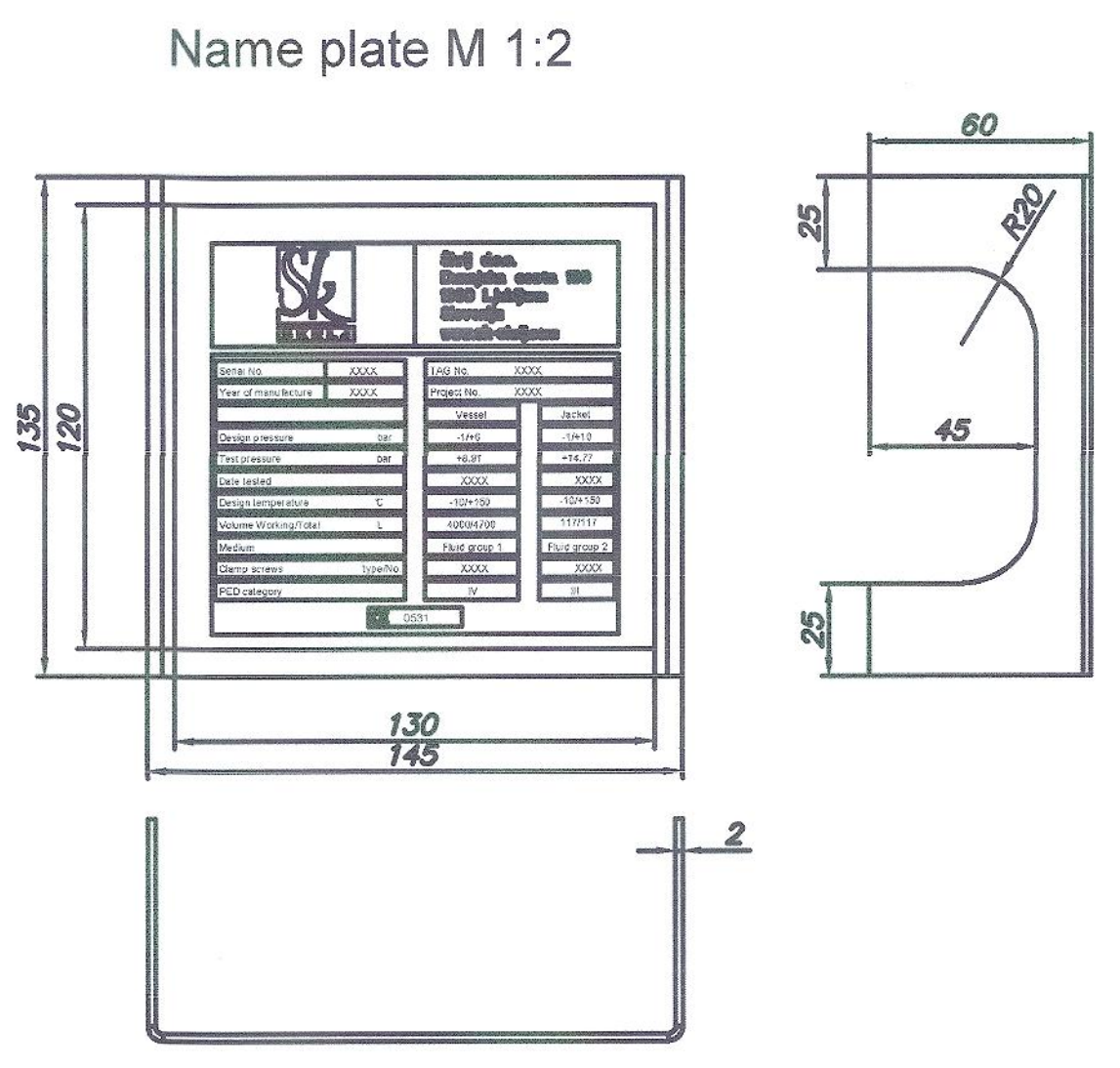
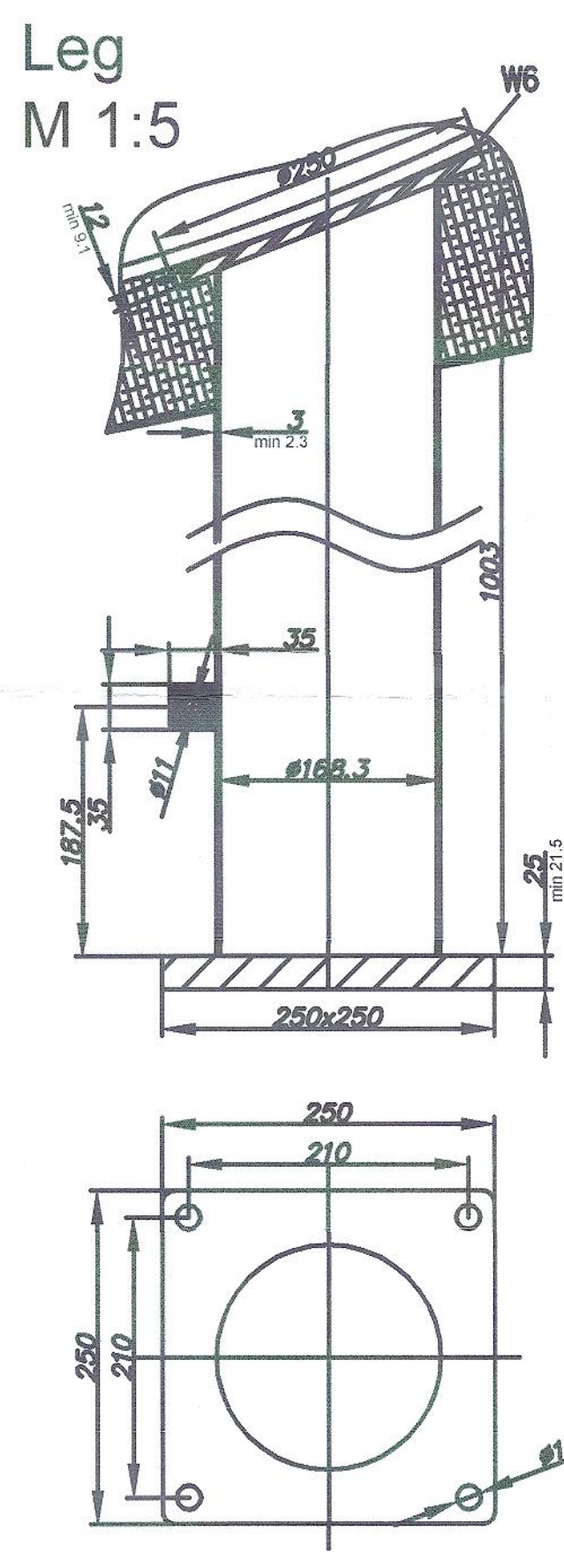


Detail A:

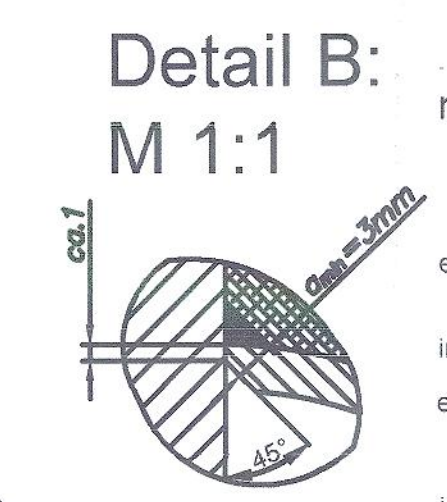


No.	Description	Item	Material	Quantity	Material
001	Test socket insulation	Supplier standard	scotch brite Disc	1	W.Nr.1.4301
002	Inlet tempering nozzle	DN 100-3 21	cobalt work Steg	1	W.Nr.1.4571
003	Outlet tempering nozzle	DN 100-3 21	cobalt work Steg	1	W.Nr.1.4571
004	Spare	DN 100-3 21	flange flanged	1	W.Nr.1.4530
005	Spare	DN 100-3 21	flange flanged	1	W.Nr.1.4530
006	Sampling	flange	flange	1	W.Nr.1.4530
007	Temperature measurement	flange	flange	1	W.Nr.1.4530
008	Bottom outlet	flange	flange	1	W.Nr.1.4530
009	Inlet pipe	DN 100-3 21	flange flanged	1	W.Nr.1.4530
010	Inlet pipe (tube)	DN 100-3 21	flange flanged	1	W.Nr.1.4530
011	Cl. Inlet 3	DN 100-3 21	flange flanged	1	W.Nr.1.4530
012	Cl. Inlet 2	DN 100-3 21	flange flanged	1	W.Nr.1.4530
013	Cl. Inlet 1	DN 100-3 21	flange flanged	1	W.Nr.1.4530
014	CIP 1	DN 100-3 21	flange flanged	1	W.Nr.1.4530
015	CIP 2	DN 100-3 21	flange flanged	1	W.Nr.1.4530
016	CIP 3	DN 100-3 21	flange flanged	1	W.Nr.1.4530
017	Spare part	DN 100-3 21	flange flanged	1	W.Nr.1.4530
018	Ventilation	DN 100-3 21	flange flanged	1	W.Nr.1.4530
019	Level switch	flange	flange	1	W.Nr.1.4530
020	Filling level	flange	flange	1	W.Nr.1.4530
021	Pressure probe	flange	flange	1	W.Nr.1.4530
022	Pressure gauge	flange	flange	1	W.Nr.1.4530
023	Rupture disc	flange	flange	1	W.Nr.1.4530
024	Sight glass with light	flange	flange	1	W.Nr.1.4530
025	Sight glass	flange	flange	1	W.Nr.1.4530
026	Manhole	flange	flange	1	W.Nr.1.4530

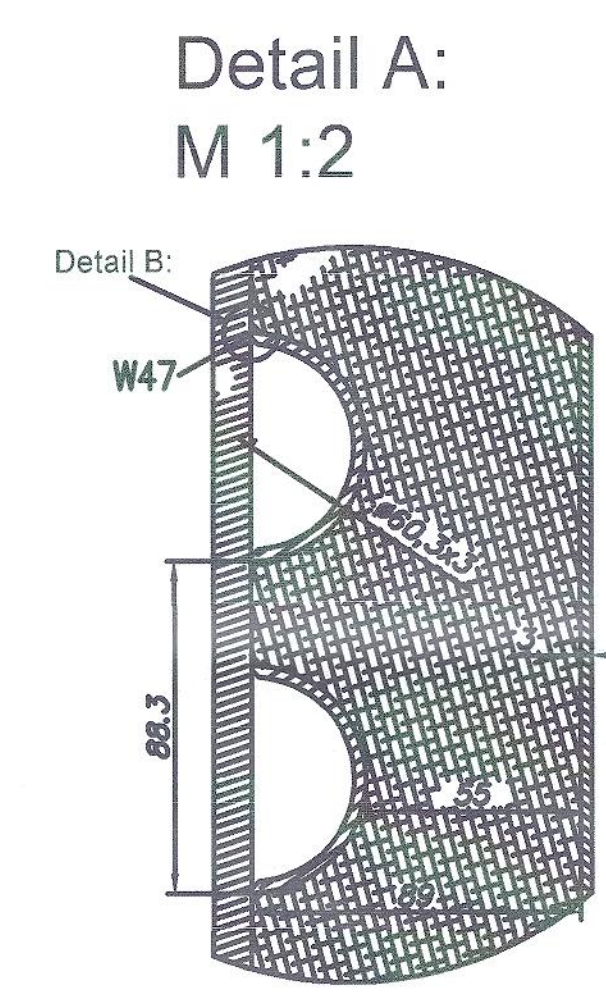
WEISSFREIGABE
 Überprüfung der Einarbeitung von Handeinträgungen aus der AFC Freigabezeichnung vom 29.09.2017, Revision 1.
 Alle Anpassungen wurden ordnungsgemäß übernommen.
 Geprüft M+W: 08.10.17
 Genehmigt M+W: 06.10.2017/CSL/FR 12.10.17



Leg
M 1:5

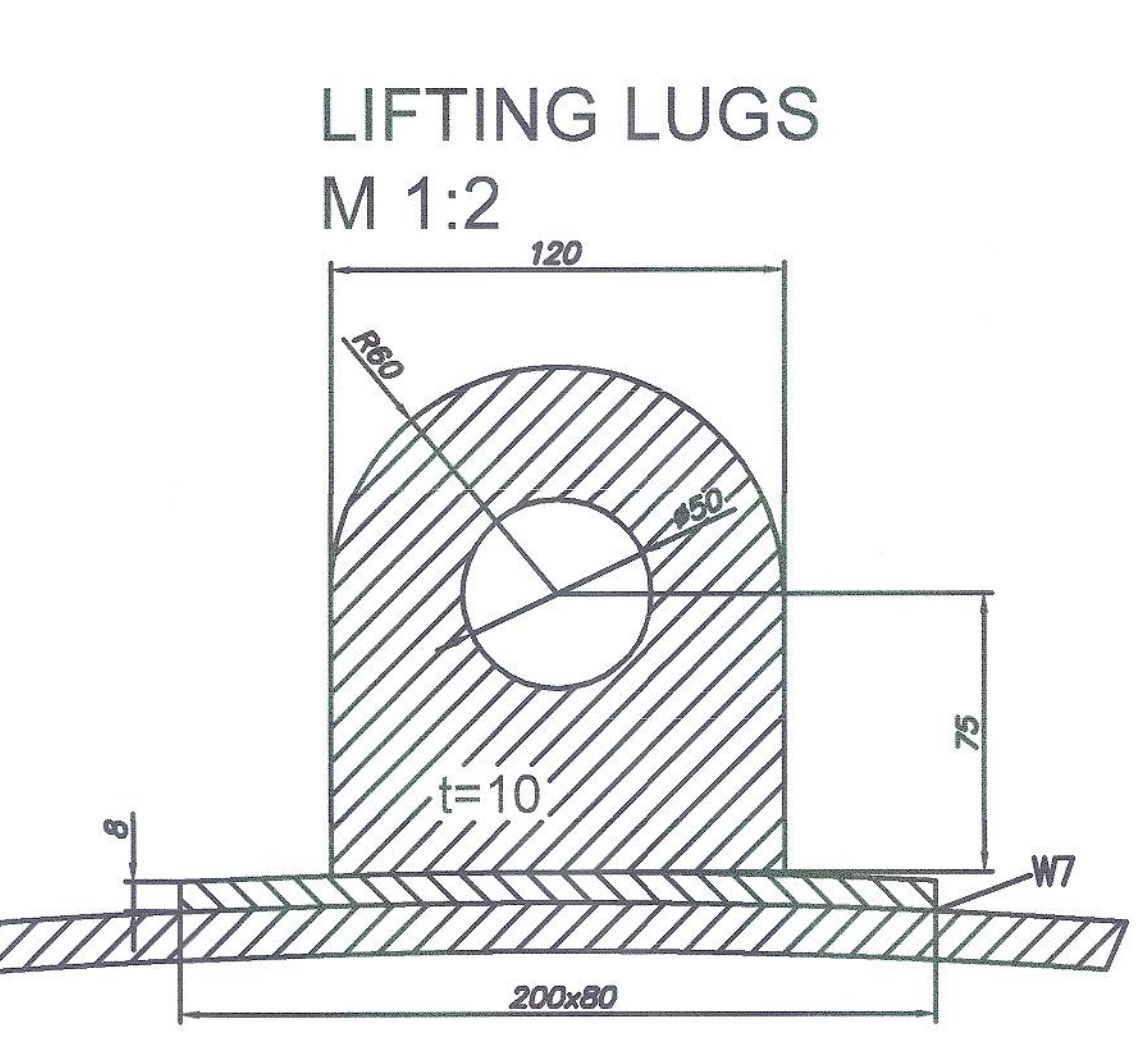
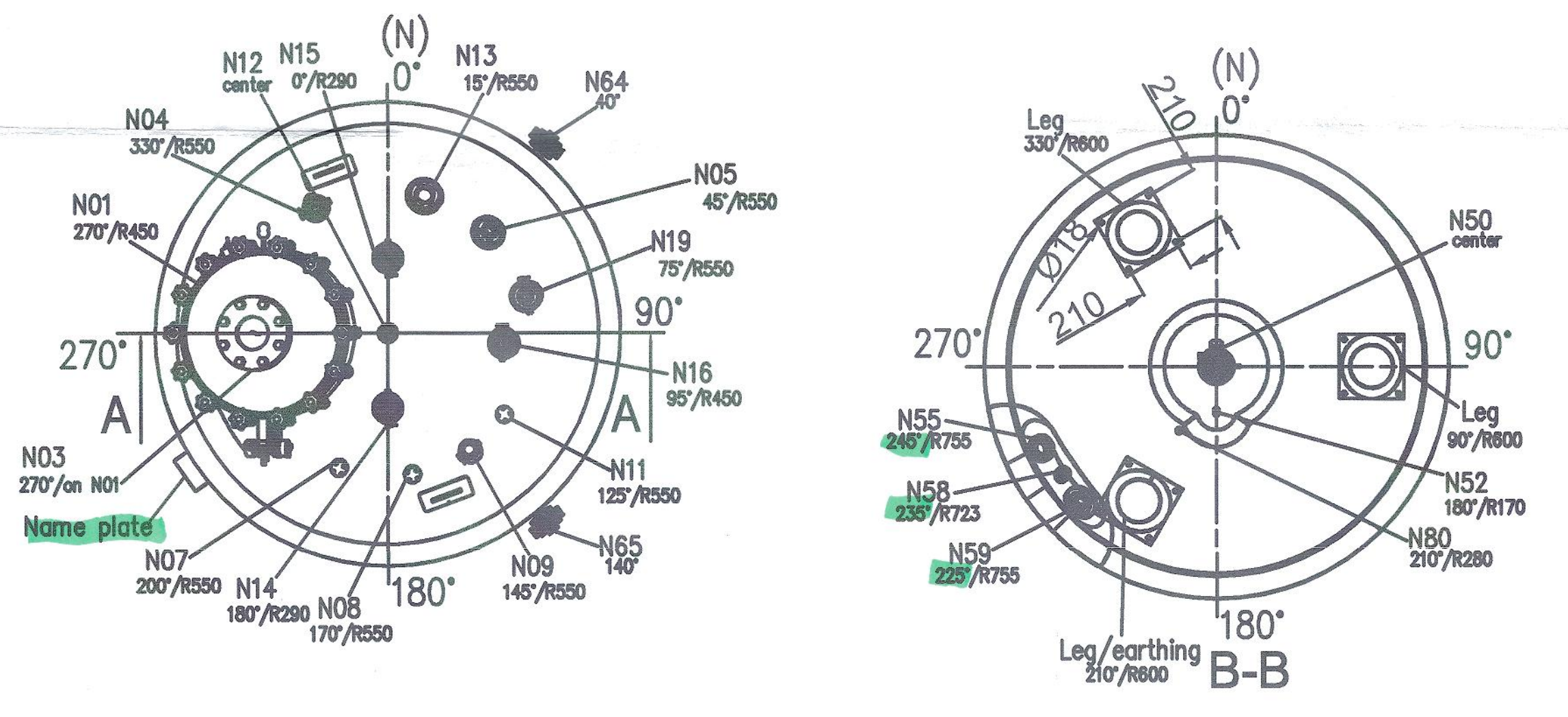


Detail B:
M 1:1

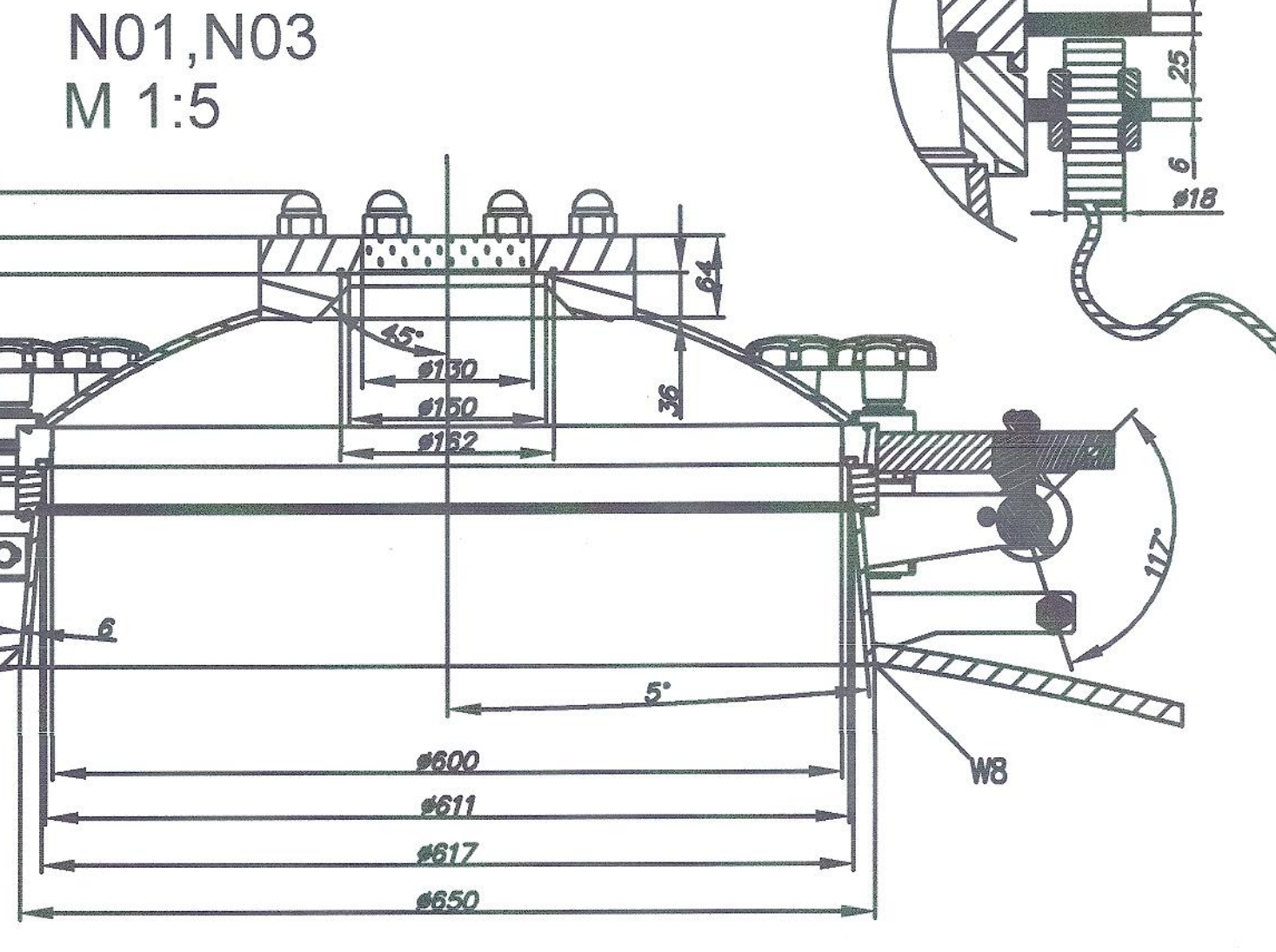


Detail A:
M 1:2

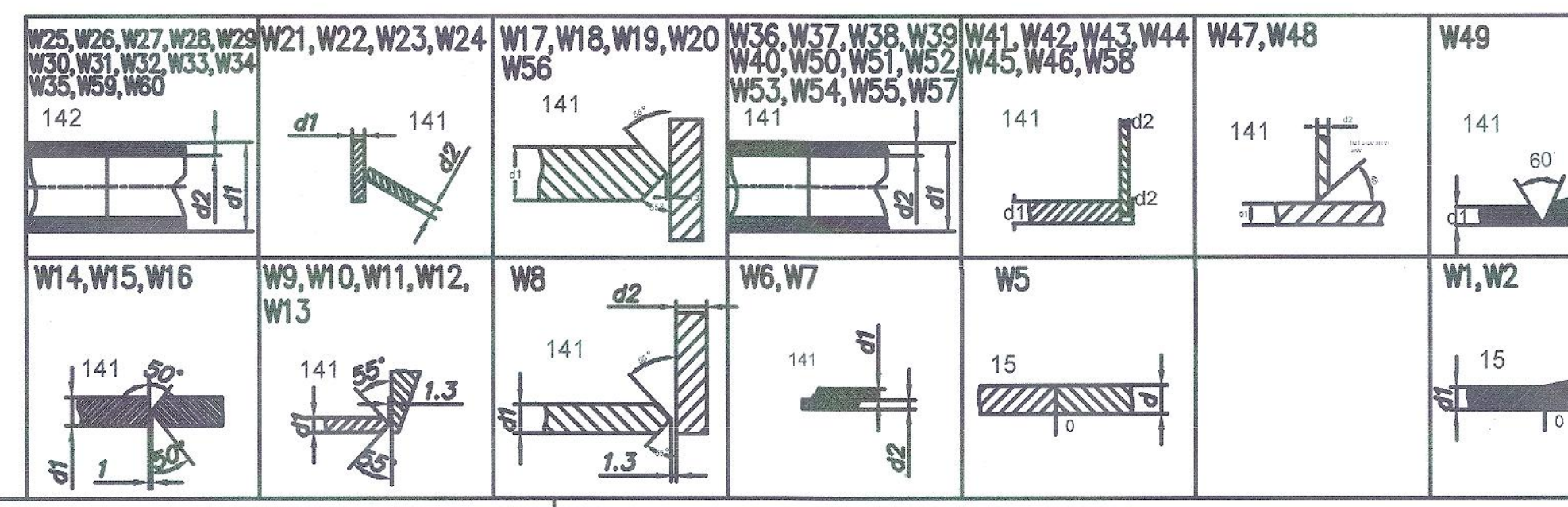
material non product contacted parts: W.Nr. 1.4301
 external surface finishing: bottom, tank wall and lid scotch brite (SB); Ra<1,2µm
 internal product contact surface finishing: brushed, certified roughness Ra<0,6 µm 100% of the surface
 external welds finishing: cleaned and mechanically polished and passivated, weld structure is visible, Ra<1,2µm, roughness of the weld surface is not inspected.
 internal product contact welds finishing: butt welds flat brushed (K220), certified roughness 100% Ra<0,6 µm, corner welds brushed (K220), certified roughness 100% Ra<0,6 µm
 6-ferte content for all materials <3% and welding seams <= 3 %



LIFTING LUGS
M 1:2

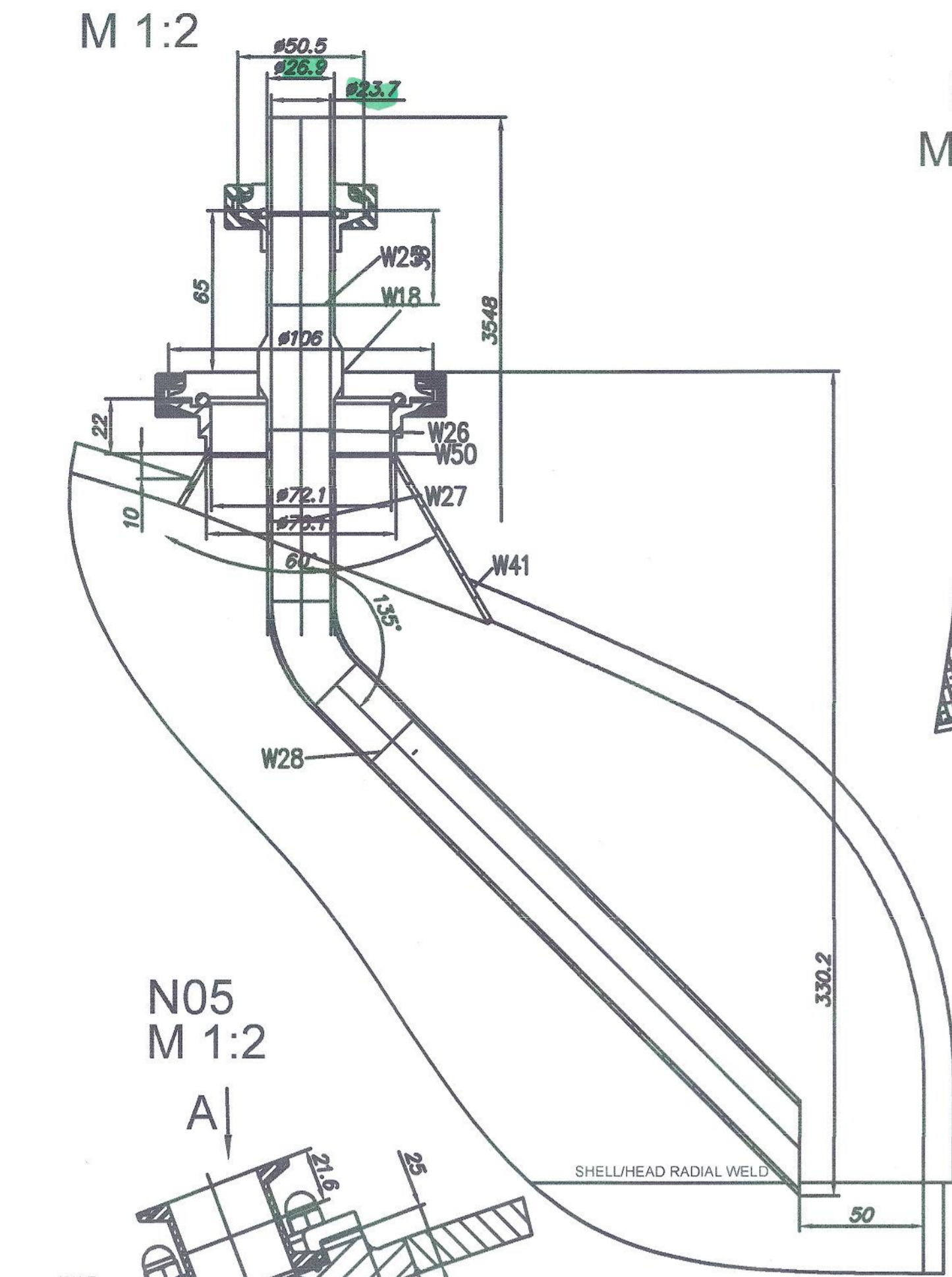


N01, N03
M 1:5

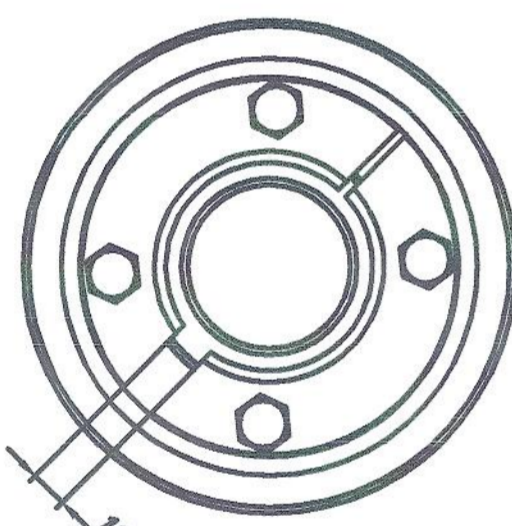
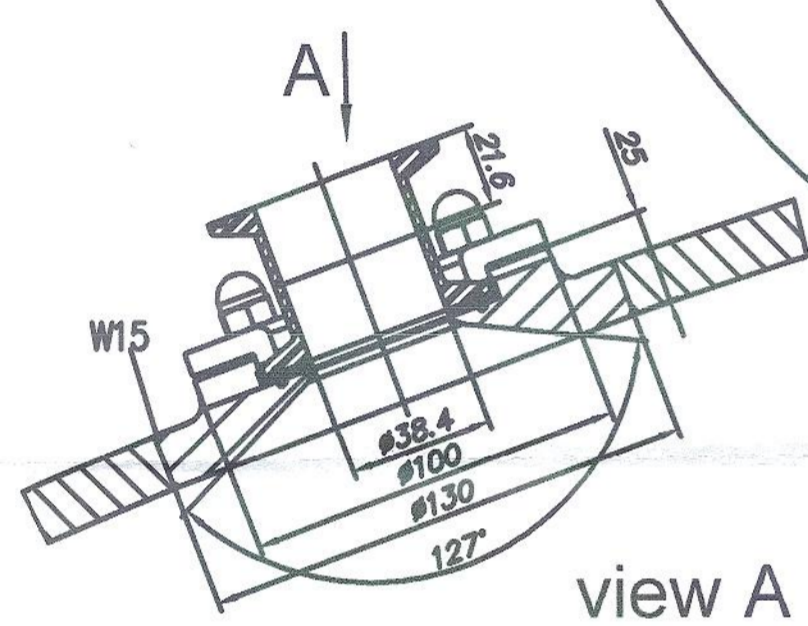


SURFACE DATA VERFAHRENDATEN	INSIDE	OUTSIDE	
	ROUGHNESS Ra (µm)	<0,6	<1,2
WORKING PROCESS	brushed	scotch brite	
REMARKS			
WELDING DATA SCHWEIßDATEN	SHELL	JACKET	
	WELDING PROCESS	TIG-141/TIG-142 PAW-15	TIG-141/TIG-142 PAW-15
MATERIAL OF WELDING WIRE	Ø1	Ø1	
WELDER'S CERTIFICATE	SIST EN 9808-1,14732	SIST EN 9808-1,14732	
METHOD OF THE WELDED JOINTS TESTING	radiographic	radiographic	
Penetration test – product contact welds (%)	100	10 100(VT)	
CROSS WELDS TEST	100	100	
LONGITUDINAL WELDS TEST	100	10	
CIRCUMFERENTIAL WELDS TEST	25	10	
STANDARD: AD2000; SR 930.114; 2014/68/EU (PED)	SHELL	JACKET	
MATERIAL DATA BENUTZMATERIAL	W.Nr.1.4530	W.Nr.1.4571	
	SEALS	Olyon Eto Pro USP/Polysulfid	
SIGHT GLASS	Borosilicate acc. to DIN 7080		
SCREWS,NUTS	A2-70/A2-70		
INSULATION	mineralwool (ISOVER) acc.AG/0132		
DESIGN AND WORKING DATA KONSTRUKTIONS- UND BETRIEBSDATEN	REMARKS/BEMERKUNGEN	PRODUKTRAUM SHELL	HEIZMANTEL JACKET
	STANDARD: AD2000; SR 930.114; 2014/68/EU (PED)		
	DESIGN PRESSURE/AUSLEGUNGSDRUCK (bar(g))	-1/8	-1/10
	OPERATION PRESSURE/BETRIEBSDRUCK (bar(g))	tbid	tbid
	TEST PRESSURE/TESTDRUCK (bar(g))	6,91	14,77
	DESIGN TEMPERATURE/AUSLEGUNGSTEMPERATUR (°C)	-10/+150	-10/+150
	OPERATION TEMPERATURE/BETRIEBSTEMPERATUR (°C)	tbid	tbid
	TOTAL VOLUME/NENN-VOLUMEN (L)	4700	117
	WORKING VOLUME (L)	4000	117
	NUMBER OF LOAD CYCLES/LASTWECHSEL ZAHL (N)	8000	8000
	MEDIUM	Fluid group 1	Fluid group 2
	MEDIUM DENSITY/MEDIUMDICHTHE (kg/m³)	1200	1000
TOTAL VESSEL WEIGHT/TOTAL GEWICHT (kg)		1961	
EFFECTIVE HEATING SURFACE (m²)		3,2	
PERMISSIBLE DESIGN STRESS LEVEL IN JOINTS	v=0,85		
VESSEL CLASSIFICATION – TEST GROUP	IV	III	
REMARKS	PED modul H1	PED modul H	
VESSEL DATA BETÄTLER DATEN	NAME	BUFFER HOLD VESSEL 4000L 1B4900	
	TYPE	Vertical pressure vessel	
	DESCRIPTION	FORM	Cylindrical with torispherical end
	BESCHREIBUNG	SITUATION	Vertical
	DESTINATION	Pressure vessel	
	SEISMIC ZONE	SIA 261 – Zone 1	
SERIAL NUMBER	xxxxxxxx		
CLIENT/KUNDE	CSL BEHRING AG		
PRODUCER/HERSTELLER	SKRL J d.o.o.		
YEAR OF PRODUCTION/TEST	2018/01-2018		
REMARKS/BEMERKUNGEN			
DIN ISO 2768-1:m	Material EN:1.4530/A571/A501	Scale M1:20	Mass-kg/piece 1961
Date	Name	Signature	Title
3.10.17	SKRL J T.		
3.10.17	Kate I.		
3.10.17	Kate I.		
3.10.17	SKRL J T.		
BUFFER HOLD VESSEL 4000L 1B4900			
Drawing Nr. 116685 / Sheet 1/2			

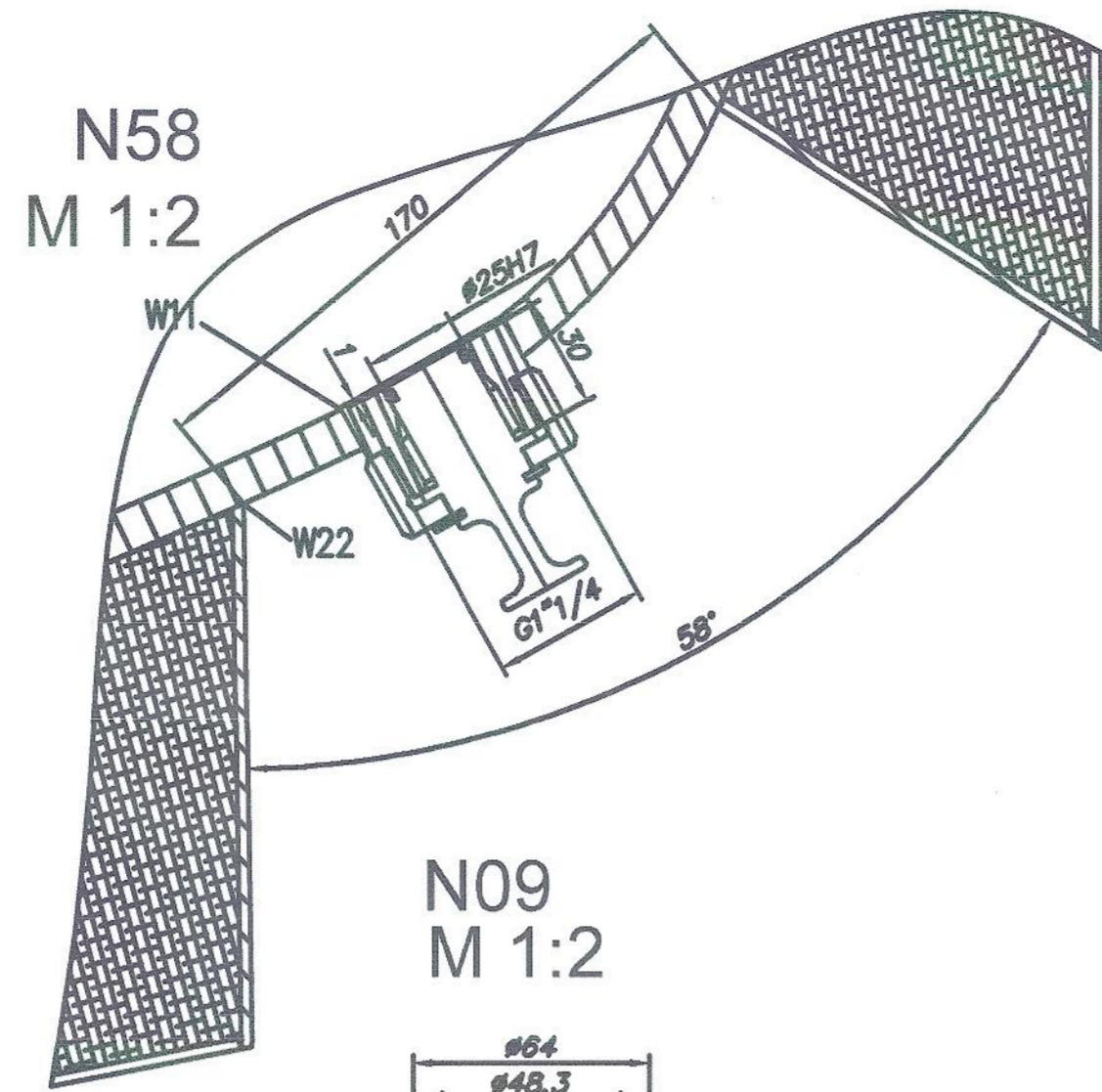
N19,N19.1
M 1:2



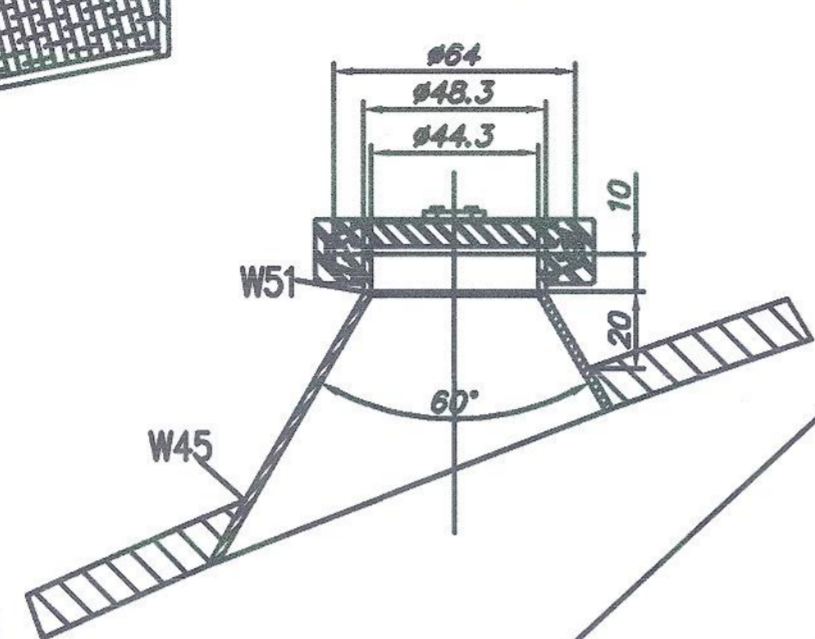
N05
M 1:2



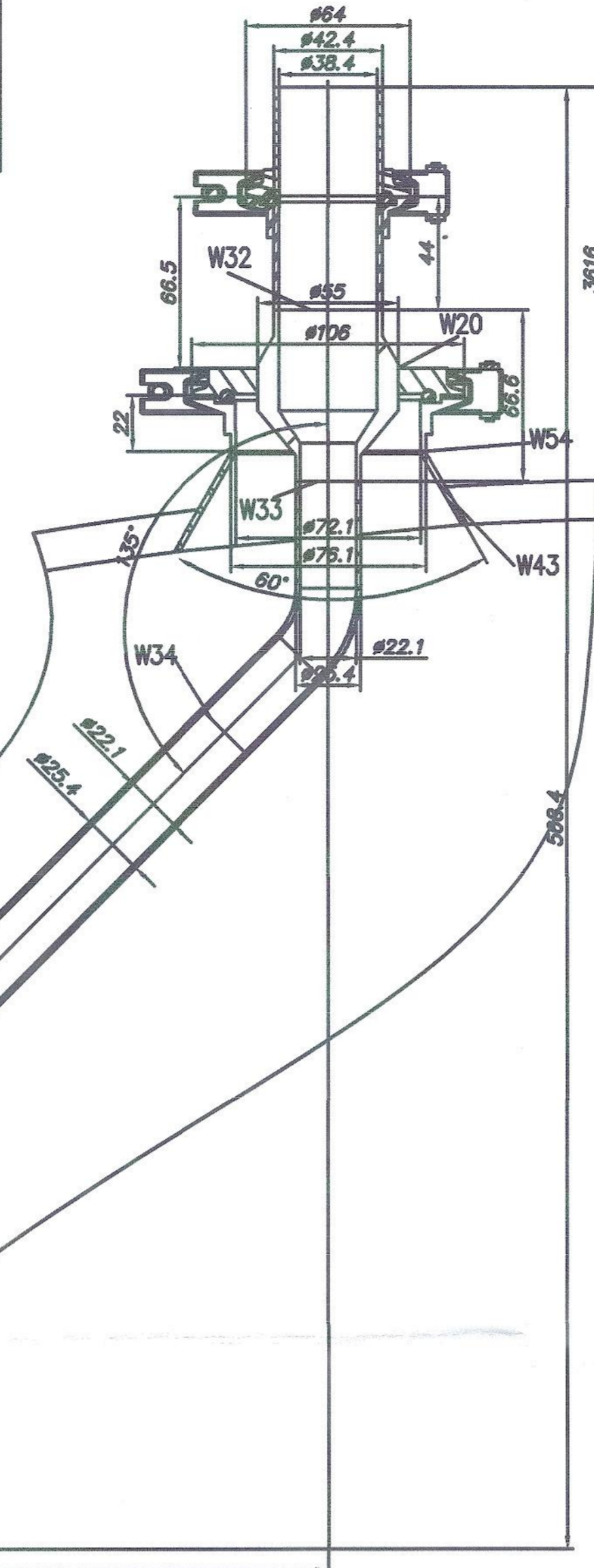
N58
M 1:2



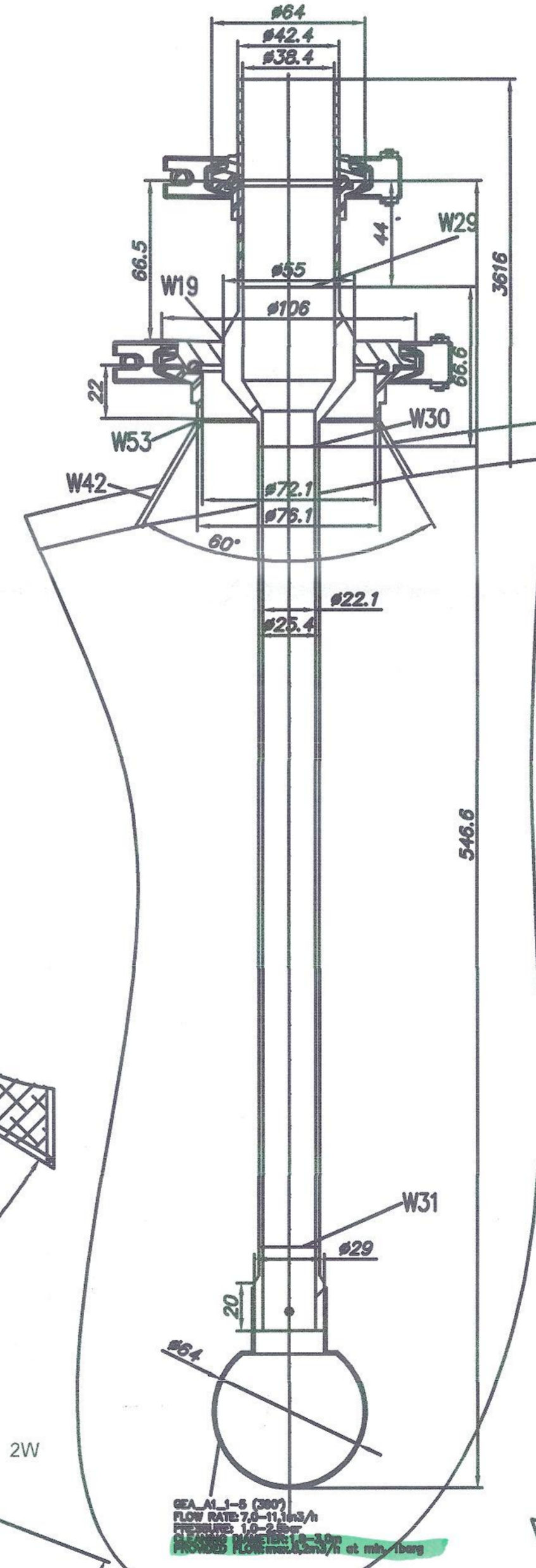
N09
M 1:2



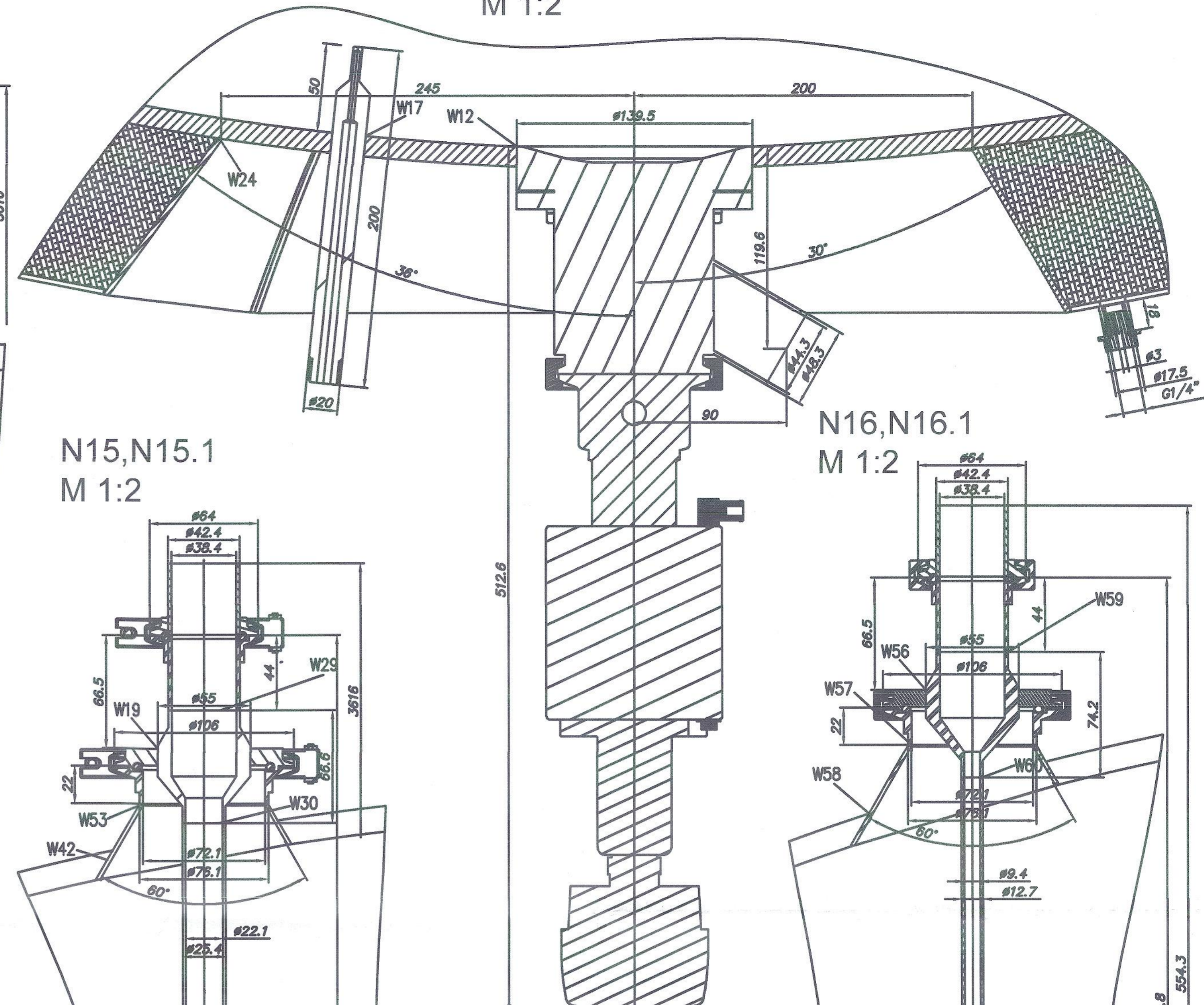
N14,N14.1
M 1:2



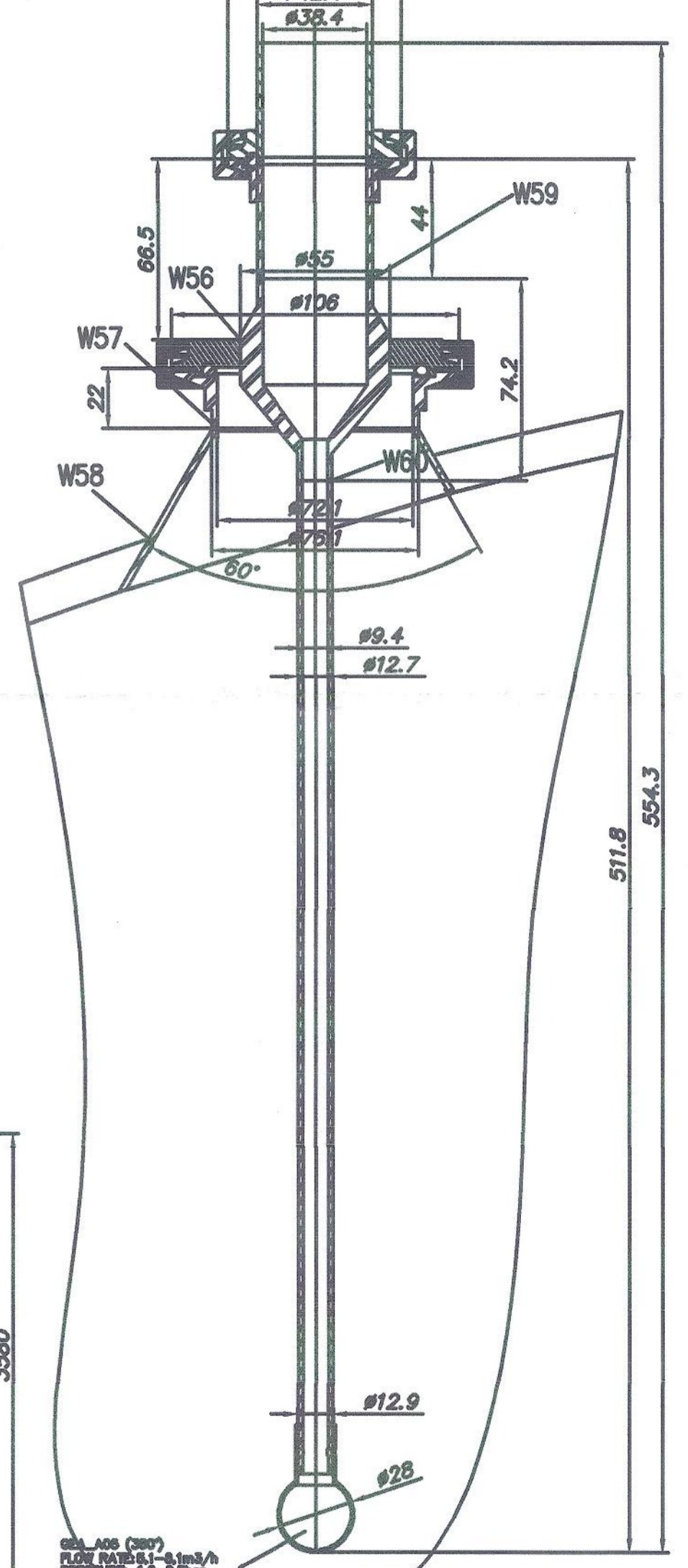
N15,N15.1
M 1:2



N50,N52,N80
M 1:2

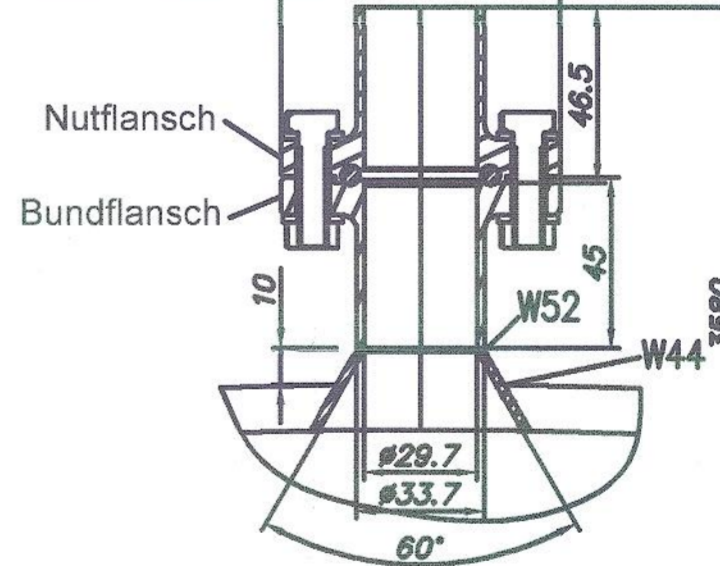


N16,N16.1
M 1:2

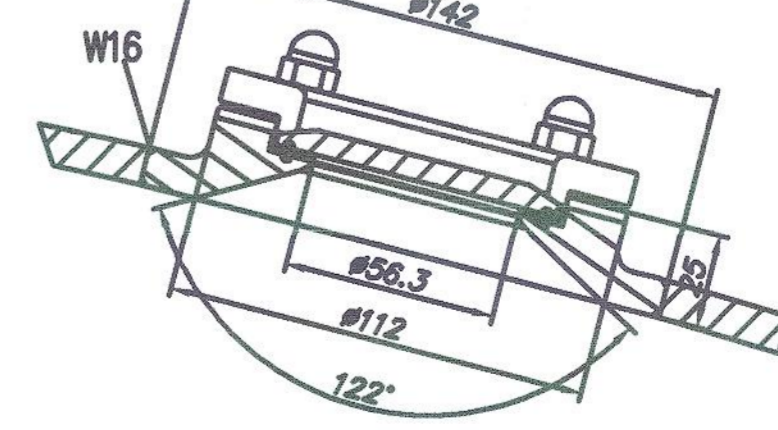


Aseptic Bottom Seat Valve SVP Type A386 D-E outlet 30°
Weld-in-flange Material 1.4359
Gasket P3 Diaphragm / EPDM
Mounting Kit with Gemü Control Unit Type 4242

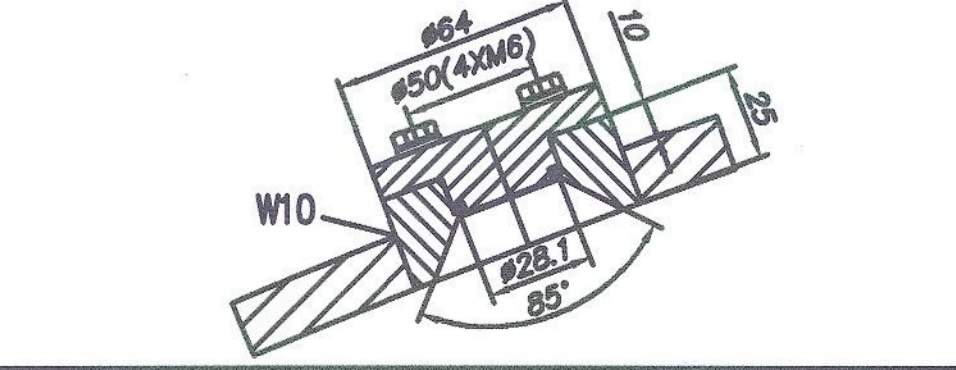
N12
M 1:2



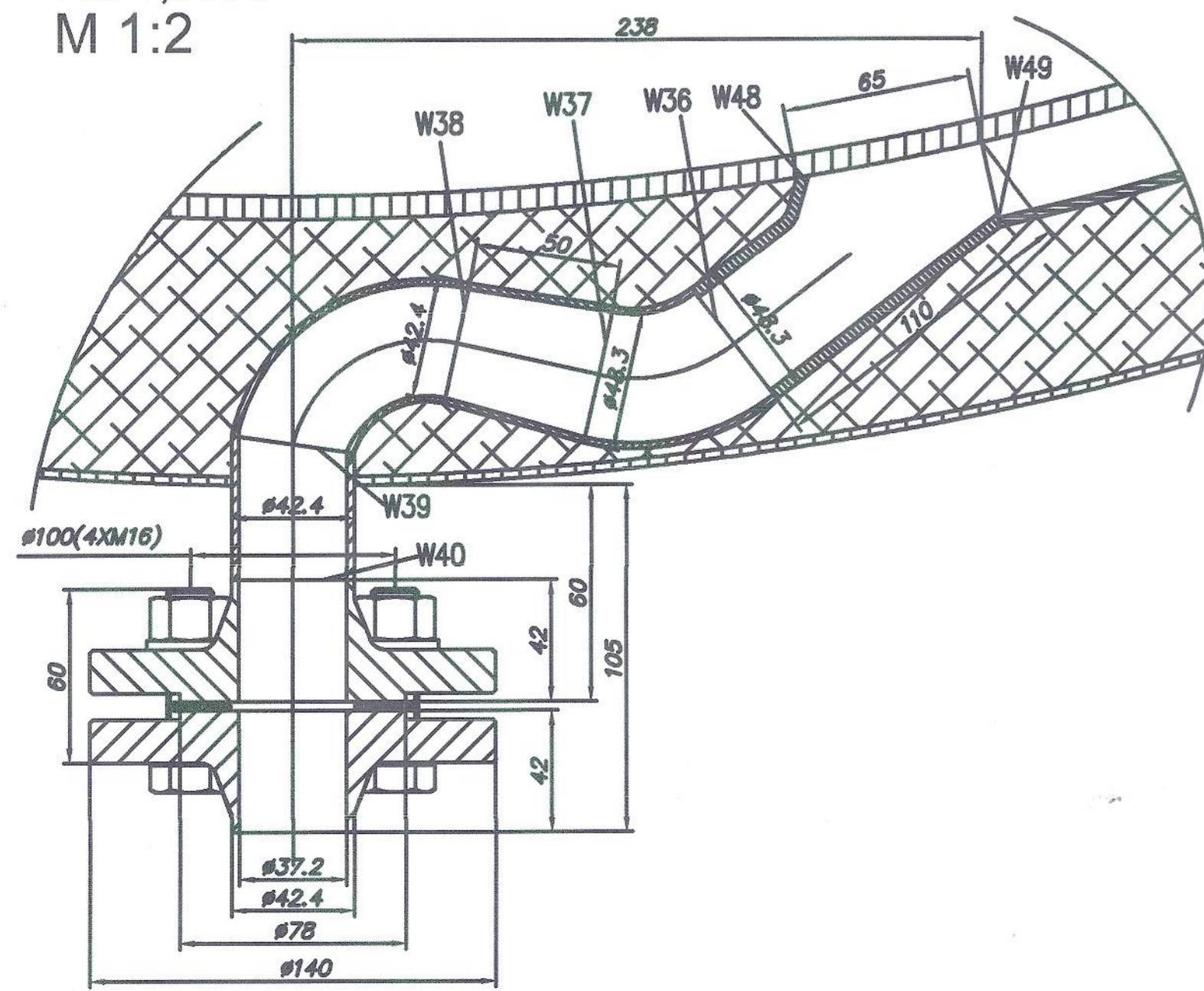
N13
M 1:2



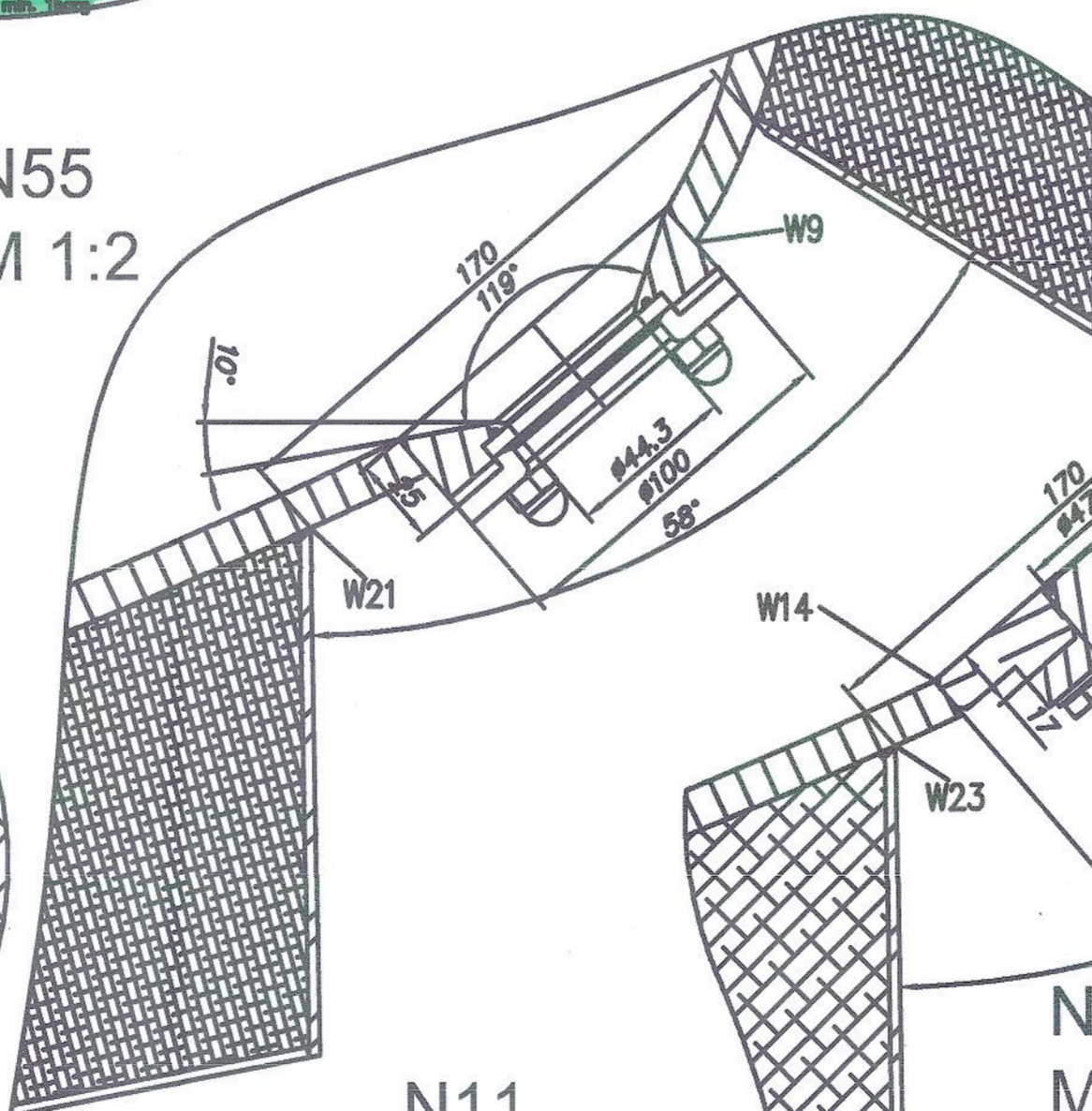
N07,N08
M 1:2



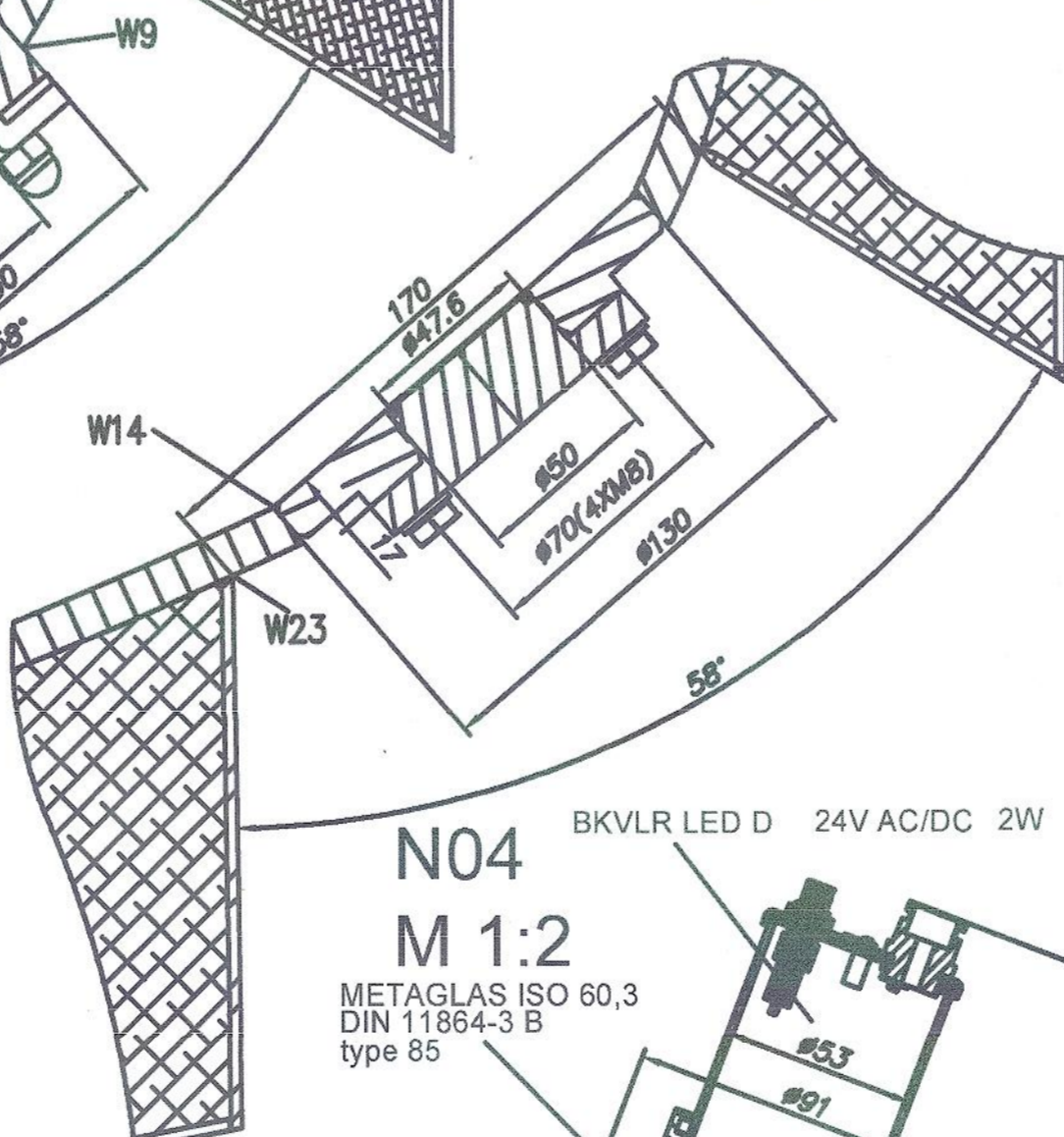
N64,N65
M 1:2



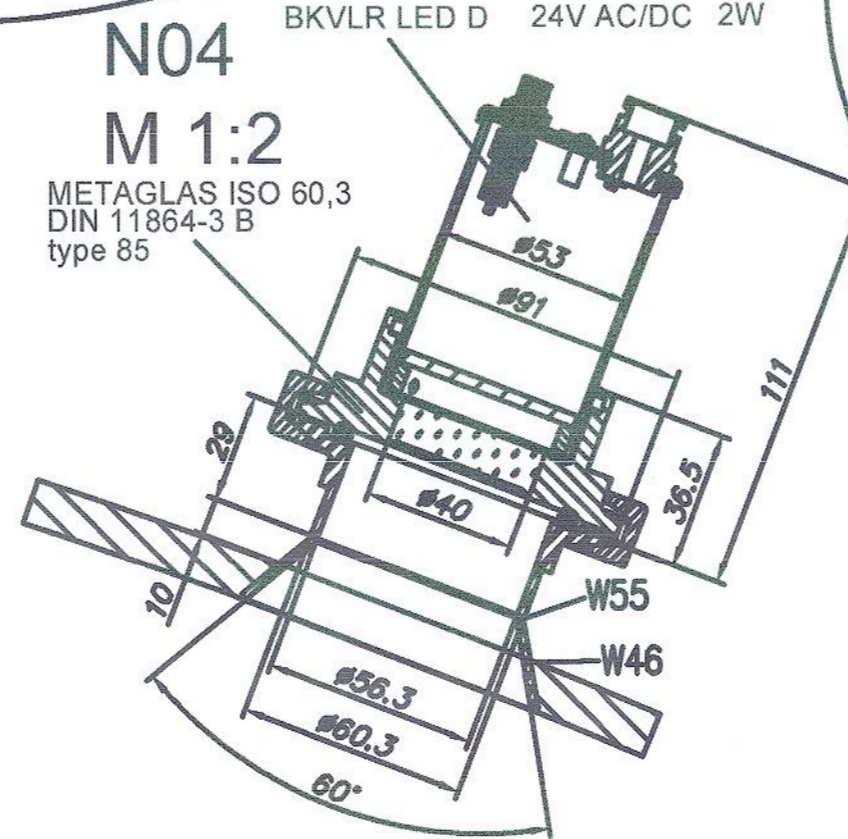
N55
M 1:2



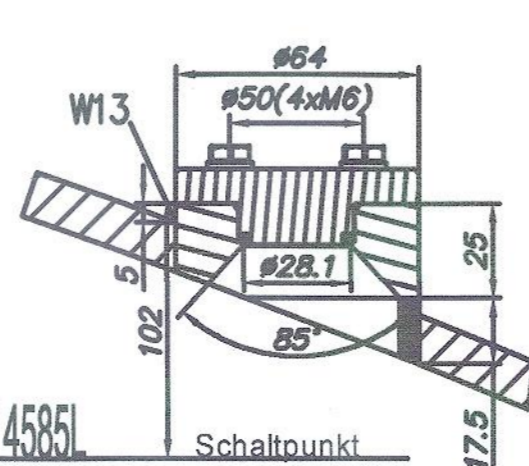
N59
M 1:2



N04
M 1:2



N11
M 1:2



WEISSFREIGABE

Überprüfung der Einarbeitung von Handeintragungen aus der AFC Freigabezeichnung vom 25.09.2017, Revision 1. Alle Anpassungen wurden ordnungsgemäß übernommen.

Geprüft M+W: 6.10.17 Jany Genehmigt CSL: 2.10.17
Genehmigt M+W: 06.10.2017 K. Müller

DN ISO 2768-1:m		Material		Scale		Mass-kg/piece	
		Wk.L450/L451/L451		M1:20		1961	
Date	Name	Signature	Title				
3.10.17	Sigrid J. T.			BUFER HOLD VESSEL 4000L 1B4900			
3.10.17	Kate L.						
3.10.17	Kate L.						
3.10.17	Sigrid J. T.						
2 R2 3.10.17 Kate L. 1 R1 09.17 Kate L.				Drawing Nr. 116685		Sheet 2/2	
Mark/Modification Date Signature				BUFER HOLD VESSEL 4000L 1B4900_R1			