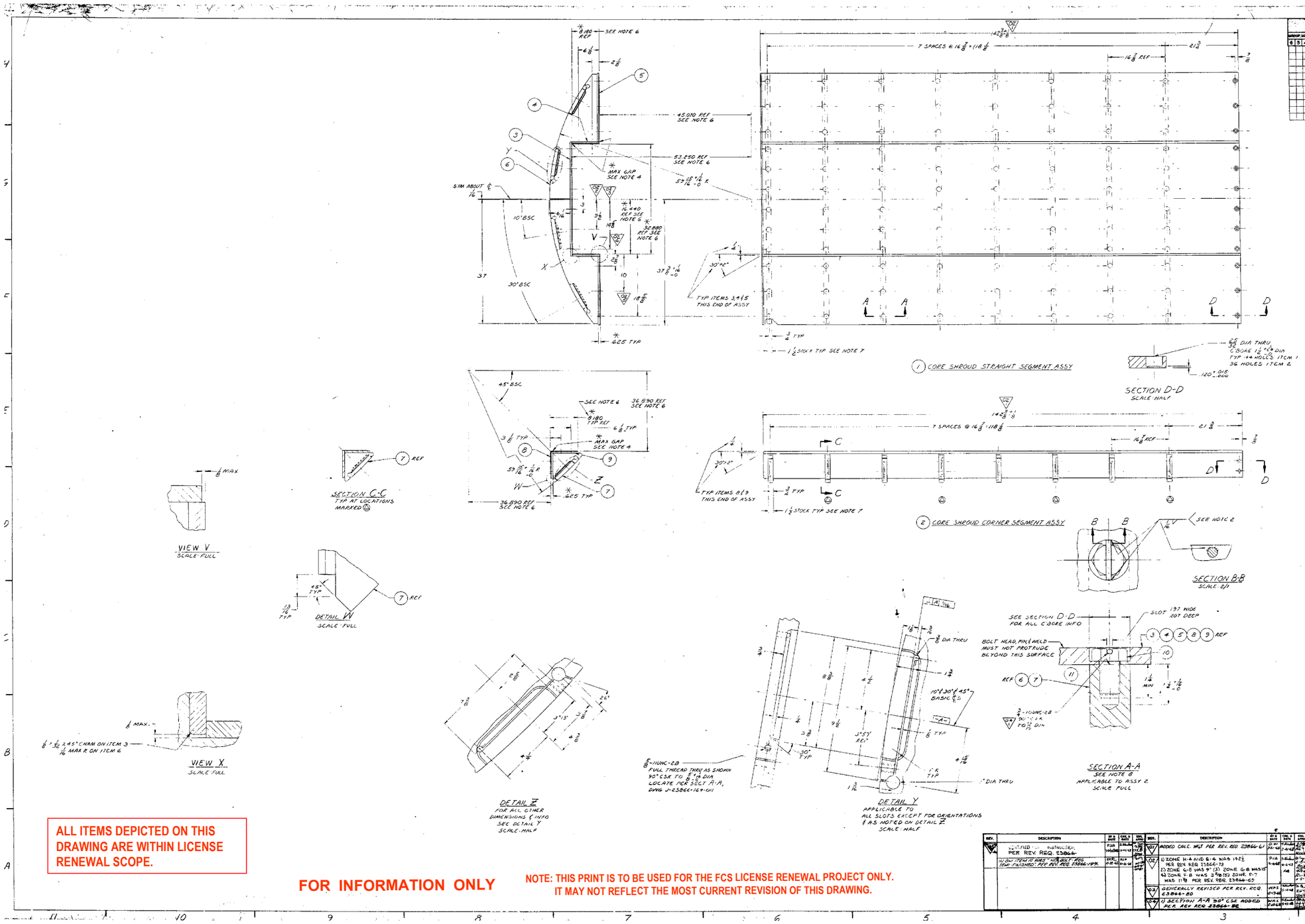

BILL OF MATERIALS

QUANTITIES ARE FOR:

GROUP NO. & QUANTITY 6	5	4	3	2	1	ITEM NO.	NAME	PIECE NO.	MATERIAL	REMARKS
					X	1	CORE SHROUD STRAIGHT SEGMENT ASSY	J-23866-164-025		
				X		2	CORE SHROUD CORNER SEGMENT ASSY	-4		
					1	3	SHROUD PLATE	-5	SEE NOTE 10	
				2		4	SHROUD PLATE	-6		
				2		5	SHROUD PLATE	-7		
					16	6	CENTERING PLATE	-8	SEE NOTE 11	
			8			7	CENTERING PLATE	-9	SEE NOTE 11	
				1		8	SHROUD PLATE	-10	SEE NOTE 10	
				1		9	SHROUD PLATE	-11	SEE NOTE 10	
			32	108		10	FINISHED HEX BOLT	-12	SEE NOTE 5	3/4-10UNC-2A x 1 1/4 LONG
			32	324		11	DOWEL PIN	-13	SEE NOTE 12	.188 DIA x 1 3/4 LONG

12. MATL: ASTM A-276 GR SPI-2 WRAP
11. MATL: ASTM A-240-63 SPI-1 WRAP
10. MATL: ASTM A-240 GR SPI-2 CRA
9. MATL: ASTM A-193-66 SPI-1
8. LOCATION OF BOLT HOLES TO BE ± 1/64
7. STOCK MILL TOLERANCE PER SECTION II OF ASME BOILER & PRESSURE VESSEL CODE
6. THIS DIMENSION IS REF, ASSY MUST FALL WITHIN MASTER 3-PIECE ENVELOPE DICTATED BY TOLERANCE FOR DETAIL SHOWN ON DWG J-23866-164-011
5. * INDICATES AS BUILT DIMENSIONS ARE TO BE RECORDED PER CENPD SPEC 23866-16-40-1
4. LOCAL GAPS ON BUTTED SURFACES OF ALL SHROUD PLATES MUST NOT EXCEED .010
3. BOLTS & MATING THREADS MUST BE NEOLUBED PRIOR TO INSTALLATION & FINAL TORQUING
2. PRODUCT TO BE IN ACCORDANCE WITH CENPD SPEC 23866-16-40-1
1. DIMENSIONING & TOLERANCING PER USASI Y14.5-1966

J-23866-164-025
J-23866-164-025 05

EA-FC-00-134 DF 12/01

CERTIFIED FOR CONSTRUCTION

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FOR INFORMATION ONLY

NOTE: THIS PRINT IS TO BE USED FOR THE FCS LICENSE RENEWAL PROJECT ONLY. IT MAY NOT REFLECT THE MOST CURRENT REVISION OF THIS DRAWING.

REV.	DESCRIPTION	BY & DATE	CHK. & DATE	ENG. APPR.
01	VERIFIED AS-BUILT INSTALLATION PER REV. REQ. 23866-	P.J.B. 5-15-92	S.B.L. 5-15-92	J.W. 5-15-92
02	AS-BUILT ITEM 10 WAS 1/2" BOLT FCS SEAT. FINISHED REV PER REQ 23866/199.	S.C.C. 8-21-92	R.L.P. 8-24-92	J.W. 8-24-92

REV.	DESCRIPTION	BY & DATE	CHK. & DATE	ENG. APPR.
01	ADDED CALC. MAT PER REV. REQ 23866-61	G.W. 10-14-91	P.J.B. 10-14-91	J.W. 10-14-91
02	1) ZONE H-A AND G-A WAS 1 1/2 PER REV. REQ 23866-73 2) ZONE G-B WAS 9" (3) ZONE G-B WAS 10 4) ZONE F-B WAS 2 7/8 (5) ZONE E-7 WAS 11 7/8 PER REV. REQ. 23866-85	P.J.B. 4-4-92	S.B.L. 4-4-92	J.W. 4-4-92
03	GENERALLY REVISED PER REV. REQ. 23866-90	W.A.S. 5-7-94	S.C.C. 5-7-94	R.L.P. 5-7-94
04	1) SECTION A-A 90° CSK ADDED PER REV REQ 23866-96	W.A.S. 5-24-94	S.C.C. 5-24-94	R.L.P. 5-24-94

NEXT ASSY:	J-23866-164-011
FINAL ASSY:	
SUPERSEDES:	
SUPERSEDED:	
DO NOT SCALE DWG.	CALC. WT.:
	SCALE: FIGHTH
	ACT. WT.:

TOLERANCES UNLESS OTHERWISE SPECIFIED

DIMENSIONS	UNDER 4	4 - 18	OVER 18
DECIMAL DIMS.	±.005	±.005	±.010
FRACTIONAL DIMS.	±1/64	±1/32	±1/16
ANGULAR DIMS.	ANGLES ± 1/2°		
THREADS-UNIFIED	CL 2A-2B	CHAMFER ± 1°	
BREAK CORNERS	1/64 MAX. RAD. OR CHAMFER		
FILLETS	1/64 TO 1/32 RADIUS		
CONVERSION	1 INCH = 25.4 MM		

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OMAHA PUBLIC POWER DISTRICT

FORT CALHOUN UNIT NO. 1

PREPARED UNDER ABT CONTRACT | CASE CONTRACT 23866

DRAWN BY:	W. SHARP	11-12-88
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	J.W.	11-12-88
	R.L.P.	11-12-88
	J.W.	11-12-88

CORE SHROUD ASSEMBLIES

J-23866-164-025 05

SHEET OF REV.