ANALYZE FOR SAFETY, ECOLOGY, AND MINIMUM ESSENTIAL DESIGN

(2) COVER ALIGNMENT PINS SEE DET. D199326-C

1½" SCRD CAP 3000#

2 - LIFTING TRUNNIONS EQ. SPACED PER D199326-D

5" LEAD SHIELDING IS REQ'D. FOR ALL PORTIONS OF BOX ABOVE GRADE.

SEE ENLARGED VIEW GUIDE PLATE

SEE ENLARGED VIEW GUIDE PL

3" S.G.R. 27 GRAYLOCK HUB (TYP)

SEE ENLARGED DETAIL 1

WEIR PLATE (TYP)

3" SCH. 40 S PIPE CORE (TYP) CORE PIPE SPEC.

4" SCH. 40 S JK'T. PIPE (TYP.) S.S. TP 304L

1½" SCH. 40S S.S. PIPE TP304L

BEVEL PIPE END FOR WELD

1½" S.S. TP304L PIPE "HLLCP" (REF.)

(2) - 1½" DIA. HOLES IN BOTTOM HD. FLANGE ON 1'-5¾" RAD., AT 45° & 180°

PLAN

D199324-A

(APPROX. WGT: 15000#)

N.T.S.

TAPER I.D. OF SCH. 40S PIPE TO MATCH I.D. OF SCH 10S PIPE

ENLARGED DET. 1

SCALE: NONE

FOR ENLARGED VIEW SEE DWG. D199326-F

¾" HILLS-McCANNA S303-SGL-R-SG-SP BALL VA (TYP) (SV347)

¾" F.P.T. SHUT OFF HANSEN MFG. CO. SERIES 6 HK PART No. ML6-K31-143 (2-REQ'D.)

STAMP OR WELD WGT. ON OUTER SHELL IN ½" HIGH NUMBERS

1" SCRD CAP

PIPE SUPPT.

CORE PIPE SPEC.

SUPPORT 3"x¼" THK. C.S. PL CUT LENGTH TO SUIT (TYP)

1" SCH. 40S SS TP304L PIPE (SMEAR PROBE)

SUPPORT ¼x3" WIDE PL CUT LENGTH TO SUIT (TYP) SS TP304L

SUPPORT ¼x3" WIDE PL CUT LENGTH TO SUIT (TYP) SS TP304L

SEE DET. 2 THIS DWG.

3/16" x 1" F.B. WEIR W/ (3) 60° V NOTCHES x 1" DP. 304L

WEIR PL ¼ THK. SS. PL TP 304L

SECTION A-A

VALVE BOX

N.T.S.

SECTION D-D

NO SCALE

3'-6⅝" O.D. x 2'-8¾" I.D. x ½" THK PL (TYP)

TOP RING: ST. STL.

BOTTOM RING: C.S.

3'-6⅝" O.D. (REF.)

2'-8⅜" O.D

"HLLCP"

CONT. SEAL WELD (TYP)

¼" PL S.S. TP 304L

3'-2" Ø x 5/16 THK. BOTTOM PL. SS. TP 304L

L 4"x4"SQ. PL (2-REQ'D) L 2"x2½" (2-REQ'D)

SECTION B-B

NO SCALE

STAMP OR WELD WGT ON TOP IN ½" HIGH NUMBERS

¼" PL. (TYP. ALL SLEEVES) SS. TP 304L

6" I.D. SLEEVE

6" I.D. SLEEVE

PLAN

D199324-C

WGT. APPROX 2650 LBS.

3/4" SCH. 40S S/S PIPE TP 304L

CORE PIPE SPEC.

3" SCH 40S SST. PIPE TP 304L

BORE HOLE TO SUIT

DETAIL - 2 - CORE PIPING

SCALE - 6" = 1'-0" (SEE NOTE 1)

2 - 3/8 TH'K. LIFTING LUGS, 180° APART.

1" Ø HOLE

VIEW "G-G"

1" 3000# THD. CAP

1" SCH 40S S.S. TP304L PIPE

4" JACKET 3" CORE

SMEAR PROBE

10"

SECTION "H-H"

SCALE: 6" = 1'-0"

⅞" DRILL THRU EACH ANGLE TO MATCH PINS IN VALVE BOX FLG. FOR COVER ALIGNMENT.

3'-6⅝" O.D.

3x3x¼ x 3" LG.

SECTION E-E

VALVE BOX COVER

N.T.S.

5" LEAD FILLED BORE HOLE

1" 90° EL - L.R. - SCH. 40S S.S. TP304L

9¼"

¼" x 2" x 2" GUSSETS, 3-REQ'D. EA. GUIDE PL. SEE SECTION "B-B" FOR SPACING SS TP304L

SS TP304L ¼" PL

¼" PL SS TP304L

¼" x 2" DP. GUSSET. (LGTH TO SUIT)

ENLARGED VIEW GUIDE PLATE

SCALE: 6" = 1'-0"

(2 REQ'D, ONE OPPOSITE HAND)

SLOT

FABRICATOR MAY MODIFY AS REQ'D FOR SMOOTH OPERATION

SECTION F-F

SCALE: 6" = 1'-0"

GENERAL NOTES:

1. MATL: BOX & INTERIOR PCE.S 304L SST. PER SW 300M. BOX JACKET EXT. PCE.S C.S. SA 36.
2. CORE PIPING TYPE 304L EQUAL PER DUPONT SPEC. 4482 CODE P 224 A OTHER 304L PIPE COM'L. QUAL. (CORR EVAL. NOT REQ'D.) PER SW 300M UNLESS NOTED FOR GRAYLOC HUBS SEE PURCHASE ORDER (AXC-8835W)
2. WELDING:
   SST TO SST - SPEC. SW 17 W
   C.S. TO C.S. - SPEC. SG 5.1 S
   SST TO C.S. - SPEC. SW 20.1 W (E309 OR E310 ELECTRODES)
3. ALL UNDERGROUND PIPING & METAL SURFACES IN CONTACT WITH EARTH TO BE COATED & WRAPPED AS FOLLOWS: PER SRP STD. 7797 SYSTEM C.
4. FABRICATION OF VESSEL TO BE IN ACCORDANCE WITH STD. SG 5 S.
5. HYDROSTATIC TEST ALL CORE PIPE PER CODE 4482, P224A
6. CORROSION ALLOWANCE: NONE (EXCEPT PIPING PER PIPING SPECS)
7. BREAK ALL SHARP EDGES
8. DYE CHECK ALL PENETRATION WELDS THRU VALVE BOX, AND BOTTOM PL CLOSURE WELDS, AND LIFTING TRUNNION & LUG WELDS.
9. ROLLER SLOT TO BE CHECKED FOR SMOOTH ROLLER TRAVEL BEFORE FINAL ASSEMBLY.
10. HYDRO TEST BOX BY FILLING WITH WATER AND HOLDING FOR 24 HRS.

D 199324 LAST REV. 26

Barcode A00038453

M/F | TYPE 27 | **D 199324** | LAST REV. 26

SAVANNAH RIVER PLANT
BLDG. 241-H TANK 40
WASTE TRANSFER FACILITIES
VALVE BOX DET. Y340
PROCESS S.H. 1

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THE PHOTOGRAPHIC LINES ON THIS TRACIN MAY BE REMOVED WITH A WET ERASER

PROJ	NO.	REVISION	RVSD	CHKD	APPD	DATE
951780	13-15	ADDED "CORE PIPE SPEC."				
	16	WAS 9"				
951780	17	GUIDES WERE WELDED TO BOTTOM				
	18	ADDED NOTE 4 REV. RING MATL.				
	20	WAS 1'-8" APPROX 2 WAS 1'-8¼"				
	22	ADDED NOTE: COPING AROUND SCRD PAD				
951780	23	ADDED 1½" DIMENSION				
	24	WAS 5/8" AND SYSTEM IE (SRP REV)				
	25	DELETE SP1.1B				
	26	ADD'D. CPL'G. & ASSOC. DIMENSIONS				

PROJ	NO.	REVISION	RVSD	CHKD	APPD	DATE
951780	1	ADDED TAPER NOTE				
	2	REVISED NOTE 1				
	3	MODIFIED NOTE 5				
	4	ADDED CORE PIPE-REPEL NOTE				
	5	ADDED DRAIN PIPE SIZE				
	6	REVISED NOTE #1				
	7	NOTE 3 WAS 5/8 PER DUPONT STD SP1.18(K)				
	8-10	REVISED NOTES #5, 6 & 8				
	11	ADDED NOTE #10				
	12	ADDED: SW 300M / STD 7779				

DWGS: WB07576, SW 17 W, SW 300M, SG 5.1 S, SRP STD 7797, SW 20.1 W, SG 5 S, SPEC. 4436 P 224 A

STDS

TOLERANCES ON ALL DIMENSIONS, UNLESS OTHERWISE NOTED, TO BE:

DECIMALS: 1-PLACE ± 0.05 IN. 2-PLACE ± 0.01 IN.

ANGLES ± 0°30' FRACTIONS ± 1/8"

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PROJECT 751780
SCALE NONE NOTED. DATE
DRAWN V.L. SANTAMAURO JUL 8 1985
CHECKED S. RAYNES 7-25-85
APPROVED-I.C.R. [signature] 7/31/85
APPROVED-FINAL [signature] 7-31-85

E. I. DU PONT DE NEMOURS & CO., INC.
WILMINGTON, DELAWARE
ENGINEERING DEPARTMENT
D 199324

Y340/27