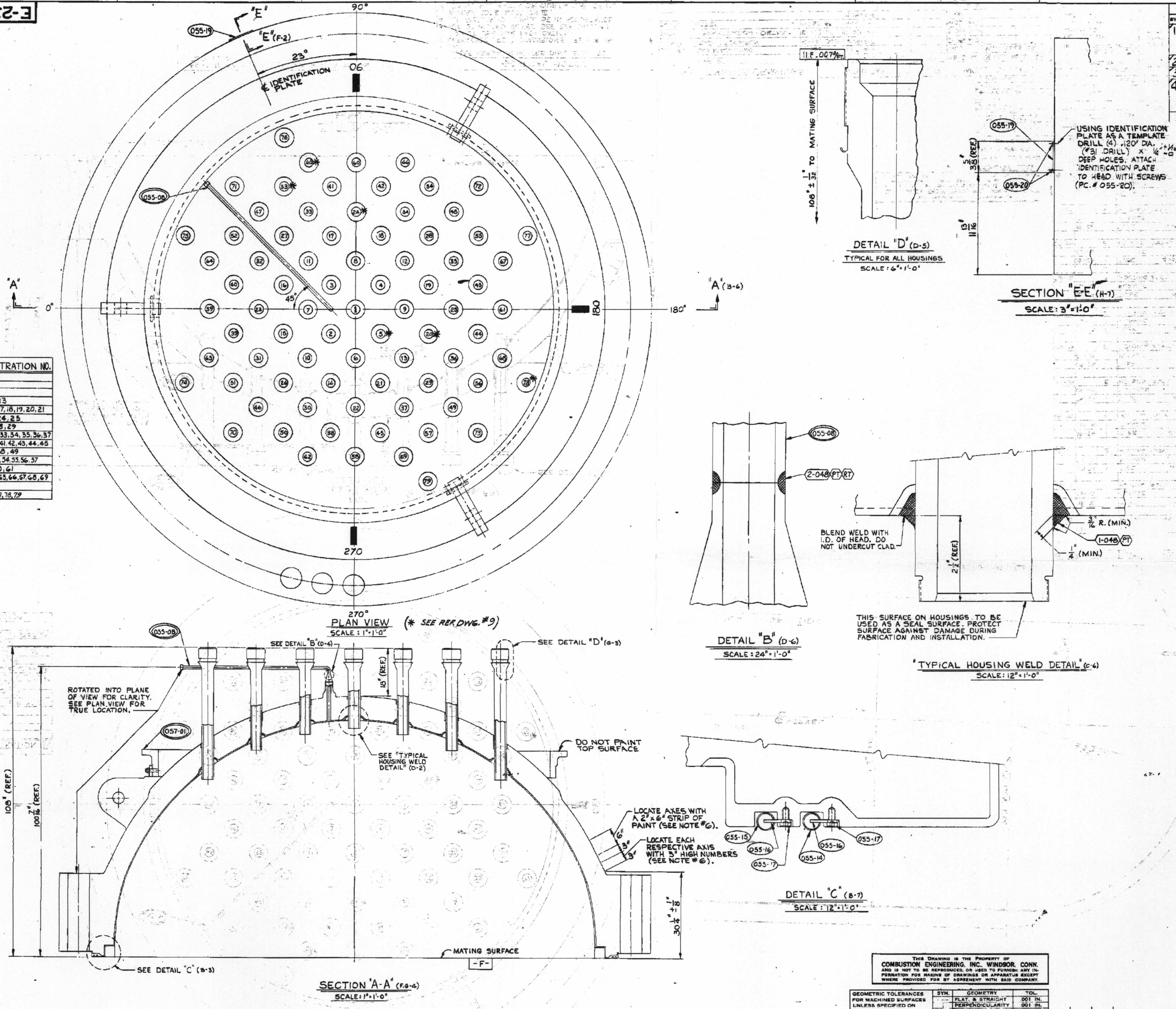
E-233-048

REVISIONS				
SYM	ZONE	DESCRIPTION	DATE	APPROVED
1	H-4 E-2 C-5 A-6	REVISED PARALLELISM TOL. ADDED 3/16" R. TO WELD. ADDED NOTE. REVISED NOTE # 5.	GM 12-29-67	B.M. 6-3-68
2	E-6 E-8	79 CONTROL ROD HOUSINGS WAS 78.	7-10-68 J.E.B.	B.M. 9-10-68
3	A-6	REVISED NOTE № 5	10-11-68 J.E.B.	B.M. 10-14-68
4	GH-2 A-4 &D-6	REVISED NOTE FOR ATTACHING NAME PLATE. ADDED REF. DWG # 9. ADDED * AND NOTE AT PLAN VIEW.	4-8-69 J.E.B.	B.M. 4-21-69

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
051-16	74, 75, 76, 77, 78, 79



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SEE FIRST SHEET FOR APPROVAL STATUS SHT # 9 — S-1 PSBP # 325043

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	SIZE TOL.

ASSY NO.	PC. NO.	NO. REQD.	NOMENCLATURE	MATERIAL	MATERIAL SPEC.

LIST OF MATERIAL - QUANTITIES FOR

6. PAINT TO BE GILMAN LS-937 HEAT RESISTANT STENCIL RED PAINT.

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 SECTION 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).

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 ASS'Y. - MODIFICATION	SE-3266-46

WELD TABULATION

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

ALL DIMENSIONS APPLY AT REFERENCE TEMP. OF 68° F. SEE NOTE # 3
FINISH √ UNLESS NOTED
TOLERANCE ON: FRACTIONS ± 1/16", DECIMALS ± .010", ANGLES ± 0°-30' UNLESS NOTED

CONTRACT 3266

DWN. BY GARY McCOLLUM DATE 7-13-67
CKD. BY WFO DATE 7-20-67
APPD. BY DJM DATE 7-27-67
STRESS ENG'R. GLC DATE 7-29-67

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

D-02