



LIDCO, Pars SEE Zone, Assaluyeh,
Integrated Methanol and Ammonia
Plant 3000 MTPD MeOH / 900 MTPD NH3 PROJECT



Detail Drawings for Pulsation Dampers

Document No. 17735-23B

Project No.	Vendor Doc.	P.O. No.	Department	Document Type	Serial No	Revision	Page
N278	VD	6019	ME	DWG	0025	03	Page 1 of 6

**Airpack B.V. - Air Compressor –
Integrated Methanol and Ammonia Plant
17735-COM Detail Drawings for Pulsation Dampers (K020)**

03	16-09-2024	Issued for Approval	S.K.	J.J.	S.K.
02	15-05-2024	Issued for Approval	S.K.	J.J.	S.K.
01	21-02-2024	Issued for Approval	S.K.	J.J.	S.K.
REV.	DATE	DESCRIPTION	DRAWN	CHECKED	APPROVED

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Detail Drawings for Pulsation Dampers

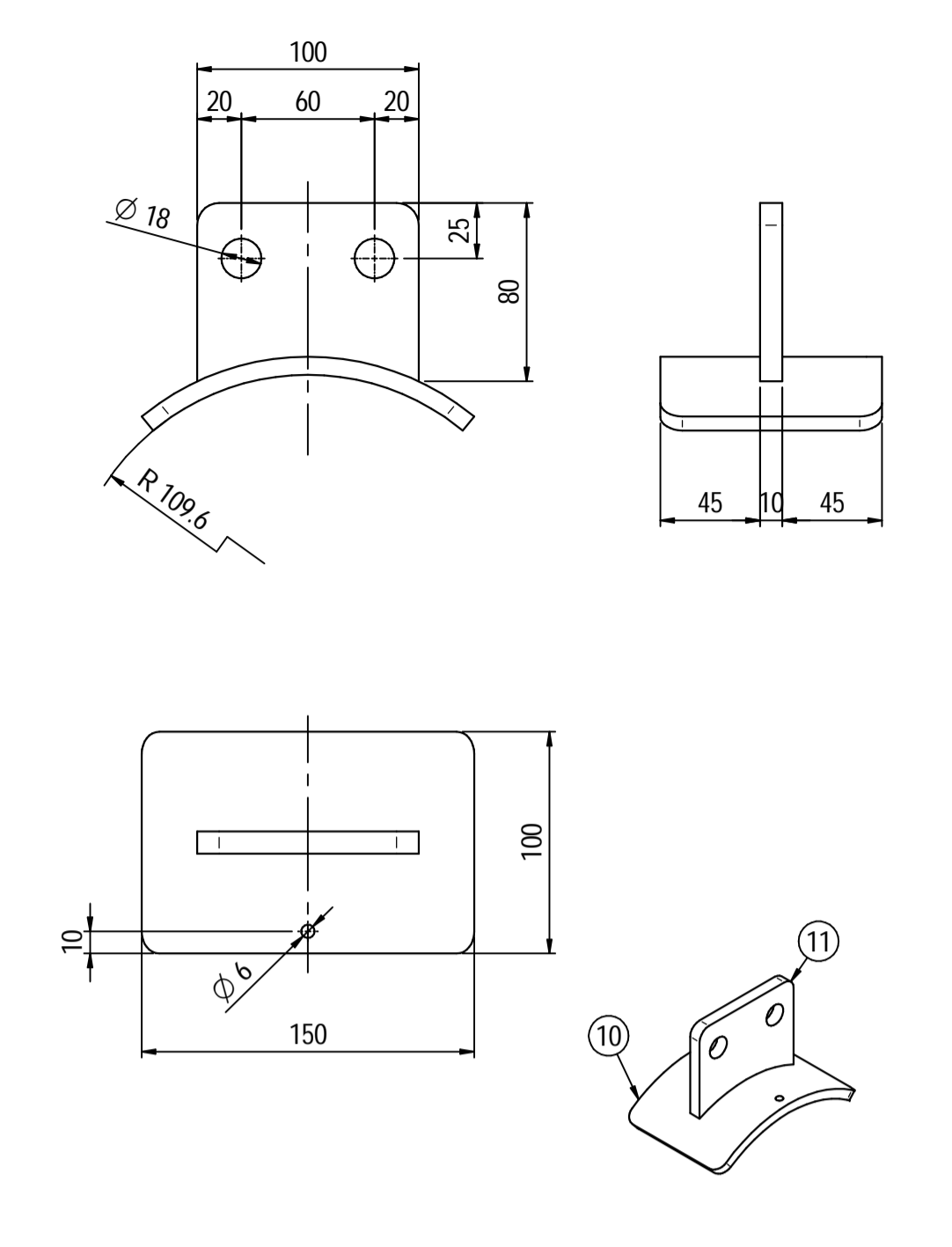
Document No. 17735-23B

Project No.	Vendor Doc.	P.O. No.	Department	Document Type	Serial No	Revision	Page
N278	VD	6019	ME	DWG	0025	03	Page 2 of 6

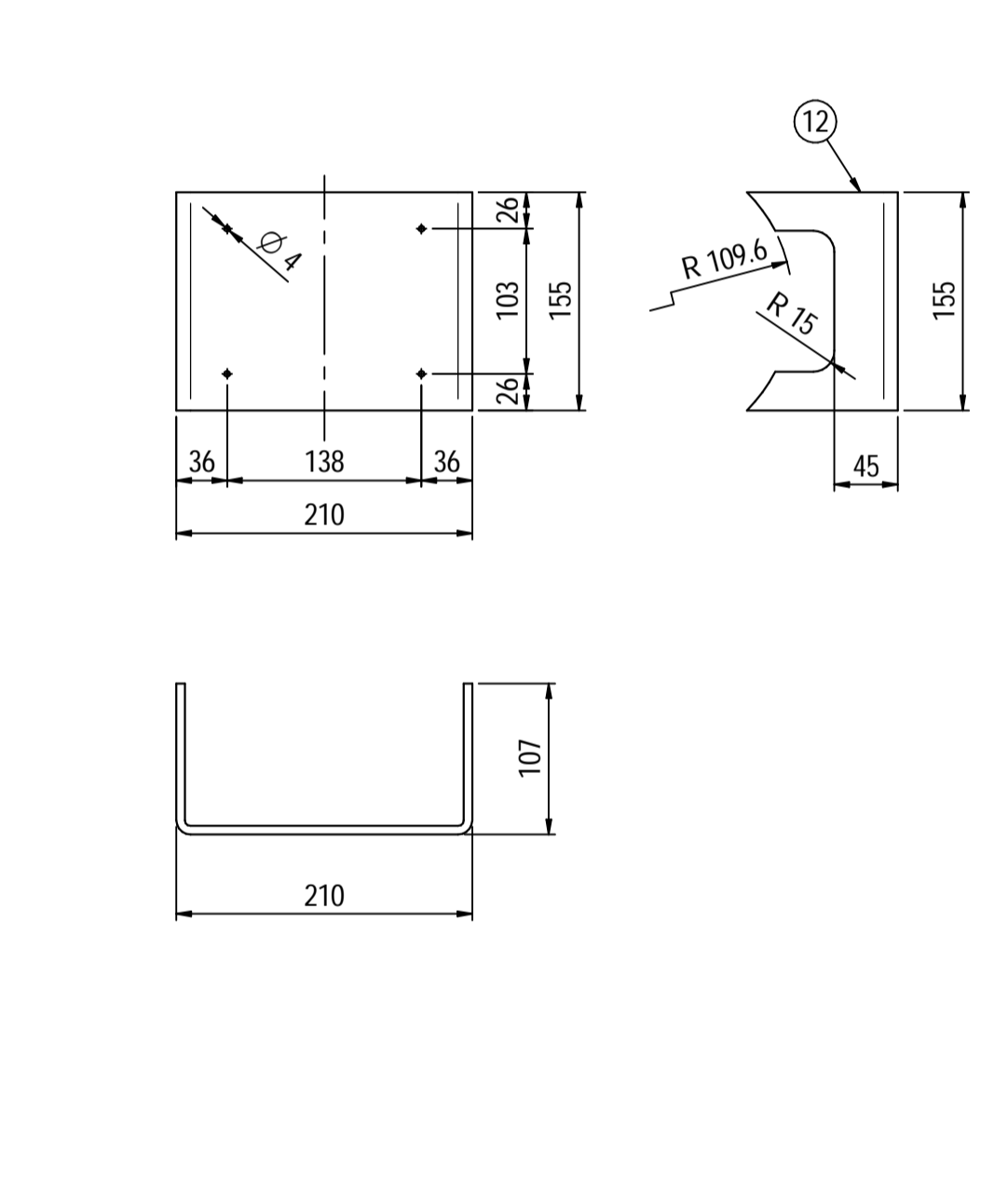
LIST OF REVISED PAGES

Rev. Page	01	02	03	04	05	Rev. Page	01	02	03	04	05	Rev. Page	01	02	03	04	05	Rev. Page	01	02	03	04	05
1	X	X	X			26						51						76					
2	X	X	X			27						52						77					
3	X	X	X			28						53						78					
4	X	X	X			29						54						79					
5	X	X	X			30						55						80					
6	X	X	X			31						56						81					
7						32						57						82					
8						33						58						83					
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10						35						60						85					
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12						37						62						87					
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20						45						70						2					
21						46						71						3					
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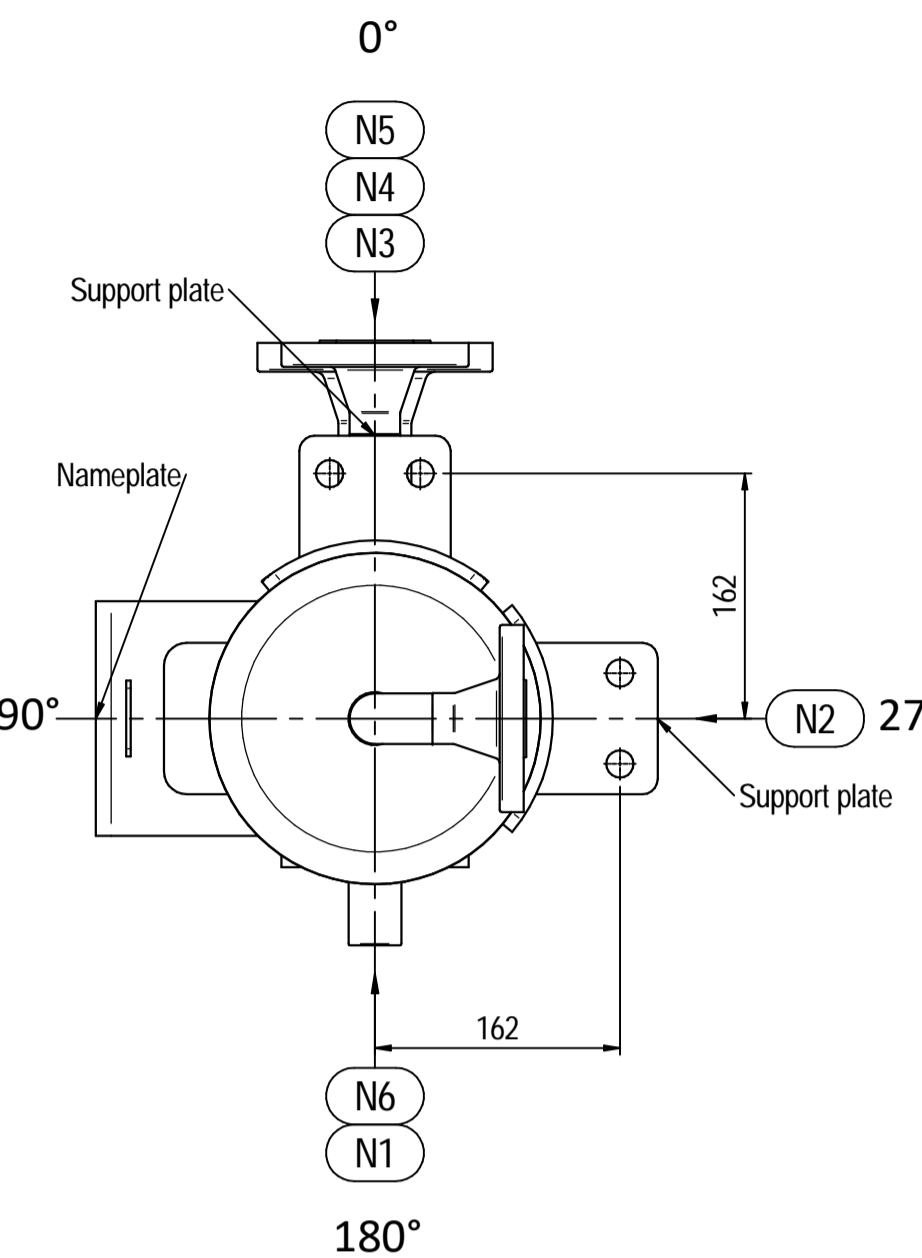
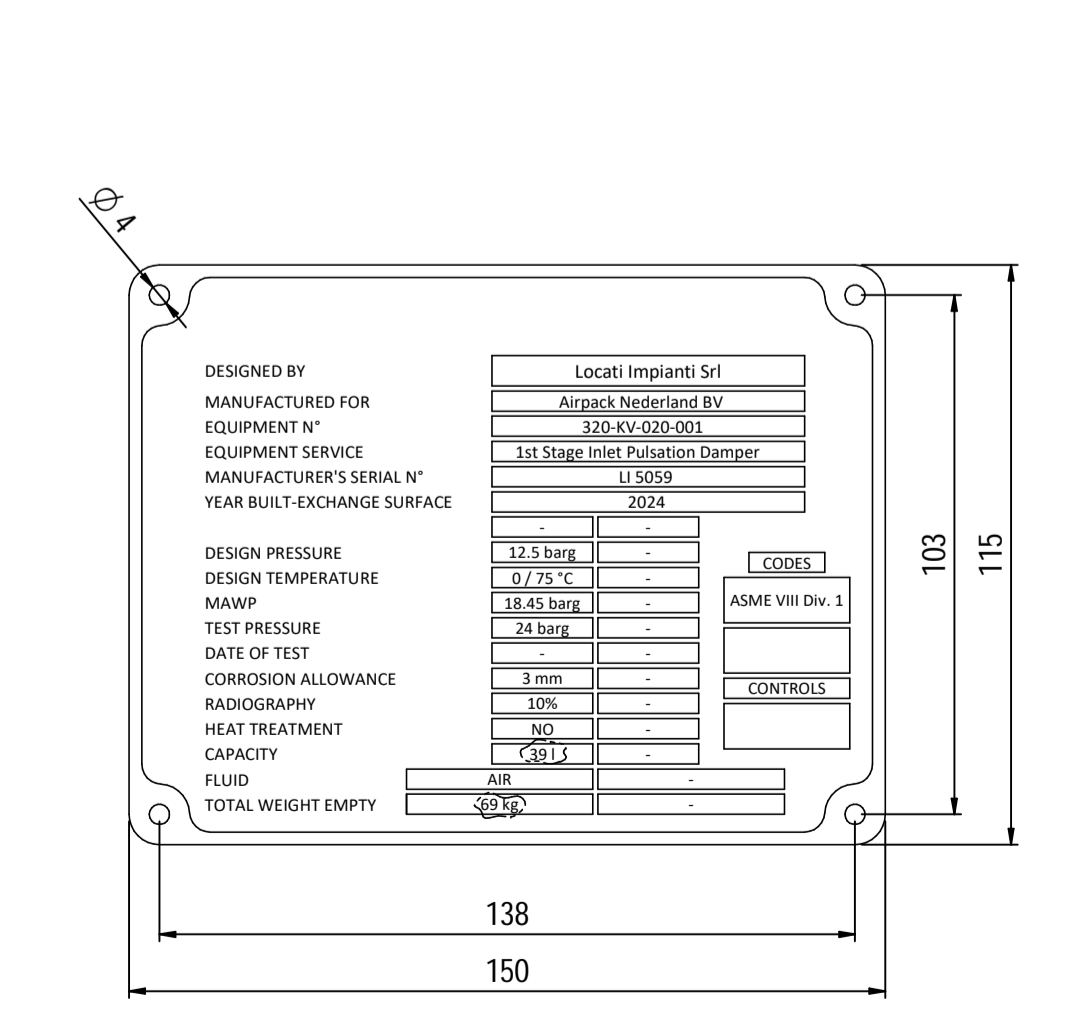
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Scale 1 : 3



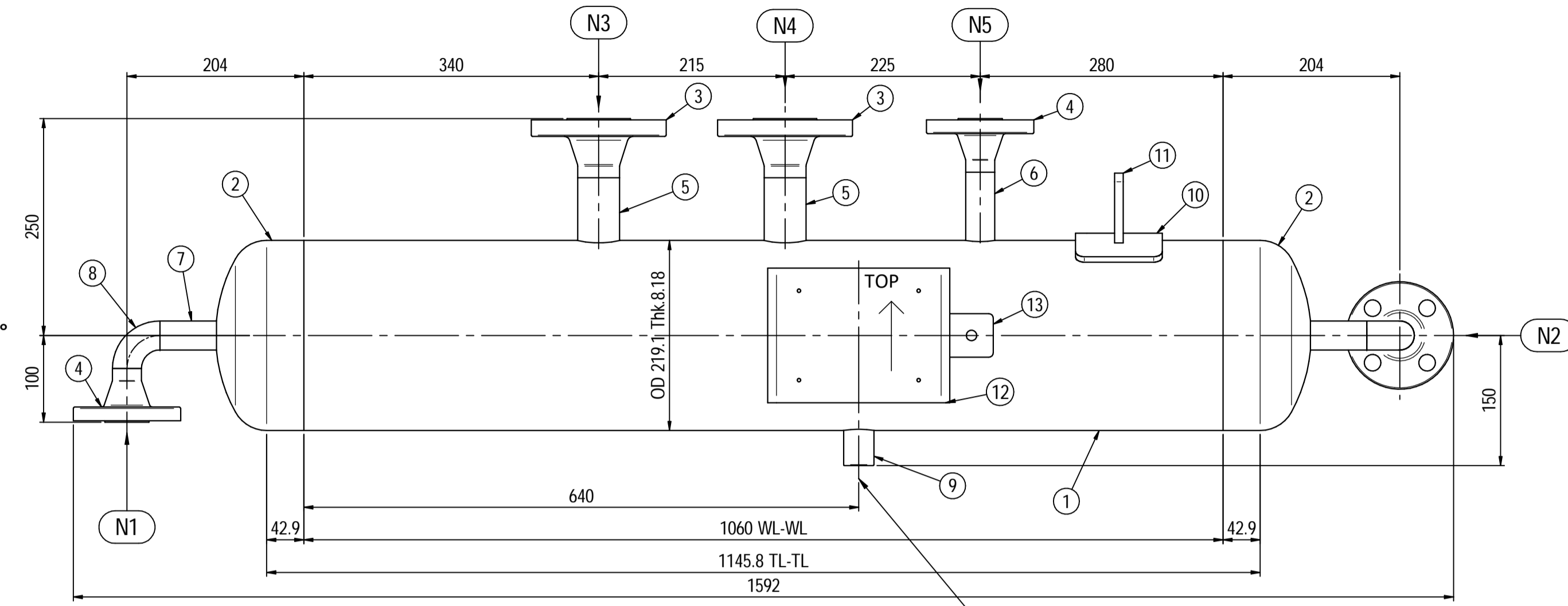
Nameplate detail
Scale 1:5



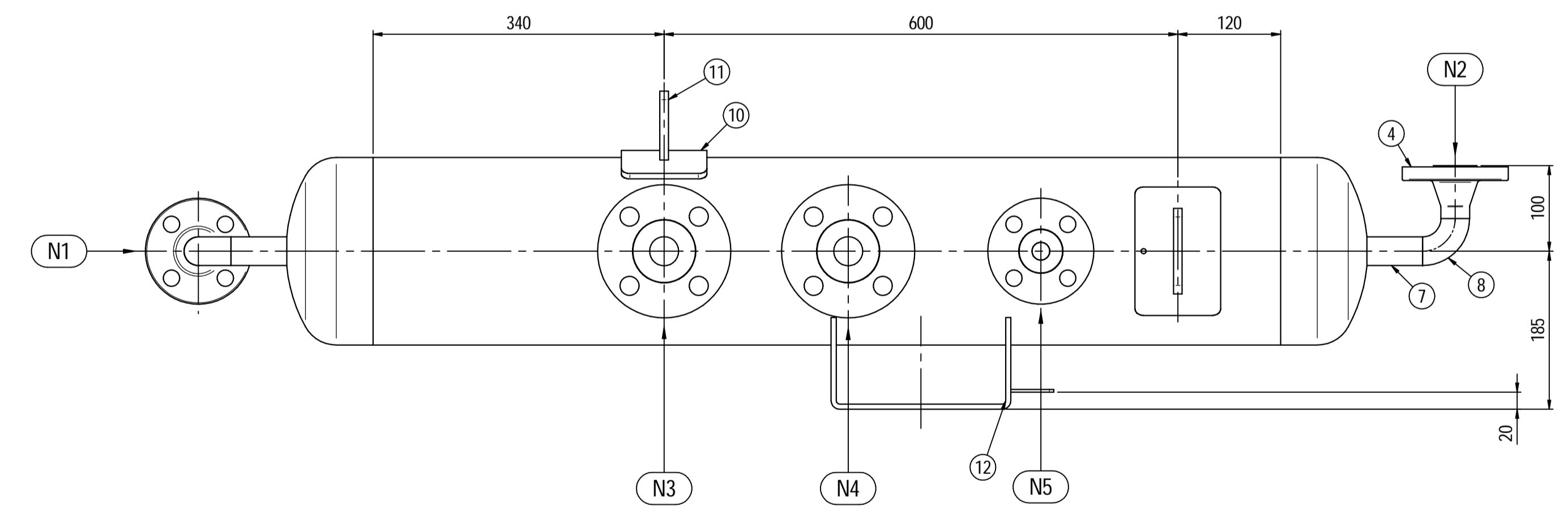
Nameplate detail
scale 1:1.5



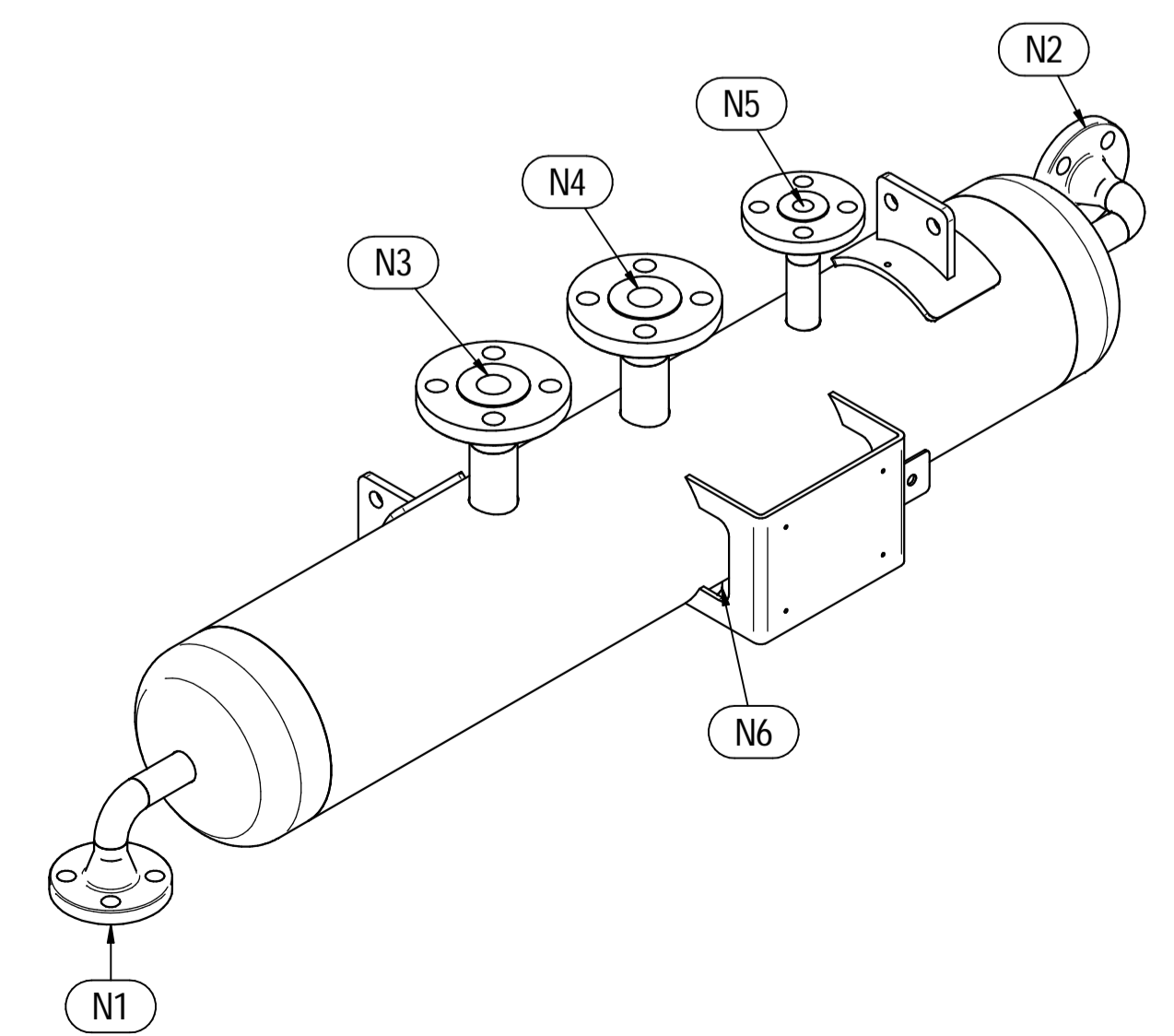
ORIENTATION VIEW



ELEVATION VIEW



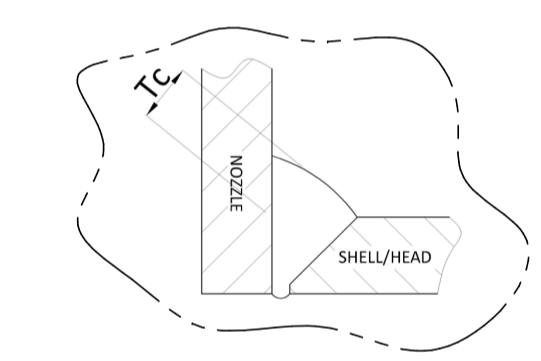
PLAN VIEW



ISOMETRIC VIEW

Pos.	QTY	Description	Material	Cert.
1	1	Shell by Seamless Pipe 8" Sch.40 L=1060	SA106 Gr.B	3.1
2	2	Cap 8" Sch.40	SA234 WPB	3.1
3	2	Flange 1 1/2" WN #300 RF Sch.160	A105	3.1
4	3	Flange 1" WN #300 RF Sch.160	SA105	3.1
5	2	Seamless Pipe 1 1/2" Sch.160 L=75	SA106 Gr.B	3.1
6	1	Seamless Pipe 1" Sch.160 L=80	SA106 Gr.B	3.1
7	2	Seamless Pipe 1" Sch.160 L=73	SA106 Gr.B	3.1
8	2	Seamless elbow 1" 90° LR Sch.160	SA234 WPB	3.1
9	1	Coupling 1/2" NPT #6000	A105	3.1
10	2	Pad by pipe 100 x 150 Thk.8.18	SA106 Gr.B	
11	2	Support plate 100 x 80 Thk.10	SA516 70	
12	1	Nameplate support by plate 403 x 155 Thk.6	SA516 70	
13	1	Earthing plate 50 x 40 Thk.3	SA240 TP316L	

- Note:**
- Governing measurement S.I. unless otherwise specified
 - Flange bolt holes have to be straddled from main vessel center line in plan & vertical & horizontal centreline in elevation
 - Material: certification 3.1 EN 10204
 - All internal edge shall be rounded off
 - Nozzle flanges in accordance with ASME B16.5: 2020
 - Flange fittings in accordance with ASME B16.9: 2018
 - All fillet welds not detailed on "WELDING MAP" or drawing shall have the weld throated equal to 0.7 times the minimum thickness to be welded
 - All welds are continuous except where indicate
 - Delated
 - The nameplate ise in SS316 and is laser engraved
 - Non corrosive service, no inspection opening per UG-46(a)
 - On support hexagonal bolts DIN 933, class 8.8 shall be use (Airpack scope)



ITEM	QTY	SERVICE	SIZE	O.D.	THK	RATING	TYPE	FACE	O.D.	THK.	Tc
N6	1	DRAIN	1/2"	38.1	8.38	#6000	NPT-F	-	-	-	8±10
N5	1	PSV CONNECTION	1"	33.4	6.35	#300	WN RF	-	-	-	8±10
N4	1	TEMPERATURE GAUGE	1 1/2"	48.3	7.14	#300	WN RF	-	-	-	8±10
N3	1	TEMPERATURE TRANSMITTER	1 1/2"	48.3	7.14	#300	WN RF	-	-	-	8±10
N2	1	AIR OUTLET	1"	33.4	6.35	#300	WN RF	-	-	-	8±10
N1	1	AIR INLET	1"	33.4	6.35	#300	WN RF	-	-	-	8±10

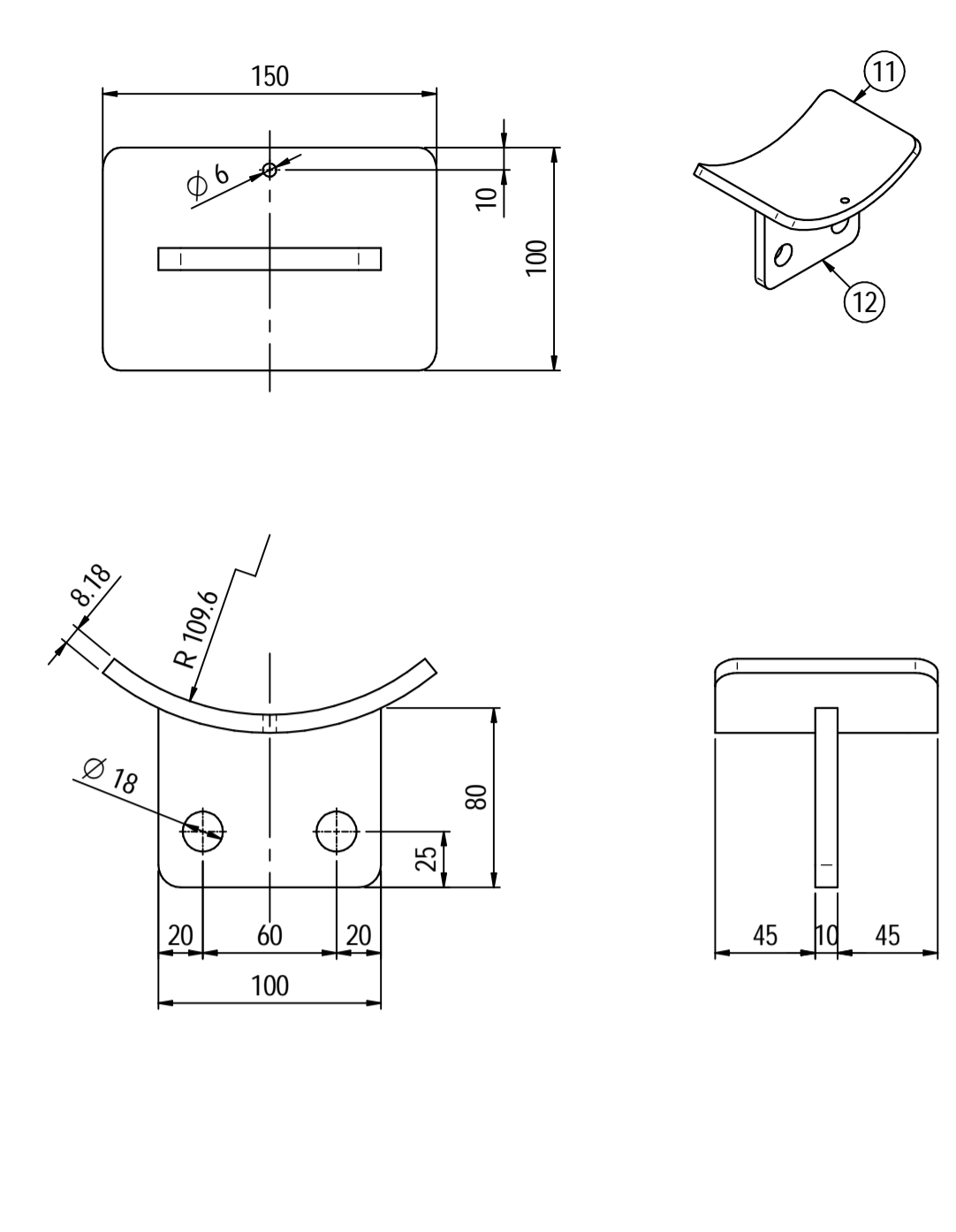
ITEM	Qtà	SERVIZIO	NPS/DN	O.D.	THK	RATING	TYPE	FACE	O.D.	THK.
							FLANGIA			
							FLANGIA			
							FLANGIA			

DATI DI PROGETTO / Design data		COLLAUDO / Test	
FLUIDO	Air	COLLAUDO	Irqa Inspection Iberia SA
Fluid	Test	Test	
STATO FISICO DEL FLUIDO	Gas	PED	N/A
Physical state of fluid			
CODICE DI CALCOLO	ASME VIII Div.1 Ed.2021		
Construction code			
PRESSIONE DI ESERCIZIO	9.5 barg	SERVIZIO LETALE	
Operating pressure		Lethal service	NO
PRESSIONE DI PROGETTO	12.5 barg	X-RAY	
Design pressure		RT examination	Spot (10%)
PRESSIONE ESTERNA	NO	LIQUIDI PENETRANTI	
External pressure		Dye penetrant extension	NO
PRESSIONE DI PROVA IDRAULICA	24 barg	ULTRASUONI	
Hydraulic test pressure		Ultrasonic extension	NO
TEMPERATURA DI ESERCIZIO	5 - 46 °C	CONTROLLO MAGNETOSCOPICO	
Operating temperature		Magnetic particle examination	NO
TEMPERATURA DI PROGETTO	75 °C	TALLONE DI SALDATURA	
Design temperature		Weld test coupon	NO
SOUVRANETALLO DI CORROSIONE	3 mm	PROCEDIMENTO DI SALDATURA	See doc. C230048WBK009
Corrosion allowance		Welding procedure	
CAPACITA'	39 l	TIPO DI FONDO	
Capacity		Head type	CAP
EFFICIENZA GIUNTI	0.85	FORMATURA FONDO	
Joint efficiency		Head formed	HOT
MAWP @ Design Temperature	18.45 barg @ +75 °C	PESO A VUOTO	
		Empty weight	69 kg
MAWP(EXT)	NO	PESO IN ESERCIZIO	
		Operating weight	69 kg
MDMT @ MAWP	0 °C @ 18.45 barg	PESO PIENO D'ACQUA	
		Full water weight	109 kg
TRATTAMENTO TERMICO	NO	DATI DEL VENTO	
P.W.H.T.		Wind data	
IMPACT TEST	NO	DATI SISMICI	
Exemption		Seismological data	

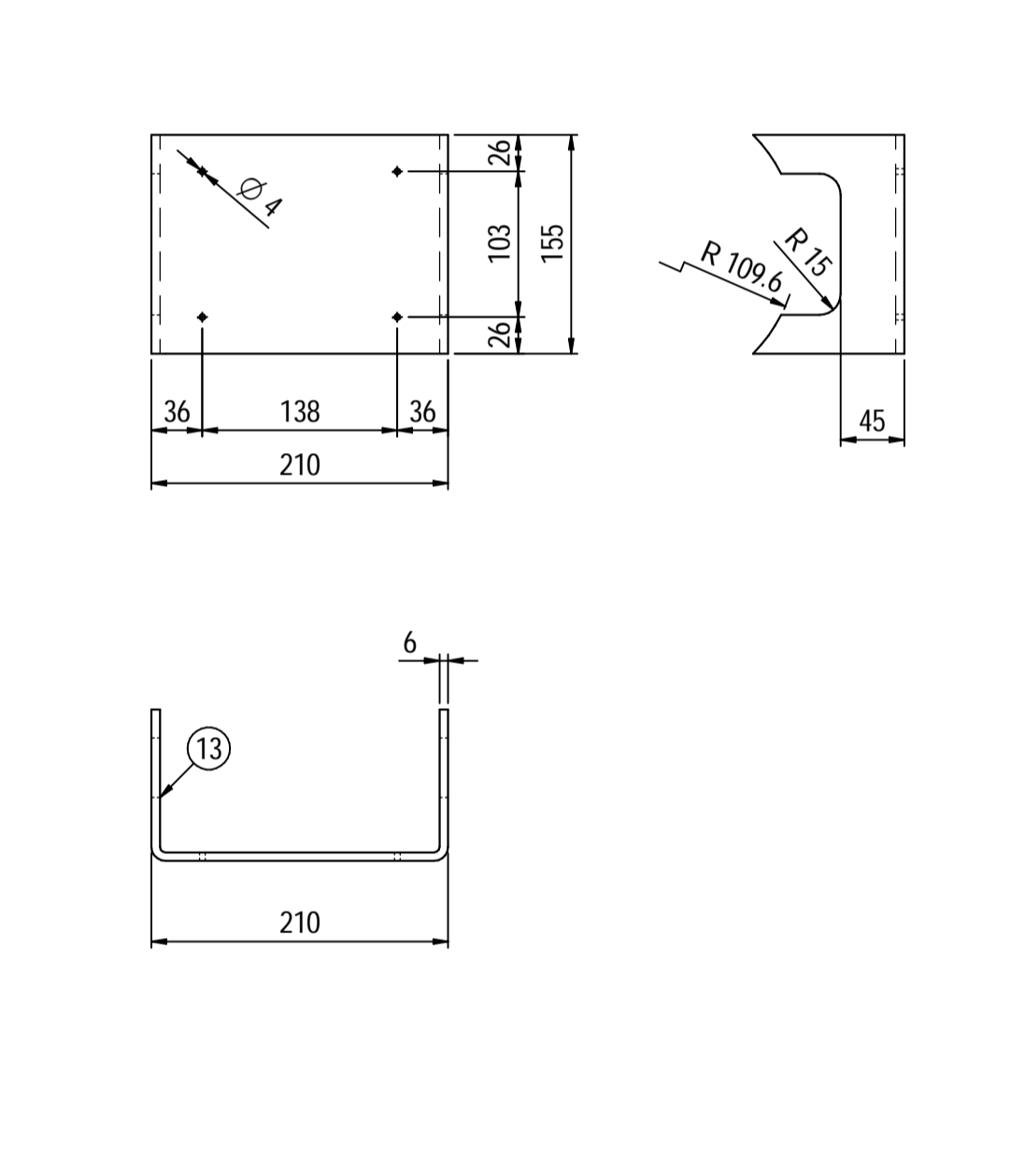
Rev.	Descrizione / Description	Disegnato/Draw	Controllato/Checked	Approvato/Approved	Data/Date
03	Issue for approval	LG	MV	MV	11/09/2024
02	Modified total volume	LG	MV	MV	03/08/2024
01	Revised as per Customer comments	LG	MV	MV	11/05/2024
00	FIRST ISSUE	LG	MV	MV	03/02/2024

Oggetto/Object			
1st STAGE INLET PULSATION DAMPER			

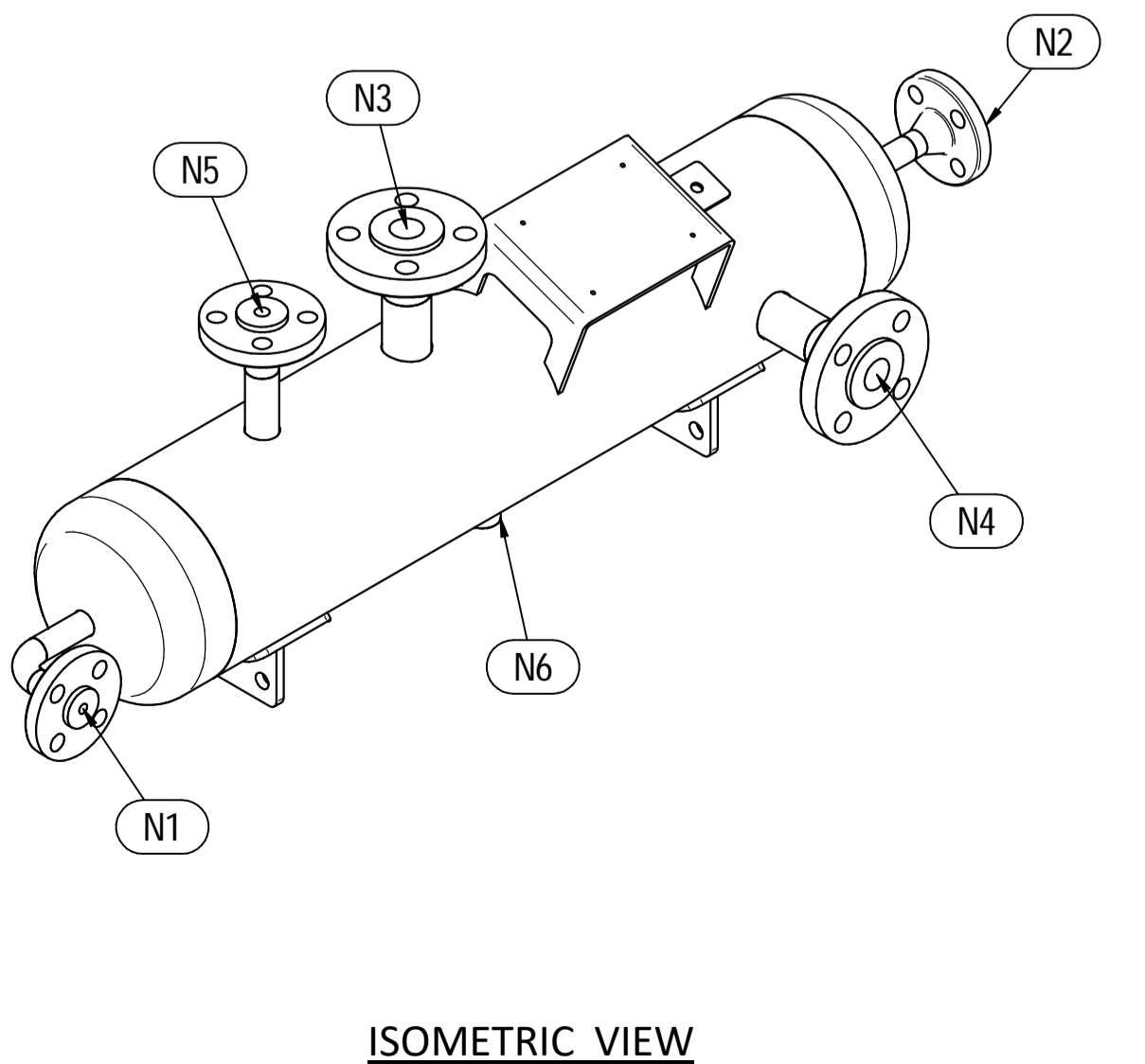
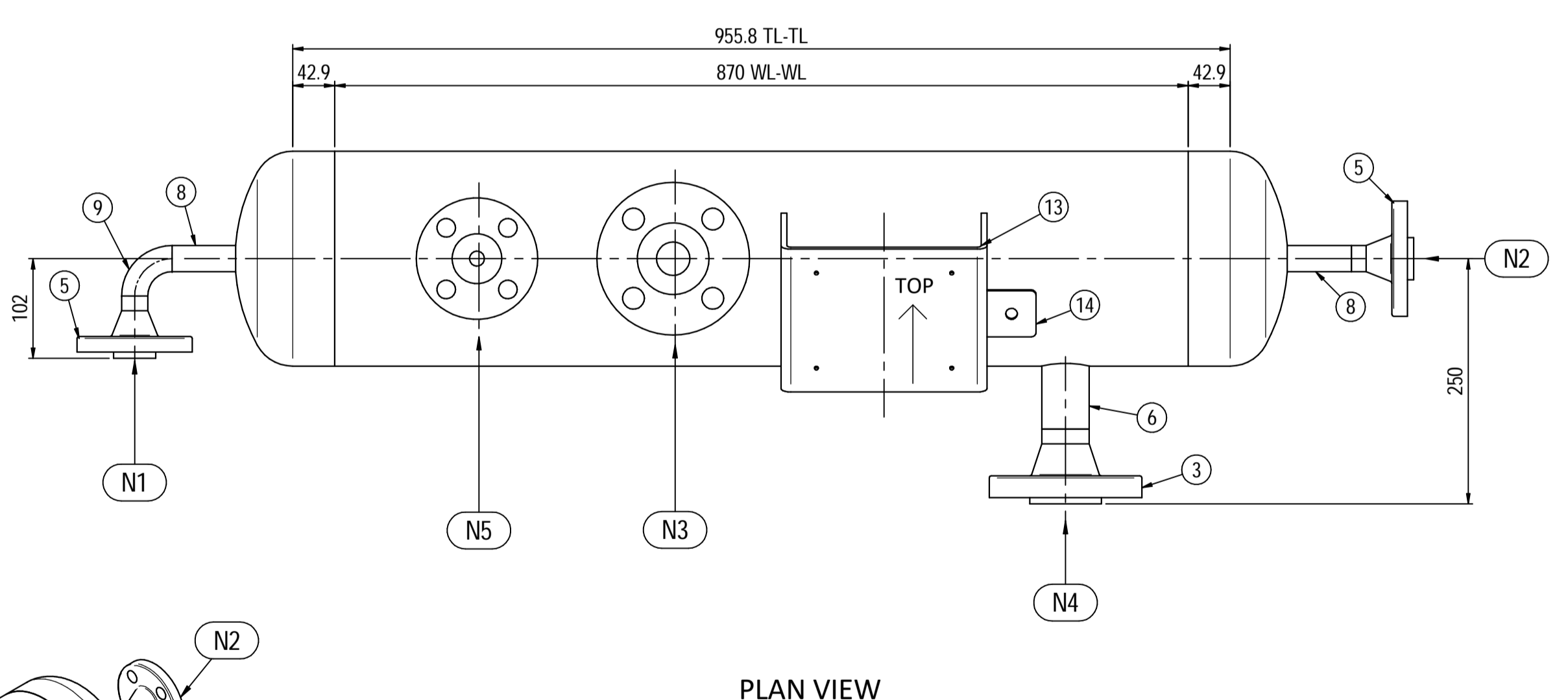
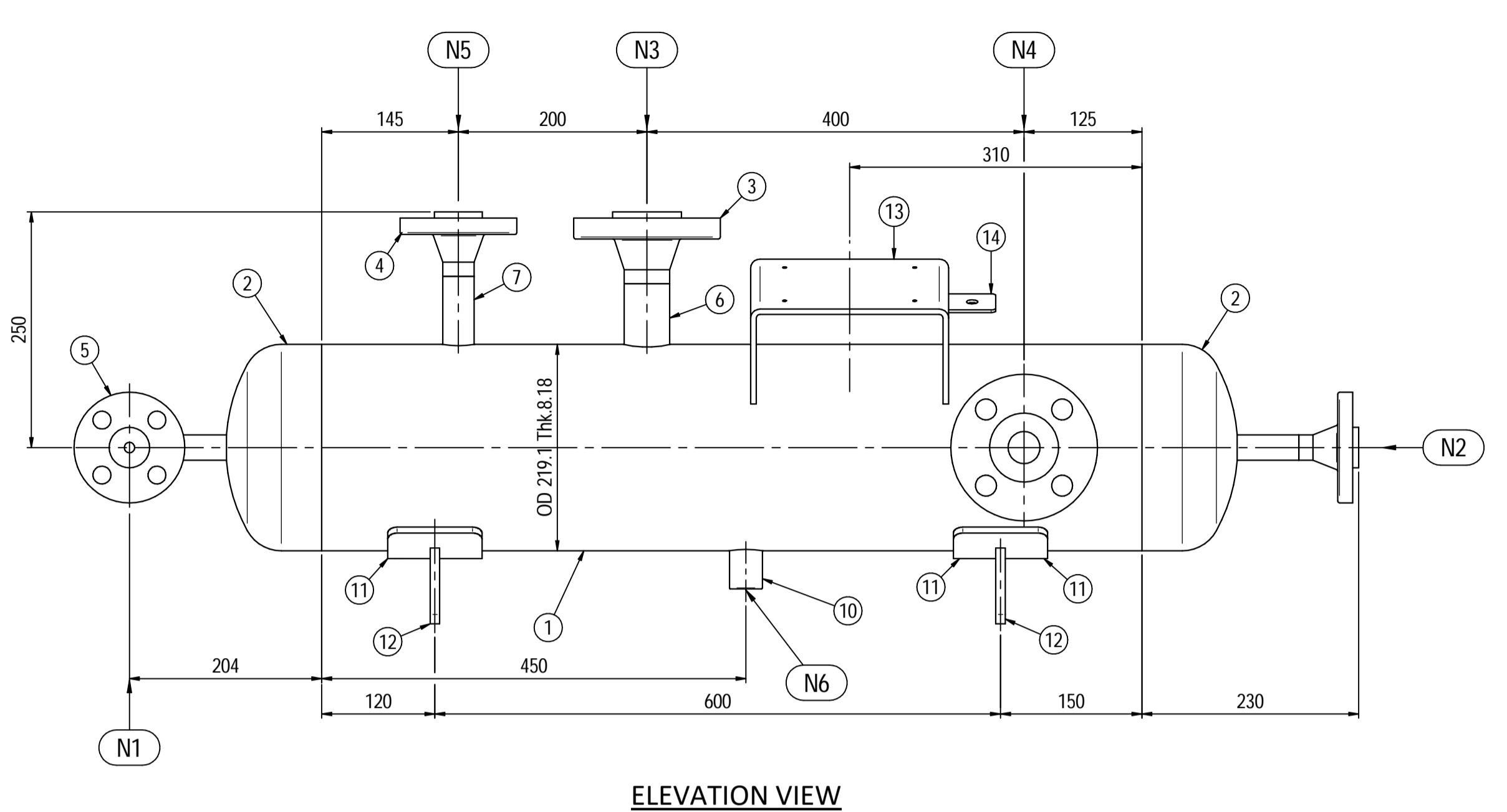
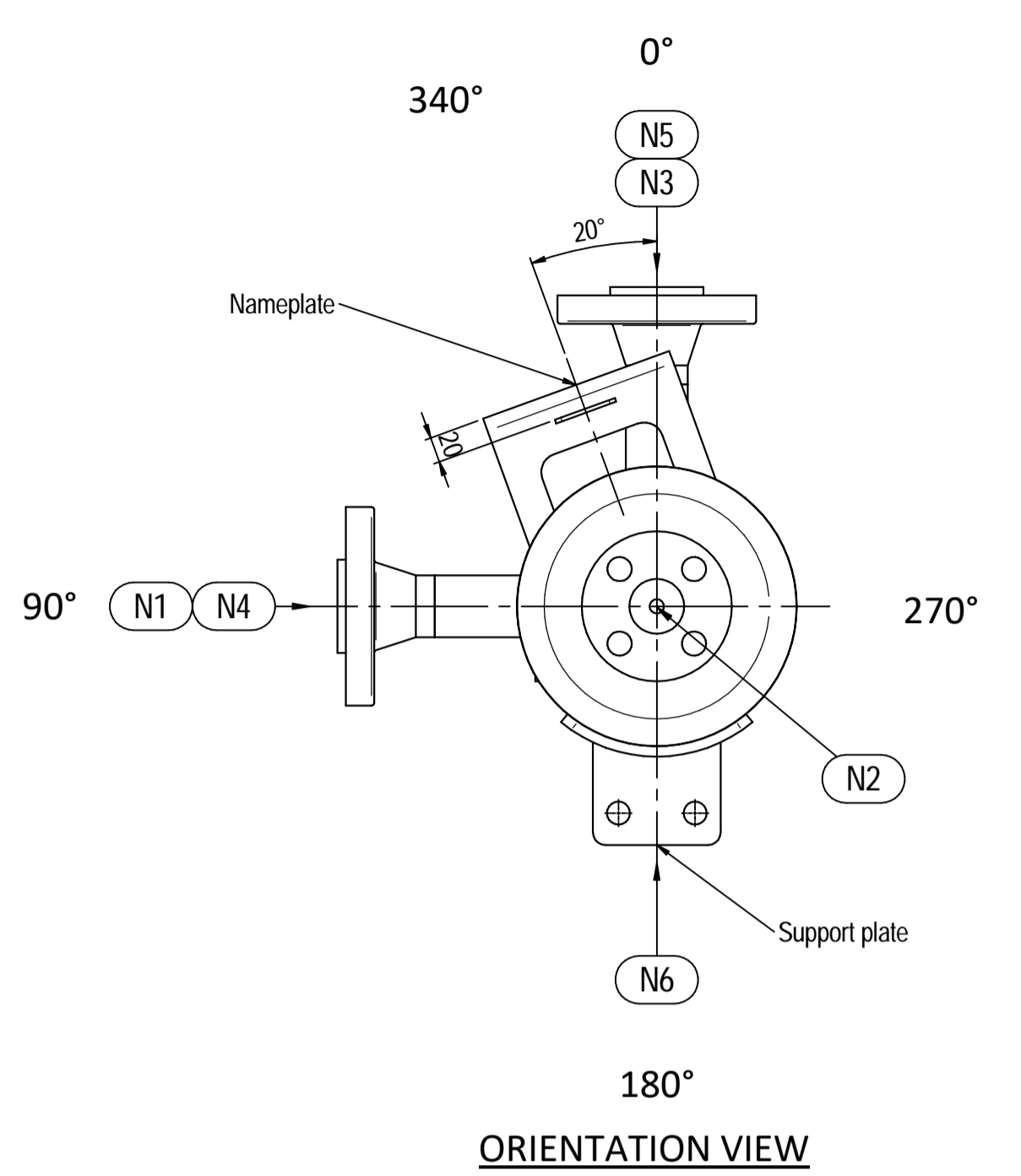
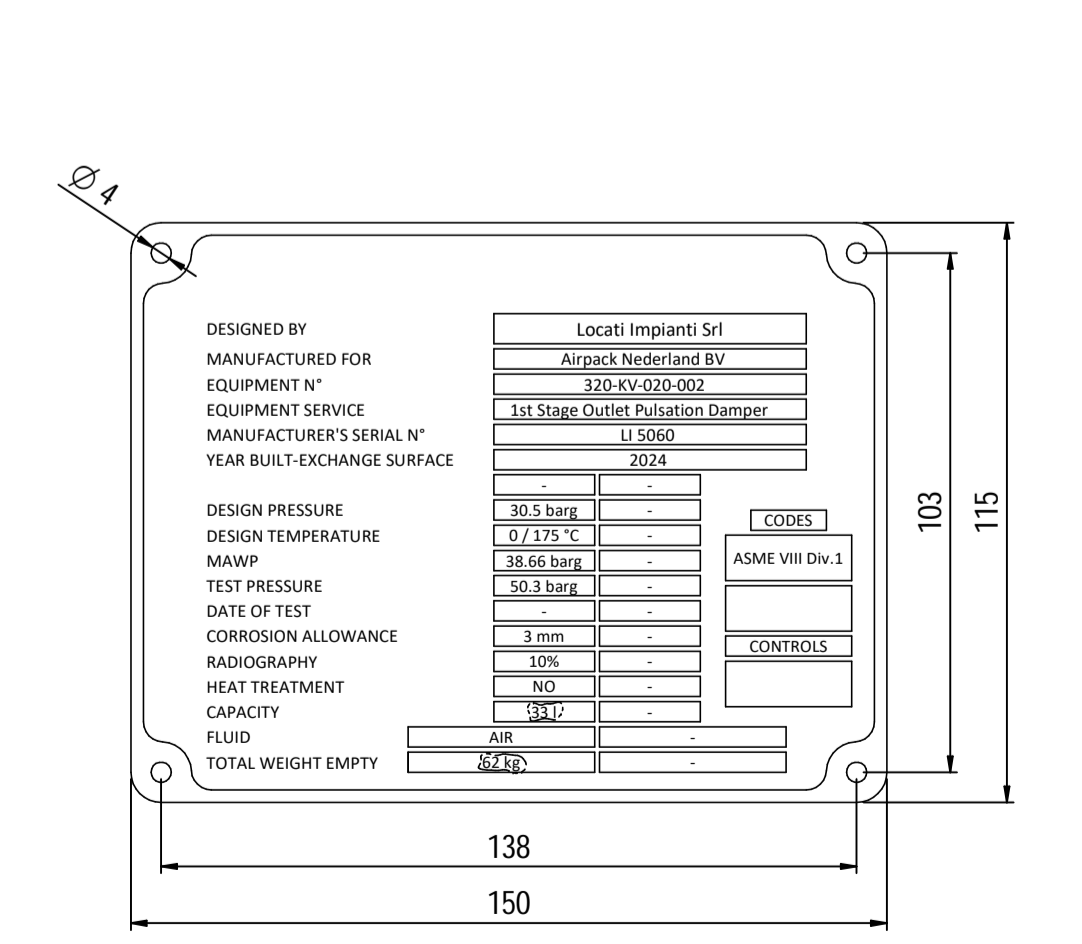
Supports detail
Scale 1 : 3



Nameplate detail
Scale 1:5



Nameplate detail
scale 1:1.5



Pos.	QTY	Description	Material	Cert.
1	1	Shell by Seamless Pipe 8" Sch.40 L=870	SA106 Gr.B	3.1
2	2	Cap 8" Sch.40	SA234 WPB	3.1
3	2	Flange 1 1/2" WN #600 RF Sch.160	SA105	3.1
4	1	Flange 1" WN #600 RF Sch.XXS	SA105	3.1
5	2	Flange 3/4" WN #600 RF Sch.XXS	SA105	3.1
6	2	Seamless Pipe 1 1/2" Sch.160 L=75	SA106 Gr.B	3.1
7	1	Seamless Pipe 1" Sch.XXS L=80	SA106 Gr.B	3.1
8	2	Seamless Pipe 3/4" Sch.XXS L=73	SA106 Gr.B	3.1
9	1	Seamless elbow 3/4" 90° LR Sch.XXS	SA234 WPB	3.1
10	1	Coupling 3/4" NPT #6000	A105	3.1
11	2	Pad by pipe 100 x 150 Thk.8.18	SA106 Gr.B	
12	2	Support plate 100 x 80 Thk.10	SA516 70	
13	1	Nameplate support by plate 403 x 155 Thk.6	SA516 70	
14	1	Earthing plate 50 x 40 Thk.3	SA240 TP316L	

- Note:
- 1) Governing measurement S.I. unless otherwise specified
 - 2) Flange bolt holes have to be straddled from main vessel center line in plan & vertical & horizontal centreline in elevation
 - 3) Material: certification 3.1 EN 10204
 - 4) All internal edge shall be rounded off
 - 5) Nozzle flanges in accordance with ASME B16.5: 2020
 - 6) Flange fittings in accordance with ASME B16.9: 2018
 - 7) All fillet welds not detailed on "WELDING MAP" or drawing shall have the weld throated equal to 0.7 times the minimum thickness to be welded
 - 8) All welds are continuous except where indicate
 - 9) Deleted
 - 10) The nameplate use in SS316 and is laser engraved
 - 11) Non corrosive service, no inspection opening per UG-46(a)
 - 12) On support hexagonal bolts DIN 933, class 8.8 shall be use (Airpack scope)

ITEM	QTY	SERVICE	SIZE	O.D.	THK	RATING	TYPE	FACE	O.D.	THK.	Tc
N6	1	DRAIN	3/4"	38.1	8.38	#6000	NPT-F	-	-	-	8 ± 10
N5	1	TEMPERATURE GAUGE	1 1/2"	48.3	7.14	#600	WN RF	-	-	-	8 ± 10
N4	1	TEMPERATURE TRANSMITTER	1 1/2"	48.3	7.14	#600	WN RF	-	-	-	8 ± 10
N3	1	PSV CONNECTION	1"	33.4	9.09	#600	WN RF	-	-	-	8 ± 10
N2	1	AIR OUTLET	3/4"	26.7	7.82	#600	WN RF	-	-	-	8 ± 10
N1	1	AIR INLET	3/4"	26.7	7.82	#600	WN RF	-	-	-	8 ± 10

ITEM	Qtà	SERVIZIO	NPS/DN	O.D.	THK	RATING	TYPE	FACE	O.D.	THK.	RINFORZO
DATI DI PROGETTO / Design data											
FLUIDO	Air		COLLAUDO		Test		0094 Iqqa Inspection Iberia SA				
STATO FISICO DEL FLUIDO	Gas		PED		N/A						
CODICE DI CALCOLO	ASME VIII Div. 1 Ed.2021										
PRESSIONE DI ESERCIZIO	23.3 barg		SERVIZIO LETALE		NO						
PRESSIONE DI PROGETTO	30.5 barg		RT examination		Spot (10%)						
PRESSIONE ESTERNA	NO		LIQUIDI PENETRANTI		NO						
PRESSIONE DI PROVA IDRAULICA	50.26 barg		ULTRASUONI		NO						
TEMPERATURA DI ESERCIZIO	157 °C		CONTROLLI MAGNETOSCOPICO		NO						
TEMPERATURA DI PROGETTO	175 °C		WELD TEST COUPON		NO						
SOVRAMEZZA DI CORROSIONE	3 mm		PROCEDIMENTO DI SALDATURA		See doc: C230048WBK009						
CAPACITA'	331		TIPO DI FONDO		CAP						
EFFICIENZA GIUNTI	0.85		FORMAZIONE FONDO		HOT						
MAWP @ Design Temperature	38.66 barg @ +175 °C		PESO A VUOTO		62 kg						
MAWP(EXT)	NO		PESO IN ESERCIZIO		62 kg						
MDMT @ MAWP	0 °C @ 38.66 barg		PESO PIENO D'ACQUA		95 kg						
TRATTAMENTO TERMICO	NO		DATI DEL VENTO								
IMPACT TEST	NO		DATI SISMICI								

Rev.	Descrizione / Description	Disegnato/Draw	Controllato/Checked	Approvato/Approved	Data/Date
03	Issue for approval	LG	MV	MV	11/09/2024
02	Upated volume	LG	MV	MV	03/08/2024
01	Revised as per Custome comments	LG	MV	MV	11/05/2024
00	FIRST ISSUE	LG	MV	MV	03/02/2024

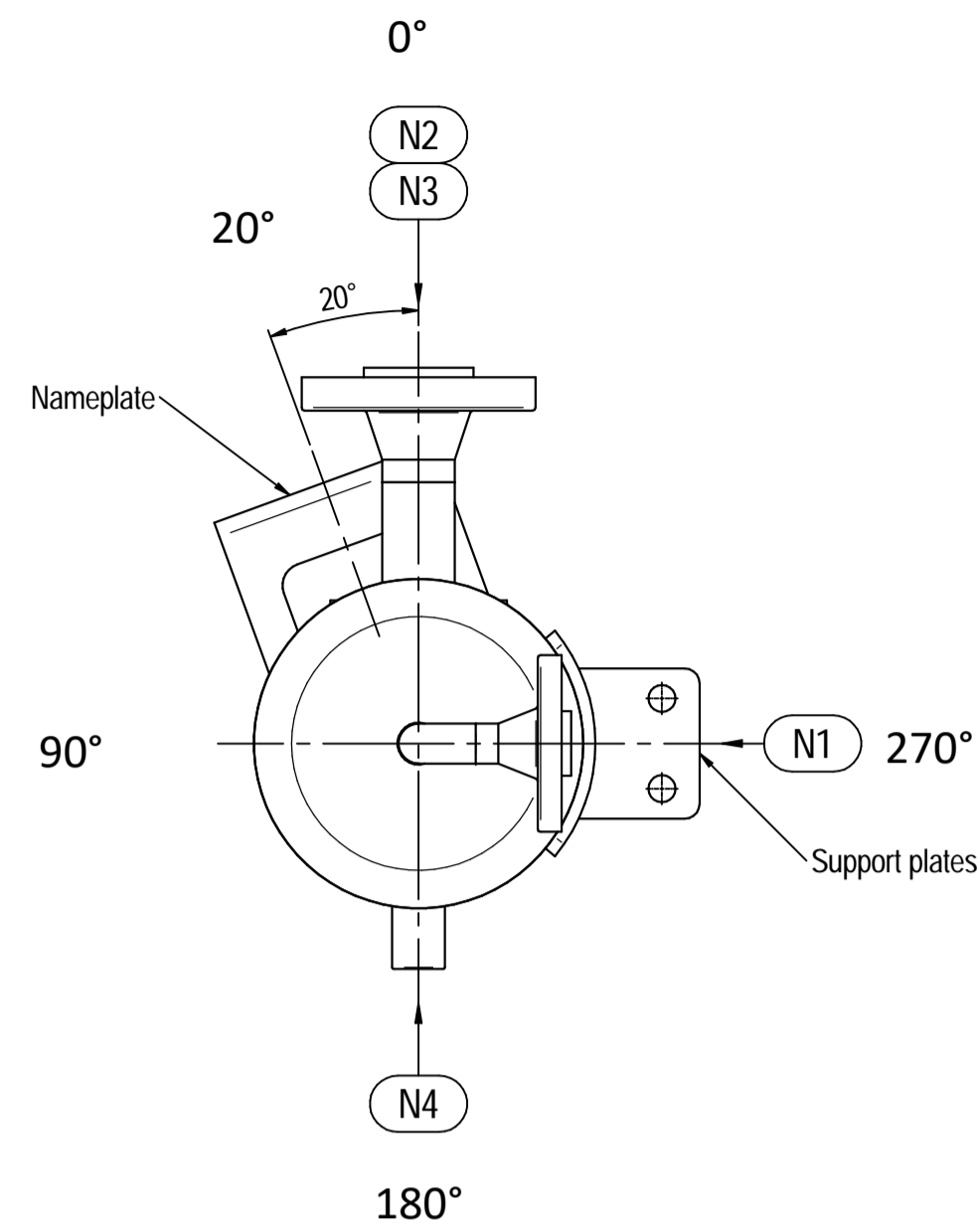
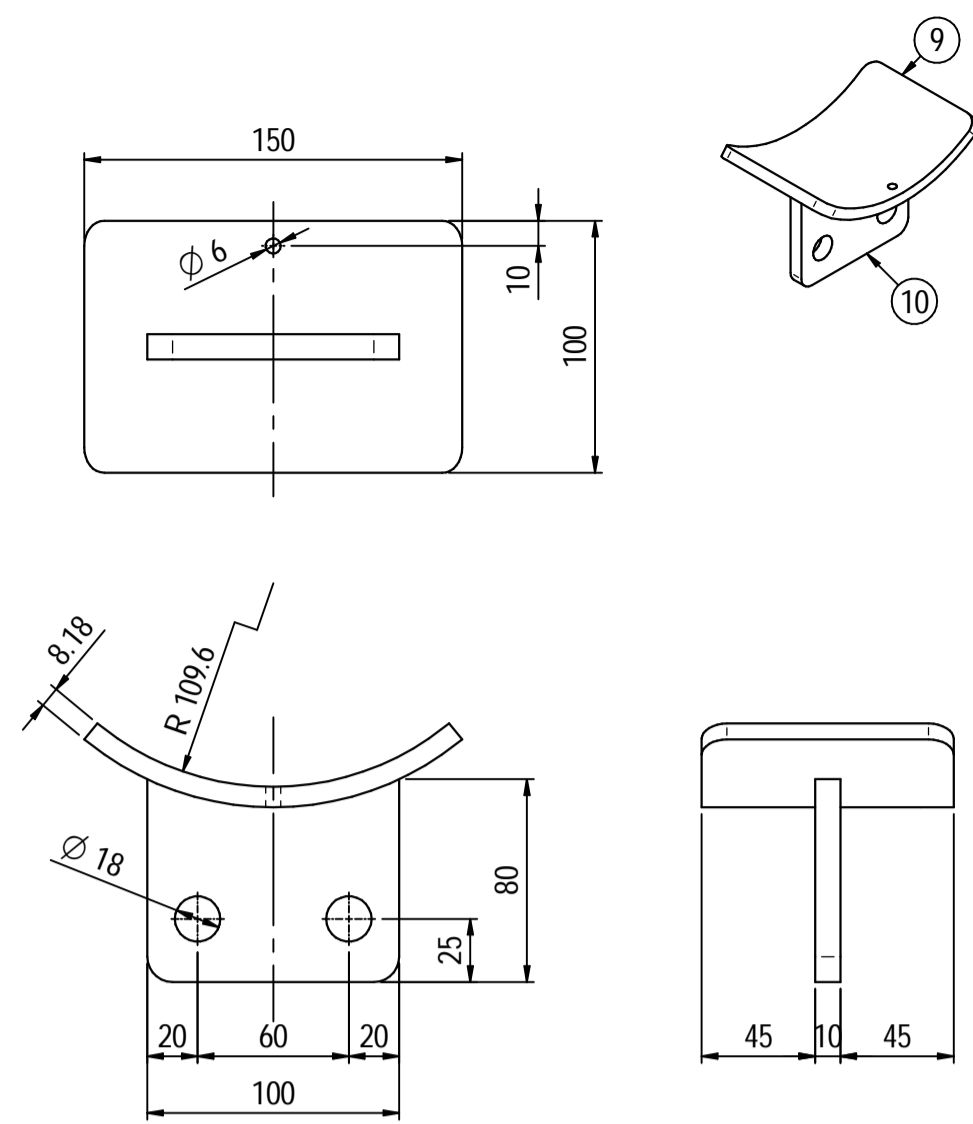
Objetto/Object: **1st STAGE OUTLET PULSATION DAMPER**

Scala/Scale	1 : 5	Formato/Size	A1
Comm. N°/Job No.	C230048	Foglio/Sheet	1 - 1
Cliente/Customer	Airpack Nederland B.V.		
Ord. No.	17735-VV-900 (SK)		
Dis. N°/Dwg No.	C230048DWG002	Rev.	03

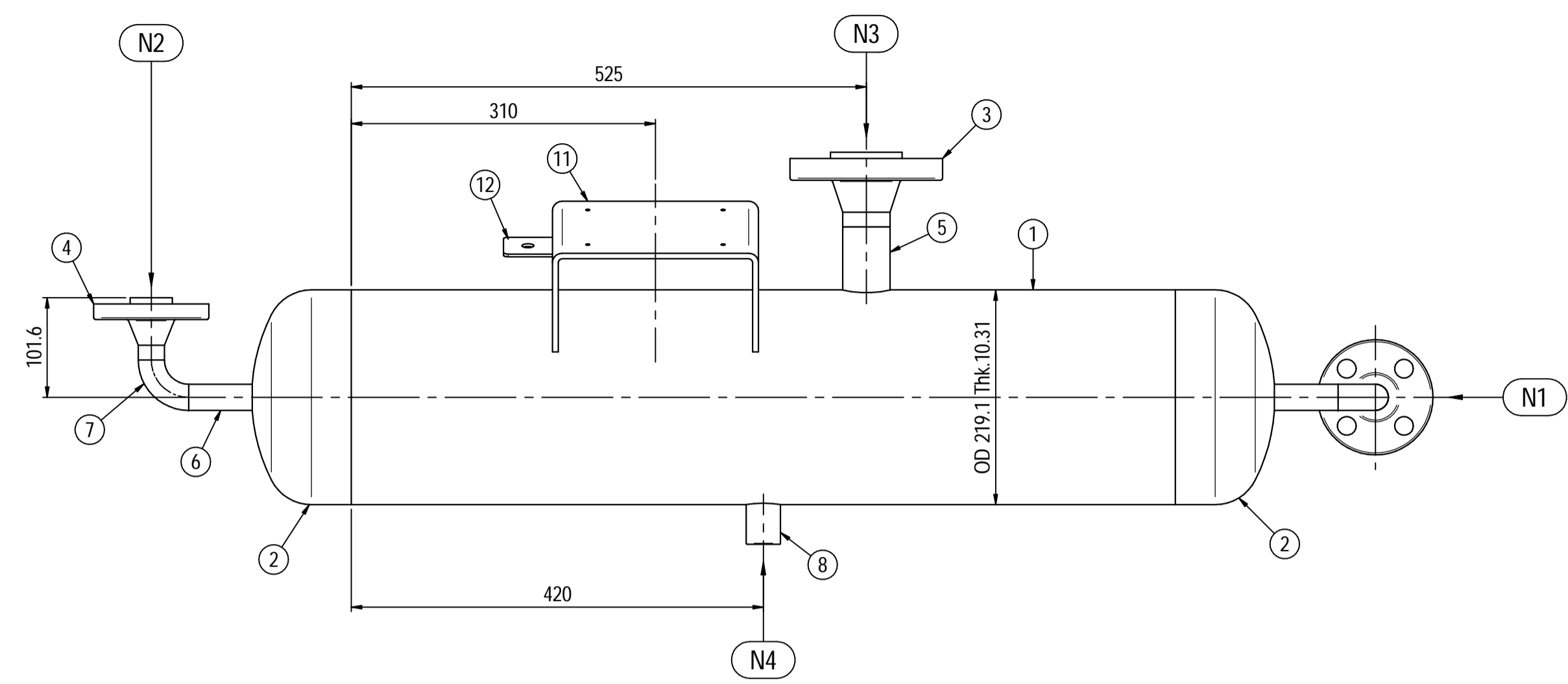
Locati Impianti Srl - Via Vittoria Veneto, 37 24040 Verdello (BG) Italy - P. +39 (0)35.883.176 Fax +39 (0)35.885.035 - e-mail: info@locatiimpianti.com http: www.locatiimpianti.com

Supports detail

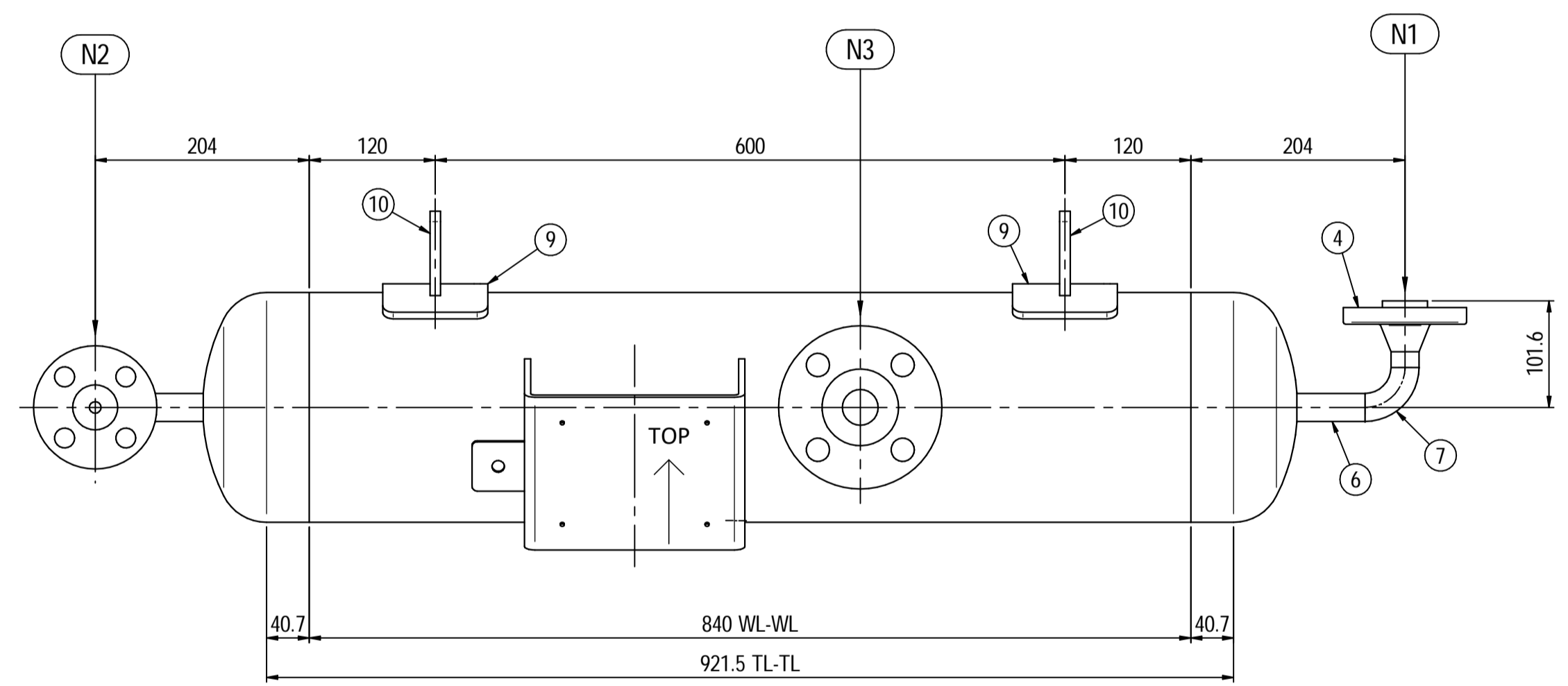
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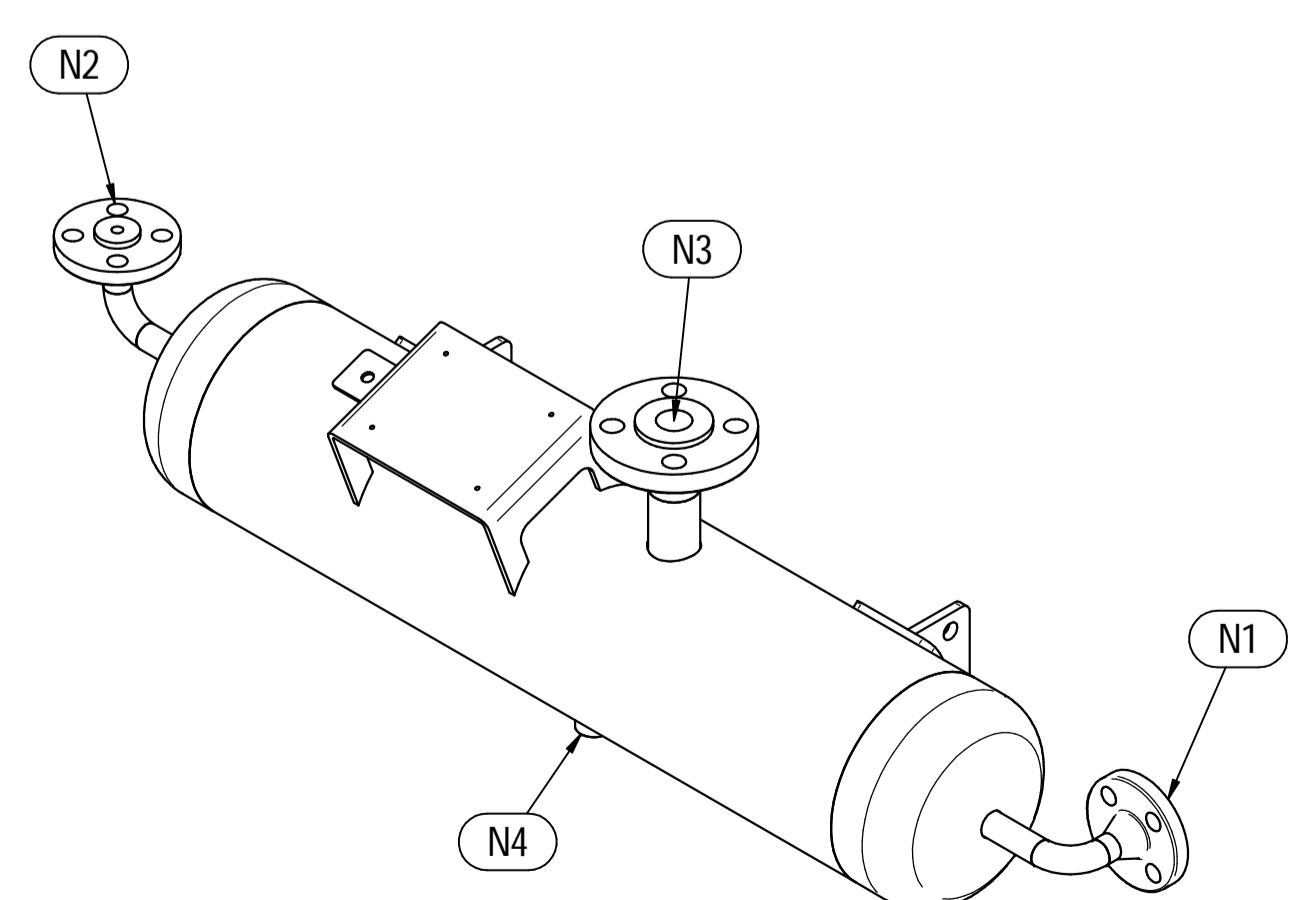
ORIENTATION VIEW



ELEVATION VIEW



PLAN VIEW

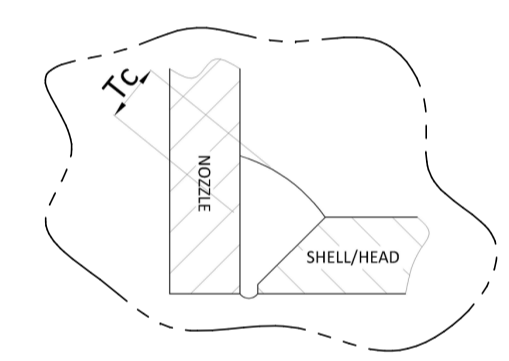


ISOMETRIC VIEW

Pos.	QTY	Description	Material	Cert.
1	1	Shell by Seamless Pipe 8" Sch.80 L=840	SA106 Gr.B	3.1
2	2	Cap 8" Sch.80	A234 WPB	3.1
3	1	Flange 1 1/2" WN #600 RF Sch.160	SA105	3.1
4	2	Flange 1/2" WN #600 RF Sch.XXS	SA105	3.1
5	1	Seamless Pipe 1 1/2" Sch.160 L=80	SA106 Gr.B	3.1
6	2	Seamless Pipe 1/2" Sch.XXS L=7"	SA106 Gr.B	3.1
7	2	Seamless elbow 1/2" 90° LR Sch.XXS	SA234 WPB	3.1
8	1	Coupling 1/2" NPT #6000	A105	3.1
9	2	Pad by pipe 100 x 150 Thk.8.18	SA106 Gr.B	3.1
10	2	Support plate 100 x 80 Thk.10	SA516 70	
11	1	Nameplate support by plate 403 x 155 Thk.6	SA516 70	
12	1	Earthing plate 50 x 40 Thk.3	SA240 TP316L	

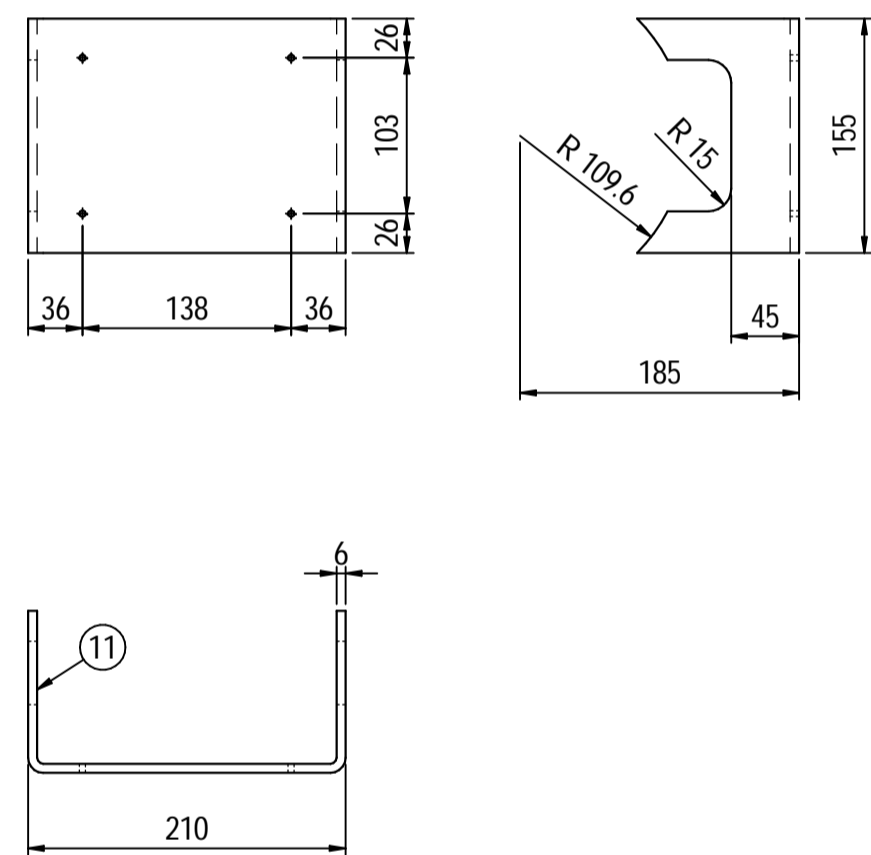
Note:

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- All internal edge shall be rounded off
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- Flange fittings in accordance with ASME B16.9: 2018
- All fillet welds not detailed on "WELDING MAP" or drawing shall have the weld throated equal to 0.7 times the minimum thickness to be welded
- All welds are continuous except where indicate
- Delated
- The nameplate use in SS316 and is laser engraved
- Non corrosive service, no inspection opening per UG-46(a)
- On support hexagonal bolts DIN 933, class 8.8 shall be use (Airpack scope)



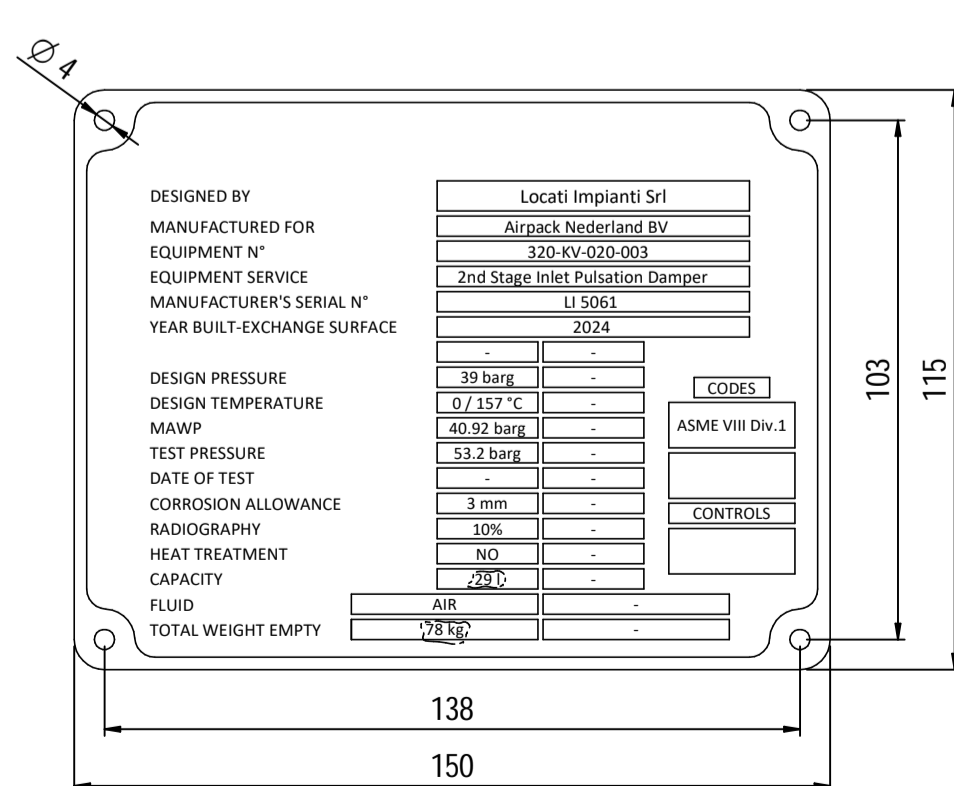
Nameplate detail

Scale 1:5



Nameplate detail

scale 1:1.5



ITEM	QTY	SERVICE	SIZE	O.D.	THK	RATING	TYPE	FACE	O.D.	THK.	Tc
N4	1	DRAIN	1/2"	38.1	8.28	#6000	NPT-F				8 ± 10
N3	1	TEMPERATURE TRANSMITTER	1 1/2"	48.3	7.14	#600	WN	RF			8 ± 10
N2	1	AIR OUTLET	1/2"	26.7	7.82	#600	WN	RF			8 ± 10
N1	1	AIR INLET	1/2"	26.7	7.82	#600	WN	RF			8 ± 10

ITEM	Qtà	SERVIZIO	NPS/DN	O.D.	THK	RATING	TYPE	FACE	O.D.	THK.	RINFORZO

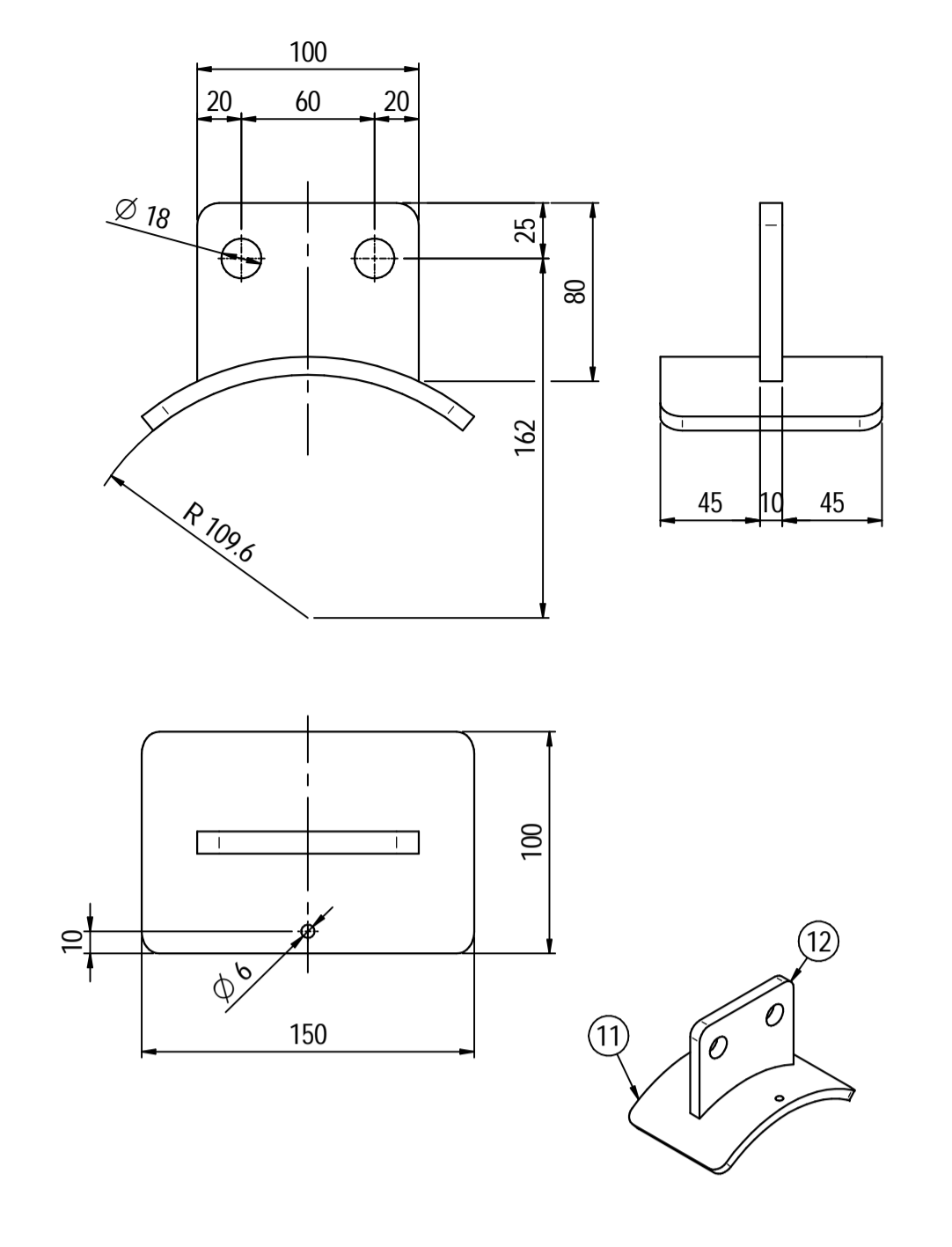
DATI DI PROGETTO / Design data			
FLUIDO	Air	COLLAUDO	Test
STATO FISICO DEL FLUIDO	Gas	PED	N/A
CODICE DI CALCOLO	ASME VIII Div. 1 Ed.2021		
PRESSIONE DI ESERCIZIO	22.1 barg	SERVIZIO LETALE	NO
PRESSIONE DI PROGETTO	39 barg	R-T examination	Spot (10%)
PRESSIONE ESTERNA	NO	LICUIDI PENETRANTI	NO
PRESSIONE DI PROVA IDRAULICA	53.2 barg	ULTRASUONI	NO
TEMPERATURA DI ESERCIZIO	60 °C	CONTROLLO MAGNETOSCOPICO	NO
TEMPERATURA DI PROGETTO	157 °C	WELD TEST COUPON	NO
SOVRAMEZZA DI CORROSIONE	3 mm	PROCEDIMENTO DI SALDATURA	See doc: C230048WBK009
CAPACITA'	291	TIPO DI FONDO	CAP
EFFICIENZA GIUNTI	0.85	FORMAZIONE FONDO	HOT
MAWP @ Design Temperature	40.92 barg @ +157 °C	PESO A VUOTO	78 kg
MAWP(EXT)	NO	PESO IN ESERCIZIO	78 kg
MDMT @ MAWP	0 °C @ 40.92 barg	PESO PIENO D'ACQUA	108 kg
TRATTAMENTO TERMICO	NO	DATI DEL VENTO	
IMPACT TEST	NO	DATI SISMICI	

Rev.	Descrizione / Description	Disegnato/Draw	Controllato/Checked	Approvato/Approved	Data/Date
02	Issue for approval	LG	MV	MV	11/09/2024
01	Revised as per Customer comments	LG	MV	MV	11/05/2024
00	FIRST ISSUE	LG	MV	MV	03/02/2024

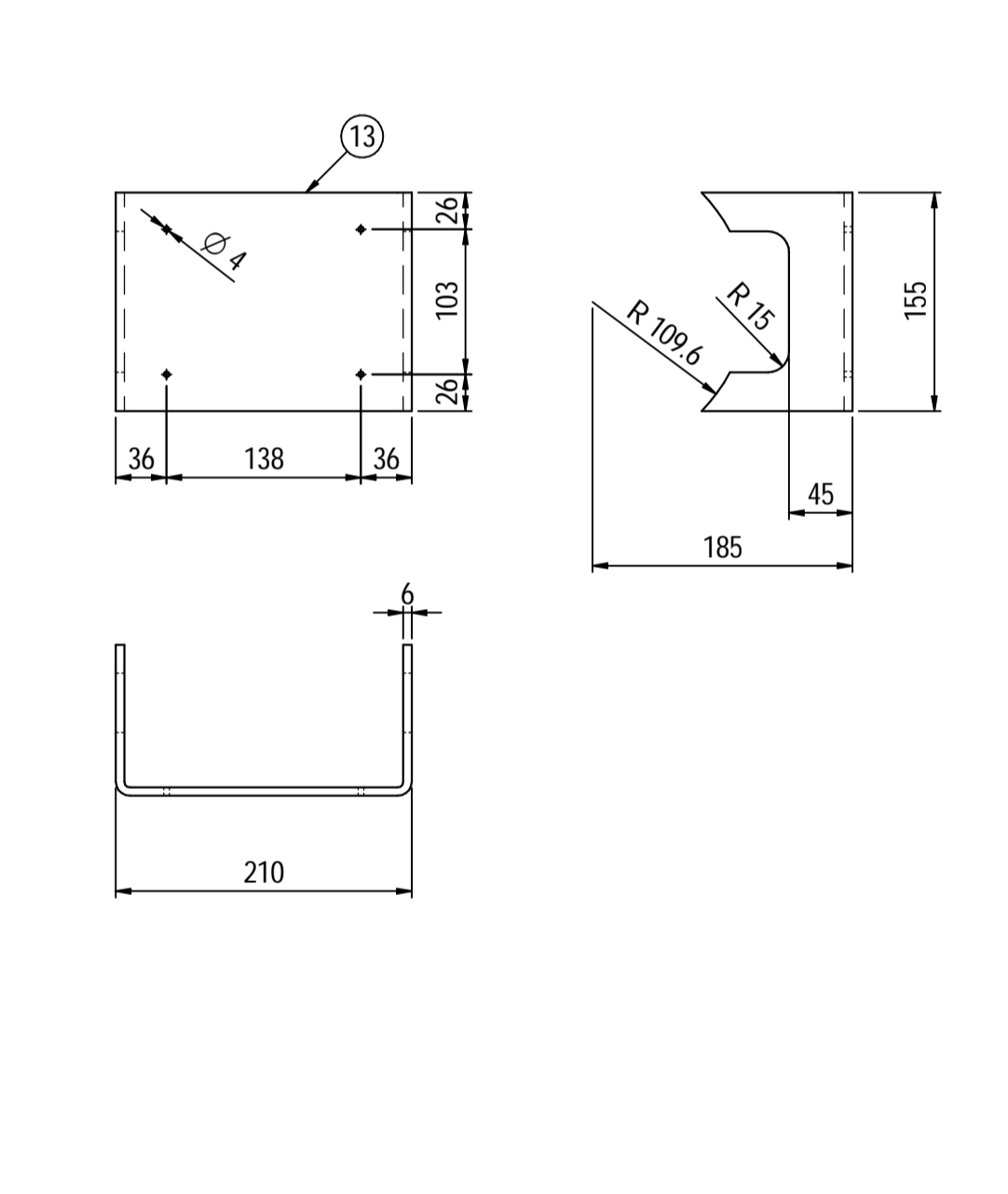
Oggetto/Object: 2nd STAGE INLET PULSATION DAMPER

Scala/Scale	1 : 5	Formato/Size	A1
Comm. N°/Job No.	C230048	Foglio/Sheet	1 - 1
Cliente/Customer	Airpack Nederland B.V.		
Ord. No.	17735-VV-900 (SK)		
Dis. N°/Dwg No.	C230048DWG003	Rev.	02

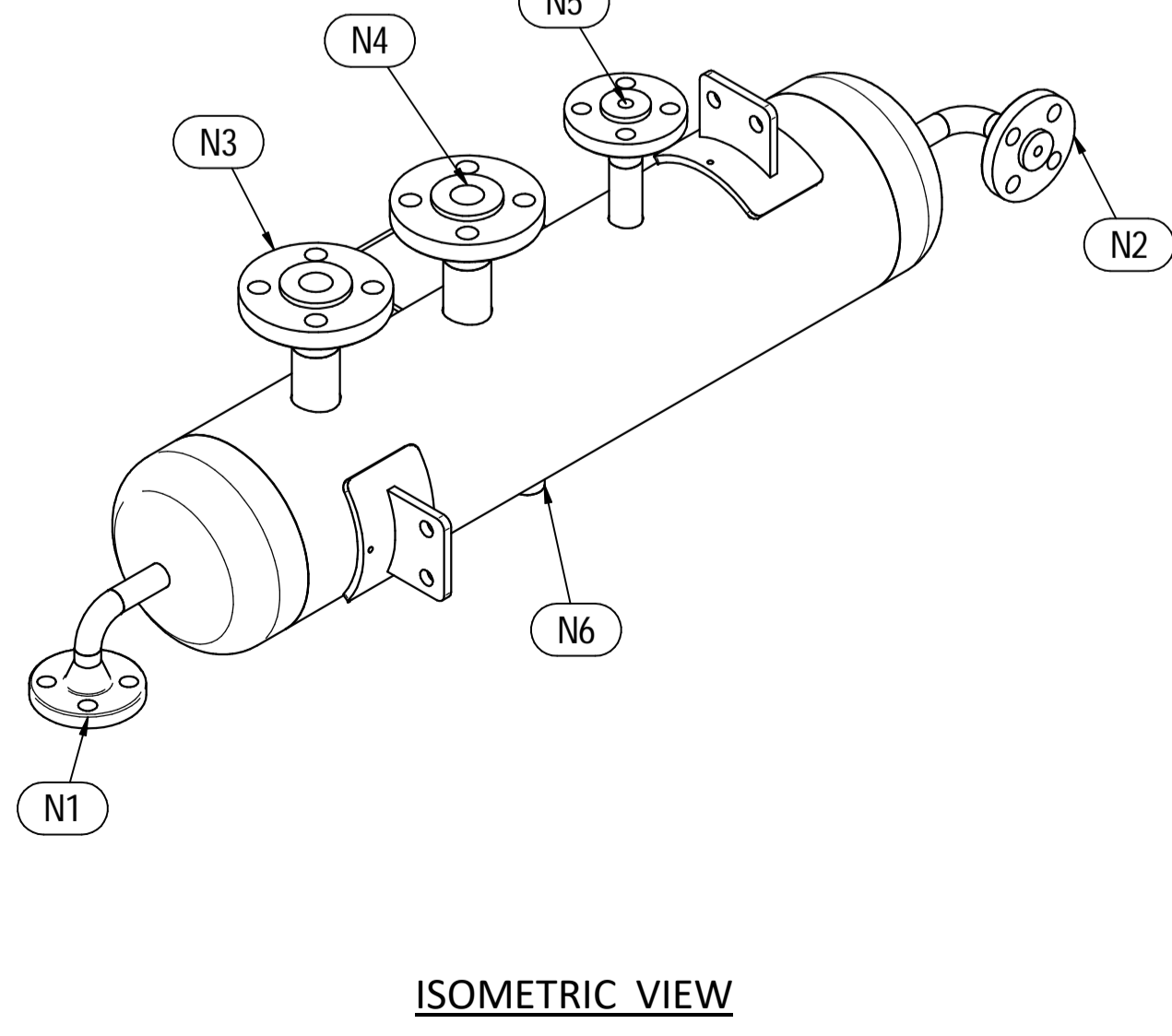
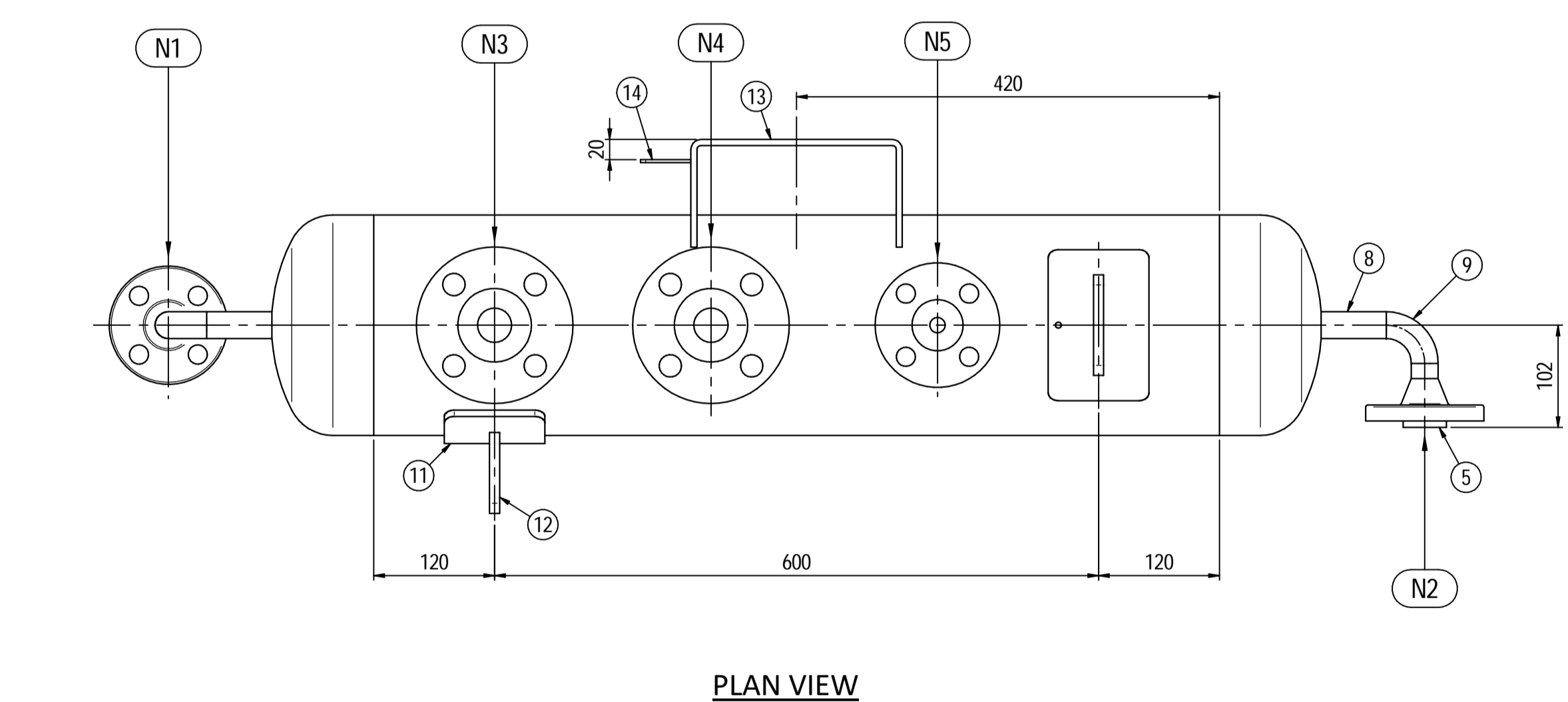
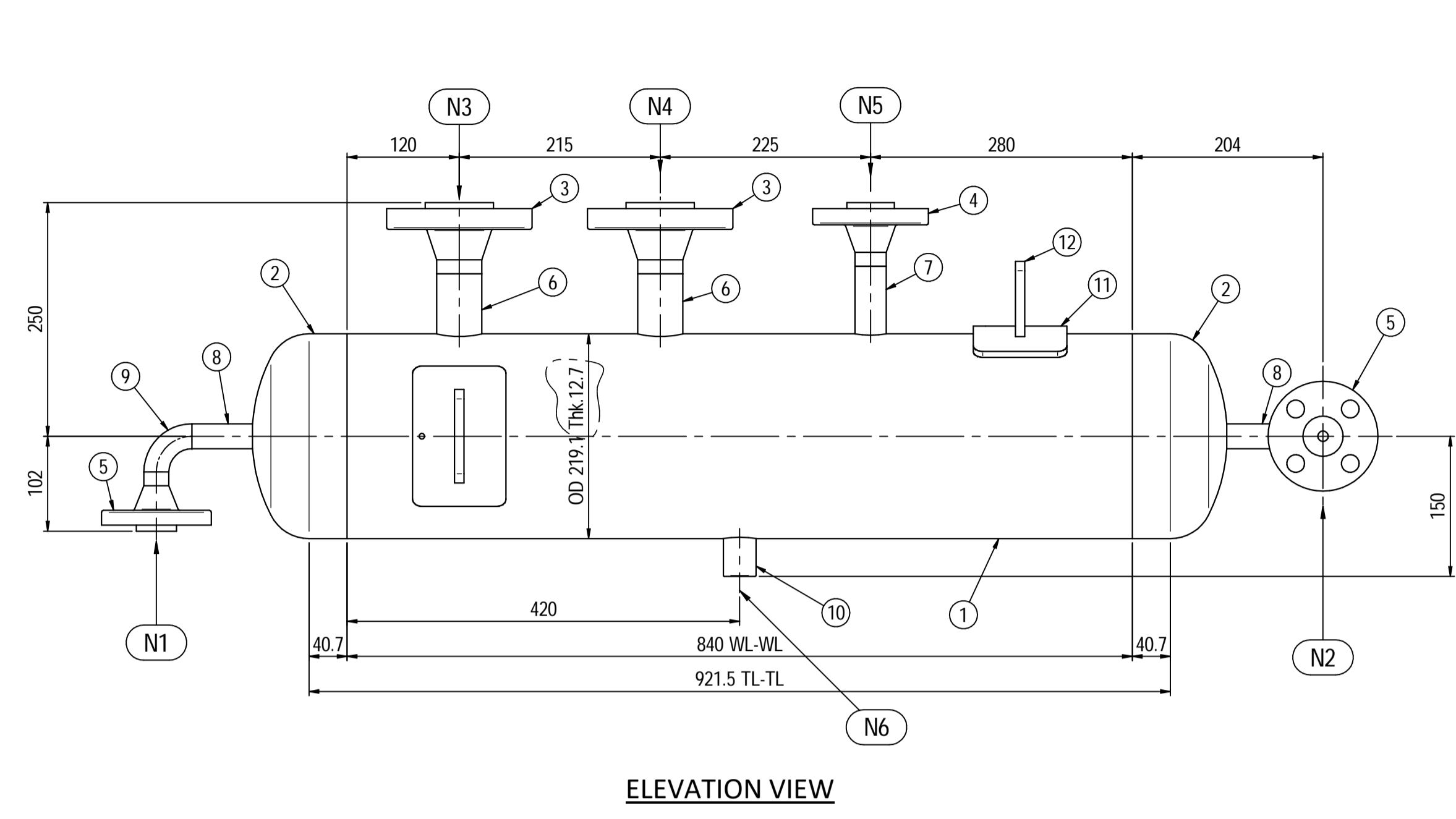
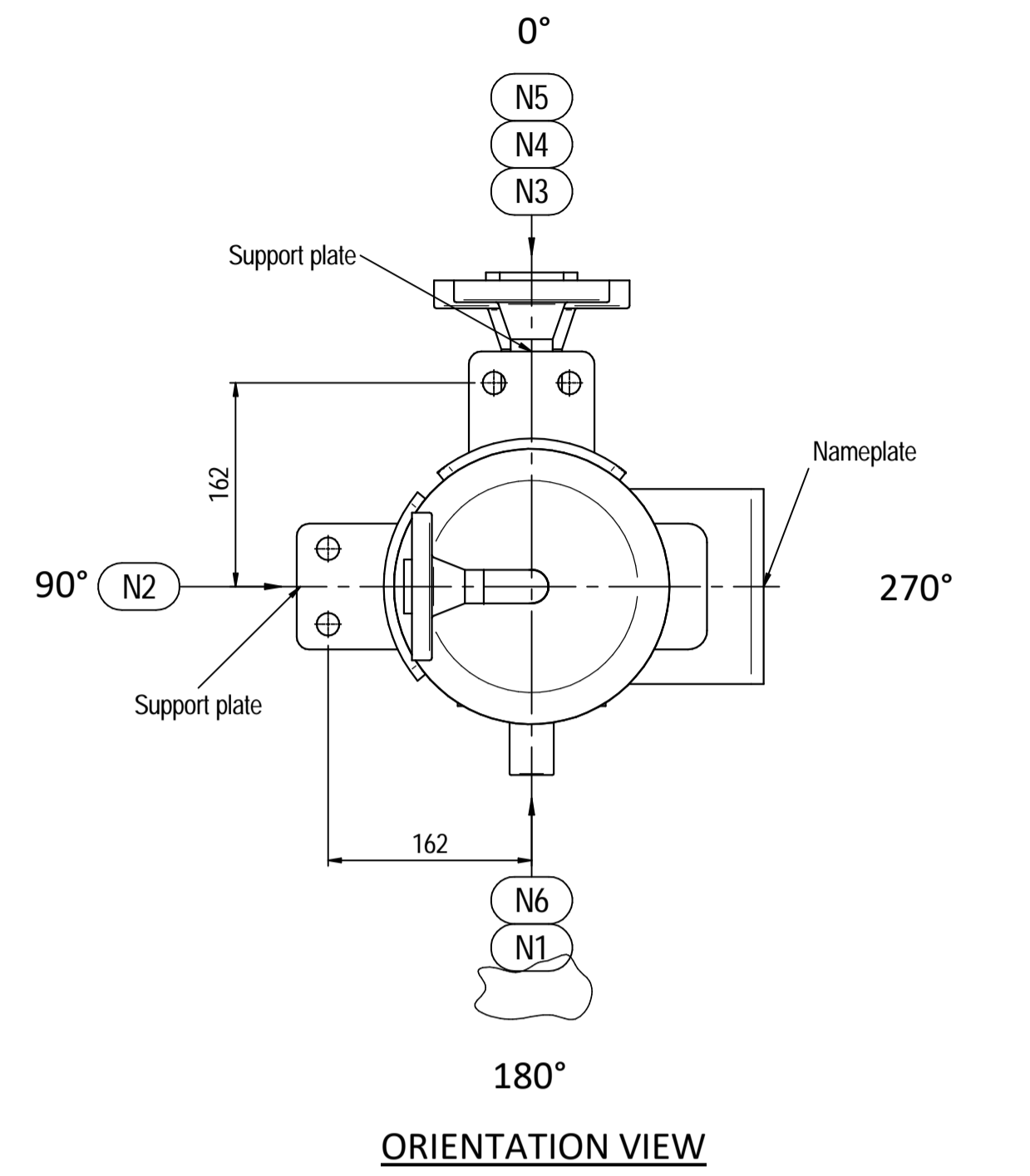
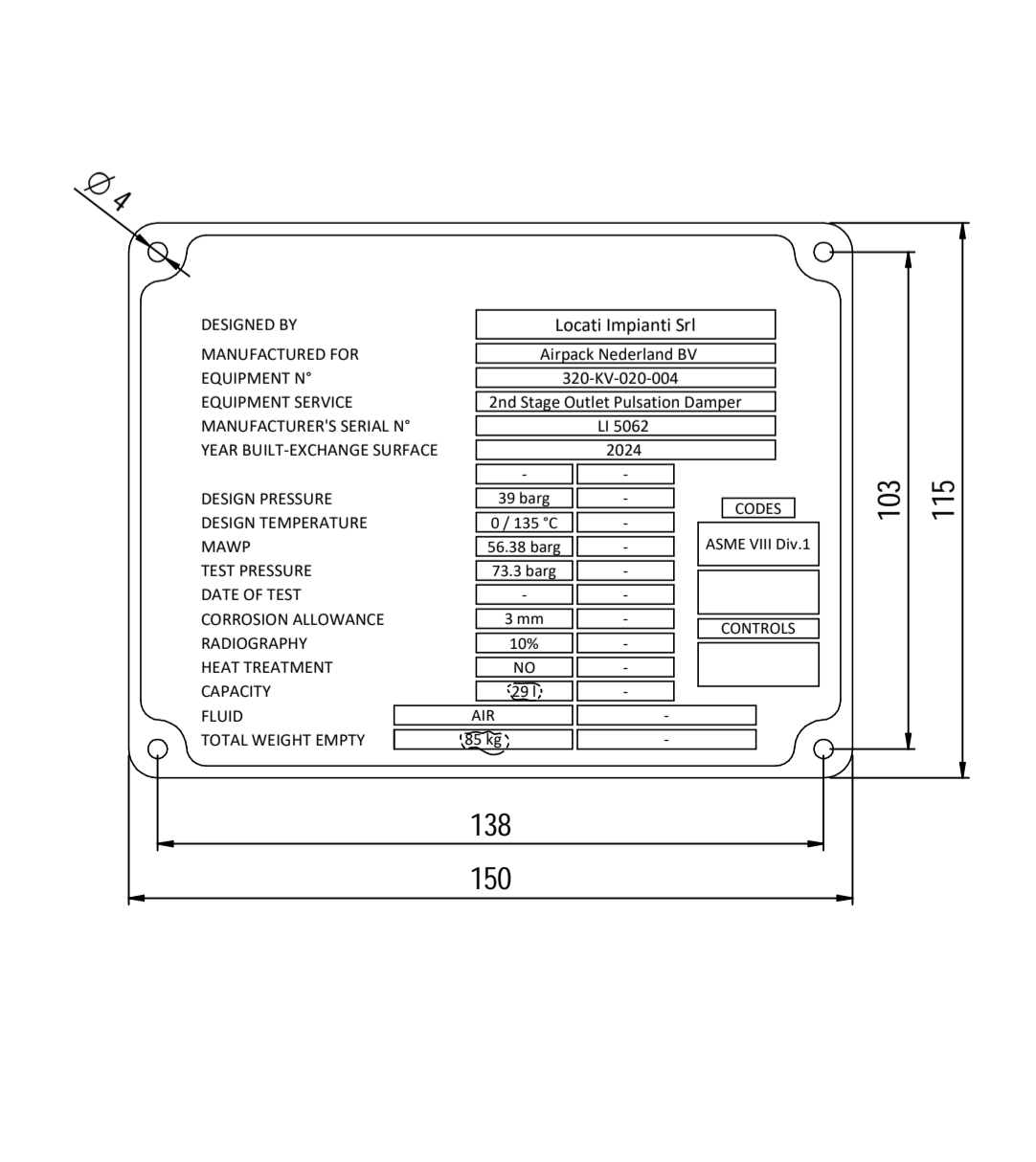
Supports detail
Scale 1 : 3



Nameplate detail
Scale 1:5



Nameplate detail
scale 1:1.5



Pos.	QTY	Description	Material	Cert.
1	1	Shell by Seamless Pipe 8" Sch.80 L=840	SA106 Gr.B	3.1
2	2	Cap 8" Sch.80	A234 WPB	3.1
3	2	Flange 1 1/2" WN #600 RF Sch.160	SA105	3.1
4	1	Flange 1" WN #600 RF Sch.XXS	SA105	3.1
5	2	Flange 3/4" WN #600 RF Sch.XXS	SA105	3.1
6	2	Seamless Pipe 1 1/2" Sch.160 L=80	SA106 Gr.B	3.1
7	1	Seamless Pipe 1" Sch.XXS L=80	SA106 Gr.B	3.1
8	2	Seamless Pipe 3/4" Sch.XXS L=77	SA106 Gr.B	3.1
9	2	Seamless elbow 3/4" 90° LR Sch.XXS	SA234 WPB	3.1
10	1	Coupling 1/2" NPT #6000	A105	3.1
11	2	Pad by pipe 100 x 150 Thk.8.18	SA106 Gr.B	3.1
12	2	Support plate 100 x 80 Thk.10	SA516 70	
13	1	Nameplate support by plate 403 x 155 Thk.6	SA516 70	
14	1	Earthing plate 50 x 40 Thk.3	SA240 TP316L	

- Note:
- Governing measurement S.I. unless otherwise specified
 - Flange bolt holes have to be straddled from main vessel center line in plan & vertical & horizontal centreline in elevation
 - Material: certification 3.1 EN 10204
 - All internal edge shall be rounded off
 - Nozzle flanges in accordance with ASME B16.5: 2020
 - Flange fittings in accordance with ASME B16.9: 2018
 - All fillet welds not detailed on "WELDING MAP" or drawing shall have the weld throated equal to 0.7 times the minimum thickness to be welded
 - All welds are continuous except where indicate
 - Deleted
 - The nameplate use in SS316 and is laser engraved
 - Non corrosive service, no inspection opening per UG-46(a)
 - On support hexagonal bolts DIN 933, class 8.8 shall be use (Airpack scope)

ITEM	QTY	SERVICE	SIZE	O.D.	THK	RATING	TYPE	FACE	O.D.	THK.	Tc
N6	1	DRAIN	1/2"	38.1	8.38	#6000	NPT-F	-	-	-	8 ± 10
N5	1	PSV CONNECTION	1"	33.4	9.09	#600	WN RF	-	-	-	8 ± 10
N4	1	TEMPERATURE TRANSMITTER	1 1/2"	48.3	7.14	#600	WN RF	-	-	-	8 ± 10
N3	1	TEMPERATURE GAUGE	1 1/2"	48.3	7.14	#600	WN RF	-	-	-	8 ± 10
N2	1	AIR OUTLET	3/4"	26.7	7.82	#600	WN RF	-	-	-	8 ± 10
N1	1	AIR INLET	3/4"	26.7	7.82	#600	WN RF	-	-	-	8 ± 10

ITEM	Qtà	SERVIZIO	NPS/DN	PIPE TUBO	FLANGE	FACE	O.D.	THK.	PAD	THK.	RINFORZO
DATI DI PROGETTO / Design data											
FLUIDO		Air		COLLAUDO		Test			0094 Iqa Inspection Iberia SA		
STATO FISICO DEL FLUIDO		Gas		TEST		PED			N/A		
CODICE DI CALCOLO		ASME VIII Div.1 Ed.2021									
PRESSIONE DI ESERCIZIO		30 barg		SERVIZIO LETALE		NO					
PRESSIONE DI PROGETTO		39 barg		RT examination		Spot (10%)					
PRESSIONE ESTERNA		NO		LICUIDI PENETRANTI		NO					
PRESSIONE DI PROVA IDRAULICA		73.3 barg		ULTRASUONI		NO					
TEMPERATURA DI ESERCIZIO		116°C		CONTROLLO MAGNETOSCOPICO		NO					
TEMPERATURA DI PROGETTO		135 °C		WELD tests coupon		NO					
SOVRAMEALLO DI CORROSIONE		3 mm		PROCEDIMENTO DI SALDATURA		See doc: C230048WBK009					
CAPACITA'		291		TIPO DI FONDO		CAP					
EFFICIENZA GIUNTI		0.85		FORMAZIONE FONDO		HOT					
MAWP @ Design Temperature		56.38 barg @ +135°C		PESO A VUOTO		59 kg					
MAWP(EXT)		NO		PESO IN ESERCIZIO		59 kg					
MDMT @ MAWP		0 °C @ 56.38 barg		PESO PIENO D'ACQUA		114 kg					
TRATTAMENTO TERMICO		NO		DATI DEL VENTO							
IMPACT TEST		NO		DATI SISMICI							

Rev.	Descrizione / Description	Disegnato/Draw	Controllato/Checked	Approvato/Approved	Data/Date
03	Issue for approval	LG	MV	MV	11/09/2024
02	Change position of N2 nozzle	LG	MV	MV	11/07/2024
01	Revised as per Customer comments	LG	MV	MV	11/05/2024
00	FIRST ISSUE	LG	MV	MV	03/02/2024

Oggetto/Object: 2nd STAGE OUTLET PULSATION DAMPER

Scala/Scale	1 : 5	Formato/Size	A1
Comm. N°/Job No.	C230048	Foglio/Sheet	1 - 1
Cliente/Customer	Airpack Nederland B.V.		
Ord. No.	17735-VV-900 (SK)		
Dis. N°/Dwg No.	C230048DWG004	Rev.	03