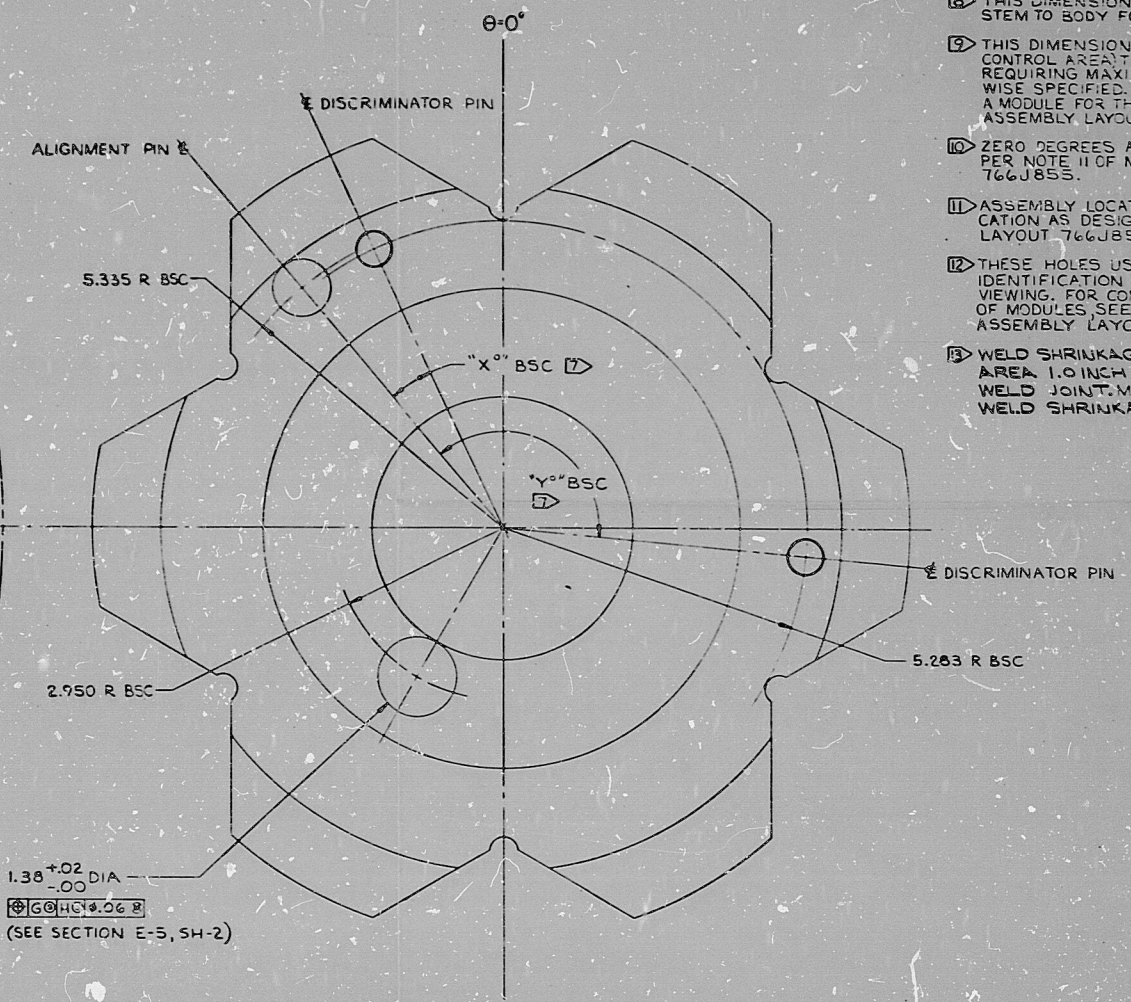
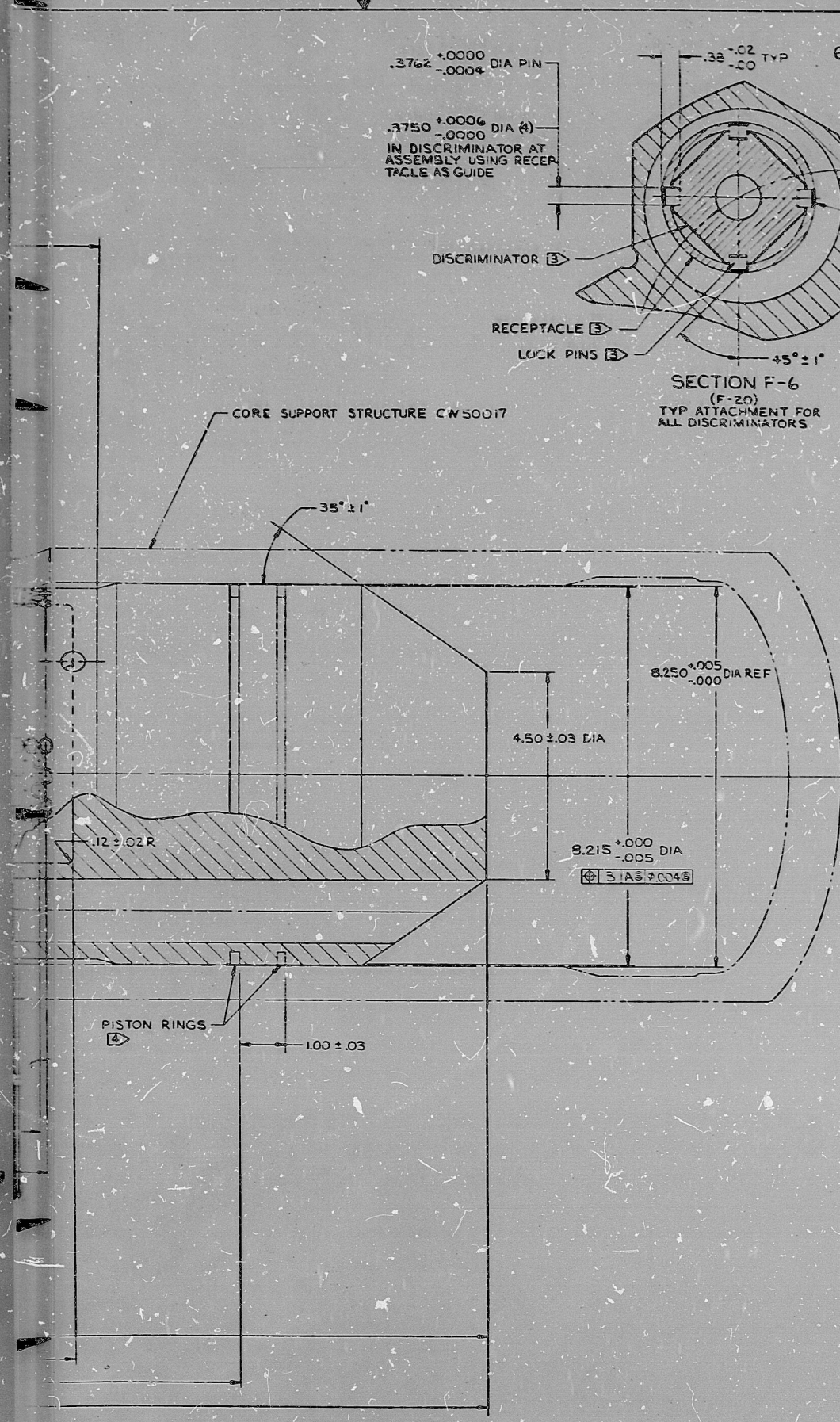




- NOTES
1. FOR SPECIFIC MODULES USING THIS LAYOUT FOR THEIR CONSTRUCTION SEE MASTER ASSEMBLY LAYOUT 766J855.
 2. ALL MATERIAL TO BE STAINLESS STEEL TYPE 304, UNLESS OTHERWISE SPECIFIED.
 3. THIS MATERIAL TO BE ASME SA-437 GRADE 718, PRECIPITATION HARDENED.
 4. PISTON RINGS SHALL BE PRECIPITATION HARDENING NICKEL ALLOY WITH A CHEMICAL COMPOSITION EQUAL TO ASME SA-437 GRADE 718, PRECIPITATION HARDENED, AND SHALL BE CHROMIUM PLATED PER NOTE 5.
 5. CHROMIUM PLATE IN ACCORDANCE WITH QQ-C-320B, CLASS 2A, .0002 TO .0004 THK.
 6. MAXIMUM EXPECTED REACTOR ASSEMBLY AXIAL MOVEMENT AT OPERATING TEMPERATURE (730°F).
 7. DISCRIMINATOR PINS LOCATED PER TABLE I MASTER ASSEMBLY LAYOUT 766J855.
 8. THIS DIMENSION USED FOR ALIGNMENT OF STEM TO BODY FOR WELDING.
 9. THIS DIMENSION FOR ASSEMBLY FLOW CONTROL AREA TYPICAL FOR AN ASSEMBLY REQUIRING MAXIMUM FLOW UNLESS OTHERWISE SPECIFIED. FOR SPECIFIC LOCATIONS WITHIN A MODULE FOR THIS CONDITION SEE MASTER ASSEMBLY LAYOUT 766J855.
 10. ZERO DEGREES AND MODULE IDENTIFICATION PER NOTE II OF MASTER ASSEMBLY LAYOUT 766J855.
 11. ASSEMBLY LOCATION, REFERENCE IDENTIFICATION AS DESIGNATED ON MASTER ASSEMBLY LAYOUT 766J855.
 12. THESE HOLES USED FOR SPECIFIC MODULE IDENTIFICATION FOR UNDER SODIUM VIEWING. FOR COMPLETE IDENTIFICATION OF MODULES SEE TABLE III, MASTER ASSEMBLY LAYOUT 766J855.
 13. WELD SHRINKAGE IS PERMITTED IN AN AREA 1.0 INCH EITHER SIDE OF THE WELD JOINT. MAXIMUM ALLOWABLE WELD SHRINKAGE IS .030 DIAMETRAL.

REVISION	DESCRIPTION
1	ECN-254 ECP-W-1808
2	ECN-254 ECP-W-1808
3	ECN-254 ECP-W-1808
4	ECN-254 ECP-W-1808
5	ECN-254 ECP-W-1808
6	ECN-254 ECP-W-1808
7	ECN-254 ECP-W-1808
8	ECN-254 ECP-W-1808
9	ECN-254 ECP-W-1808
10	ECN-254 ECP-W-1808
11	ECN-254 ECP-W-1808
12	ECN-254 ECP-W-1808

PRC
APERTURE
CARD

LCR-77-365

CLINCH RIVER
BREEDER REACTOR PLANT
DWG NO. 766J667
REV 12 SHEET 1
FRAME 2

SCALE 1/1		FOR REFERENCE ONLY	
DATE	BY	DATE	BY
10/12/77	REV 12	10/12/77	REV 12
ENGINEERING RELEASE BY		ENGINEERING RELEASE BY	
SCALE 1/1		SCALE 1/1	
DWG NO. 766J667		DWG NO. 766J667	
REV 12		REV 12	
SHEET 1		SHEET 1	
FRAME 2		FRAME 2	

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