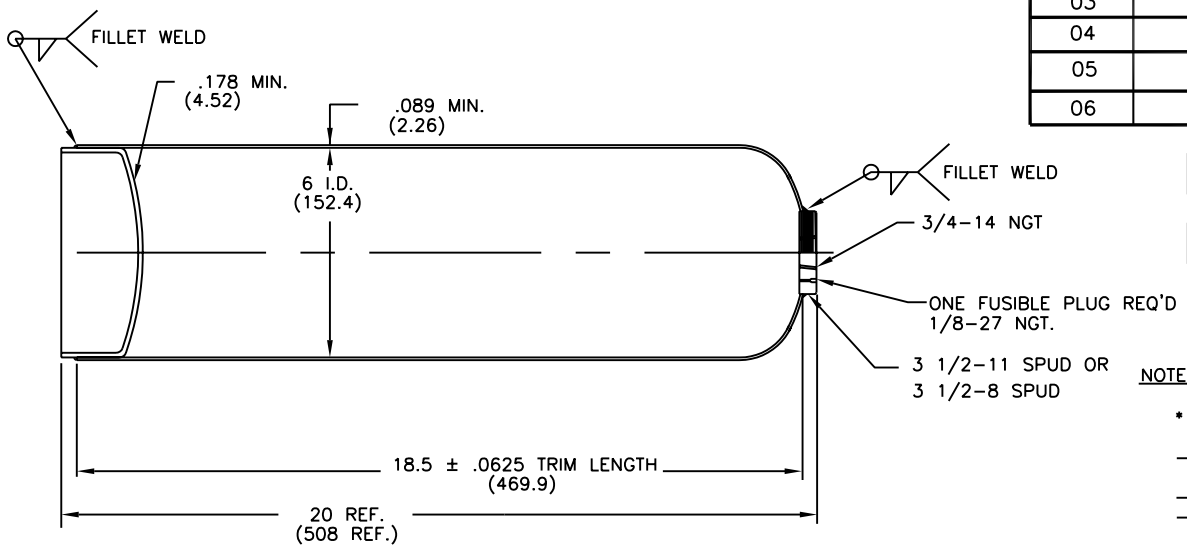
REV.	ECN – DESCRIP.	DATE	DRWN.	CHKD.	CHKD.	APP.
02	1282	1/29/96	MB	AM	RS	BA
03	1291	3/04/96	MB	AM	RS	BA
04	1754	2/16/98				
05	2327	10/23/03				
06	2446	12/2/04	RS			



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 shell dimensions are per Coyne drawing No. HV–NBF–40
– All dimensions are inches (mm) and nominal unless otherwise indicated
– Valve has been omitted for clarity

MODEL: BC–11

SPECIFICATION: DOT 8 or 8AL / TC 8WM OR 8WAM

1. PRINCIPAL ELEMENTS:

Rated acetylene capacity	40 ft^3	(1.13 m^3)
Acetone weight *	5 lb–7 oz	(2.47 kg)
Approx. tare weight*	28 lb	(12.7kg)
Cylinder leak test pressure	400–450 psi	(2.76–3.1MPa)

2. POROUS MASS:

Material:	SuperFiber–90™	
Nominal porosity	0.90	
Clearance between mass & shell (top & bottom combined)	≤0.060 in	(≤1.52mm)

3. SHELL REQUIREMENTS:

Min. water capacity	16.8 lb/466in^3	(7.6 liter)
Max. water capacity	17.6 lb/489in^3	(8.0 liter)
Shell weight (Nom.)	15.4 lb	(7.0 kg)
Min. hydro test pressure(Ph) (min. one per lot)	750 psi	(5.2 MPa)
Pressure test (each shell)	500–600 psi	(3.5–4.1MPa)

Material, Manufacture & Heat treatment:
Per DOT–8/8AL or TC 8WM/8WAM 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 QRD–ADM–94

Mechanical properties:

Min. tensile strength**	45400 psi	(313MPa)
Elongation (on 24 x t gauge)	≥20%	(≥20%)
Wall stress at Ph** (Per DOT/TC formula)	≤22700 psi	(≤156.5MPa)

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

SHELL PRODUCT NUMBER	MODEL
AX03	BC–11
AX34	BC–8

NORRIS CYLINDER COMPANY
P.O. BOX 7486 LONGVIEW, TEXAS 75607

MODEL BC ACETYLENE CYLINDER

DWN. BY	M. BENHAM	3/24/94	DRAWING NO.	REV.
CHK'D BY	A. MANKUS	3/24/94	901D–B–9002	06
CHK'D BY	R. SHAFKEY	3/24/94		
APP'D BY	B. ARNOLD	3/24/94	SHEET NO. 1 OF 1 SHEETS	