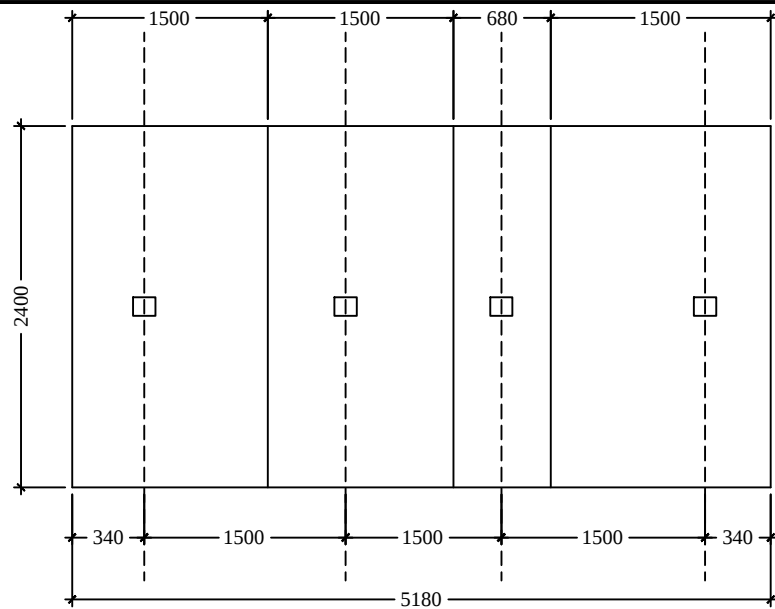
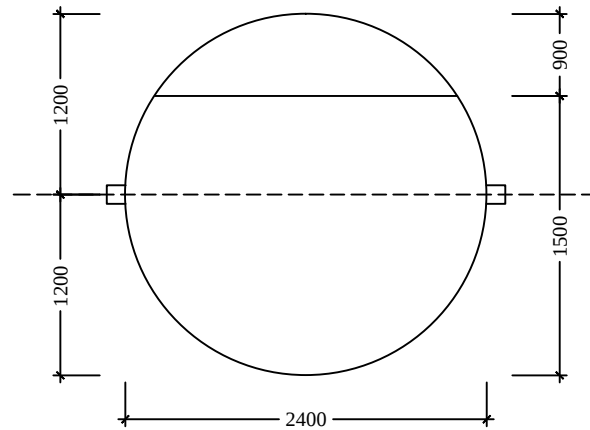




SHELL PLATE



END PLATE

ARRANGEMENT OF SHELL AND END PLATE

BILL OF MATERIAL & FITTINGS FOR TANKS

SR. NO.	DESCRIPTION	NOS REQUIRED
1	6mm Tth. SHELL PLATE TYPICAL ARRANGEMENT - 1500mm x 6300mm	AS PER ARRANGEMENT OF SHELL AND END PLATE SHOWN
2	8mm Tth. END PLATE TYPICAL ARRANGEMENT - 1500mm x 6300mm	
3	ISA 90 x 90 x 8mm ANGLE STIFFENERS 2140 LONG	2
4	ISA 90 x 90 x 8mm ANGLE STIFFENERS 1790 LONG	4
5	ISA 40 x 40 x 6mm ANGLE STIFFENERS 7600 LONG	2
6	6mm Tth. MS PAD PLATE FOR DIP ROD TO BE WELDED INSIDE SHELL PLATE OF SIZE 200mm x 200mm	1
7	6mm Tth. MS PAD PLATE FOR MANHOLE NECK - 340mm x 180mm	2
8	6mm Tth. MS PAD PLATE FOR MANHOLE NECK - 500mm x 2040mm	2
9	10mm Tth. 742 dia MS PLATE FOR MANHOLE COVER PLATE (WITHOUT JOINTS)	2
10	ISA 65 x 65 x 8mm MANHOLE COVER NECK ANGLE RING (ID - 612mm & OD - 742mm) WITH 3mm Tth. FIRE FLY GASKET	2
11	STANDARD LIFTING EYE 40mm INTERNAL dia (AS PER DETAILS)	2
12	EARTHING BOSS CONNECTION (AS PER DETAILS)	2
13	100mm dia DIP PIPE - MS HEAVY DUTY PIPE 2600mm LONG INSIDE & 500mm LONG OUTSIDE THE TANK (IN TWO PIECES), INSIDE PIPE TO BE THREADED AT ONE END, OUTSIDE PIPE TO BE THREADED AT BOTH ENDS, BOTTOM OF DIP PIPE TO BE CHAMFERED AT 45° DEGREES	1
14	50mm dia DIP PIPE - MS HEAVY DUTY PIPE 2000mm LONG INSIDE & 500mm LONG OUTSIDE THE TANK (IN TWO PIECES), INSIDE PIPE TO BE THREADED AT ONE END, OUTSIDE PIPE TO BE THREADED AT BOTH ENDS.	1
15	50mm dia SUCTION PIPE - MS HEAVY DUTY PIPE 2600mm LONG INSIDE & 150mm LONG OUTSIDE THE TANK (IN TWO PIECES), INSIDE PIPE TO BE THREADED AT ONE END, OUTSIDE PIPE TO BE THREADED AT BOTH ENDS.	3
16	80mm dia VENT PIPE - MS HEAVY DUTY PIPE 100mm LONG INSIDE & 150mm LONG OUTSIDE THE TANK (IN TWO PIECES), INSIDE PIPE TO BE THREADED AT ONE END, OUTSIDE PIPE TO BE THREADED AT BOTH ENDS.	1
17	80mm dia AUTOMATION PIPE - MS HEAVY DUTY PIPE 100mm LONG INSIDE & 500mm LONG OUTSIDE THE TANK (IN TWO PIECES), INSIDE PIPE TO BE THREADED AT ONE END, OUTSIDE PIPE TO BE THREADED AT BOTH ENDS.	1
18	100mm dia STP PIPE - MS HEAVY DUTY PIPE 40mm LONG INSIDE & 150mm LONG OUTSIDE THE TANK, WELDED WITH CLASS 150 SLIP ON FLANGE ON THE OUTSIDE FOR FIXING SUBMERSIBLE TURBINE PUMP (STP).	1
19	80mm dia x 90mm LONG MS HEXAGONAL HEAD BUSHING (80 OD), THREADED ON BOTH SIDE TO SUIT 50mm dia HD PIPE (DIP & SUCTION) ALONG WITH 115mm LONG MS SOCKET THREADED TO SUIT THE BUSHING (WELDED TO THE MANHOLE COVER PLATE).	4
20	15mm MS HEXAGONAL HEAD BUSHING (110 OD) THREADED ON BOTH SIDE TO SUIT 80mm dia HEAVY DUTY MS PIPE (VENT & AUTOMATION) ALONG WITH 115mm LONG MS SOCKET THREADED TO SUIT THE BUSHING (WELDED TO THE MANHOLE COVER PLATE)	2
21	15mm MS HEXAGONAL HEAD BUSHING THREADED ON BOTH SIDES TO SUIT 100mm dia HEAVY DUTY MS PIPE (FILL) ALONG WITH 140mm LONG MS SOCKET THREADED TO SUIT THE BUSHING (WELDED TO THE MANHOLE COVER PLATE)	1
22	BRASS CAP WITH LOCKING ARRANGEMENT FOR 50mm dia DIP PIPE (AS PER DETAILS)	1
23	HOLDING DOWN BRACKETS (AS PER DETAILS)	6
24	25mm dia BOLT WITH HEXAGONAL HEAD, 500mm LONG WITH R.H. THREADS	6
25	225mm LONG TURN BUCKLE (AS PER DETAILS)	6
26	25mm dia BOLT WITH HEXAGONAL HEAD, 200mm LONG WITH L.H. THREADS	6
27	ISA 75 x 75 x 6mm Tth. - 200mm LONG (USED IN HOLDING DOWN ARRANGEMENT)	6
28	12mm dia RIBBED TOR STEEL HOLDING DOWN BARS 2000mm LONG	12
29	ENTRY BARRIER MADE OF 25 x 5mm MS FLAT (AS PER DETAILS) FOR MANHOLE (1 - WELDED AT SITE & 1 - FOR WELDING AT SITE)	2
30	12mm SQUARE ALUMINUM DIP ROD 3400mm LONG GRADUATED ON ONE SIDE IN CM & 1/5 CM	1



Lanka IOC

Lanka IOC PLC

FABRICATION DETAIL FOR 22.5KL TANKS

DRAWN BY :- F. C. P. D.	DATE :- 21.08.2025	SHEET NO :- 02	SEAL :-
SCALE :- N. S. T.	DRAWING NO :- LIOC/ENGG/TANK FAB/ 22.5KL - 01	REVISION :-	
CHECK AND VERIFIED :-	APPROVED :-		