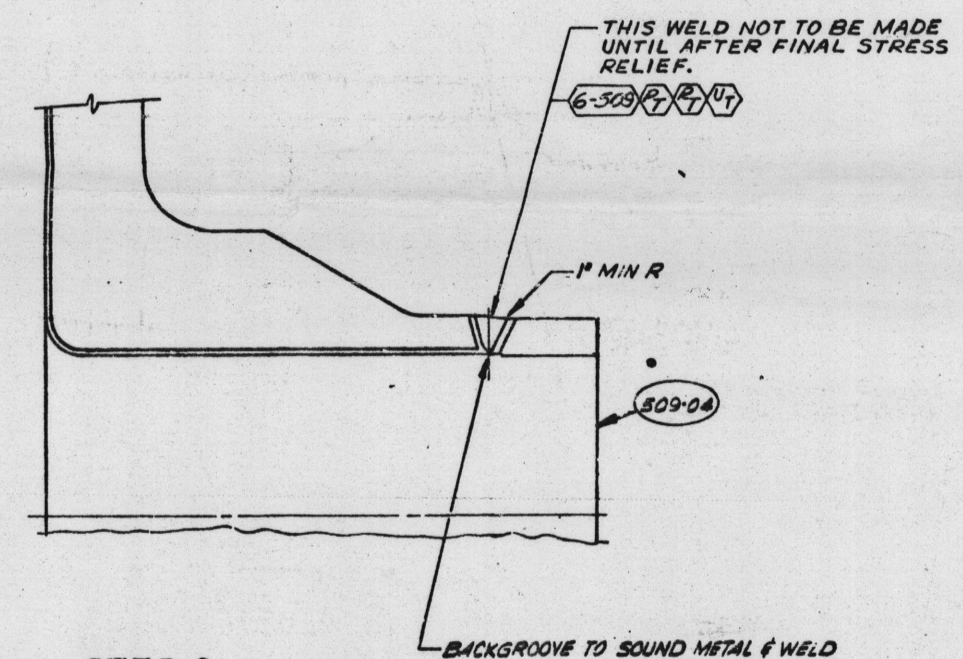
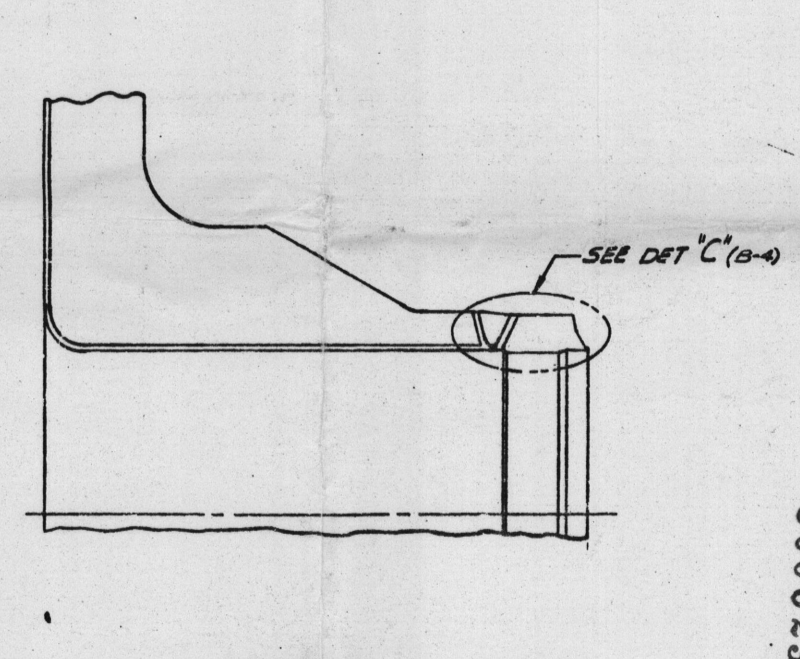


STEP 1

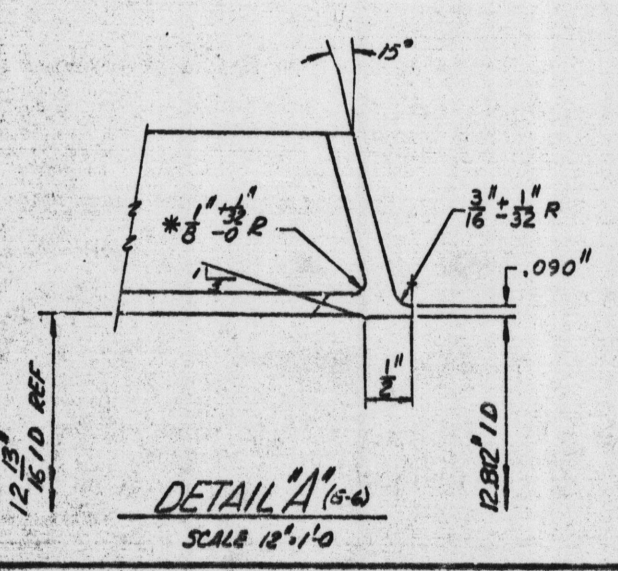


STEP 2

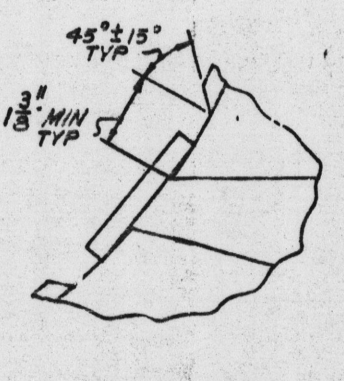


STEP 3

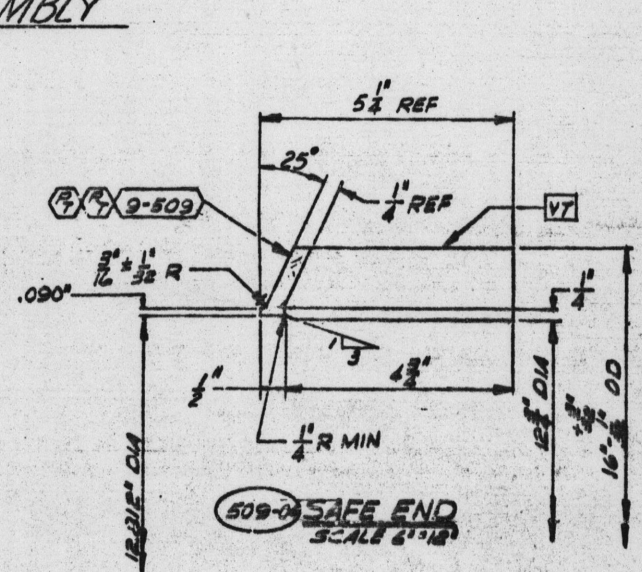
509-03 SHUTDOWN COOLING OUTLET NOZZLE ASSEMBLY SCALE 3\"/>



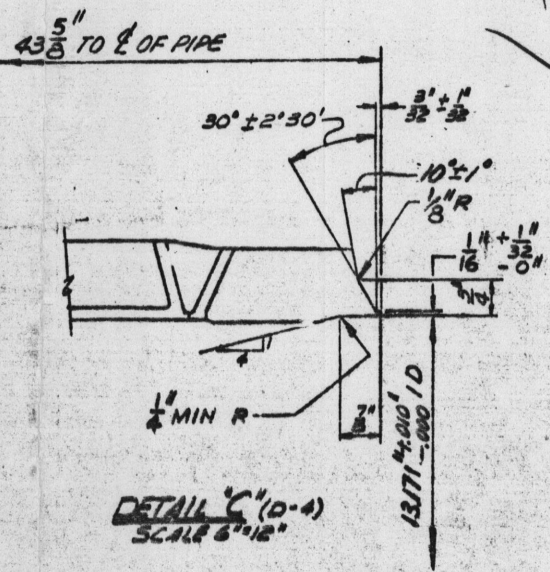
DETAIL A'(A-4) SCALE 12\"/>



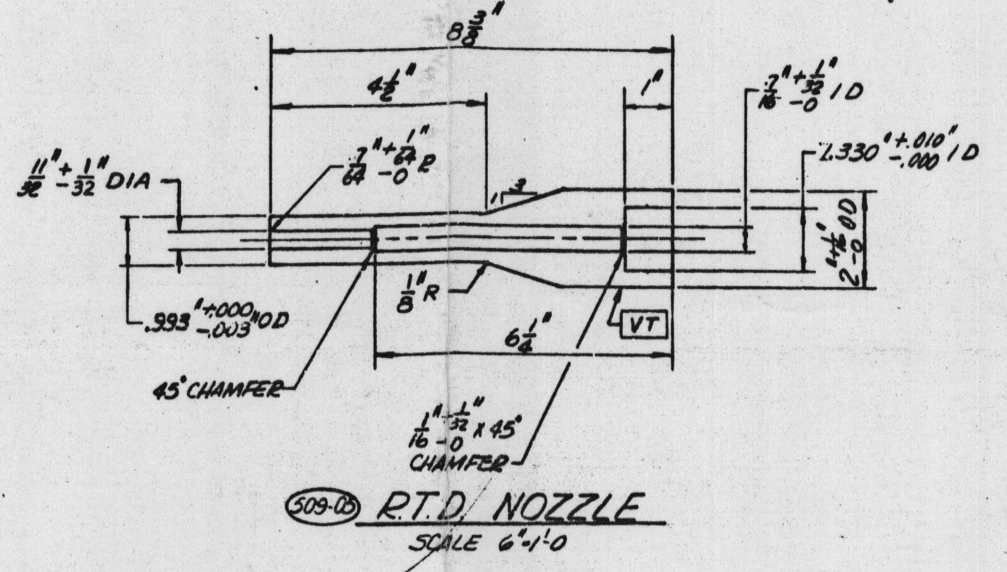
DETAIL B'(B-7) SCALE 12\"/>



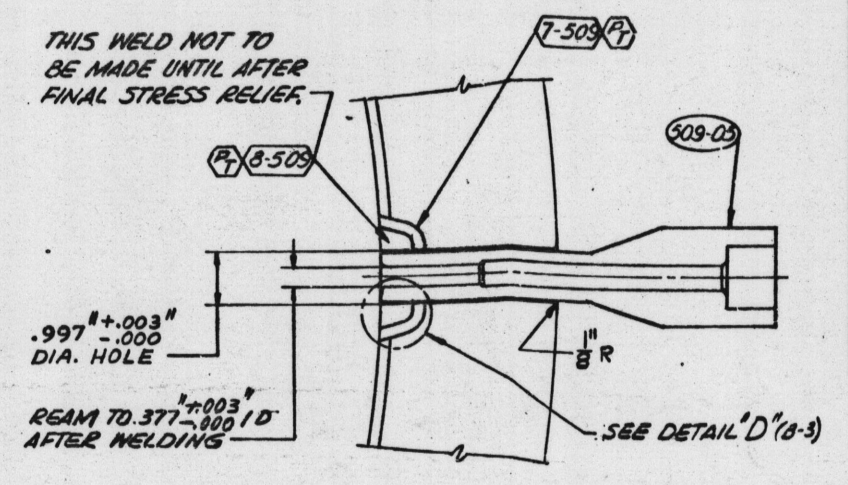
DETAIL C'(C-4) SCALE 8\"/>



DETAIL D'(D-2) SCALE 12\"/>



509-05 R.T.D. NOZZLE SCALE 6\"/>



INSTALLATION OF R.T.D. NOZZLE SCALE 6\"/>

		REVISIONS			
BY	DATE	DESCRIPTION	DATE	APPROVED	
1	L/M D-6	REVISED I.D. FOR PC.# 509-04.			
2	GEN	REVISED PC NO. 509-02 & PC NO. 509-04.			
3	B-5 B-6	ADDED 1/8\"/>			
4	B-5 B-6	REVISED PC NO. 509-04 ADDED WELD NO. 9-508			
5	B-4	ADDED # TO 1/8\"/>			
		WELD 9-508 HAS 9-508			
		PC NO. 509-04 HAS 508-04			
		REVISED DETAIL 'C'			

IMPORTANT: If the shop or fabricator is offered this document, it must be verified that it is a duplicate of the original and not a copy of a copy. All drawings are the property of Combustion Engineering, Inc. and are not to be used for any other purpose without the written consent of Combustion Engineering, Inc. All drawings are the property of Combustion Engineering, Inc. and are not to be used for any other purpose without the written consent of Combustion Engineering, Inc.

TERA APERTURE CARD

509-03-19-3

REV.	NO.	NO.	NO.	NO.	NO.	NO.	NO.
509-03	22	RTD NOZZLE (SEE DETAIL)					
509-04	1	SAFE END 10\"/>	337	38-231	C		
509-04	1	BACKING RING 26\"/>	C-57L	COML			
509-04	1	NOZZLE FORGING (PER DWG #E-230-425)	C-57L	3A-105-GR	B		
509-04	1	SHUTDOWN COOLING OUTLET NOZZLE ASS'Y CONSISTING OF:					

LIST OF MATERIAL - QUANTITIES FOR ONE (1) UNIT

ALL DIMENSIONS APPLY AT REFERENCE TEMP. OF 68°F. SEE REF DWG #2.

FINISH UNLESS NOTED

TOLERANCE ON FRACTIONS 1/16

DECIMALS ±.005

ANGLES ±.05° UNLESS NOTED

CONTRACT 71470

COMBUSTION ENGINEERING, INC. CHATTANOOGA DIVISION

NOZZLE DETAILS SAN ONOFRE II BIDDING

E 235-184 5

GENERAL NOTES

- IN-PROCESS ULTRASONIC EXAMINATION TO BE PERFORMED BEFORE FINAL STRESS RELIEF.
- ASTERISK INDICATES "AS ORDERED" DIMENSIONS FROM MILL.
- ALL CLADDING TO BE "AS DEPOSITED" FINISH, UNLESS NOTED AND A MIN THICKNESS OF 1/8" UNLESS NOTED.

REFERENCE DRAWINGS

NO.	TITLE	DWG NO.
1	STANDARD NOTES	A-288-822
2	MATERIAL NOTES	A-234-823
3	M.P. SPECIFICATIONS	A-234-824
4	WELD PROC ASSIGNMENT SHEET	A-234-825
5	ASSEMBLY	A-235-726
6	WELDING ASSEMBLY	A-235-727
7	FORGING ASSEMBLY	A-235-820

COMBUSTION ENGINEERING, INC. WINDSOR, CONN.

ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED ARE IN INCHES.

UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE TO BE HOLDING DIMENSIONS.

UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE TO BE HOLDING DIMENSIONS.

DWN BY: LARRY EBY

DATE: 6-2-77

CHKD BY: J. H. COLLIER

DATE: 6-1-77

APPR BY: J. H. COLLIER

DATE: 6-1-77

STRESS ENGR: J. H. COLLIER

DATE: 6-1-77

APPROVAL