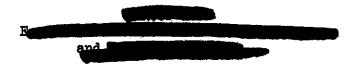
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2.1 E-N DEMONSTRATION LOAD

by:

L. H. Rice Fuels Engineering Subsection Research & Engineering Section - DUN

May 24, 1967

APPROVED FOR PUBLIC RELEASE

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TO

J. T. Stringer, Manager

Manufacturing Engineering Subsection

Production Fuels Section

FROM

L. H. Rice, Supervisor

Product Engineering Unit

Fuels Engineering Subsection - R&E

SUBJECT

2.1 E-N DEMONSTRATION LOAD

In preparation for the full core 2.1 E-N load tentatively scheduled for charging in a K Reactor in July 1968, a technical document is being prepared which will serve as a basis for presentations at AEC Headquarters around the middle of next month. This document is to include a comparison of the material and fabrication costs of Li-Al and LiAlO, target elements and a discussion of the procurement problems that may be encountered, both of which are to be prepared by people in your organization. The most probable loading pattern is with the targets and drivers in separate tubes, in which case we will use solid targets, and your estimates should be directed principally toward this case. However, there is the possibility that we will use striped loads which will require an I&E Li-Al or LiAlO2 target. The design of an I&E LiAlO, target is not sufficiently firm to provide a basis for estimating; however, we should have an estimate of the cost penalty of using I&E rather than solid Li-Al targets. The relative cost comparisons should be valid for a continuing program as well as for this specific demonstration.

One item that should not be overlooked is the net cost of fabricating the uranium drivers (excluding costs for criticality control which are being developed by a group headed by Austin Hardin). There will be costs incurred in components, sleeves, tooling, etc., and at the same time there will be a substantial savings due to a reduction in the number of standard fuels produced.

The load will require charging of around 15,600 lithium-bearing targets and 62,600 2.1 enriched drivers, and the targets and drivers will displace 132,000 standard elements that would normally be charged in a K Reactor during the period of the demonstration load. The driver element will be very close to the KX (2.1) design already established (drawing number H-3-7350 Rev. 15), and the tentative design and specifications for the Li-Al and LiAlO, targets are attached. The target designs are not firm, but any changes should not be of a nature that will substantially effect the fabrication costs or procurement problems. Please identify any items in the



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J. T. Stringer

specifications that, if revised, would have a significant effect on costs. We are currently working on these designs and should have better ones in two weeks. Your contributions would be appreciated by June 5.

Please call on us for assistance whenever we can help.

IHR:scc

Attachment

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TENTATIVE SPECIFICATIONS - LITHIUM-BEARING TARGETS

1. Cladding - C-64 Alloy

2. Core Material

	L1-A1		Lialo	
	Min.	Max.	Min.	Max.
w/o Li	2,75	3.45	9.7	10.2
a/o Li-6 (Li Basis)	44.3	Nom.	17.0	19.0
Density	_		1.94	2.16
Hydrogen - Vol.%		6	_	
Water - ppm				50
Boron - ppm		2		2
Cadmium - ppm		2		2
Chromium - ppm		200		200
Cobalt - ppm		10		10
Copper - ppm		200		200
Fluorine - ppm				25
Iron - ppm		500		500
Manganese		50		50

3. Target Dimensions

	Solid Li-Al(1)	1&E Li-Al(1)	Solid LiAlO ₂
Element Length Cap Thickness	Dwg. H-3-27060	8.822 ± .070 0.160 min.	$0.200 \pm .010$
Base Thickness		$0.175 \pm .020$	
Element O.D.		1.593 ± .008	1.600 ± .003
Element I.D.		$0.437 \pm .005$	
Core O.D.		1.503 ± .002	$1.390 \pm .002$
Core I.D.		0.527 ± .002	0.800 ± .015
Core Length		8.397 ± .010	8.398 ± .025
Axial Gap		None	0.112 ± .025
Can Wall Thickness		0.045 ± .005	$0.100 \pm .007$
Minimum Support		0.038	0.038
Height		_	-
Maximum Projected		1.700	1.700
Diameter		•	•

⁽¹⁾ $_{\text{Li-Al}}$ targets require sizing

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