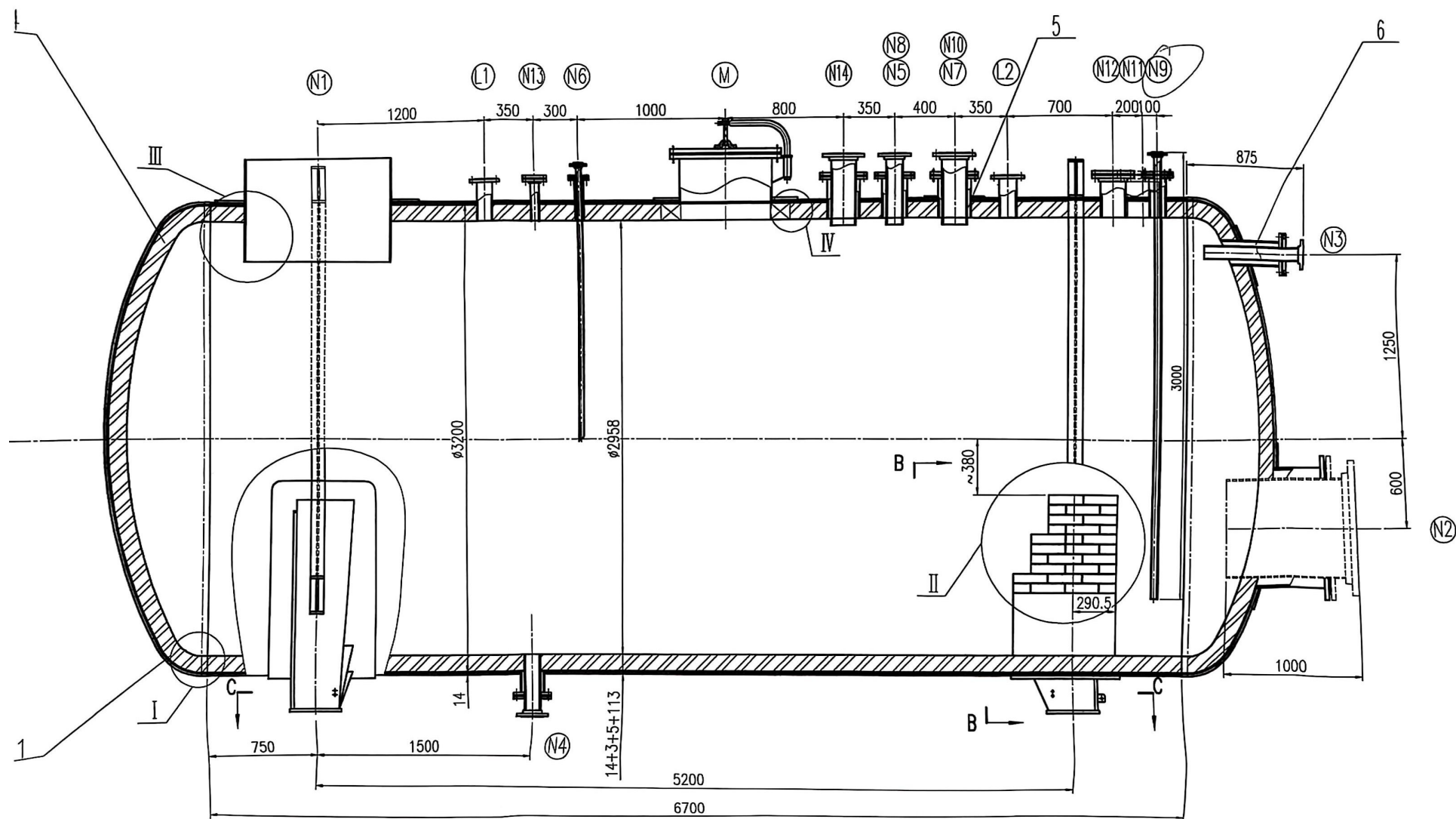




magnifier , and no crocks, bubbles, etc.

2.耐酸瓷砖衬里施工完毕后,需进行固化处理和酸化处理;

2.After the construction of acid-resistant ceramic tile lining is completed, curing treatment and acidification treatment shall be carried out;

3.衬砖砌好后不得在进行任何焊接;

3.After the brick is lined , no welding shall be performed;

4.设备外壁涂漆防腐:环氧富锌底漆2道,~40 μ m(干膜)/道;云铁环氧中间;漆1道,~50 μ m(干膜)/道;氟碳面漆2道,~40 μ m(干膜)/道.

4.Anti corrosion coating of equipment outer wall: 2 coats of epoxy zinc rich primer, ~40 μ m(dry film)/channel; Micaceous iron epoxy intermediate; One coat of paint, ~50 μ m(dry film) /channel; 2 fluorocarbon finishing coats, ~40 μ m(dry film) /channel.

5.所有法兰螺栓孔必须跨中均布.

5.All flange bolt holes must be evenly distributed across the middle span.

6.所有补强圈焊好后,由M10螺孔通入0.4~0.5MPa的压缩空气,检查补强圈连接焊缝的质量,角焊缝不得有渗漏现象.

6.After all reinforcing rings are welded, inject 0.4~0.5MPa compressed air through M10 screw hole check the quality of connecting welds of reinforcing rings, and the fillet welds shall be free of leak

注:除N1,N2,N4,L1~L2,M管口以外,其余壳体上法兰与接管均需内衬PTFE材料

Note: Except for N1, N2, N4, L1-L2, and M flanges, all flange connections on the shell must be lined w PTFE material

江苏索普赛瑞装备制造有限公司

施工用图

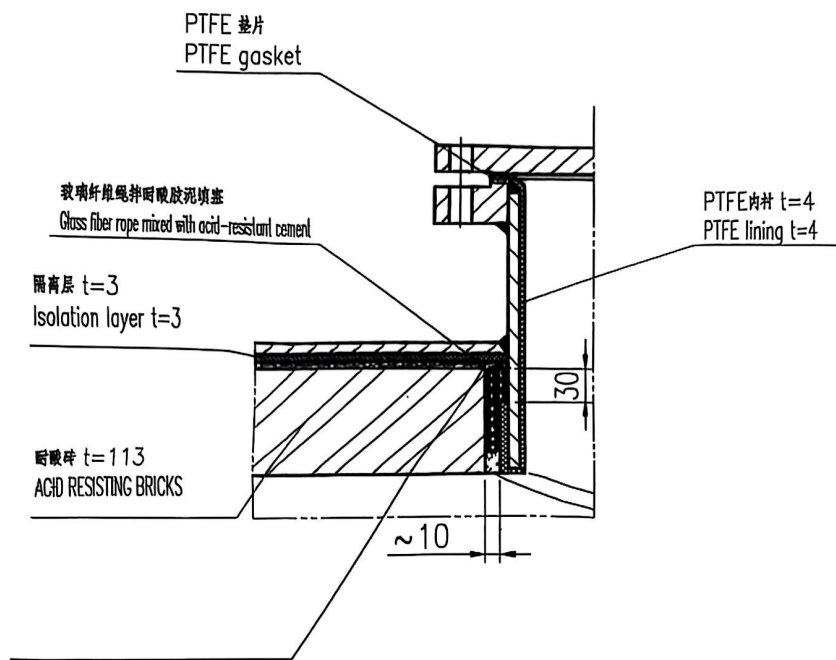
产品工号 玻璃纤维 243082484455 /

玻璃纤维 12~18

M	NB/T11025-2022	补强圈 dN600×14-D reinforcing pad	1	Q235B		51.8	M
	HG/T21522-2014	人孔 RF x t(NM-PTFE)600-6 Manhole	1	组合件 Assembly		199	筒体为φ630×8 cylinder φ630×8
L1	GB/T8163-2018	接管φ114.3×6.3 L=257 Steel Pipe	2	S31603	4.34	8.68	L1,L2
L2	GB/T9124.1-2019	法兰 DN100-PN16 PL RF I Flange	2	S31603	4.39	8.78	L1,L2
N13	GB/T8163-2018	接管φ60.3×5.6 L=273 Steel Pipe	1	20		2.06	
	GB/T9124.1-2019	法兰 DN50-PN16 SO RF I Flange	1	Q235B		2.39	
N12	GB/T9124.1-2019	法兰 DN150-PN16 SO RF I Flange	1	Q235B		7.24	
	GB/T8163-2018	接管 φ168.3×7.1 L=271 Steel Pipe	1	20		7.65	
N11	NB/T11025-2022	补强圈 dN200×14-D reinforcing pad	1	Q235B		10.4	
	GB/T8163-2018	接管 φ219.1×8 L=271 Steel Pipe	1	20		11.3	
	GB/T9124.1-2019	法兰 DN200-PN16 SO RF I Flange	1	Q235B		9.8	
N9	GB/T8163-2018	接管φ114.3×6.3 L=272 Steel Pipe	1	20		4.56	
	GB/T9124.1-2019	法兰 DN100-PN6 PL RF I Flange	1	Q235B		3.26	
N8 N10 N14	NB/T11025-2022	补强圈 dN200×14-D reinforcing pad	3	Q235B	10.4	31.2	
	GB/T8163-2018	接管 φ219.1×8 L=271 Steel Pipe	3	20	11.3	34	
	GB/T9124.1-2019	法兰 DN200-PN6 PL RF I Flange	3	Q235B	6.88	20.6	
N6 N7	GB/T8163-2018	接管φ60.3×5.6 L=273 Steel Pipe	2	20	2.06	3.9	
	GB/T9124.1-2019	法兰 DN50-PN6 PL RF I Flange	2	Q235B	1.48	2.96	
N3 N4 N5	NB/T11025-2022	补强圈 dN150×14-D reinforcing pad	2	Q235B	5.83	11.7	N4
	GB/T8163-2018	接管 φ168.3×7.1 L=271 Steel Pipe	1	20		7.65	N5
	GB/T8163-2018	接管 φ168.3×7.1 L=162 Steel Pipe	1	S31603		4.6	N4
	GB/T8163-2018	接管φ168.3×7.1 L=471 Steel Pipe	1	20		19.6	N3
	GB/T9124.1-2019	法兰 DN150-PN6 PL RF Flange	1	S31603		4.63	N4
	GB/T9124.1-2019	法兰 DN150-PN6 PL RF Flange	2	Q235B	4.76	9.52	N3,N5
N2	92GB-804B-JS15-TK-103/203/303-Q3	补强圈 reinforcing pad	1	Q235B		50.8	
		接管 φ813×12 L=489 Steel Pipe	1	Q235B		116	N2
	GB/T9124.1-2019	法兰 DN800-PN6 PL RF Flange	1	Q345R		54	N2
件号 No.	图号或标准号 DWG. OR STAND. No.	名称 DESCRIPTION	数量 QTY.	材料 MATERIAL	单UNIT 重量 WEIGHT(kg)	总TOTAL	备注 REMARKS
管口组件明细表 LIST OF NOZZLE COMPONENTS							
1-9		筒体 φ3200 t=14 L=6700 cylinder	1	Q235B		7435	
1-8		设备铭牌座 Equipment nameplate seat	1	S30408		2.5	
1-7	NB/T47065.1-2018	支座BII 3200-F Saddle	1	Q235B			

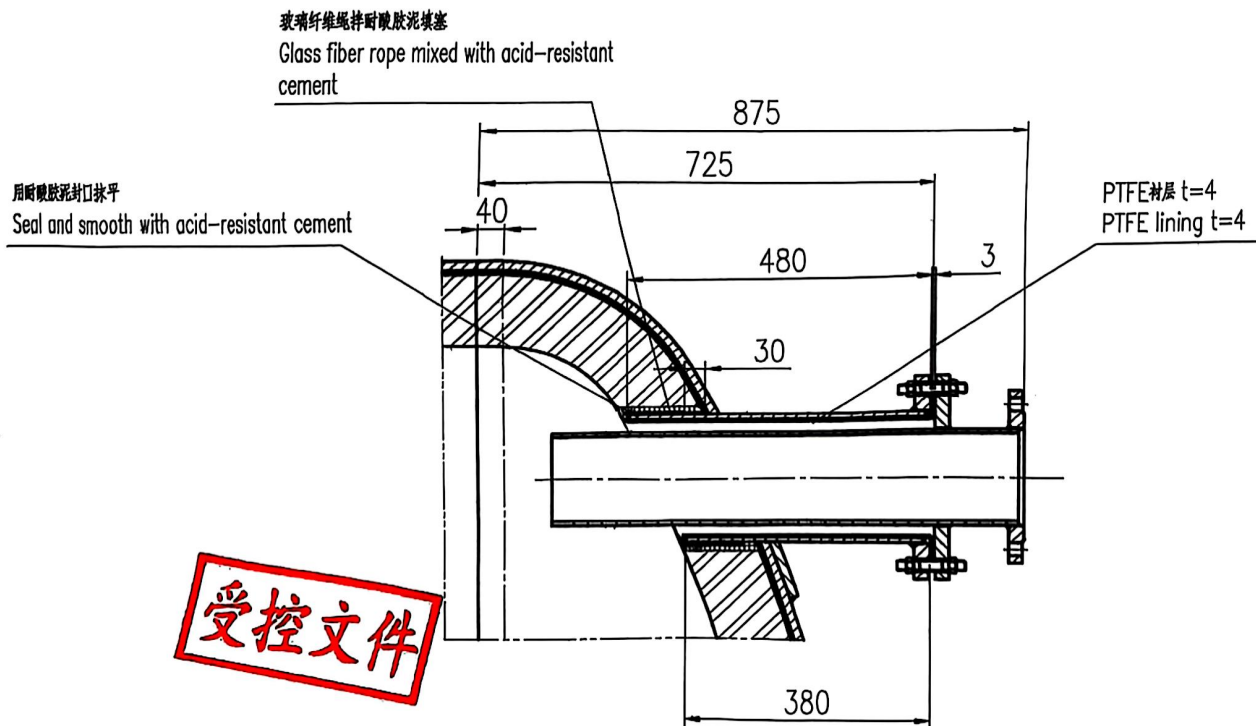
内衬接管开孔密封详图
Detailed drawing of bricklaying with inner
lining connecting pipe opening

不按比例 NO SCALE



接管N3详图
NozzleN3 details

不按比例 NO SCALE



受控文件

2	供制造 FOR MANUFACTURING	张远新	牛小军	董志军		2025.4.9
版次 REV.	说明 DESCRIPTION	设计 DEGND	校核 CHECK	审核 APPRO	批准 APPROV	日期 DATE



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