



NOTES:

1. ALL OF ITEM 5 ARE NOT SHOWN FOR CLARITY.
2. WELDING SHALL BE IN ACCORDANCE WITH ASME CODE SECTION IX.
3. PAINT PER SCIENTIFIC ECOLOGY GROUP, INC. SPECIFICATION STD-S-91-003.
4. LEAD FILL SHALL BE IN ACCORDANCE WITH SCIENTIFIC ECOLOGY GROUP, INC. APPROVED LEAD POURING PROCEDURE.
5. INSTALL ITEM 5 WITH HANDLE ORIENTED TO TIGHTEN BINDER AS HANDLE IS PULLED AWAY FROM SHIELD BODY.
6. LOCKWIRE PRIMARY, SECONDARY LIDS, DRAIN AND VENT REQUIRED FOR SHIPMENT.
7. TORQUE ITEM 6 NUTS TO 100 FT.-LBS. ± 10 - 0 FT.-LBS.
8. ALL WELDS SHALL BE VISUALLY EXAMINED IN ACCORDANCE WITH ASME CODE SECTION III, DIV. 1, SUBSECTION NB, ARTICLE NB-5000 AND SECTION V, ARTICLE 9.
9. CONTINUOUS WELDS ON LIFTING AND HOLD DOWN LUGS SHALL BE MAGNETIC PARTICLE OR LIQUID PENETRANT INSPECTED AFTER 125% LOAD TEST IN ACCORDANCE WITH ASME CODE SECTION III, DIV. 1, SUBSECTION NB, ARTICLE NB-5000, AND SECTION V, ARTICLE 7 OR G. ALL OTHER WELDS SHALL BE INSPECTED TO THESE REQUIREMENTS EXCEPT LOAD TEST SHALL NOT BE PERFORMED. AS AN OPTION, LONGITUDINAL SEAM WELDS MAY BE RADIOGRAPHIC INSPECTED PER ASME CODE, SECTION III, DIV. 1, SUBSECTION NB, ARTICLE NB-5000 AND SECTION V, ARTICLE 2 IN LIEU OF LP OR MP INSPECTION.
10. TORQUE BINDER STU 100/10 FTLBS.

11. WEIGHT - LBS.
EMPTY WEIGHT - 38,400 LBS.
PAYLOAD WEIGHT - 20000 LBS.
LOADED WEIGHT - 58,400 LBS.
12. ITEMS 12 AND 13 SHALL BE INSTALLED INTO ITEM 2 AND SEAL WELDED ALONG ALL EDGES. ITEMS 42-43-46 AND 47 SHALL BE INSTALLED INTO ITEM 2 AND SEAL WELDED ALONG ALL EDGES.
13. ITEMS 44 AND 45 SHALL BE ATTACHED TO ITEMS 3 AND 4 RESPECTIVELY AND SEAL WELDED ALONG ALL EDGES.
14. BINDER PINS ARE TO BE DRILLED WITH A MINIMUM DOUBLE SHEAR WELD STRENGTH OF 111% OF 125.
15. MATERIAL SHALL COMPLY WITH CRITERIA ESTABLISHED IN SECTION 3.3 NUREG CR-615.
16. THE CASK BODY AND EACH CASK LID SHALL BE MARKED IN ACCORDANCE WITH 10CFR 71.09(C) NAME PLATES AND MOUNTING BRACKETS FOR PLACARDS MAY BE WELDED TO THE CASK WITH 1/8" FILLET WELDS.
17. MATERIAL FINISH SHALL BE 125 RMS MINIMUM ON ALL SURFACES INTERFACING WITH ITEMS 20 AND 24.
18. DRILL ITEM 47 AS REQ'D FOR INSTALLATION OF ITEM 60 (OPTIONAL).
19. BENT WASHERS SHALL BE TACK WELDED TO CASK AS REQ'D FOR LANYARD.
20. GASKETS MAY BE ADHERED TO EITHER SEATING SURFACE PROVIDED THAT POSITIONING IS MAINTAINED AS DIMENSIONED.
21. ITEM 20 MAY BE MODIFIED AT THE POINT WHERE THE VENT PASSAGE EXISTS AT THE BOTTOM OF ITEM 3 AND MADE THINER THAN THE WIDTH OF ITEM 20 MAY BE REMOVED. (SEE ITEM 20 DETAIL SHG. 2)
22. AS AN OPTION 1 1/4" X 5" THREADS PER INCH NOME THREAD, 8 1/2" LG. SOCKET HEAD SCREW MAY BE USED (ITEM 34), MATERIAL TO BE ASTM A540 GRADE 588, CLASS 3 OR EQUIVALENT.

REV.	DESCRIPTION	ENG.	CHK.	DATE
0	ISSUE ENR 07-025	GA	ENR	7/28/87
1	SEE ECN 87-028	GA	ENR	10/1/87
2	SEE ECN 87-036	GA	ENR	10/1/87
3	SEE ECN 88-009	GA	ENR	1/14/88
4	SEE ECN 88-016	GA	ENR	1/14/88
5	SEE ECN 88-034	GA	ENR	1/14/88
6	SEE ECN 88-060	GA	ENR	1/14/88
7	SEE ECN 90-010	GA	ENR	1/14/88
8	SEE ECN 93-023	GA	ENR	1/14/88
9	SEE ECN 94-067	GA	ENR	1/14/88
10	SEE ECN 94-070	GA	ENR	1/14/88

ITEM	QTY	DESCRIPTION	UNIT	STANDARD	REMARKS
1	1	ROUND BAR 3/4" DIA (OPTIONAL)	ASTM-A36		
2	1	WELDED CASK BODY			
3	1	WELDED CASK LID			
4	1	DRILL LOCK PIN	3/16" DIA X 1 1/2" LONG		
5	1	DRILL LOCK PIN	3/16" DIA X 1 1/2" LONG		
6	1	DRILL LOCK PIN	3/16" DIA X 1 1/2" LONG		
7	1	DRILL LOCK PIN	3/16" DIA X 1 1/2" LONG		
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50	1	DRILL LOCK PIN	3/16" DIA X 1 1/2" LONG		

9403220221

DO NOT SCALE PRINT
TOLERANCES UNLESS NOTED
UNLESS OTHERWISE SPECIFIED
LOCAL TO 1/8" 2/32"

DATE 3-18-87
CHECKED BY [Signature]
DATE 1-6-87
DRAWN BY R.A. FAIRHEAD
DATE 7-1-87
PROJ. # 9403220221
DATE 7-1-87

THE SCIENTIFIC ECOLOGY GROUP, INC.
One Royal Tankership - U.S.A.

14-215 CASK ASSEMBLY

SIZE: E
SCALE: 1/4" = 1'-0"

REV: 10

* 9403090192

PDR RIDS

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