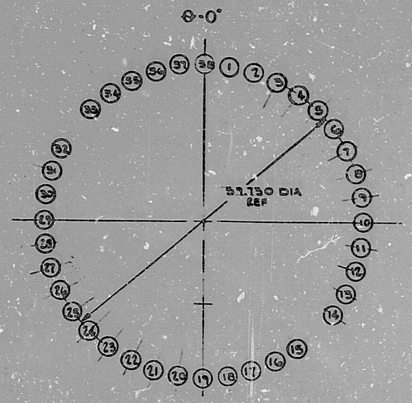
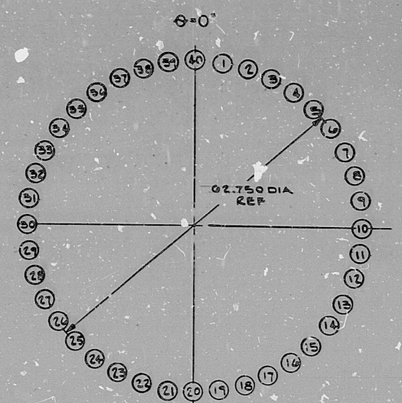


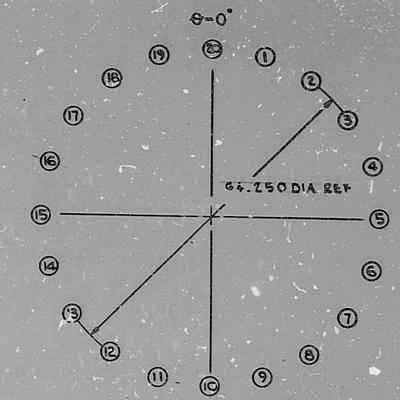
STUD IDENT. NO.	1	20	11	39	6	25	34	3	22	33	8	27	36	5	24	35	4	23	32	9	28	37	10	29	38	12	40
TENSION SEQUENCE	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
TENSILE LOAD PER STUD 33,000 LBS 1ST STAGE & 46,800 ± 4,600 LBS FINAL STAGE																																							

SRP INNER TOP STUD TENSION SEQUENCE FOR IT (19) ON SH 3 (83)



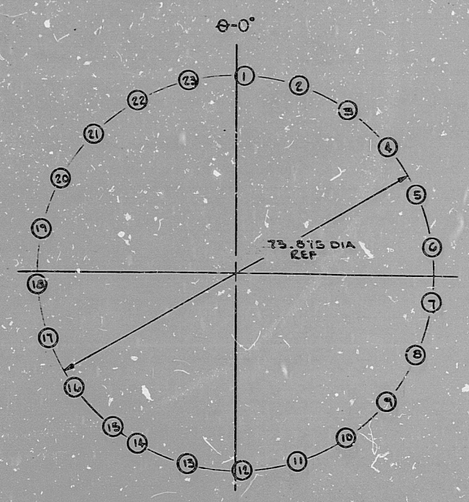
CAP SCREW IDENT NO	1	21	11	31	6	26	16	34	3	23	13	33	8	28	18	38	2	22	12	32	7	27	17	37	4	24	14	34	9	29	19	39	5	25	15	35	10	30	20	40
TORQUE SEQUENCE	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40
INCH-LBS	120 IN-LB 1ST STAGE & 155±5 IN-LB FINAL STAGE																																							

SRP SEAL RING CAP SCREW TORQUE SEQUENCE FOR IT (25) ON SH 3 (83)



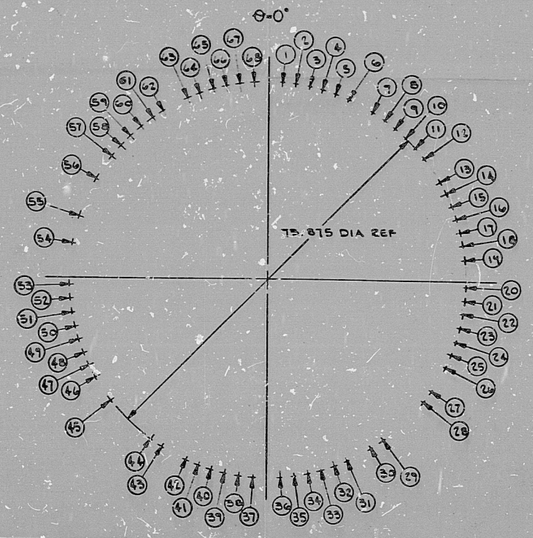
CAP SCREW IDENT NO	1	11	6	3	5	8	15	2	12	7	17	4	14	9	19	10	20	16	13	18
TORQUE SEQUENCE	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
INCH-LBS	120 IN-LB 1ST STAGE & 155±5 IN-LB FINAL STAGE																			

SRP RETAINER RING CAP SCREW TORQUE SEQUENCE (83)
ABOVE CAP SCREW (IT 08 OF DWG 766J762(G01) ARE PART OF SRP BULL GEAR ASSY IT (16)



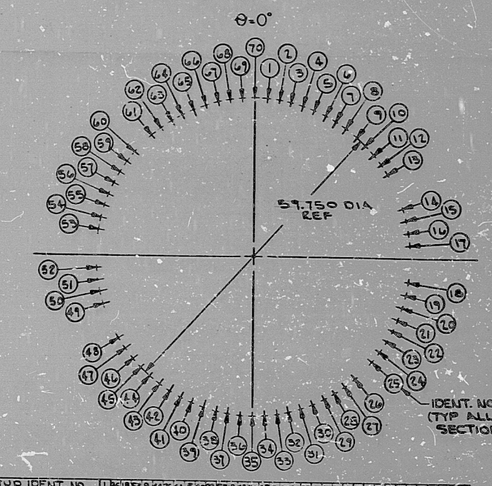
CAP SCREW IDENT NO	1	12	7	19	4	16	10	22	3	14	9	21	5	17	11	23	1	13	8	20	2	15	18	6
TORQUE SEQUENCE	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24
FT-LBS	#3 F-S 1ST STAGE & 55±2 FT-LB FUAL STAGE																							

SRP SEAL FOLLOWER CAP SCREW TORQUE SEQUENCE FOR IT (66) ON SH 10 (23)



STUD IDENT. NO.	1	35	18	52	9	43	26	60	5	39	22	56	13	47	30	64	3	37	20	54	11	45	28	62	7	41	24	58	15	49	32	66	17	51
TENSION SEQUENCE	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34
STUD IDENT. NO.	36	68	2	34	19	53	10	44	27	61	14	48	31	65	4	38	21	55	12	46	29	63	8	42	25	59	16	50	33	67	6	40	23	57
TENSION SEQUENCE	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68
TENSILE LOAD PER STUD 50,000 LBS 1ST STAGE & 55,700 ± 5,500 LBS FINAL STAGE																																		

SRP OUTER TOP STUD TENSION SEQUENCE FOR IT (47) ON SH 3 (23)



STUD IDENT. NO.	1	36	18	53	9	44	26	61	5	40	22	57	13	48	30	65	3	38	20	55	11	46	28	63	7	42	24	59	15	50	32	67	17	52
TENSION SEQUENCE	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34
STUD IDENT. NO.	69	2	37	19	54	10	45	27	62	14	49	31	66	4	39	21	56	12	47	29	64	8	43	25	60	16	51	33	68	6	41	23	58	35
TENSION SEQUENCE	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68
TENSILE LOAD PER STUD 57,000 LBS 1ST STAGE & 79,200 ± 7,900 LBS FINAL STAGE																																		

SRP INNER STUD (BASE FLG) TENSION SEQUENCE FOR IT (55) ON SH 3 (83)

Status print, uncontrolled copy transmitted to assist NRC review of CRBRP.

REVISIONS			
ZONE	DESCRIPTION		(5)
	ECN 01609 1		
E-1	127,000 LBS WAS 121,000		
H-1	53,000 LBS WAS 51,500		
K-1	30,000 LBS WAS 31,500		
	[illegible] 11-20-81		
	ECN 01762 1		(8)
E-7	TENSION SEQUENCE WAS 48,300 ± 2,200 LBS		
B-5	55,700 ± 5,500 LBS		
B-2	79,200 ± 7,900 LBS WAS 74,400 ± 3,800 LBS		
	[illegible] 11-20-81		

PRC APERTURE CARD

DFTM		CRBRP Project Office	
CHKR		Energy Research and Development Administration	
M.S. ENG.		CLINCH RIVER BREEDER REACTOR PLANT	
ENGR		Westinghouse Electric Corporation	
APJC		ADVANCED REACTORS DIVISION	
APPD		MADISON, PA	
NEXT ASSY	UPPD	REACTOR CLOSURE HEAD ASSEMBLY	
DWG DATA TYPE	APPD		
ENGINEERING RELEASE	FT APPD	DWG. NO. 1535E45	REV. 6
BY (W) A/D	SCALE 1/8		SH. 7 OF
ECN DATE	D SPEC COMMEN. PRT		

RIDS

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