



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)**

Code 2
M.Dalakeh

REV.	DATE	DESCRIPTION	DRAWN	CHECKED	APPROVED
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.

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Detail Drawings for Pulsation Dampers

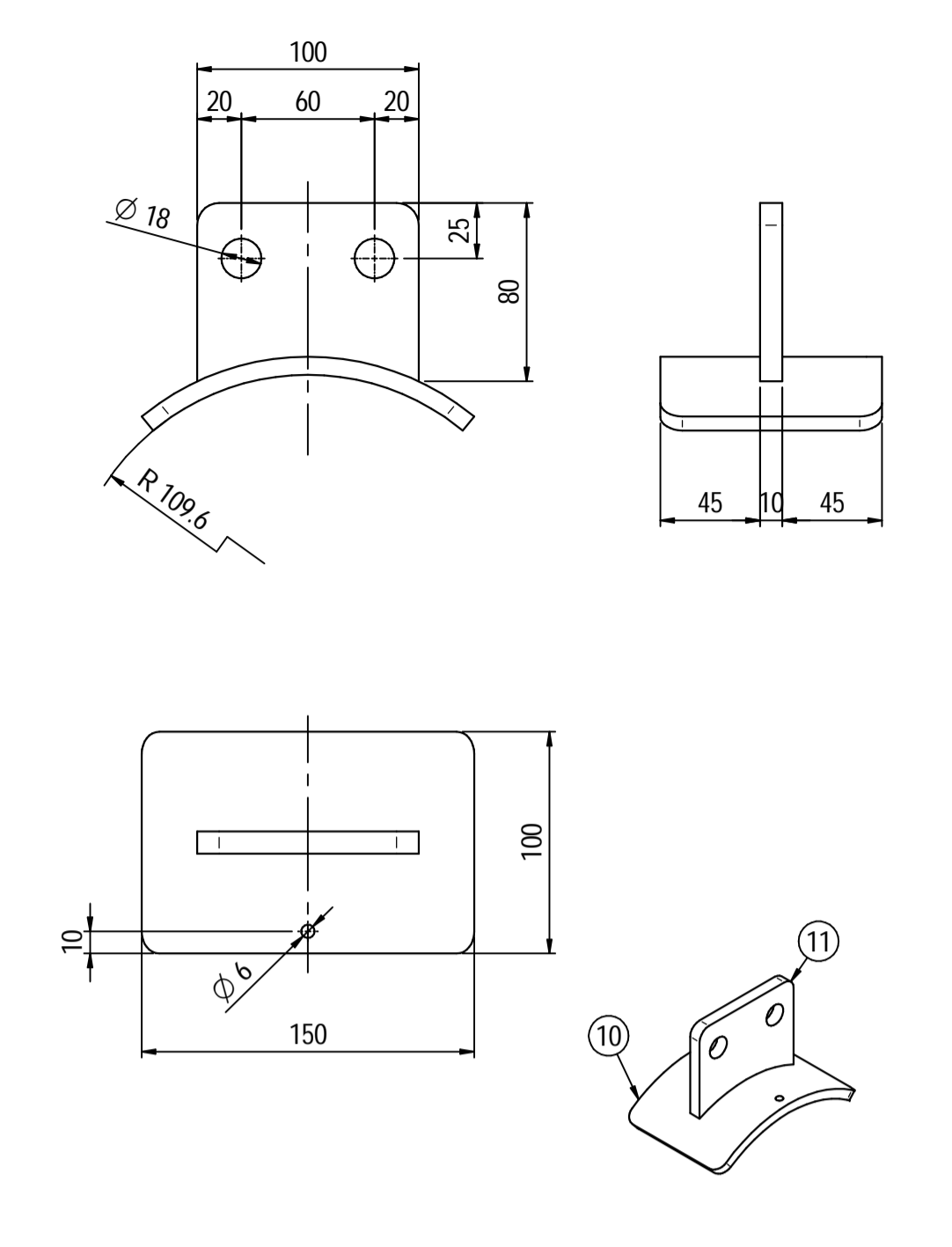
Document No. 17735-23B

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

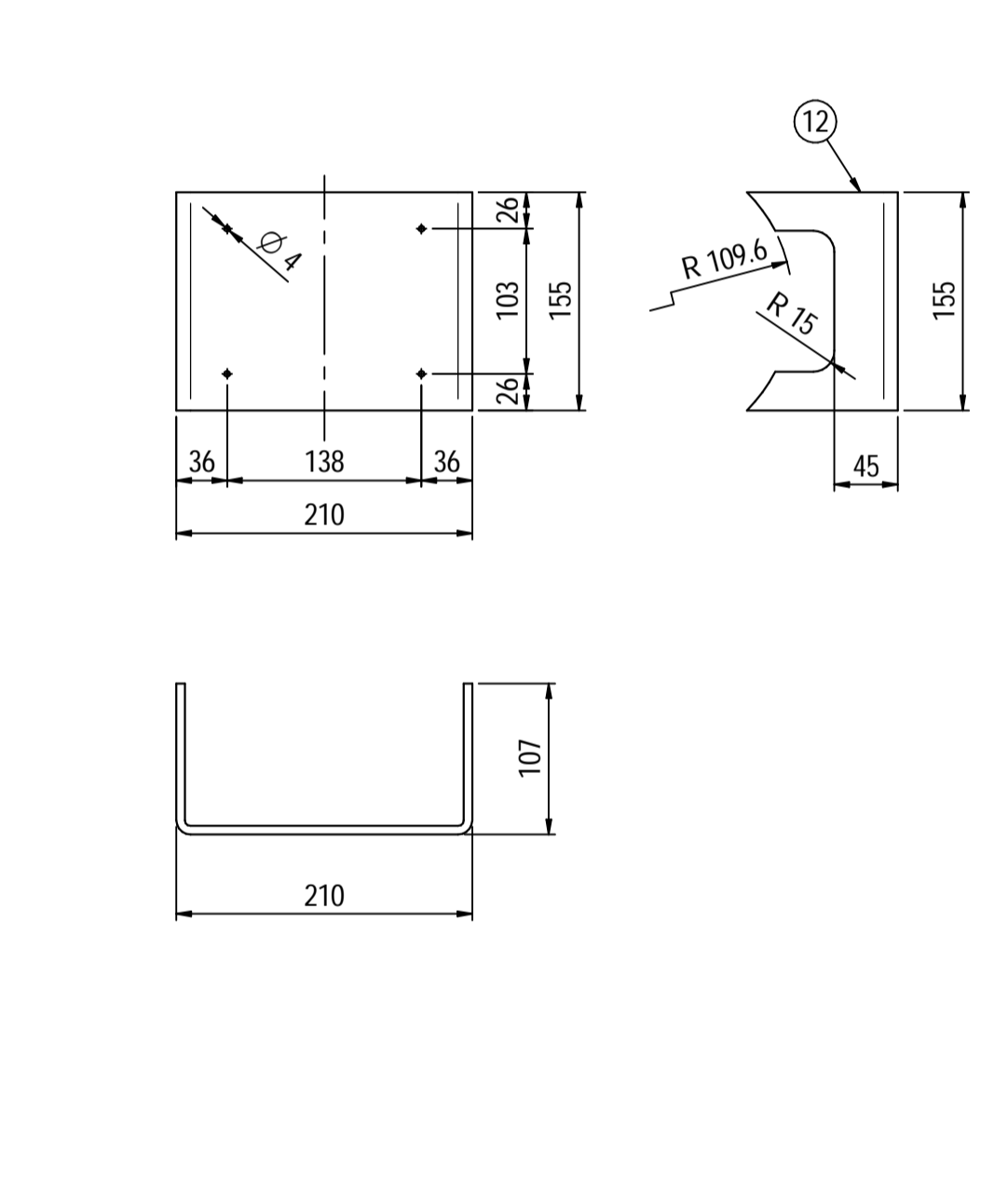
LIST OF REVISED PAGES

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						
9						34						59						84						
10						35						60						85						
11						36						61						86						
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15						40						65						90						
16						41						66						91						
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18						43						68						ATTACHMENT						
19						44						69						1						
20						45						70						2						
21						46						71						3						
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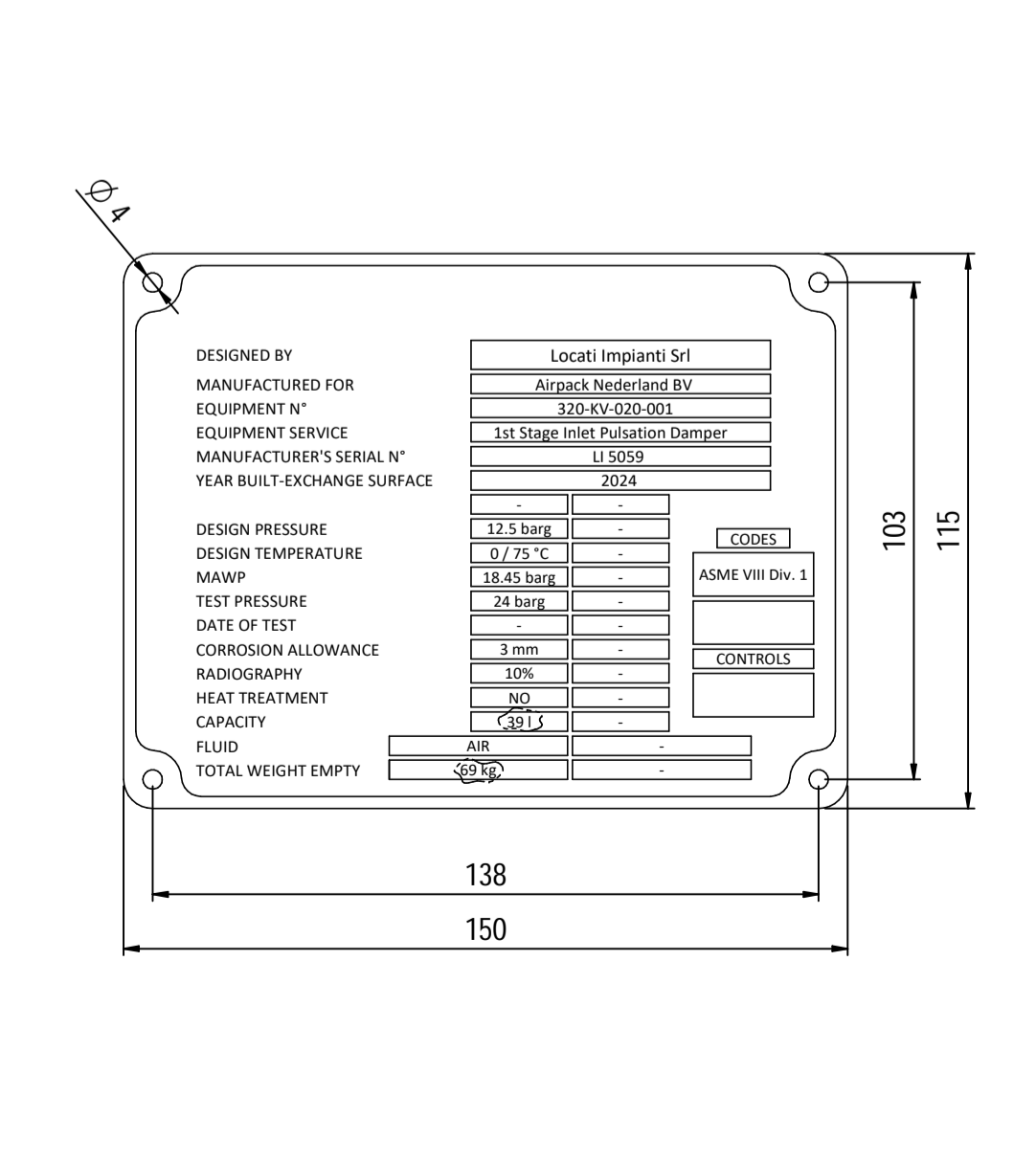
Supports detail
Scale 1 : 3



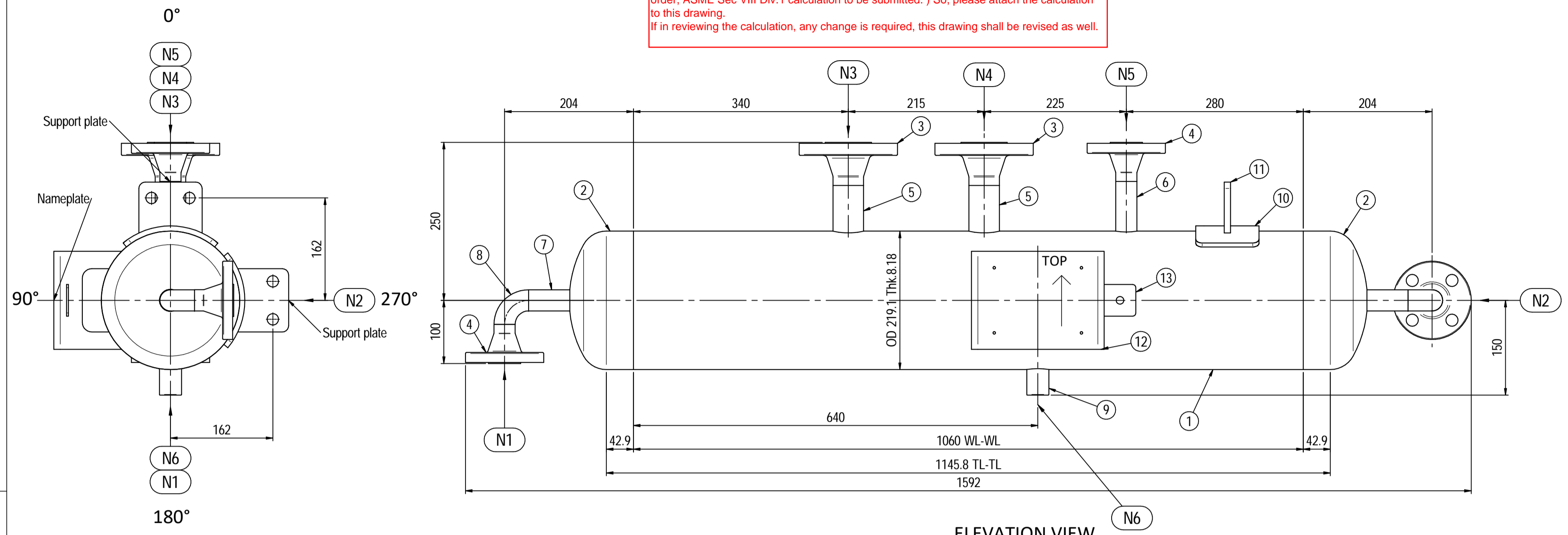
Nameplate detail
Scale 1:5



Nameplate detail
scale 1:1.5



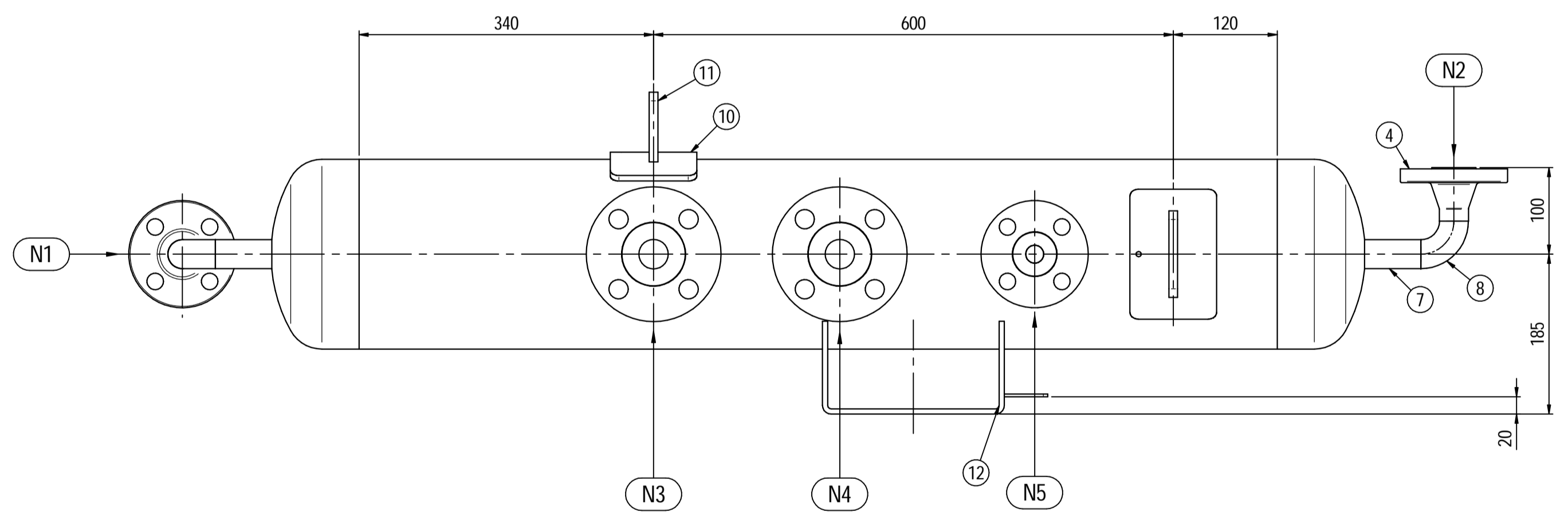
Repetitive comment:
Please be noted that mentioned document is not found on the VPIS. On VPIS only "Pulsation Study Approach 1 Calculations" is considered which is different from mechanical calculation. Therefore please consider below comment from previous revision.
General comment for all drawing:
Please note that drawing shall be submitted with calculations. (As per agreements in before order, ASME Sec VIII Div.1 calculation to be submitted.) So, please attach the calculation to this drawing.
If in reviewing the calculation, any change is required, this drawing shall be revised as well.



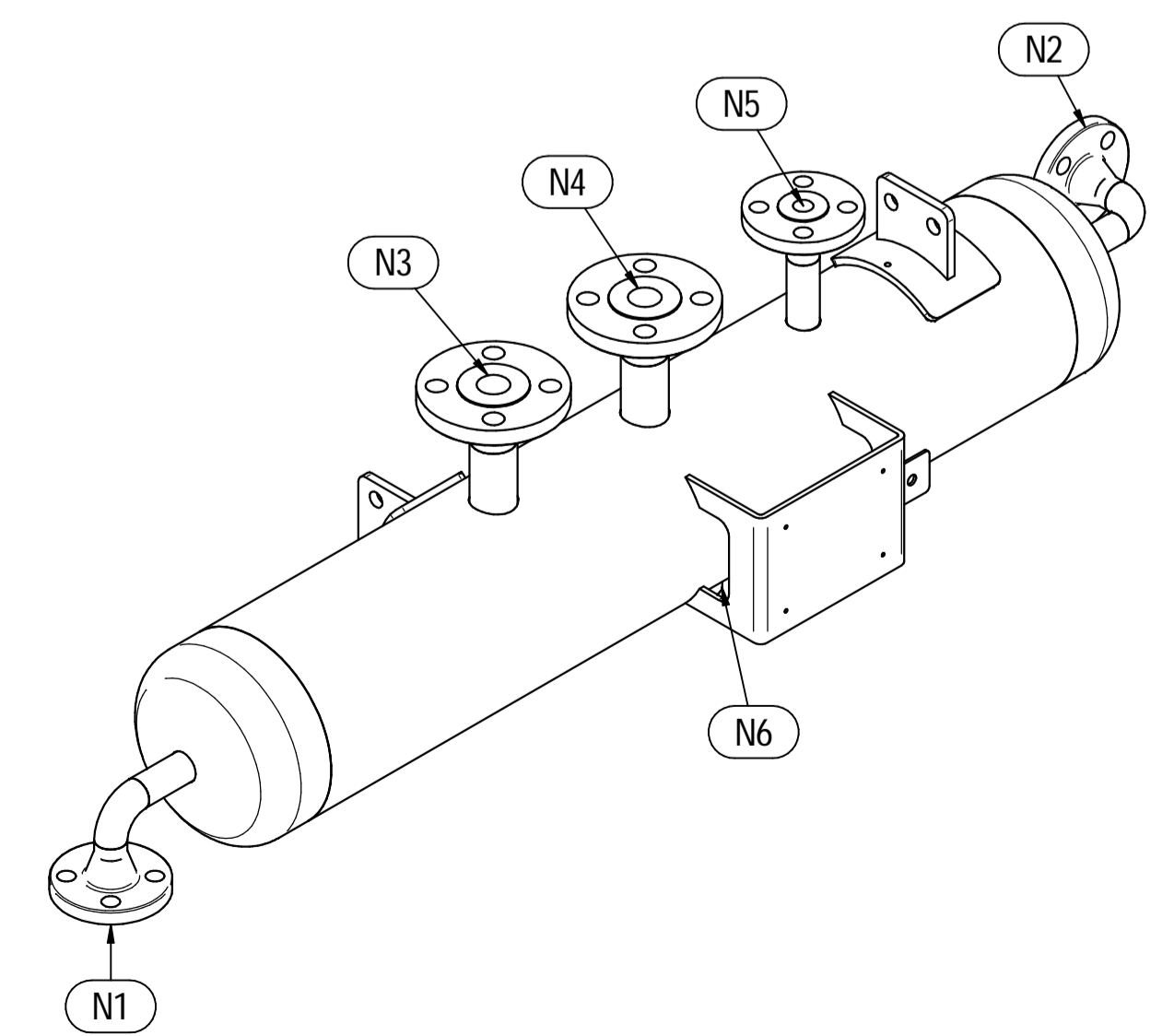
ELEVATION VIEW

ORIENTATION VIEW

Note and calculation shall be bring back.



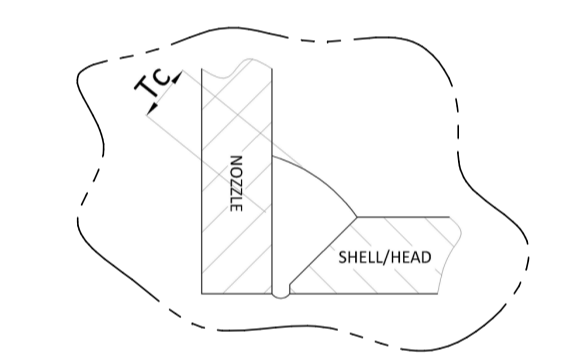
PLAN VIEW



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)



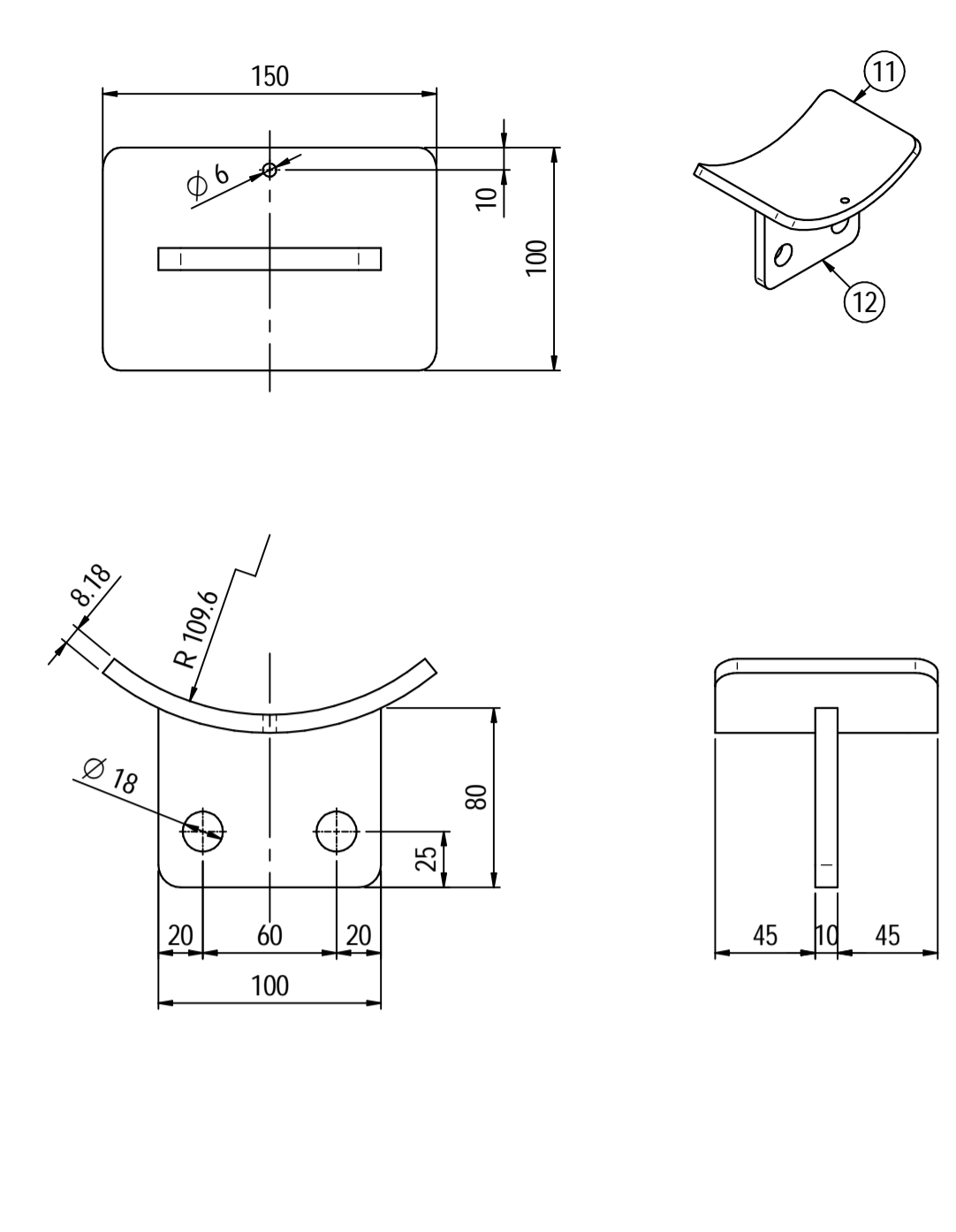
N°	QTY	DESCRIPTION	SIZE	O.D.	THK	RATING	TYPE	FACE	O.D.	THK.	Tc
N6	1	DRAIN	1/2"	38.1	8.38	#6000	NPT-F	-	-	-	8±10
N5	1	PSV CONNECTION	1"	33.4	6.35	#300	WN RF	-	-	-	8±10
N4	1	TEMPERATURE GAUGE	1 1/2"	48.3	7.14	#300	WN RF	-	-	-	8±10
N3	1	TEMPERATURE TRANSMITTER	1 1/2"	48.3	7.14	#300	WN RF	-	-	-	8±10
N2	1	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	QTY	SERVICE	SIZE	O.D.	THK	RATING	TYPE	FACE	O.D.	THK.	Tc
ITEM	Qtà	SERVIZIO	NPS/DN	O.D.	THK	RATING	TYPE <td>FACE</td> <td>O.D.</td> <td>THK.</td> <td>Tc</td>	FACE	O.D.	THK.	Tc

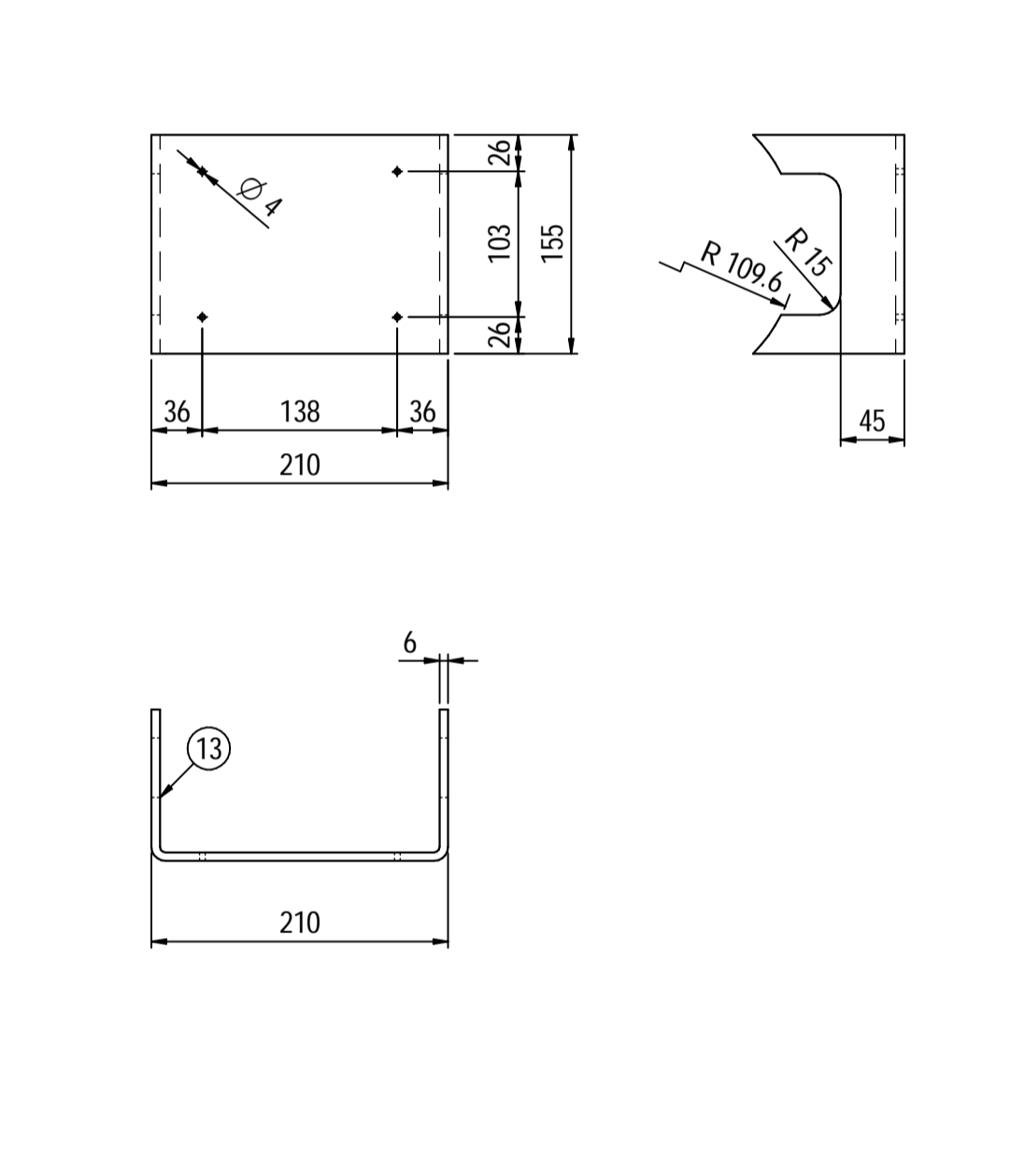
DATI DI PROGETTO / Design data		COLLAUDO / Test	
FLUIDO	Air	COLLAUDO	Test
STATO FISICO DEL FLUIDO	Gas	PED	N/A
CODICE DI CALCOLO	ASME VIII Div.1 Ed.2021	SERVIZIO LETALE	NO
PRESSIONE DI ESERCIZIO	9.5 barg	X-RAY	NO
PRESSIONE DI PROGETTO	12.5 barg	RT examination	Spot (10%)
PRESSIONE ESTERNA	NO	LIQUIDI PENETRANTI	NO
PRESSIONE DI PROVA IDRAULICA	24 barg	ULTRASUONI	NO
TEMPERATURA DI ESERCIZIO	5 - 46°C	CONTROLO MAGNETICO	NO
TEMPERATURA DI PROGETTO	75°C	ALLONNE DI SALDATURA	NO
SOUVRANETA' ALLO DI CORROSIONE	3 mm	PROCEDIMENTO DI SALDATURA	See doc. C230048WBK009
CAPACITA'	39 l	TIPO DI FONDO	CAP
EFFICIENZA GIUNTI	0.85	FORMATURA FONDO	HOT
MAMP @ Design Temperature	18.45 barg @ +75°C	PESO A VUOTO	69 kg
MAMP(EXT)	NO	PESO IN ESERCIZIO	69 kg
MDMT @ MAMP	0°C @ 18.45 barg	PESO PIENO D'ACQUA	109 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	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

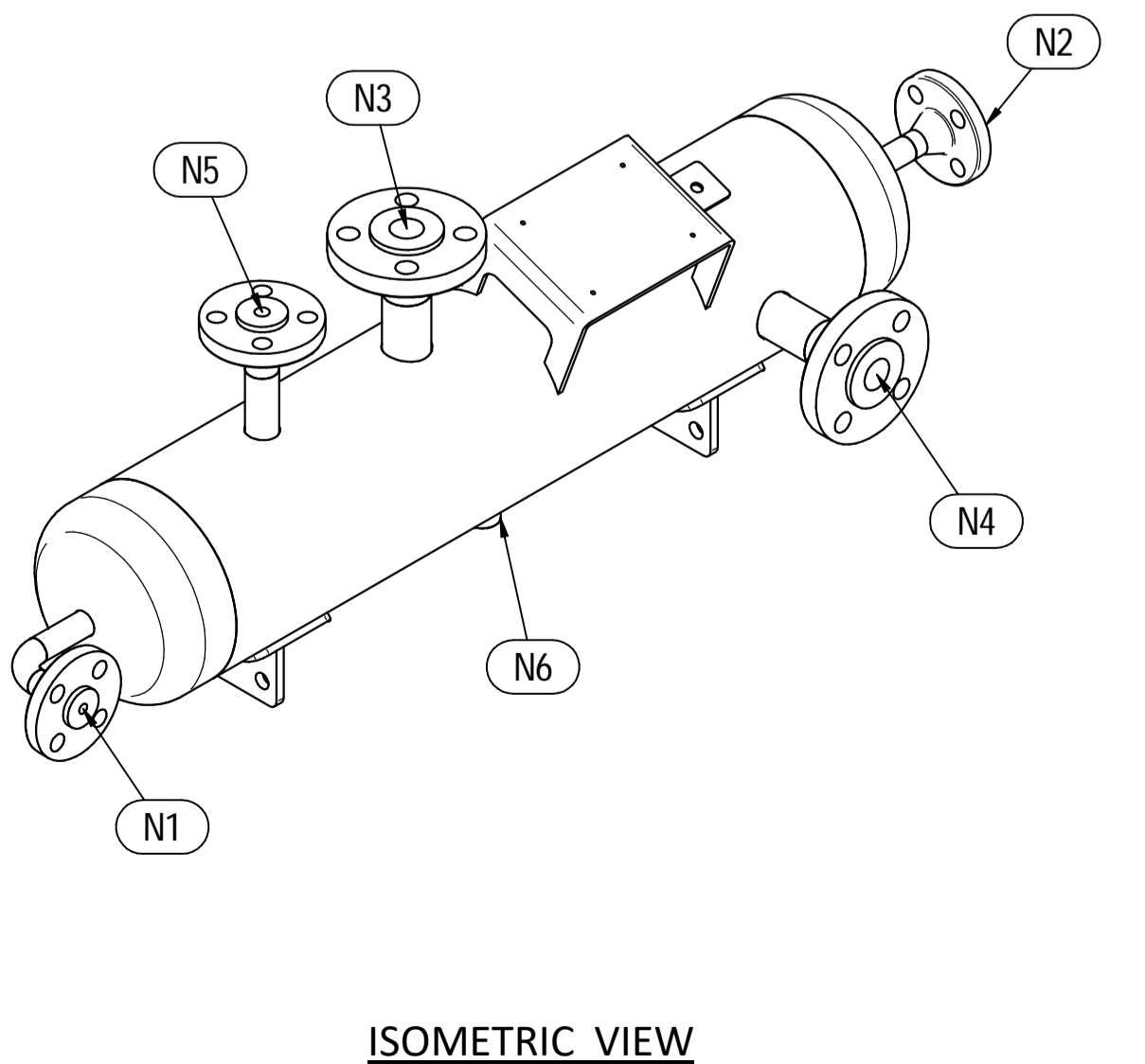
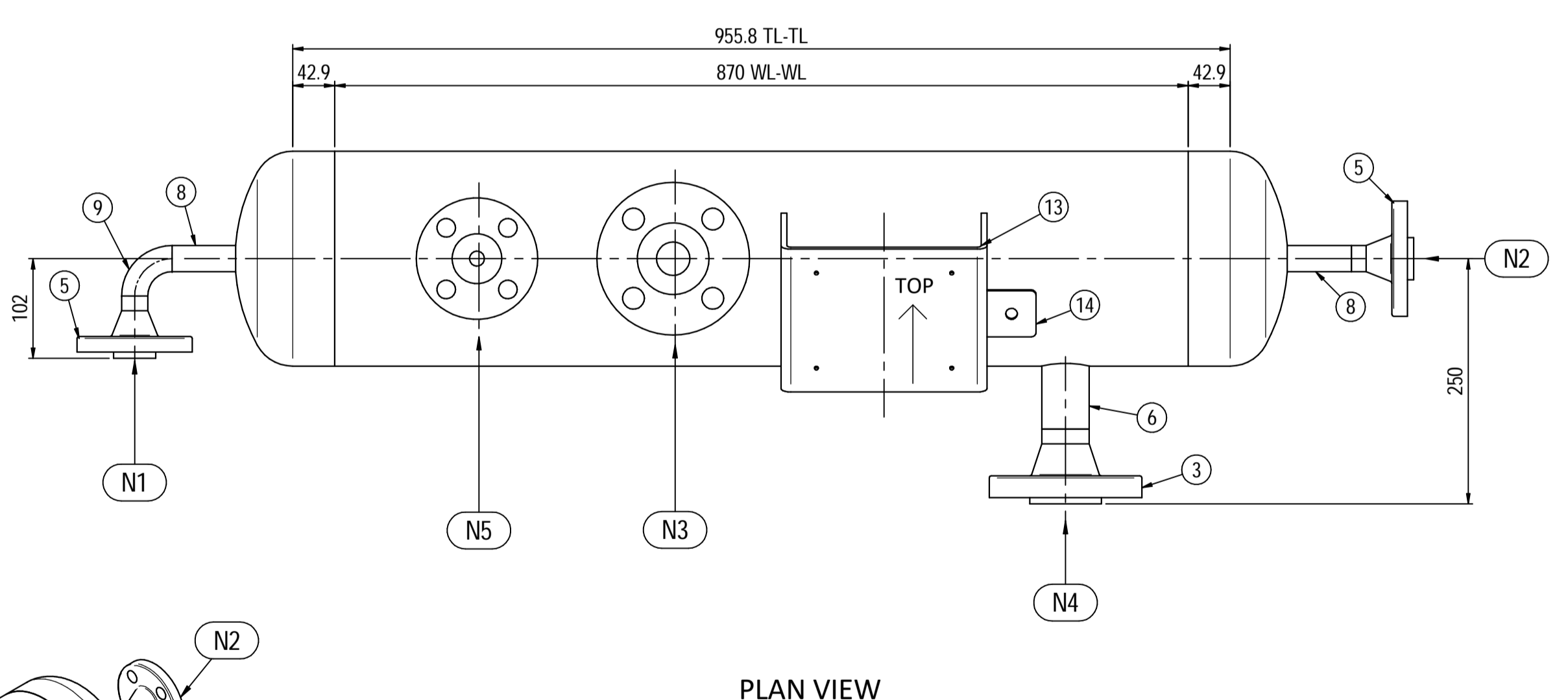
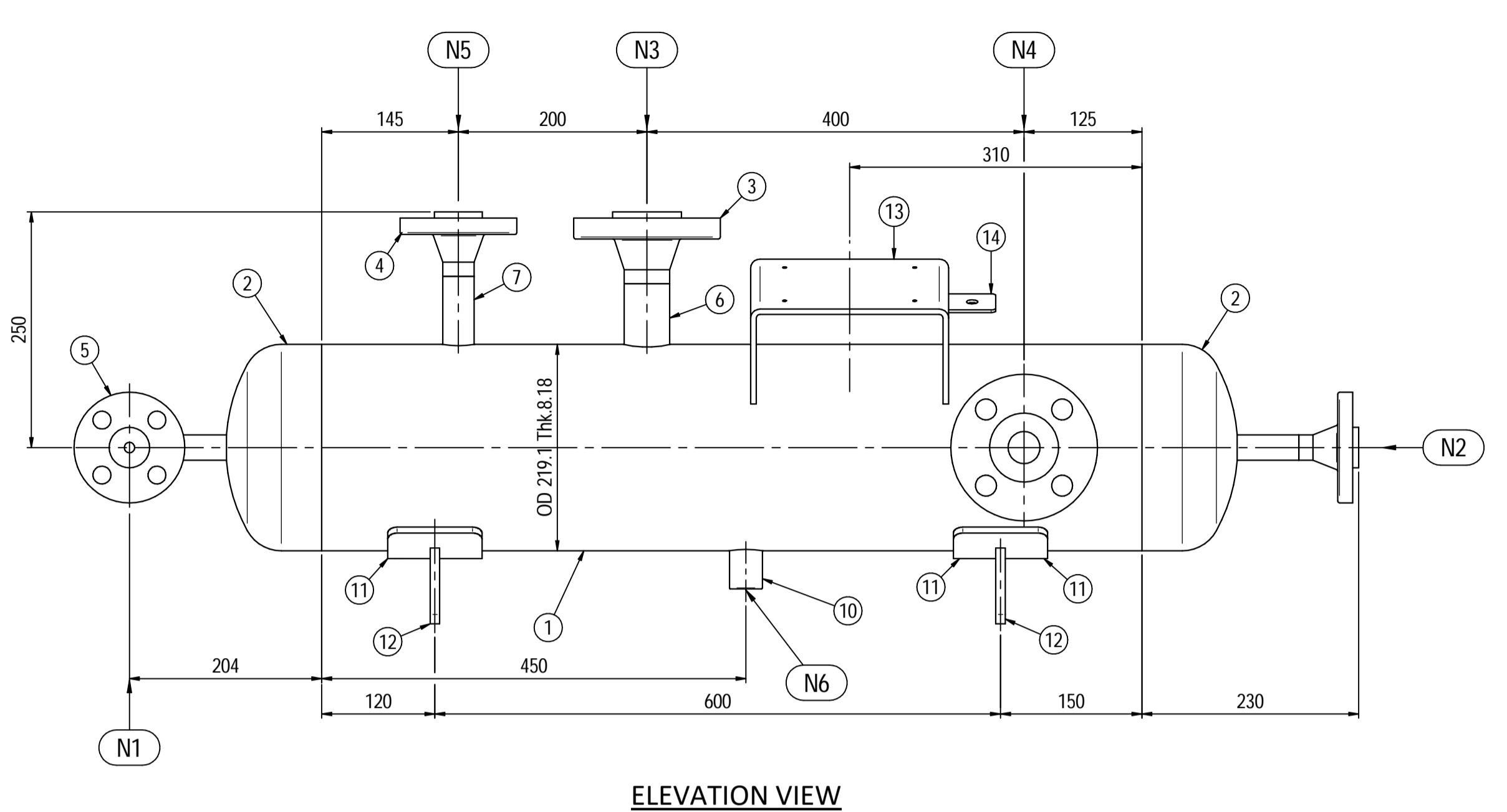
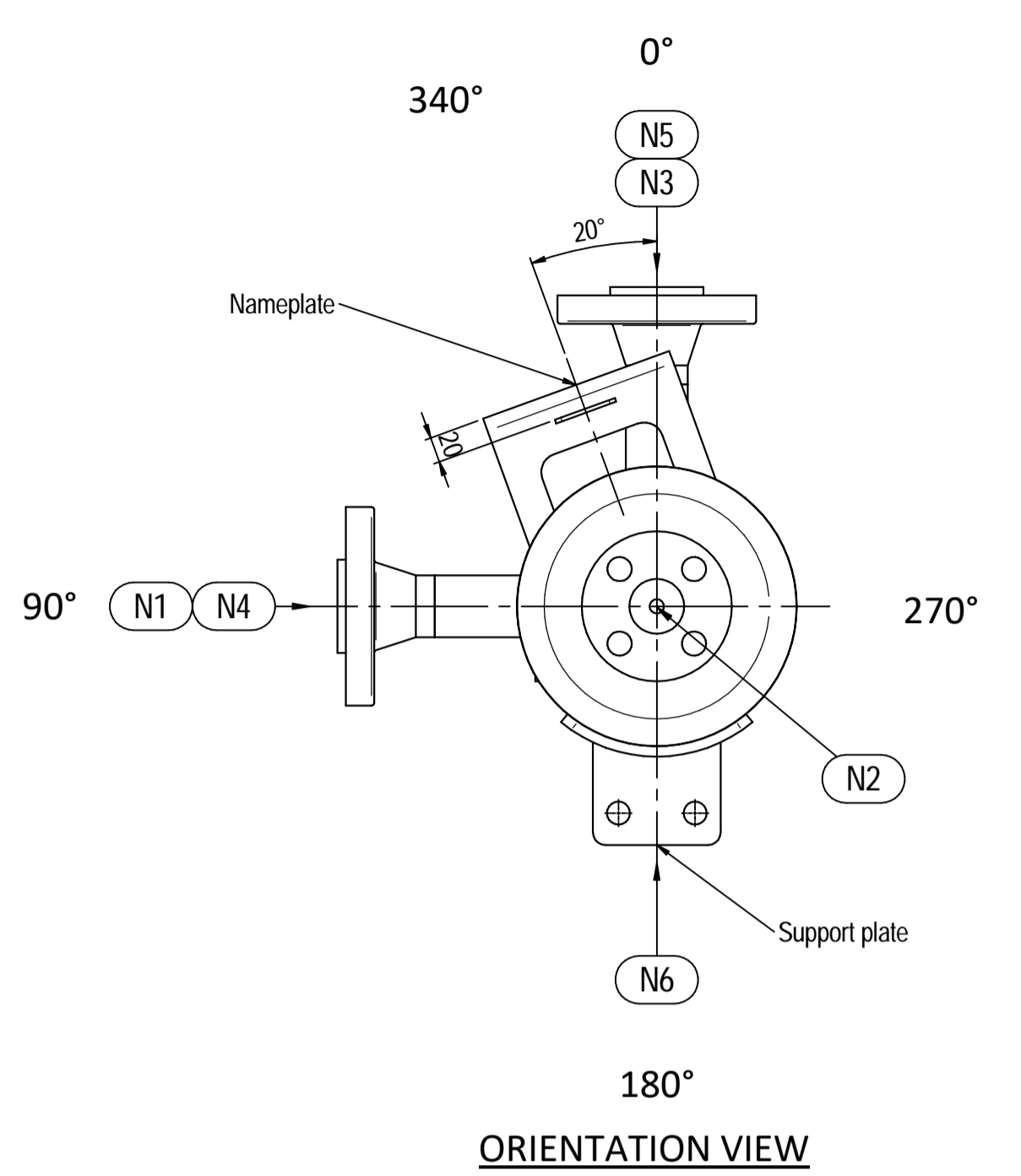
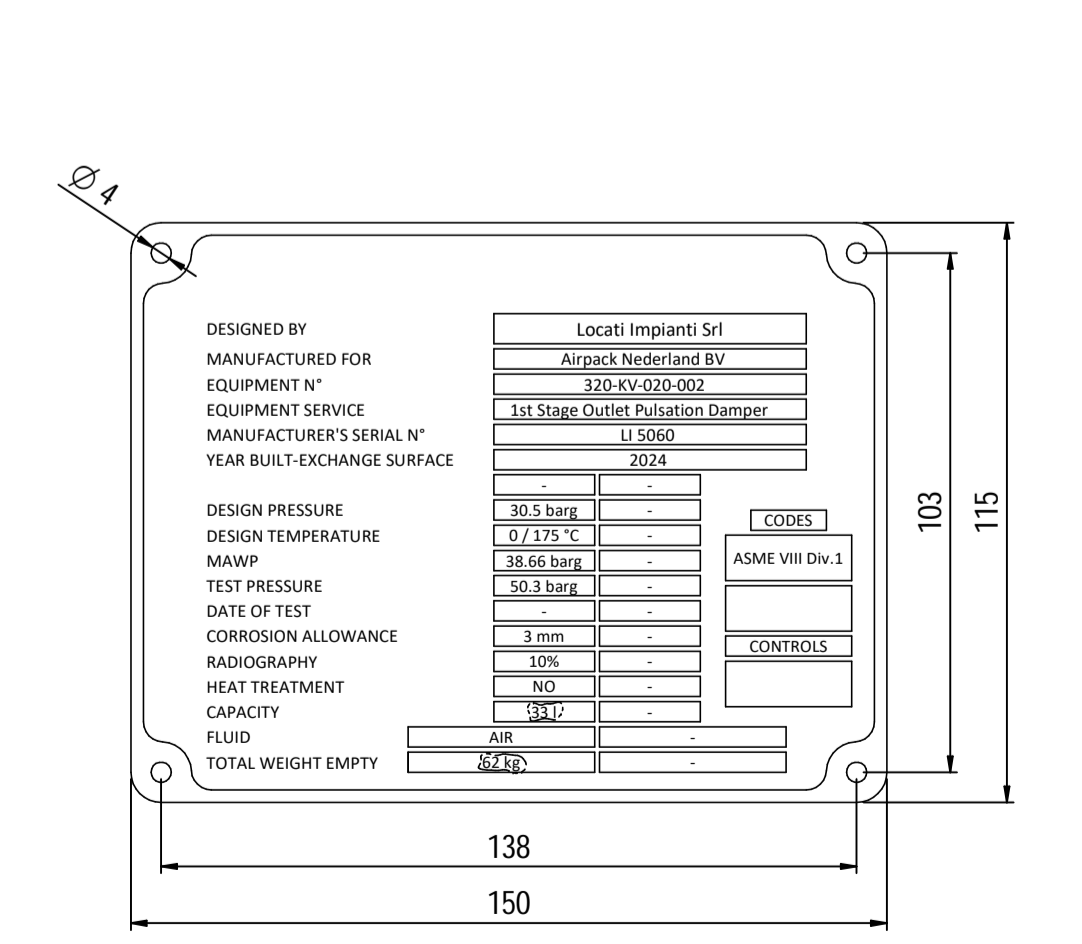
Supports detail
Scale 1 : 3



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					0094 Iqqa Inspection Iberia SA
STATO FISICO DEL FLUIDO		Gas				Test					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				X-RAY					Spot (10%)
PRESSIONE ESTERNA		NO				LIQUIDI PENETRANTI					NO
PRESSIONE DI PROVA IDRAULICA		50.26 barg				ULTRASUONI					NO
TEMPERATURA DI ESERCIZIO		157 °C				CONTROLLO MAGNETOSCOPICO					NO
TEMPERATURA DI PROGETTO		175 °C				TALONE DI SALDATURA					NO
SOVRAMEZZO 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					

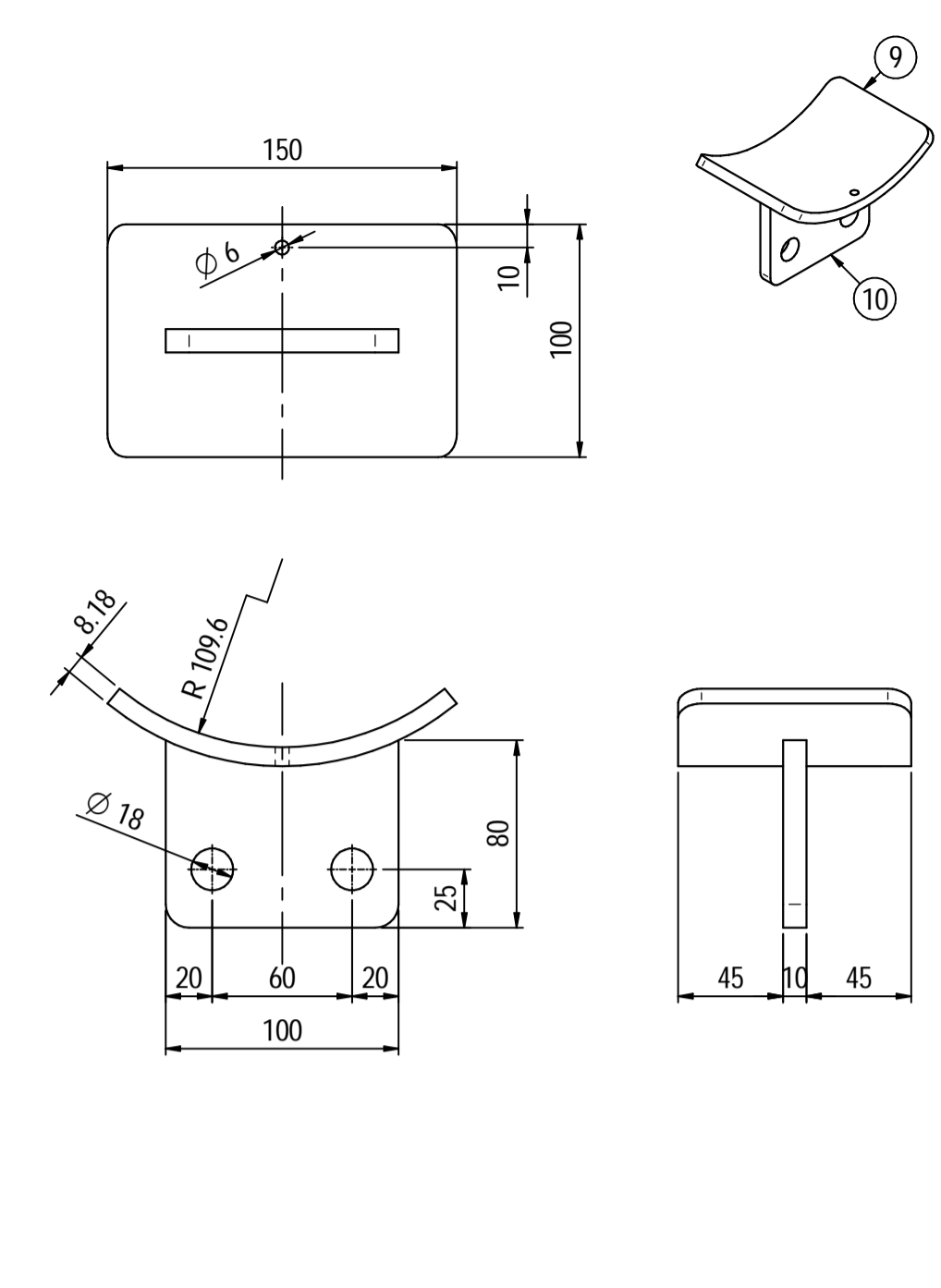
Rev.	Descrizione / Description	Disegnato/Draw	Controllato/Checked	Approvato/Approved	Data/Date
03	Issue for approval	LG	MV	MV	11/09/2024
02	Upated volume	LG	MV	MV	03/08/2024
01	Revised as per Custome comments	LG	MV	MV	11/05/2024
00	FIRST ISSUE	LG	MV	MV	03/02/2024

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

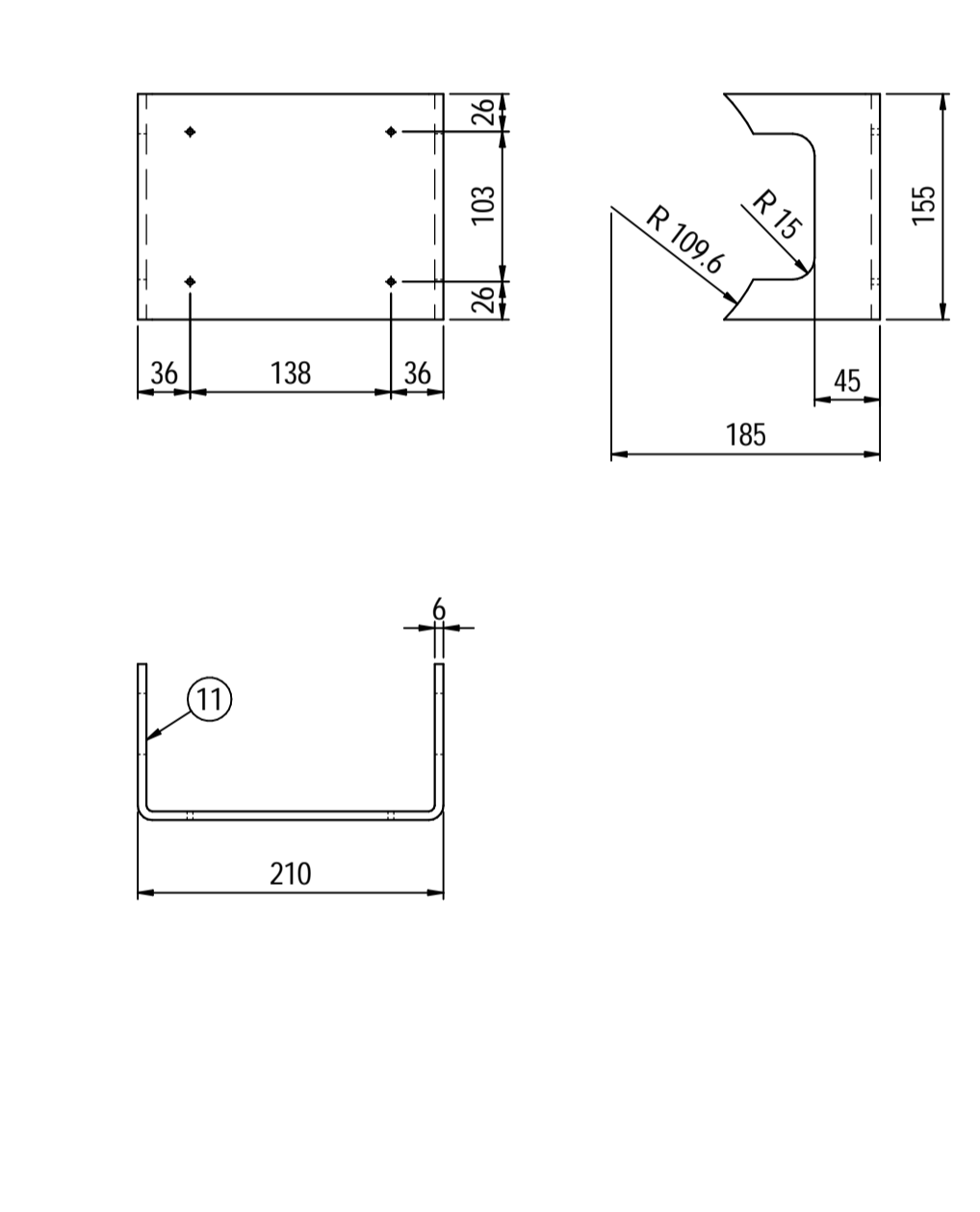
Scala/Scale	1 : 5	Formato/Size	A1
Comm. N°/Job No.	C230048	Foglio/Sheet	1 - 1
Cliente/Customer	Airpack Nederland B.V.		
Ord. No.	17735-VV-900 (SK)		
Dis. N°/Dwg No.	C230048DWG002	Rev.	03

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

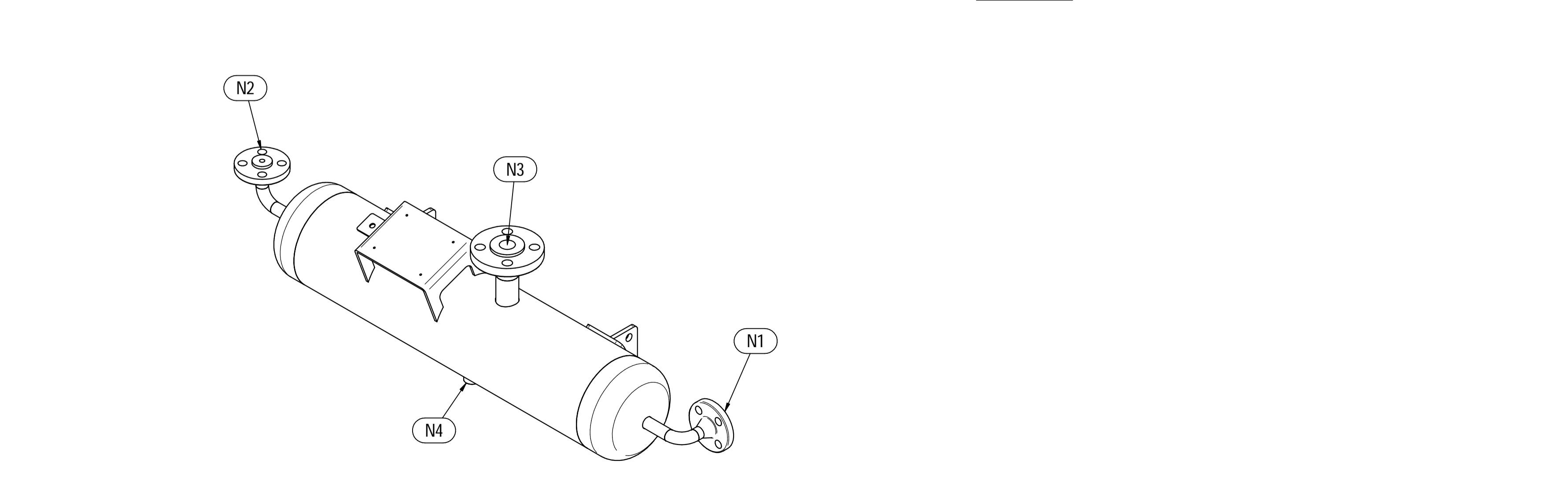
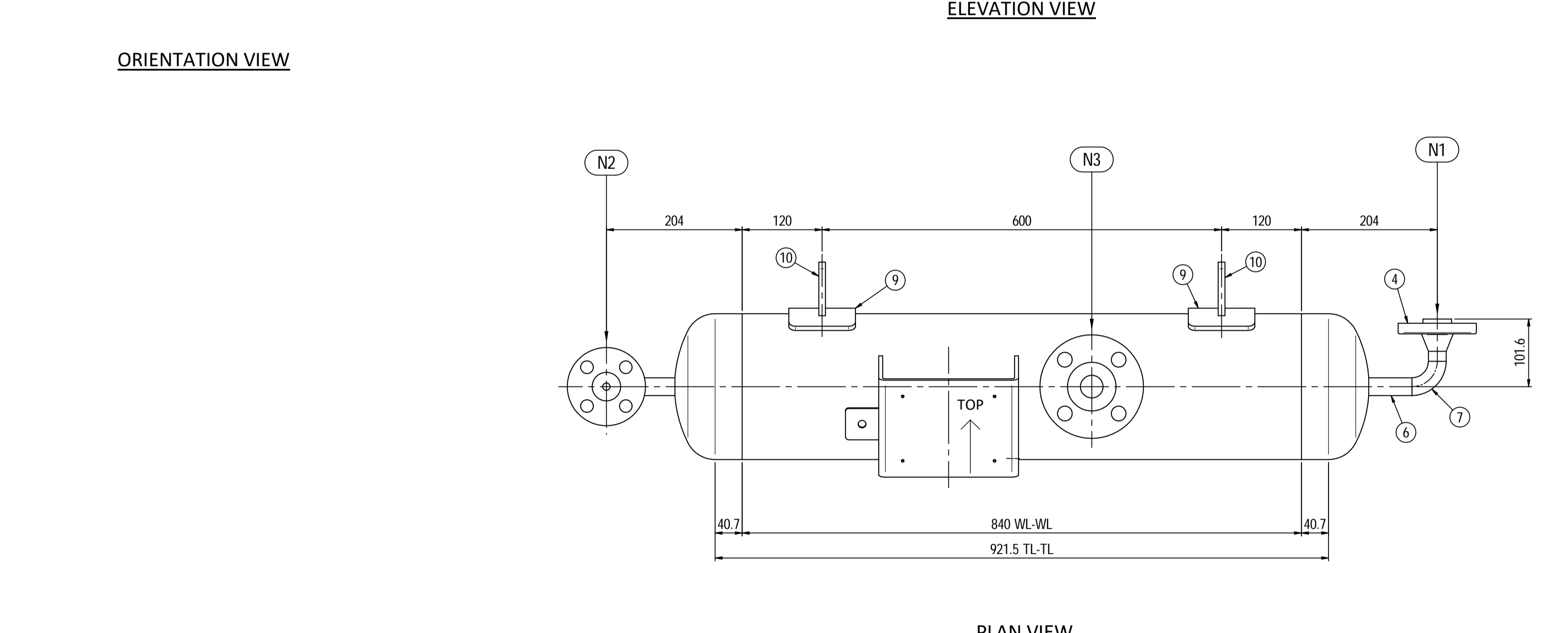
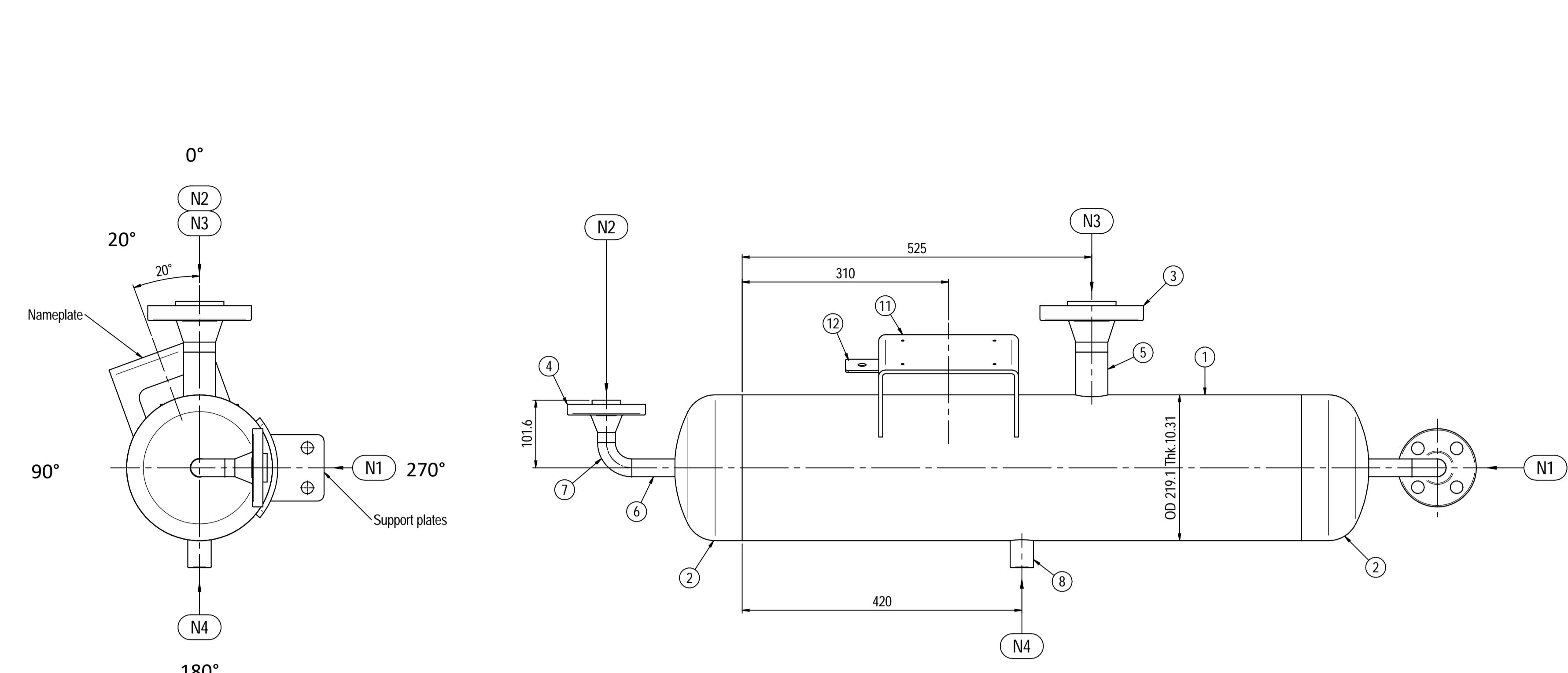
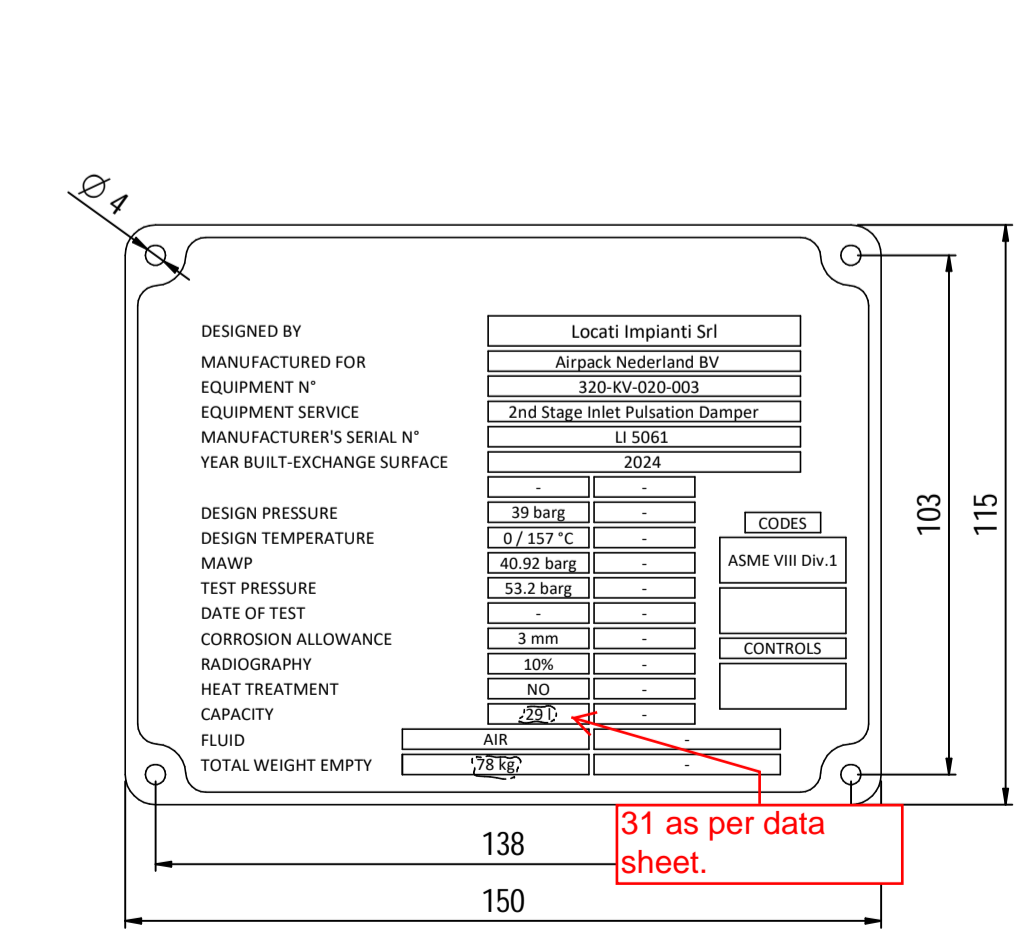
Supports detail
Scale 1 : 3



Nameplate detail
Scale 1:5

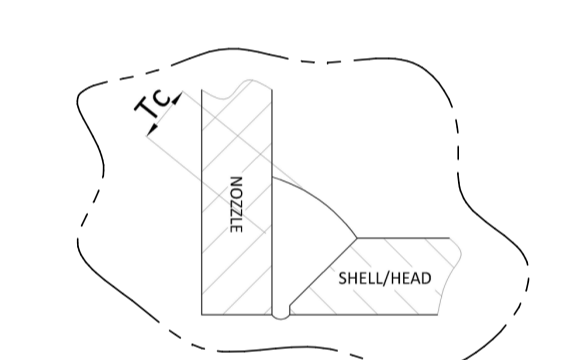


Nameplate detail
scale 1:1.5



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	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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 - 8) All welds are continuous except where indicate
 - 9) ~~Delated~~
 - 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)



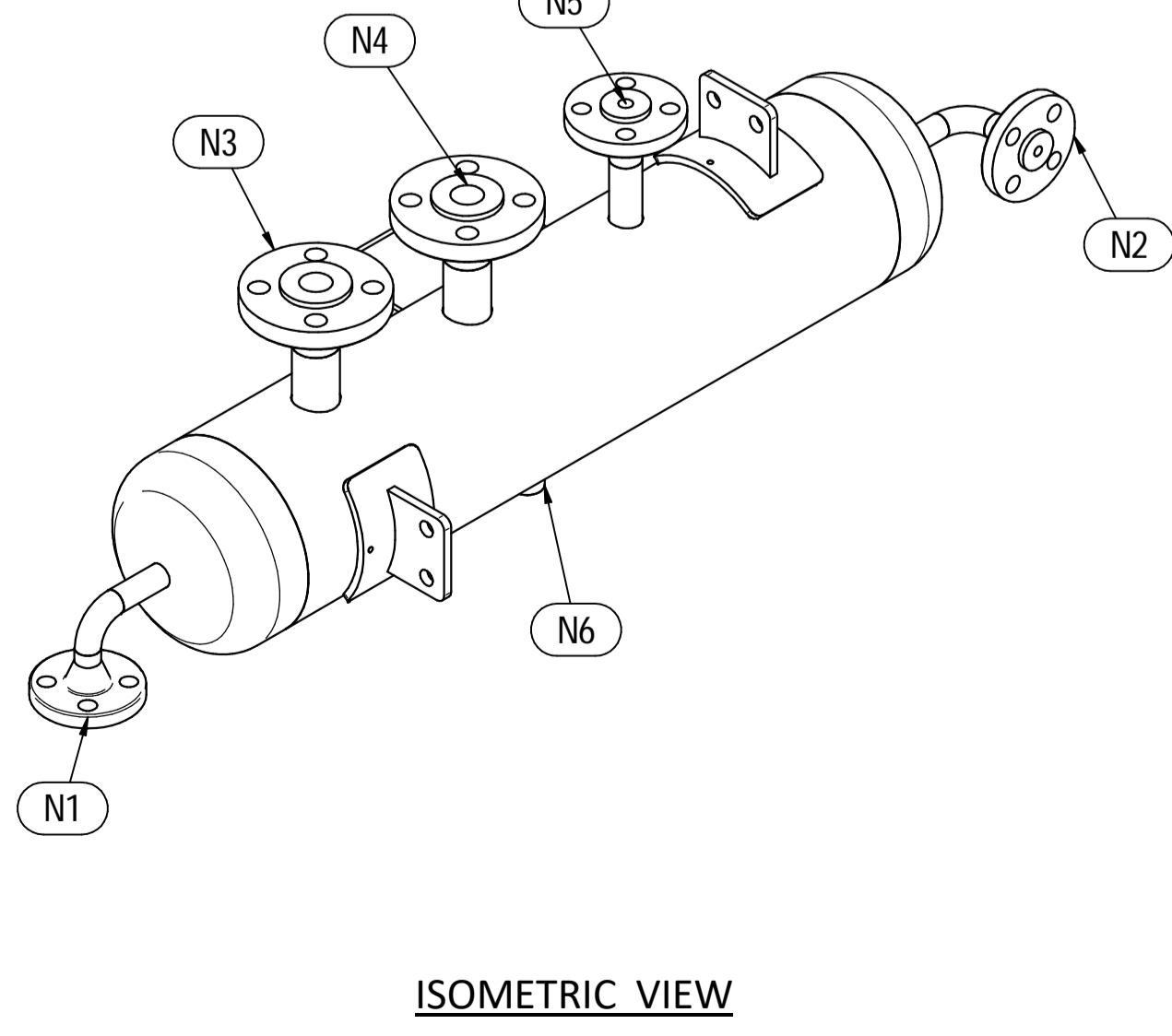
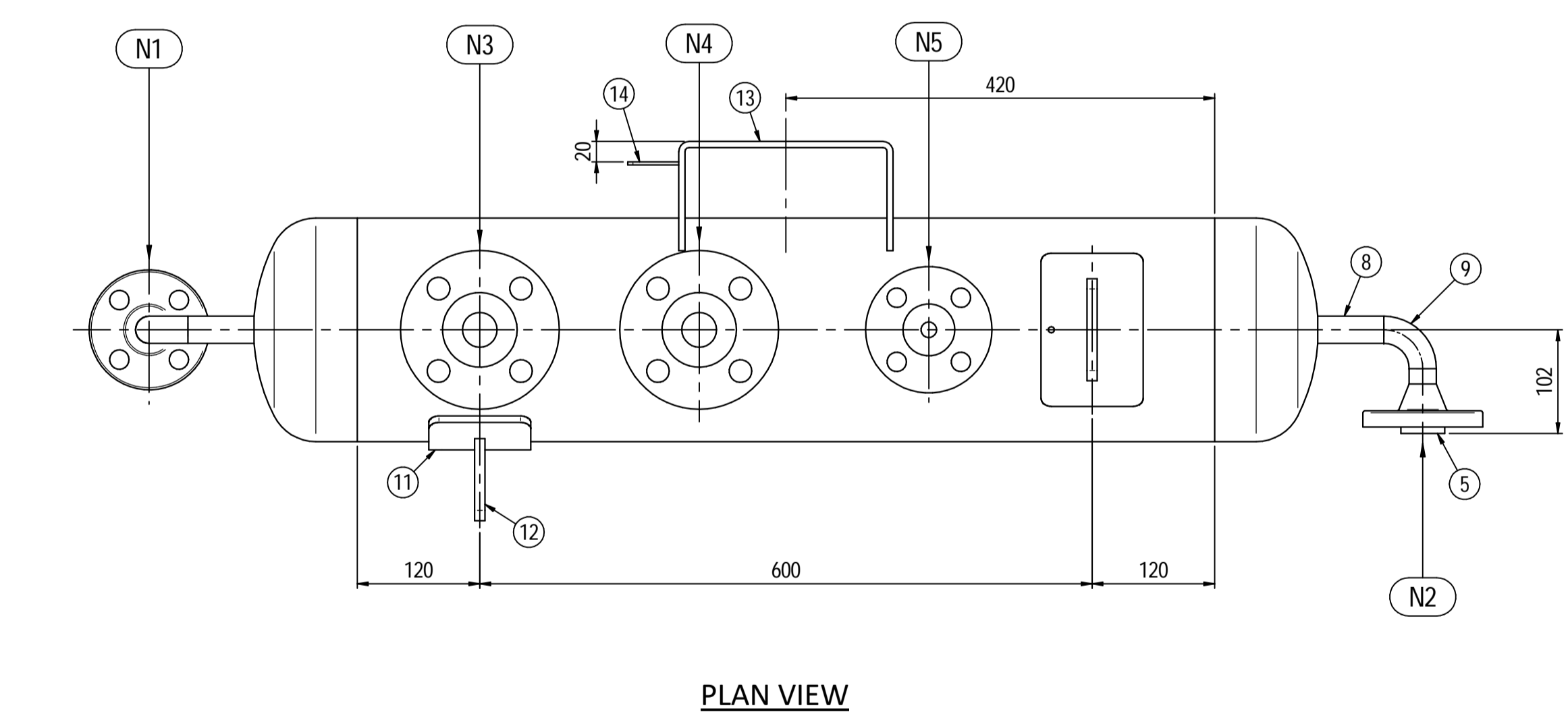
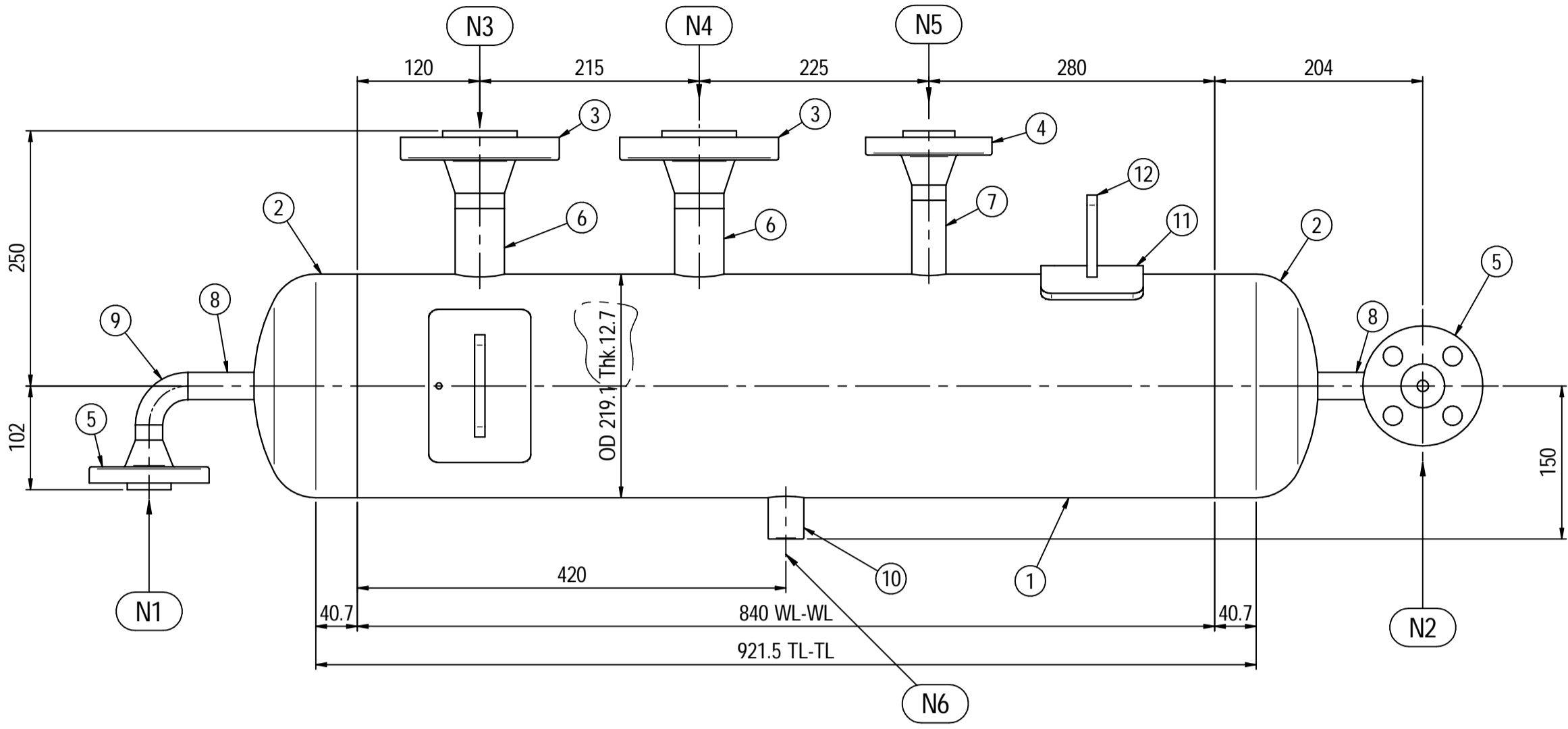
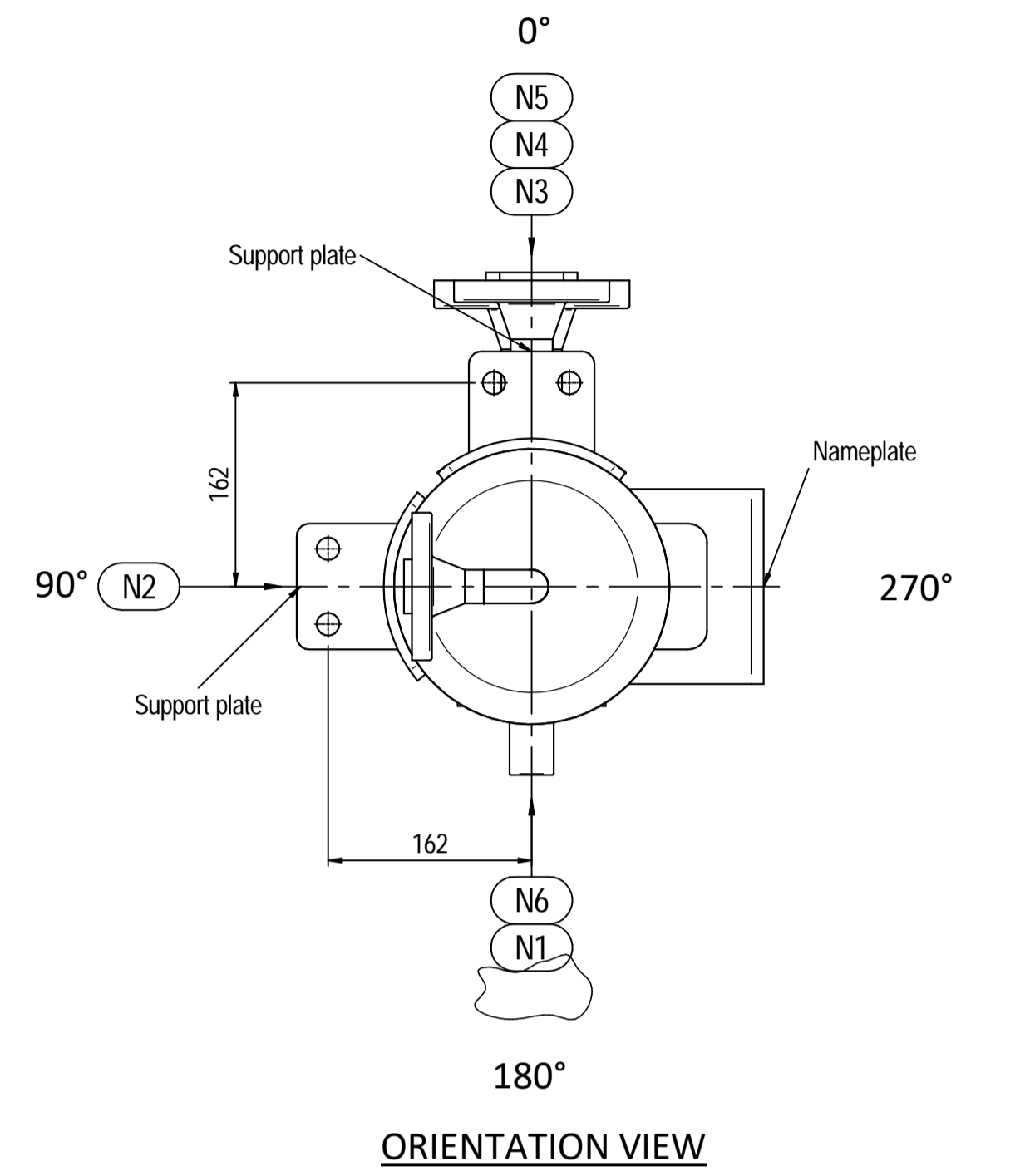
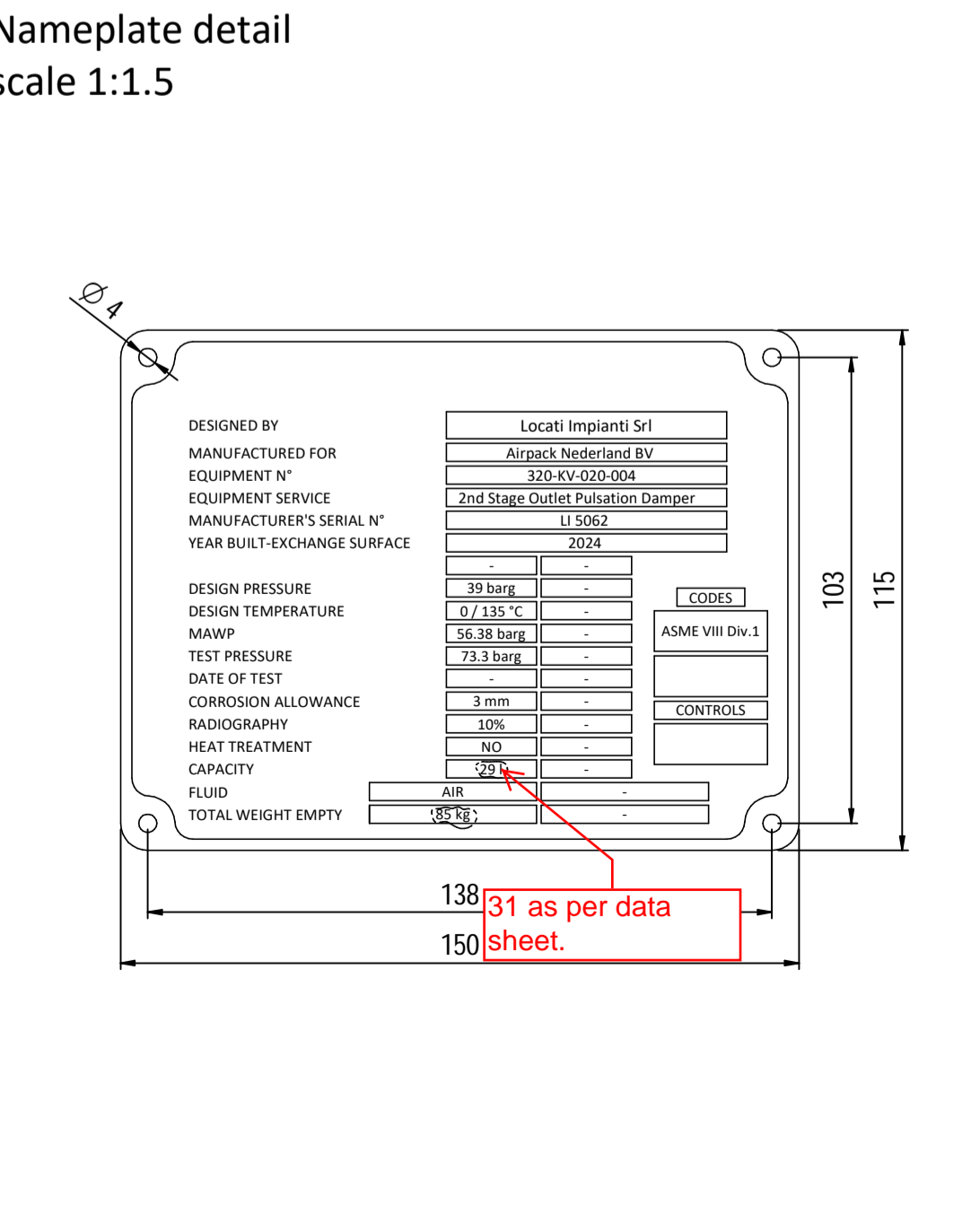
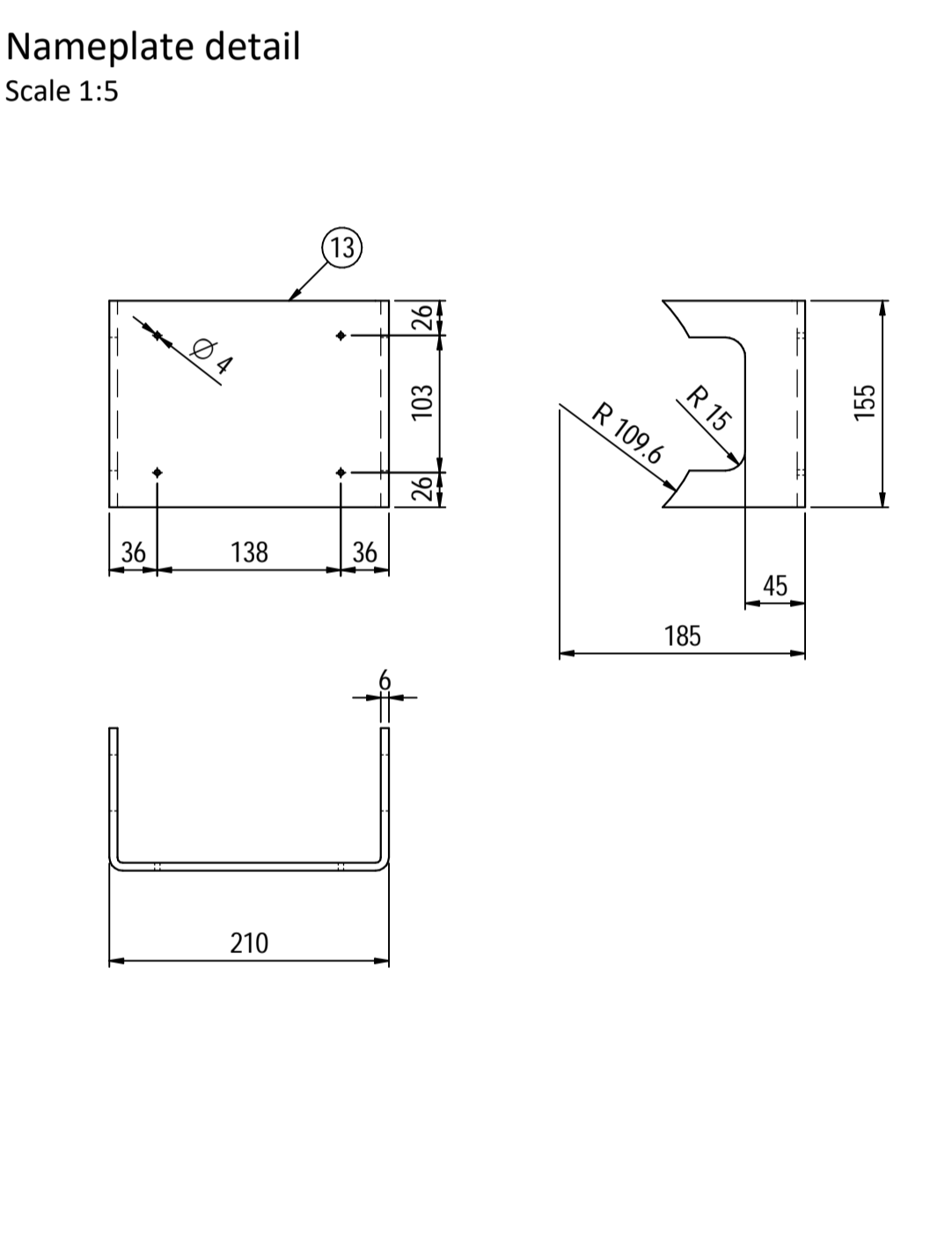
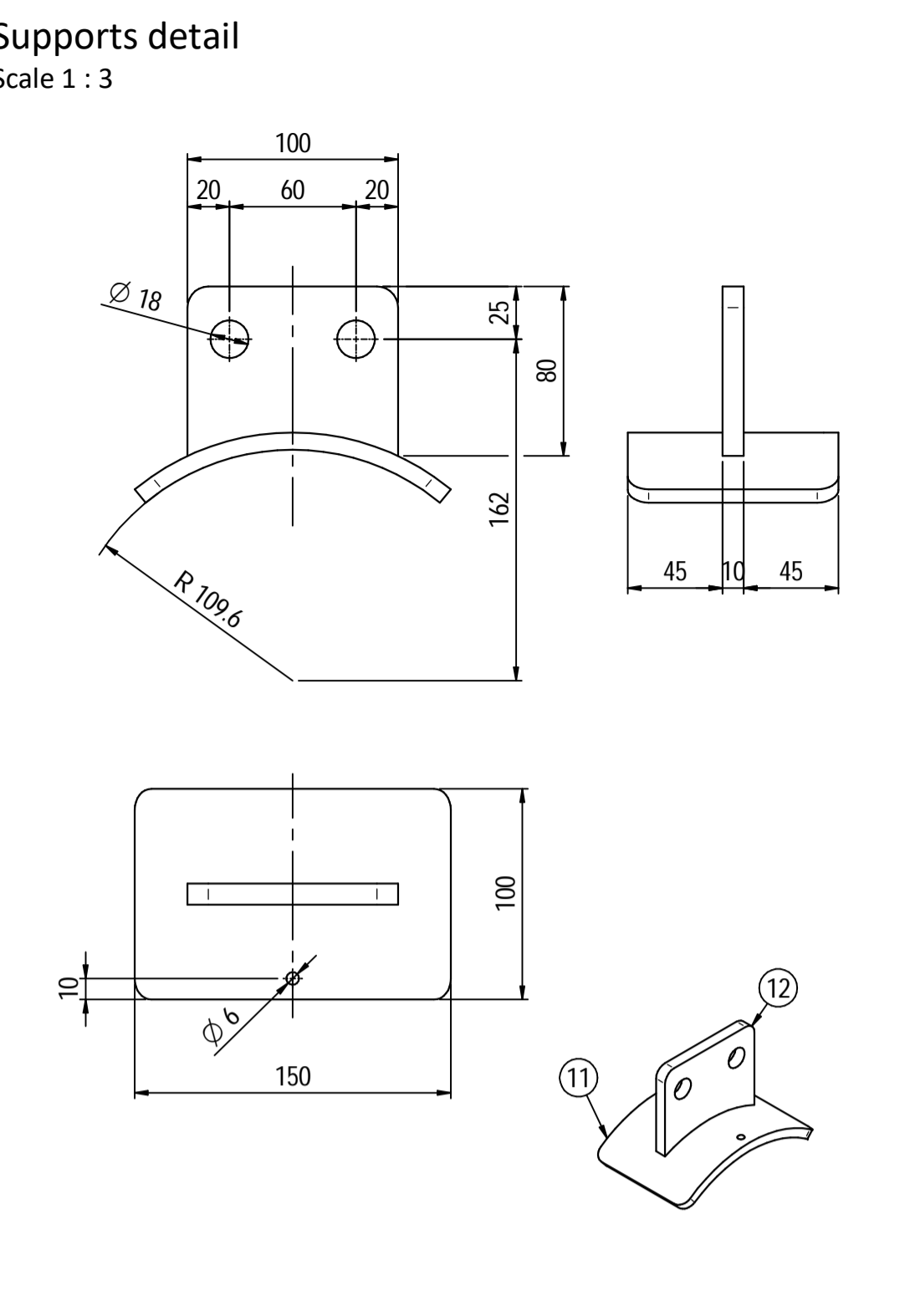
ITEM	QTY	SERVICE	SIZE	O.D.	THK	RATING	TYPE	FACE	O.D.	THK.	Tc
N4	1	DRAIN	1/2"	38.1	8.28	#6000	NPT-F	-	-	-	8 ± 10
N3	1	TEMPERATURE TRANSMITTER	1 1/2"	48.3	7.14	#600	WN RF	-	-	-	8 ± 10
N2	1	AIR OUTLET	1/2"	26.7	7.82	#600	WN RF	-	-	-	8 ± 10
N1	1	AIR INLET	1/2"	26.7	7.82	#600	WN RF	-	-	-	8 ± 10

ITEM	Qtà	SERVIZIO	NPS/DN	O.D.	THK	RATING	TYPE	FACE	O.D.	THK.	RINFORZO
DATI DI PROGETTO / Design data											
FLUIDO		Air									
STATO FISICO DEL FLUIDO		Test									
CODICE DI CALCOLO		ASME VIII Div. 1 Ed.2021									
PRESSIONE DI ESERCIZIO		22.1 barg					SERVIZIO LETALE				
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 TISSUE				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
MAMP @ Design Temperature		40.92 barg @ +157 °C					PESO A VUOTO				78 kg
MAMP(EXT)		NO					PESO PIENO D'ACQUA				108 kg
MDMT @ MAMP		0 °C @ 40.92 barg					PESO A VUOTO				78 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**

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



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 1/2" 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	1/2"	26.7	7.82	#600	WN RF	-	-	-	8 ± 10

ITEM	Qtà	SERVIZIO	NPS/DN	PIPE TUBO	FLANGE	FACE	O.D.	THK.	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		Lethal service				NO
PRESSIONE DI PROGETTO		39 barg		X-RAY		RT examination				Spot (10%)
PRESSIONE ESTERNA		NO		LICUIDI PENETRANTI		Dye penetrant extension				NO
PRESSIONE DI PROVA IDRAULICA		73.3 barg		ULTRASUONI		Ultrasonic extension				NO
TEMPERATURA DI ESERCIZIO		116°C		CONTROLLO MAGNETOSCOPICO		Magnetic particle examination				NO
TEMPERATURA DI PROGETTO		135 °C		TALLONE DI SALDATURA		Weld tests coupon				NO
SOVRAMEZZO DI CORROSIONE		3 mm		PROCEDIMENTO DI SALDATURA		Welding procedure				See doc: C230048WBK009
CAPACITA'		291		TIPO DI FONDO		Head type				CAP
EFFICIENZA GIUNTI		0.85		FORMAZIONE FONDO		Head form				HOT
MAMP @ Design Temperature		56.38 barg @ +135°C		PESO A VUOTO		Empty weight				59 kg
MAMP(EXT)		NO		PESO IN ESERCIZIO		perating weight				59 kg
MDMT @ MAMP		0 °C @		ES0 PIENO D'ACQUA		Full water weight				114 kg
TRATTAMENTO TERMICO		NO		DATI DEL VENTO		Wind datas				
IMPACT TEST		NO		DATI SISMICI		Seismological datas				

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