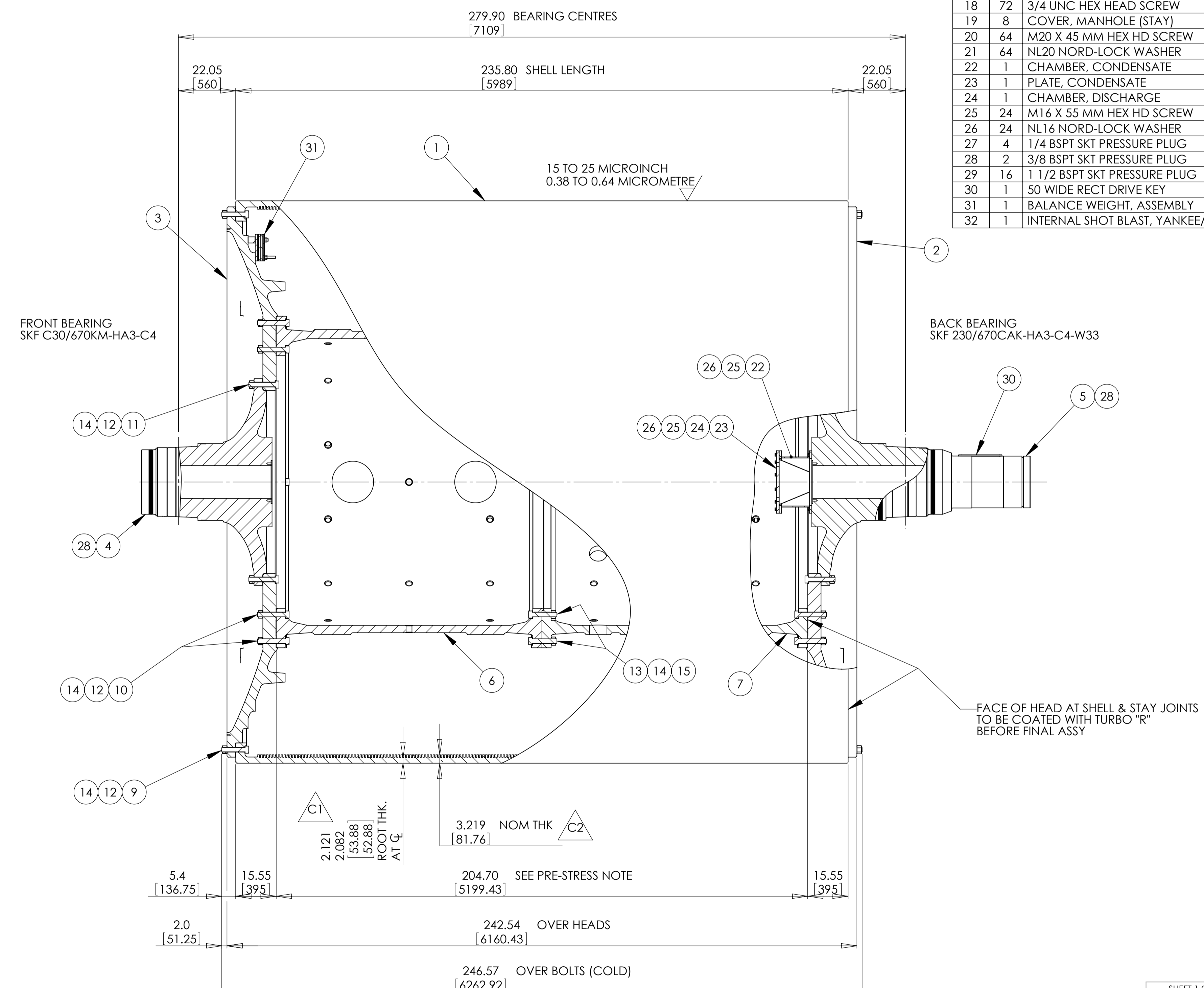


**PRE-STRESS NOTE :-**  
 SHORTEN THE STAY ASSEMBLY 0.093 inches (2.36 mm) LESS THAN THE FINISHED DISTANCE BETWEEN THE HEAD JOINT FACES.



ITEM	QTY	DESCRIPTION	PART NUMBER	MATERIAL
1	1	SHELL, 18 FT DIA YANKEE	YD10423	CI-601S
2	1	HEAD, 18 FT YANKEE	YD10409-1	CI-501S
3	1	HEAD, 18 FT YANKEE	YD10409-1	CI-501S
4	1	JOURNAL, FRONT 18 FT YANKEE	YD10424	CI-502S
5	1	JOURNAL, BACK 18 FT YANKEE	YD10425	CI-502S
6	1	FRONT CENTRE STAY, 18 FT YANKEE	YD10426	CI-406
7	1	BACK CENTRE STAY, 18 FT YANKEE	YD10427	CI-406
8	1	CHILLS FOR 18FT CASTING	CHILL18	MS
9	320	BOLT, 1-3/4" UNC FITTED	DS250010	SA193B7
10	296	BOLT, 1-3/4" UNC	DS250011-3	SA193B7
11	120	BOLT, 1-3/4" UNC	DS250011-2	SA193B7
12	736	WASHER FOR 1-3/4 Y.D. BOLT	44YD1618-6	Copper
13	96	BOLT, 1-3/4" UNC	DS250011-4	SA193B7
14	832	NUT, 1-3/4 UNC WASHER FACED HEX	DS250009	NOTED
15	96	1 3/4" SPECIAL WASHER	OS60097	M.S.
16	4	COVER, MANHOLE (HEAD)	DF250029	NOTED
17	4	GASKET, HEAD MANHOLE COVER	OS50020	NOTED
18	72	3/4 UNC HEX HEAD SCREW	33YD2033	SA193B7
19	8	COVER, MANHOLE (STAY)	DF250690	MS
20	64	M20 X 45 MM HEX HD SCREW	2902604	HTS
21	64	NL20 NORD-LOCK WASHER	2881027	Yell Crom
22	1	CHAMBER, CONDENSATE	DF450724	MS
23	1	PLATE, CONDENSATE	DS350054	MS
24	1	CHAMBER, DISCHARGE	DF450821	316S11
25	24	M16 X 55 MM HEX HD SCREW	2902491	HTS88
26	24	NL16 NORD-LOCK WASHER	2881022	Yell Crom
27	4	1/4 BSPT SKT PRESSURE PLUG	6601275	HTS
28	2	3/8 BSPT SKT PRESSURE PLUG	6601277	HTS
29	16	1 1/2 BSPT SKT PRESSURE PLUG	6601293	HTS
30	1	50 WIDE RECT DRIVE KEY	DS350048	O80M40
31	1	BALANCE WEIGHT, ASSEMBLY	90-8401-10093	NOTED
32	1	INTERNAL SHOT BLAST, YANKEE/MG	OS53918	NOTED

SHEET 1 OF 2 CERTIFIED 19/12/2012

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BNC 26-5041 BUC DRPP DATE 19/12/2012 PAINT	PROJECTION 3RD ANGLE	CUSTOMER NAME A.CELLI SpA	FILE/ORDER 16233
	CRITICAL C= MAJOR M= CLASSIFICATION OF CHARACTERISTICS	MILL LOCATION SCA, SOVETSK, RUSSIA	MACH. NO -
		DRAWN CRB	VERIFIED DYP
	DYP 15/02/2013 DYP 19/12/2012 DYP 10/10/2012 REVISION C2 BI A	UNITS in SCALE 1:25 DATE DRAWN 20/07/2012	
TITLE DRYER, 18 FT DIA YANKEE		IDENTIFICATION NUMBER 26-5041-10536	
		ORDERING DOCUMENT RD-1J38-26-1630	
		LAST REV C-01	

Info of Plot Time: 15 February 2013 PDWworks Location: 16233

**GENERAL NOTES :-**

THE DRYER TO BE DESIGNED AND BUILT IN ACCORDANCE WITH A.S.M.E. SECTION VIII DIV.1 PER 2010 EDITION (2011 ADDENDA)

DRYER DESIGNED FOR 125 P.S.I.G. (8.62 Bar) MAX. OPERATING STEAM PRESSURE AND TO BE HYDROSTATICALLY TESTED TO 250 P.S.I.G. (17.24 Bar) IN THE PRESENCE OF THE AUTHORIZED INSPECTOR.

 THE NAMEPLATES TO BE FIXED NEAR TO THE FRONTSIDE MANHOLE (BOLT No 1) BEFORE STAMPING.

OUTER UNMACHINED PARTS OF HEADS TO BE CLEANED AND COATED WITH EPIGRIP J792. ALL OTHER MACHINED AND POLISHED PARTS OF DRYER TO BE COMPLETELY COVERED WITH A PROTECTIVE COATING. WRAPPED AND LAGGED. REFER DATA SHEETS 11-77-2781-0 TO -4.

THOROUGHLY CLEAN AND VACUUM INSIDE OF DRYER TO REMOVE ALL PARTICLES OF CAST IRON AND ALL TRACES OF OIL AND GREASE BEFORE GRINDING AND AFTER GRINDING. INSPECT FOR CLEANLINESS PRIOR TO SHIPPING. THE DRYER MUST BE THOROUGHLY DRY INTERNALLY.

ASSEMBLE HEADS TO SHELL SO THAT MANHOLES ARE IN LINE.

1 3/4" UNC NUTS TO BE TIGHTENED TO 3300 lbs.ft (4474 Nm).  
 3/4" UNC SCREWS TO BE TIGHTENED TO 250 lbs.ft ( 339 Nm).  
 APPLY MOLYKOTE 1000 HOT SCREW PASTE TO BOLT or SCREW THREAD AND WASHER FACE OF NUT or SCREW BEFORE TIGHTENING.

HEAD TO SHELL BOLTS ARE TO BE NUMBERED BY STAMPING EVERY TENTH BOLT ON BOTH FRONT AND BACK SIDES. NUMBERS ON FRONTSIDE TO START AT ONE MANHOLE AND RUN CLOCKWISE, BACKSIDE TO BE NUMBERED COUNTER-CLOCKWISE STARTING WITH No.1 DIRECTLY OPPOSITE No.1 ON FRONTSIDE.

DYNAMICALLY BALANCE TO ISO 1940 QUALITY GRADE G6.3 FOR A SPEED OF 6562 ft/min (2000 m/min).  
 MAXIMUM RESIDUAL UNBALANCE PER BEARING = 51442 oz. in (37068 g.m).  
 MAXIMUM RESIDUAL UNBALANCE WEIGHT AT THE BALANCE WEIGHT RADIUS OF 89.8 in (2.28 m) = 35.8 lb (16.24 kg).  
 MAXIMUM SLOW ROLL RUNOUT = 0.004 inches (0.10 mm).  
 BALANCING MACHINE SPEED = 50 R.P.M.

ATTACH CONDENSATE PLATE, DISCHARGE CHAMBER AND CONDENSATE CHAMBER TO REAR JOURNAL PRIOR TO FIXING INTO HEAD.

EIGHT STAY MANHOLE COVERS TO BE PLACED INSIDE THE DRYER PRIOR TO FIXING BOTH HEADS IN POSITION.

CALCULATED WEIGHT OF DRYER IS 140.7 TON (1 TON = 2240 lbs) (143.0 TONNE) .

CALCULATED MASS MOMENT OF INERTIA OF DRYER IS 974500 TON IN\*\*2 (638800 kg M\*\*2).

MAXIMUM DESIGN METAL TEMPERATURE 450 DEG.F (232 DEG.C).

MAXIMUM OPERATING TEMPERATURE 368 DEG.F (186 DEG.C).


MINIMUM DESIGN METAL TEMPERATURE 50 DEG.F (10 DEG.C).

DRYER SERIAL NUMBER 1345.

Unit Conversions				
US Customary		SI		
value	unit	value	unit	Source
1	in	25.4	mm	ASME Section VIII Div 1 Part GG-3
1	ft	0.3048	m	ASME Section VIII Div 1 Part GG-3
1	U.S. gal	0.003785412	m <sup>3</sup>	ASME Section VIII Div 1 Part GG-3
1	U.S. gal	3.785412	liters	ASME Section VIII Div 1 Part GG-3
1	psi	0.0068948	Mpa	ASME Section VIII Div 1 Part GG-3
1	psi	0.0068948	N/mm <sup>2</sup>	ASME Section VIII Div 1 Part GG-3
1	psi	6.894757	kPa	ASME Section VIII Div 1 Part GG-3
1	psi	0.06894757	bar	ASME Section VIII Div 1 Part GG-3
1	F (non differential)	0.5556 (-32)	C (non differential)	ASME Section VIII Div 1 Part GG-3
1	F (differential)	0.5556	C (differential)	ASME Section VIII Div 1 Part GG-3
1	lbm	0.4535924	kg	ASME Section VIII Div 1 Part GG-3
1	lbf	4.448222	N	ASME Section VIII Div 1 Part GG-3
1	ft-lb	1.3558181	N.m	ASME Section VIII Div 1 Part GG-3

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BUG		MILL LOCATION SCA, SOVETSK, RUSSIA	MACH.NO -	
DRPR DATE 19/12/2012	CLASSIFICATION OF CHARACTERISTICS CRITICAL C= MAJOR M=	DRAWN CRB	VERIFIED DYP	
REVISION A		DEPARTMENT ENG	UNITS in	
C2 15/02/2013	DYP	APPROVED CRB	SCALE 1:20	
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