

ATTACHMENT 8.3

**MODIFICATION DRAWING 107E5679
REV. 7 AND PARTS LIST 107E5679
REV. 5**

9608210139 960814
PDR ADOCK 05000220
PDR





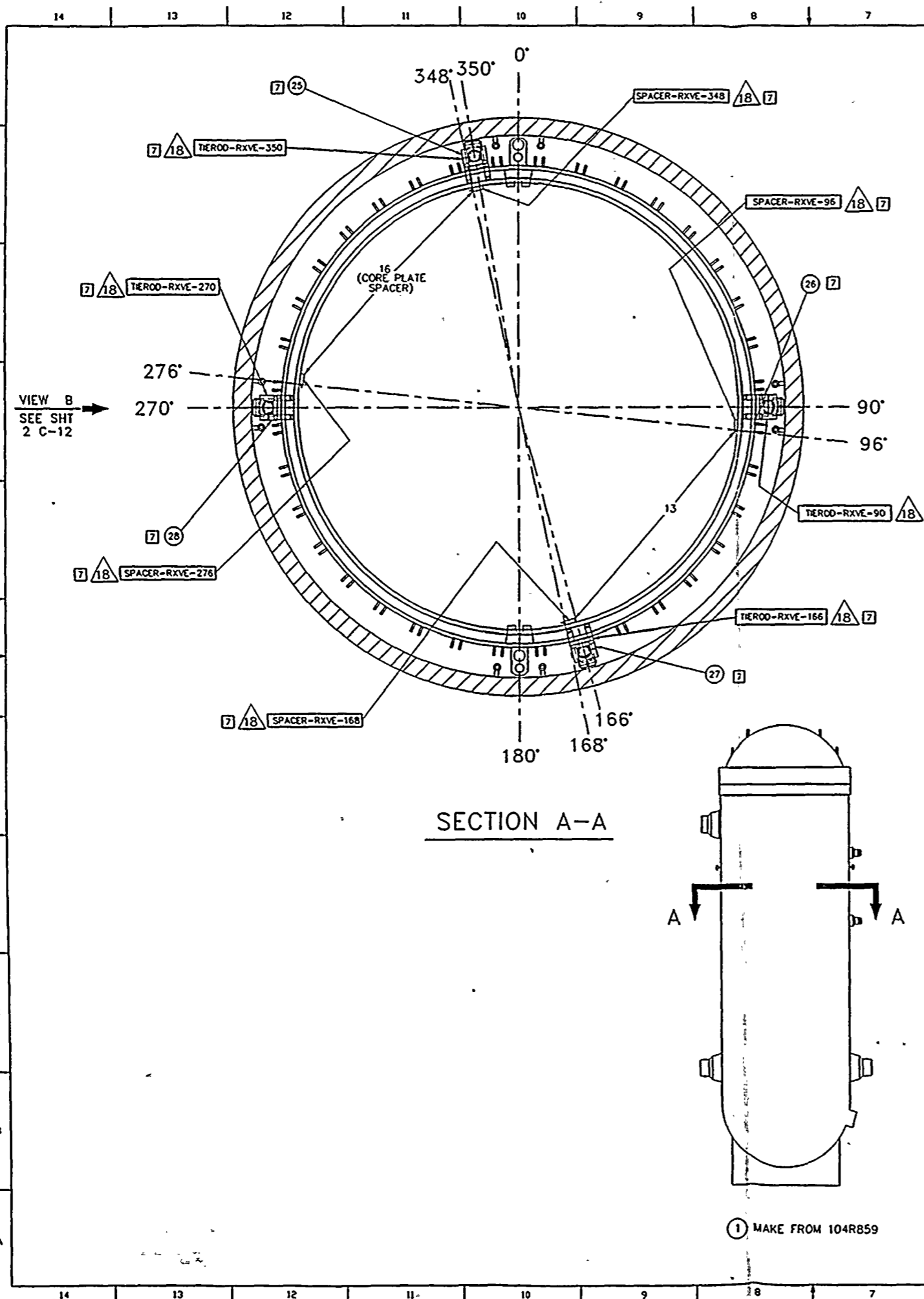


GE Nuclear Energy

TITLE: REACTOR		General Electric Company, San Jose, California 95125										PL 107E5679		SECT A	REV 05
ITEM NO.	A L T	DOCUMENT TYPE	DESCRIPTION		DOC STA	E C	GROUP NUMBER AND QUANTITY					U/M	SRC	ACTION	
			NAME	IDENTIFICATION			G001	G002	G003	G004	G005				
001			ASSEMBLY		ASM		X								
002		ASSEMBLY	UPPER SUPPORT	112D6573G001		P	DLT	1	1	1	1			CHANGED	
003		ASSEMBLY	UPPER SPRING	112D6574G001		P	DLT	1	1	1	1			CHANGED	
004							DLT							DELETED	
005		ASSEMBLY	MID SUPPORT	112D6575G001		P	DLT	1	1	1	1			CHANGED	
006		ASSEMBLY	LOWER SUPPORT	112D6576G001		P	DLT	1	1	1	1			CHANGED	
007		DETAIL DWG	NUT, TIE ROD	112D6548P001		P	DLT	1	1	1	1			CHANGED	
008							DLT	DLT						DELETED	
009							DLT							DELETED	
010		DETAIL DWG	TOP SUPPORT	112D6588P001		P	DLT	1	1	1	1			CHANGED	
013		ASSEMBLY	CLAMP/SPACER	112D6618G001		P	DLT		1	1				CHANGED	
014		MATL SPEC	THREAD LUBRICANT	D50YPSB			DLT	AR	AR	AR	AR			CHANGED	
015		ASSEMBLY	TIE ROD/SPRING	112D6546G001		P I	DLT	1	1	1				CHANGED	
		ASSEMBLY	TIE ROD/SPRING	112D6546G002		P I					1				
016		ASSEMBLY	CLAMP/SPACER	112D6618G002		P	DLT	1			1			CHANGED	
017							DLT							DELETED	
018		DETAIL DWG	SPACER	262B1285P001		P	DLT	AR	AR	AR	AR			CHANGED	
019		DETAIL DWG	SPACER	262B1285P002		P	DLT	AR	AR	AR	AR			CHANGED	
020		DETAIL DWG	SPACER	262B1285P003		P	DLT	AR	AR	AR	AR			CHANGED	
021							DLT							DELETED	
022							DLT							DELETED	
023							DLT							DELETED	
024		DETAIL DWG	BOTTOM SPRING SPACER	148C6912P001		P I		1	1	1				CHANGED	
025		ASSEMBLY	REACTOR	107E5679G002		P	1							ADDED	
			ASSEMBLY		ASM			X						CHANGED	
MADE BY		YR		DATE	DAY	CONT ON SHEET			SH NO	PL 107E5679			SECT	REV	
EDP		96		08	01	LAST ITEM NO. USED - 028			3	2	A			05	







- NOTES:
- UNLESS OTHERWISE SPECIFIED ALL DIMENSION ARE IN INCHES.
 - LUBRICATE THREADS INSTALLED HEREIN WITH ITEM 14.
 - FOR ADDITIONAL INSTALLATION REQUIREMENTS SEE INSTALLATION SPECIFICATION 25A5585.
 - MEASURE WTDH AT INDICATED ELEVATION. MACHINE PER VIEW K-K TO PRODUCE .01 MIN SPRING COMPRESSION.
 - MEASURE ANNULUS WTDH, U1 AND U2 AT INDICATED ELEVATIONS. MACHINE PER DETAIL Z AND C.
 - TORQUE TIE ROD NUT, ITEM 7, TO 175 ± 15 FT-LBS.
 - ADJUST JACKING SCREW TO PROVIDE 0.07 ± 0.02 SPRING COMPRESSION (8 ± 2 TURNS AFTER CONTACTING VESSEL WALL).
 - AFTER INSTALLATION OF LOWER SUPPORT ASSEMBLY, 11205676, MEASURE DISTANCE V AT THE MID SUPPORT.
 - PRIOR TO REMOVAL OF THE SHROUD HEAD, SCRIBE DATUM \square -A- LINE ON VERTICAL SURFACES OF SHROUD AND SHROUD HEAD AS SHOWN.
 - TORQUE TOGGLE BOLTS TO 40 ± 5 FT-LBS. TORQUE LOCK NUT TO 30 ± 10 FT-LBS. THEN CRIMP THE NUT RETAINER INTO GROOVES OF TOGGLE BOLT. VISUALLY EXAMINE TO CONFIRM THAT CRIMP HAS OCCURED.
 - THE INDICATED DIMENSION OR REQUIREMENT MAY BE VERIFIED BY QUALIFICATION OF THE INSTALLATION TOOLING AND PROCEDURES IN MOCK-UP TESTING.
 - SIZE TOLERANCE OF SLOTS APPLIES AT INSIDE SURFACE OF SHROUD HEAD FLANGE. TO ACCOMODATE SLOT TAPER, TOLERANCE MAY BE INCREASED LINEARLY TO 50% GREATER AT OUTSIDE SURFACE OF SHROUD HEAD FLANGE.
 - POSITION AND SIZE TO BE DEFINED BY CONTROL TOOLING AND QUALIFIED PROCESS CONTROL.
 - SEPARATE PARTS LIST IDENTIFIED AS PL107E5679.
 - THE AS-INSTALLED LOWER CONTACT ON THE LOWER SPRING DOES NOT ENCOMPASS SHROUD WELD H6A, AS WAS INTENDED BY DESIGN. MODIFICATIONS AS SHOWN IN VIEW "M" WERE MADE TO CAPTURE WELD H6A.
 - HOLES AT THE 90° - 166° AND 270° AZIMUTHS WERE HONED TO 4.11" DIAMETER.
 - THE UPPER BRACKET ASSEMBLY AT THE 166° AZIMUTH IS NOT CENTERED BETWEEN THE SHROUD HEAD BOLT LUGS, IT STRADDLES THE LUGS AS SHOWN IN FDDR EA1 - 0021.
 - CUSTOMER (NMPC) "EPN" EQUIPMENT PIECE NUMBER.

REV	STATUS	REVISIONS
1	A	PRELIMINARY
2	T	ISSUE
3	T	10 DEC 1994
4	T	P.E. PANSOY
5	T	26 JAN 1995
6	T	M. MONTOTA
7	T	7 FEB 1995
8	T	R. GODFREY
9	T	7 JAN 1995
10	T	P.E. PANSOY
11	T	9 OCT 1995
12	T	J. DUM
13	T	ADD 01 02A
14	T	END CHANG

107E5679

ANSTEAG
APERTURE CARD

Also Available on
Aperture Card

9608210139-01

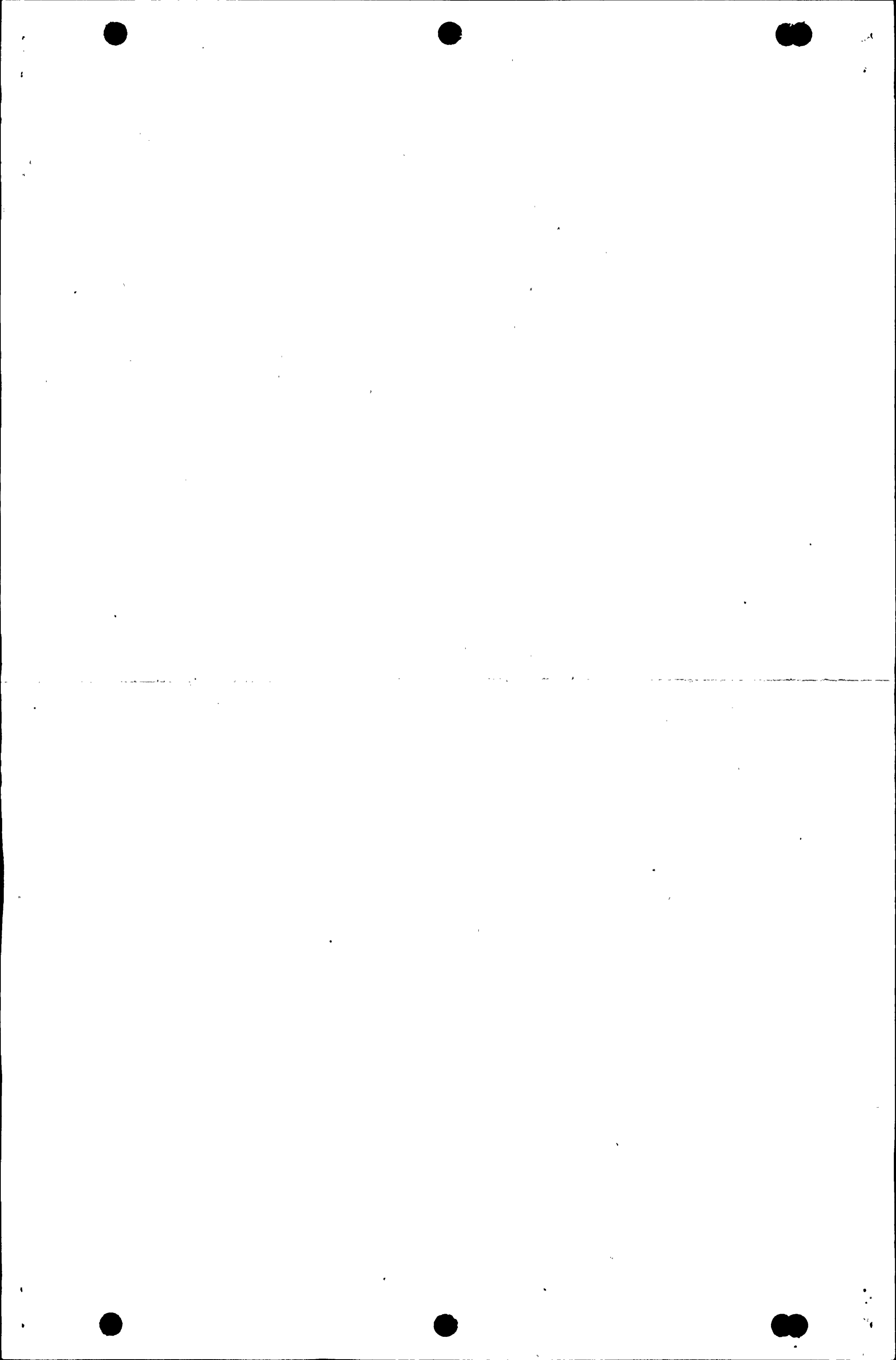
PL ISSUED

SIGNATURES	DATE	REVISION
E. PATSTON	10/11/94	1
J. GLEASON	10/11/94	2
M. MONTOTA	10/11/94	3
P. PANSOY	10/11/94	4
J. GLEASON	10/11/94	5

UNLESS OTHERWISE SPECIFIED
TOLERANCES ON:
2 PLACE DECIMALS & FRACTIONS &
3 PLACE DECIMALS & ANGLES &

FOR THIS UNIT:
10 NOV 1994
107E5679
REV 7

AC-94669H 1100C



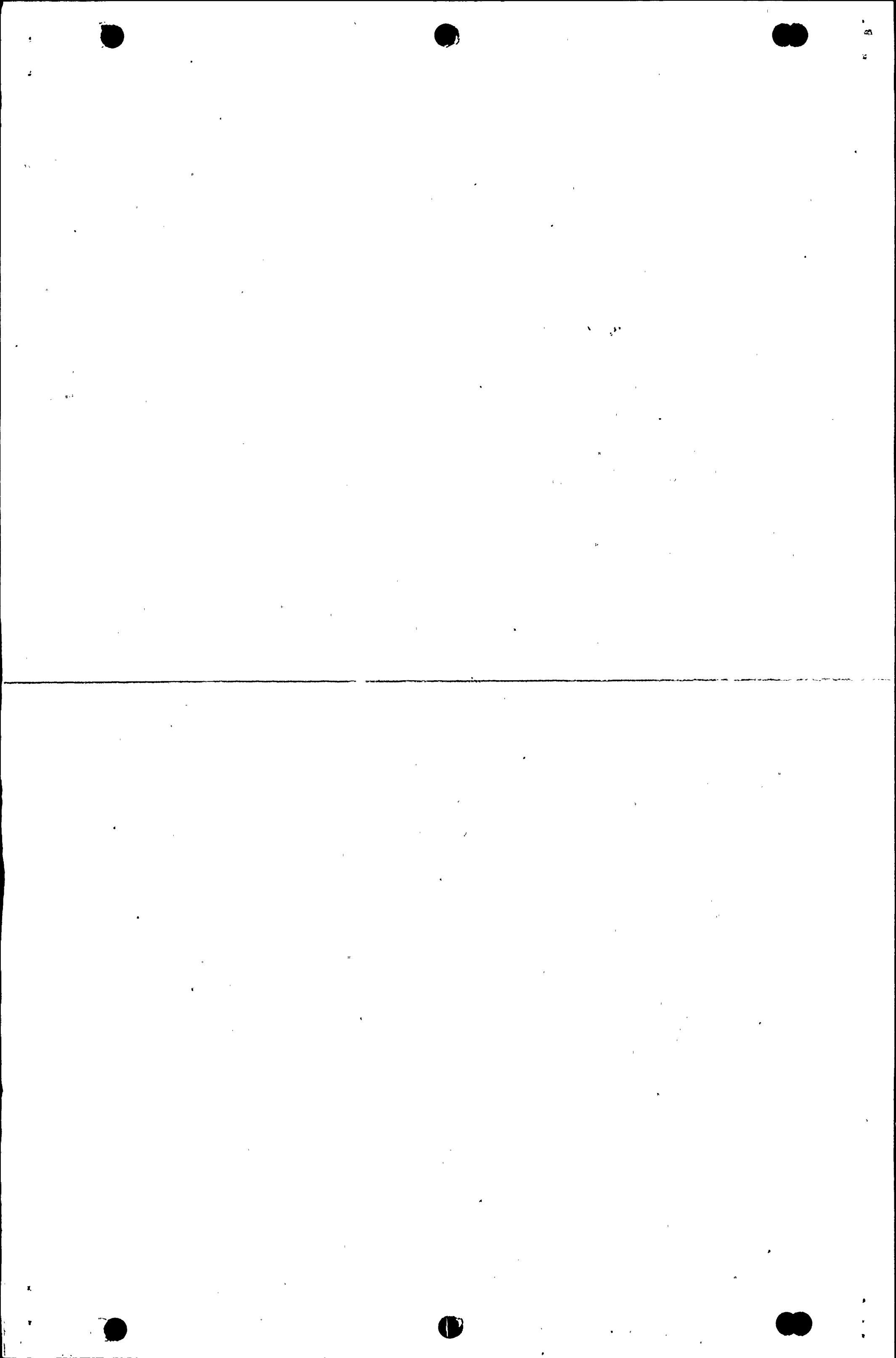
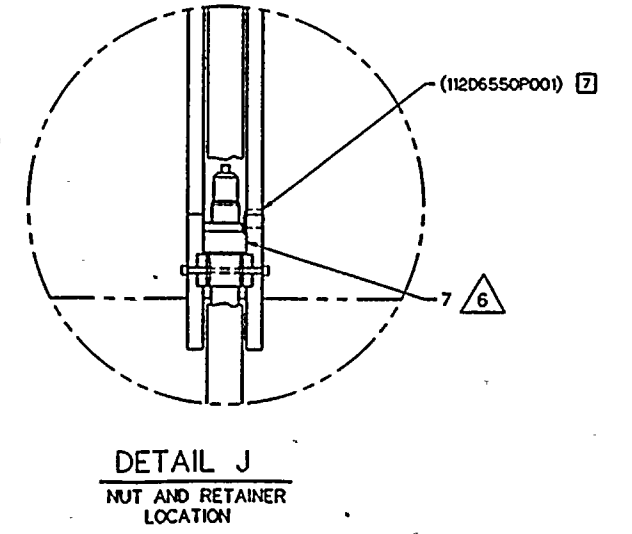
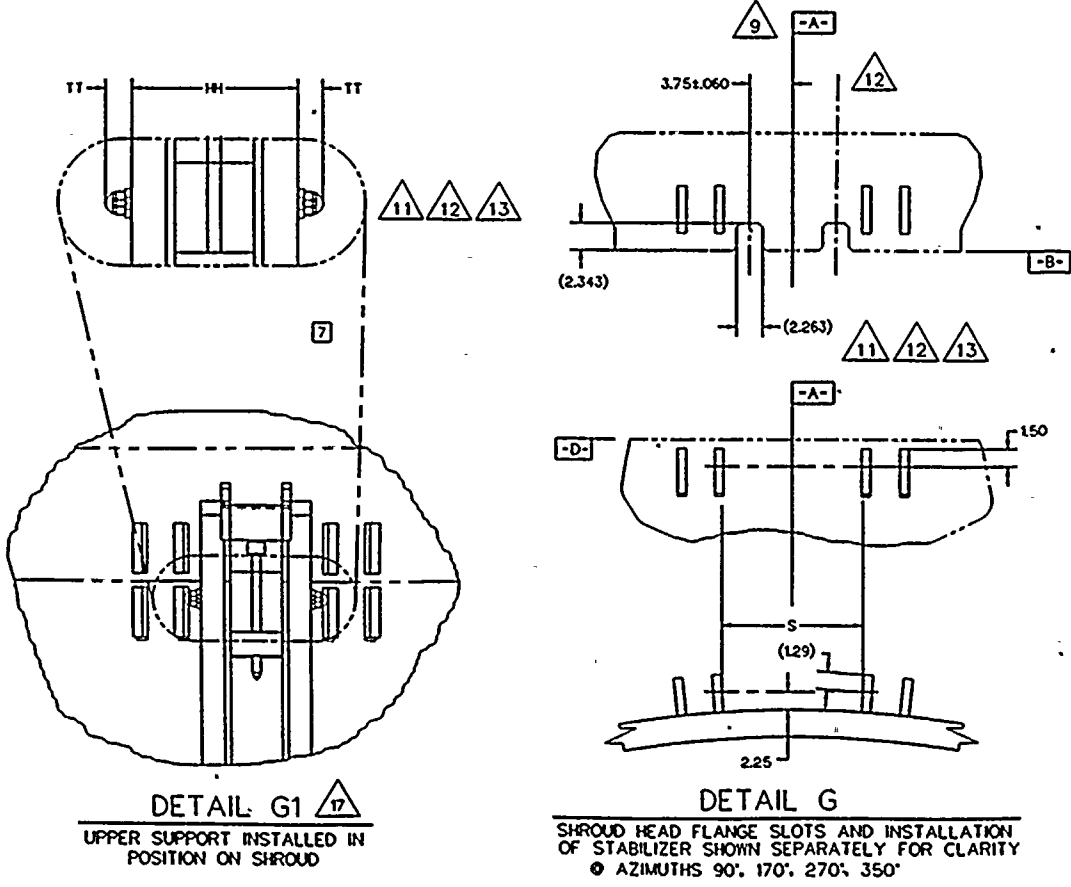
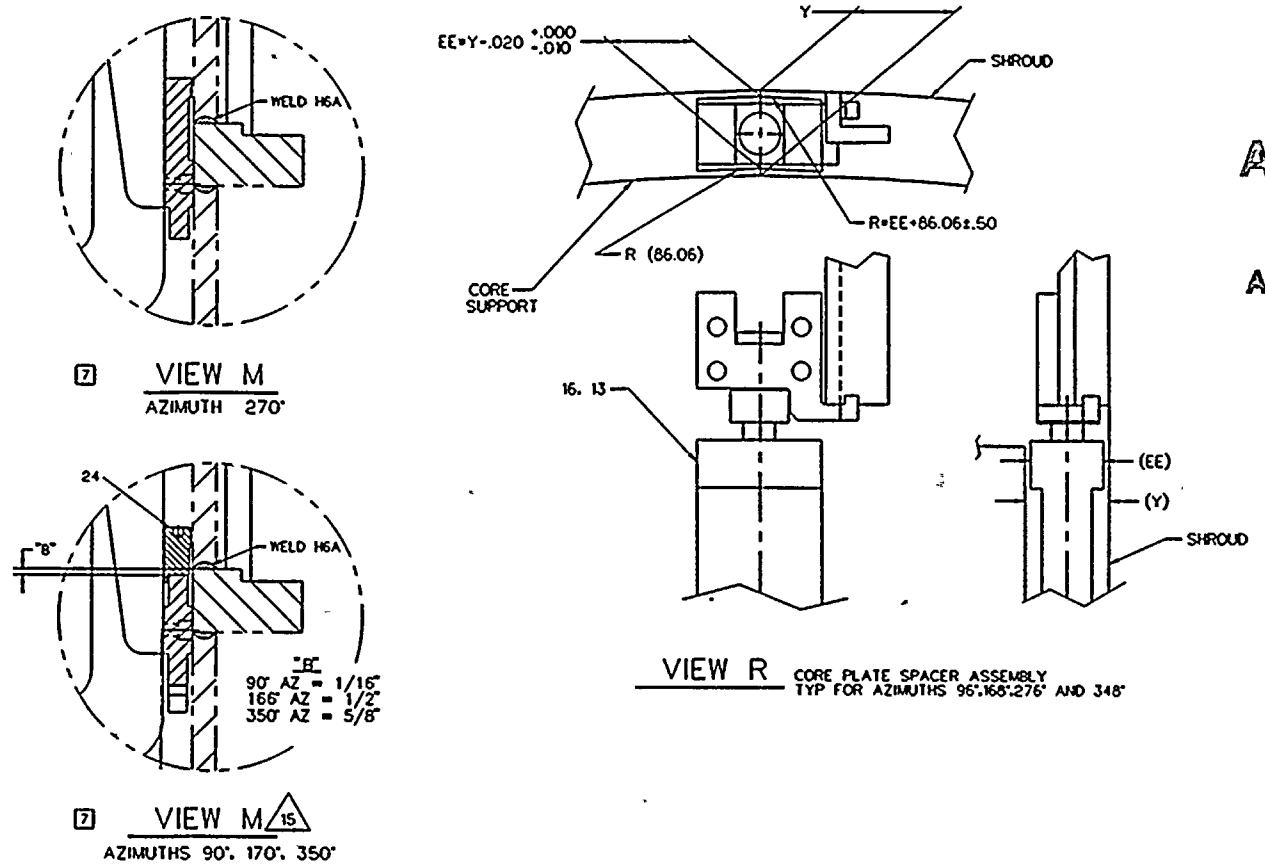


TABLE 1						
AZIMUTH	ITEM # - DET Z	AS MEASURED U2	DD=U2-1100±.010	AS MACHINED DD	SERIAL #	
90°	(112D6577) - DET Z	11.6904	DD=0.690	0.690	1	
166°	(112D6577) - DET Z	12.148	DD=1.148	1.148	2	
270°	(112D6577) - DET Z	11.834	DD=0.834	0.834	3	
350°	(112D6577) - DET Z	11.908	DD=0.908	0.908	4	
AZIMUTH	ITEM # - DET D	AS MEASURED V	BB=V+.25±.01	AS MACHINED BB	SERIAL #	
90°	5 - DET D	4.698	BB=4.948	4.948	1	
166°	5 - DET D	5.389	BB=NA	FDDR EA1-0029	5	
270°	5 - DET D	4.961	BB=5.211	5.211	3	
350°	5 - DET D	5.106	BB=NA	FDDR EA1-0029	2	
AZIMUTH	ITEM # - VIEW K-K	AS MEASURED W1-W2	CC=W1-W2+.121 +.010/-0.000	AS MACHINED CC	SERIAL #	
90°	(112D6570) - VIEW K-K	FDDR EA1-0017	CC=NA	16.847	1	
166°	(112D6570) - VIEW K-K	FDDR EA1-0017	CC=NA	16.848	2	
270°	(112D6570) - VIEW K-K	FDDR EA1-0027	CC=NA	16.825	4	
AZIMUTH	ITEM # - VIEW R	AS MEASURED Y	EE=Y-.020 +.000/-0.010	AS MACHINED EE	SERIAL #	
96°	13 VIEW R	2.0312	EE=2.011	2.011	1	
168°	13 VIEW R	1.969	EE=1.949	1.948	2	
276°	16 VIEW R	1.797	EE=1.777	1.776	3	
348°	16 VIEW R	2.125	EE=2.105	2.104	4	
AZIMUTH	ITEM # - VIEW S	AS MEASURED X	AS MEASURED X1	SERIAL #		SHIM THICKNESS = X-X1-2.75±.25
90°	18,19,20 - VIEW S	190.766	185.487	2.529	NA	
166°	18,19,20 - VIEW S	190.963	185.500	2.712	NA	
270°	18,19,20 - VIEW S	190.281	185.395	2.136	NA	
350°	18,19,20 - VIEW S	191.250	185.405	3.095	NA	
AZIMUTH	ITEM # - DET C	AS MEASURED UI	AA=±.261	AS MACHINED AA	SERIAL #	
90°	(112D6565) - DET C	FDDR EA1-0028	AA=2.786	2.589	6	
166°	(112D6565) - DET C	FDDR EA1-0028	AA=2.155	2.159	1	
270°	(112D6565) - DET C	FDDR EA1-0028	AA=2.399	2.259	5	
350°	(112D6565) - DET C	FDDR EA1-0028	AA=2.051	2.055	3	
AZIMUTH	ITEM # - DET G&G1	AS MEASURED S	AS MEASURED H	TT = .5*(S+.004-H) -.015±.003	SERIAL #	
90°	(262B1286) - DET G&G1	FDDR	EA1-0026	1.6710	NA	
166°	(262B1286) - DET G&G1	FDDR	EA1-0021	0.723	NA	
270°	(262B1286) - DET G&G1	FDDR	EA1-0026	1.6439	NA	
350°	(262B1286) - DET G&G1	FDDR	EA1-0026	1.686	NA	

107E5679	3
REVISED	
PRELIMINARY	
ISSUE	
1	REV-01371
2	CHG2038
3	CHG2123
4	CHG2173
5	CHG2583
6	CHG3150
7	CHG3778 RD 01 02



ANSTEC
APERTURE
CARD

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9608210139-03

107E5679	7
REVISED	
PRELIMINARY	
ISSUE	
1	REV-01371
2	CHG2038
3	CHG2123
4	CHG2173
5	CHG2583
6	CHG3150
7	CHG3778 RD 01 02

