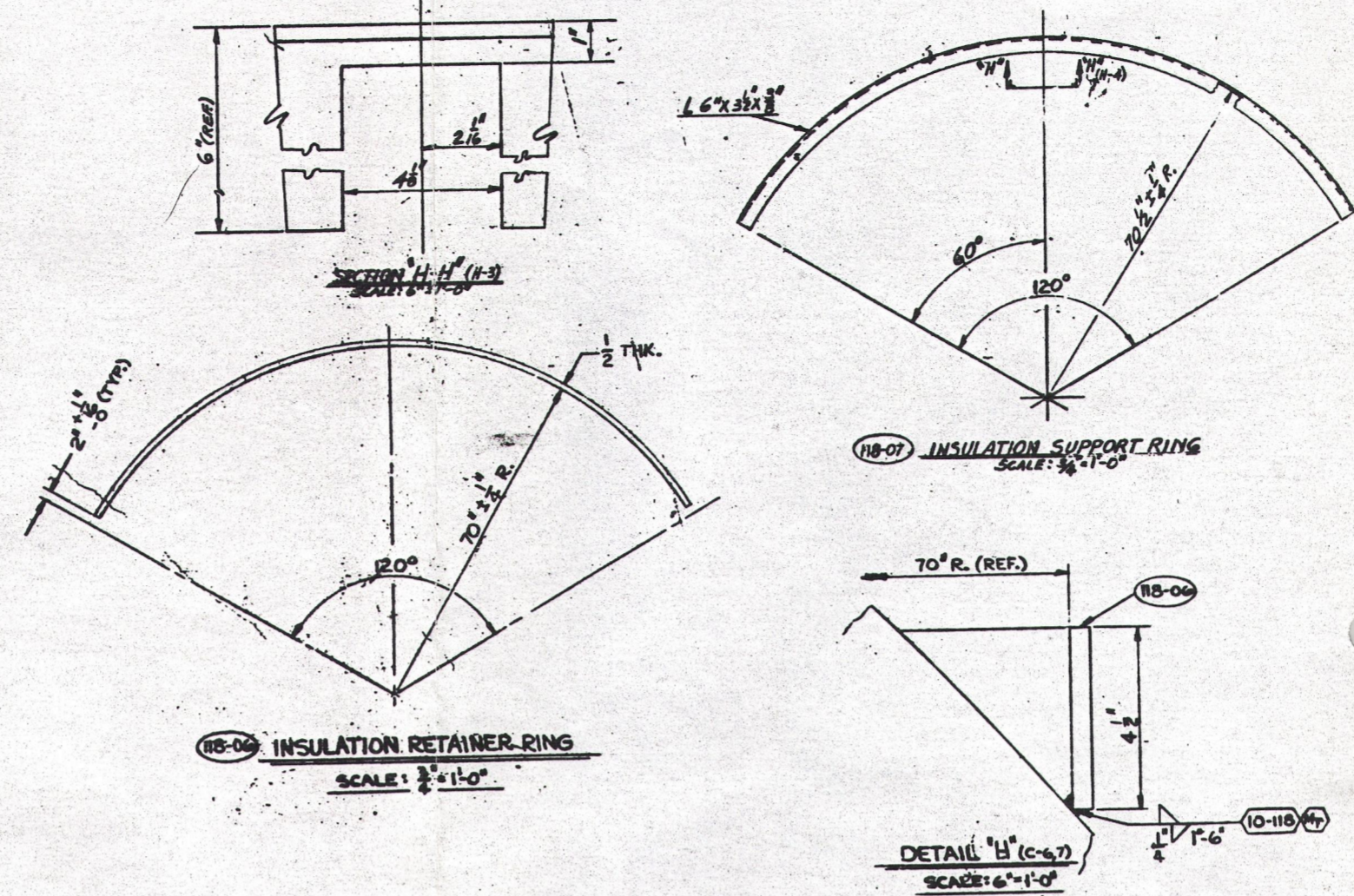
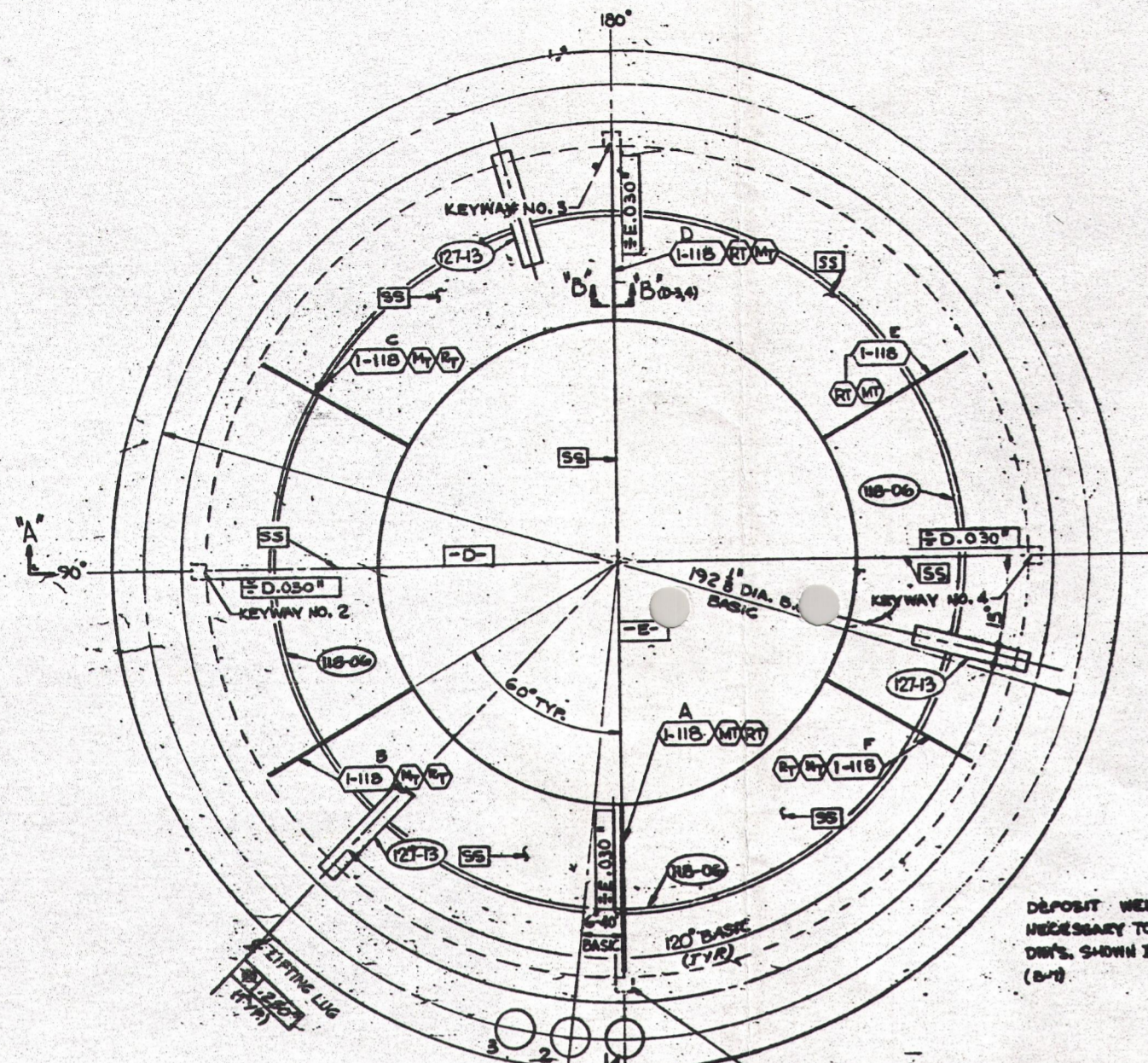


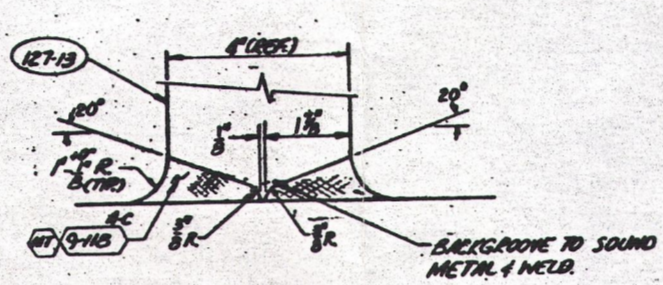
REV. NO.	DESCRIPTION	DATE	APPROVED
1	B-3 REVISED WELD NO'S. IN DETAIL 'E'. A-3 2-118 A-C WAS 2-118 A-D, 4-118 A-G WAS 4-118 A-B; AND ADDED B-118 A, B IN WELD TABULATION. C-D-4 REVISED (A) NOTE AND DELETED DIM LINES	JUL 2 1966	J.S. 5-64
2	C-3-48 REVISED KEYWAY AT VIEW 'F-F' DETAIL 'F'	JUL 7 1966	CM 7-20-66
3	E-4-11 ADDED SECT. 'G-G' (C. NO. 127-11) RELATED TO C-8 (DIMENSIONS)	JUL 11 1966	AT 7-11-66
4	C-3 KEY SIZES OF RETAINERS #1123	FEB 26 1966	AT 2-26-66
5	D-7 B6 WAS 69' C-8 60' WAS 60 1/2' G-8 ROTATED PC #127-13 15° D-4 REVISED DETAIL 'F'	JUL 26 1966	AT 7-26-66
6	E-7 7 1/2" DIA. WAS 7 1/4" GEN. ADDED PC #118-06 F-3 ADDED DETAIL 'H' A-7 ADDED NOTE #8	JUL 27 1966	T.M.F. 8-17-67
7	C-D-4 ADDED 166 3/16" DIA. & 150 1/4" DIA. E-7-8 REVISED NOTE	JUL 27 1966	T.M.F. 8-17-67
8	E-7 ADDED 'BASIC' TO 120° TYP. DIM. E-8 ADDED NOTE AND TRUE POS. TOL. E-9 REVISED SECTION 'G-G'	JUL 27 1966	T.M.F. 8-17-67
9	G-3 ADDED PINS 118-07 & 118-08	JUL 27 1966	T.M.F. 8-17-67



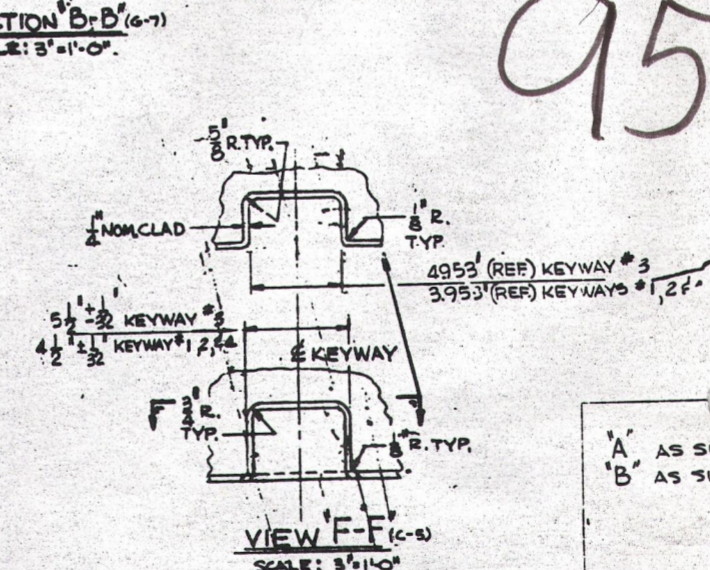
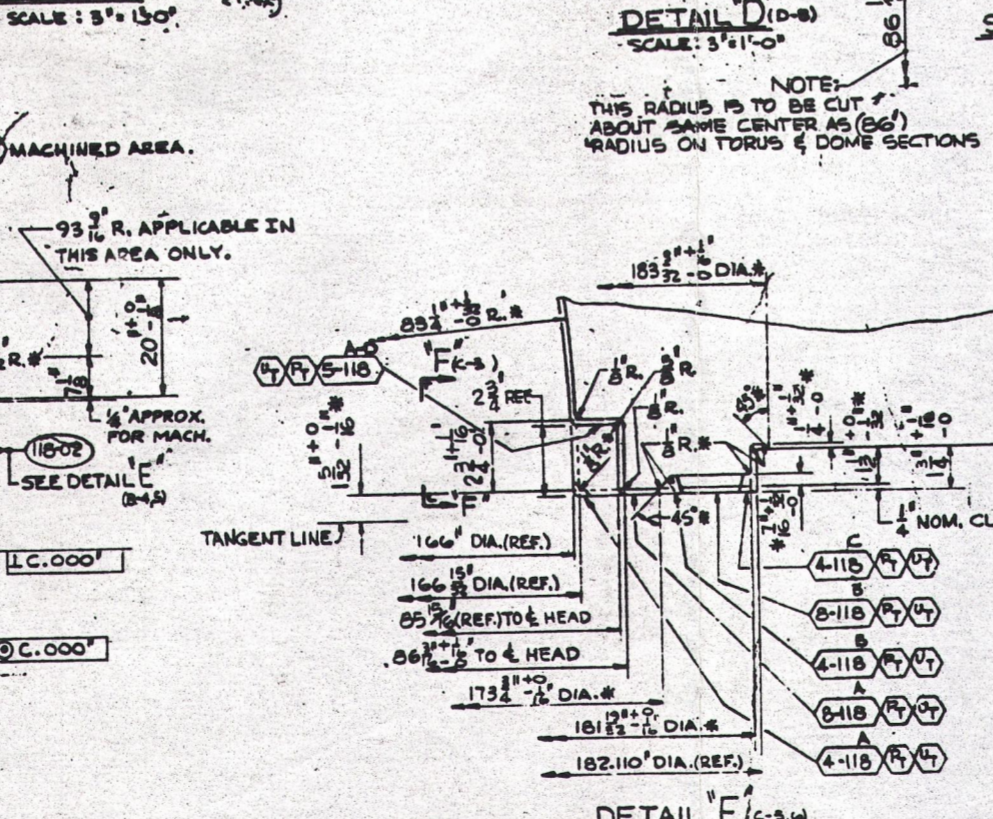
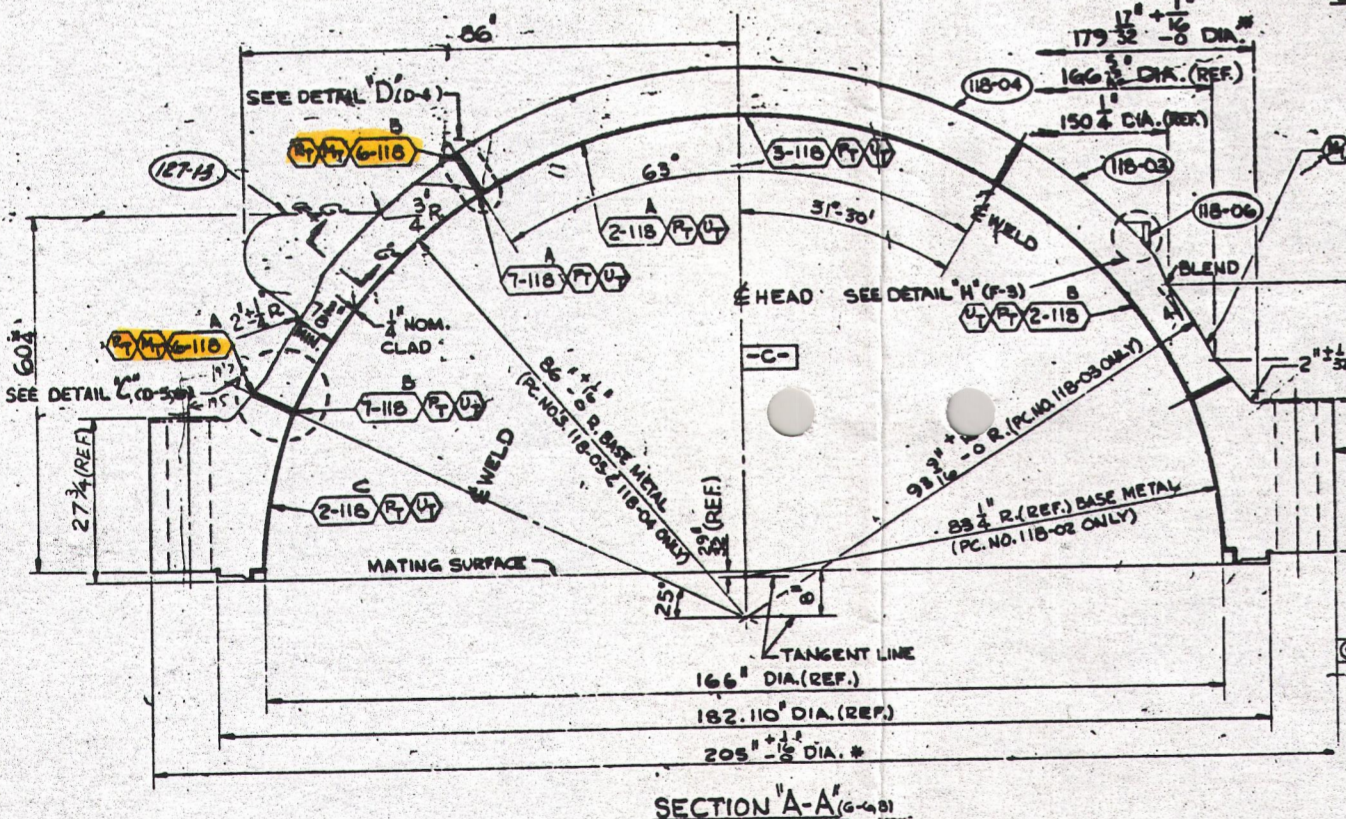
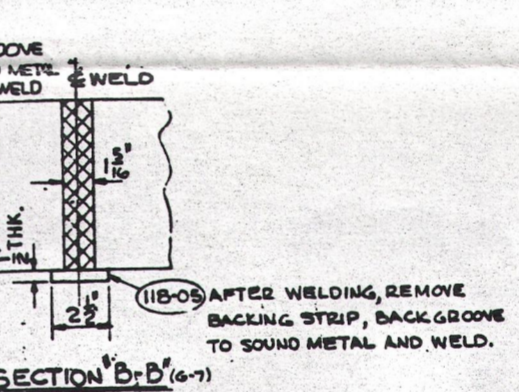
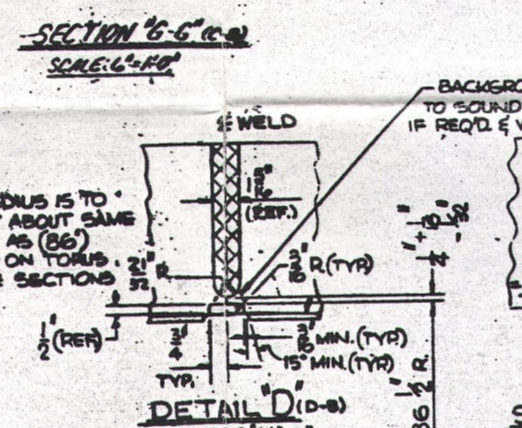
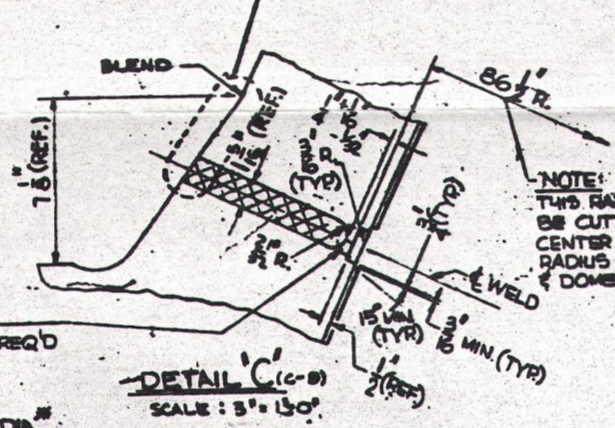
ANSTEC APERTURE CARD

54 HOLES EQUALLY SPACED STARTING AS SHOWN (B. 060) FINISH MACHINE LATER. HOLES #2 THRU #27 & #29 THRU #54 TO BE 7 3/8" DIA. (REF.). HOLES #1 & #3 TO BE 7 1/2" DIA. (REF.).

DEPOSIT WELD METAL IF NECESSARY TO MACHINE TO DIM'S. SHOWN IN SEC. 'A' (B-9)



(118-01) CLOSURE HEAD ASSY. SCALE: 3/4"=1'-0"



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MATERIAL NOTES
A AS SUPPLEMENTED BY C.E. PURCHASE SPECIFICATION P3C3(b).
B AS SUPPLEMENTED BY C.E. PURCHASE SPECIFICATION P3F3(a).

See Relief Requests #2 + #8

REV. NO.	DESCRIPTION	DATE	APPROVED
118-07	3 INSULATION SUPPORT RING 6 1/2" X 14 1/2" X 1/4" D.L. CARBON STEEL		COMM.
118-04	3 INSULATION RETAINER RING - 1/2" X 1/2" X 14 1/2" D.L. CARBON STEEL		COMM.
118-05	3 LIFTING LUG (SEE REF. DWG. 'G')		COMM.
118-06	6 BACKING STRIP 1/2" THK. X 2 1/2" X AS REQ'D. CARBON STEEL		COMM.
118-04	1 DOME SECTION MAKE FROM 8 1/2" THK. R. ALLOY STEEL SA-302-B		1B
118-03	6 PEEL SEGMENT MAKE FROM 8 1/2" THK. R. FORGED STEEL A-508-G		1A
118-02	1 FLANGE AS SHOWN		
118-01	1 CLOSURE HEAD ASSY. CONSISTING OF: NOMENCLATURE		

LIST OF MATERIAL - QUANTITIES FOR ONE (1) UNIT

REV. NO.	DESCRIPTION	DATE	APPROVED
118-06	3 INSULATION RETAINER RING - 1/2" X 1/2" X 14 1/2" D.L. CARBON STEEL		COMM.
118-05	3 LIFTING LUG (SEE REF. DWG. 'G')		COMM.
118-06	6 BACKING STRIP 1/2" THK. X 2 1/2" X AS REQ'D. CARBON STEEL		COMM.
118-04	1 DOME SECTION MAKE FROM 8 1/2" THK. R. ALLOY STEEL SA-302-B		1B
118-03	6 PEEL SEGMENT MAKE FROM 8 1/2" THK. R. FORGED STEEL A-508-G		1A
118-02	1 FLANGE AS SHOWN		
118-01	1 CLOSURE HEAD ASSY. CONSISTING OF: NOMENCLATURE		

CONTRACT 2366 A

GENERAL NOTES
1. FOR STANDARD NOTES, SEE REF. DWG. NO. 1.
2. DOUBLE ARROW INDICATES DIMENSION TO GIVEN REFERENCE LINE.
3. # DENOTES AS RECEIVED DIMENSIONS.
4. SIZES IN LINES ARE FINISHED SIZES. NO ALLOWANCE MADE FOR FABRICATION OR WELD SHRINKAGE, UNLESS NOTED.
5. REFERENCE (REF.) DIMENSIONS ARE FOR INFORMATION ONLY, DO NOT USE FOR FABRICATION.
6. ALL FABRICATION SHALL BE IN ACCORDANCE WITH ASME BOILER CODE SECTION III.
7. ALL CLADDING TO BE AS DEPOSITED FINISH UNLESS NOTED WITH

REFERENCE DRAWINGS

NO.	TITLE	DWG. NO.
1	STANDARD NOTES	A-230-535
2	CLOSURE HEAD NOZZLE DETAILS	E-232-119
3	CLOSURE HEAD PENETRATIONS	E-232-120
4	CLOSURE HEAD MACHINING	E-232-121
5	CLOSURE HEAD ASSEMBLY	E-232-122
6	MISCELLANEOUS DETAILS	E-232-127

WELD TABULATION

WELD NO.	DETAIL WELD PROC.
1-118 A-F	WA-2366 A-118
2-118 A-C	WB-2366 A-118
3-118	WC-2366 A-118
4-118 A-C	WD-2366 A-118
5-118 A-D	WE-2366 A-118
6-118 A-B	WF-2366 A-118
7-118 A-B	WG-2366 A-118
8-118 A-B	WH-2366 A-118
9-118 A-C	WI-2366 A-118
10-118	WK-2366 A-118

ALL DIMENSIONS APPLY AT REFERENCE TEMP. OF 68° F. - SEE NOTE #1
FINISH UNLESS NOTED
TOLERANCE ON FRACTIONS 1/16
DECIMALS ±.010
ANGLES ±0°-30'
UNLESS NOTED.

CONTRACT 2366 A

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