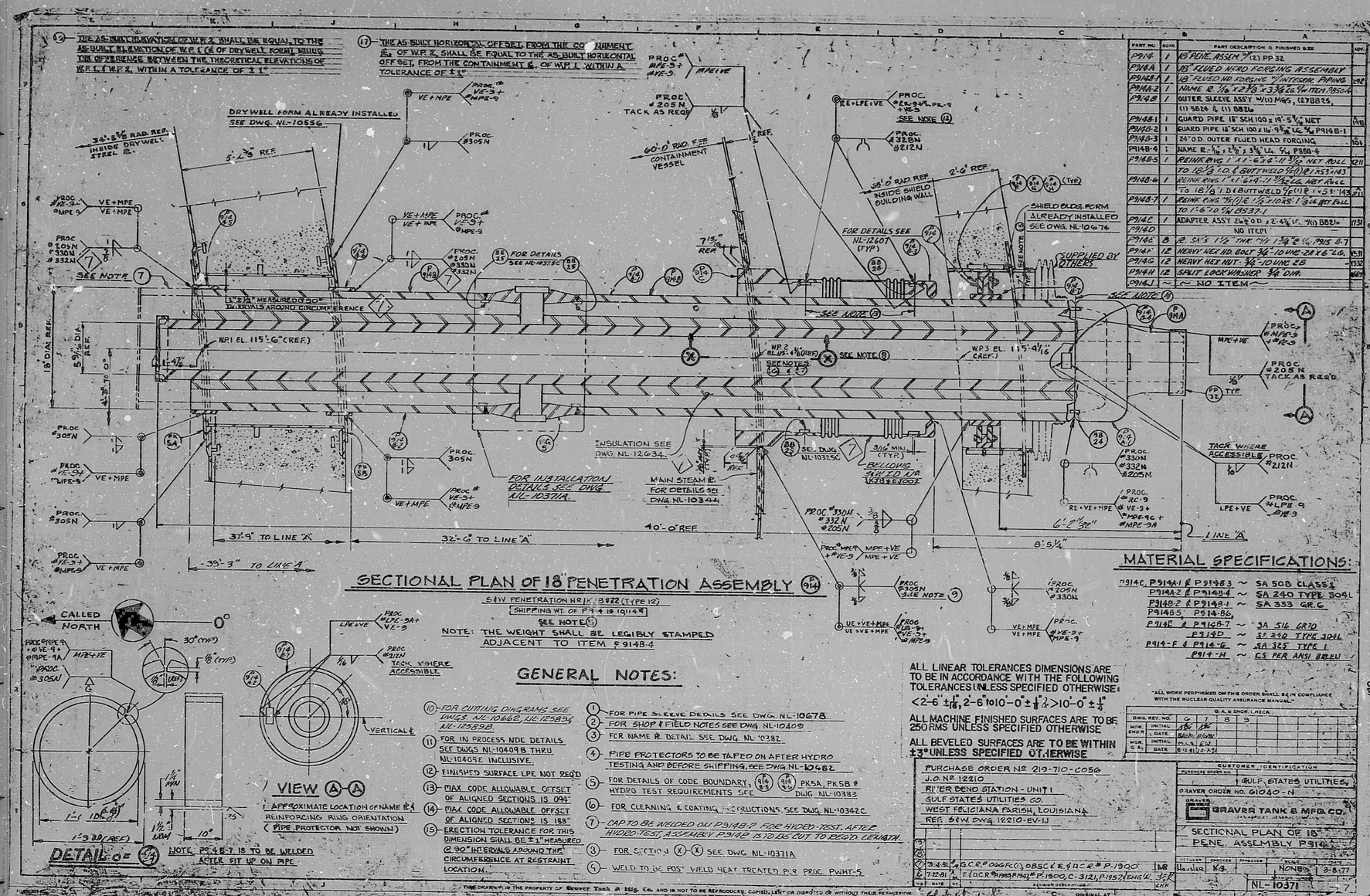
(16) THE AS-BUILT ELEVATION OF W.P. 2 SHALL BE EQUAL TO THE AS-BUILT ELEVATION OF W.P. 1 ℄ OF DRYWELL FORM, MINUS THE DIFFERENCE BETWEEN THE THEORETICAL ELEVATIONS OF W.P. 1 & W.P. 2, WITHIN A TOLERANCE OF ± 1".

(17) THE AS-BUILT HORIZONTAL OFFSET, FROM THE CONTAINMENT ℄, OF W.P. 2, SHALL BE EQUAL TO THE AS-BUILT HORIZONTAL OFFSET, FROM THE CONTAINMENT ℄, OF W.P. 1, WITHIN A TOLERANCE OF ± 1".



SECTIONAL PLAN OF 18" PENETRATION ASSEMBLY (914)

S&W PENETRATION NO. K/B 822 (TYPE 12)

SHIPPING WT. OF P914 & 18 10148

SEE NOTE (5)

NOTE: THE WEIGHT SHALL BE LEGIBLY STAMPED ADJACENT TO ITEM P 9148-4

GENERAL NOTES:

(1) FOR PIPE SLEEVE DETAILS SEE DWG. NL-10678
(2) FOR SHOP & FIELD NOTES SEE DWG. NL-10409
(3) FOR NAME ℄ DETAIL SEE DWG. NL-10382
(4) PIPE PROTECTORS TO BE TAPED ON AFTER HYDRO TESTING AND BEFORE SHIPPING, SEE DWG. NL-10482
(5) FOR DETAILS OF CODE BOUNDARY, (9/4 5/5) (9/4 5/5) PK5A, PK5B & DWG. NL-10383
(6) FOR CLEANING & COATING INSTRUCTIONS, SEE DWG. NL-10347C
(7) CAP TO BE WELDED ON P9148-2 FOR HYDRO-TEST. AFTER HYDRO-TEST, ASSEMBLY P914B IS TO BE CUT TO REQ'D. LENGTH.
(8) FOR SECTION (X)-(X) SEE DWG. NL-10371A
(9) WELD TO DC POS'N WELD HEAT TREATED PER PROC. PWHT-5
(10) FOR CUTTING DIAGRAMS SEE DWGS. NL-10462, NL-12589A, NL-12589B.
(11) FOR IN PROCESS NDE DETAILS SEE DWGS. NL-10409 B THRU NL-10409E INCLUSIVE.
(12) FINISHED SURFACE LPE NOT REQ'D
(13) MAX CODE ALLOWABLE OFFSET OF ALIGNED SECTIONS IS .094"
(14) MAX CODE ALLOWABLE OFFSET OF ALIGNED SECTIONS IS .188"
(15) ERECTION TOLERANCE FOR THIS DIMENSION SHALL BE ±1" MEASURED @ 90° INTERVALS AROUND THE CIRCUMFERENCE AT RESTRAINT LOCATION.

PART NO.	QUAN.	PART DESCRIPTION & FINISHED SIZE	MAT.
P914	1	18" PENE. ASSM. (2) PP 32	
P914A	1	18" FLUED HEAD FORGING ASSEMBLY	
P914B-1	1	18" FLUED HD. FORGING 3/4" INTEGRAL PIPING	304
P914B-2	1	WANE @ 1/16 x 2 3/8 x 3 3/8 x 26 7/8 ITEM P9148-4	
P914B	1	OUTER SLEEVE ASSY W/(1) MGS, (2) BB25,	
		(1) SB26 & (1) BB26	
P914B-1	1	GUARD PIPE 18" SCH. 100 x 14'-5 9/16" NET	348
P914B-2	1	GUARD PIPE 18" SCH. 100 x 16'-9 7/16" LG. 5/16 P914B-1	
P914B-3	1	24" O.D. OUTER FLUED HEAD FORGING	304
P914B-4	1	NAME R-1/16 x 2 1/8 x 3 3/8 LG. 5/16 PB5A-4	
P914B-5	1	REINF. RING 1" x 1'-6" & 2'-11 3/32" NET ROLL	241
		TO 18 1/8" I.D. & BUTTWELD 5/8" (1) @ 1 x 53'-143	
P914B-6	1	REINF. RING 1" x 1'-6" & 2'-11 3/32" LG. NET ROLL	
		TO 18 1/8" I.D. & BUTTWELD 5/8" (1) @ 1 x 53'-142	241
P914B-7	1	REINF. RING 5/8" (1) E 1 1/2 x 10 x 5'-1" LG. ART. ROLL	
		TO 1'-6" O.D. 5/8" DS37-1	
P914C	1	ADAPTER ASSY 26 1/2" O.D. x 2'-4 3/8" LG. 7/16 BB21	1151
P914D		NO ITEM	
P914E	8	2 SK'S 1 1/2" THK 7/16 x 1 3/8" @ 5/16 P915 B-7	
P914F	12	HEAVY HEX HD. BOLT 3/4"-10 UNC-2A x 6" LG.	1531
P914G	12	HEAVY HEX NUT 3/4"-10 UNC 2B	1532
P914H	12	SPLIT LOCKWASHER 3/4" DIM.	1600
P914J	~	~ NO ITEM ~	

MATERIAL SPECIFICATIONS:

P914C, P914A-1 & P914B-3	~	SA 508 CLASS 1
P914A-2 & P914B-4	~	SA 240 TYPE 304L
P914B-2 & P914B-1	~	SA 333 GR. 6
P914B-5 & P914B-6		
P914E & P914B-7	~	SA 516 GR 70
P914D	~	SA 240 TYPE 304L
P914-F & P914-G	~	SA 325 TYPE 1
P914-H	~	CS PER ANSI B18.21

ALL LINEAR TOLERANCES DIMENSIONS ARE TO BE IN ACCORDANCE WITH THE FOLLOWING TOLERANCES UNLESS SPECIFIED OTHERWISE:
<2'-6" ±1/16", 2'-6" to 10'-0" ± 1/8", >10'-0" ± 1/4"

ALL MACHINE FINISHED SURFACES ARE TO BE 250 RMS UNLESS SPECIFIED OTHERWISE

ALL BEVELED SURFACES ARE TO BE WITHIN ±3° UNLESS SPECIFIED OTHERWISE

"ALL WORK PERFORMED ON THIS ORDER SHALL BE IN COMPLIANCE WITH THE NUCLEAR QUALITY ASSURANCE MANUAL"

Q.A. INDX.						
DWG. REV. NO.	G	7	8	9		
NOR. ENG'R	INITIAL					
	DATE					
NOR. Q.A.	INITIAL					
	DATE					

PURCHASE ORDER Nº 210-710-C056
J.O. Nº 12210
RIVER BEND STATION - UNIT 1
GULF STATES UTILITIES CO.
WEST FELICIANA PARISH, LOUISIANA
REF. S&W DWG. 12210-EV-1J

REV.	DATE	DESCRIPTION	BY
9	9-4-81	G.C.R. # 066R(C) OBSC & E & D-2 # P-1900	WR
8	7-22-81	E/O.C.R. # 1985R(A) # P-1900, C-3121, P1957 (ENGL.)	JEH

CUSTOMER IDENTIFICATION
PURCHASE ORDER NO. GULF STATES UTILITIES
GRAVER ORDER NO. 61040-N
GRAVER TANK & MFG. CO.
SECTIONAL PLAN OF 18" PENE. ASSEMBLY P914
DESIGNED Hodges | CHECKED K.G. | DRAWN | SCALE NONE | DATE 8-5-77
NL-10371

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STONE & WEBSTER ENGINEERING CORPORATION
RIVER BEND STATION - UNIT 1
GULF STATES UTILITIES COMPANY

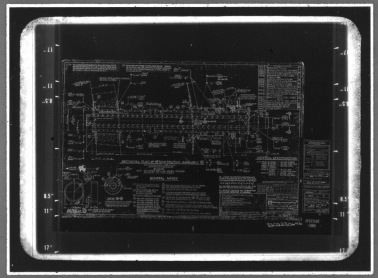
✓ INSTRUCTIONS TO SUPPLIER (E2)
✓ APPROVED — AS DEFINED IN SPECIFICATION
APPROVED AS REVISED
✓ RELEASED FOR FABRICATION
RELEASED FOR MATERIAL PURCHASE
SUPPLIER TO RESUBMIT: QUANTITY — REVISED PRINTS; REVISED MICROFILM APERTURE CARDS; FOR REVIEW; FOR RECORD; NONE REQUIRED
NOTES:
(E9) ✓ FOR INFORMATION ONLY — RETURN TO SUPPLIER NOT REQUIRED
INSTRUCTIONS TO SUPPLIER (E2): F-O, P-L, P-, REC, F-O, NEA, REV
DESIGN ENGINEER'S DATE STAMP (E2): OUT. NOV 13 1981 J. U. RUNER
INITIALS OF SELECTED REVIEWERS
RESPONSIBLE ENGINEER'S DATE STAMP (E2): INTER OCT 29 1981
SUPERSEDES S&W FILE NO. (E2) (35-38): 0 2 1 1 9 7 1 5 0 5 6 79.5G
REMARKS (C) (LIMIT TO 22 CHARACTERS & BLANKS) (35-74)
S&W EQUIP. I.D. CODE (E2): KJB822 (75-80); AREA DESIGNATION CODES (E1) (9-80)
MFR'S DWG. NO. (E1) (LIMIT TO 16 CHARACTERS & BLANKS) (1-8): NL-10371 REV. 7
MFR'S. NAME (E1) (LIMIT TO 20 CHARACTERS & BLANKS) (9-28): GRAVER TANK & MFG. CO.
FUNCTIONAL TITLE (E1) (LIMIT TO 40 CHARACTERS & BLANKS) (29-68): SECT PLAN 18" PENE ASSM. P914
S&W FILE NO. (E1): 0 2 1 1 9 7 1 5 0 5 6 79.5H
JOB ORDER NO. 12210 .00
ATTACH TO

8202230646

APERTURE CARD

RIDS

8202230646



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