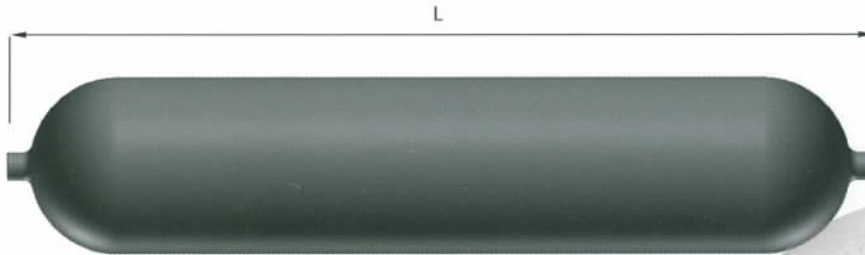


Production of cylinders in any length up to 2100 mm

## 2 NECKED CASCADE CYLINDERS Ø 273 up to 100 Lt. working pressure 275 bar



2-NECKED CASCADE CYLINDERS COMPLYING WITH PED DIRECTIVE (97/23/CE)							
<b>REFERENCE TECHNICAL STANDARD:</b>				IEN 13445			
Water capacity [Lt.]	40	50	60	70	80	90	100
Nominal weight [kg.]	69	82	95	107	120	133	146
Lenght l [mm.] (±20)	1000	1190	1385	1575	1770	1960	2150
<b>Material:</b>	SEAMLESS STEEL TUBE		34CrMo4	(EN 10083-1)			
<b>MANUFACTURING DETAILS</b>							
MANUFACTURING PROCESS: HOT SPINNING OF SEAMLESS STEEL TUBE							
HEAT TREATMENT: QUENCHING AND TEMPERING							
MECHANICAL PROPERTIES (min.)							
R <sub>m</sub> [Mpa]	R <sub>e</sub> [Mpa]	A <sub>5</sub> [%]	KV IMPACT TEST AT -50 °C [J/cm <sup>2</sup> ]				
1000	860	14	average on 3 specimens			single value	
HB= 290 ÷ 320			40			32	
<b>DESIGN DATA</b>							
NECK THREAD	Inl. thread	Ext. thread	Ø <sub>e</sub>	Ø <sub>i</sub>	h		
	25E EN 629-1	-	45	-	≈ 25		
	W31,3 DIN 477	-	45	-	≈ 25		
	Alternative thread to customer's requirement						
MINIMUM EFFECTIVE THICKNESS for the cylindrical wall, net of tolerance:						<b>8 mm</b>	
Working pressure: up to 275 bar		Test pressure = up to 393,3 bar			Burst pressure: ≥ 638,32 bar		
Working temperature: min. -40 °C; max +80 °C							