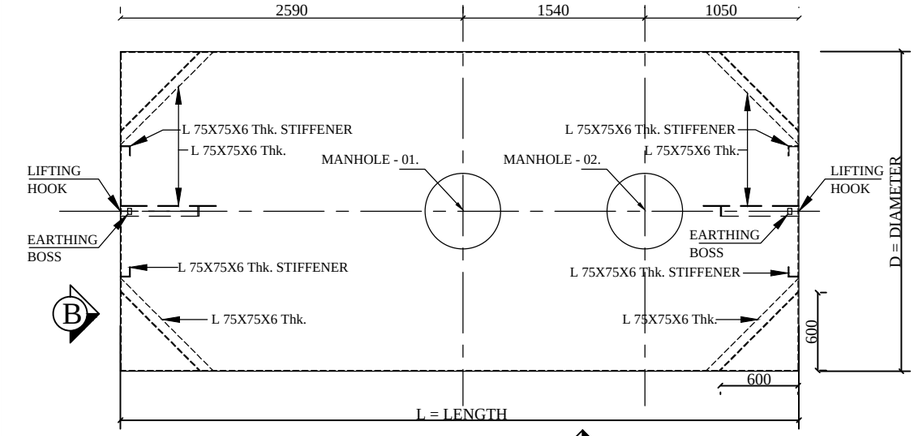
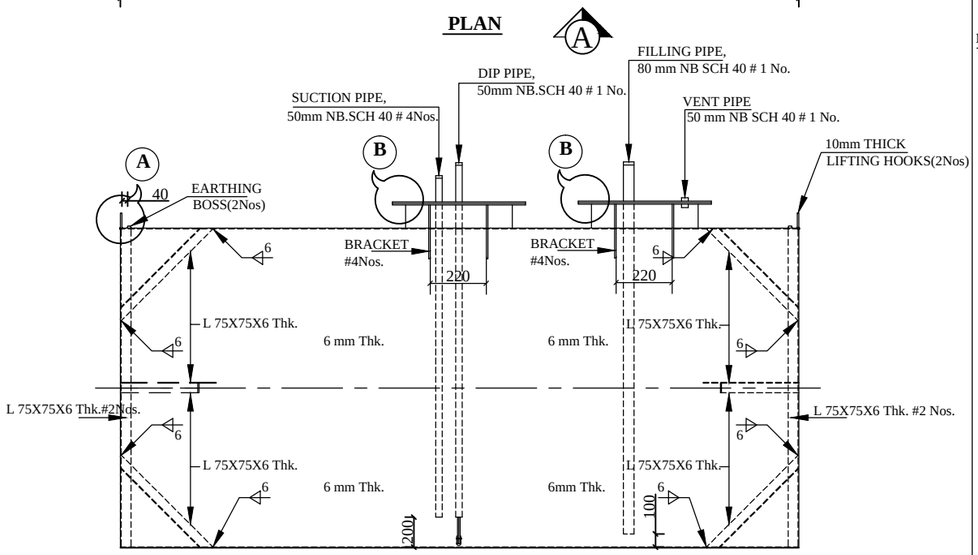
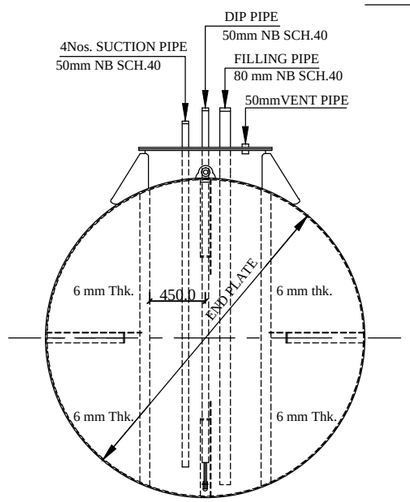


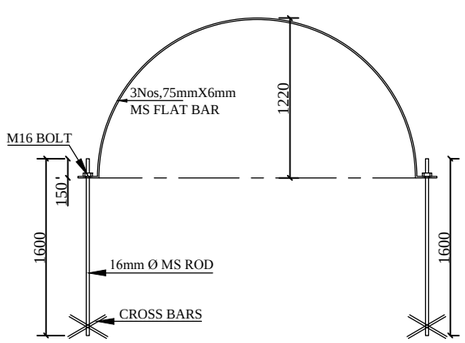
PLAN



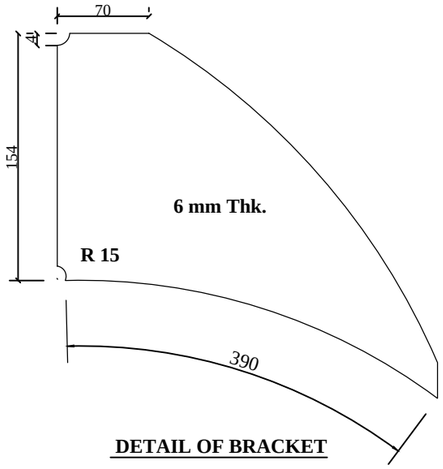
ELEVATION - A



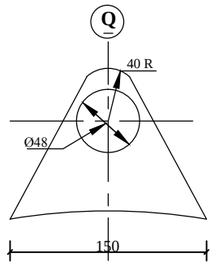
ELEVATION - B



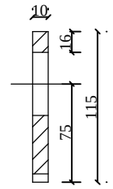
DETAIL OF ANCHORING BELT



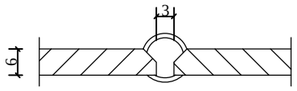
DETAIL OF BRACKET



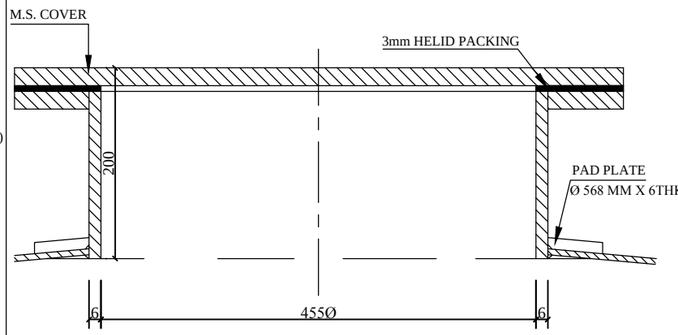
DETAIL OF LIFTING HOOK



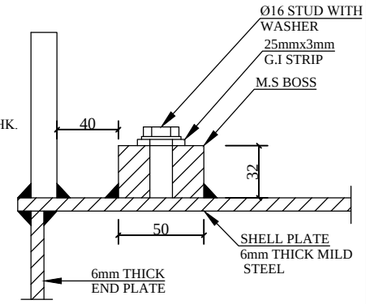
SECTION Q



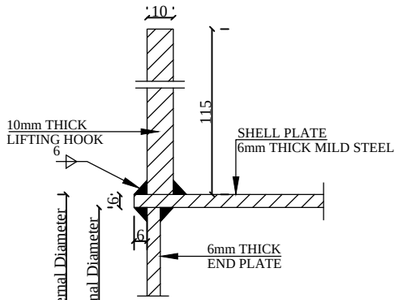
BUTT WELDING AT SHELL (TYPICAL)



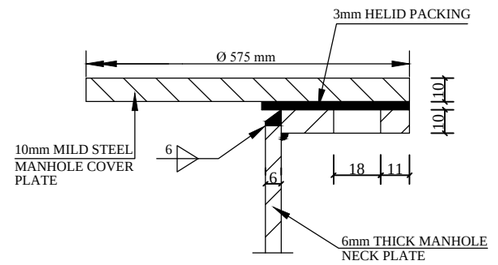
SECTION THROUGH P-P MANHOLE COVER



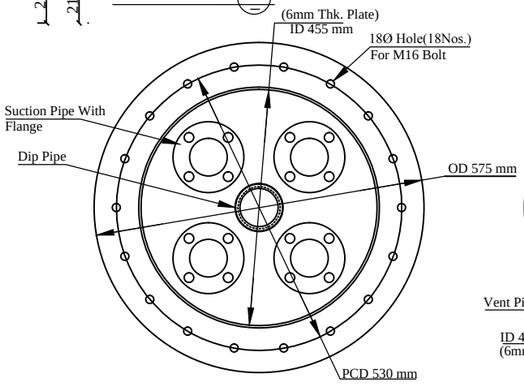
DETAIL OF EARTHING BOSS



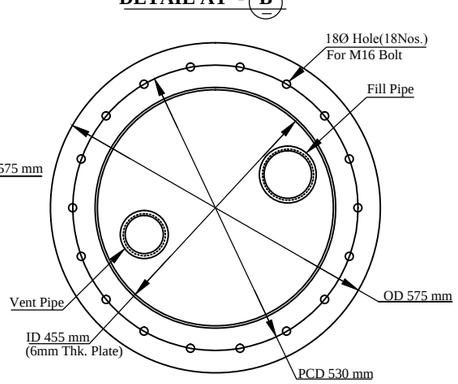
DETAIL AT - A



DETAIL AT - B



DETAIL OF MANHOLE -01



DETAIL OF MANHOLE -02

NOTES:-

1. MATERIAL

1.1 STEEL PLATES FOR THE TANK SHELL AND END PLATES TO BE AS PER BS4360 Gr. 43A. OR ASTM A.36 OR ASTM A131

1.2 ALL PIPES SHOULD BE MS BLACK AS PER BS1387(LATEST) WITH BSPT,11TPI SCH 40

1.3 HORIZONTAL AND CYLINDRICAL SEAMS TO BE BUTT WELDED AND GROUNG SMOOTH.

1.4 STRUCTURAL STEEL USED SHOULD BE ASTM A 36 OR EQUIVALANT.

2 . TANK TO BE SUPPLIED WITH MANHOLE COVER FITTINGS, ASBESTOS RING TO SUCTION PIPES AND BOLTS & NUTS AS SHOWN IN THE DRAWING.

2.1 10mm THICK RING TYPE IRON MANHOLE TO BE FITTED WITH 3mm HELID PACKING TO ENSURE THE TANK IS AIR TIGHT.

3. TESTING OF TANK

3.1 TANK TO BE HYDROTESTED TO 0.5KSC BY MAINTAINING WATER COLUMN OF 5.2M AND OBSERVING FOR A PERIOD OF 2HRS,PRESSURE GAGE READING INCLUDING WATER COLUMN TO BE FURNISHED AS PART OF TEST REPORT

4. SURFACE PREPARATION & PAINTING

4.1 SURFACE PREPARATION: MECHANICAL CLEANING BY POWER BRUSH TO SSPC SP2 OR BETTER

4.2 PAINTING : EXTERNAL SURFACE OF TANK AND ACCESSORIES TO BE WITH 2COATS OF ZINC PHOSPHATE PRIMER TO A DFT OF 30 TO 35 MICRONS, PER COATS FOLLOWED BY 2 COATS OF BITUMEN EMULATION FLINCOAT 3 FOR A COVERAGE OF 1.5LIT/M2 FOR 2COATS

5 . WELDER

5.1 SHALL BE CERTIFIED FOR 5E POTION AS PER ASME 9

6 . DIP ROD

6.1 THE SUPPLY OF ONE NUMBER DIP-ROD SHOULD BE MARKED IN CENTMETERS AND CALIBRATION CHARTS IN DUPLICATE FOR EACH TANK SHOULD BE SUBMITTED WITH TANKS.

7. ALL DIMENSIONS ARE IN MILIMETERS. (MM)

S.NO.	CAPACITY OF THE TANK	' D ' (ID)	' L ' (OUTER)
1.	22500 LITRES	2440	5180

REV.NO	DESCRIPTION	REV.BY	DATE

LANKA IOC PLC

DRAWING TITLE :

FABRICATION DETAIL OF 22.5KL HORIZONTAL UNDERGROUND TANK. (GENERAL ARRANGEMENT)

DRAWN BY	CHECKED BY	APPROVED BY
DRG.Ref.	LIOC/TANK/22.5KL/1 OF 2	SCALE: N.T.S