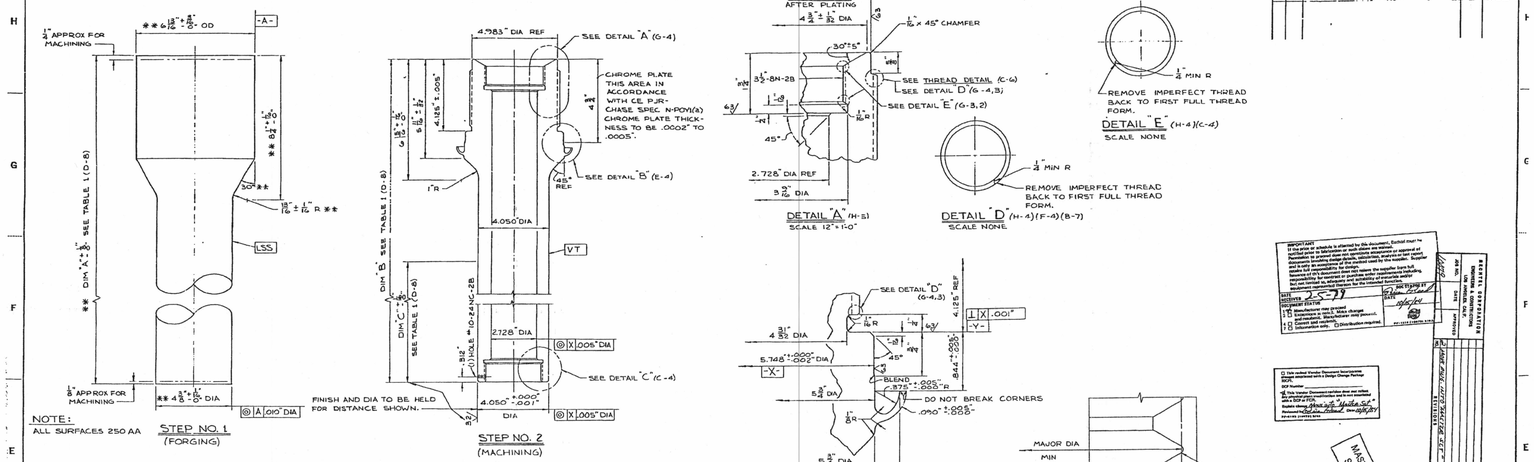
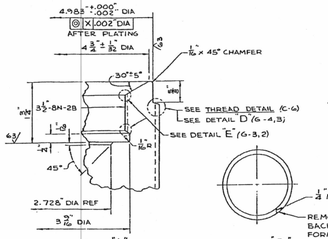
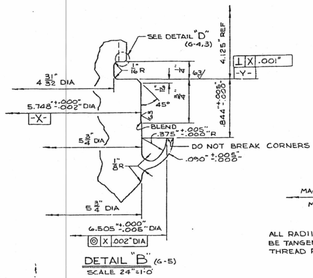
E-234-659

REVISIONS				
SYM	ZONE	DESCRIPTION	DATE	APPROVED
1		C/M REVISED MAT'L NOTE 5 (PC NO. 210-07 THRU 210-16), REVISED MAT'L & MAT'L SPEC (PC NO. 210-17)	10-5-77	[illegible]
		B-5 DELETED CHROME PLATING NOTE		







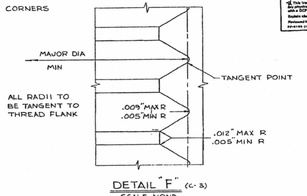
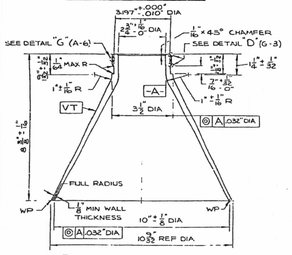
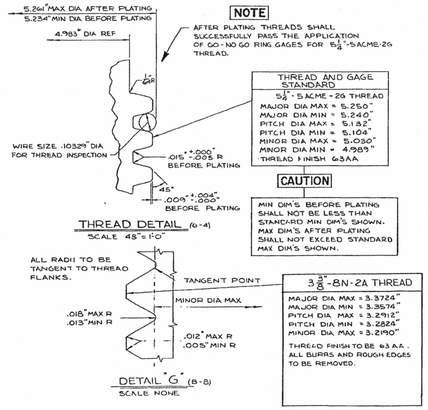
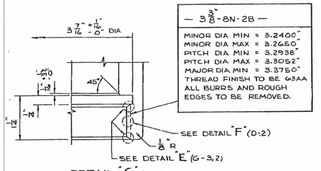


TABLE 1			
PC NO.	DIM A	DIM B	DIM C
210-01	20 9/16	20 3/16	12"
210-02	21 3/8	21 1/2	12 1/2"
210-03	22 1/16	22 7/16	12 3/4"
210-04	24 3/16	24 5/16	13 7/32"
210-05	26 1/2	25 7/8	13 7/16"
210-06	28 3/16	27 13/16	14 3/32"
210-07	29 1/16	28 11/16	14 3/32"
210-08	30"	29 5/8"	14 1/2"
210-09	32 3/4	32 3/8	15 1/4"
210-10	35 11/16	35 5/16	15 3/4"
210-11	36 1/16	36 5/16	15 3/32
210-12	37 1/16	37 5/16	16 5/16"
210-13	39 3/4	39 3/8	16 21/32
210-14	45 7/16	44 15/16	17 5/32"
210-15	46 5/16	45 11/16	18 1/4"
210-16	53 7/8	53 1/4"	20 1/4"







GENERAL NOTES

1. AFTER MACHINING AND BEFORE CHROME PLATING, Ⓜ EACH NOZZLE OVER OUTSIDE SURFACES PER M&P SPEC 2-4-3, ⊕ AND ADDENDA VALVE (A).
2. ** ASTERISK DENOTES AS FINISHED DIMENSIONS FROM MILL.

REFERENCE DRAWINGS

NO	TITLE	DRAWING NO.
1	STANDARD NOTES	A-244-841
2	CLOSURE HEAD PENETRATION FINAL MACHINING	E-234-654
3	CLOSURE HEAD MACHINING	E-234-601
4	CLOSURE HEAD ASSEMBLY	E-234-662
5	CLOSURE HEAD PENETRATION MACH & CLAD	E-234-660
6	GENERAL ARRANGEMENT - ELEVATION	E-234-650
7	MATERIAL NOTES	A-244-242

THIS DRAWING IS THE PROPERTY OF COMBUSTION ENGINEERING, INC. WINDSOR, CONN. AND IS NOT TO BE REPRODUCED, OR USED TO FURNISH ANY INFORMATION FOR THE BENEFIT OF OTHERS, EXCEPT WITH THE SPECIFIC PERMISSION FOR BY AGREEMENT WITH SAID COMPANY.

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	SEE DWG
⌒	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. FINISH √ UNLESS NOTED
TOLERANCE ON: FRACTIONS ± 1/64 DECIMALS ± .010 ANGLES ± 0° 30' UNLESS NOTED

CONTRACT 72170

MATERIAL NOTES

#-FOR MATERIAL NOTES SEE REF DWG NO. 7

ASSY NO.	PC NO.	NO. REQD	NOMENCLATURE	MATERIAL	MATERIAL SPEC	# MATL NOTES
210-17	91	1	HEX SOCKET SET SCREW, "CUP POINT" 10-24 NC-2A x 3/16 LG	NI-CR-FE	SB-166	
210-17	91	1	GUIDE CONE SEE "DETAIL A" (B-8)	SST	A-276 TYPE 17-4 PH	
210-16	2					
210-15	3					
210-14	1					
210-13	4					
210-12	1					
210-11	4					
210-10	1					
210-09	5					
210-08	1					
210-07	1					
210-06	1		CLOSURE HEAD NOZZLE SEE DETAIL (E-7,8)	N-CR-FE	SB-166	"K"

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

DWN. BY D. REDMAN DATE 4-16-76
DES. BY N. S. OSTON DATE 4-16-76
APPD BY L. K. TOMLIN DATE 8-12-76
STRESS ENGR. T. T. PETERSON DATE 8-12-76
APPROVAL

COMBUSTION ENGINEERING, INC. CHATTANOOGA DIVISION

CLOSURE HEAD NOZZLE DETAILS

SAN ONOFRE III 172" ID PWR

SIZE E | 234-659 | REV. 1

SCALE NONE WEIGHT SHEET

IMPORTANT
If the part or item/code is affected by this document, Contract must be approved by Engineering before any work starts on material or fabrication to prevent scrap and rejection. Approval or failure to comment does not relieve supplier of responsibility to meet all requirements of the contract including, but not limited to, specifications, quantities, and delivery. Supplier is responsible for the adequacy and safety of his procedures.
DATE RECEIVED 8-5-77
DISPOSITION
1 Manufacture as is, release
2 Manufacture as noted, release
3 Resubmit for approval
4 Correct and resubmit
5 Rejected
Signature [illegible] 8-5-77
Title [illegible]
Company [illegible]
Supplier may proceed with manufacture

Ⓒ Data marked Vendor Document Description should be entered into Design Change Package DCP.
Ⓒ Any Vendor Document number does not relieve Vendor of responsibility to number his documents.
Vendor Drawing 9844-E-234-659 Rev 1
Reviewed for CE Design Requirements
Date 8-5-77

MASTER ESS

IMPORTANT
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RECEIVED QUALITY ACCEPTABLE

5023-901-213-21

D01