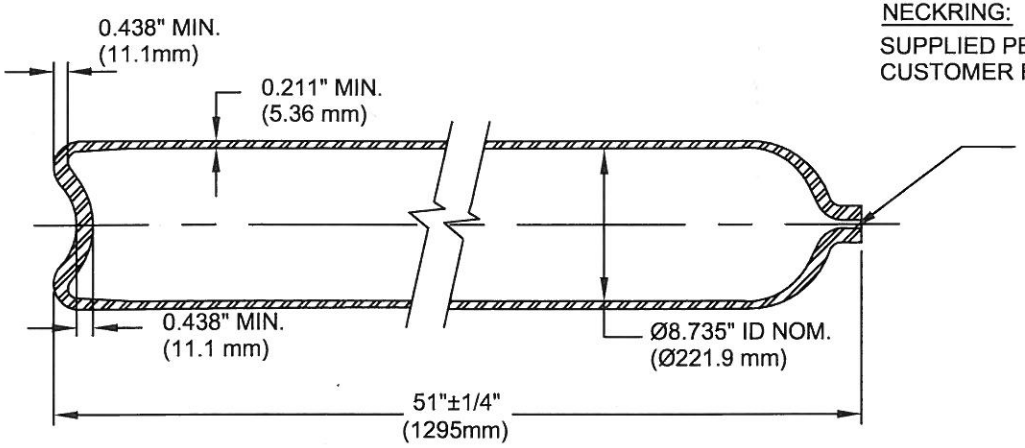
DRAWING FOR REFERENCE ONLY

REV.	ECN - DESCRIP.	DATE	DRWN.	CHKD.	APP.
08	2896	8/25/09	JJM	SAM	
09	2924	12/15/09	SAM		



NECKRING:
SUPPLIED PER
CUSTOMER REQUEST

3/4-14 NGT (8BC250-3),
1 -11 1/2 NGT (8BC250-1),
25E (8BC250-25E FOR TC-SU10088),
DIN 477 28,8 (8BC250-D for TC-SU10088),
OR COMPARABLE

SPECIFICATION: DOT 3AA 2265 /TC 3AAM 173 or TC-SU10088-173
MODEL: 8BC250

1. Principal Elements:

- Min. water capacity:	95.2 lbs	(43.2 kg)
- Min water volume:	2640 in^3	(43.2 liter)
- Approx. cyld. weight:	115 lbs	(52.2 kg)
- DOT Service pressure:	2265psi	(156.2 bar)
- TC Service pressure:	173 bar	
- Test pressure:	3775psi	(260.3 bar)

2. Material: Chrome-Moly steel, (A.I.S.I. 4130X)

3. Manufacture:
Hot billet pierce followed by hot drawing.

4. Heat Treatment: Q & T

5. Norris Standard Mechanical Properties:
- Tensile: ≥ 105,000 psi (724 MPa)
- Elong.: ≥ 20% (on 2" gauge)
- Flattening: to 6xt without cracks

D.O.T. Wall Stress Calculations: $S = P(1.3D^2 + 0.4d^2)/(D^2 - d^2)$

S = Maximum wall stress, psi
P = Test pressure, psi
D = Outside diameter, inch
d = Inside diameter, inch

$$s = \frac{3775\,[1.3\,(9.157)^2 + 0.4\,(8.735)^2]}{(9.157)^2 - (8.735)^2}$$

s = 69,759psi (481 MPa)

Required Minimum tensile: $= \frac{69,759}{0.67} = 104,118$ psi (717.9 MPa)

NOTE:
Charpy at -50'C ≥ 28 J/cm^2 on customer request.
(Individual specimen)

NORRIS CYLINDER COMPANY
4818 WEST LOOP 281 LONGVIEW, TEXAS 75603 USA

REFILLABLE SEAMLESS STEEL GAS CYLINDER, MODEL 8BC250 /TC

SCALE	NOT TO SCALE		DRAWING NO.	REV.
DWN. BY	S. JOHNSON	10/30/91	901A-B-9105	09
CHK'D BY	RS	10/30/91		
APP'D BY	BALDUR	10/30/91	SHEET NO. 1 OF 1 SHEETS	