

REV	DESCRIPTION	DATE	APPROVED
1	A-0 REVISED WELD TABULATION F-6 ADDED WELD NO. 3-988 G-8 DELETED RT FROM WELD NO. 2-988 E-1 ADDED 1/2" E-5 G-2 ADDED 1/2" E-3 ADDED MIN. TO 2 3/4" DIM. E-4 ADDED (REF) G-4 E-2 ADDED 25" (TYP) E-2 ADDED 3" DIM. E-5 ADDED 5 3/4" DIM. E-3 ADDED 3 3/8" ± 1/2" DIM. E-3 REVISED NOTE	L.T. 12/11/68 L.A.R. 12/11/68	
2	H-4 ADDED 14 3/32" DIA. & 2 1/16" DIA HOLE H-8 DELETED WELD #1-989 & ADDED PC # 989-30 TO DETAIL "F" ADDED VIEW "U-U" G-4 G-6 ADDED 2" DIA HOLE & 6" DIM. B-8 ADDED VIEW "X-X" D-7 LIM ADDED PC # 989-30, 990-23, 990-19 & 990-20 ADDED NOTES NO. 5 & 6	L.T. 12/11/68 L.A.R. 12/11/68	
3	G-4 ADDED 20 3/16" (REF) E-3 1 1/8" N/A 1/2" G-2 A-5 REVISED HOLE LOCATION IN SUPPORT RING	L.T. 12/11/68 L.A.R. 12/11/68	
4	A-5 ROTATED KEYWAYS 25" IN VIEW "B-B"	L.T. 12/11/68 L.A.R. 12/11/68	

SEP 10 1968

DISTRIBUTION

1 ORIGINAL
1 ASSEMBLY
1 SHOP
1 OFFICE
1 ARCHIVE

APPROVED BY: [Signature]

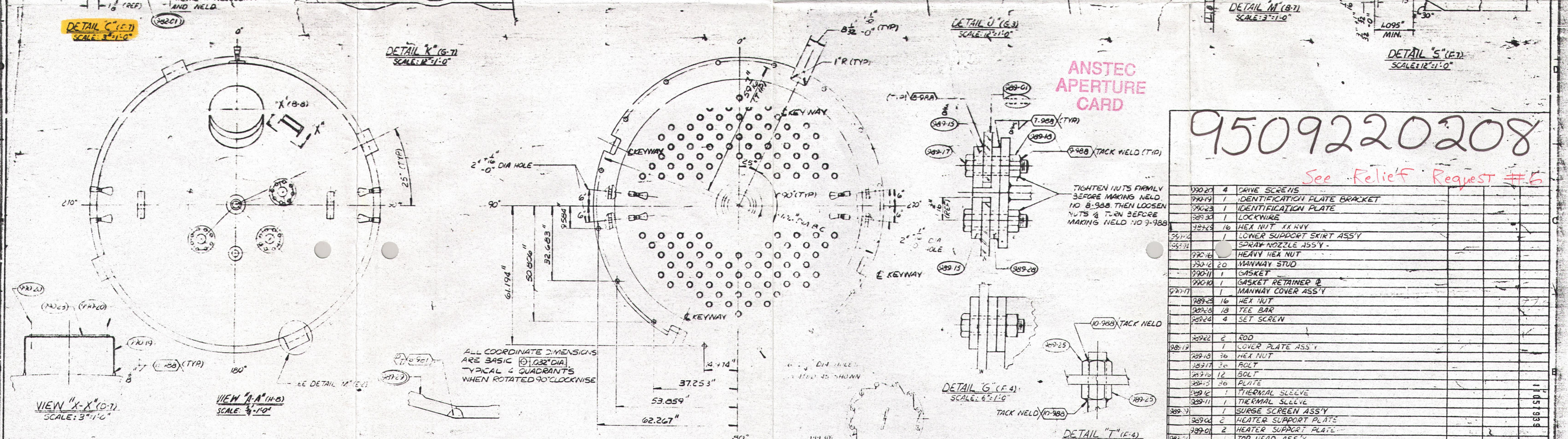
DESIGNED BY: [Signature]

CHECKED BY: [Signature]

DATE: 9/10/68

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

CONSUMERS POWER CO.



9509220208

See Relief Request #5

QTY	DESCRIPTION	UNIT
4	DRIVE SCREWS	
1	IDENTIFICATION PLATE BRACKET	
1	IDENTIFICATION PLATE	
1	LOCKWIRE	
16	HEX NUT X-HVY	
1	LOWER SUPPORT SKIRT ASSY	
1	SPRAY NOZZLE ASSY	
1	HEAVY HEX NUT	
20	MANWAY STUD	
1	GASKET	
1	GASKET RETAINER	
1	MANWAY COVER ASSY	
16	HEX NUT	
18	TEE BAR	
4	SET SCREEN	
2	ROD	
1	COVER PLATE ASSY	
36	HEX NUT	
30	BOLT	
12	BOLT	
30	PLATE	
1	THERMAL SLEEVE	
1	THERMAL SLEEVE	
1	SURGE SCREEN ASSY	
2	HEATER SUPPORT PLATE	
2	HEATER SUPPORT PLATE	
1	TOP HEAD ASSY	
1	SHELL & BOTTOM HEAD ASSY	
1	VESSEL ASSEMBLY CONSISTING OF:	

WELD TABULATION

WELD NO.	DETAIL	WELD PROC.
1-988	NA 2966-988	304
2-988	NA 2966-988	304
3-988	NA 2966-988	304
4-988	NA 2966-988	304
5-988	NA 2966-988	304
6-988	NA 2966-988	304
7-988	NA 2966-988	304
8-988	NA 2966-988	304
9-988	NA 2966-988	304
10-988	NA 2966-988	304
11-988	NA 2966-988	304

HEAT STACK GRAY PAINT # 33-E-102.
6. STENCIL WARNING - DO NOT BURN,
WELD, CHIP, GRIND OR ALLOW ARC
STRIKES ON THIS VESSEL IN 2" HIGH
LETTERS WITH RED HEAT RESISTANT
PAINT (GILMAN LS-937 OR EQUAL) AT
PLACES SHOWN. STAGGER ROWS
AT APPROX. 45°

GENERAL NOTES

- FOR STANDARD NOTES, SEE REF DWG. NO. B.
- REFERENCE DIMENSIONS ARE FOR INFORMATION ONLY. DO NOT USE FOR FABRICATION.
- THERMAL SLEEVES TO BE EXPANDED IN NOZZLES ACCORDANCE WITH MED SPEC. (16g.)
- ALL FABRICATION SHALL BE IN ACCORDANCE WITH A.S.M.E. CODE SECTION III.
- PAIN ALL CARBON STEEL SURFACES EXCEPT BOTTOM OF BASE RING AND 3" FROM ENDS OF NOZZLES WITH ONE COAT OF GILMAN HIGH

REFERENCE DRAWINGS

NO.	TITLE	DWG. NO.
10	SPRAY NOZZLE PERMANENT INSTALLATION	E-231-379
11	HEATER ARRANGEMENT & DETAILS	E-231-387

REFERENCE DRAWINGS

NO.	TITLE	DWG. NO.
1	WELDING SYMBOLS & WELDING	E-231-982
2	WELDING SYMBOLS & WELDING	E-231-983
3	WELDING SYMBOLS & WELDING	E-231-984
4	WELDING SYMBOLS & WELDING	E-231-985
5	WELDING SYMBOLS & WELDING	E-231-986
6	WELDING SYMBOLS & WELDING	E-231-987
7	WELDING SYMBOLS & WELDING	E-231-988
8	WELDING SYMBOLS & WELDING	E-231-989

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GEOMETRIC TOLERANCES UNLESS SPECIFIED ON FACE OF DRAWING

SYMBOL	GEOMETRY	TOLERANCE
—	FLAT & STRAIGHT	.001
⊥	PERPENDICULARITY	.001 IN
∥	PARALLELISM	.001 IN
∠	ANGULARITY	SEE DWG.
⊘	SYMMETRY	SEE DWG.
⊙	TRUE POSITION	SEE DWG.
⊖	CONCENTRICITY	.010 TIR
⊕	ROUNDNESS	SIZE F30

ALL DIMENSIONS APPLY AT REFERENCE TEMP OF 68° F. SEE NOTE 7. FINISH UNLESS NOTED.

TOLERANCE ON FRACTIONS 1/16 DECIMALS 1/10 ANGLES 10-30 UNL. IS NOTED

OWN BY: LEE TADE
DATE: 8-27-68
CHKD BY: [Signature]
DATE: 8-27-68
APPD BY: [Signature]
DATE: 8-27-68
STRESS ENGR: [Signature]
DATE: 8-27-68

COMBUSTION ENGINEERING, INC.
CHATTANOOGA DIVISION

VESSEL ASSEMBLY & FINAL MACHINING

CONSUMERS POWER PRESSURIZER

APPROVED: [Signature] DATE: 8-27-68

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

WEIGHT: 11.5 LBS

CONTRACT: 231-68

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