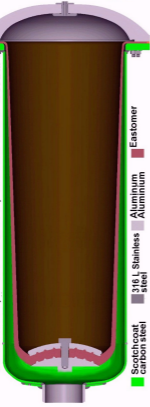


Surge and Water Hammer Accumulators

"SURGE-ACC" From stock Inventory

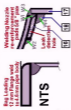
Surge-Acc.com
Americas Support@surge-acc.com
China fangshu_meng@bjhr.com
India periyathiruvaiyil@gmail.com
Scan, hari.castleman@foxexperts.nl
S. East Asia cynthiatechno@gsatel.com
Singapore
Western Europe ej@ll.co.uk

SURGE-ACC, 6" Model: SAC 6", 175 Liter 20 bar & 40 bar

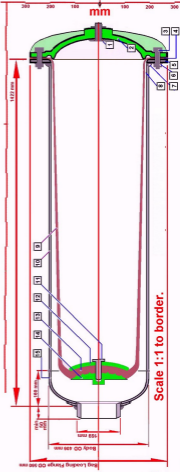


- Scotchcoat carbon steel
- 316 L Stainless steel
- Aluminum
- Eastomer

For Smaller Sizes
Please goto associate :-
www.ShockGuard.co.UK
CLICK ON INVENTORY



Surge Accumulators Are Normally Mounted Vertically



For print -
A4 or 8.5x11
paper

BILL OF MATERIALS FOR 175 Liter SURGE-ACC 6" - PIPES

20	
19	
18	W4 14 mm fillet weld
W3	Seal weld the inside top of the nozzle pipe to the SE head hole.
17	Insert 169 mm OD 6" Sch 40 nozzle pipe Minimum length 55 mm
W2	Fillet weld pad circumference to head 100 % GTAW, using 309ss filler.
W1	Weld pad with weep hole, to 2:1 SE head, 100 % GTAW, using 309ss filler.
16	Nozzle re-enforcement pad 170mm hole with internal weld prep
15	2:1 SE head from SA516 Gr 70 with 37.5° weld bevel for full penetration & dress.
14	222 mm Ø cast Aluminum with epoxy coat 1 mm thick on anti-extrusion plate
13	Concave gas bag end profile prevents anti-extrusion plate premature closure
12	226 mm Ø cast Aluminum with epoxy bond coat 1 mm thick
11	M 24 or 1" UNF carbon steel hex bolt
10	16" Sch 10s pipe by 1290 mm long
9	Gas bag thicknesses - wall taper. Flange 6 mm , top corner 4 mm , bottom corner 8 mm, concavity 10 mm.
8	If long seam welded 16" Sch 10 pipe dress weld smooth for elastomer gas bag
7	309 ss full penetration & fillet weld dress off weld root to smooth for bag
6	To prevent thread galling plated carbon steel nuts
5	396 mm ID, 558 mm OD, 22 mm thick top flange, 8 mm rad. top inside corner. PVQ plate SA 516 Gr 60/70
	Brass or Aluminum wire spacer 4.7 mm gage.
4	Gas bags, from Nitrile for hydrocarbons , EthylenePropylene ("EPDM") for water etc, Fluorinated for difficult compatibilities. 555mm Top flange clamp sealed, Heles punch 18mm, con- cave bottom, OAL 1310 mm 355 mm top, 325 bottom. Taper wall thickness (see 9)
3	24 bolts, 0.5" UNC, or M12, 304 / 18-8 stainless + standard small washers on 480 mm PCD. Torque setting 20Nm
2	Gas bag loading manway cover bolt flanged 2:1 SE Head, aluminum coated 1mm thick epoxy bonded
1	Air /Nitrogen cushion gas connection, SA 479 (316L) stainless bar. Normally 1/2" F x 20 TPI, 1/2" FNPT max