OUTSTANDING CHANGES MUST BE ATTACHED FOR WORKING COPY
VTD 3250413 009 1 Printed 20040112

E-233-048

SYM	ZONE	DESCRIPTION	DATE	APPROVED
1	B-6	REVISED PARALLELISM TOL.	10-5-67	S.M.
	B-2	ADDED 5/16" R. TO WELD.	10-5-67	6-3-68
	C-5	ADDED NOTE.		
	A-6	REVISED NOTE #5.		
2	E-5	79 CONTROL ROD HOUSINGS WAS 78.	7-26-68	S.M.
	E-6		10-4-68	5-15-68
3	F-6	REVISED NOTE NO 5	10-14-68	S.M.
4	GH-2	REVISED NOTE FOR ATTACHING NAME PLATE.	4-21-69	S.M. 4-21-69
		ADDED REF DWG #9, ADDED # AND NOTE AT PLAN VIEW.		

ASS'Y NO.	PENETRATION NO.
051-01	1
051-02	2, 3, 4, 5
051-03	6, 7, 8, 9
051-04	10, 11, 12, 13
051-05	14, 15, 16, 17, 18, 19, 20, 21
051-06	22, 23, 24, 25
051-07	26, 27, 28, 29
051-08	30, 31, 32, 33, 34, 35, 36, 37
051-09	38, 39, 40, 41, 42, 43, 44, 45
051-10	46, 47, 48, 49
051-11	50, 51, 52, 53, 54, 55, 56, 57
051-12	58, 59, 60, 61
051-13	62, 63, 64, 65, 66, 67, 68, 69
051-14	70, 71, 72, 73
051-15	74, 75, 76, 77, 78, 79*

270° PLAN VIEW (* SEE REF. DWG. #9)
SCALE: 1"=1'-0"

SECTION "A-A" (F-6)
SCALE: 1"=1'-0"

DETAIL "B" (D-6)
SCALE: 24"=1'-0"

"TYPICAL HOUSING WELD DETAIL" (E-6)
SCALE: 12"=1'-0"

DETAIL "C" (B-7)
SCALE: 12"=1'-0"

DETAIL "D" (D-5)
TYPICAL FOR ALL HOUSINGS
SCALE: 6"=1'-0"

SECTION "E-E" (H-7)
SCALE: 3"=1'-0"

GENERAL NOTES

1. DOUBLE ARROW INDICATES DIMENSIONS TO A GIVEN REFERENCE LINE.
2. REFERENCE (REF) DIMENSIONS ARE FOR INFORMATION ONLY, DO NOT USE FOR FABRICATION.
3. FOR STANDARD NOTES SEE REF. DWG. #1.
4. ALL FABRICATION SHALL BE IN ACCORDANCE WITH ASME BOILER CODE SECT. III.
5. PAINT ALL EXTERIOR SURFACES OF CLOSURE HEAD EXCEPT HOUSINGS MATING SURFACE AND AREAS OTHERWISE NOTED WITH TWO (2) COATS OF MIL-P-14276B PAINT (GILMAN PAINT & VARNISH COMPANY'S HEAT RESISTING ALUMINUM OR EQUAL).
6. PAINT TO BE GILMAN LS-937 HEAT RESISTANT STENCIL RED PAINT.

REFERENCE DRAWINGS

NO.	TITLE	DRAWING NO.
1.	STANDARD NOTES	A-230-536
2.	GENERAL ARRANGEMENT - ELEVATION	E-233-040
3.	GENERAL ARRANGEMENT - PLAN	E-233-041
4.	CLOSURE HEAD FORMING AND WELDING	E-233-046
5.	CLOSURE HEAD MACHINING	E-233-047
6.	CONTROL ROD MECHANISM HOUSING DET.	E-233-051
7.	CONTROL ROD PENETRATION DETAILS	E-233-052
8.	MISCELLANEOUS DETAILS	E-233-055
9.	CLOSURE HEAD ASSY. MODIFICATION	SE-2269-46

WELD TABULATION

WELD NO.	DETAIL WELD PROC.
1-048	WA-3266-048
2-048	WA-3266-048

GEOMETRIC TOLERANCES FOR MACHINED SURFACES UNLESS SPECIFIED ON FACE OF DRAWING

SYM.	GEOMETRY	TOL.
—	FLAT & STRAIGHT	.001 IN.
⊥	PERPENDICULARITY	.001 IN.
//	PARALLELISM	.001 IN.
∠	ANGULARITY	SEE DWG.
⊕	SYMMETRY	SEE DWG.
⊕	TRUE POSITION	SEE DWG.
◎	CONCENTRICITY	.010 TIR
○	ROUNDNESS	.010 TOL.

ALL DIMENSIONS APPLY AT REFERENCE TEMP OF 68° F. SEE NOTE "3"
FINISH √ UNLESS NOTED
TOLERANCE ON: FRACTIONS ± 1/64", DECIMALS ± .010", ANGLES ± 2°30' UNLESS NOTED
CONTRACT 3266

ASSY NO.	PC. NO.	NO. REQ'D.	NOMENCLATURE	MATERIAL	MATERIAL SPEC.

LIST OF MATERIAL - QUANTITIES FOR

DWN. BY Gary McCollum DATE 1-15-68
CKD. BY [illegible] DATE 1-22-68
APPD. BY [illegible] DATE 2-5-68
STRESS ENGR. [illegible] DATE 2-5-68
APPROVED DATE

COMBUSTION ENGINEERING, INC.
CHATTANOOGA DIVISION

CLOSURE HEAD ASSEMBLY
FOR: WESTINGHOUSE ELECTRIC CORP.
173" I.D. REACTOR VESSEL

CODE IDENT. NO. | SIZE: E | 233-048-4
SCALE AS NOTED | WEIGHT | SHEET

SEE FIRST SHEET FOR APPROVAL STATUS SHT # 9

S-1 PSEP # 325043

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