S.O. SV-62530

	1	ORIGINAL
5	1	12-V-668-R CHANGE LGTH ITEM 5 FROM 44 TO 47 3/8" LONG H. MILLER 7-9-51
	2	12-V-668-R SECTION C-C, SECTION F-F, TWO LOADING EDGE DIMENSIONS CHANGED TO AGREE WITH PRESENT DATA. REVISION NOTE 3 (MAY 30-52) L. TRAUB 7-30-52
	3	12-V-668-R THE MACHINED BORE FOR GLAND RING FROM 11'-8" DIA. TO 11'-8 1/8" DIA. TO AGREE WITH ORIGINAL DESIGN. NOTE #3 WAS ADDED TO ASSURE OF FACING MACHINE TOOLS IN MAKING CUT. THIS WILL NOT AFFECT CLEARANCE FOR GLAND RING. SEE SHEET #2 OF DWG. 12-V-668-R. R. F. STOLL 8-27-52
	4	12-V-668-R Added 1 Dwg. 30 and 20. L. TRAUB 8 Nov. 52
	5	12-V-668-R ADDED CHAMFER 3/4 x 45° I.D. TO INLET END OF BORE. ADDED DRAIN GROOVE THRU BORE. R. F. STOLL 3-22-53
	6	CHG'D 2 - 8 TAP CL. 7 TO CL. 5. ADDED NOTE TO FLANGE: "DRILL FOR DOWELS" SEE "G" LETTER SV-7389 5-22-53 RODRIGUES
	7	12-V-668-R REMOVED NOTE 5 DEPTH OF COUNTERBORE WAS 4" REG CONN 6-13-53
	8	12-V-668-R "G" LETTER "G" LETTER SV-7389
21		ADDED IT. 21 ADDED NOTE — USE GLAND RING SEGMENT DWG. SV-5C-58 AS DRILL JIGS. E. ZEIS 8-26-53 Rodriguez

(21) 8 HOLES - 15/32 DRILL - 1 1/2 DEEP ▲ REAM FOR 1/2 DOWEL PIN (TIGHT FIT) LOCATE FROM GLAND RING SEGMENTS DWG. SV-5C-56 ▲

36 HOLES 2 1/16 DRILL - 1/4 DEEP TAP 3/8"-10 CL. 3B USE GLAND RING SEGMENTS DWG. SV-5C-58 AS DRILL JIGS. ▲

80 HOLES TOTAL - STRADDLE ℄ 12 HOLES - 21/32 DRILL THRU C'BORE 1 1/16 DIA. x 1/2 DEEP 4 HOLES - 2 1/8 DRILL - 3/4 DEEP THD 1/4-8 CL. 3 B (SPOTFACE - MAY SIDE - TO 3 "MANAGE THICKNESS)

5'-3 1/2" D.A. B.C.

11'-3 1/2" DIA. B.C.

2 HOLES - WITH UPPER FLANGE MATES ASSEMBLED. DRILL FOR 3/4 TAPER DOWEL. COUNTERBORE 1 1/8 DIA x 2 1/4 DEEP AND REAM FOR 3/4 TAPER DOWEL. 7/8 DIA SPOTFACE TO TRUE UP ONLY

16 HOLES - 21/32 DRILL THRU SPACE 4 1/8 DIA TO TRUE I.D. ONLY

SECTION E-E

6 EQUAL SPACES @ 5° EACH = 30°

6 EQUAL SPACES @ 5° EACH = 30°

5'-7 7/8" 5'-7 7/8" 5'-10" 5'-10"

11'-8" DIA. (REF.)

10'-7.010" DIA. 10'-7.015

5'-8" DIA. (REF.)

5'-1.750 DIA. 5'-1.770

5'-0.026" DIA. 5'-0.023"

10'-10 1/2" TO ℄ OF GASKET GROOVE

SEE DETAIL OF GASKET GROOVE

5'-0"

4'-5 3/8"

TO DEPTH OF SPOTFACE

END OF SPLITTER

10'-6" DIA (REF.)

4 HOLES - 2 1/4" DRILL THRU

4 HOLES - 1 1/8" DRILL THRU

CUT A SPIRAL GROOVE FULL CENTRALLY FOR 3/16 WIRE 12 m LEAD

6 HOLES - 3/4 DRILL THRU (STRADDLE ℄'S)

ONE HOLE - 2 3/4 DRILL THRU - 2" PIPE TAP

2 HOLES - 1 3/4 DRILL THRU

5'-6" DIA

5'-8.005" DIA. 5'-8.010"

6'-6" DIA (REF.)

GASKET GROOVE IN EACH FLANGE OF JOINT (ONE FLANGE ONLY SHOWN)

VIEW B-B

5'-3 3/4" FROM ℄ OF VALVE

3'-4"

5'-1 1/2"

5'-4"

30°

SYM. ABOUT ℄

6'-1" DIA. B.C.

44 HOLES - EQUALLY SPACED (44 HOLES TOTAL ON PULL CIRCLE)

44 HOLES - DRILLED AS SHOWN 3/4 DRILL - 3/4 DEEP THD 1 1/4-6 THD. CL. 3 B

HALF-SECTION A-A

SECTION D-D

11'-8" DIA.

6'-0 5/8" DIA. (SEE NOTE 2)

END OF SPLITTER

6'-6 7/8" DIA. (SEE NOTE 2)

10'-8 1/2" DIA.

MACHINED WELDMENT (SEE NOTE #3)

SECTION C-C

4 SPLITTERS EQUALLY SPACED

5'-11.062" DIA 5'-11.067 (SEE NOTE #3)

DETAIL OF GASKET GROOVE

18 HOLES - 3/8 DRILL THRU

9 EQUAL SPACES @ 5/8" DIA = 6'-4 5/8"

4 HOLES - 1/8 DRILL THRU

APPARATUS 84" HOLLOW JET VALVE

BODY OUTLET SECTION

DWG SV-1J-168 SUB-DWG SV-1J-1678

SYM. ITEM	DESCRIPTION — MATERIAL DIMENSIONS IN INCHES	PART No. OR DWG.	P.N. OR UNIT NO.	PATTERN	QTY. CR	FINISH CUST.		
1	FLANGE - HALF	SV-1J-5770 (Rev 1)	1		2	1	1	1
2	OUTER CYLINDER - HALF	SV-1J-5810 (Rev 1)	1		2	1	1	1
3	STIFFENER PLATE - HALF	SV-1J-5770 (Rev 1)	1		2	1	1	1
4	SPLITTERS	SV-1J-5764 (Rev 1)	1		6	1	1	1
5	SLIDE FLANGE	SV-1J-5761 (Rev 1)	1		2	1	1	1
6	STUD BOLTS 2 1/4-8 x 10 1/2 LG.	SV-1J-5781 (Rev 1)	3		36	1	1	1
7	NUT, HEX REG. 2 1/4-8		3		36			
8	TAPER DOWEL 3/4 (CONICAL)	SV-1J-5769 (Rev 1)	1		2			
9	NUT, HEX REG. 3/4-10 NC-3		3		2			
10	SCREW-SOCKET HD CAP 1 1/8-7 x 2 3/4 LG.		3		2			
11	GASKET (AS USED IN JOINT)		3		2			
12	STUD BOLTS 1 1/8-7 x 12		3		12			
13	PLATE BRACKET	SV-5C-5810 (Rev 1)	1		1			
14	INNER CYL. OF FLANGE	SV-1J-5771 (Rev 1)	1		1			
15	GASKET GROOVE RING 1/8 x 2 3/16		1		1			
16	CAP SCREW SOCKET HD 1 1/8-7 x 3 1/2 LG.		3		12			
17	NUT, HEX - "JAMB" 1 1/8-7 THD		3		12			
18	CAP SCREW SOCKET HD 3/8-16 x 1 1/4 LG.		3		18			
19	WASHER - "BELLEVILLE" 3/8-10		3		18			
20	SLIDE FLANGE	SV-1J-5760 (Rev 1)	1		2			
21	DOWEL PIN 1/2 DIA. x 2 1/2 LG.	G-1755	3		8			

#1. WELDING TO BE IN ACCORDANCE WITH ⓦ PROCESS SPEC. № 602885.

#2. WITH ITEMS 1 & 21 INSTALLED AND BORE BORING TO DIAMETERS SHOWN ON MACHINED WELDMENT - DWG. SV-1J-5761 IN ACCORDANCE WITH ⓦ PROCESS SPECIFICATION 602894.

WESTINGHOUSE ELECTRIC CORPORATION

TITLE BODY OUTLET SECTION

SV-1J-168