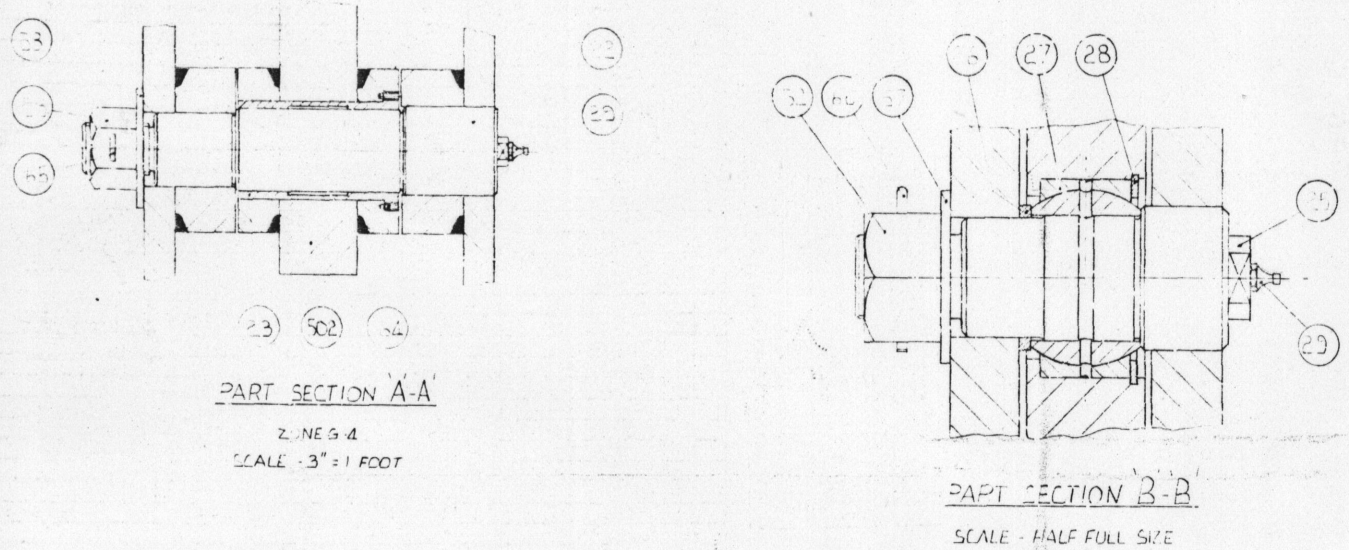
R222A947

SURFACES MARKED THUS TO BE MACHINED AND ALLOWANCE TO BE MADE FOR THIS MACHINING. DIMENSIONS IN INCHES UNLESS OTHERWISE STATED

THIRD ANGLE PROJECTION DO NOT SCALE

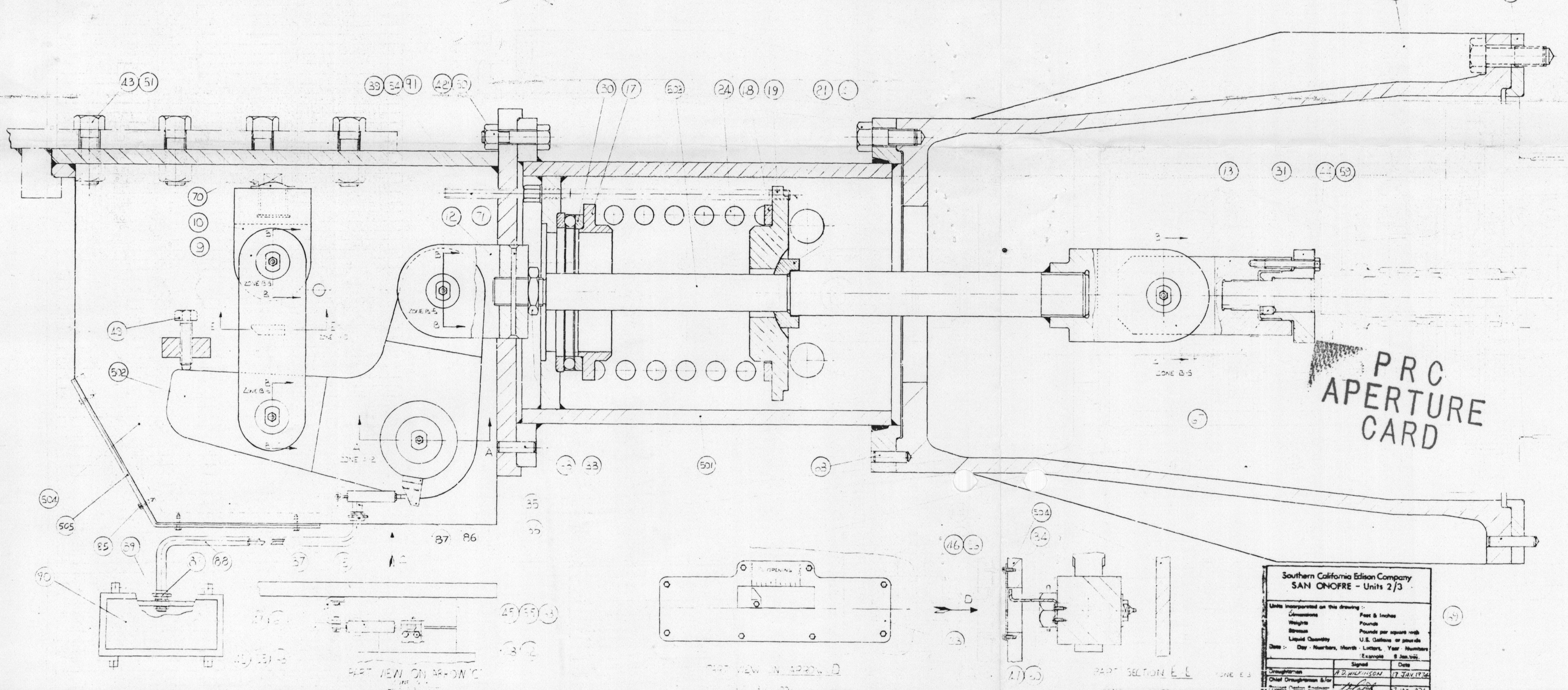
UNTOLERANCED DECIMAL DIMENSIONS ARE TO BE WITHIN THE FOLLOWING LIMITS (TOLERANCES MUST NOT BE CUMULATIVE) - BORE DIAMETERS, SLOT AND RECESS DEPTHS AND WIDTHS - SIZE TO + .010" SHAFT DIAMETERS AND SPIGOT HEIGHTS - SIZE TO - .010" CENTRE DISTANCES AND CENTRES TO FACES - SIZE TO ± .005"



NOTE

JACKSCREW, ROD BOLT, NUT & WASHER REF. Nos 49, 39, 54 & 91 ARE FOR ASSEMBLY AND SETTING PURPOSES ONLY, AND MUST BE REMOVED AND KEPT IN TOOLBOX ONCE SPINDLE IS IN POSITION

FOR SETTING INSTRUCTIONS SEE GENERAL ARRANGEMENT DRG.



PRC APERTURE CARD

COMP. ... FIRST USED ON SAN ONOFRE 75/R2750/12

PARTS LIST — NUMBERS OFF ARE FOR ONE LEVER ASSEMBLY

No. Off Comb.	Name of Part	Ref. No.	Part No.	Matl. Spec. Order Ref. Patt. Remarks etc.
1	TOP FLANGE	1	R220 4094 /1	S. BS 4360 GR 40A
1	BOTTOM FLANGE	2	" " /2	S.
1	TUBE	3	" " /3	S
1	LOCATION PLATE	4	" " /4	S
5	RIB	5	R220 4094 /5	S BS 4360 GR 40A
1	LEVER	6	R220A4096 /1	S } 35 059 NORMALISED
1	BOSS	7	" " /2	S } 35 059 NORMALISED
1	BOSS	8	R220A4096 /3	S. } 35 059 NORMALISED
1	DOUBLE FORK	9	R220 / 4073 /9	S BS970 EN3A FORGING R253/3321/3 ORD. BY DO
1	TONGUE	10	R220 / 4073 /10	S BS970 EN3A FORGING R253/3321/4 ORD. BY DO
1	FORK	11	R220A4096 /8	S BS970 EN3A FORGING R253M3341/2 ORD BY DO
1	FORK	12	" " /9	S BS970 EN3A FORGING R253M3341/3 ORD. BY DO
1	TONGUE	13	" " /10	S. CMA 30/365
1	SPINDLE	14	R220A4096/7	S. BS970 GR905 M31 CONDITION 'R'
1	POTENTIOMETER	15	R222A947 /15	PENNY & GILES LCP/SA2 ORD BY PSD T PARK
1	COLUMN	16	R220 A4093 /1	S 35/067 CLASS B
1	THRUST RING	17	R220A4096 /4	S 35/059
1	SPACER	18	" /5	S BS 4360 GR 43A
1	SPRING CARRIER	19	" /6	S BS. 970 GR905 M31 CONDITION 'R'
~~1~~	~~SPHERICAL WASHER~~	~~20~~	~~" " /11~~	~~S BS 970 GR905 M31 CONDITION 'R'~~
1	SPHERICAL COLLAR	21	" " /12	S BS 970 GR905 M31 CONDITION 'R'
1	PIN	22	" " /13	S 30/366 NITRIDED
1	BUSH	23	R220A4096 /14	S 30/366 NITRIDED
1	SPRING	24	R220F4099 /1	S BS 1429 EN45 ORD BY DO
4	LEVER PIN	25	R253 / 3081 /12	S 30 365
4	SPACER	26	R253 / 3081 /7	S BS 970 EN38
4	SPHERICAL BEARING	27	R222A947 /27	ROSE CAT No RBJ448DHA483 ORD. BY DO.
4	CIRCLIP	28	" /28	ANDERTON NAM 1300-475 ORD BY DO
5	GREASE NIPPLE	29	" " /29	TECALEMIT HYDRAULIC NA6629 ORD BY DO
1	THRUST BEARING	30	R222A947 /30	SKEFKO CATALOGUE No 51168 ORD BY DO
1	GUIDE NUT	31	R220A4100 /1	S CMA 30/365
1	PACKING RING	32	" " /2	S BS 4360 GR 40A OR 43A
1	INDICATOR PLATE	33	" /3	1/8 THICK RIGID PVC ORD BY DO
1	POINTER	34	" /4	S BS 970 EN3A
1	PACKER	35	" /5	S BS970 EN3A
1	BRACKET	36	" /10	S BS970 EN3A
1	BRACKET	37	" /11	S BS970 EN3A
1	LOCK NUT	38	" " /8	S BS970 EN3B 4½ A/F HEX BAR
—	ROD BOLT	39	R220A4100 /9	S BS970 EN38
~~16~~	~~SPECIAL BOLT~~	~~40~~	~~R200M4918 /15~~	~~S CMA 30 365~~
12	BOLT 1¾ 8 UN x 12 LG	41	IF30025A36	S BS970 EN16S
11	BOLT 1½ 8 UN x 5½ LG	42	IF30024A38	S BS970 EN16S
8	BOLT 2 8 UN x 5½ LG	43	IF30026A38	S BS970 EN16S FOR ACTUATOR FLANGE
10	SPECIAL BOLT	44	R200M4918/14	S CMA 30 365 FOR REFS 13 & 31
2	SPECIAL BOLT	45	R253(A3)3440/1	S To B.S. 970 070 M 20 FOR REF 15
8	SCREW ½ 20UNC 2A x ⅝ LG	46	IF20050B3	S BS970 EN16S FOR REF 33
4	SCREW ½ 20UNC 2A x ¾ LG	47	IF20050A4	S BS970 EN16S FOR REFS 34 & 36
2	SCREW ½ 20UNC 2A x 1½ LG	48	IF20050A8	S BS970 EN16S FOR REF 35
—	JACK SCREW 1½ UNF x 5 LG	49	R200 S 5046/17	S C.M.A. TO B.S. 30/368
11	NUT 1½ 8UN-2B	50	IF0003A64	S BS970 EN3A FOR REF 42
8	NUT 2 8UN-2B	51	IF0003A66	S BS970 EN3A FOR REF 43
4	NUT 2½ 8UN-2B	52	IF0003A67	S BS970 EN3A FOR REF 25
1	NUT 2½ 8UN-2B	53	IF0003A68	S BS970 EN3A FOR REF 22
—	NUT 1-8UNC-2B	54	R200S5265/6	S BS970 EN3A FOR REF 33
2	HEX.NUT No 8-32UNC-2B	55	IF0003A8	S BS970 EN1A FOR REF 45
8	WASHER ¼ DIA	56	IF2005 31	S BS1449 EN2 FOR REF 46
4	WASHER 2½ DIA	57	IF2005A17	S BS1449 EN2 FOR REF 25
1	WASHER 2½ DIA	58	IF2005A18	S BS1449 EN2 FOR REF 22
10	STRIP WASHER ½ DIA x 2 LG	59	IF2064A6	S BS1449 EN2 FOR REF 44
2	STRIP WASHER ½ DIA x 1 LG	60	IF2057A11	S BS1449 EN2 FOR REF 34
2	STRIP WASHER ½ DIA x 1⅛ LG	61	IF2057A12	S BS1449 EN2 FOR REF 37
2	STRIP WASHER ½ DIA x 1½ LG	62	IF2057A14	S BS1449 EN2 FOR REF 43
6	WASHER 2 BA	63	IF2000A3	S BS1449 EN2 FOR REF 45
2	SOCKET SCREW ½ 20UNC	64	IF2149IA9	S BS970 EN16 FOR REFS 22 & 23
1	SPLIT PIN ⅛ DIA x 1½ LG	65	IF8011A32	S BS970 EN3B FOR REF 53
4	SPLIT PIN ⅛ DIA x 1 LG	66	IF8010A29	S BS970 EN3B FOR REF 52
3	DOWEL ½ DIA x 1 LG	67	P324101 /6	S BS 970 EN3A FOR REF 31
1	DOWEL ½ DIA x 3½ LG	68	P324103 /15	S BS 970 EN3A FOR REF 501
[illegible]	DOWEL [illegible] LG	69	P324103 /21	S BS970 EN3A FOR REFS 16 & 32
[illegible]	[illegible] WASHER [illegible] DIA	70	IF2020A20	S BS1449 EN2 FOR REF 10
[illegible]	PIN ¾ DIA [illegible] LG	71	R222A947 /71	S BS 970 EN3B ¾ DIA BAR x 9½ LG. FOR REF 12
[illegible]	JOINT FLANGE	72	R202A4095/1	S BS 4360 GR 40A OR 43A
[illegible]	FACING	73	" /2	S " "
[illegible]	SIDE PLATE	74	" /3	S " "
1	SIDE PLATE	75	" /4	S " "
4	RIB	76	" /5	S " "
2	LOCATION LUG	77	" " /6	S " "
[illegible]	TIE BAR	78	" /7	S BS4360 GR40A OR 43A
1	FULCRUM BOSS	79	" /8	S 35A064 BS 970 EN3A
1	FULCRUM BOSS	80	R220A4095 /9	S 35A064 BS 970 EN3A
2	END ANGLE	81	R220(A2)4383/1	S BS. 4360 GR 40A OR 43A } 2 x 1½ x ¼
4	SIDE ANGLE	82	R220(A2)4383/2	S " " " " } x 2.70 FT/LB
1	STIFFENER BAR	83	R220(A2)4383/3	S BS. 4360 GR. 40A OR 43A. 1½" x ¼" THK
1	WELDMESH [illegible]	84	R220(A2)4383/4	S EXPAMET CAT. MESH No 1595 17" x 33" x (.062" / 1.58 mm) THK.
8	SCREW 3/8-16UNC-2A x [illegible]	85	IF 20052A5	S FOR ASSY 505.
1	ADAPTOR	86	R200Z5384/3	S TO BS 970 070M20
2	END FITTING	87	R222A947/87	SUPERFLEXIT CAT REF 'H' TYPE T2475-16 (MALE) } ORD BY DO
[illegible]	SUPERFLEXIT CONDUIT 12.7 mm BORE	88	" /88	" SCO22/S/216 [illegible] NEOPRENE } ORD BY DO
1	LOCKNUT 16 MM	89	R222A947/89	WALCALL F746L RUGBY INS. STOCK RC 825
1	JUNCTION BOX	90	R222A947/90	GEC ELLIOT DRG B705102 ORDD BY DO
—	WASHER 1" DIA.	91	IF 2005A10	S BS 1449 PT1 CR4 FOR REF 39
SCE #0520			S023-401-A265-3	
1	COLUMN ASSY	501	R220/4094/501	COMPRISING OF REFS. 1 TO 5 INC.
1	LEVER ASSY	502	R220A4096/501	COMPRISING OF REFS. 6 TO 8 INC
1	FORK ASSY	503	R220A4096/502	COMPRISING OF REFS. 11 TO 14
1	ACTUATOR LEVER HOUSING	504	R220A4095/501	COMPRISING OF REFS. 72 TO 80 INC
1	GUARD ASSY	505	R220(A2)4383/501	COMPRISING OF REFS. 81 TO 84 INC.

⊕ NOTE. - SEE SEPARATE PARTS LIST FOR QUANTITIES OF JACKSCREWS (REF 49) ROD BOLTS (REF 39) NUTS (REF. 54) WASHERS (REF. 91)

Southern California Edison Company
SAN ONOFRE - Units 2/3

Units incorporated on this drawing :-	
Dimensions	Feet & Inches
Weights	Pounds
Stresses	Pounds per square inch
Liquid Quantity	U.S. Gallons or pounds
Date :- Day - Numbers, Month - Letters, Year - Numbers	(Example 8 Jan. 1966)

	Signed	Date
Draughtsman	A.D. WILKINSON	17 JAN. 1974
Chief Draughtsman &/or Project Design Engineer	[signature]	17 JAN. 1974
Submittal No.	373	

ASSEMBLY REFERENCE	PARTS USED	DRAWN	
		TRACED	
		CHECKED	
		APPROVED	

GEC Turbine Generators Limited

TITLE: ASSEMBLY OF COLUMNS & LEVERS FOR THROTTLE VALVE

SCALE 3" = 1 FOOT | ISSUING DEPT TDO | FIRST ORDER SAN ONOFRE | DRG. No. R222A947 | SHEET No. — OF — SHEETS

WHEN QUOTING DRAWING NUMBER STATE LATEST REVISION OR ISSUE

POOR ORIGINAL

I CERTIFY THAT THE IMAGE CONTAINED ON THIS FRAME WAS MADE IN THE NORMAL AND REGULAR COURSE OF BUSINESS ON THE DATE STATED BELOW AND THAT IT IS AN ACCURATE REPRODUCTION OF THE DOCUMENT SUBMITTED TO MICROGRAPHICS.
DATE CAMERA OPERATOR SECTION SUPERVISOR

8302100282

Docket #
Control # 8302100280
Date 2/8/83 of Document
REGULATORY DOCKET FILE

MICROFILM QUALITY ACCEPTABLE