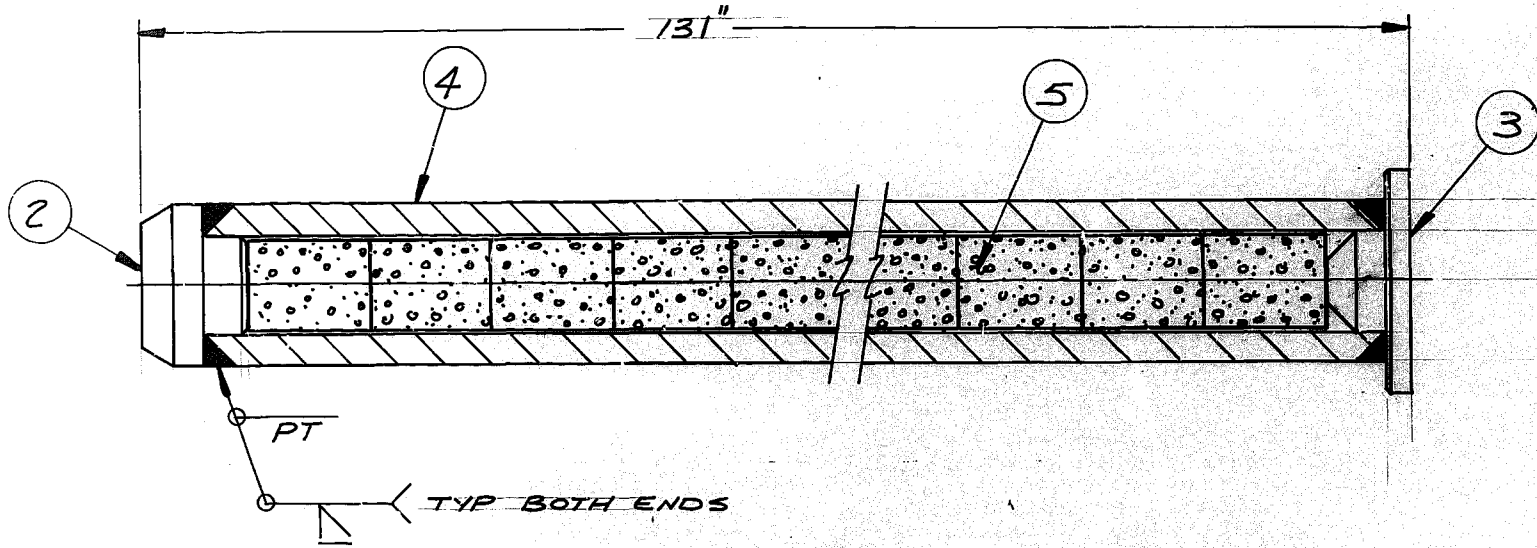


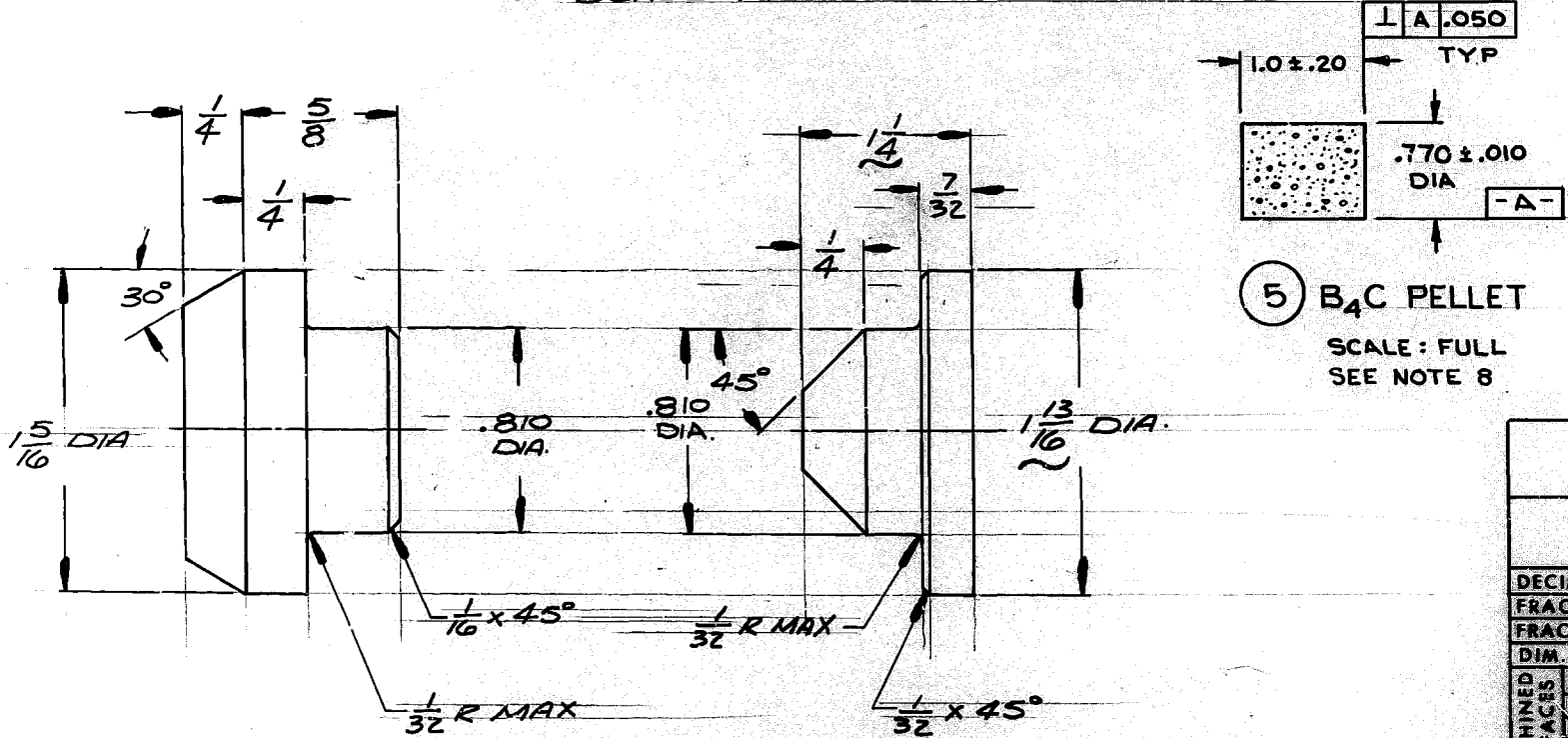
REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
1	REV. & REDRAWN	10/15/84	J.H. Peas P.C. Childress
2	REVISED NOTES 1 AND 6 131" WAS 134 3/4"	11/29/84	J.H. Peas P.C. Childress
3	REVISED NOTES 4 & 6. ADDED NOTES B-10 ADDED VIEW OF P/N 5 @ B-2. P/N 5 WAS B4C POWER	5/24/84	J.H. Peas P.C. Childress



- THE FABRICATOR SHALL USE A GAGE AT LEAST .010 GREATER THAN THE MAXIMUM PELLET DIAMETER IN A FULL-LENGTH INSERTION VERIFICATION TEST OF THE TUBE PRIOR TO LOADING THE PELLETS.
- THE PELLETS, P/N 5, SHALL BE LOADED IN A MANNER TO ASSURE NO MORE THAN .25 TOTAL AXIAL GAP.

BILL OF MATERIAL				
PART NO.	QUAN	DWG. NO.	DESCRIPTION	MAT'L SPEC
1	-	1150946C	POISON TUBE ASSY	
2	1		TOP END CAP	SEE NOTE 1
3	1		BOTTOM END CAP	SEE NOTE 1
4	1		PIPE, 1" SCH 160	NOTE 2
5	9/2		B4C PELLET	SEE NOTE 4

1 POISON TUBE ASSY
SCALE: FULL



5 B4C PELLET
SCALE: FULL
SEE NOTE 8

- NOTES:
- MATERIAL: ASTM A-479 TYPE 316L STAINLESS STEEL BAR
 - MATERIAL: ASTM A-312 GRADE TP 316L STAINLESS STEEL PIPE
 - WELD WIRE PER AWS 5.4 TYPE 316L
 - MATERIAL: ASTM C-750 BORON CARBIDE POWDER (TYPE 2). THE PELLET SHALL BE STACKED IN THE TUBE TO PRODUCE A MINIMUM LINEAR DENSITY OF 1.66 GRAMS OF B10 PER INCH. AT LEAST 1500 GRAMS WILL BE LOADED INTO EACH ROD.
 - "PT" DENOTES A LIQUID PENETRANT EXAMINATION OF THE WELDS PER ASTM E-165.
 - THE B4C PELLETS SHALL BE PROTECTED FROM CONTACT WITH CLEANING AGENTS, PETROLEUM PRODUCTS OR OTHER CONTAMINANTS AT ALL TIMES PRIOR TO AND AFTER LOADING.
 - WELD PREP AT FABRICATOR OPTION.
 - PELLET DIMENSIONS ARE REFERENCE FOR PROCESS USE.

2 TOP END CAP
SCALE: 2X
✓ ALL OVER

3 BOTTOM END CAP
SCALE: 2X
✓ ALL OVER

FOR ORIGINAL SIGNATURES
SEE MICROFILM CARD IN
RECORDS CENTER

1	K.O. CANISTER INTERNALS ASSY	1154027F
NO.	DRAWING TITLE	DWG. NO.
	REFERENCE DWGS	

TOLERANCES UNLESS OTHERWISE SPECIFIED ALL TOLERANCE DEFINITIONS PER ANSI Y14.5 - 1973 ALL DIMENSIONS ARE FOR PART TEMPERATURE OF 68°F						
	UP TO 6" INCL.	OVER 6" TO 12" INCL.	OVER 12" TO 24" INCL.	OVER 24" TO 60" INCL.	OVER 60" TO 14'-0" INCL.	OVER 14'-0"
DECIMAL DIMENSIONS	± .003"	± .005"	± .005"	± .010"	± .031"	
FRAC. DIM. MACH.	± 1/64"	± 1/32"	± 1/32"	± 1/16"	± 1/8"	± 1/8"
FRAC. DIM. UNMACH.	± 1/16"	± 1/16"	± 3/32"	± 1/8"	± 3/16"	± 3/16"
DIM. FOR BURNING	± 1/8"	± 1/8"	± 1/8"	± 1/8"	± 3/16"	± 3/16"
MACHINED SURFACES	FLATNESS .001" / IN. OF SURFACE UP TO .020" MAX				BREAK CORNERS 1/64" R. MIN. OR CHAMFER	
	PERPENDICULARITY .002" / IN. OF SURFACE UP TO .020" MAX					
	CONCENTRICITY .015" DIA.					
	ANGULARITY ± 0° - 30°				CHAMFER ± 5°	
ALL MACHINED SURFACES TO HAVE 250/RHR FINISH UNLESS OTHERWISE NOTED						

DRAWN BY BARRY WOOD CHECKED BY D.J. ATTIX FABRICATED BY E.J. MCGUINN APPROVED BY P.C. CHILDRESS STD. DATE 8-31-84 CONTRACT NO.	KNOCKOUT CANISTER POISON TUBE ASSY	THIS DRAWING IS THE PROPERTY OF Babcock & Wilcox a McDermott Company AND IS LOANED UPON CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED IN WHOLE OR IN PART, OR USED FOR FURNISHING INFORMATION TO OTHERS, OR FOR ANY OTHER PURPOSE DETRIMENTAL TO THE INTEREST OF BABCOCK & WILCOX AND WILL BE RETURNED UPON REQUEST.
IN ANY SCALE SEE DIMENSIONS ONLY.	SCALE NOTED	DRAWING NO. 1150946 C
		REV. NO. 3

D
C
B
A

D
C
B
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