

REQUIREMENTS FOR DESIGN DRAWINGS  
OF CENTRIFUGES

Project No.:	Location: – Kansas City	Spec. No.:
Asset No(s):		Item No(s): See Section 1.1 of Specification
As a minimum, the requirements for Drawings of centrifuges shall conform to the following:		
<ol style="list-style-type: none"> <li>1. Computer Aided Design Drawings (CADD), generated with Microstation J, are required. In addition three sets of drawings shall be submitted for review / comment, approval, and as-built.</li> <li>2. A separate set of drawings is required for each piece of equipment ordered.</li> <li>3. Elevation dimensions shall be based from top of inertia block. Other dimensions shall be referenced from centerline of basket.</li> <li>4. Plan view dimensions locating supports and support bolting shall be dimensions that can be measured, i.e. internal arc length, external arc length, chord length, etc..</li> <li>5. Miscellaneous detail information required: <ol style="list-style-type: none"> <li>5.1 Top / Bottom: Material, type, thickness, etc. as applicable.</li> <li>5.2 Top / Bottom mounted connections: Nozzle neck to flange and nozzle neck to top/bottom, material, weld preparation and weldments. Details are required for each nozzle.</li> <li>5.3 Housing: Material, thickness, weld preparation and weldments as applicable.</li> <li>5.4 Housing mounted connections: Nozzle neck to flange and nozzle neck to body, material, weld preparation and weldments. Details are required for each nozzle size ordered.</li> <li>5.5 Anchor Bolt Plan: <ol style="list-style-type: none"> <li>5.5.1 Size, number and location of all bolt holes.</li> <li>5.5.2 Location of each bolt hole as dimensioned from the drive end.</li> <li>5.5.3 Anchor loadings.</li> </ol> </li> <li>5.6 Externals: (Inertia Block, Solids Discharge Screw Conveyor, Vibration Isolators, Controller, VFD System, Vibration Monitor, Lubrication Unit, Hydraulic Unit, Motors, V-Belt Drives, TFKR Controller, Pad for Nuclear Densitometer, grounding lugs, lifting lugs, etc.). Material, size, thickness, location, weldments, etc as applicable shall be shown on the main centrifuge drawing. Additional drawings to fully detail each external component shall be provided.</li> <li>5.7 Internals: (Filter Basket, Shaft, Seal, Bearings, Feed Pipe, Backwash Pipe, Wash Pipe, Peeler Mechanism, etc.). Material, size, thickness, location, weldments, etc as applicable shall be shown on the main centrifuge drawing. Additional drawings to fully detail each external component shall be provided.</li> <li>5.8 Weld details: <ol style="list-style-type: none"> <li>5.8.1 Weld preparation.</li> <li>5.8.2 Weld process, or tie into the weld map.</li> <li>5.8.3 Weld size - fillet, weld penetration, groove.</li> <li>5.8.4 Non destructive examination.</li> <li>5.8.5 Back chip - Procedure.</li> </ol> </li> </ol> </li> </ol>		