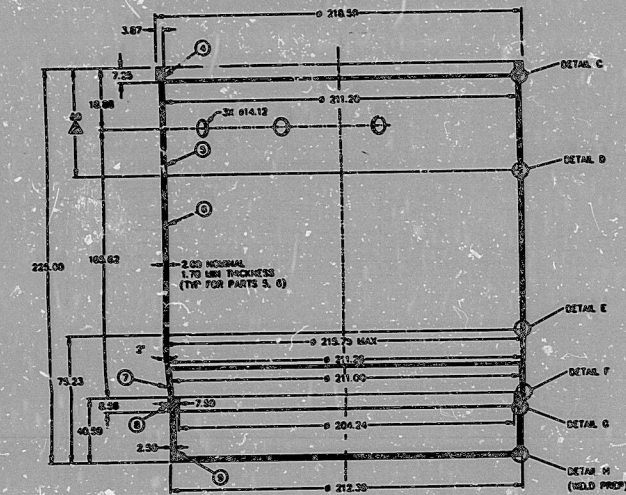


- NOTES:
1. CORE SPRAY SPARGER ASSEMBLY, INTERNAL AND EXTERNAL BRACKET/PAGE ARE NOT SHOWN FOR CLARITY.
 2. ALL DIMENSIONS ARE NOMINAL.
 3. DIMENSIONS ARE FOR FINAL FINISHED PARTS UNLESS OTHERWISE NOTED.



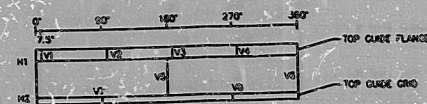
- NOTES:
1. DIMENSIONS ARE FOR FINAL FINISHED PARTS UNLESS OTHERWISE NOTED.
 2. THIS FINISHED MACHINED DIMENSION IS NOT REFLECTED ONLY THE ROUGH MACHINED DIMENSION IS NOTED.

PART NUMBER	PART NAME	QUANTITY	TYPE	MATERIAL	PLATE CERTIFICATE NUMBER	CERTIFY CONTENT -- 2
1	TOP GUIDE FLANGE	4 PIECES	ASME SA-240 304L HEAD	2300-1A		0.011
2	TOP GUIDE SHELL	2 PIECES	ASME SA-240 304L HEAD	2373-1A		0.015
3	TOP GUIDE COIL	2 PIECES	ASME SA-240 304L HEAD	2373-1A		0.015
4	SHROUD UPPER RING	1 PIECE	ASME SA-240 304L HEAD	2373-1A		0.012
5	SHROUD UPPER MID CYLINDER	2 PIECES	ASME SA-240 304L HEAD	2373-1A		0.016
6	SHROUD CENTRAL LOWER CYLINDER	2 PIECES	ASME SA-240 304L HEAD	2373-1A		0.017
7	SHROUD LOWER RING	4 PIECES	ASME SA-240 304L HEAD	2373-1A		0.016
8	SHROUD LOWER CYLINDER	2 PIECES	ASME SA-240 304L HEAD	2373-1A		0.015

GRAND GULF 1 SHROUD AND TOP GUIDE DATA

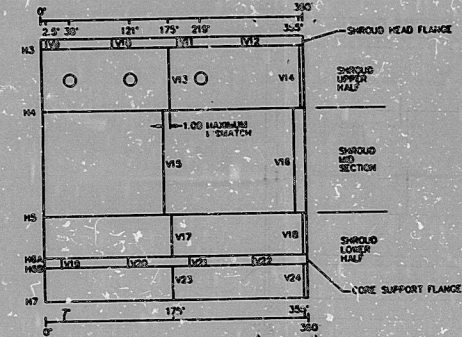
HORIZONTAL WELD	WELD NO.	WELD NO.	WELD NO.
WELD NO.	DETAIL NO.	WELD NO.	WELD NO.
H1	DETAIL A	AS 1.2-BA	128
H2	DETAIL B	AS 1.2-BA	128
H3	DETAIL C	AS 1.2-BA	128
H4	DETAIL D	AS 1.2-BA	128
H5	DETAIL E	AS 1.2-BA	128
H6	DETAIL F	AS 1.2-BA	128
H7	DETAIL G	AS 1.2-BA	128
H8	DETAIL H	AS 1.2-BA	128

- NOTES:
1. POSSIBLE CYLINDER WALL MISMATCH MAY EXIST AT WELD JOINT 128.
 2. ALL WELD PREPARATION DETAILS USED ARE NOMINAL DIMENSIONS.
 3. WELD PREPARATIONS FOR HORIZONTAL WELD DETAILS ARE SHOWN FROM THE TOP EXCEPT FOR HORIZONTAL WELD NO. H2.



TOP GUIDE SURFACE DEVELOPMENT

- NOTES:
1. ADDITIONAL LOCATION OF THE VERTICAL WELDS IN THE FABRICATED TOP GUIDE ARE SHOWN.
 2. SEVERAL HOLE PATTERNS ARE LOCATED IN THE TOP GUIDE FLANGE. THE FIRST HOLE IS LOCATED AT 2".
 3. A 90 HOLE PATTERN IS LOCATED IN THE TOP GUIDE WRO FLANGE. HOLE HOLE IS LOCATED AT 17". THIS HOLE PATTERN ORIENTS THE TOP GUIDE TO THE SHROUD.



SHROUD SURFACE DEVELOPMENT

- NOTES:
1. ADDITIONAL LOCATION OF THE LONGITUDINAL WELDS FOR THE SHROUD ARE NOT SHOWN ON THE EXISTING DOCUMENTATION.
 2. A 90 HOLE PATTERN IS LOCATED IN THE SHROUD HEAD FLANGE. HOLE HOLE IS LOCATED AT 17". THIS HOLE PATTERN ORIENTS THE TOP GUIDE TO THE SHROUD.

VERTICAL WELD	WELD NO.	WELD NO.	WELD NO.
WELD NO.	DETAIL NO.	WELD NO.	WELD NO.
V1	DETAIL A	AS 1.2-BA	128
V2	DETAIL B	AS 1.2-BA	128
V3	DETAIL C	AS 1.2-BA	128
V4	DETAIL D	AS 1.2-BA	128
V5	DETAIL E	AS 1.2-BA	128
V6	DETAIL F	AS 1.2-BA	128
V7	DETAIL G	AS 1.2-BA	128
V8	DETAIL H	AS 1.2-BA	128
V9	DETAIL I	AS 1.2-BA	128
V10	DETAIL J	AS 1.2-BA	128
V11	DETAIL K	AS 1.2-BA	128
V12	DETAIL L	AS 1.2-BA	128
V13	DETAIL M	AS 1.2-BA	128
V14	DETAIL N	AS 1.2-BA	128
V15	DETAIL O	AS 1.2-BA	128
V16	DETAIL P	AS 1.2-BA	128
V17	DETAIL Q	AS 1.2-BA	128
V18	DETAIL R	AS 1.2-BA	128
V19	DETAIL S	AS 1.2-BA	128
V20	DETAIL T	AS 1.2-BA	128
V21	DETAIL U	AS 1.2-BA	128
V22	DETAIL V	AS 1.2-BA	128
V23	DETAIL W	AS 1.2-BA	128
V24	DETAIL X	AS 1.2-BA	128

- NOTES:
1. VERTICAL WELD PREPARATIONS FOR THE RINGS AND THE CYLINDERS ARE NOTED FROM THE TOP OF THE SHROUD ON THE DRAWING.
 2. ALL WELD PREPARATION DETAILS USED ARE NOMINAL DIMENSIONS.
 3. WELD PREPARATIONS FOR ORO PLATE SQUARE HOLES ARE OMITTED FOR CLARITY.

9408290384

ANSTEC APERTURE CARD

PRELIMINARY PRINT FOR REVIEW ONLY

SHROUD FABRICATED BY: WILLAMETTE
FOR ANSTEC, FABRICATED DATA SEE REPORT DATE 7/16/79-0004
WFL ITEM NO. 853-200

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PDR RIDS

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