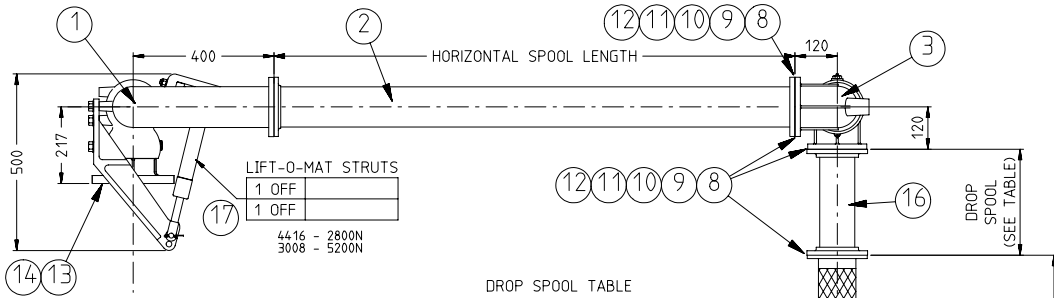


PLAN VIEW OF ARM



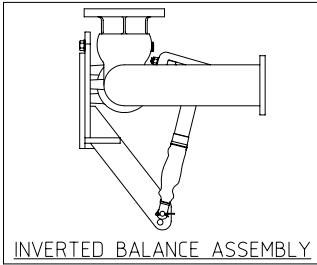
DROP SPOOL TABLE

ARM NO	SPOOL LENGTH (mm)	PART NO	QTY REQ'D
1			
2			
3			
4			
5			
6			

L220T - STEEL TUBE
L220A - ALUMINIUM TUBE
L220P - STEEL PIPE

PAINTING
SEE ATTACHED
TO LIQUIP SPEC

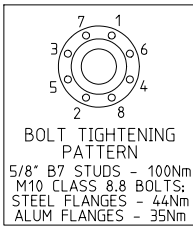
CIRCLE WHICHEVER IS APPLICABLE



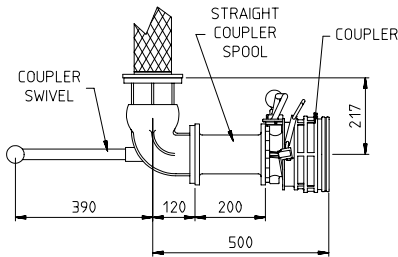
INVERTED BALANCE ASSEMBLY

NOTES

- STEEL PIPE TO BE STANDARD SEAMLESS TO APISL-B & ANSI B36.10. STEEL TUBE TO BE TO A178-C. ALUMINIUM PIPE TO BE 6061 T6 (ASTM B209). ALUMINIUM TUBE TO BE TO BS1474 (AUST GRADE 6060 T5).
- FLANGES (EXCEPT TTMA) TO BE TO ANSI B16.5 & ASTM A105.
- ALL STEEL SWIVELS ARE TO ASTM A633 GRADE E. BUTTWELD FITTINGS TO BE TO ANSI 16.9 & ASTM A106 GRADE B.
- TEST AS PER TESTING TABLE.
- WHERE WELDING PROCEDURES HAVE NOT BEEN SPECIFIED, THE MINIMUM REQUIREMENT WILL BE VISUALLY INSPECTED IN ACCORDANCE TO AS4041-2006 (EQUIVALENT TO ANSI B31.3 SECTIONS 8 & 9).
- PAINT AS PER CUSTOMER SPECIFICATION, OTHERWISE PAINT WHITE AS FOLLOWS:
PREPARATION: ABRASIVE BLAST TO AS1627.4 CLASS 2.5 (FOR CAST STEEL, APPLY 1 COAT OF GALMET IRONIZE BEFORE PRIMER)
PRIMER: 1 COAT ISO FREE 2-PACK AMINE - EPOXY FUNCTIONAL ACRYLIC ZINC PHOSPHATE
TOP COAT: 1 COAT ISO FREE 2-PACK AMINE - EPOXY FUNCTIONAL ACRYLIC ZINC PHOSPHATE
- ALL LOADING ARMS ARE INDIVIDUALLY DESIGNED. LIFT-O-MAT STRUT STRENGTH DEPENDS ON ARM LENGTH, ARM MATERIAL AND CONTENTS eg LIQUID OR VAPOUR. EACH JOB DRAWING MUST SPECIFY THE STRUT TO BE USED.
- DISCONNECT LIFT-O-MAT STRUT(S) FROM BALANCE ASSEMBLY FOR TRANSPORT.



BOLT TIGHTENING PATTERN
5/8" B7 STUDS - 100Nm
M10 CLASS 8.8 BOLTS - 44Nm
STEEL FLANGES - 44Nm
ALUM FLANGES - 35Nm



STRAIGHT CONNECTION

ITEM	PART NO	DESCRIPTION	QUANTITY FOR THE FULL ORDER	MATERIAL	EXTRA NOTES
1		BALANCE ASSEMBLY --- HAND		CAST STEEL	
2		HORIZONTAL SPOOL ---NB ---mm LONG TTMA FLANGE BOTH ENDS			
3		INTERMEDIATE SWIVEL ASSEMBLY			
4		DROP HOSE ---NB ---mm LONG			
5		COUPLER SWIVEL ASSEMBLY			
6		COUPLER SPOOL - STRAIGHT / ANGLED		ALUMINIUM	
7		DRY BREAK COUPLER		ALUMINIUM	
8	4248	GASKET 100mm TTMA		KLINGERITE	
9	6745	BOLT M10 x 45mm LONG - CLASS 8.8	8 per gasket	STEEL	
10	6744	NUT M10 - CLASS 8	8 per gasket	STEEL	
11	5261	WASHER SPRING M10 ASA MED	8 per gasket	STEEL	
12	5288	WASHER FLAT M10 x 21 OD	16 per gasket	STEEL	
13	4235	GASKET 100mm CLASS 150 ANSI SEAL FACE	1 per arm	KLINGERITE	
14	4892	STUD 5/8" UNC x 3 1/2" LONG B7 C/W 2 OFF 2H NUTS	8 per arm	STEEL	
15	4782	VELVET TOUCH MK2 INSTALLATION MANUAL (NOT SHOWN)	1 per arm	PAPER	
16		DROP SPOOL ---NB TTMA FLANGE BOTH ENDS - SEE TABLE FOR DETAILS			
17	4416	LIFT-O-MAT STRUT 2800N x 500mm	2 per arm	STEEL	
	3008	LIFT-O-MAT STRUT 5200N x 500mm	2 per arm	STEEL	

THIS IS CONFIDENTIAL INFORMATION

TESTING REQUIREMENTS: SEE TESTING TABLE PACKAGING REQUIREMENTS: REMOVE STRUT AS DRAWING BY AS

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STD. TOLERANCES & PRACTICES: HEAT TREATMENT: DRAWN BY NVA CHECKED NVA

DIMENSIONS: (UNLESS OTHERWISE SPECIFIED) MATERIAL: SEE PARTS LIST APPROVED NVA

DECIMAL PLACES: NOMINAL: 0.1mm PROTECTIVE TREATMENT: SEE NOTE 6 ASST. DRWG NVA

WELDING: 2. NOMINAL: 1.5mm

WELDING: 3. NOMINAL: 1.5mm

WELDING: 4. NOMINAL: 1.5mm

WELDING: 5. NOMINAL: 1.5mm

WELDING: 6. NOMINAL: 1.5mm

WELDING: 7. NOMINAL: 1.5mm

WELDING: 8. NOMINAL: 1.5mm

WELDING: 9. NOMINAL: 1.5mm

WELDING: 10. NOMINAL: 1.5mm

WELDING: 11. NOMINAL: 1.5mm

WELDING: 12. NOMINAL: 1.5mm

WELDING: 13. NOMINAL: 1.5mm

WELDING: 14. NOMINAL: 1.5mm

WELDING: 15. NOMINAL: 1.5mm

WELDING: 16. NOMINAL: 1.5mm

WELDING: 17. NOMINAL: 1.5mm

IF IN DOUBT ASK DO NOT SCALE OFF DRAWING

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LOADING ARM PRODUCTION DWG
VELVET TOUCH MK2 JOB

DATE: 23/2/01
PART No: NVA
DRAWING No: X1100001
ISSUE: C

TESTING TABLE	TEST TYPE	PRESSURE/LOAD	TEST TIME/CYCLES	TESTING MEDIUM	NOTES	DATE	BY	DATE	ISSUE
ALL SWIVEL ASSEMBLIES	AIR PRESSURE	(1) 200kPa (2) 400kPa (3) 200kPa (4) 20kPa	1 MIN EACH SETTING	AIR	START AT (1) INCREASE AS LISTED REMOVE SCREW FROM TELL-TALE HOLE FIRST				
					FULLY IMMERSE COMPONENTS IN WATER AND BLOW DRY WITH COMPRESSED AIR AFTERWARDS.				