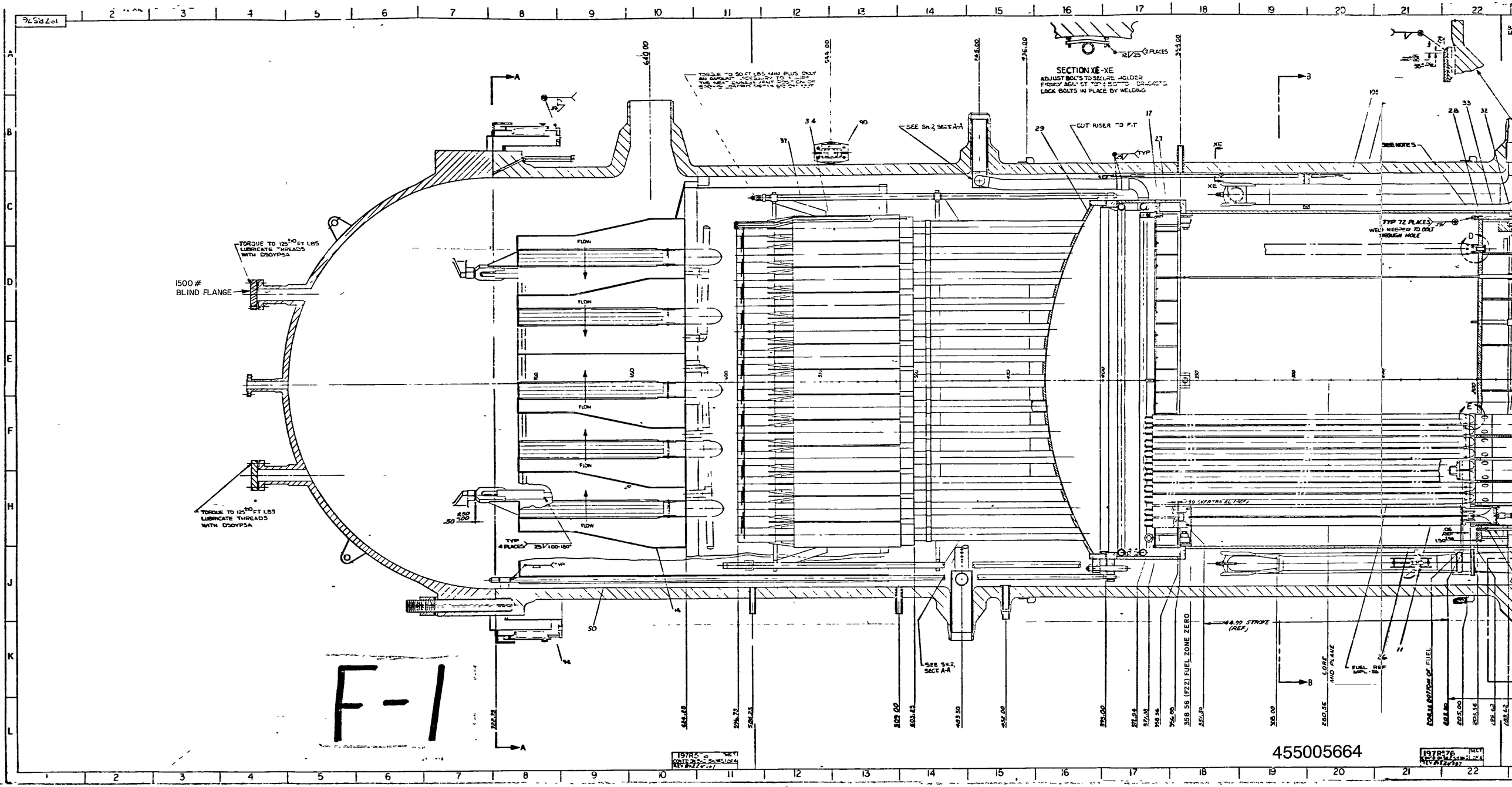
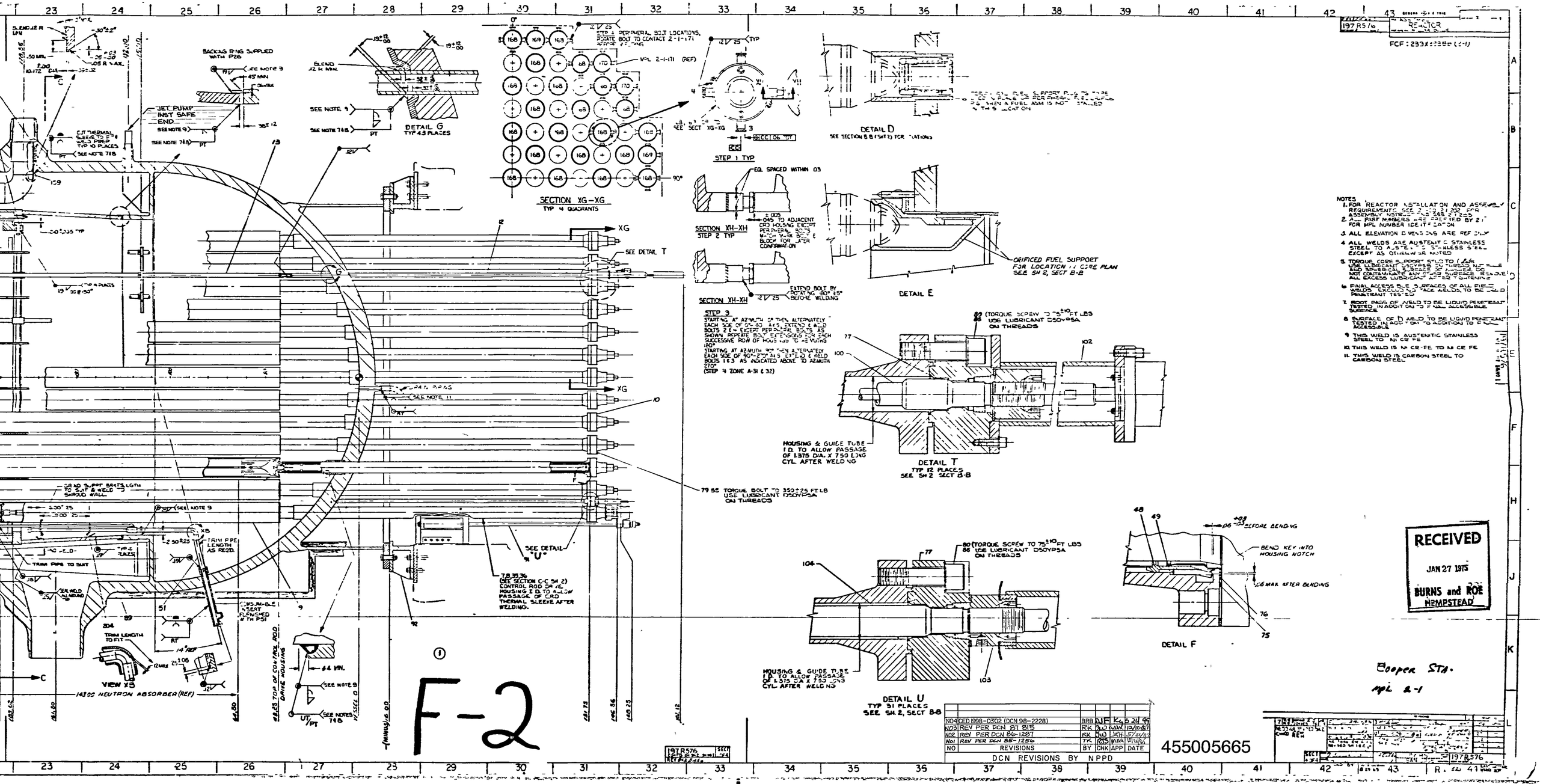

SECTION XE-XE
ADJUST BOLTS TO SECURE HOLDER
LOCK BOLTS IN PLACE BY WELDING
12/25 (2 PLACES)
TORQUE TO 50 FT LBS MIN. PLUS ONLY AN AMOUNT NECESSARY TO ALIGN THE NEAT ENGAGEMENT POINT FOR CONTACT
CUT RISER TO FIT
SEE SH.3, SECT A-A
SEE SH.2, SECT A-A
TORQUE TO 125 +10 FT LBS
LUBRICATE THREADS WITH DSOYPSA
1500 # BLIND FLANGE
FLOW
TYP 4 PLACES
TYP 12 PLACES
WELD KEEPED TO DOT THROUGH HOLE
SEE NOTES
50 OVERTRAVEL (REF)
48.00 STROKE (REF)
358.56 (FZ2) FUEL ZONE ZERO
CORE MID PLANE
FUEL REF
BOTTOM OF FUEL
455005664
F-1


SECTION XG-XG
TYP 4 QUADRANTS
DETAIL G
TYP 43 PLACES
DETAIL D
SEE SECTION B-B (SHT 2) FOR LOCATIONS
STEP 1 TYP
SECTION XH-XH
STEP 2 TYP
SECTION XH-XH
STEP 3
DETAIL E
ORIFICED FUEL SUPPORT FOR LOCATION IN CORE PLAN SEE SH 2, SECT B-B
DETAIL T
TYP 12 PLACES
SEE SH 2 SECT B-B
HOUSING & GUIDE TUBE I.D. TO ALLOW PASSAGE OF 1.375 DIA. X 7.50 LONG CYL. AFTER WELDING
DETAIL U
TYP 31 PLACES
SEE SH. 2, SECT B-B
DETAIL F
BEND KEY INTO HOUSING NOTCH
.06 MAX AFTER BENDING
BEFORE BENDING
JET PUMP INST SAFE END
BACKING RING SUPPLIED WITH P26
DETAIL G
TYP 43 PLACES
SEE DETAIL T
SEE DETAIL "U"
79 85 TORQUE BOLT TO 350±25 FT LB USE LUBRICANT DSOYPSA ON THREADS
82 (TORQUE SCREW TO 75±10 FT LBS USE LUBRICANT DSOYPSA ON THREADS
80 (TORQUE SCREW TO 75±10 FT LBS USE LUBRICANT DSOYPSA ON THREADS
78 83 86 (SEE SECTION C-C SH 2) CONTROL ROD DRIVE HOUSING I.D. TO ALLOW PASSAGE OF CRD THERMAL SLEEVE AFTER WELDING.
VIEW X3
14302 NEUTRON ABSORBER (REF)
TRIM PIPE LENGTH AS REQ'D.
TRIM PIPE TO SUIT
GRAD SUPPORT BRKTS LGTH TO SUIT & WELD TO SHROUD WALL
SEAT FLANGED WITH P51
TRIM LENGTH TO FIT
44 MIN.
SEE NOTE 9
SEE NOTES 74B
48.25 TOP OF CONTROL ROD DRIVE HOUSING
F-2
RECEIVED
JAN 27 1973
BURNS and ROE
HEMPSTEAD
Cooper STA.
NOTES
1. FOR REACTOR INSTALLATION AND ASSEMBLY REQUIREMENTS SEE 2-302-21-302 FOR ASSEMBLY INSTRUCTIONS 2-365-21-203
2. ALL PART NUMBERS ARE PREFIXED BY 21 FOR MPL NUMBER IDENTIFICATION
3. ALL ELEVATION DIMENSIONS ARE REF ONLY
4. ALL WELDS ARE AUSTENITIC STAINLESS STEEL TO AUSTENITIC STAINLESS STEEL EXCEPT AS OTHERWISE NOTED
5. TORQUE CORE SUPPORT STUD TO 1,600 USE LUBRICANT DSOYPSA ON THREADS, NUT FACE AND SPHERICAL SEATS. DO NOT LUBRICATE ANY OTHER SURFACE REMOVE ALL EXCESS LUBRICANT AFTER TORQUING
6. FINAL ACCESSIBLE SURFACES OF ALL FIELD WELDS, EXCEPT BACK WELDS, TO BE LIQUID PENETRANT TESTED
7. ROOT PASS OF WELD TO BE LIQUID PENETRANT TESTED IN ADDITION TO FULL ACCESSIBLE SURFACE
8. SURFACE OF D WELD TO BE LIQUID PENETRANT TESTED IN ADDITION TO FULL ACCESSIBLE
9. THIS WELD IS AUSTENITIC STAINLESS STEEL TO NI CR FE
10. THIS WELD IS NI CR-FE TO NI CR FE
11. THIS WELD IS CARBON STEEL TO CARBON STEEL
NO4 CED 1998-0302 (DCN 98-2228)
NO3 REV PER DCN RT 815
NO2 REV PER DCN 86-1297
NO1 REV PER DCN 85-1286
NO REVISIONS BY CHK APP DATE
DCN REVISIONS BY NPPD
455005665
197R576