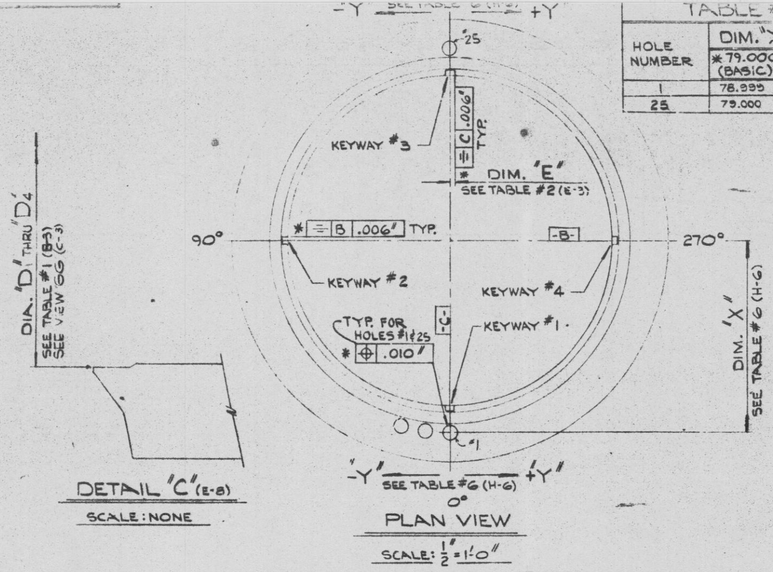
TABLE #6		
HOLE NUMBER	DIM. "X"	DIM. "Y"
	*79.000" (BASIC)	
1	78.995	.000
25	79.000	.000

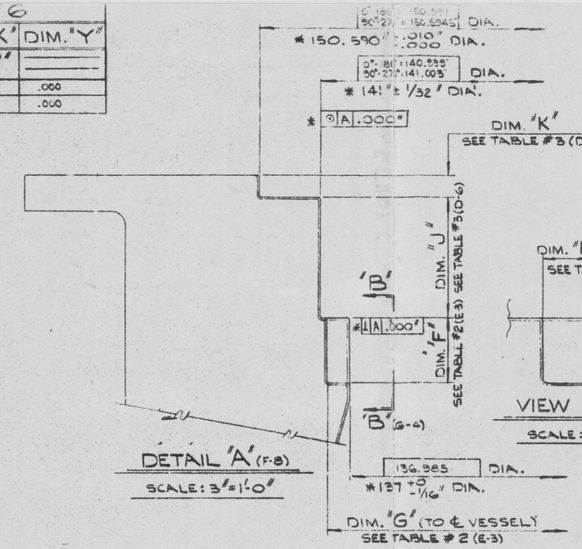


PLAN VIEW

SCALE: 1/2"=1'-0"

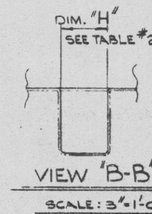
DETAIL 'C' (E-8)

SCALE: NONE



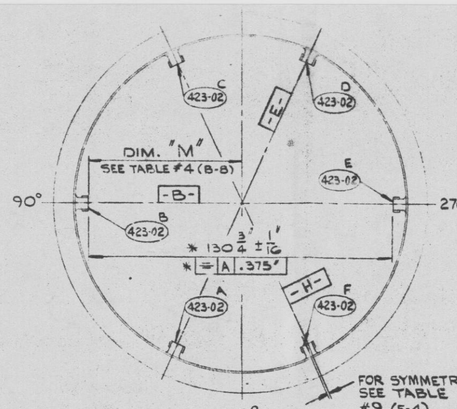
DETAIL 'A' (F-8)

SCALE: 3"=1'-0"



VIEW 'B-B' (G-5)

SCALE: 3"=1'-0"



SECTION 'E-E' (C-6)

SCALE: 1/2"=1'-0"

1	H-6	ADDED TABLE #6		10-30-68
	F-7	REVISED "PLAN VIEW."		T.N.E. 10-9-68
2	GEN.	ADDED DIMENSIONS SHOWN ON FABRICATION DRAWINGS.		T.N.E. 1-23-69
3	GEN.	ADDED VIEW 'H-H', 'G-G' & SECT 'J-J'. ADDED DIM. 'Q' THRU 'S'. ADDED TABLE #7 & 8. ADDED REF. DWG. #5. REVISED TABLE #1. REVISED DIM. 'A', 'B' & 'D'		T.N.E. 6-10-69
4	C-1	ADDED KEY PLAN		T.N.E. 6-10-69
5	D-6	REVISED TABLE #3.		T.N.E. 10-10-69
	B-3	IN TABLE #1, DIM. 'A' WAS 'A', & DELETED DIM. 'A'.		
	F-4	ADDED TABLE #9.		
	G-3	IN SECTION 'E-E', ADDED DATUMS E, H, & B.		T.N.E. 10-10-69
6	C-3	REVISED TABLE #8		T.N.E. 11-27-69
7	GEN.	ADDED AS BUILT DIMENSIONS. DELETED INSPECTION REVISION BLOCK. ADDED NOTES #2, 3, 4 & 5.		2-16-70 8-14-70

TABLE #9			
STATE WHETHER ACTUAL ℄ IS CLOCKWISE OR COUNTER-CLOCKWISE OF THE THEORETICAL ℄ OF LUG.			
PIECE NO.		E, H, B,	AMOUNT OF C.W. OR C.C.W.
423-02 A	⌖	E	.256" C.W. .128"
423-02 B	⌖	B	.360" C.W. .180"
423-02 C	⌖	H	.588" C.W. .294"
423-02 D	⌖	E	.317" C.C.W. .1585"
423-02 E	⌖	B	.370" C.C.W. .185"
423-02 F	⌖	H	.464" C.W. .232"

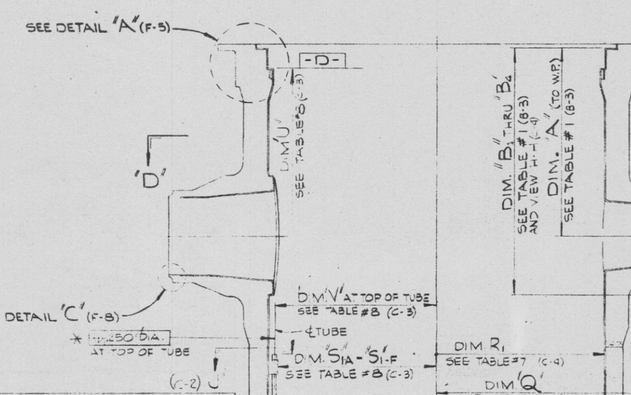
** SEE NOTE N°5

ANSTEC APERTURE CARD

D

9503230040

50-220
9503290007
3/20/95

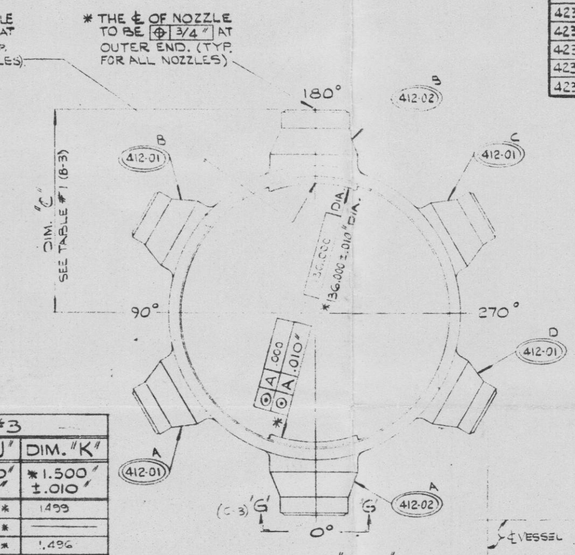


SECTIONAL ELEVATION

SCALE: 1/2"=1'-0"

TABLE #5		
PIECE NUMBER	DIM. "N"	DIM. "P"
	*308 5/8" ± 1/16"	*59 7/8" ± 1/4" TOP / BOTTOM
411-08 A	308 1/16"	59 3/32 / 59 2/32
411-08 B	308 2/32"	59 1/32 / 59 3/32
411-08 C	308 1/16"	59 1/32 / 59 3/32
411-08 D	308 3/32"	59 3/32 / 59 3/32
411-08 E	308 3/16"	58 7/8 / 59 1/32
411-08 F	308 5/8"	59 1/2" / 58 31/32
411-08 G	308 3/16"	59 5/32 / 59 1/32
411-08 H	308 5/8"	58 31/32 / 59 1/2"
411-08 J	308 11/16"	59 1/32 / 59 3/16"

TABLE #4		
PIECE NUMBER	DIM. "L"	DIM. "M"
	*303 5/8" ± 1/32"	TOP / BOTTOM
423-02 A	303 3/16"	65 1/32 / 66 1/32
423-02 B	303 1/32"	65 7/8 / 66 5/8
423-02 C	303 1/32"	65 7/32 / 65 1/32
423-02 D	303 3/16"	65 1/16 / 65 1/32
423-02 E	303 1/32"	65 7/8 / 65 1/32
423-02 F	303 3/16"	65 7/8 / 65 1/32

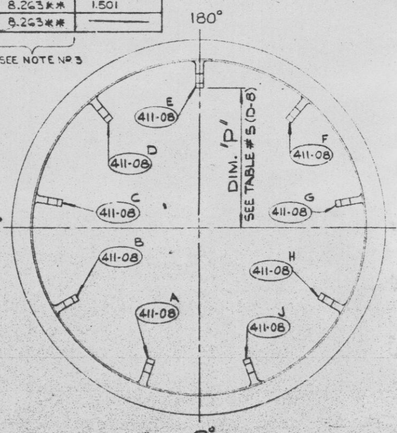


SECTION 'D-D' (E-6)

SCALE: 3/8"=1'-0"

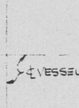
TABLE #3		
LOCATION	DIM. 'J'	DIM. 'K'
	*8.250" ±.005	*1.500" ±.010
J° AXIS	8.262 **	1.499
45° AXIS	8.263 **	—
90° AXIS	8.264 **	1.496
135° AXIS	8.264 **	—
180° AXIS	8.264 **	1.504
225° AXIS	8.263 **	—
270° AXIS	8.263 **	1.501
315° AXIS	8.263 **	—

SEE NOTE N°3



SECTION 'F-F' (B-6)

SCALE: 1/2"=1'-0"



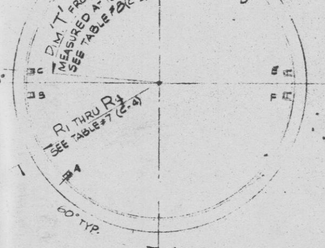
VIEW 'H-H' (E-6)

SCALE ~ NONE

VIEW 'G-G' (D-5)

TYPICAL FOR INLET & OUTLET

SCALE ~ NONE



SECTION 'J-J' (D-8)

SCALE ~ NONE

TABLE #7					
LOCATION	* 70.125" MIN.				
	R1	R2	R3	R4	
0°	70 23/32	70 21/32	70 5/8	70 31/32	
60°	70 1/2	70 17/32	70 3/8	70 7/8	
120°	70 5/16	70 5/8	70 7/32	70 11/16	
180°	70 1/8	70 29/32	70 3/16	70 3/4	
240°	70 5/8	70 11/16	70 11/32	70 11/16	
300°	70 17/32	70 3/4	70 7/16	70 3/4	

TABLE #8									
LOCATION	* 68.132 BASIC		T		* 'U'	V 69.156 BASIC		
	S1	S2	TOP	BOTTOM	BASIC	18 1/2 ± 1/16	R2 TOP	R2 BOTTOM
A	68 3/32	67 31/32	135° 5' 4"	135° 12' 27"	135°	118 7/16	69.312	68.125
B	68 1/16	67 31/32	85° 0' 12"	85° 6' 8"	85°	118 7/16	69.250	68.218
C	68 1/32	68 1/32	84° 59' 38"	84° 53' 38"	85°	118 7/16	69.187	68.234
D	68 1/16	68 1/32	44° 54' 14"	44° 48' 57"	45°	118 3/16	69.250	68.156
E	68 1/16	68 1/32	85° 0' 22"	85° 0' 22"	85°	118 1/16	69.234	69.250
F	68 1/16	68 1/16	84° 58' 27"	84° 52' 40"	75°	118 11/32	69.250	69.343

SEE NOTE N°4

TABLE #1														
ASSEMBLY NUMBER	* 78" BASIC	* 102 5/16 = L				*112" ± 1/16 OUTLET	*110" ± 1/16 INLET	* 32" +1/16 -0 OUTLET * 24" +1/16 -0 INLET				104 1/4 ± 1/16 *	AZIMUTH	
	DIM. 'A'	DIM. B1	DIM. B2	DIM. B3	DIM. B4	DIM. 'C'	DIM. 'C'	DIA. 'D1'	DIA. 'D2'	DIA. 'D3'	DIA. 'D4'	DIM. 'Q'		
412-01 A	78 1/8"	102.333	102.333	102.335	102.334	—	110 1/16"	24.010	24.010	24.010	24.010	104 3/32"	59° 59' 57"	60° BASIC
412-01 B	78"	102.338	102.340	102.341	102.340	—	110 1/16"	24.024	24.023	24.022	24.023	104 1/4"	120° 00' 57"	120° BASIC
412-01 C	77 5/64	102.344	102.344	102.346	102.346	—	110 1/16"	24.012	24.012	24.012	24.012	104 1/4"	240° 02' 47"	240° BASIC
412-01 D	78 1/8"	102.358	102.359	102.358	102.357	—	110 1/16"	24.017	24.017	24.018	24.018	104 3/32"	300° 00' 58"	300° BASIC
412-02 A	77 15/16"	—	—	—	—	112"	—	32.028	32.028	32.028	32.028		359° 58' 36"	0° BASIC
412-02 B	78 1/64"	—	—	—	—	112 1/16"	—	32.012	32.012	32.012	32.012		179° 58' 36"	180° BASIC

C-232-420

CERTIFIED AS CONSTRUCTED BY H.M. Smith DATE 2-16-70

APPROVED
FOR CERTIFICATION AS BUILT DRAWING
SUBJECT TO COMMENTS DATED
MAR 27 1970
BECHTEL & HILL, INC.
SO. BAILTING ENGINEERS
NEW YORK

OFFICE COPY

FT. CALHOUN UNIT 1
CONT. NO. 750

9503230040(1)

ASSY NO.	PC. NO.	NO. REQD.	NOMENCLATURE	MATERIAL	MATERIAL SPEC.
			RECD. JUN 1 1970		

LIST OF MATERIAL — QUANTITIES FOR

GENERAL NOTES
1. ASTERISK (*) DENOTES DIMENSIONS SHOWN ON REFERENCE DRAWINGS #1 THRU #5, AND ARE REFERENCE, DO NOT USE FOR FABRICATION.
2. DOUBLE ASTERISK (**) INDICATES DIMENSION OUT OF TOLERANCE.
3. REPORTED IN MDR-71166-2.
4. REPORTED IN MDR-71166-5.
5. REPORTED IN MDR-71166-6.

REFERENCE DRAWINGS		
NO.	TITLE	DWG. NO.
1	PRESSURE VESSEL WELDING AND MACHINING	E-232-410
2	PRESSURE VESSEL FINAL MACHINING	E-232-413
3	VESSEL SUPPORTS	E-232-414
4	CORE SUPPORT LUGS ASSEMBLY AND DETAILS	E-232-423
5	SURVEILLANCE HOLDER ASSY. AND DETAILS	E-232-551

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GEOMETRIC TOLERANCES FOR MACHINED SURFACES UNLESS SPECIFIED ON FACE OF DRAWING

SYM.	GEOMETRY	TOL.	SYM.	GEOMETRY	TOL.
	FLATNESS	.001/IN.	∠	ANGULARITY	SEE DWG.
	STRAIGHTNESS	.001/IN.	↗	RUNOUT	SEE DWG.
	ROUNDNESS	SEE DWG.	⌖	TRUE POSITION	SEE DWG.
	CYLINDRICITY	SEE DWG.	◎	CONCENTRICITY	.010 TIR
	PROFILE OF LINE	SEE DWG.	⌯	SYMMETRY	SEE DWG.
	PROFILE OF SURFACE	SEE DWG.			
	PARALLELISM	.001/IN.			
	PERPENDICULARITY	.001/IN.			

ALL DIMENSIONS APPLY AT REFERENCE TEMP. OF 68° F.
FINISH UNLESS NOTED
TOLERANCE ON: FRACTIONS DECIMALS ANGLES UNLESS NOTED
CONTRACT 71166

DWN. BY	GARY McCOLLUM	
DATE	7-3-68	
CKD. BY	WE O	
DATE	8-5-68	
APPD. BY	[illegible]	
DATE	8-5-68	
ENGR.		

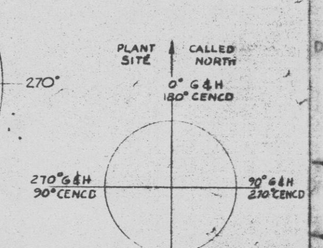
COMBUSTION ENGINEERING, INC. CHATTANOOGA DIVISION

PRESSURE VESSEL 'AS-BUILT' DIMENSIONS

FOR: OMAHA POWER 140" I.D. PWR

SIZE F | 232-426

SCALE (SIZE F) | WEIGHT | SHEET



KEY PLAN
(FOR CUSTOMER USE ONLY)
SCALE IN ONE