



BILL OF MATERIAL				IDENT. GROUP	
ITEM	QTY	PART NAME	SIZE REFERENCE INFORMATION	GROUP	EST. WT.
01	1	CELL ASSY.		6130E38001	54.7256
02	1	FILL ASSY.		6130E39002	18.515
03	1	FILL ASSY.		6130E39003	1.1
04	1	GRID ASSY.		6130E35001	1.1
05	1	GRID ASSY.		6130E35002	1.1
06	1	BASE ASSY.		6130E37001	1.1
07	1	BASE ASSY.		6130E37002	1.1

- NOTES:
- FABRICATE PER PS 80314 JS.
 - AFTER COMPLETION OF ALL WELDING, THE DATUM WALLS (J & K) OF EACH CELL SHALL BE VERTICAL WITHIN .08. THE DATUM WALLS OF EACH CELL ARE DEFINED AS THE TWO SIDES NEAREST THE RACK ASSEMBLY IDENTIFICATION NO.
 - AFTER COMPLETION OF THE RACK ASSEMBLY EACH STORAGE CELL MUST BE CAPABLE OF ACCEPTING WITHOUT RESTRICTION A FREEPATH GAGE 8.210" X .040" SQUARE WITH .060" X .015" CORNER CHAMFERS X 178.00 MIN. LONG, AND A SQUARE PLATE GAGE 8.320" X .040" X .015" CORNER CHAMFERS FULL LENGTH.
 - IMPRESSION STAMP IDENTIFICATION NO., DRAWING & GROUP NO. IN THIS AREA USING .50 (MIN.) CHARACTERS PER PS 83862KF.
- A.C. S. []
- A.C. R. []
- AT RACK ASSEMBLY ALIGN UPPER GRID ASSEMBLY AND BASE ASSEMBLY TO ENSURE THAT THE NORTH ARROWS STAMPED ON BOTH ASSEMBLIES ARE POINTING IN THE SAME DIRECTION. THE ENVELOPE OF THE TOP GRID MUST BE WITHIN THE VERTICAL PROJECTION OF THE RACK ENVELOPE AT THE BOTTOM WITHIN .300.
 - CLEAN PER PS 82311 MW. AFTER ASSEMBLY.
 - CONTROL AS NECESSARY TO PROVIDE A MINIMUM FLAT DIMPLE SURFACE AT BOTTOM GRID INTERFACE FOR CELL-TO-GRID WELDING.
- A.C. NO. []

NON-PROPRIETARY

PRC
APERTURE
CARD

8303160399

GROUP-1,2 & 3
SCALE-1:10

3	7843
7	17239
	17715
GROUP	LB.

EST. WT.	
6130E4102	
SPIN-FHSES	

PS 80314 JS
REVISIONS
DATE
BY

DESIGNED BY
CHECKED BY
DATE

APPROVED BY
DATE

GROUP 1, 2 & 3

SFR.CHW.6130E4102.01.S1.021983

RWD

8303160399

