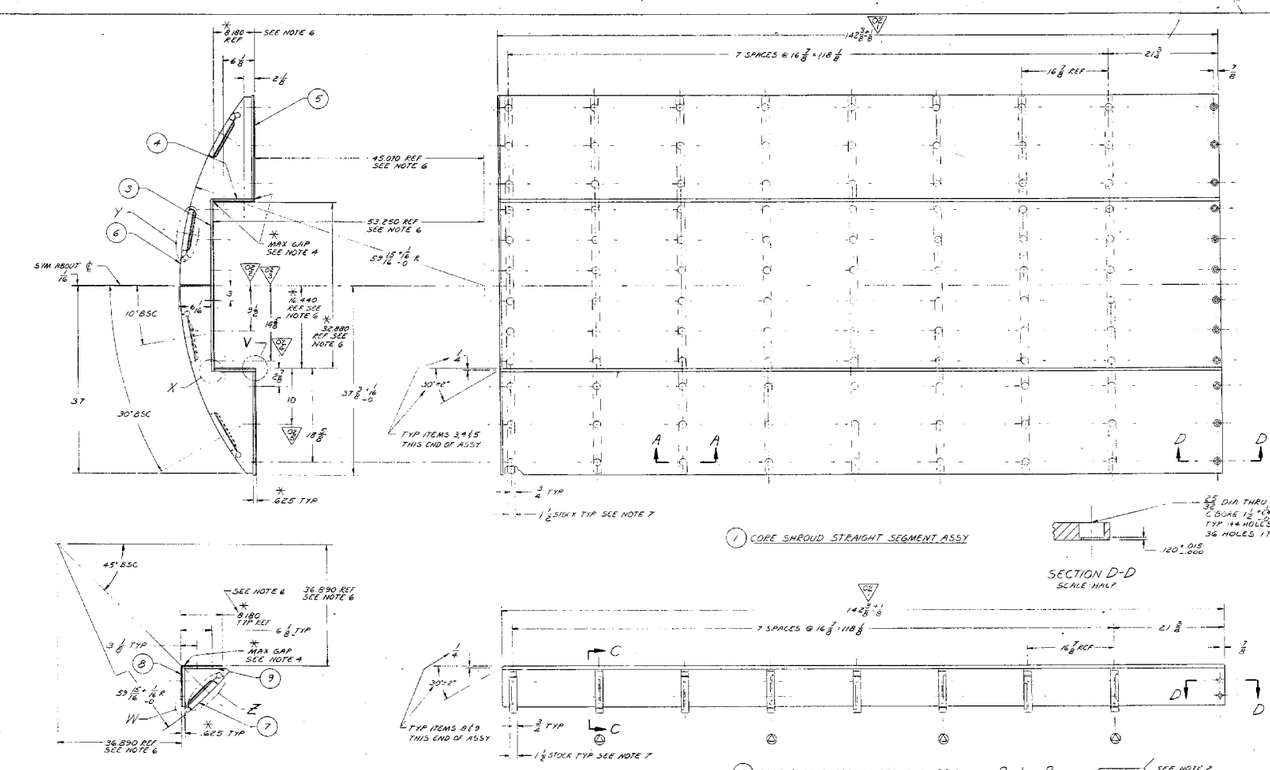

1 CORE SHROUD STRAIGHT SEGMENT ASSY

2 CORE SHROUD CORNER SEGMENT ASSY

SECTION A-A
SEE NOTE 6
APPLICABLE TO ASSY 2
SCALE: FULL

SECTION B-B
SCALE: 2/1

SECTION D-D
SCALE: HALF

SECTION C-C
TYP AT LOCATIONS MARKED ⓒ

VIEW V
SCALE: FULL

DETAIL W
SCALE: FULL

VIEW X
SCALE: FULL

DETAIL Z
FOR ALL OTHER DIMENSIONS & INFO. SEE DETAIL Y
SCALE: HALF

DETAIL Y
APPLICABLE TO ALL SLOTS EXCEPT FOR ORIENTATIONS & AS NOTED ON DETAIL Z
SCALE: HALF

BILL OF MATERIALS
QUANTITIES ARE FOR:

GROUP NO. & QUANTITY 6	5	4	3	2	1	ITEM NO.	NAME	PIECE NO.	MATERIAL	REMARKS
					X	1	CORE SHROUD STRAIGHT SEGMENT ASSY	J-23866-164-025		
				X		2	CORE SHROUD CORNER SEGMENT ASSY	-026		
					1	3	SHROUD PLATE	-001	SEE NOTE 10	
				2		4	SHROUD PLATE	-002	"	
				2		5	SHROUD PLATE	-003	"	
					16	6	CENTERING PLATE	-004	SEE NOTE 11	
			8			7	CENTERING PLATE	-005	SEE NOTE 11	
				1		8	SHROUD PLATE	-006	SEE NOTE 10	
				1		9	SHROUD PLATE	-007	SEE NOTE 10	
			32	108		10	FINISHED HEX BOLT	-008	SEE NOTE 5	3/4-10UNC-3A x 4 1/2 LONG
			32	128		11	DOWEL PIN	-009	SEE NOTE 12	.188 DIA X 1 3/4 LONG

ALL ITEMS DEPICTED ON THIS DRAWING ARE WITHIN LICENSE RENEWAL SCOPE.

FOR INFORMATION ONLY

NOTE: THIS PRINT IS TO BE USED FOR THE FCS LICENSE RENEWAL PROJECT ONLY. IT MAY NOT REFLECT THE MOST CURRENT REVISION OF THIS DRAWING.

12. MATL: ASTM A-276 GR 304 SPT-2 WRAP
11. MATL: ASTM A-240-63 SPT-1 WRAP
10. MATL: ASTM A-240 GR 304 SPT-2 CRA
9. MATL ASTM A-193-66 SPT-1
8. LOCATION OF BOLT HOLES TO BE ± 1/64
7. STOCK MILL TOLERANCE PER SECTION III OF ASME BOILER & PRESSURE VESSEL CODE
6. THIS DIMENSION IS REF, ASSY MUST FALL WITHIN PROJECTED 3-SPACE ENVELOPE DICTATED BY TOLERANCE FOR DETAIL SHOWN ON DWG J-23866-164-011
5. ⅜ INDICATES AS BUILT DIMENSIONS ARE TO BE RECORDED PER CENPD SPEC 23866-16-401-1
4. LOCAL GAPS ON BUTTED SURFACES OF ALL SHROUD PLATES MUST NOT EXCEED .010
3. BOLTS & MATING THREADS MUST BE NEOLUBED PRIOR TO INSTALLATION & FINAL TORQUING
2. PRODUCT TO BE IN ACCORDANCE WITH CENPD SPEC 23866-16-401-1
1. DIMENSIONING & TOLERANCING PER USASI YN 5-1966

J-23866-164-025 1
J-23866-164-025 05

EA-FC-00-134 DF 1201

CERTIFIED FOR CONSTRUCTION

OFFICE COPY

OMAHA PUBLIC POWER DISTRICT
FORT CALHOUN UNIT NO. 1

REV.	DESCRIPTION	BY & DATE	CHK'D & DATE	ENG. APPR. & DATE
02	VENTED PER REV. REQ. 23866	PJB 1-6-67	R.M.C. 1-6-67	
	SEAM ITEM 10 MADE "NOT SEAL WELDED" PER REV. REQ. 23866-189	DOC. 8-21-68	R.M.C. 8-21-68	

REV.	DESCRIPTION	BY & DATE	CHK'D & DATE	ENG. APPR. & DATE
03	ADDED CALC. MST PER REV. REQ 23866-01	D.W. 10-4-68	R.M.C. 10-4-68	
04	1) ZONE H-A AND B-G WAS 19 3/4 PER REV. REQ 23866-79 2) ZONE G-B WAS 9" (3) ZONE G-B WAS 10 3/4 ZONE E-B WAS 2 3/8 (2) ZONE C-D WAS 11 7/8 PER REV. REQ. 23866-02	PJB 5-8-69	R.M.C. 5-8-69	
05	GENERALLY REVISED PER REV. REQ. 23866-80	WAS 11-7-69	R.M.C. 11-7-69	
06	1) SECTION A-A 30° CSK ADDED PER REF REQ 23866-86	WAS 12-10-69	R.M.C. 12-10-69	

TOLERANCES UNLESS OTHERWISE SPECIFIED			
DIMENSIONS	UNDER 6	6 - 18	OVER 18
DECIMAL DIMS.	±.005	±.008	±.010
FRACTIONAL DIMS	±1/64	±1/32	±1/16
FINISH (MICRO-INCHES)	ANGLES ± 1/2°		
THREADS-UNIFIED 2A-2B	CHAMFER ± 1°		
BREAK CORNERS-.064 MAX. RAD. OR CHAMFER			
FILLETS-1/64 TO 1/32 RADIUS			
TEMPERATURE 18 INCHES BASED ON 68°F (20°C)			

NEXT ASSY:	J-23866-164-011
FINAL ASSY:	
SUPERSEDES:	
SUPERSEDED:	
DO NOT SCALE DWG.	CALC. WT.:
SCALE: EIGHTH	ACT. WT.:

THIS DRAWING IS THE PROPERTY OF COMBUSTION ENGINEERING, INC. NUCLEAR WINDSOR, CONNECTICUT AND IS NOT TO BE REPRODUCED, OR LENT OR DISCLOSED DIRECTLY OR INDIRECTLY NOR USED FOR BY AGREEMENT WITH SAID COMPANY.

PREPARED UNDER ART CONTRACT | CODE CONTRACT 23866

DRAWN BY: W. SHARP	10-28-68	
CHECKED: R.M.C.	10-29-68	
APPROVED: W.P.S.	10-31-68	
ENGINEER: R.M.C.	10-31-68	
ENGINEER: R.M.C.	11-7-69	
ENGINEER: R.M.C.	12-10-69	

CORE SHROUD ASSEMBLIES

J-23866-164-025 05

SHEET OF REV.