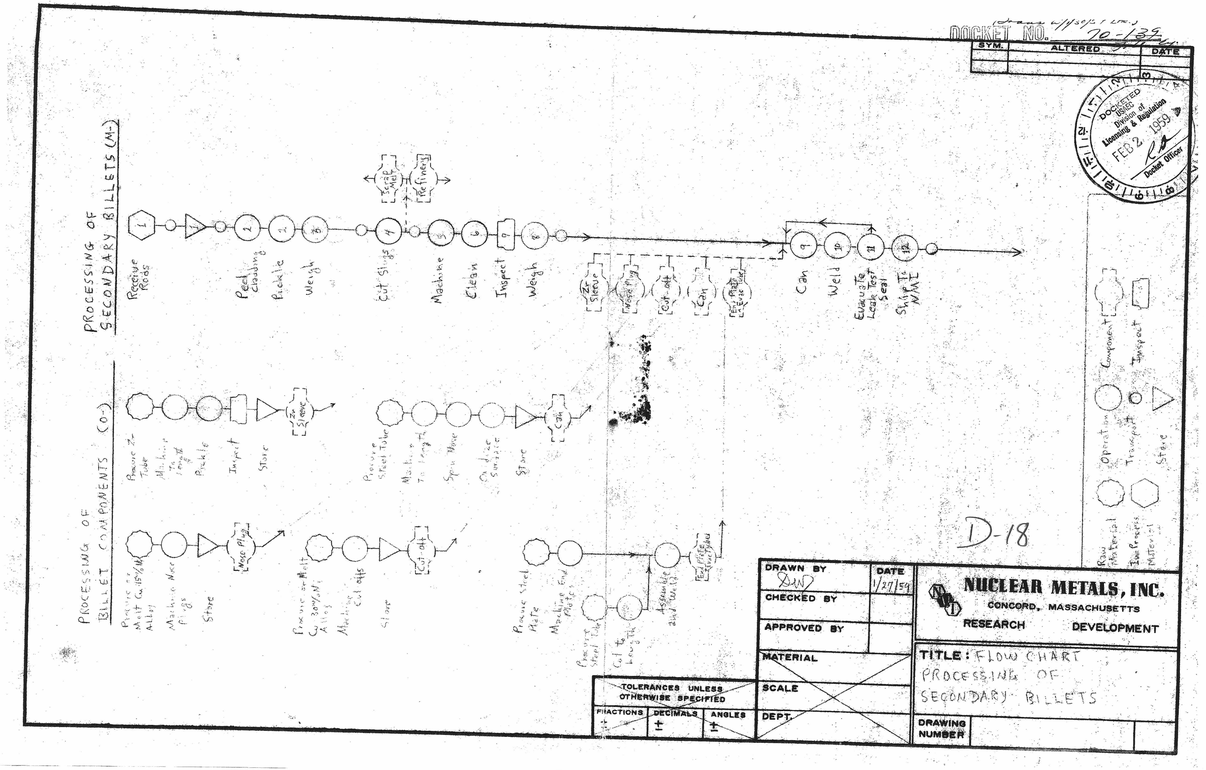

DOCKET NO. 70-139
SYM.
ALTERED
DATE
DOCKETED USNRC Division of Licensing & Regulation FEB 2 1959 Docket Officer
PROCESSING OF SECONDARY BILLETS (M-)
Receive Rods
Peel Cladding
Pickle
Weigh
Cut Slugs
Machine
Clean
Inspect
Weigh
Scrap Melt
Refinery
Zr Sleeve
Nose Plug
Cut-off
Can
Can
Weld
Evacuate Leak test Seal
Ship To NMI
PROCESSING OF BILLET COMPONENTS (O-)
Procure Zr Tube
Machine To Length
Pickle
Inspect
Store
Procure Steel Tube
Machine To Length
Spin Hose
Outside Surface
Store
Procure Steel Plate
Machine End Plates
Procure Steel Tube
Cut to Length
Assemble 2nd Weld
Component
Inspect
Operation
Transport
Store
Raw Material
Inspected Material
D-18
DRAWN BY
DATE 1/27/59
CHECKED BY
APPROVED BY
MATERIAL
SCALE
DEPT.
TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS
DECIMALS
ANGLES
NUCLEAR METALS, INC.
CONCORD, MASSACHUSETTS
RESEARCH DEVELOPMENT
TITLE: FLOW CHART PROCESSING OF SECONDARY BILLETS
DRAWING NUMBER