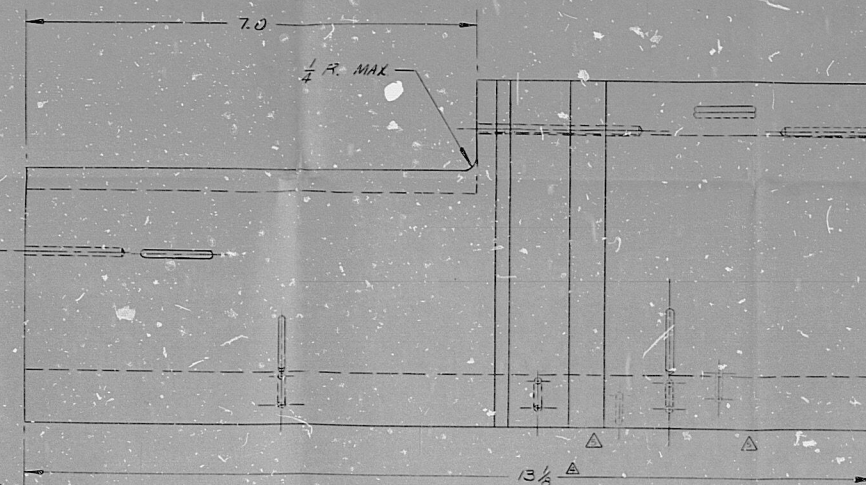
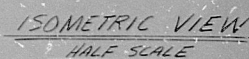
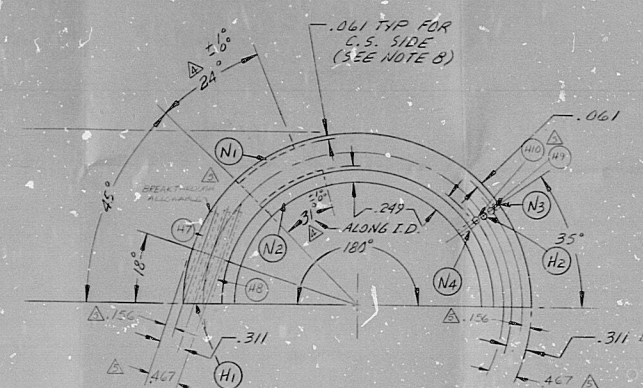
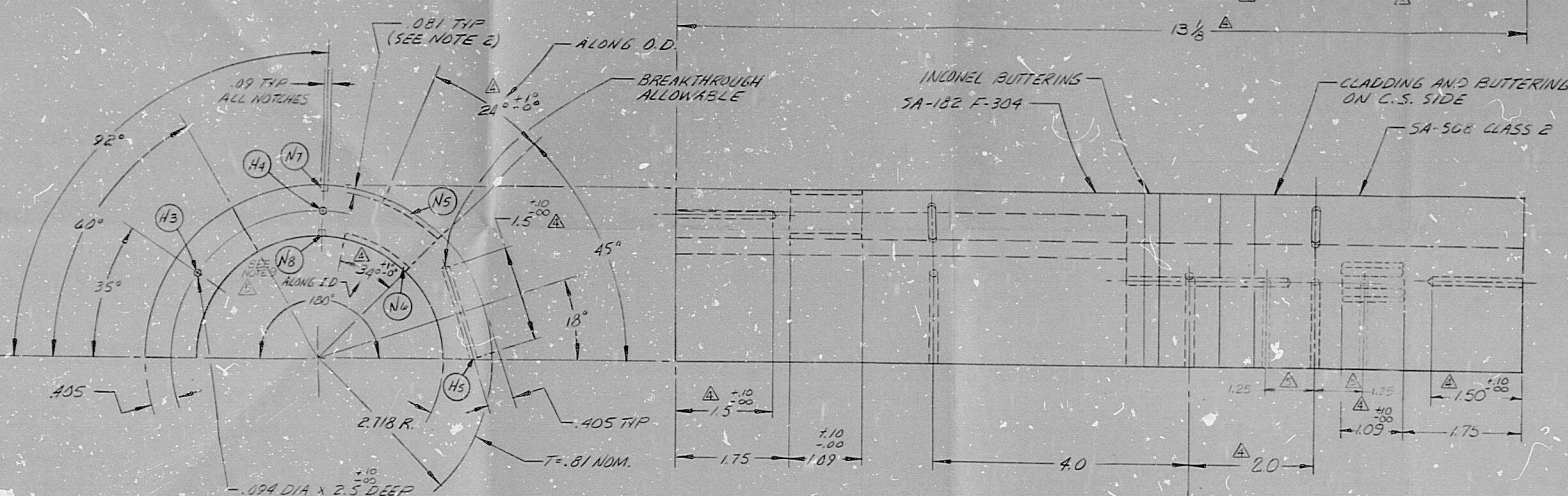


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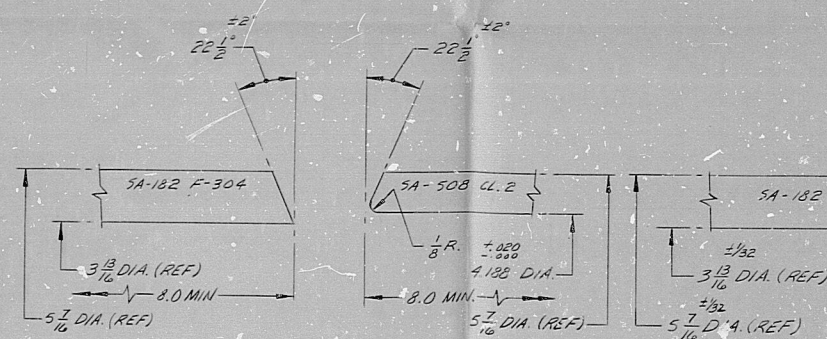


IDENTIFICATION ON CURVED SURFACE
METAL STAMP WITH .12 HIGH CHARACTERS
(SEE NOTE 6)

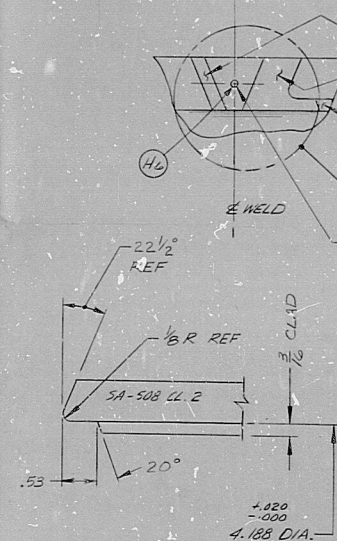


NOTES

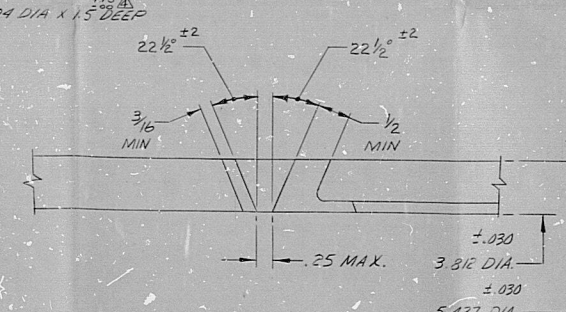
- NOTES:
- 1- HOLES: 3/32" DIA. X 1.5 DEEP (TYP 9 PLACES). 1.50
1.50 △
- 2- NOTCHES: .09 WIDE X 1.05" LENGTH X .031 DEEP
TYP FOR STAINLESS STEL TYPE 304
(4 PLACES). ALSO SEE NOTE 7 (1)
- 3- MATERIAL: SA-508 CLASS II CARBON STEEL } AS SHOWN
SA-182 TYPE 304 STAINLESS STEEL }
- 4- BUTTERING AND WELD FILLER METAL SB-275 E-
N/C F6-3 (INCO 182).
- 5- "STAINLESS STEEL CLADDING AND BUTTERING SA278
TYPE E-308-15 FOR FIRST LAYER
TYPE E-308-15 FOR ALL SUBSEQUENT LAYERS
- 6- IDENTIFICATION: "SNPS-1P1"
- 7- REFER TO NES WELD SPECIFICATION NO. BDA0426
- 8- NOTCHES FOR 508 CLASS E .09 WIDE X 1.05" LENGTH X
.061 DEEP (4 PLACES) (PARENT MATERIAL TYP 4 PLACES)
- 9- NOR 1-0 TO BE MACHINED TO .125 WIDE X 1.09" .09 LENGTH X
NOR 1-1 DEEP



STEP 1



STEP 2



STEP 3
DETAIL A
WELD FIT-UP

PRC
APERTURE
CARD

CONTROLLED
COPY

THIS DRAWING AFFECTED BY ECO NO.		ITEM	QTY	CODE	IDENT	PART NUMBER	PARTS LIST	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES, FRACTIONS OF INCHES TO 1/32 INCHES, DECIMALS OF INCHES TO 0.001 INCHES, MILLIMETERS TO 0.1 MILLIMETERS. ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE ORDERED AND BREAK SHARP CORNERS.		SIGNATURES		DATE		AUTOMATION INDUSTRIES, INC. NUCLEAR ENERGY SERVICES		
		DRAWN BY: <u>HATZLER JR</u>		<u>9-9-79</u>				
TYPICAL <u>AS SHOWN</u>		CHECKED				TITLE CALIBRATION BLOCK JET PUMP INSTRUMENT NOZZLE TO SAFE END		
		<u>ASH DOD</u> <u>11/1/79</u> <u>PAUL WICK</u> <u>11/1/79</u> <u>151 ENGR MGR</u> <u>11/1/79</u> <u>FLD OPS MGR</u> <u>11/1/79</u>						
FINISH		APPROVED DESIGN ACTIVITY				SIZE	CODE IDENT NO.	DRAWING NO.
<u>250/0R BETTER</u>		<u>2536-250</u>					<u>78446</u>	<u>80E0415</u>
NEXT STEP		APPROVED				SCALE	1:1	SHEET
APPLICATION		<u>A. MGR</u> <u>11/1/79</u>						
						RE <u>5</u>		

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