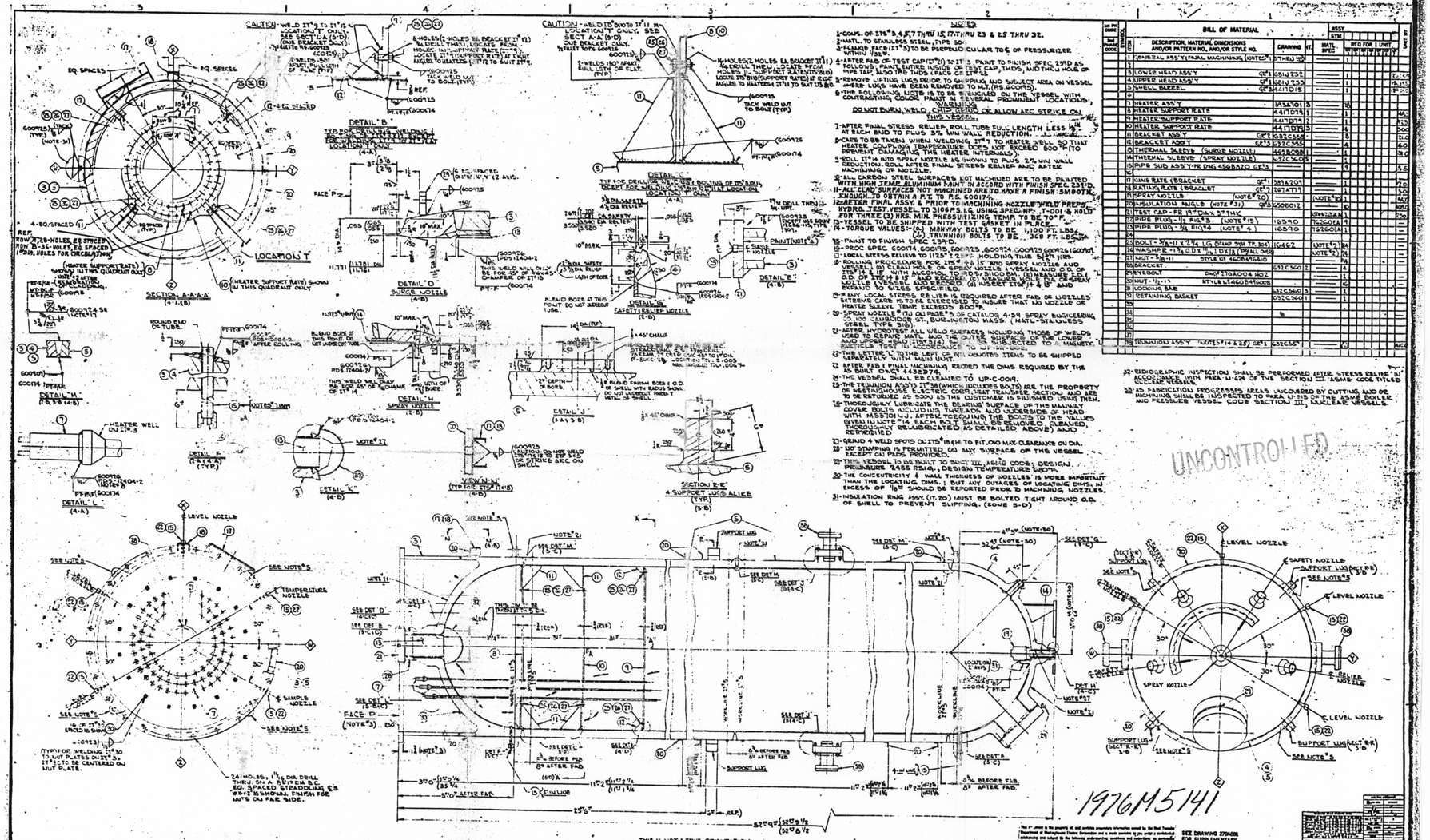

NOTES

1-COMPL OF 371'S 4,5,7 THRU 15, 17 THRU 23 & 25 THRU 32.
2-MATL - TO STAINLESS STEEL, TYPE 304.
3-CLAMP FACE (371'S) TO BE PERPENDICULAR TO C OF PRESSURIZER WITHIN 1/32.
4-AFTER PAD OF TEST CAP (371) TO 31' I FINISH TO FINISH SPEC 2390 AS FOLLOWS: PAINT ENTIRE INSIDE OF TEST CAP, THDS, AND THRU HOLE OF PIPE TAP, ALSO THE THDS FACE OF 371'S.
5-REMOVE LIFTING LUGS PRIOR TO SHIPPING AND SUBJECT AREA ON VESSEL WHERE LUGS HAVE BEEN REMOVED TO MT (THREE SHOTS).
6-THE FOLLOWING NOTE IS TO BE DUPLICATED ON THE VESSEL WITH CONTRASTING COLOR. PAINT IN SEVERAL PROMINENT LOCATIONS:

WARNING
DO NOT BURN, WELD, CHIP, GRIND OR ALLOW ARC STRIKE ON THIS VESSEL

7-AFTER FINAL STRESS RELIEF, ROLL TUBE FULL LENGTH LESS 1/4 AT EACH END TO PLUS 3% MIN WALL REDUCTION.
8-CARE TO BE TAKEN WHEN WELDING 371 TO HEATER WELL SO THAT HEATER COUPLING TEMPERATURE DOES NOT EXCEED 600 F (TO PREVENT DAMAGING THE HEATER INTERNALS).
9-ROLL 371-14 INTO SPRAY NOZZLE AS SHOWN TO PLUS 2% MIN WALL REDUCTION AFTER FINAL STRESS RELIEF AND AFTER MACHINING OF NOZZLE.
10-ALL CARBON STEEL SURFACES NOT MACHINED ARE TO BE PAINTED WITH HIGH TEMPERATURE ALUMINUM PAINT IN ACCORD WITH FINISH SPEC 2390.
11-ALL CLAD SURFACES NOT MACHINED ARE TO HAVE A FINISH SIMILAR TO THAT OF THE CLAD SURFACES.
12-AFTER FINAL ASSY. & PRIOR TO MACHINING NOZZLE WELD PREPS, HYDRO. TEST VESSEL TO 3106 PS.I.G. USING SPEC NO. T-001 & HOLD FOR THREE (3) HRS. MIN. PRESSURIZING TEMP. TO BE 70 F.
13-VESSEL TO BE SHIPPED WITH TEST GASKET IN PLACE.
14-TORQUE VALUES - (A) MANWAY BOLTS TO BE 1100 FT. LBS. (B) TRUNNION BOLTS TO BE 360 FT. LBS.
15-PAINT TO FINISH SPEC 2390.
16-PROC SPEC 600174, 600195, 600823, 600824, 600925, 600826 (600927).
17-LOCAL STRESS RELIEVE TO 1125 F ± 25 HOLDING TIME 5 HRS MIN.
18-ROLLING PROCEDURE FOR 371'S IS TO BE SUCH THAT SPRAY NOZZLE AND VESSEL I.D. CLEAN HOLE OR SPRAY NOZZLE I.D. AND VESSEL O.D. OR 371 I.D. WITH ALCOHOL TO 200 F PRIOR TO ROLLING. (B) MEASURES TO BE TAKEN SO THAT 371 AND RECESS (C) MEASURE WALL DIA OF SPRAY NOZZLE I.D. AND INSERT 371 TO WITHIN 1/64" OF THIS DIA. (D) EXPAND 371 TO WITHIN 2% OF MIN WALL REDUCTION AS SPECIFIED.
19-A NDT LOCAL STRESS RELIEF IS REQUIRED AFTER PAD OF NOZZLES EXTREME CARE IS TO BE EXERCISED TO INSURE THAT NO NOZZLE OR HEATER SLEEVE TEMP EXCEEDS 600 F.
20-SPRAY NOZZLE (1) OLI PAGE 5 OF CATALOG 4-59 SPRAY BUSHLEERING TO 300 CAMBRIDGE ST., BURLINGTON, MASS. (MATL - STAINLESS STEEL TYPE 316).
21-AFTER HYDROTEST ALL WELD SURFACES INCLUDING THOSE OF WELDS USED TO REPAIR MATL BASE THE OUTER SURFACE OF THE LOWER AND UPPER HEAD (ITEMS 2 & 3) SHALL BE SUBJECTED TO A MAGNETIC PARTICLE TEST IN ACCORDANCE TO NB-2545.
22-THIS LETTER 2 TO THE LIST OF ITEMS TO BE SHIPPED SEPARATELY WITH MAIN UNIT.
23-AFTER FAB & FINAL MACHINING REQ'D THE DIMS REQUIRED BY THE AS BUILT DWG 1463276.
24-THE VESSEL SHALL BE CLEANED TO UPC-0001.
25-THE TRUNNION AND 371'S (NON-MACH. BOLDED BOLTS) ARE THE PROPERTY OF WESTINGHOUSE ELECTRIC CORP. HEAT TRANSFER SECTION AND ARE TO BE RETURNED AS SOON AS THE CUSTOMER IS FINISHED USING THEM.
26-THOROUGHLY LUBRICATE THE BEARING SURFACE OF THE MANWAY COVER BOLTS INCLUDING THREADS AND UNDERSIDE OF HEAD WITH MS35761U. AFTER TORQUING THE BOLTS TO THE VALUES GIVEN IN NOTE 14, EACH BOLT SHALL BE REMOVED, CLEANED, THOROUGHLY RELUBRICATED AS DETAILED ABOVE AND RETORQUED.
27-GRIND 4 WELD SPOTS ON 371'S FLUSH TO FIT, ONE MAX CLEARANCE ON DIA.
28-NO STAMPING IS PERMITTED ON ANY SURFACE OF THE VESSEL EXCEPT ON PADS PROVIDED.
29-THIS VESSEL TO BE BUILT TO SECT III, ASME CODE; DESIGN PRESSURE 2485 PSIG, DESIGN TEMPERATURE 650 F.
30-THE CONCENTRICITY & WALL THICKNESS OF NOZZLES IS MORE IMPORTANT THAN THE LOCATING DIMS.; BUT ANY OUTAGES OF LOCATING DIMS. IN EXCESS OF 1/8" SHOULD BE REPORTED PRIOR TO MACHINING NOZZLES.
31-INSULATION RING ASSY. (IT. 20) MUST BE BOLTED TIGHT AROUND O.D. OF SHELL TO PREVENT SLIPPING. (ZONE 5-D)
32-RADIOGRAPHIC INSPECTION SHALL BE PERFORMED AFTER STRESS RELIEF IN ACCORDANCE WITH PARA U-124 OF THE SECTION III ASME CODE TITLED NUCLEAR POWER PLANT COMPONENTS.
33-AS FABRICATION PROGRESSES AREAS LOCATED BY CUTTING AND OR MACHINING SHALL BE INSPECTED TO MEET THE SECTION III ASME BOILER AND PRESSURE VESSEL CODE SECTION III, NUCLEAR VESSELS.

BILL OF MATERIAL

ITEM	DESCRIPTION, MATERIAL DIMENSIONS AND/OR PATTERN NO., AND/OR STATE NO.	DRAWING	MT.	MATL SPEC	ASSY SYM REQ'D FOR 1 UNIT
1	GENERAL ASS'Y (FINAL MACHINING) (NOTE 1)	(STRUC) 500			1
2					
3	LOWER HEAD ASS'Y	GE's 681J232			1
4	UPPER HEAD ASS'Y	GE's 681J353			1
5	SHELL BARREL	GE's 4411D15			1
6					
7	HEATER ASS'Y	3858101	5		18
8	HEATER SUPPORT PLATE	4411D179	1		1
9	HEATER SUPPORT PLATE	4411D179	2		1
10	HEATER SUPPORT PLATE	4411D179	3		1
11	BRACKET ASS'Y	GE's 831C556			4
12	BRACKET ASS'Y	GE's 831C556			4
13	THERMAL SLEEVE (SURGE NOZZLE)	4658D061			1
14	THERMAL SLEEVE (SPRAY NOZZLE)	837C5605			1
15	PIPE SUB ASS'Y-MK DWG 4568A20	GE's			1
16					
17	NAME PLATE (BRACKET	GE's 3858203			1
18	RATING PLATE (BRACKET	GE's 1614T71			1
19	SPRAY NOZZLE	(NOTE 20)			1
20	INSULATION NIGLE (NOTE 31)	GE's 5008012			1
21	TEST CAP - FR 197 DWG 877H4				1
22	PIPE PLUG - 1/2 PIPE'S	(NOTE 12)		16990	1
23	PIPE PLUG - 3/4 PIPE'S	(NOTE 12)		16990	1
24	PIPE PLUG - 3/4 PIPE'S	(NOTE 2)		16990	1
25					
26	BOLT - 3/4-11 x 2 3/4 LG (MAY BE TP 304)			16462	(NOTE 22) 16
27	WASHER - 1 1/4 O.D. x				(NOTE 22) 16
28	NUT - 3/4-11	STYLE NP 4608A164A10			16
29	GASKET				1
30	RIVET	DWG 2710A004 H02		631C560	2
31	NUT - 1/2-13	STYLE NP 4608A164A06			4
32	LOCKING BAR			631C560	3
33	RETAINING BASKET			631C560	1
34					
35					
36					
37					
38	TRUNNION ASS'Y (NOTES 14 & 25)	GE's 631C558			4

UNCONTROLLED

1976M5141

SEE DRAWING 270A008 FOR SUPPLEMENTARY MANUFACTURING DATA.

FINAL ISSUE
F. P. No. 9321-05-2292 (1 of 3)
REV. 02 DATE 02-20-73
05 FP. 2292-0

Westinghouse Electric Corporation
FRAME 1800 CU. FT. PRESSURIZER
TITLE GENERAL ASSEMBLY & FINAL MACHINING
SCALE 1/2" = 1'-0" SIZE D NO. OF SHEETS 3
STEAM DIVISION, SUNBURY, PA. U.S.A.
681J281

Attachment to IIN-02-024
RR 3-16, Rev. 1
D.4