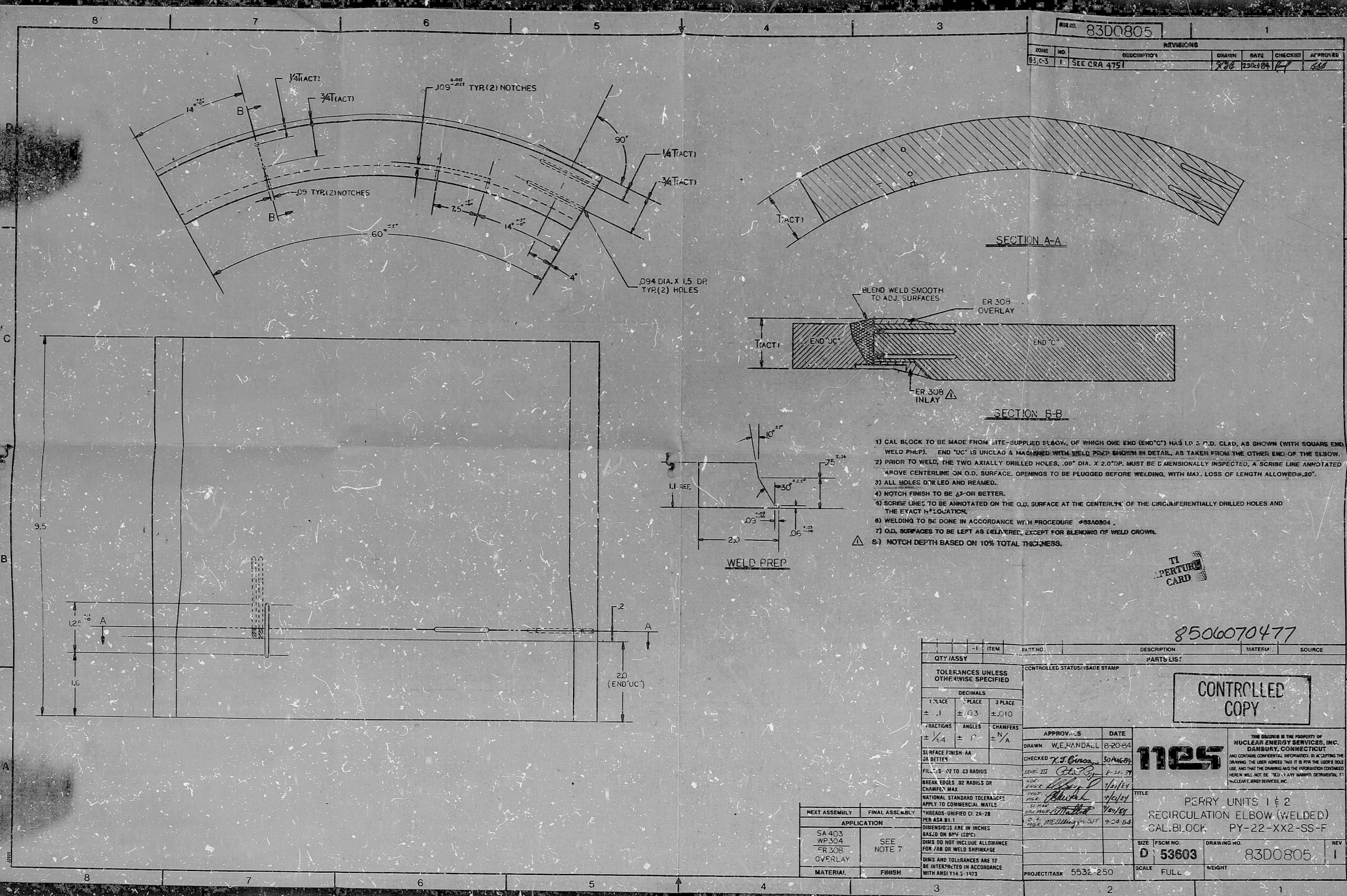




- 1) CAL BLOCK TO BE MADE FROM LITE-SUPPLIED ELBOW, OF WHICH ONE END (END "C") HAS 1.0" O.D. CLAD, AS SHOWN (WITH SQUARE END WELD PHAF). END "UC" IS UNCLAD & MACHINED WITH WELD PREP SHOWN IN DETAIL, AS TAKEN FROM THE OTHER END OF THE ELBOW.
- 2) PRIOR TO WELD, THE TWO AXIALLY DRILLED HOLES, .09" DIA. X 2.0" DP, MUST BE DIMENSIONALLY INSPECTED, A SCRIBE LINE ANNOTATED ABOVE CENTERLINE ON O.D. SURFACE, OPENINGS TO BE PLUGGED BEFORE WELDING, WITH MAX. LOSS OF LENGTH ALLOWED=.30".
- 3) ALL HOLES DRILLED AND REAMED.
- 4) NOTCH FINISH TO BE 3-OR BETTER.
- 5) SCRIBE LINES TO BE ANNOTATED ON THE O.D. SURFACE AT THE CENTERLINE OF THE CIRCUMFERENTIALLY DRILLED HOLES AND THE EFFECT H-LOCATION.
- 6) WELDING TO BE DONE IN ACCORDANCE WITH PROCEDURE #83A0804.
- 7) O.D. SURFACES TO BE LEFT AS DELIVERED, EXCEPT FOR BLENDING OF WELD CROWN.
- 8) NOTCH DEPTH BASED ON 10% TOTAL THICKNESS.

QTY/ASSY		ITEM	PART NO.	DESCRIPTION	MATERIAL	SOURCE		
TOLERANCES UNLESS OTHERWISE SPECIFIED			CONTROLLED STATUS/ISSUE STAMP					
DECIMALS			CONTROLLED COPY					
1 PLACE	2 PLACE	3 PLACE						
± .1	± .03	± .010						
FRACTIONS	ANGLES	CHAMFERS						
± 1/4	± 1°	± N/A						
SURFACE FINISH - AA OR BETTER			THIS DRAWING IS THE PROPERTY OF NUCLEAR ENERGY SERVICES, INC. DANBURY, CONNECTICUT AND CONTAINS CONFIDENTIAL INFORMATION. BY ACCEPTING THE DRAWING, THE USER AGREES THAT IT IS FOR THE USER'S SOLE USE, AND THAT THE DRAWING AND THE INFORMATION CONTAINED HEREIN MAY NOT BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.					
FILL - .02 TO .03 RADIUS								
BREAK EDGES .02 RADIUS OR CHAMFER MAX								
NATIONAL STANDARD TOLERANCES APPLY TO COMMERCIAL MATLS								
THREADS - UNIFIED CI 2A-2B PER ASA B1.1								
DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED								
DIMENSIONS DO NOT INCLUDE ALLOWANCE FOR FAB OR WELD SHRINKAGE								
DIMENSIONS AND TOLERANCES ARE TO BE INTERPRETED IN ACCORDANCE WITH ANSI Y14.5-1973								
PROJECT/TASK 5532-250								
APPROVALS							DATE	
DRAWN W.E. RANDALL							8-20-84	
CHECKED J.S. GIBSON							30/4/84	
REVIEW III J.S. GIBSON							8-21-84	
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NUCLEAR ENERGY SERVICES, INC.

TITLE
PERRY UNITS 1 & 2
RECIRCULATION ELBOW (WELDED)
CAL. BLOCK PY-22-XX2-SS-F

SIZE FSCM NO. D 53603
DRAWING NO. 83D0805
SCALE FULL
WEIGHT

PDR RIDS

8506070477

