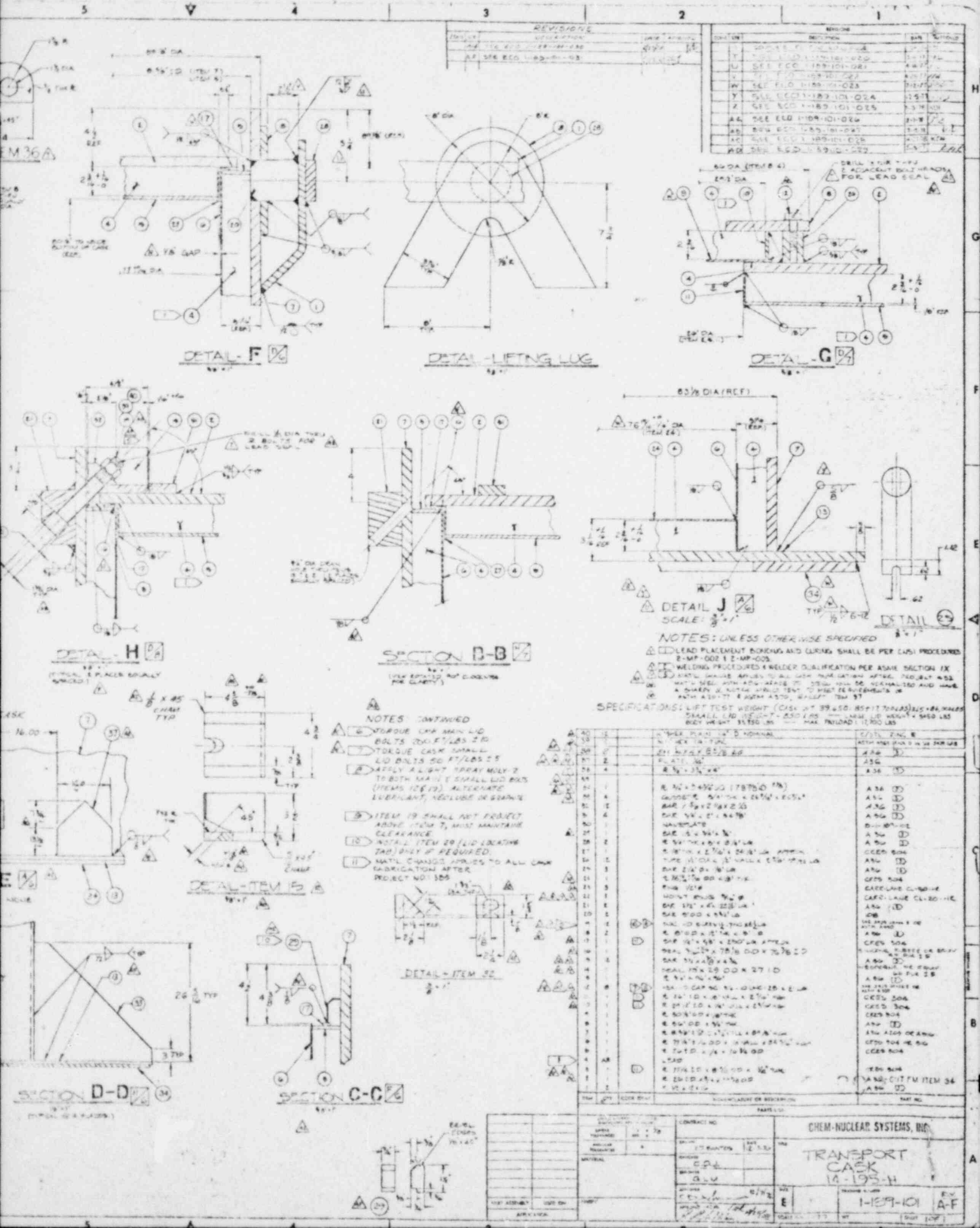


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REVISIONS

NO.	DESCRIPTION	DATE	BY	CHKD.
1	ISSUED FOR FABRICATION	12-15-54
2	REVISED TO REFLECT CHANGE IN MATERIAL	1-10-55
3	REVISED TO REFLECT CHANGE IN DIMENSIONS	2-15-55

NO.	DESCRIPTION	DATE	BY	CHKD.
1	ISSUED FOR FABRICATION	12-15-54
2	REVISED TO REFLECT CHANGE IN MATERIAL	1-10-55
3	REVISED TO REFLECT CHANGE IN DIMENSIONS	2-15-55

DETAIL-F

DETAIL-LIFTING LUG

DETAIL-G

DETAIL-H

SECTION B-B

DETAIL J

NOTES CONTINUED

- FORGUE OR MAIN LID BOLTS 200 K/LBS 2 1/2
- TORQUE CASK SMALL LID BOLTS 50 FT/LBS 2 1/2
- APPLY A LIGHT SPRAY OIL TO BOTH MAIN & SMALL LID BOLTS (ITEMS 12 & 13) ALTERNATE LUBRICANT, NEOLUBE OR GRAFVIX
- ITEM 19 SHALL NOT PROJECT ABOVE ITEM 7, MUST MAINTAIN CLEARANCE
- NOTAL ITEM 20 LID DEADEND TAG/KEY IF REQUIRED
- MATL CHANGES APPLIES TO ALL CASK FABRICATION AFTER PROJECT NO. 1505

NOTES: UNLESS OTHERWISE SPECIFIED

- LEAD PLACEMENT BENDING AND CURVING SHALL BE PER CASK PROCEDURE 2-MP-002 1 2-MP-005
- WELDING PROCEDURES & WELDER QUALIFICATION PER ASME SECTION IX
- MATL CHANGES APPLIES TO ALL FABRICATION AFTER PROJECT NO. 1505
- MATL TESTS WITH ADV. NOTICE TO THE FABRICATION SHOP TO BE OBTAINED AND HAVE A QUARTY & NOTAL WOULD TEST TO MEET REQUIREMENTS OF ANH A10-TT & ANH AS20, WELDER TEST 37

SPECIFICATIONS: LIFT TEST WEIGHT (CASK WT 39,650 LB) 117,000 LB. MAX. SMALL LID WEIGHT - 2,500 LB. MAX. LID WEIGHT - 1,800 LB. MAX. PRELOAD - 11,000 LB.

ITEM NO.	DESCRIPTION	QTY	UNIT	REMARKS	STANDARD
1	TOP COVER PLATE	1	PC	1/2" X 12" X 12"	A 36 (D)
2	TOP COVER GASKET	1	PC	1/2" X 12" X 12"	A 36 (D)
3	TOP COVER BOLTS	4	PC	1/2" X 12" X 12"	A 36 (D)
4	TOP COVER NUTS	4	PC	1/2" X 12" X 12"	A 36 (D)
5	TOP COVER WASHERS	4	PC	1/2" X 12" X 12"	A 36 (D)
6	TOP COVER BRACKET	1	PC	1/2" X 12" X 12"	A 36 (D)
7	TOP COVER BRACKET BOLTS	4	PC	1/2" X 12" X 12"	A 36 (D)
8	TOP COVER BRACKET NUTS	4	PC	1/2" X 12" X 12"	A 36 (D)
9	TOP COVER BRACKET WASHERS	4	PC	1/2" X 12" X 12"	A 36 (D)
10	TOP COVER BRACKET GASKET	1	PC	1/2" X 12" X 12"	A 36 (D)
11	TOP COVER BRACKET BRACKET	1	PC	1/2" X 12" X 12"	A 36 (D)
12	TOP COVER BRACKET BRACKET BOLTS	4	PC	1/2" X 12" X 12"	A 36 (D)
13	TOP COVER BRACKET BRACKET NUTS	4	PC	1/2" X 12" X 12"	A 36 (D)
14	TOP COVER BRACKET BRACKET WASHERS	4	PC	1/2" X 12" X 12"	A 36 (D)
15	TOP COVER BRACKET BRACKET GASKET	1	PC	1/2" X 12" X 12"	A 36 (D)
16	TOP COVER BRACKET BRACKET BRACKET	1	PC	1/2" X 12" X 12"	A 36 (D)
17	TOP COVER BRACKET BRACKET BRACKET BOLTS	4	PC	1/2" X 12" X 12"	A 36 (D)
18	TOP COVER BRACKET BRACKET BRACKET NUTS	4	PC	1/2" X 12" X 12"	A 36 (D)
19	TOP COVER BRACKET BRACKET BRACKET WASHERS	4	PC	1/2" X 12" X 12"	A 36 (D)
20	TOP COVER BRACKET BRACKET BRACKET GASKET	1	PC	1/2" X 12" X 12"	A 36 (D)
21	TOP COVER BRACKET BRACKET BRACKET BRACKET	1	PC	1/2" X 12" X 12"	A 36 (D)
22	TOP COVER BRACKET BRACKET BRACKET BRACKET BOLTS	4	PC	1/2" X 12" X 12"	A 36 (D)
23	TOP COVER BRACKET BRACKET BRACKET BRACKET NUTS	4	PC	1/2" X 12" X 12"	A 36 (D)
24	TOP COVER BRACKET BRACKET BRACKET BRACKET WASHERS	4	PC	1/2" X 12" X 12"	A 36 (D)
25	TOP COVER BRACKET BRACKET BRACKET BRACKET GASKET	1	PC	1/2" X 12" X 12"	A 36 (D)
26	TOP COVER BRACKET BRACKET BRACKET BRACKET BRACKET	1	PC	1/2" X 12" X 12"	A 36 (D)
27	TOP COVER BRACKET BRACKET BRACKET BRACKET BRACKET BOLTS	4	PC	1/2" X 12" X 12"	A 36 (D)
28	TOP COVER BRACKET BRACKET BRACKET BRACKET BRACKET NUTS	4	PC	1/2" X 12" X 12"	A 36 (D)
29	TOP COVER BRACKET BRACKET BRACKET BRACKET BRACKET WASHERS	4	PC	1/2" X 12" X 12"	A 36 (D)
30	TOP COVER BRACKET BRACKET BRACKET BRACKET BRACKET GASKET	1	PC	1/2" X 12" X 12"	A 36 (D)
31	TOP COVER BRACKET BRACKET BRACKET BRACKET BRACKET BRACKET	1	PC	1/2" X 12" X 12"	A 36 (D)
32	TOP COVER BRACKET BRACKET BRACKET BRACKET BRACKET BRACKET BOLTS	4	PC	1/2" X 12" X 12"	A 36 (D)
33	TOP COVER BRACKET BRACKET BRACKET BRACKET BRACKET BRACKET NUTS	4	PC	1/2" X 12" X 12"	A 36 (D)
34	TOP COVER BRACKET BRACKET BRACKET BRACKET BRACKET BRACKET WASHERS	4	PC	1/2" X 12" X 12"	A 36 (D)
35	TOP COVER BRACKET BRACKET BRACKET BRACKET BRACKET BRACKET GASKET	1	PC	1/2" X 12" X 12"	A 36 (D)
36	TOP COVER BRACKET BRACKET BRACKET BRACKET BRACKET BRACKET BRACKET	1	PC	1/2" X 12" X 12"	A 36 (D)
37	TOP COVER BRACKET BRACKET BRACKET BRACKET BRACKET BRACKET BRACKET BOLTS	4	PC	1/2" X 12" X 12"	A 36 (D)
38	TOP COVER BRACKET BRACKET BRACKET BRACKET BRACKET BRACKET BRACKET NUTS	4	PC	1/2" X 12" X 12"	A 36 (D)
39	TOP COVER BRACKET BRACKET BRACKET BRACKET BRACKET BRACKET BRACKET WASHERS	4	PC	1/2" X 12" X 12"	A 36 (D)
40	TOP COVER BRACKET BRACKET BRACKET BRACKET BRACKET BRACKET BRACKET GASKET	1	PC	1/2" X 12" X 12"	A 36 (D)

SECTION D-D

SECTION C-C

CONTRACT NO. _____

CHEM-NUCLEAR SYSTEMS, INC.

TRANSPORT CASK 14-195-H

REV. _____

DATE: 1-15-55

BY: _____

CHKD.: _____

APPROVED: _____