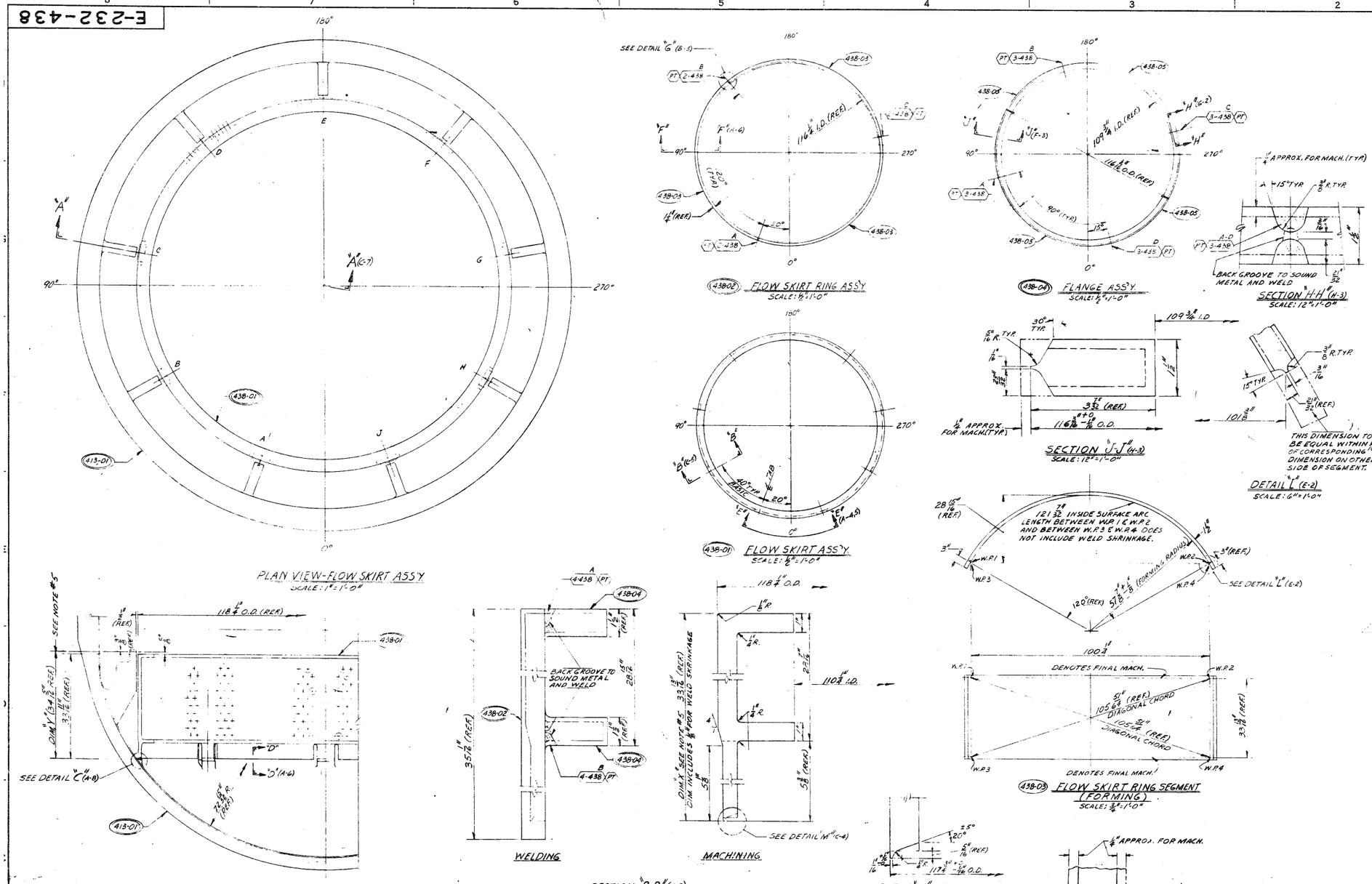
E-232-438



REVISIONS				
SYM	ZONE	DESCRIPTION	DATE	APPROVED
11	C-7 A-5	REVISED SECTION "A-A" GT REVISED VIEW "E-E" (125) 2 1/4" DIA HOLES WAS (88).	10-22-68	10-24-68 T.N.F. 10-26-68

RECEIVED JAN - 3 1969 Gibbs & Hill, Inc.

MATERIAL NOTES

"A" AS SUPPLEMENTED BY C.E. PURCHASE SPEC. P43F3(d)

EA-FC-00-134 DF 12/01

ASSY NO.	PC. NO.	NO. REQD.	NOMENCLATURE	MATERIAL	MATERIAL SPEC.	MATL NOTE
	438-05	4	FLANGE SEGMENT MAKE FROM 1 1/2" R SEE DETAIL	INCONEL	SB-168	"A"
438-04	—	2	FLANGE ASSY. EACH CONSISTING OF:			
	438-03	3	RING SEGMENT MAKE FROM 1 1/2" R X 35 13/32" X 128 15/16" O.L.	INCONEL	SB-168	"A"
438-02		1	FLOW SKIRT RING ASSY. CONSISTING OF:			
438-01		1	FLOW SKIRT ASSY. CONSISTING OF:			

LIST OF MATERIAL — QUANTITIES FOR ONE (1) UNIT, ONE (1) UNIT ON CONTRACT

ALL ITEMS DEPICTED ON THIS DRAWING ARE WITHIN LICENSE RENEWAL SCOPE.

GENERAL NOTES

1. DOUBLE ARROW INDICATES DIMENSION TO GIVEN REFERENCE LINE.
2. REFERENCE (REF) DIMENSIONS ARE FOR INFORMATION ONLY, DO NOT USE FOR FABRICATION.
3. ALL FABRICATION SHALL BE IN ACCORDANCE WITH ASME CODE SECTION III.
4. SEE REFERENCE DRAWING NO. 3 FOR STD. NOTES.
5. DIM "K" IS EQUAL TO AS BUILT OF DIM "Y" MINUS 1/2".
6. DEVELOPED LENGTH IN L/M IS GIVEN ON THE MEAN ℄.

REFERENCE DRAWING

NO.	TITLE	DWG. NO.
1.	BOTTOM HEAD FORMING & WELDING	E-232-411
2.	PRESSURE VESSEL FINAL MACHINING	E-232-413
3.	STANDARD NOTES	A-230-543

WELD TABLE

WELD NO.	DETAIL WELD PROC.
1-438A-J	WA-7/16-6-438
2-438A-C	WB-7/16-6-438
3-438A-D	WC-7/16-6-438
4-438A,B	WD-7/16-6-438

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GEOMETRIC TOLERANCES FOR MACHINED SURFACES UNLESS SPECIFIED ON FACE OF DRAWING

SYM.	GEOMETRY	TOL.	SYM.	GEOMETRY	TOL.
⏥	FLATNESS	.001/IN.	∠	ANGULARITY	SEE DWG.
—	STRAIGHTNESS	.001/IN.	↗	RUNOUT	SEE DWG.
○	ROUNDNESS	SEE DWG.	⌖	TRUE POSITION	SEE DWG.
⌭	CYLINDRICITY	SEE DWG.	◎	CONCENTRICITY	.010 TIR
⌒	PROFILE OF LINE	SEE DWG.	⌯	SYMMETRY	SEE DWG.
⌓	PROFILE OF SURFACE	SEE DWG.			
∥	PARALLELISM	.001/IN.			
⊥	PERPENDICULARITY	.001/IN.			

ALL DIMENSIONS APPLY AT REFERENCE TEMP. OF 68° F. SEE NOTE NO. 4
FINISH √ UNLESS NOTED
TOLERANCE ON: FRACTIONS ± 1/16" DECIMALS ± .010" ANGLES ± 0°-30' UNLESS NOTED

CONTRACT 7/166

DWN. BY T.B. DATE 7-23-68
CKD. BY W.E.G. DATE 8-6-68
APPD. BY DATE
STRESS ENGR. DATE 8-6-68

APPROVED DATE

COMBUSTION ENGINEERING, INC.
CHATTANOOGA DIVISION

FLOW SKIRT ASSEMBLY AND DETAILS
FOR OMAHA POWER 140" I.D. P.W.R.
RC-7

SIZE E | 232-438 | REV. 1
SCALE AS NOTED | WEIGHT | SHEET

001447

V-70032

FOR INFORMATION ONLY

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