



SECTION Z-Z

REV. NO.	DESCRIPTION	DATE	APPROVAL
1	REVISED IN LOCATIONS MARKED WITH Δ (FIGURAL) ON 10 WAS 3/16 @ F. 7/8 WAS 7/8 @ F. 2/8 WAS 1/16 @ D-S. ADDED 10 1/2 REF @ D-S. REV NOTE 1 AND 2, ADD REF @ D-S	7/2/85	BBC/CH
2	CORRECTED WITNESS LINE FOR 14.093-14.083 DIM. REVISED GEOMETRIC TOL IN VIEW A-A 1/8 TO BOTTOM OF SLOT WAS 1/2 TO R. CENTER IN VIEW A-A	11/1/85	BBC/CH
3	REVISED NOTE 2	2/1/85	BBC/CH
4	Z WAS 1/8 @ A-14	3-5 85	BBC/CH
5	40 GRAMS WAS 10 GRAMS IN NOTE 2	4-12 85	BBC/CH

PART NO.	QUAN.	DWG. NO.	DESCRIPTION	MATL. SPEC.
1	-	1154046F	KNOCKOUT CANISTER HEAD WELDMENT	
2	1	1150944C	FILTER & KNOCKOUT CANISTER SKIRT	
3	1	1150943E	KNOCKOUT CANISTER HEAD	
4	1	1154039C	LEAD-IN SLEEVE KNOCKOUT CANISTER	
5	1	1154042C	INLET TUBE SLEEVE KNOCKOUT CANISTER	
6	2	1154053C	KNOCKOUT-FILTER CANISTER COVER	
7	1/2	1150940A	H ₂ -O ₂ RECOMBINER CATALYST PELLETS (DECO ₂)	
8	1/2	1150937A	SILICON-COATED RECOMBINER CATALYST	
9	1	1154012D	SCREEN ASSY	

- NOTES:
- WELD WIRE PER AWS 5.4 TYPE 316L OR 308L.
 - FILL POCKETS WITH RECOMBINER CATALYST. THE REQUIRED AMOUNTS IN EACH POCKET ARE 10 * 1/2 GRAMS OF PART NO. 8. FILL THE REMAINDER OF THE POCKET WITH PART NO. 7 (A MINIMUM OF 40 GRAMS (PER POCKET) IS REQUIRED).
 - THIS PART MUST BE PROCURED, FABRICATED, INSPECTED, AND CERTIFIED IN ACCORDANCE WITH THE ASME BOILER & PRESSURE VESSEL CODE, SECTION VIII, DIVISION 1 OF THE 1983 EDITION WITH NO ADDENDA FOR A LETHAL VESSEL.
 - "PT" DENOTES A LIQUID PENETRANT INSPECTION OF THE WELD IN ACCORDANCE WITH ASTM E-365.
 - THE CANISTER SERIAL NUMBER AND FLOW DIRECTION SHALL BE APPLIED BY ENGRAVING, MILLING OR WELD DEPOSIT IN THE AREA SHOWN. THE LETTERS AND DIGITS SHALL BE AT LEAST 1 INCH HIGH AND MUST BE CLEARLY VISIBLE FROM A DISTANCE OF 15 FEET. THE SERIAL NUMBER SHALL BE IN THE FORM "K-XXX" WHERE "K" DESIGNATES KNOCKOUT CANISTER AND "XXX" IS A CONSECUTIVE SERIES OF 3 DIGITS BEGINNING WITH 501.
 - THE CATALYTIC RECOMBINERS SHOULD BE PROTECTED FROM CONTACT WITH CLEANING AGENTS, PETROLEUM PRODUCTS OR OTHER CONTAMINANTS AT ALL TIMES, PRIOR TO OR AFTER LOADING.

TOLERANCES UNLESS OTHERWISE SPECIFIED	
ALL DIMENSIONS ARE FOR PART TEMPERATURE OF 68°F	
	ALL DIMENSIONS ARE FOR PART TEMPERATURE OF 68°F
UP TO 6"	OVER 6" TO 12"
6" INCL. TO 12" INCL.	12" INCL. TO 24" INCL.
OVER 12" TO 24" INCL.	OVER 24" TO 48" INCL.
OVER 48" TO 14'-0" INCL.	OVER 14'-0" TO 14'-0"
DECIMAL DIMENSIONS	± .003" ± .005" ± .010" ± .031"
FRACTIONAL DIM. MACH.	± 1/64" ± 1/32" ± 1/16" ± 1/8" ± 3/16" ± 1/8"
FRACTIONAL DIM. UNMACH.	± 1/16" ± 1/8" ± 3/32" ± 1/8" ± 3/16" ± 3/16"
DIM. FOR BURNING	± 1/8" ± 1/8" ± 1/8" ± 1/8" ± 3/16" ± 3/16"
FLATNESS	.001" / IN. OF SURFACE UP TO .020" MAX. BREAK CORNERS
PERPENDICULARITY	.002" / IN. OF SURFACE UP TO .020" MAX. OR CHAMFER
CONCENTRICITY	.015" DIA.
ANGULARITY	± 9° - 30°
ALL MACHINED SURFACES TO HAVE 250/RHR FINISH UNLESS OTHERWISE NOTED	

1154046F	KNOCKOUT CANISTER ASSEMBLY	1154046F
1154046F	HEAD WELDMENT	1154046F
1154046F	WELDMENT	1154046F

KNOCKOUT CANISTER HEAD WELDMENT
 DWG. NO. 1154046F
 REV. 6
 SCALE 1:1
 DATE 8-31-85
 DESIGNED BY [Signature]
 CHECKED BY [Signature]
 APPROVED BY [Signature]
 THE BACOCK & WILCOX CO. POWER GENERATION GROUP
 THIS DRAWING IS THE PROPERTY OF THE BACOCK & WILCOX CO. AND IS LOANED TO YOU UNDER NO. 10 IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF THE BACOCK & WILCOX CO. THIS DRAWING IS NOT TO BE REPRODUCED OR COPIED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF THE BACOCK & WILCOX CO.