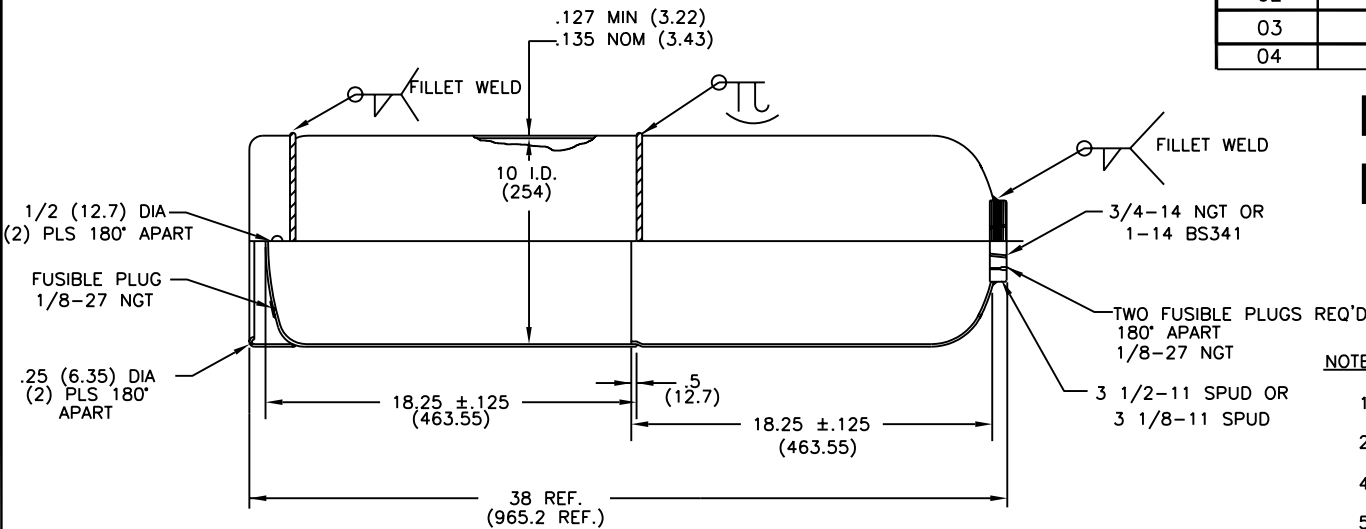


REV.	ECN - DESCRIPT.	DATE	DRWN.	CHKD.	CHKD.	APP.
01	1282	1/29/96	MB	AM	RS	BA
02	1291	3/06/96	DL	AM	RS	BA
03	1689	7/08/98				
04	2331	10/23/03	RS			

DRAWING FOR REFERENCE ONLY



NOTES:

- * Tare weight includes the shell, fuse plugs, valve, filler, acetone, saturation gas and paint
- SuperFiber-90 is a trade mark of Norris silica-lime (SL) asbestos free filler
- All dimensions are inches (mm) and nominal unless otherwise indicated
- Valve has been omitted for clarity

MODEL: A250

SPECIFICATION: DOT 8 / TC 8WM

1. PRINCIPAL ELEMENTS:

Rated acetylene capacity	250 ft ³	(7.08 m ³)
Acetone weight *	30 lb-12 oz	(13.90kg)
Approx. tare weight	117 lb	(53.1 kg)
Cylinder leak test pressure	400-450 psi	(2.76-3.1MPa)

2. POROUS MASS:

Material:	SuperFiber-90™	
Nominal porosity	0.90	
Top clearance (mass & shell)	≤0.084 in	(≤2.13mm)

3. SHELL REQUIREMENTS:

Min. water capacity	93.8lb/2602in ³	(42.5liter)
Max. water capacity	98.5lb/2733in ³	(44.7liter)
Shell weight (Nom.)	58.0lb	(26.3kg)
Min. hydro test pressure(Ph)	750 psi	(5.2 MPa)
(min. one per lot)		
Pressure test (each shell)	500-600 psi	(3.5-4.1MPa)

Material, Manufacture & Heat treatment:

Per DOT-8 or TC 8WM requirements as appropriate to the specification stamped on the cylinder.

- Shells will be cold plate drawn.
- All welding shall be in accordance with CGA pamphlet C-3 and Norris acetylene purchasing specification ORD-ADM-94

Mechanical properties:

Min. tensile strength**	51700 psi	(356.5MPa)
Elongation (on 24 x t gauge)	≥20%	(≥20%)
Wall stress at Ph**	≤25850 psi	(≤178.2MPa)

** These values are not mandatory for DOT 8 shells
For carbon steel yield/tensile ≤ 73%

SHELL PRODUCT NUMBER	MODEL
AX16	A250-11
AX29	A250-11S
AX16	A250-11BS



NORRIS CYLINDER COMPANY

P.O. BOX 7486 LONGVIEW, TEXAS 75607

MODEL A250 ACETYLENE CYLINDER

DWN. BY	MBENHAM	2/1/94	DRAWING NO.	REV.	
CHK'D BY	AMANKUS	2/1/94	901D-B-9007	04	
CHK'D BY	RSHAFKEY	2/1/94			
APP'D BY	BARNOLD	2/1/94			SHEET NO. 1