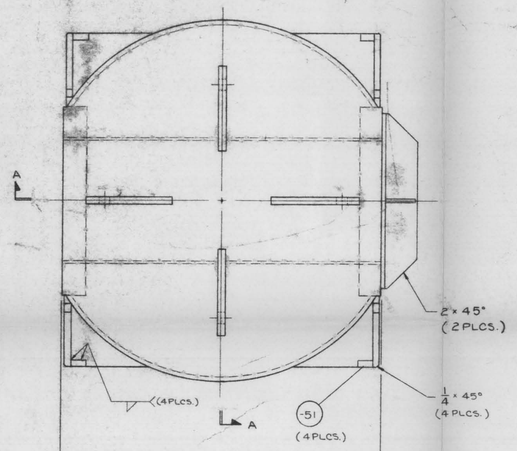
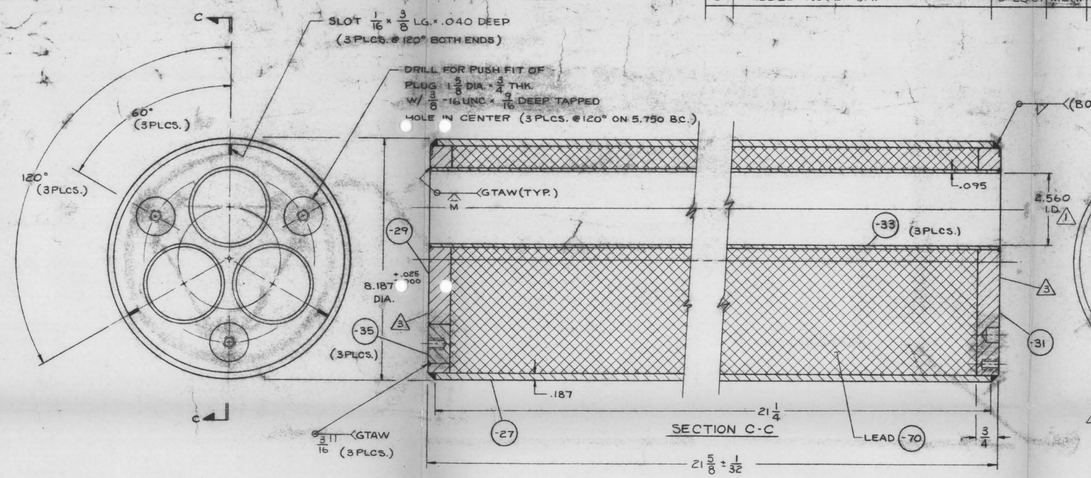
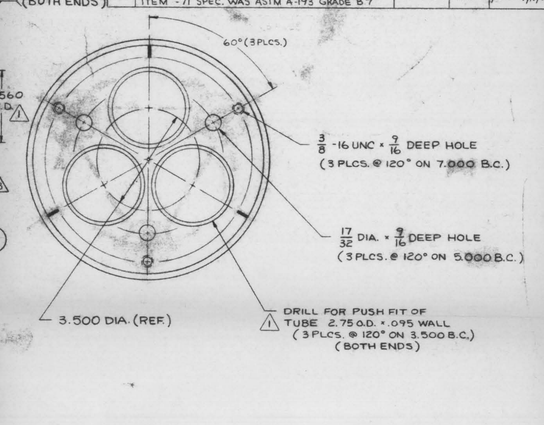
REV	DESCRIPTION	DATE	BY	APPROVED
D	ADDED NOTE 8A.	8-28-87	MLH	RZ 9/14/87
A	CHANGED WELD @ H-4, & ADDED ALTERNATE STN.STL. TYPE 316	3-24-86	MLH.	RZ 3/26/86
B	CHANGED WELD @ H-3, & ADDED NOTES 7 & 8.	12-4-86	MLH.	RZ 12/10/86
C	ADDED TORQUE SPEC. NOTE 7 & ASME SPEC. NOTE 8 ITEM -71 SPEC. WAS ASTM A-193 GRADE B7	5-6-87	MLH.	RZ 6/19/87

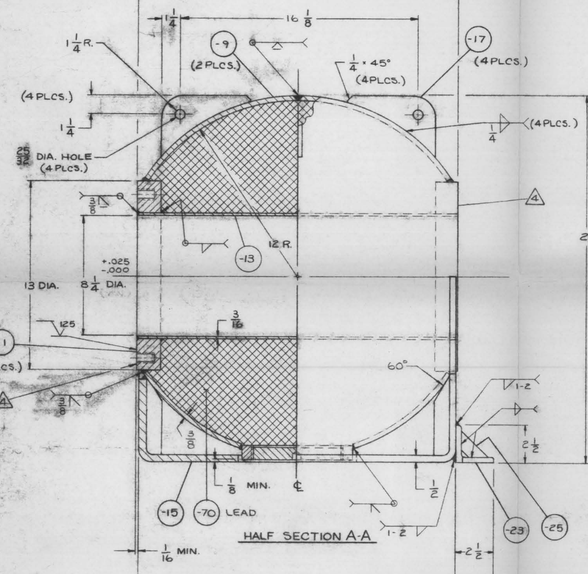




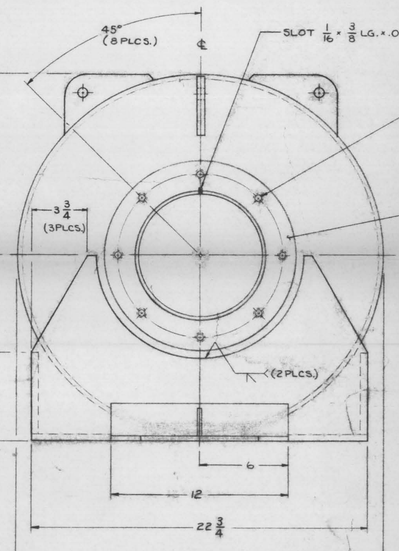


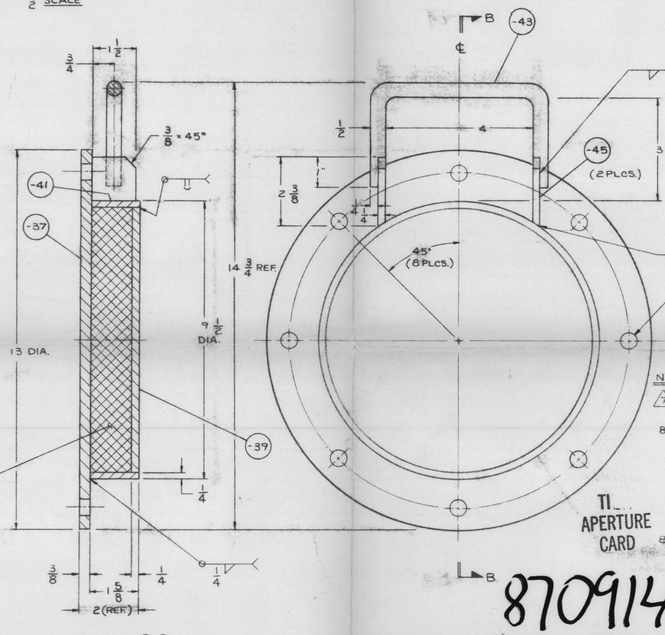
-5 DRUM ASSEMBLY

1/2 SCALE



HALF SECTION A-A





SECTION B-B

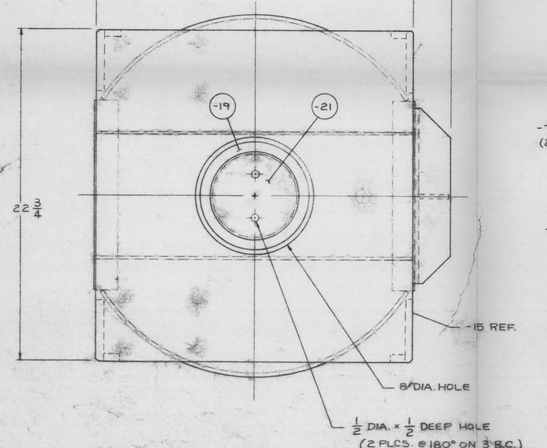
NOTES:

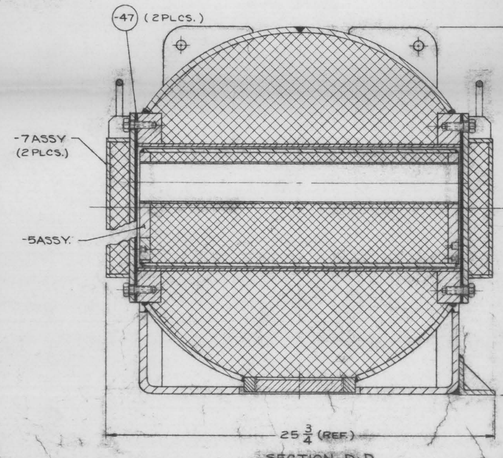
7. TORQUE BOLTS TO 100-125 lb-in. TO FIRMLY COMPRESS GASKET
8. ALL WELD JOINTS WHICH ARE PART OF THE BOUNDARY OF THE LEAD CONTAINING CAVITIES SHALL BE EXAMINED USING LIQUID PENETRANT IN ACCORDANCE WITH ASME B & PV CODE SEC. V. AREAS WITH POSITIVE INDICATION SHALL BE GROUND AND RETESTED. IF UNDERCUTTING RESULTS, THE AREAS SHALL BE REWELDED AND RETESTED.
8A. ACCEPTANCE CRITERIA SHALL BE IN ACCORDANCE WITH ASME B & PV CODE SEC. VIII, DIV. 1 APPENDIX 8.

TI APERTURE CARD

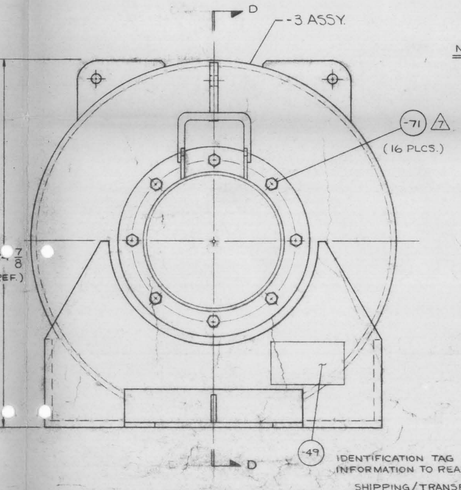
8709140304 D-1

-3 SHELL ASSEMBLY





SECTION D-D



-1 CASK ASSEMBLY

-7 COVER ASSEMBLY

1/2 SCALE

NOTES:

1. DEBURR & BREAK SHARP EDGES
2. 2.550 DIA. x 21 5/8 LG. ROD MUST FREELY PASS THROUGH FULL LENGTH OF TUBES. BORE TO BE PARALLEL WITH DRUM O.D. MAX. RUN OUT .010" PER FT.
3. FURNISHED BY N.P.I.
4. MACHINE FACE SQUARE TO DRUM O.D. MAX. RUN OUT .005 TIR.
5. MACHINE FACE SQUARE TO 8 1/4 DIA. BORE MAX. RUN OUT .010 TIR.
- UNLESS OTHERWISE SPECIFIED
5. ALL WELDS TO BE:
   - A.) IN ACCORDANCE WITH ASME B & PV CODE SEC. VIII
   - B.) QUALIFIED IN ACCORDANCE WITH ASME B & PV CODE SEC. IX
   - C.) MADE BY WELDERS QUALIFIED UNDER ASME B & PV CODE SEC. IX
   - D.) FULL PENETRATION UNLESS OTHERWISE SPECIFIED
6. ALL EXTERNAL SURFACES TO BE PAINTED WITH:
   - A.) RUST INHIBITING PRIMER
   - B.) HIGH QUALITY WEATHER RESISTANT PAINT

IDENTIFICATION TAG R 3x5 x 1/16 MIN. THK.
INFORMATION TO READ
SHIPPING/TRANSFER CASK
MODEL S/TC MK II
No. X (NUMBER SEQUENTIALLY)
NEUTRON PRODUCTS INC.
DICKERSON, MD.

AUG 28 1987

ITEM	DESCRIPTION	SPECIFICATIONS	-1	-3	-5	-7
			QUAN PER ASSY.			
-71	HEX HD. CAP SCREW 1/2 - 13UNC x 1 1/4 LG.	STEEL SAE GRADE 8	16			
-70	LEAD PIG LEAD (CHEMICAL GRADE)	ASTM B-29				
-51	GUSSET R 1/2 THK. x 1" x 6 LG.	ASTM A-516 GRADE 70		4		
-49	IDENTIFICATION TAG		1			
-47	GASKET SILICONE RUBBER 13 DIA. 1/16 THK.	ASTM D-2000-80	2			
-45	R 1/4 THK. x 1 1/2 x 2 3/8 LG.	ASTM A-516 GRADE 70				2
-43	HANDLE BAR 1/2 DIA. x APPROX. 11 LG.	ASTM A-36				1
-41	RING R 1/4 THK. x 1 5/8 x APPROX. 29 3/8 LG. (ROLL TO 9 1/2 O.D.)	ASTM A-516 GRADE 70				1
-39	CAP R 1/4 THK. x 9 DIA.	" "				1
-37	COVER R 3/8 THK. x 13 DIA.	" "				1
-35	PLUG R 3/4 THK. x 1 5/8 DIA. STAINLESS STEEL TYPE 304 OR 316	ASTM A-240			3	
-33	DRUM LINER TUBING 2.750 O.D. x .095 WALL x 21 5/8 LG. STAINLESS STEEL TYPE 304/316	ASTM A-213			3	
-31	END R 3/4 THK. x 7 13/16 DIA. STAINLESS STEEL TYPE 304 OR 316	ASTM A-240			1	
-29	" "	" "			1	
-27	DRUM PIPE 8" (NPS) SCH. 60 x 21 1/4 LG. STAINLESS STEEL TYPE 304 OR 316	ASTM A-312			1	
-25	GUSSET R 1/4 THK. x 1" x 2 1/2 LG.	ASTM A-36		1		
-23	SUPPORT ANGLE L 2 1/2 x 2 1/2 x 3/8 THK. x 12 LG.	ASTM A-36		1		
-21	PLUG 6"-8UNC THREAD x 1" LG. THK.	ASTM A-516 GRADE 70		1		
-19	FLANGE 7 1/2 O.D. x 6"-8UNC THREAD I.D. x 1" THK.	ASTM A-516 GRADE 70		1		
-17	LIFTING LUG R 1/2 THK. x 4 1/4 x 6 LG.	" "		4		
-15	BASE R 1/2 THK. 22 3/4 x 46 1/2 LG. APPROX.	" "		1		
-13	SHELL LINER - PIPE 8" (NPS) SCH. 20 x 21 5/8 LG.	ASTM A-333 GRADE 6		1		
-11	FACE R 1 1/2 THK. x 13 O.D.	ASTM A-516 GRADE 70		2		
-9	HEMISPHERICAL HEAD R 3/8 THK. x 24 I.D.	ASTM A-516 GRADE 70		2		
-7	COVER ASSEMBLY		2			
-5	DRUM ASSEMBLY		1			
-3	SHELL ASSEMBLY		1			
-1	CASK ASSEMBLY					

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES: ANGULAR ± 1°, DECIMAL ± .005, FRACTIONAL ± 1/16

neutron PRODUCTS inc Dickerson, Maryland

DRAWN MLH 2-8-85
DESIGN
CHECKED 9-30-85

TITLE: SHIPPING/TRANSFER CASK MODEL S/TC MK II
APPROVED
ISSUED DATE
SIZE N
DWG. NO. 240122
REV. D
SCALE 1/4 & NOTED
SHEET