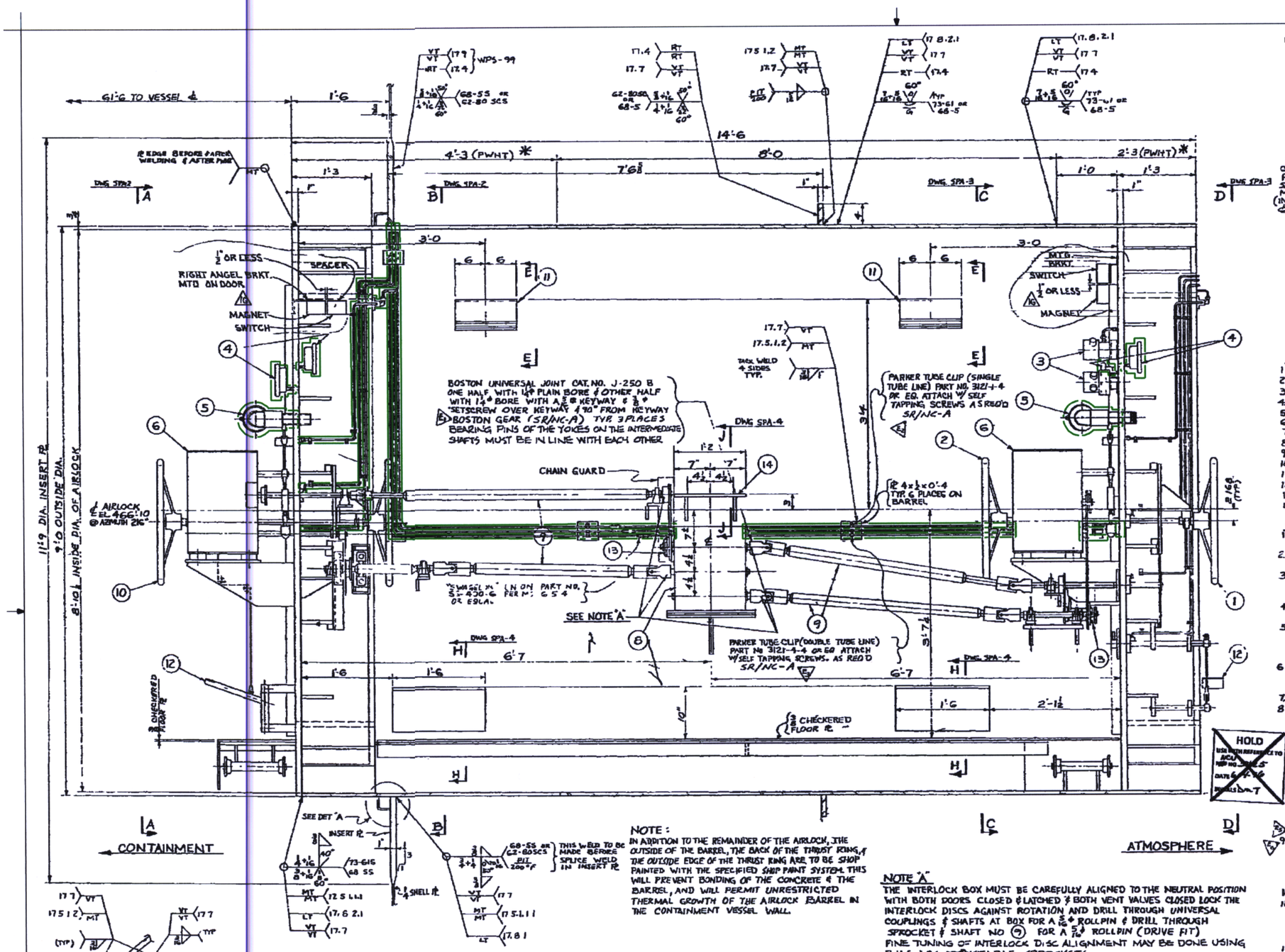
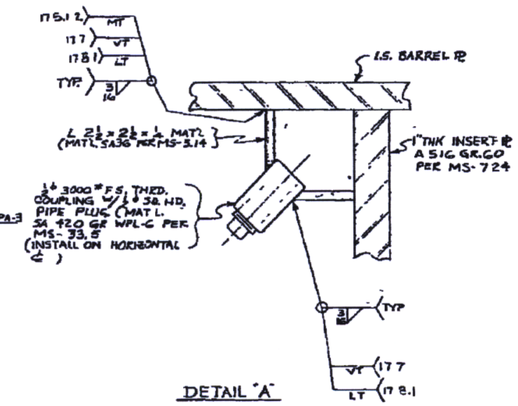
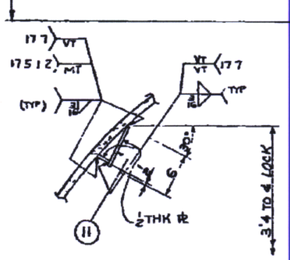




DETAIL "A"

ELEVATION VIEW OF PERSONNEL ACCESS LOCK WITH BARREL PLATE REMOVED



SECTION E-E

NOTE:
IN ADDITION TO THE REMAINDER OF THE AIRLOCK, THE OUTSIDE OF THE BARREL, THE BACK OF THE THRUST RING, & THE OUTSIDE EDGE OF THE THRUST RING ARE TO BE SHOP PAINTED WITH THE SPECIFIED SHIP PAINT SYSTEM. THIS WILL PREVENT BONDING OF THE CONCRETE & THE BARREL, AND WILL PERMIT UNRESTRICTED THERMAL GROWTH OF THE AIRLOCK BARREL IN THE CONTAINMENT VESSEL WALL.

NOTE "A"
THE INTERLOCK BOX MUST BE CAREFULLY ALIGNED TO THE NEUTRAL POSITION WITH BOTH DOORS CLOSED & LATCHED & BOTH VENT VALVES CLOSED LOCK THE INTERLOCK DISCS AGAINST ROTATION AND DRILL THROUGH UNIVERSAL COUPLINGS & SHAFTS AT BOX FOR A 5/16" ROLLPIN & DRILL THROUGH SPROCKET & SHAFT NO (9) FOR A 5/16" ROLLPIN (DRIVE FIT)
FINE TUNING OF INTERLOCK DISC ALIGNMENT MAY BE DONE USING PHAS-LOK ADJUSTABLE SPROCKETS
ROLL PINS: SR/NC-A

KEY
1 ATMOSPHERE BULKHEAD HANDWHEEL
2 INTERIOR HANDWHEEL
3 DIFFERENTIAL PRESSURE SWITCH
4. DIFFERENTIAL PRESSURE GAGE
5 VENT VALVE
6 GENEVA GEAR UNIT
7. INTERIOR HANDWHEEL
8 INTERLOCK SYSTEM
9. INTERLOCK DRIVE
10. CONTAINMENT BULKHEAD HANDWHEEL
11 LIGHT BRACKET
12. REMOTE CONTROL ENGAGEMENT TREADLE
13 PHAS-LOK ADJUSTABLE SPROCKET
14. EMERGENCY COMMUNICATION SET BRACKET

GENERAL NOTES:
1. ALL PLATE MATERIAL UNLESS NOTED OTHERWISE SHALL BE ASME SA 516 GR 70 PER MS 7.26.3
2. WORK ALL DWGS SPA-1 THRU SPA-36 TOGETHER FOR THE PERSONNEL ACCESS LOCK
3 ALL PARTS IN SLIDING CONTACT (SUCH AS THE INTERLOCK DISC & GEAR) SHOULD BE LUBRICATED DURING FINAL ASSEMBLY WITH "MOLYCOTE" TYPE 321 OR EQ.
4 USE ONLY ELECTRODES ORDERED & CERT. FOR THIS CONTRACT PER WPS-110 & APPLICABLE ELECT. SPEC'N.
5 FILLET WELDS AND PART. PENT. WELDS ARE QUALIFIED BY JOINTS
CARBON STEEL: 62-80, 68-4, 68-5 & 73-61
STAINLESS STEEL: 62-37 & 70-42
STAINLESS TO CARBON STEEL: 69-11 & 70-18
6 MINIMUM PREHEAT AND INTERPASS TEMPERATURE (PIT) 50°F EXCEPT AS NOTED.
7. ACCESS LOCK TO BE TESTED PER SPAT-1
8 ALL HANDWHEELS, GAUGES, ETC. ARE TO BE LABELED AS TO FUNCTION OR POSITION ("OPEN-CLOSED" ETC) AS SHOWN PER DWGS.
NAME PLATE LABELS-TO BE 0.60 THK BLACK/WHITE ENGRAVING STOCK #840 FORMICA, WITH WHITE CORE & BLACK EXTERNAL LAMINATION (AMERICAN CYANAMID PRODUCT) THE LETTERING IS TO BE 3/8" WHITE LETTERS ON BLACK BACKGROUND, PLASTIC IS TO BE SUITABLE FOR 312°F TEMPERATURE (2-3/32" MOUNTING HOLES PER LABEL) LABELS: SR/NC-A
THE LABELS SHALL BE ATTACHED IN CLOSE PROXIMITY OF THEIR RESPECTIVE ITEMS SO AS NOT TO OBSCURE THEIR READABILITY. ONCE POSITIONS OF LABELS HAVE BEEN DETERMINED, THEY SHALL BE USED AS TEMPLATES TO DRILL .120" HOLES (DRILL SIZE #31) x 3/16 MAX. DP. INTO BULKHEAD, GENEVA UNIT & ETC USE (2) "PARKER-KALON" #G-32 TYPE "F" x 3/8 LG SLOTTED HD SELF-TAPPING SCREWS PER LABEL SR/NC-A
9 ALL CRITICAL ITEMS OR MAT'L (PARTS OF THE ASME CODED VESSEL) ARE NOTED WITH A SPECIFICATION (MS-ELC) OTHER ITEMS OR MAT'L ARE SAFETY RELATED, NON CRITICAL AND ARE NOTED WITH SR/NC-(CATEGORY).
REQUIREMENTS FOR SR/NC ITEMS ARE DEFINED IN G.A. MANUAL SUPPLEMENT 1A APPENDIX A
10. GENEVA GEAR UNIT BY GENEVA MANUFACTURER
11 ALL SILICONE SEALS, AND THE METAL PARTS WHICH CONTACT THEM ARE TO BE LIGHTLY COATED, BEFORE SEAL INSTALLATION, WITH "SUPER-O-LUBE" MFD. BY PARKER SEAL CO WILL BE NEEDED IN THE SHOP AND UNUSED PORTION SHIPPED TO FIELD WITH AIRLOCK.
12 SEE ELECTRICAL DRAWINGS FOR DETAILS OF ELECTRICAL EQUIPMENT & MOUNTING PADS THAT ARE NOT SHOWN ON THESE DRAWINGS.

SOUTH CAROLINA ELECTRIC & GAS CO
Virgil C. Summer Nuclear Station Unit No. 1
APPROVED
APPROVED AS NOTED
RETURNED FOR CORRECTION
DALBERT ASSOCIATES, INC.
SC-4 5/28/76

SOUTH CAROLINA ELECTRIC and GAS COMPANY
PURCHASE ORDER No SV-10037-SR #2377

* CONTAINMENT BULKHEAD & INSERT ℞ & ATMOSPHERE BULKHEAD POSTWELD HEAT TREATMENT (BEFORE MACHINING)
FURNACE PREHEAT TEMP 600°F MAX.
MAX WARM-UP RATE 400°F/HR FOR 1 1/2 HRS.
HOLDING TEMP. 1100-1250°F FOR 1 HR/IN THICKNESS
MAX. COOLDOWN RATE 500°F/HR. FOR 1 HR.
TAKE OUT TEMP. 600°F MAX

REV BY GAT AS INDICATED			2 PLACES PER ECI-STEM	
5			CAL	2-9-80
REV	BY	CHECKED	APPROVED	DATE
FINAL ISSUE			GLF	12-22-75
START OF DETAIL DRAWING PREPARATION			GLF	11-28-75
CUSTOMER INFORMATION			GLF	10-23-75
MATERIAL PROCUREMENT			GLF	12-23-75
RELEASED FOR			PROJ ENGR	DATE

WPS-110
WELD SPECIFICATION 1971 ASME BOILER & PRESSURE CODE, INCLUDING ADDENDA TO WINTER 1972

GLF	E	12-8-75	RFI Rev NLC Items To SR/NC-(Category) ARM Note 9	
GLF	D	10-7-75	REVISED NOTE 11 & BEARING SUPPORTS	
GLF	C	7-11-75	REVISED TUBING FITTINGS	
GLF	B	4-24-75	REVISED LINKS FOR LIGHT BRACKET, NOTE 8 ADDED, SPROCKETS, CHAIN, SET BRACKET & NOTE 12	
GLF	A	3-6-75	GENERAL REVISION	
GLF	0	2-28-74	INITIAL ISSUE	JFS
PROJ ENGR	NO	DATE	DESCRIPTION OF REVISION	BY

PITTSBURGH-DES MOINES STEEL CO.
ENGINEERS-FABRICATORS-CONTRACTORS
PITTSBURGH PA. · SEATTLE WA. · HOUSTON TEX. · BIRMINGHAM ALA. · BATON ROUGE LA. · DES MOINES IOWA · PORTLAND OREG.
REACTOR BUILDING LINER
VIRGIL C. SUMMER NUCLEAR STATION - UNIT No 1
PERSONNEL ACCESS LOCK - ELEVATION

	BY	DATE
DESIGNED		
DRAWN	J.E.S.	
CHECKED	G.T.R.	
SCALE	1/4" = 1'-0	

DESIGN FILE-NO.
CONTRACT NO. 13684
DRAWING NO. SPA-1
DATE 12-28-75

VENDOR/DRAWING NO.
DESIGN ENGINEERING
S. C. SUMMER NUCLEAR STATION JENKINSVILLE, S.C.
MADE | CHECKED | LE APPROVAL
SCALE NO SCALE | 1MS-05-167 | 1
DRAWING NUMBER | SHT. NUMBER | REV

NO.	DATE	BY	REVISION	DES. BY	LE APPROVAL

D-6

PLEX Drawing TR00160-006

1MS-05-167 W 5