



ITEM NO.	QTY	PART DESCRIPTION & FINISHED DIM.
P853-1	1	14" PENE ASSEM. W/PP29, 10BB31(10)BB16
P853-1	1	14" FLUED HEAD FORGING WITH INTEGRAL PIPING
P853-2	1	PIPE SLEEVE 14.504 60 X 2 1/2 X 1/4
P853-3	1	1 1/2" O.D. X 1 1/2" L.G. GUARD
P853-4	1	PIPE ADAPTER
P853-5	1	NAME R 1/2 X 2 1/2 X 3 1/2 L.G. C/W ITEM P850-4
P853-6	1	CONTAINMENT INSERT R 2 1/2 X 1 1/4 I.D. X 2'-3" O.D. C/W P865-5
P853-6	1	PIPE CAP 3" CH. 80
P854-1	1	14" PENE ASSEM. W/PP29, 10BB31(10)BB16
P854-1	1	14" FLUED HEAD FORGING WITH INTEGRAL PIPING
P854-2	1	PIPE SLEEVE 14.504 60 X 2 1/2 X 1/4
P854-3	1	1 1/2" O.D. X 1 1/2" L.G. GUARD
P854-4	1	PIPE ADAPTER
P854-5	1	NAME R 1/2 X 2 1/2 X 3 1/2 L.G. C/W ITEM P850-4
P854-6	1	CONTAINMENT INSERT R 2 1/2 X 1 1/4 I.D. X 2'-3" O.D. C/W P865-5
P854-6	1	NO ITEM

MATERIAL SPECIFICATIONS:

P853-1 & P854-1	SA 508 CLASS 1
P853-2 & P854-2	SA 333 GR 6
P853-3 & P854-3	SA 316 GR 70
P853-4 & P854-4	SA 240 TYPE 304
P853-6	SA 234 WPB

- GENERAL NOTES:**
- FOR CONTAINMENT INSERT R DETAILS SEE DWG. NL-10409
 - FOR PIPE SLEEVE DETAILS SEE DWG. NL-10667
 - COLLARS TO BE ALIGNED USING COLLAR JIG
 - FOR SHOP & FIELD NOTES SEE DWG. NL-10409
 - PIPE PROTECTORS TO BE TAPPED ON BEFORE SHIPPING AFTER ASSEMBLY AS SHOWN ON DWG. NL-10667
 - PENETRATION FORGING (P853) HAS BEEN PREVIOUSLY HYDROTESTED BY SUB-SUPPLIER IN ACCORDANCE WITH A.S.M.E. III NC-8000 AT A MIN. PIPING METAL TEMP. OF 70°F AND A TEST PRESSURE OF 1675 PSIG
 - FOR IN PROCESS N.D.E. DETAILS SEE DWG. S/NL-10409 B, THRU NL-10409 E INCL.
 - FOR CLEANING & COATING INSTRUCTIONS SEE DWG. NL-10341
 - FOR NAME R DETAILS SEE DWG. NL-10382
 - FOR BACK UP BAR DETAILS SEE DWG. NL-10325A
 - FINISHED SURFACE MPE NOT REQ'D.

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

ALL LINEAR TOLERANCES DIMENSIONS ARE TO BE IN ACCORDANCE WITH THE FOLLOWING TOLERANCES UNLESS SPECIFIED OTHERWISE:

<2'-6" ± 1/8", 2'-6" 1010-0 ± 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

PURCHASE ORDER NO. 219-710-C056
 J.O. NO. 12210
 RIVER BEND STATION - UNIT 1
 GULF STATES UTILITIES CO.
 WEST FELICIANA PARISH, LOUISIANA
 REF. S&W DWG. 12210-EV-1K

CUSTOMER IDENTIFICATION
 GULF STATES UTILITIES CO.
 GRAVER ORDER NO. 01040-N

DRAPER TANK & MFG. CO.
 SECTIONAL PLAN OF 14" PENE. ASSEMBLIES P853 & P854

DATE: 5-18-77
 DRAWN BY: RL
 CHECKED BY: JKR
 SCALE: NONE
 SHEET NO.: 3-11-77
 TOTAL SHEETS: 6
 JOB NO.: NL-10687

STONE & WEBSTER ENGINEERING CORPORATION
 RIVER BEND STATION - UNIT 1
 GULF STATES UTILITIES COMPANY
 J.O. 12210

INSTRUCTIONS TO SUPPLIER (E2)

APPROVED AS REVISED IN SPECIFICATION

RELEASED FOR FABRICATION

RELEASED FOR MATERIAL PURCHASE

REVISED PRINTS

REVISED MICROFILM APERTURE CARDS

SUPPLIER TO RETURN FOR REVIEW FOR RECORD NONE REQUIRED

NOTES:

LEAD & INFORMATION ONLY RETURN TO SUPPLIER NOT REQUIRED

INSTRUCTIONS TO: 1-0 P.L. P.S. REV. P.D. NEW (REV)

DESIGN ENGINEER'S DATE STAMP (D)

OUT: MAJOR JUL 03 1981 A.M. RWZ

INITIALS OF SELECTED REVIEWERS

RESPONSE: 01010 01010 01010 01010 01010 01010

SUPERSIDES: 55- FILE NO. (REVISED) 12210-10

021191715 01912606

REMARKS: (TITLE) TO 22 CHARACTERS & BLANKS ONLY

1-4 W/ EQUIP. CODE (E1) AREA DESIGNATION (CODES) (E1) (E2) (E3) (E4) (E5) (E6) (E7) (E8) (E9) (E10) (E11) (E12) (E13) (E14) (E15) (E16) (E17) (E18) (E19) (E20) (E21) (E22) (E23) (E24) (E25) (E26) (E27) (E28) (E29) (E30) (E31) (E32) (E33) (E34) (E35) (E36) (E37) (E38) (E39) (E40) (E41) (E42) (E43) (E44) (E45) (E46) (E47) (E48) (E49) (E50) (E51) (E52) (E53) (E54) (E55) (E56) (E57) (E58) (E59) (E60) (E61) (E62) (E63) (E64) (E65) (E66) (E67) (E68) (E69) (E70) (E71) (E72) (E73) (E74) (E75) (E76) (E77) (E78) (E79) (E80) (E81) (E82) (E83) (E84) (E85) (E86) (E87) (E88) (E89) (E90) (E91) (E92) (E93) (E94) (E95) (E96) (E97) (E98) (E99) (E100)

1- KJBX 21011023 1111

2- W/S'S NAME (LIMIT TO 20 CHARACTERS & BLANKS ONLY) (E1) (E2) (E3) (E4) (E5) (E6) (E7) (E8) (E9) (E10) (E11) (E12) (E13) (E14) (E15) (E16) (E17) (E18) (E19) (E20) (E21) (E22) (E23) (E24) (E25) (E26) (E27) (E28) (E29) (E30) (E31) (E32) (E33) (E34) (E35) (E36) (E37) (E38) (E39) (E40) (E41) (E42) (E43) (E44) (E45) (E46) (E47) (E48) (E49) (E50) (E51) (E52) (E53) (E54) (E55) (E56) (E57) (E58) (E59) (E60) (E61) (E62) (E63) (E64) (E65) (E66) (E67) (E68) (E69) (E70) (E71) (E72) (E73) (E74) (E75) (E76) (E77) (E78) (E79) (E80) (E81) (E82) (E83) (E84) (E85) (E86) (E87) (E88) (E89) (E90) (E91) (E92) (E93) (E94) (E95) (E96) (E97) (E98) (E99) (E100)

3- FUNCTIONAL TITLE (E1) (E2) (E3) (E4) (E5) (E6) (E7) (E8) (E9) (E10) (E11) (E12) (E13) (E14) (E15) (E16) (E17) (E18) (E19) (E20) (E21) (E22) (E23) (E24) (E25) (E26) (E27) (E28) (E29) (E30) (E31) (E32) (E33) (E34) (E35) (E36) (E37) (E38) (E39) (E40) (E41) (E42) (E43) (E44) (E45) (E46) (E47) (E48) (E49) (E50) (E51) (E52) (E53) (E54) (E55) (E56) (E57) (E58) (E59) (E60) (E61) (E62) (E63) (E64) (E65) (E66) (E67) (E68) (E69) (E70) (E71) (E72) (E73) (E74) (E75) (E76) (E77) (E78) (E79) (E80) (E81) (E82) (E83) (E84) (E85) (E86) (E87) (E88) (E89) (E90) (E91) (E92) (E93) (E94) (E95) (E96) (E97) (E98) (E99) (E100)

4- SCCT PLAN 14" PENE ASSM P853 & P854

5- 0121191715 01912606

6- JOB ORDER NO. 12210 00

APERTURE CARD 8202230647

RIDS

8202230647

