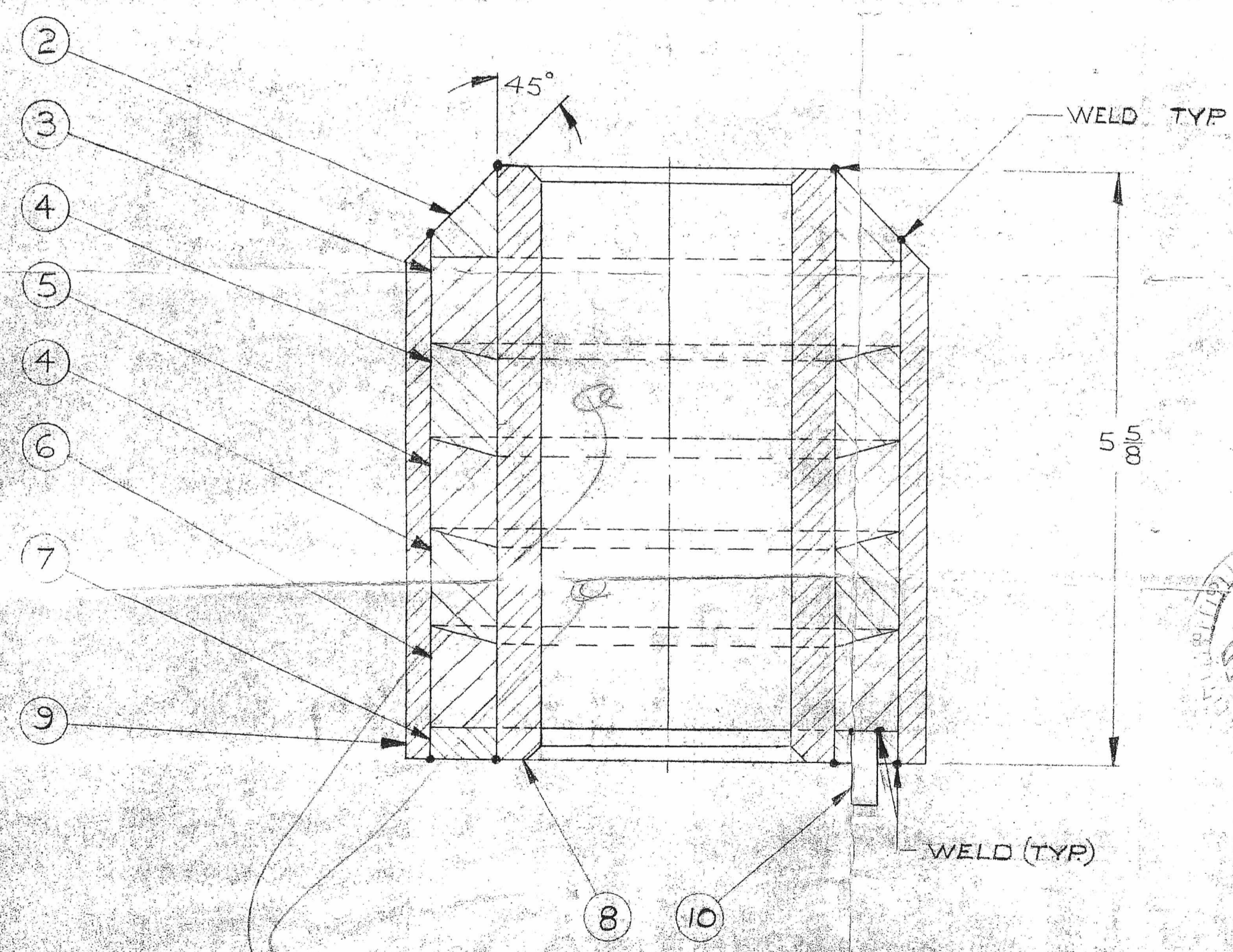
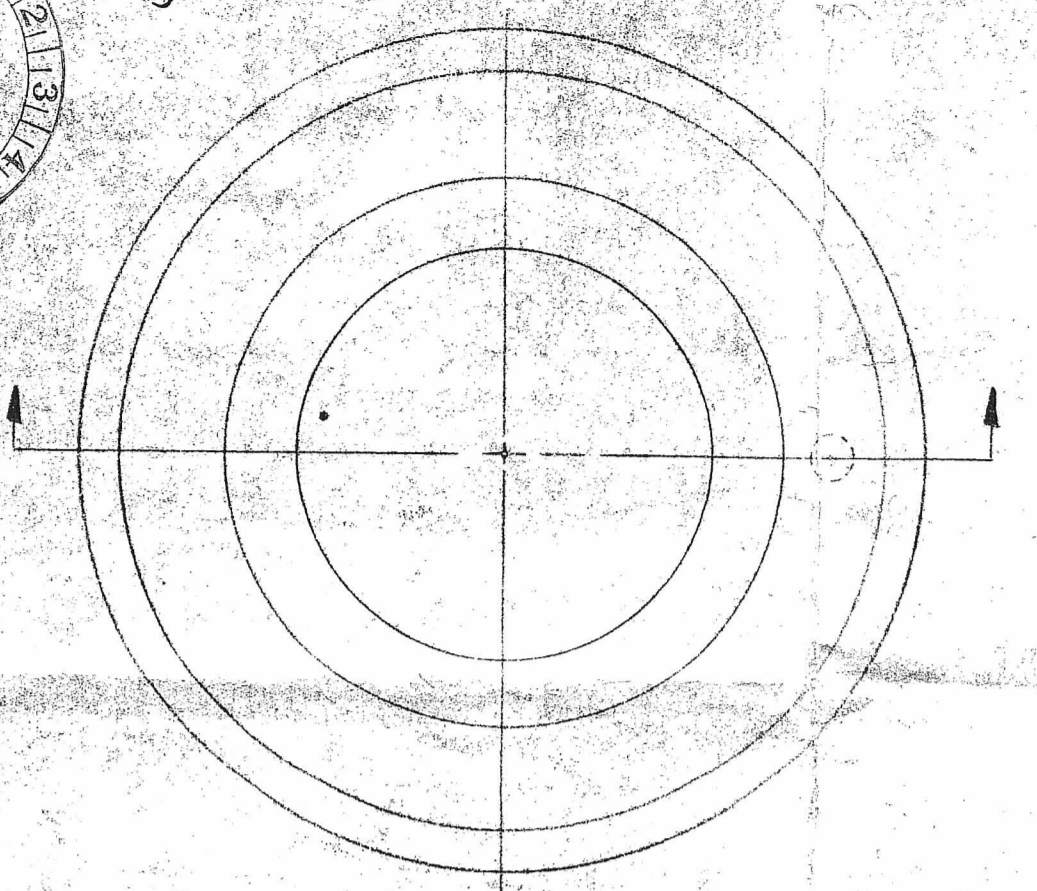


DOCKET NO. 70-139

Trans. of the 4-18-61 File Copy



Fuel Ring No. 59 See
Total 1539 U-235 per Billet

CHG. LET.	DESCRIPTION	DATE	BY	APP.	CHG. NO.
A	CHANGED LOCATION OF EVACUATION TUBE WELD	12/1/60	CP	CP	447
B	ADDED NOTES	1/24/61	CP	CP	514
C	NOTE 1.020 DEPTH WRS. 0.035 ADDED NOTE 4	2/12/61	CP	CP	641

NOTES

1. INNER & OUTER CLADDING SURFACES (ID & OD) OF COMPOSITE BILLET MUST BE FREE OF ALL INCLUSIONS; THERE MUST BE NO SHARP CORNERED, PITS, DEPRESSIONS, SCRATCHES, OR GOUGES W/A DEPTH IN EXCESS OF .005. ANY PIT, DEPRESSIONS SCRATCH OR GOUGE IN EXCESS OF .005 MUST BE BLENDED INTO THE SURFACE TO REMOVE THE SHARP EDGES, MAX. DEPTH .020
2. THE COMPOSITE BILLET MUST BE FREE OF ALL OIL & FOREIGN CONTAMINANTS
3. THE COMPOSITE BILLET MUST BE VACUUM TIGHT
4. WELDS MUST NOT PROJECT ABOVE SURFACE



QTY	ITEM NO.	DRAWING NO.	DESCRIPTION
1	10	1113-31	EVACUATION TUBE
1	9	1113-22	OUTER CLAD
1	8	1113-21	INNER CLAD
1	7	1113-20	END SEAL
1	6	1113-19	REAR SPACER
1	5	1113-18	CENTER SPACER
2	4	1113-17	FUEL RING
1	3	1113-16	FRONT SPACER
1	2	1113-15	NOSE RING
X	1	1113-5	COMPOSITE BILLET ASS'Y TYPE II

G-2 QUANTITY	G-1 ITEM NO.	DRAWING NO.	DESCRIPTION	PROJECT NO.	USED ON ASS'Y
				CP-3	

TOLERANCES UNLESS OTHERWISE SPECIFIED	APPROVED	DATE	FINISH & SPECIFICATION	TITLE
DECIMAL ± .005	AP	3/29/61	MATERIAL & SPECIFICATION	COMPOSITE BILLET ASS'Y TYPE II
FRACTIONAL ± 1/64"	CHECKED			
ANGULAR ± 1/2°	APPROVED			

BREAK ALL SHARP EDGES REMOVE ALL BURRS	ENGELHARD INDUSTRIES INC. D. E. MAKEPEACE DIVISION ATTLEBORO, MASS.	SCALE 1/1	SIZE C	DRAWING NO. 1113-5	REV C
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D-15