E-234-659

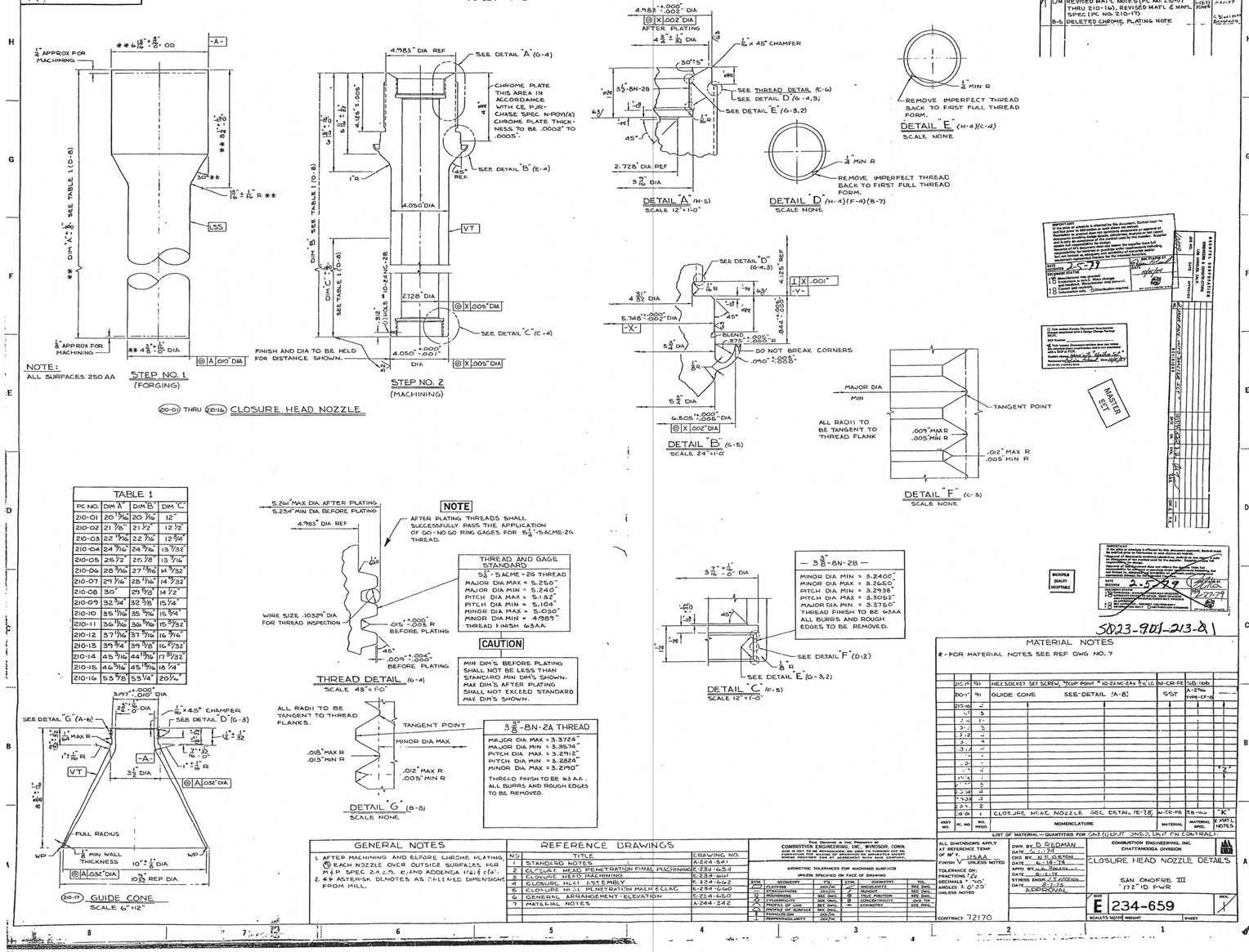

TABLE 1			
PC NO.	DIM "A"	DIM "B"	DIM "C"
210-01	20 13/16"	20 7/16"	12"
210-02	21 7/8"	21 1/2"	12 1/2"
210-03	22 13/16"	22 7/16"	12 3/4"
210-04	24 5/16"	24 5/16"	13 7/32"
210-05	26 1/2"	25 7/8"	13 7/16"
210-06	28 3/16"	27 13/16"	14 3/32"
210-07	29 1/16"	28 11/16"	14 9/32"
210-08	30"	29 5/8"	14 1/2"
210-09	32 3/4"	32 3/8"	15 1/4"
210-10	35 11/16"	35 5/16"	15 3/4"
210-11	36 11/16"	36 5/16"	15 31/32"
210-12	37 11/16"	37 5/16"	16 3/16"
210-13	39 3/4"	39 3/8"	16 21/32"
210-14	45 3/16"	44 15/16"	17 31/32"
210-15	46 5/16"	45 15/16"	18 1/4"
210-16	53 5/8"	53 1/4"	20 1/4"

NOTE

AFTER PLATING THREADS SHALL SUCCESSFULLY PASS THE APPLICATION OF GO-NO GO RING GAGES FOR 5 1/4"-5ACME-2G THREAD.

THREAD AND GAGE STANDARD

5 1/4"-5ACME-2G THREAD
MAJOR DIA MAX = 5.250"
MAJOR DIA MIN = 5.240"
PITCH DIA MAX = 5.132"
PITCH DIA MIN = 5.104"
MINOR DIA MAX = 5.030"
MINOR DIA MIN = 4.989"
THREAD FINISH 63AA

CAUTION

MIN DIM'S BEFORE PLATING SHALL NOT BE LESS THAN STANDARD MIN DIM'S SHOWN. MAX DIM'S AFTER PLATING SHALL NOT EXCEED STANDARD MAX DIM'S SHOWN.

3 3/8"-8N-2A THREAD

MAJOR DIA MAX = 3.3724"
MAJOR DIA MIN = 3.3574"
PITCH DIA MAX = 3.2912"
PITCH DIA MIN = 3.2824"
MINOR DIA MAX = 3.2190"

THREAD FINISH TO BE 63 AA. ALL BURRS AND ROUGH EDGES TO BE REMOVED.

— 3 3/8"-8N-2B —

MINOR DIA MIN = 3.2400"
MINOR DIA MAX = 3.2650"
PITCH DIA MIN = 3.2938"
PITCH DIA MAX = 3.3052"
MAJOR DIA MIN = 3.3750"
THREAD FINISH TO BE 63AA
ALL BURRS AND ROUGH EDGES TO BE REMOVED.

MATERIAL NOTES

*-FOR MATERIAL NOTES SEE REF DWG NO. 7

ASSY NO.	PC NO.	NO. REQD	NOMENCLATURE	MATERIAL	MATERIAL SPEC.	* MAT'L NOTES
	210-19	91	HEX SOCKET SET SCREW, 5/16" CUP POINT #10-24NC-2A x 3/16" LG	NI-CR-FE	SB-166	
	210-17	91	GUIDE CONE SEE DETAIL (A-8)	SST	A-296 TYPE-CF-8	
	210-16	4				
	[illegible]	3				
	[illegible]	1				
	[illegible]	2				
	[illegible]	4				
	[illegible]	4				
	[illegible]	4				
	[illegible]	4				
	[illegible]	4				
	[illegible]	4				
	[illegible]	4				
	[illegible]	4				
	[illegible]	4				
	[illegible]	4				
	[illegible]	4				
	[illegible]	4				
	[illegible]	2				
	[illegible]	1	CLOSURE HEAD NOZZLE SEE DETAIL (E-28)	NI-CR-FE	SB-166	"K"

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

GENERAL NOTES

1. AFTER MACHINING AND BEFORE CHROME PLATING, (A) EACH NOZZLE OVER OUTSIDE SURFACES PER M&P SPEC 2.4.2.9, E, AND ADDENDA 1 & 2 & 3.
2. ** ASTERISK DENOTES AS FILLERED DIMENSIONS FROM MILL.

REFERENCE DRAWINGS

NO	TITLE	DRAWING NO.
1	STANDARD NOTES	A-244-541
2	CLOSURE HEAD PENETRATION FINAL MACHINING	E-234-654
3	CLOSURE HEAD MACHINING	E-234-661
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-244-542

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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 IN.
	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 125AA UNLESS NOTED
TOLERANCE ON: FRACTIONS ± 1/64 DECIMALS ± .010 ANGLES ± 0°30' UNLESS NOTED

CONTRACT 72170

DWN. BY D. REDMAN DATE 6-11-74
CKD. BY N. P. GIBSON DATE 6-14-74
APPD BY L.W. ROBERTS DATE 6-11-74
STRESS ENGR. J. T. ROBERSON DATE 8-7-75
APPROVAL

COMBUSTION ENGINEERING, INC.
CHATTANOOGA DIVISION

CLOSURE HEAD NOZZLE DETAILS

SAN ONOFRE III
172" ID PWR

SIZE E 234-659 REV. 1

SCALE NOTED WEIGHT SHEET

5023-901-213-01

P01