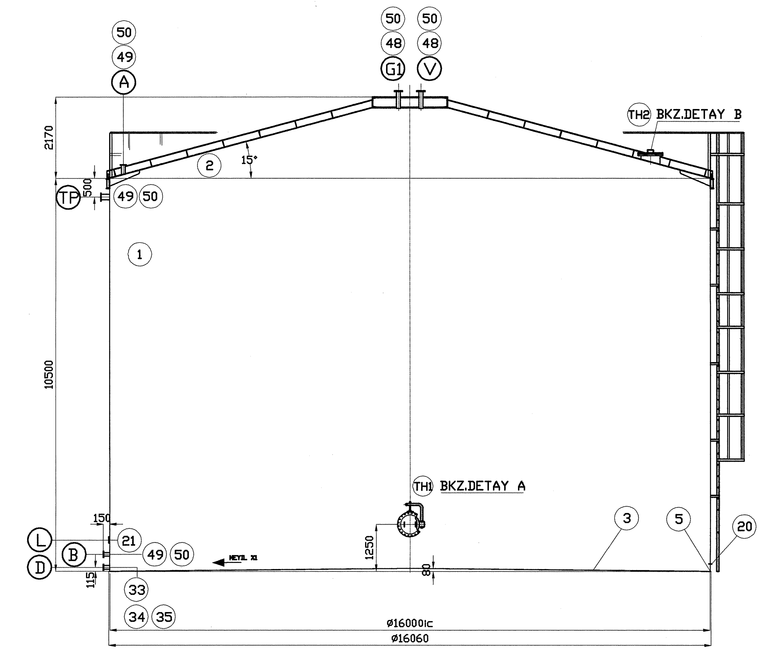
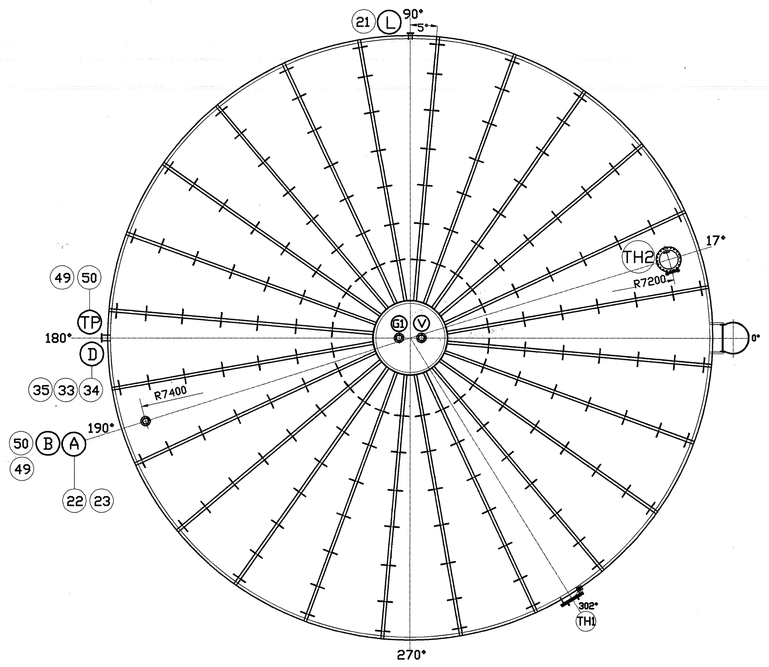
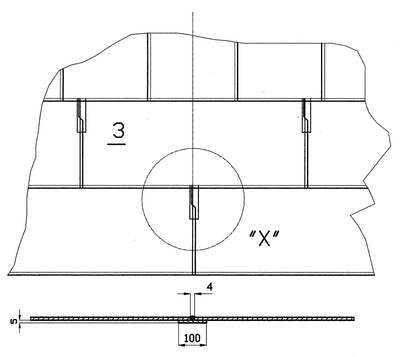
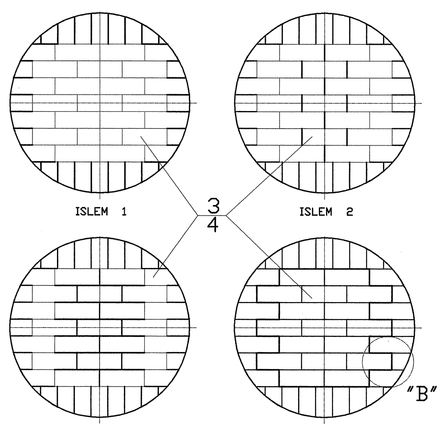


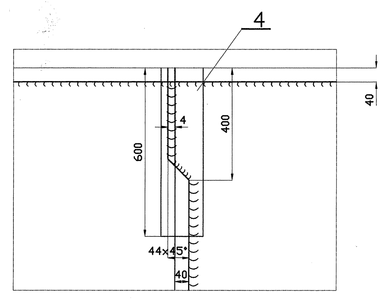




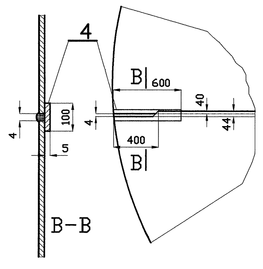
B-Detayi



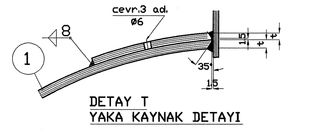
KAYNAK ISLEM SIRASI



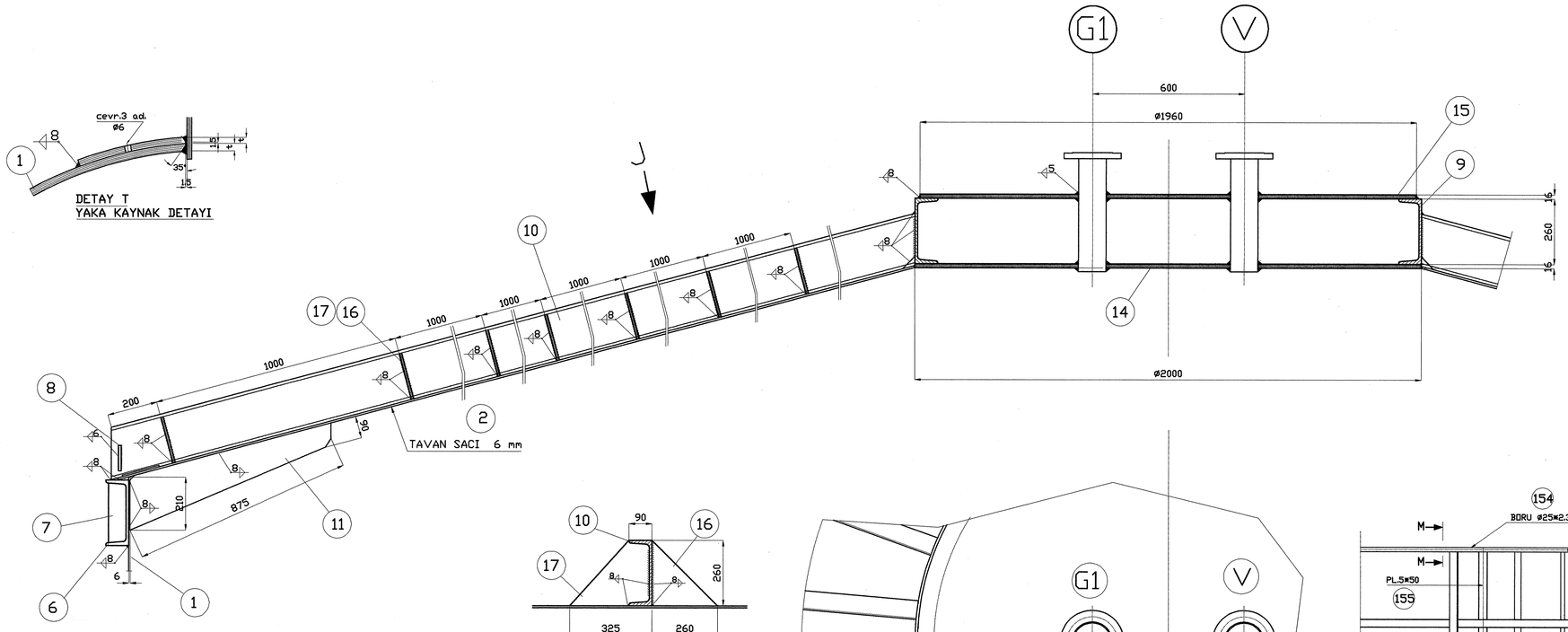
X-Detayi

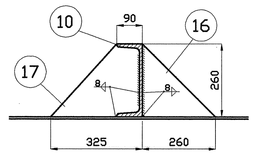


TABAN LEVHALARI
KAYNAK DETAYI

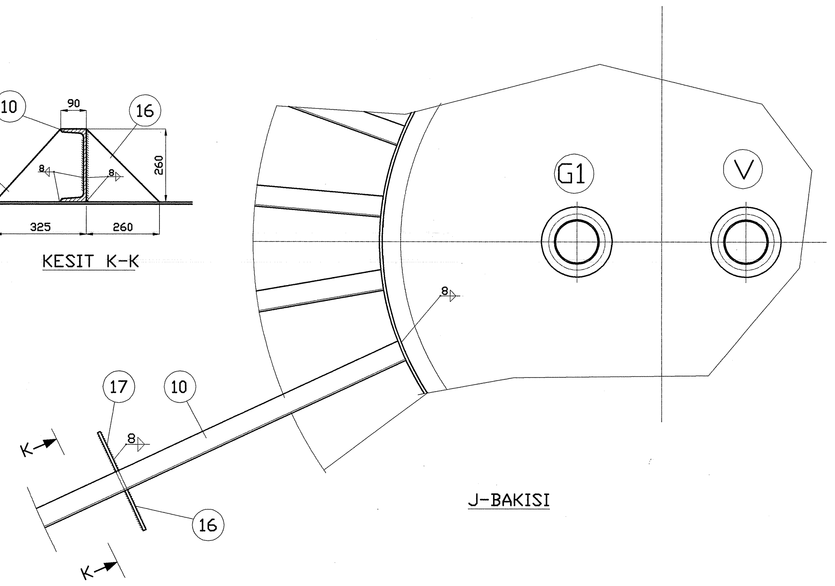


DETAY T
YAKA KAYNAK DETAYI

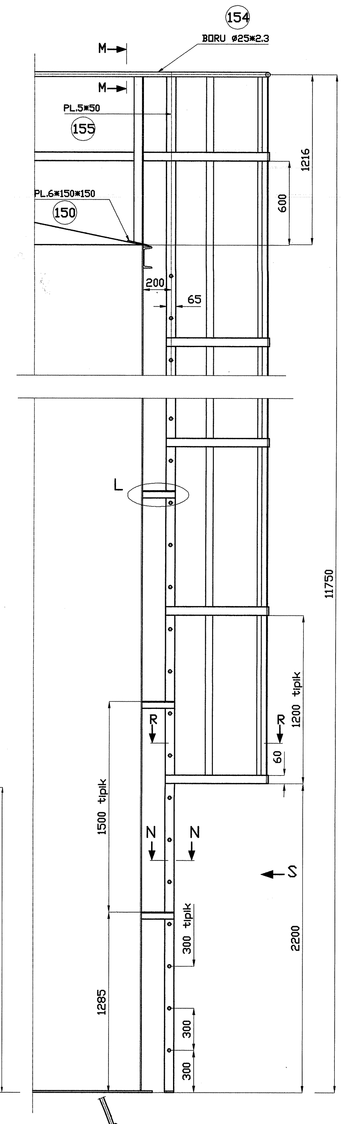


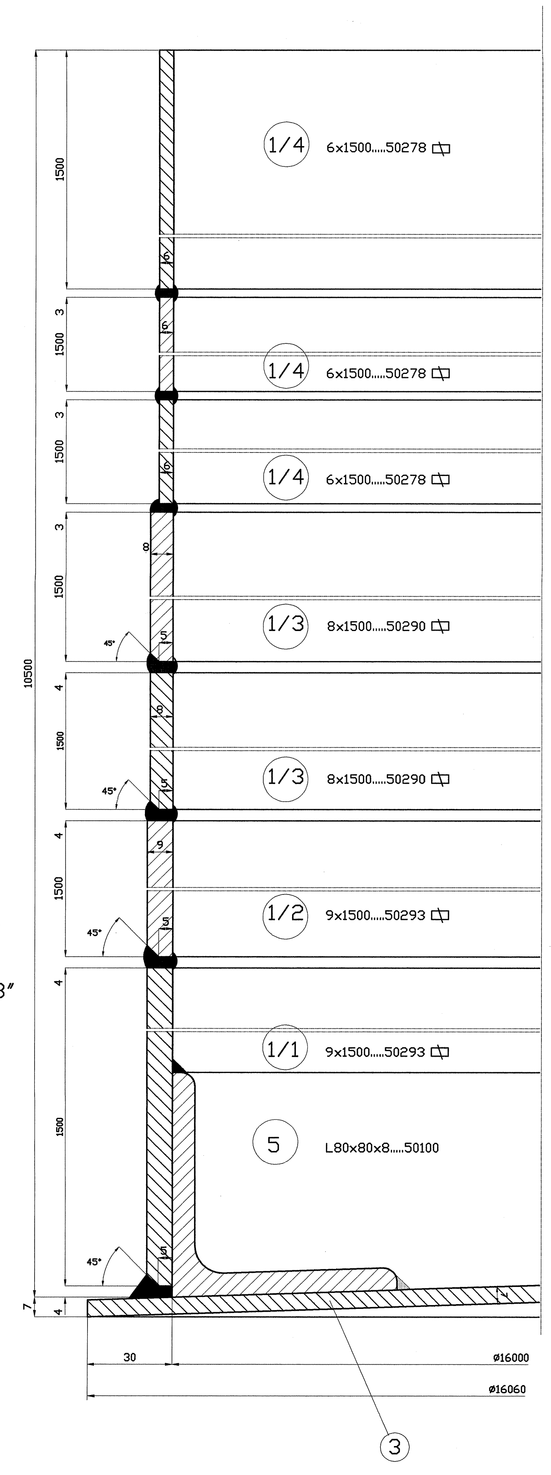


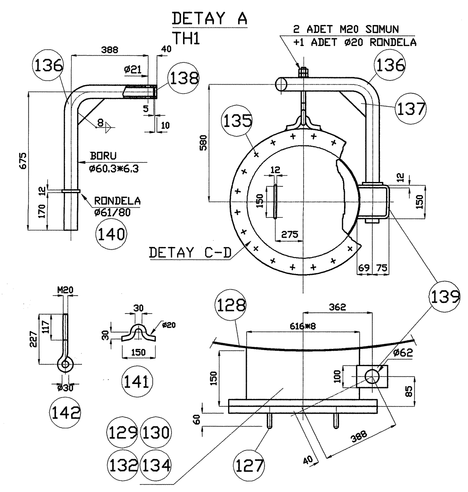
KESIT K-K

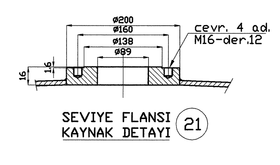


J-BAKISI

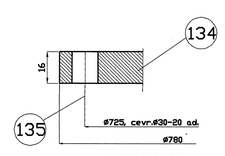




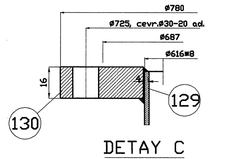




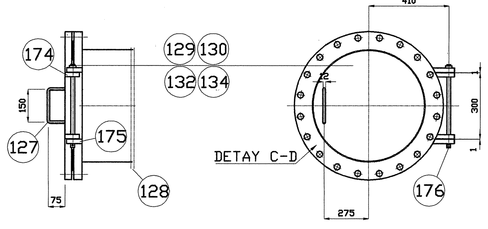
SEVIYE FLANSI
KAYNAK DETAYI

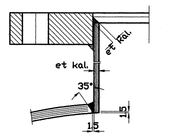


DETAY D

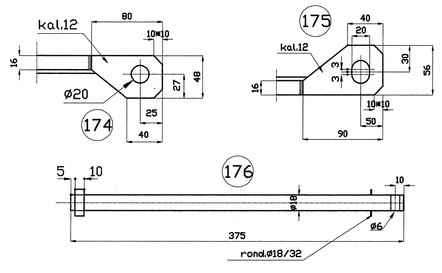


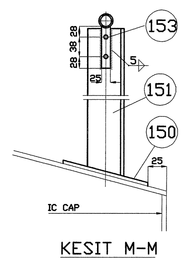
DETAY C



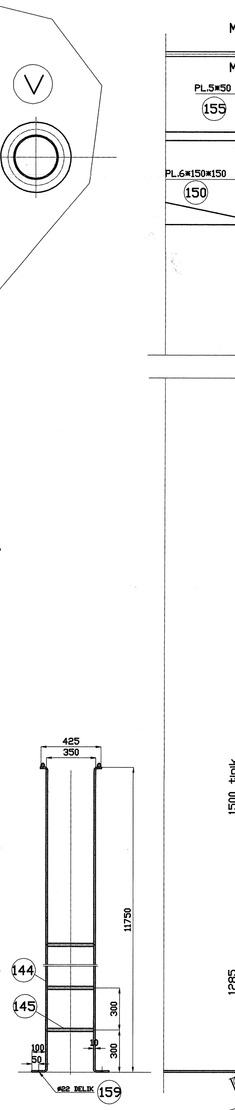


GOVDE+BORU+FLANS
KAYNAK DETAYI

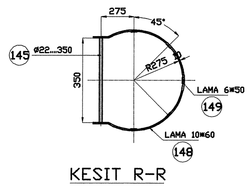




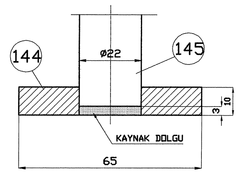
KESIT M-M



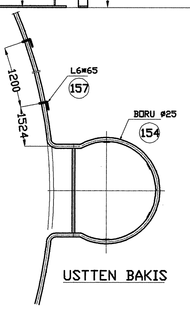
S-BAKISI



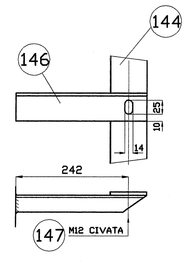
KESIT R-R



KESIT N-N



USTTEN BAKIS



L-BAKISI

MALZEME OZELLIKLERI		DIZAYN VE ISLETME DEGERLERI		
GOVDE	ST37	AKISKAN		SAF ALKOL
UST KONI	ST37	YOGUNLUK	t/m3	0.85
ALT KONI	ST37	HACIM	m3	2000
IC AKSAMLAR	ST37	ISITMA YUZEYI	m2	-
FLANSLAR ND:250	ST37	ISLETME BASINCI	bar	ATMOSFERIK
FLANSLAR ND:250	SERBEST	ISLETME SICAKLIGI GIRIS/CIKIS	°C	ATMOSFERIK
NOZUL BORULARI	ST37	TEST BASINCI	bar	HIDROSTATIK
KOR FLANSLAR	ST37	YUZEY KUMLAMA		KARBON CELIGI
YIKAMA SUYU BORUSU		IZOLASYON		-
AYAKLAR	ST37			
TAKVIYE CEMBERI	ST37			
HARICI CIVATA+SOMUN	KROMAJ	KONTROL		
CONTA		KAYNAKLAR : ultrasonik		X10 + BOYUNA
		STANDARTLAR		TS
		KAYNAK KATSAYISI		0.85
		BUSUNCELER :		
		BOS AGIRLIK	kg	98000
		ISLETME AGIRLIGI	ton	2100

NOZUL VE BAGLANTILAR

YERI	DN	PN	DIS ø BORU	MALZ. YAKALI	DIN	MALZ. FLANS	DIN	FONKSYON
TH2	600	10	616x8	-	-	St37	28025	ADAM GIRME
G1	100	10	114.3x3.2	-	-	ST37	2576	YEDEK+KOR
TH1	600	10	616x8	-	-	St37	28025	ADAM GIRME
D	150	10	168x3.6	-	-	ST37	2576	TAHLIYE
TP	100	10	114.3x3.2	-	-	ST37	2576	TASKAN
L	150	10	-	-	-	ST37	2576	SEVIYE GOSTERG.
V	100	10	114.3x3.2	-	-	ST37	2576	HAVALANDIRMA
B	100	10	114.3x3.2	-	-	ST37	2576	ALKOL CIKISI
A	100	10	114.3x3.2	-	-	ST37	2576	ALKOL GIRISI

GENEL NOTLAR:

1) TUM OLCULER MM. OLARAK VERILMISTIR.
2) SAC KALINLIKLARI MIN. OLARAK KABUL EDILECEKTIR.
3) YUZEYLER:
   -PASLANMAZ MALZEMEDE: TEMIZLEME+PASIFIZE
   -CARBON CELIGI: TEL FIRCA ILE TEMIZLEME+
   EPOKSI ESASLI CINKO-KROMATLI ASTAR BOYA (50 mikron)
   2 KAT EPOKSI ESASLI BOYA (80 mikron)
4) KAYNAK KALINLIKLARI MIN. OLARAK VERILMISTIR.
5) TUM KESKIN KENARLAR MIN. 3 mm KIRILACAKTIR.
6) TUM CONTA YUZEYLERI ▽▽ ISLENECEKTIR.
7) TUM NOZULLARIN KARSI FALNSI+CONTASI+SOMUN VE CIVATASI BIRLIKTE VERILECEKTIR.

POZ.	AD.	TANIMI	MALZEME	OLCULERI
176	1	PIM VE 2 KUPILYA	St 37	ø18x375
175	2	KULAK	St 37	-
174	2	KULAK	St 37	-
-	-	-	-	-
159	2	ANKERAJ CIVATASI	St 37	M20x65
156	-	-	-	-
155	1	KORKULUK LAMASI	St 37	6x50.....50000
154	1	KORKULUK BORUSU	St 37	ø44.3x3.2.....50000
153	66	CIVATA (KROMAJLI)	St 37	M8x25 SOMUNU ILE
152	33	KORKULUK TUTUCU	St 37	6x25x100
151	33	DIKME KOSEBENT	St 37	6x65x65.....1200
150	33	DIKME PAPUCU	ST 37	5x100x100
149	5	MERDIVEN LAMALARI	St 37	6x50x8850
148	6	MERDIVEN CEMBERI	St 37	10x60x1500
147	12	CIVATA (KROMAJLI)	St 37	M12x35 SOMUNU ILE
146	12	MERDIVEN TUTUCULAR	ST 37	6x50x50.....274
145	30	BASAMAK	St 37	ø22x362
144	2	MERDIVEN DIKMELERI	St 37	10x65x11750
-	-	-	-	-
142	1	GOZLU CIVATA	St 37	M20x280 2 ad. SOMUNU ILE
141	1	CENGEL	St 37	ø12.....300
-	-	-	-	-
138	1	TAPA RONDELA	St 37	ø47 kal.6
137	1	KOL TAKVIYESI	St 37	8x120x340
136	1	TUTUCU KOL	St 37	BORU ø60.3x6.3
135	40	SAPLAMA (KROMAJLI)	-	M27x105 2 ad. somunu ile
134	2	KOR FLANS	St 37	ø780 kal.16
133	-	-	-	-
132	2	CONTA (asbestsiz)	-	ø780/600 kal.3
131	-	-	-	-
130	2	FLANS TH1, TH2	ST37	ø780/620 kal.16
129	2	BORU TH1, TH2	ST37	ø616x8.....166
128	2	GOVDE YAKASI	ST37	ø1168/620 kal.5
127	2	TUTAMAK	ST37	ø12.....300
67	-	-	-	-
50	5	FLANS A, B, V, TP, G1	ST37	DN100, PN10, DIN 2576
49	3	BORU A, B, TP	ST37	ø114.3x32.....165
48	2	BORU V, G1	ST37	ø114.3x32.....460
36	-	-	-	-
35	1	FLANS D	ST37	DN150, PN10, DIN2576
34	1	BORU D	ST37	ø168x4.5.....160
33	1	TAKVIYE YAKASI	ST37	ø400/171 kal.8
23	-	-	-	-
22	-	-	-	-
21	1	SEVIYE FLANSI L	ST37	ø200/89.....16
20	1	TOPRAKLAMA NIPELI	ST37	ø40...40
19	-	-	-	-
18	-	-	-	-
17	168	TAKVIYE LAMALARI	ST37	10x260x325
16	168	TAKVIYE LAMALARI	ST37	10x260x260
11	24	CATI TAKVIYESI	ST37	10x90x210x875
10	24	CATI KABURGASI	ST37	U260.....7325
09	1	CATI ORTA RINGI	ST37	U260/ø2000
08	1	TAVAN CEMBERI	ST37	10x100x50670
07	24	TAKVIYE	ST37	12x70x238
06	1	GOVDE UST CEMBERI	ST37	U260.....50300
05	1	TABAN RINGI	ST37	L80x80x8.....50100
04	-	KAYNAK LAMALARI	ST37	5x100x600
03	1	TABAN CACI	ST37	ø16060x7
02	1	TAVAN SACI	ST37	ø16650 Kal.6
01	1	GOVDE	ST37	MUHTELIF

DEG.NO	DEGISIKLIK	TARIH	IMZA

	TARIH	ISIM
PROJE	20.04.95	M.DINCER
KONST.		
RESIM		
KONTROL	25.04.96	F.UCLEROGLU

AMASYA SEKER FABRIKASI A.S.

PROSES TEKNIK A.S.
Sogüt sokak No:35/9 Sihhiye-ANKARA
Tel: 0.312.4353393 Fax: 0.312.4336589

OLCEK: 1/5 1/15 1/20 1/25 1/50 1/75

FERMANTASYON TESISI
T2017 TANKI KOMPLESI
VE DETAYLARI

REV :

RESIM NO: T2017