

# TECHNICAL BULLETIN – DDR09

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**SUBJECT: STEAM HEATED DRYER DRUMS - GENERAL SPECIFICATIONS**

## General

These specifications cover a 42" Diameter x 120" Face steel fabricated drying drum with chromium plating. Fabrication and finishing complete, per ASME Section VIII, Division 1 code. The drums would be certified and registered with the National Pressure Vessel Board for operation at 160 PSIG steam pressure.

## Fabrication Details

Drum Material: A516 Grade 70 steel. Rolled and welded.

Shafts: SA - 105 steel.

Finished Wall: 1 1/8 Nominal. Bored interior diameter with reinforcing ribs.

Shaft Finish: 63 Ra to 9" diameter for spherical roller bearing.

Balance: Static balance - Slight roll.

Finish: Chrome plated - See details.

## Chrome Plating and Finishing

Preparation: Grind drum faces, shoulder, and shaft in preparation for chrome plating.

Plating: Plate with hard chromium on drum faces and shoulders for finish grinding. Flash chrome drum ends to shafts.

Finish Grinding: Grind drum face and shoulders to a 16 Ra finish or better.

Tolerances: Chrome Thickness = .004" - .006" residual chromium.  
.002" TIR for concentricity.  
.002" Taper.  
Drum length to match a mating drum within .010" in length.

Shipping: Drums are mounted on skids and covered with wood slating to protect the drums.

Skid Dimensions: Length – 14 ft.  
Width – 4 ft.  
Height – 4 - 6"  
Weight – 11,000 lbs. ea.

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