

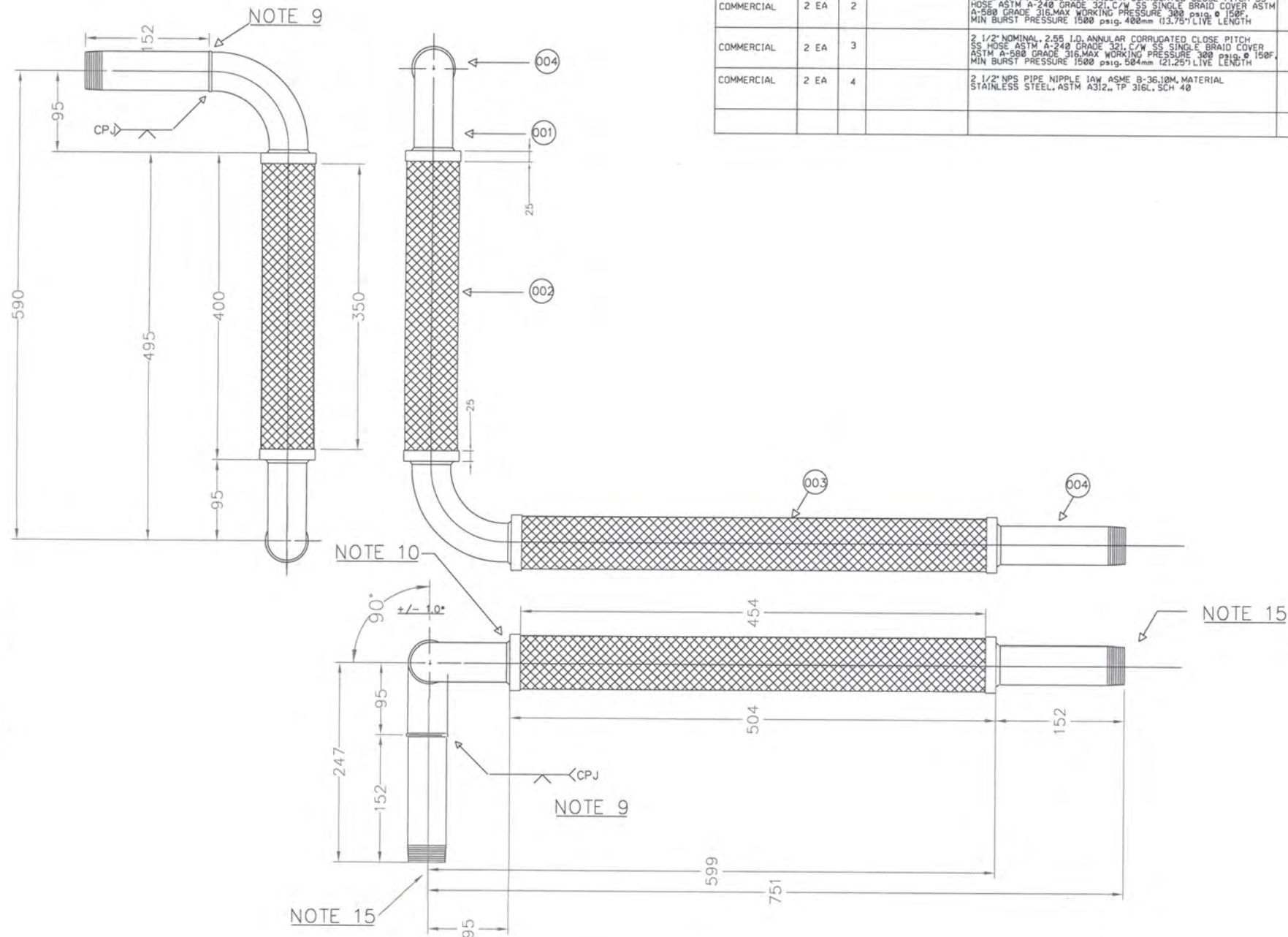
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200  
180  
160  
140  
120  
100  
80  
60  
40  
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Millimètres  
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NOTES:

1. MAXIMUM WORKING PRESSURE 350 PSIG at 150F.
2. WORKING FLUID REFRIGERANT
3. MINIMUM BURST PRESSURE SHALL BE 1750 PSIG I.A.W. CSA B52-05 paragraph 5.8.1
4. FABRICATION SHALL BE I.A.W. CSA B52-05 MECHANICAL REFRIGERATION CODE AND CSA B51-97 BOILER, PRESSURE VESSEL AND PIPING CODE.
5. WELDING SHALL BE I.A.W. ASME B31.5 REFRIGERATION PIPING AND HEAT TRANSFER COMPONENTS
6. ALL WELDS SHALL BE PERFORMED BY A QUALIFIED WELDER UTILIZING A QUALIFIED PROCESS IAW ASME BOILER AND PRESSURE VESSEL CODE SECTION IX WELDING AND BRAZING QUALIFICATIONS
7. ALL WELDS SHALL BE NDE IAW ASME BOILER AND PRESSURE VESSEL CODE SECTION V, NON-DESTRUCTIVE EXAMINATION
8. COMPLETE PENETRATION JOINT (CPJ) FORMS A SECTION OF PROCESS PIPE AND REQUIRES VISUAL TESTING (VT) AND RADIOGRAPHIC TESTING (RT)
9. MANUFACTURING PROCESS WELD MUST BE VISUAL TEST (VT) AND DYE PENETRANT TESTED (LP)
10. ALL NDE SHALL BE PERFORMED BY A CGSB QUALIFIED NDE INSPECTOR
11. HYDROSTATIC TESTING OF FLEXIBLE ASSEMBLY NOT PERMITTED I.A.W. CSA B52-05 paragraph 5.10.2.2.
12. FLEXIBLE ELEMENT TO BE PRESSURE TESTED TO 1.25x WORKING PRESSURE ( 437.5 PSIG ) USING DRY NITROGEN FOR 12 HRS WITH NO ALLOWABLE DROP
13. ALL WELDS MUST HAVE 100 PERCENT INTERNAL GAS PURGE
14. THE MANUFACTURER OF THE FLEXIBLE ELEMENT SHALL PROVIDE THE FOLLOWING WELD QUALITY RECORD AS OBJECTIVE QUALITY EVIDENCE
  - (A) WELD PROCEDURE SPECIFICATION FOLLOWED
  - (B) WELDER IDENTIFICATION
  - (C) BASE MATERIAL WELDED
  - (D) NDE and INSPECTION RECORD
15. THREADED HOSE END TO PROVIDE TEST CONNECTION FOR HOSE MANUFACTURING. NOT FOR FINAL CONNECTION.



NATO STOCK NO	-NO QTY/QTE	ITEM NO. DE L'ART	IDENTIFYING NO. D'IDENTIFICATION	NOMENCLATURE DESCRIPTION	SPECIFICATION	CODE IDENT CODE D'IDENT
COMMERCIAL	4 EA	1		2 1/2" IPS LONG RADIUS ELBOW 1AW ASME B-36.10, MATERIAL ASTM A403, TP 316, SCH 40		
COMMERCIAL	2 EA	2		2 1/2" NOMINAL, 2.55 I.D. ANNULAR CORRUGATED CLOSE PITCH SS HOSE ASTM A-240 GRADE 321, C/W SS SINGLE BRAID COVER ASTM A-568 GRADE 316, MAX WORKING PRESSURE 300 psig, 0 150F, MIN BURST PRESSURE 1500 psig, 488mm (13.75") LIVE LENGTH		
COMMERCIAL	2 EA	3		2 1/2" NOMINAL, 2.55 I.D. ANNULAR CORRUGATED CLOSE PITCH SS HOSE ASTM A-240 GRADE 321, C/W SS SINGLE BRAID COVER ASTM A-568 GRADE 316, MAX WORKING PRESSURE 300 psig, 0 150F, MIN BURST PRESSURE 1500 psig, 504mm (21.25") LIVE LENGTH		
COMMERCIAL	2 EA	4		2 1/2" NPS PIPE NIPPLE 1AW ASME B-36.10M, MATERIAL STAINLESS STEEL, ASTM A312, TP 316L, SCH 40		

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AVIS  
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MODIFICATION DRAWING

UNLESS OTHERWISE SPECIFIED/SAUF INDICATION CONTRAIRE:  
1. DIMENSIONS ARE IN/DIMENSIONS SONT EN mm  
2. TOLERANCES  
FRACTIONS ±  
DECIMALS XXX ±  
DÉCALES XX ±  
X ±  
ANGLES ±  
3. SURFACE FINISH  
FINIS DE SURFACES √  
INTERPRETATION/CE-SDO-D-01:400-001/CSG-000  
INTERPRETER LEVEL/NIVEAU 2

APPLICATION/USAGE  
HFX CLASS  
EC #19980115  
SCALE/ÉCHELLE AS SHOWN

ALL	-	LOCALLY APPROVED BY NAO	19-04-2011	JUN	SI
ZONE	LTR LET	REVISION	DATE	DWN DES	CKD VER
Defense Nationale		National Defence	CANADA		
OWN/DESS	J. NEWMAN	CKD/VER	L. DISTON.	DA/AG	S. IRETON
DESIGN AGENT/CONCEPTION	FMF(CB)/ENG/J. NEWMAN	DIV. HEAD	LCDR M. RUSSELL	NSCM/CAOF	35902
TITLE/TITRE		85 TON STANDARD FLANGED DISCHARGE FLEXIBLE ELEMENT			
DRAWING DATE DU DESSIN		12-DEC-2008			
DRAWING NO DU DESSIN		1150019			
SHEET FEUILLE		1		OF DE	1

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