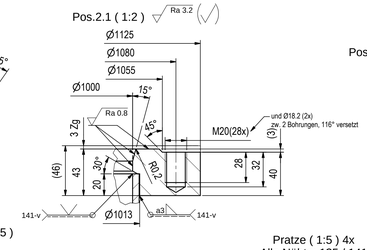
Stutzentabelle / Nozzle table

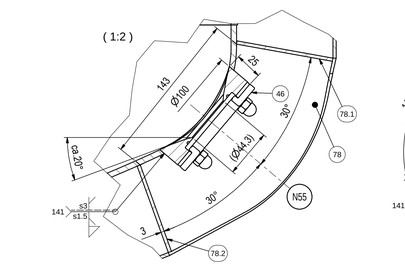


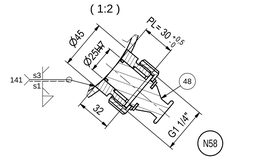


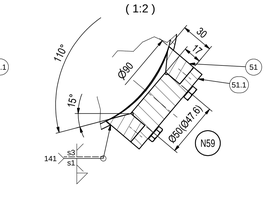


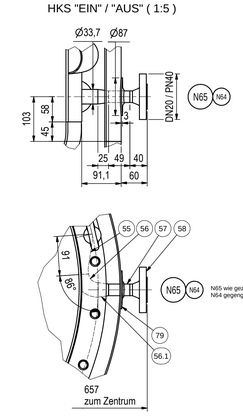


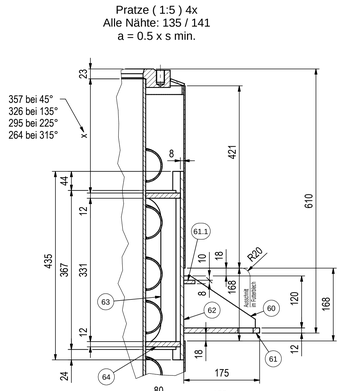




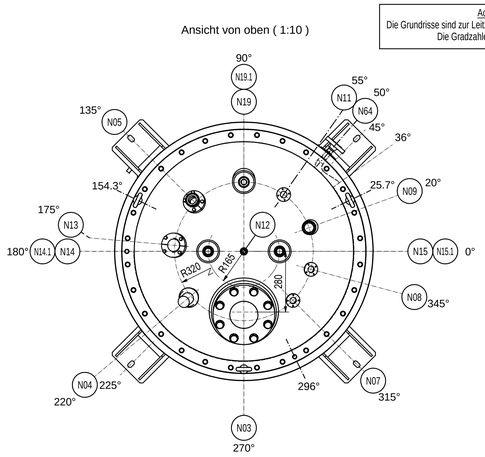


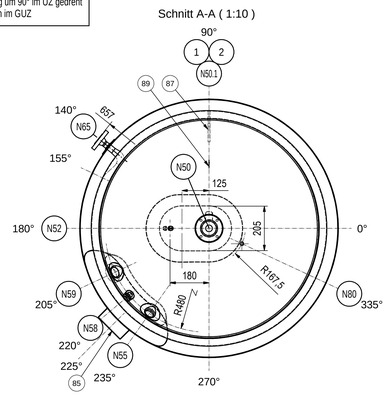


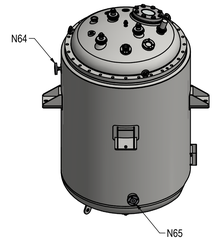




Achtung:
Die Grundrisse sind zur Leitzeichnung um 90° im UZ gedreht
Die Gradzahlen steigen im GUZ







a	Diverse Änderungen gemäss Kunde	29.08.2017	gz	27.06.2017	Q.Zuffig
b	Diverse Änderungen gemäss Kunde	20.09.2017	mg		
c					
d					
e					

Änderungen / Modifications

Gezeichnet / Drawn: gz
Geprüft / Checked: mg
Freigegeben / Released:
Ersatz für / Replaced:
Ersetzt durch / Superseded by:
Projekt-Nr. / Project-No.:
Kundenauftrag-Nr. / Order-No.: A102663
Kunde / Client: CSL Lengnau AG, Lengnau
Part of:

Massstab / Scale: 1:5 | 1:10 | 1:2 / 1:1
A0

KASAG Swiss AG
CH-3550 Langnau

Benennung / Name: Buffer Hold Vessel 1'000 ltr. 1B4300 / 1B4600 / 1B4910

Zeichnungs-Nr. / Drawing No.: E 11048

Index: b