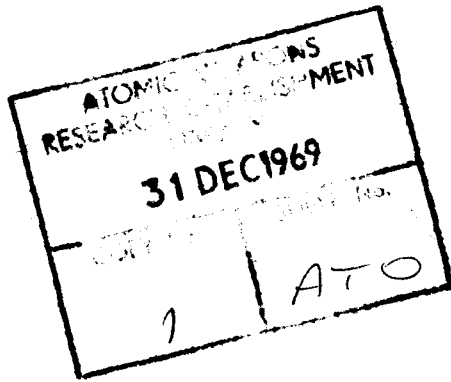


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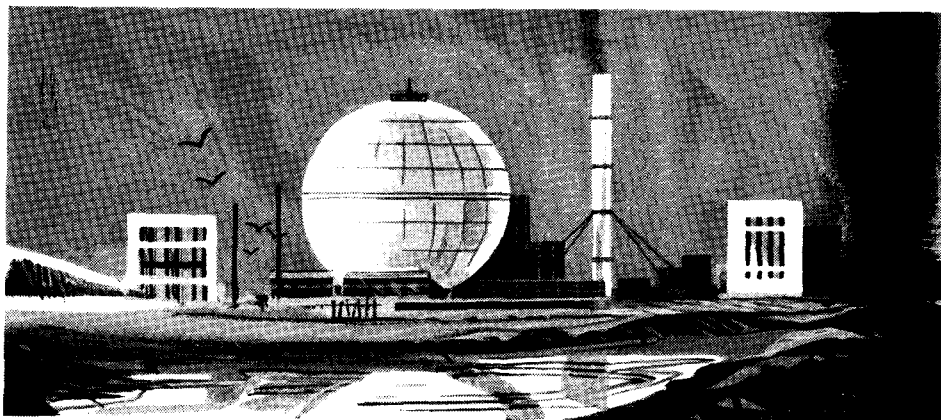
Number 158 / December 1969



MONTHLY INFORMATION BULLETIN OF

THE UNITED KINGDOM ATOMIC ENERGY AUTHORITY

Page	310	Group Technology
	317	Scientific and Technical News Service
	321	In Parliament
	325	INDEX January - December, 1969

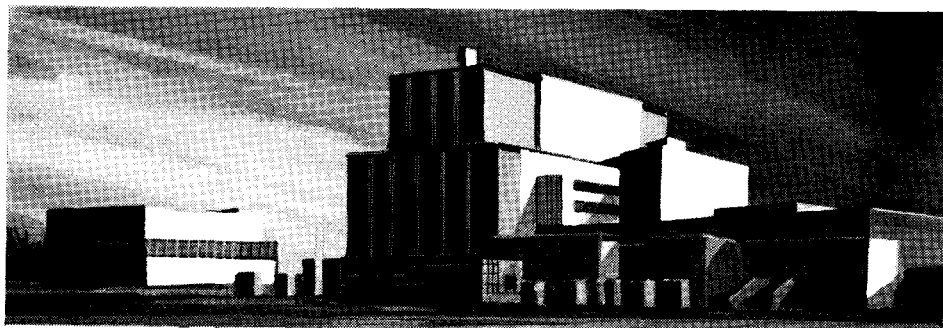


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DOUNREAY to HUNTERSTON 'B'
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John Thompson's long background in nuclear design, manufacture and site construction includes contracts at Berkeley, Dungeness 'A' and Oldbury Magnox stations, at Hinkley 'B' and Hunterston 'B' AGR stations, and at Dounreay and Winfrith Heath. This wide experience ensures that the company is in the forefront of design and development work for future nuclear reactor systems, such as the High Temperature Gas Reactor and the Sodium Cooled Fast reactor.

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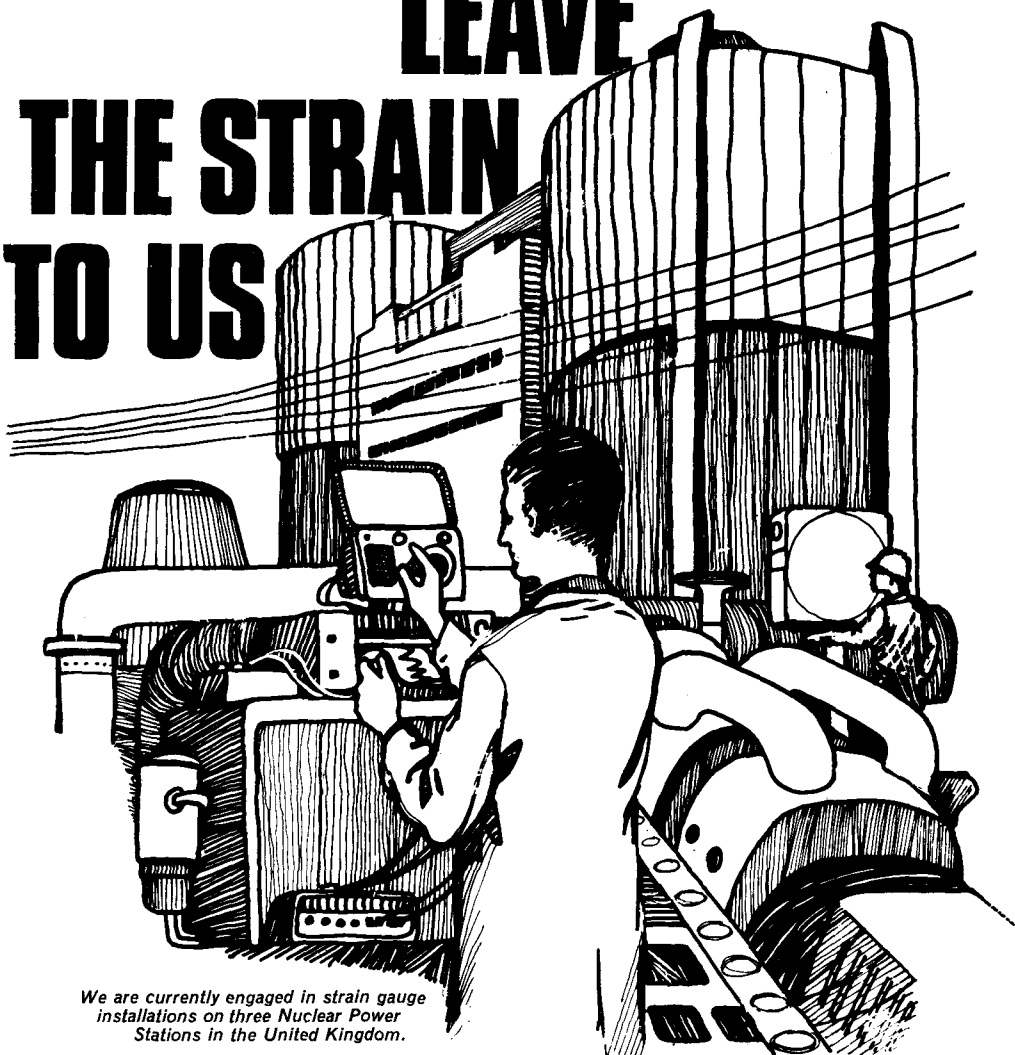


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DC/NP1 

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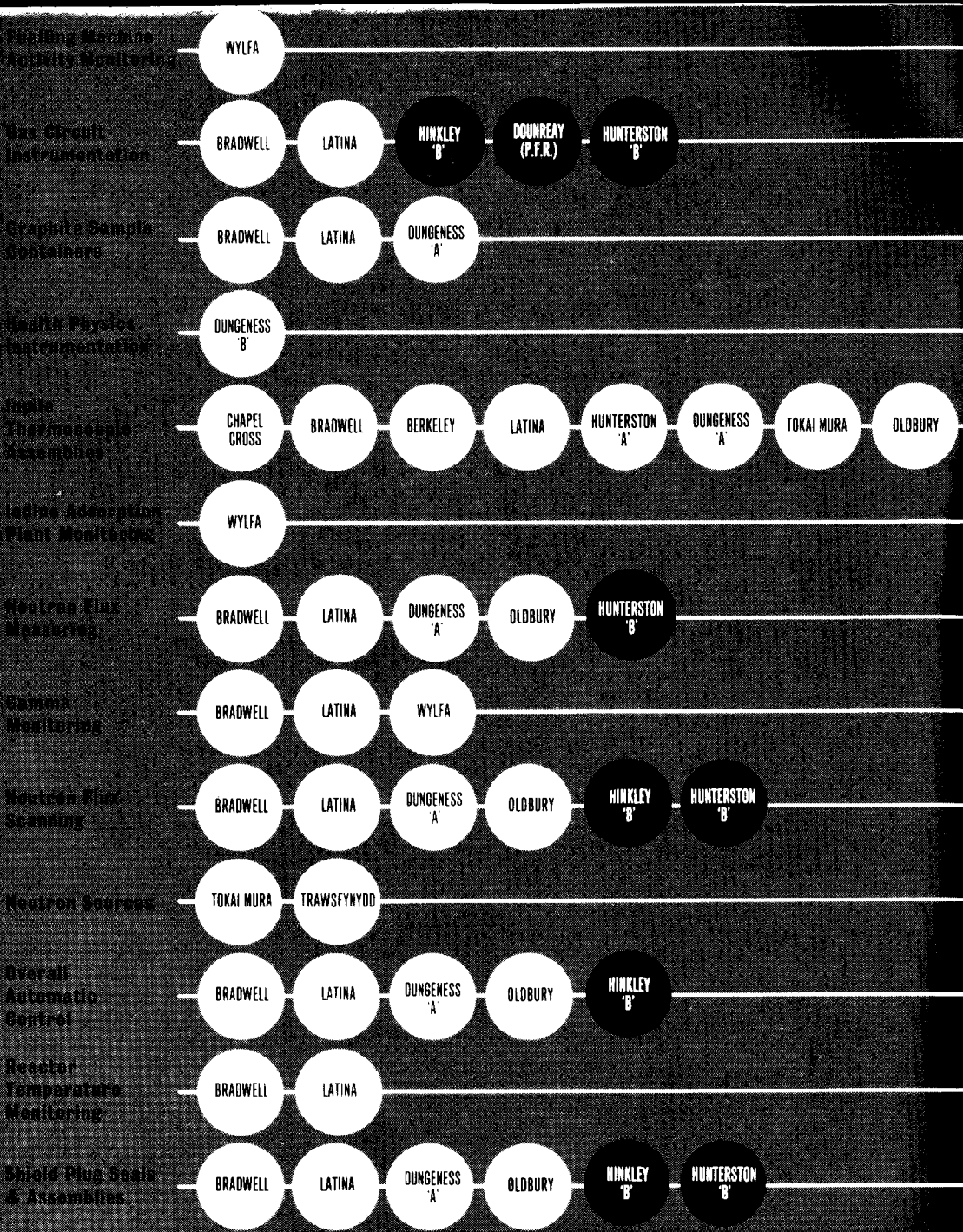
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Harwin and the electronic cake

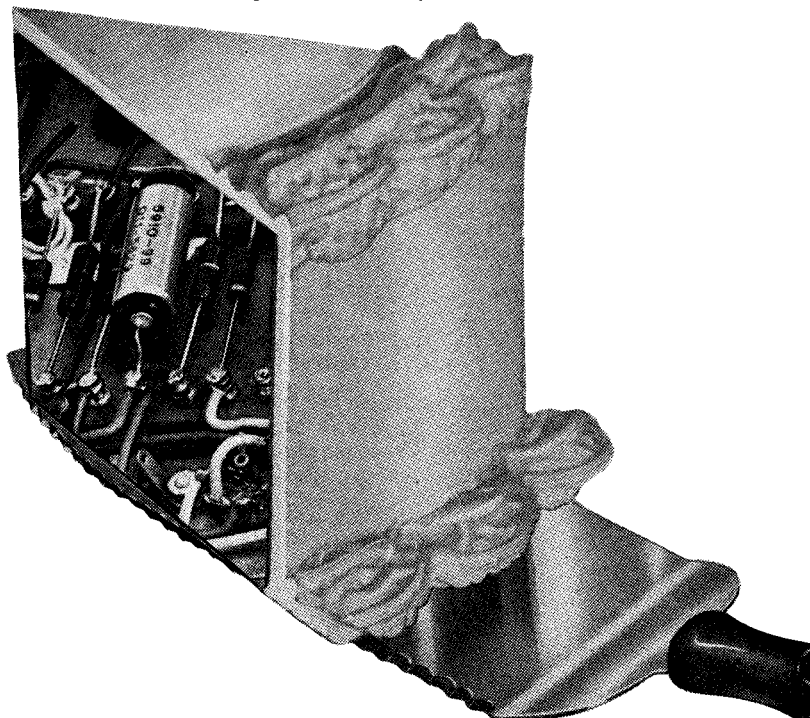
Ask any chef. He'll tell you what a saving it is to have some first-class ingredients ready-blended. It can save time and trouble – and cut the cake's cost!

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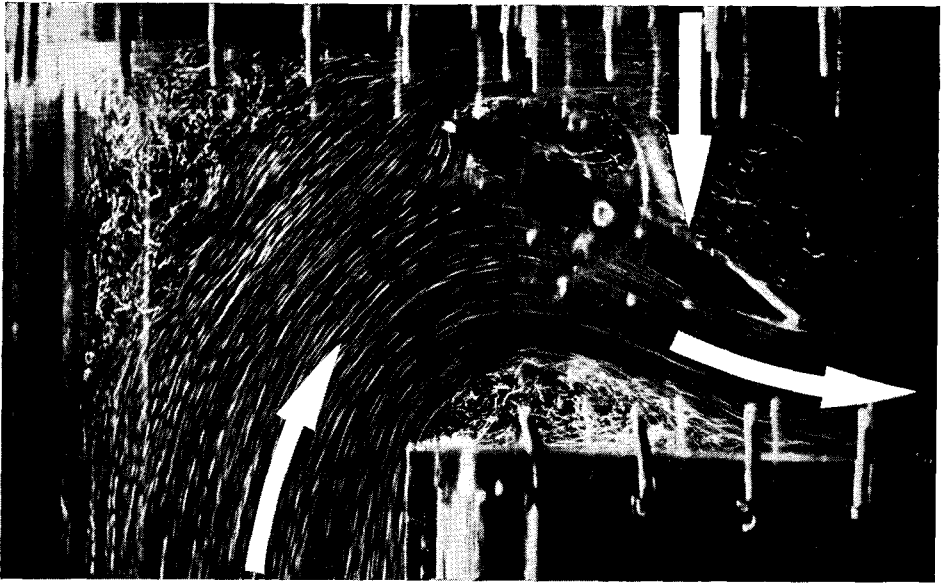
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LUCAS ENGINEERING LABORATORIES, BURNLEY



Flow visualisation by Lucas

Using a transparent 1/12th scale model of the Dounreay Prototype Fast Reactor, in conjunction with a water flow analogue, Lucas engineers have worked in close collaboration with U.K.A.E.A. to study local flow regimes in the primary circuit, pump intakes and cooling circuits giving the unique opportunity to get into the heart of the reactor and understand local flow conditions not possible in the actual plant.

The flow visualisation technique has been developed over the years by Lucas, and has been extensively used in fuel element design and development, and in the study of liquid, gas and air flow in a variety of applications.

The photograph shows the flow patterns associated with the valve for the S.G.H.W.R. suppression system. Basic data on the fluid dynamic forces encountered in this valve was obtained by hydraulic analogue technique.

Lucas are constantly extending the range of application of this technique into other fields and the Laboratory facilities are available for further work.



LUCAS GAS TURBINE EQUIPMENT LTD.,
BURNLEY, ENGLAND.
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British Acheson Graphite puts the brake on at 44,000,000 mph.

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In the world of advanced technology British Acheson are proud to have played their part once again in the supply of essential graphite components for Britain's nuclear industry.

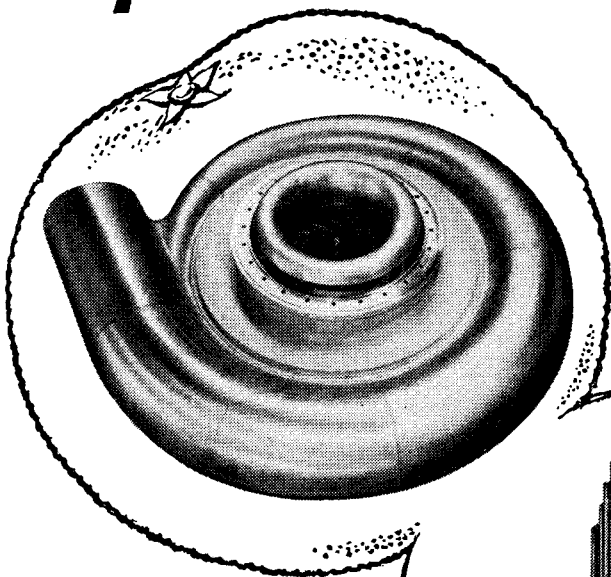


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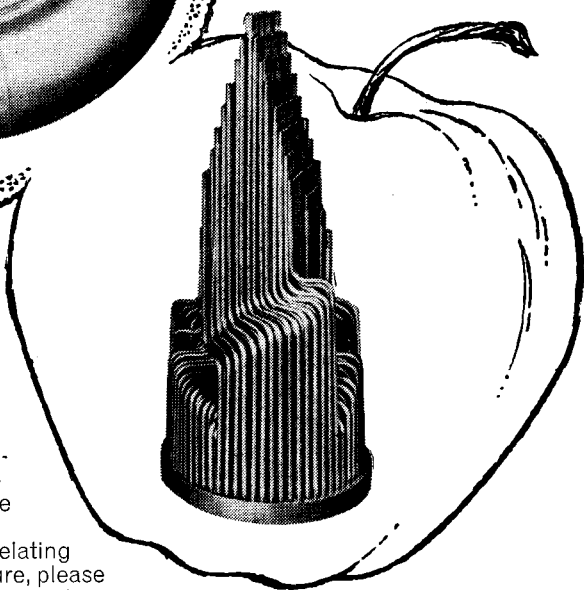
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As contractor to the United Kingdom Atomic Energy Authority from its earliest beginnings, Marston offers the assurance of nuclear engineering work carried out to the highest standards of dimensional accuracy, workmanship and cleanliness by skilled operators.

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A/9/69

ATOM

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OF THE UNITED KINGDOM
ATOMIC ENERGY AUTHORITY

NUMBER 158

December 1969

Contents

- P. 310 Group Technology
317 Scientific and Technical News Service
321 In Parliament
325 INDEX January—December, 1969

ATOM

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New power stations

Approval by the Government of the C.E.G.B.'s proposals for two further nuclear power stations—Heysham and Sizewell B—was announced on 29th October, 1969.

The C.E.G.B. subsequently stated: "Heysham will be the first station to be ordered. The Board will immediately seek competitive tenders for a two-reactor station of 1,320 MW capacity with the intention of placing the construction contract next spring and commissioning the first reactor on full power in the summer of 1975".

The timing of the release of construction contracts for Sizewell B would depend on the Government's consideration of the C.E.G.B.'s capital investment programme in the light of next spring's reappraisal of electricity growth prospects.

"Both Heysham and Sizewell B will have advanced gas-cooled reactors. Three stations of this type are already under construction for the C.E.G.B. which together with a similar station being built for the South of Scotland Electricity Board represent 5,160 MW of AGR capacity.

"Since adopting the AGR system in 1965, the Generating Board's confidence in its technical and economic merits has been confirmed as developments have proceeded. New design and construction features leading to falling costs have marked the development of the AGR which will play a growing role in the C.E.G.B.'s nuclear programme."

Computational Physics Conference Proceedings

The Computational Physics Group of the Institute of Physics and the Physical Society announce the publication by the U.K.A.E.A. Culham Laboratory of the Proceedings of the Computational Physics Conference, 1969. The work is in two volumes and the price for both parts is £4.

Volume 1 (xvi + 190 pages) consists of nine invited papers. Volume 2 (iv + 346 pages) consists of 53 original research papers in most fields of physics including those covered by the invited papers.

The Proceedings are available from H.M.S.O., 49 High Holborn, London, W.C.1, or any bookseller.

Group Technology

by D. Bennett, C.Eng., M.I.Mech.E.,
Senior Project Engineer, The Group
Technology Centre, U.K.A.E.A., Black-
nest, Brimpton, near Reading.

It has long been accepted by production engineers that the most economic methods of manufacturing engineering products occur when mass or flow line production of components can be established. Rationalisation of the product has occurred and manufacturing facilities have been tailored to produce a clearly defined range of components against an established demand.

Unfortunately most engineering organisations never attain this ideal and are faced by the nature of their products and the fluctuation in market demand to consider the manufacture of component parts in small batches. Invariably in this situation an "economic batch quantity" approach to component manufacture is adopted in an attempt to reduce machine setting costs per component. This in its turn produces large stocks of finished components awaiting orders, and when coupled with the manufacture of these components in a functionally laid out workshop, a large capital investment in work in progress.

Group Technology is a technique which allows the production of components required in small batches to achieve similar economic advantages to those associated with continuous flow line production. The approach is to analyse a company's total product and to identify within this product families of components which are related by a similarity in shape and/or the type of production facilities required to manufacture them.

To carry out this analysis it is essential that each component part can be examined in an unambiguous manner, the shape and manufacturing requirements clearly identified and related to other components within the total product. The use of functional descriptions of component parts is not normally satisfactory for this purpose as parts having similar or identical shape features can carry widely varying descriptions. A simple illustration of this is shown in

Fig. 1 where the parts are described in different functional terms but obviously their shape envelope is almost identical.

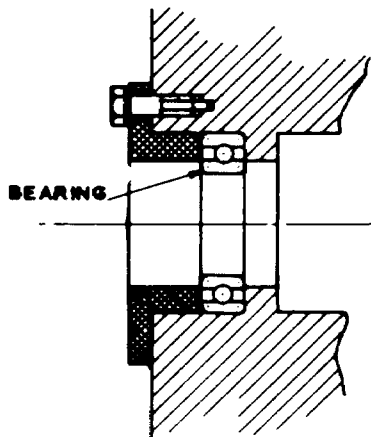
The key to the situation is to use a classification and coding system which identifies the shape and manufacturing requirements of the components by the allocation of a specific digit to each significant feature. By this means, a mass of information is subdivided into smaller related units which can then be examined more easily.

The way in which a classification system works can be illustrated by the way in which each house in the country is identified for the purposes of delivering mail. The procedure thus follows is shown. **U.K.: England: Ireland: COUNTY: TOWN: Street: House no.** The total area of a country has thus been sub-divided in such a way that the unique identity of each house is established.

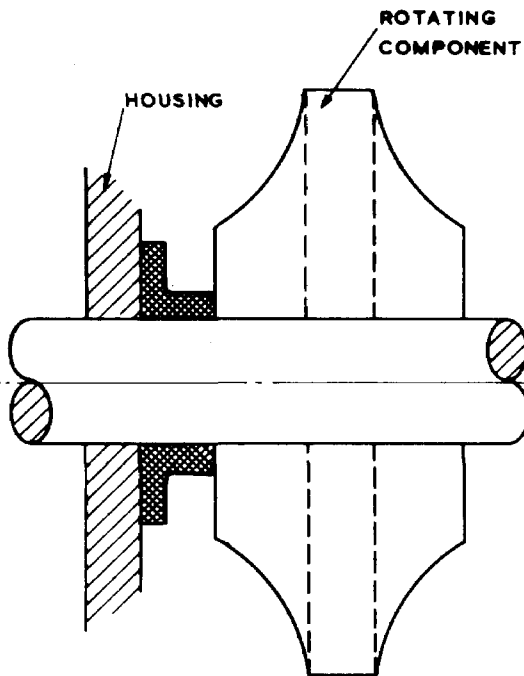
A similar approach can be made to the identification of component types where a basic division is made separating rotational (ie, components normally rotated during their machining) from non-rotational components and then identifying their shape features. Thus - **TOTAL COMPONENTS IN COMPANIES PRODUCTS: Rotational: Non Rotational: OUTSIDE SHAPE: Inside Shape: Material.** This simple method of classification is of little value in a practical sense as the information contained within it is relatively small. However, a number of more sophisticated systems do exist which identify all the features that would be required to be analysed for Group Technology purposes. The general information content that a classification system suitable for Group Technology applications should carry can be listed as follows:—

1. Geometric definition of external and internal shape.
2. Additional features such as holes, slots, splines, etc.
3. Material type and where practical the initial material form, ie. bar forgings, castings, etc.
4. Size envelope.

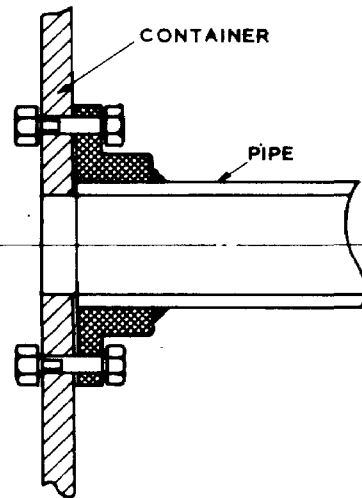
This information can be supplemented by other features such as accuracy and



BEARING FLANGE



SLIP RING



SEALING FLANGE

Figure. 1. *Components identical in shape but differing in function*

weight where the products type requires them.

It is important to recognise that a very long code number indeed would be required to classify in precise detail all the information related to each component feature. The preferred approach is to use the simplest classification system possible, which contains the necessary levels of information and use this as a key to the precise detail information already existing on the drawings and production planning documents. The code structure should ideally contain a high level of digital significance as this will greatly simplify the sorting procedures used to gather together families of similar components. With complete digital significance all that will be required is a listing of the coded components in numerical sequence which will automatically assemble components with similar major features adjacent to each other.

Having identified families of components by these means the next stage is to associate with these families the quantities of each component required over a given period, the allowed machining and setting up times, and the actual manufacturing process. By simple calculation of manufacturing times and quantities required an assessment of machine group load content of a component family can be established. Should this not be sufficient to economically load a group of machines, the parameters of the family can be logically extended in either shape, size, or material until a satisfactory load has been established.

At this stage the opportunity should be taken to examine the technological processes used to manufacture the components as this could well be changed when considering the production of what is now effectively a very large batch of components with a high level of similarity.

The final stage in the process is the examination of each component within the family to define its tooling requirement. Once this has been done a group of dissimilar machines can be brought together which will be capable of manufacturing the complete component family. To gain maximum benefits all the technical requirements of the machine group in terms of information, tools and services should be associated with it.

When this has been done the total manufacturing time cycle of the components will be very clearly defined.

The immediate effects of manufacturing on this machine group will be a radical reduction in total component manufacturing time as components will enter the group as raw material and emerge as finished parts. Machine setting times will be drastically reduced as machines will now be "adjusted" round a basic setting rather than being reset completely for each new component. Work in progress will be reduced as the lower machine setting times will allow actual component production to reflect much more closely the state of the company order book. Also the queuing time associated with inter operational machine loading in the functional lay-out workshop will have been eliminated, and this in turn will reduce the work in progress still further.

The finished stock holding of a company is often a reflection of lack of confidence in the production departments achieving their manufacturing objectives. As the machine group has been tailored to a precise manufacturing requirement, this uncertainty no longer exists and a positive approach can be made to the reduction of finished stock holding with a consequent release of capital.

To create this situation a large bank of data will have been established to identify the families of components and their manufacturing processes. This data can be used for a number of other purposes, the inter-relationships of some of which are shown in Fig. 2.

Consideration of the planning function indicates the ability to create standard planning procedures related by component similarity. The documentation of process planning then becomes greatly simplified particularly where it has been possible to establish large and homogeneous component families. An examination of allowed manufacturing and machine setting times of closely related components can easily be carried out and, from the results of this, standard work/time schedules based on real or synthetic times produced.

If the product demands it one of the parameters for a machine group could be a special level of accuracy. In this case it becomes possible to institute individual machine group costing and so create a

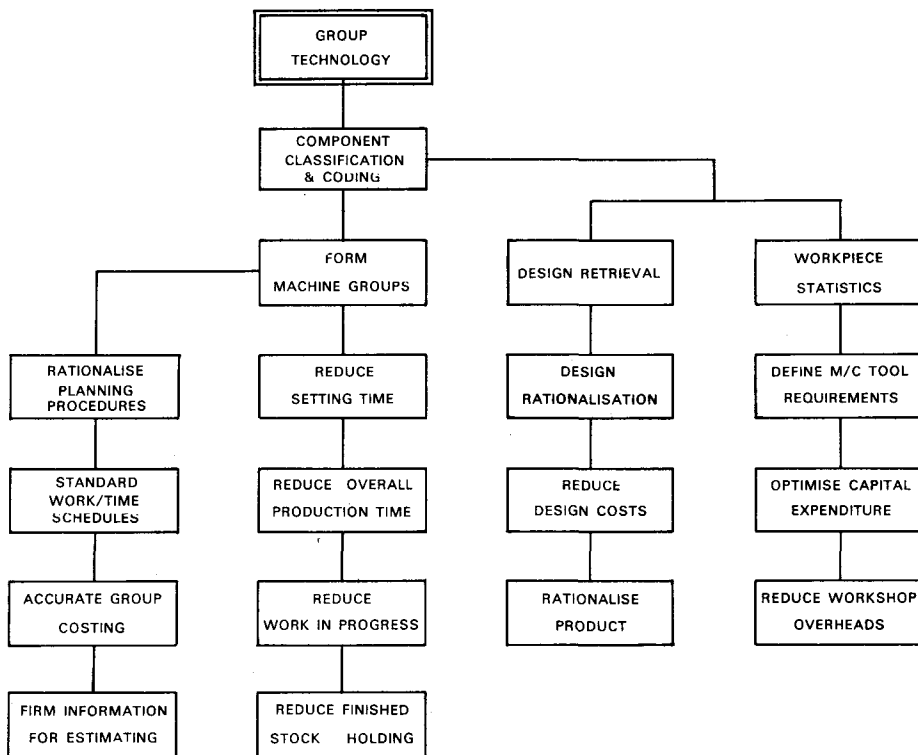


Figure 2

situation where the overheads collected by the component truly reflects the capital costs of the machines required to produce it.

By establishing a classification-based retrieval facility containing all this data a powerful tool is available for estimating production time and costs for any new product. All that is needed is to code the component parts of the new product and having so identified them search the classified data files for information on currently manufactured components with similar code numbers.

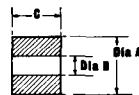
In the design office a retrieval facility can be established by creating a duplicate set of reduced size or microfilmed drawings filed in code number order. The designer or draughtsman considering a new component design can, after coding a rough sketch, quickly search the retrieval facility to identify any similar components already in existence which may suit his purpose. This same retrieval facility also creates a very firm foundation on which to base a programme of standardisation, value analysis, or any other technique which requires the exami-

nation of components related by specific features.

The relationships between component shape and manufacturing requirements used to establish the machine groups can also be used to define very closely the type and size of machine tools required to produce them. With this information, any future machine tool purchase programme can be based upon the clearly identified needs of the components to be produced. Analyses of present workshops machine capacity invariably reveal a total imbalance between the size of components produced and the size of machine tools available to produce them. The machine tools are much too large in size and must therefore have been more expensive than was necessary. Keeping in mind that the machine tool population of Great Britain is estimated at about 1,000,000 the potential savings available to industry by instituting a machine tool purchase programme based on true workpiece statistics is enormous.

An example of the use of this inter-related information is shown in Fig. 3. Here a number of very simple component

COMPONENT FAMILIES



DESIGN

**ANNUAL
USAGE**

PRODUCTION

PLANNING

**MANUFACTURE
TOOLING ANALYSIS**




ALPHABETIC CLASSIFICATION	DIMENSIONS	SUPPLEMENTARY INFORMATION (Material Form & Accuracy)
00100 00	210	
00100 00	210	
00100 00	210	
00100 00	210	
00100 00	210	
.. ..	210	
.. ..	213	
.. ..	210	
.. ..	210	
.. ..	215	
.. ..	210	
.. ..	210	
.. ..	210	
.. ..	210	
.. ..	410	
.. ..	410	
.. ..	210	
.. ..	210	
.. ..	410	
.. ..	213	
.. ..	510	
.. ..	210	
.. ..	210	
.. ..	210	
.. ..	210	

DRAWING No.	DIMENSIONS			TITLE
	DIA A	DIA B	C	
20274	.228 .223	.125	.020	WASHER
20343	.301	.189	.028	WASHER
21150	.318 315 312	.250 251 251	.032 032 032	WASHER
21094	.333 330 330	.250 251 251	.032 030 030	WASHER
2508	.406	.191	.125	EJECTOR SPRING WASHER
20198	.406	.257	.020	SPECIAL WASHER
20414	.485 482 479	.3753 3753 3753	.187 187 182	SLEEVE
10006	.500	.218	.125	WASHER
2494	.500	.257	.125	WASHER - EJECTOR SPRING
20391	.570 570 5025	.5020 5025	.187 187	THRUST SLEEVE
20219	.546	.250	.046	SPECIAL WASHER
20218	.546	.390	.031	SPECIAL WASHER
21015	.562	.390	.036	WASHER
001-38064	.620 619 619	.218	.156	WASHER
20837	.625	.390	.048	WASHER
2493	.625	.390	.125	WASHER
001-29502	.687	.251 .252 .245	.245	ROLLER
2187	.705 700	.257 252	.093	WASHER-CUP TOP WASHER
280	.750	.250	.125	TOP WASHER
21121	.750	.250 .251 .244	.249 249	ROLLER
20056	.750	.3125 .3132	.300	ROLLER - COLLET VALVE
2580	.750	.390	.250	SPECIAL WASHER
20987	.750	.390	.250	WASHER
001-38171	.750	.531	.062	SHIM
20822	.750	.546	.048	WASHER

**IDENTICAL
COMPONENTS**

70
31
50
107
7
1
15
1
36
1
1
1
60
2
17
6
162
9
6
8
87
1
1
1

TIME IN HOURS	
Setting	In/Cycle
75	3
30	3
30	5
30	4
30	5
30	5
45	10
30	5
30	2
60	3
30	5
30	5
30	5
30	4
45	3
30	15
60	5
30	6
30	12
45	10
30	3
30	5
30	5

EXTERNAL FORM			RADIUS	PART OFF	INTERNAL FORM			RADIUS
		CHAMFER 45°				DRILL	REAMER	
✓	✓			✓	$\frac{1}{8}$			
✓	✓			✓	No. 2 (.100)			
✓	✓			✓		$\frac{1}{4}$		
✓	✓			✓	No. 1 (.191)			
✓	✓			✓	F (.257)			
✓	✓			✓		$\frac{3}{8}$		
	✓	$\frac{1}{32}$		✓	$\frac{7}{32}$		$\frac{3}{64}$	
	✓			✓	F (.257)			
✓	✓			✓		$\frac{1}{2}$		
✓	✓			✓	$\frac{1}{4}$			
✓	✓			✓	$\frac{25}{64}$			
✓	✓			✓	$\frac{25}{64}$			
✓	✓			✓	$\frac{7}{32}$		$\frac{5}{64}$	
	✓			✓	$\frac{25}{64}$			
	✓			✓	$\frac{25}{64}$			
✓	✓			✓		$\frac{1}{4}$		
✓	✓		$\frac{5}{64}$	✓	F (.257)			
	✓			✓	$\frac{1}{4}$			
	✓			✓		$\frac{1}{4}$		
	✓			✓		$\frac{5}{16}$		
	✓			✓	$\frac{25}{64}$			
	✓			✓	$\frac{25}{64}$			
	✓			✓	$\frac{17}{32}$			
	✓			✓	$\frac{35}{64}$			

DIMENSIONS IN INCHES
TOLERANCE $\pm .005$ UNLESS STATED

Figure 3

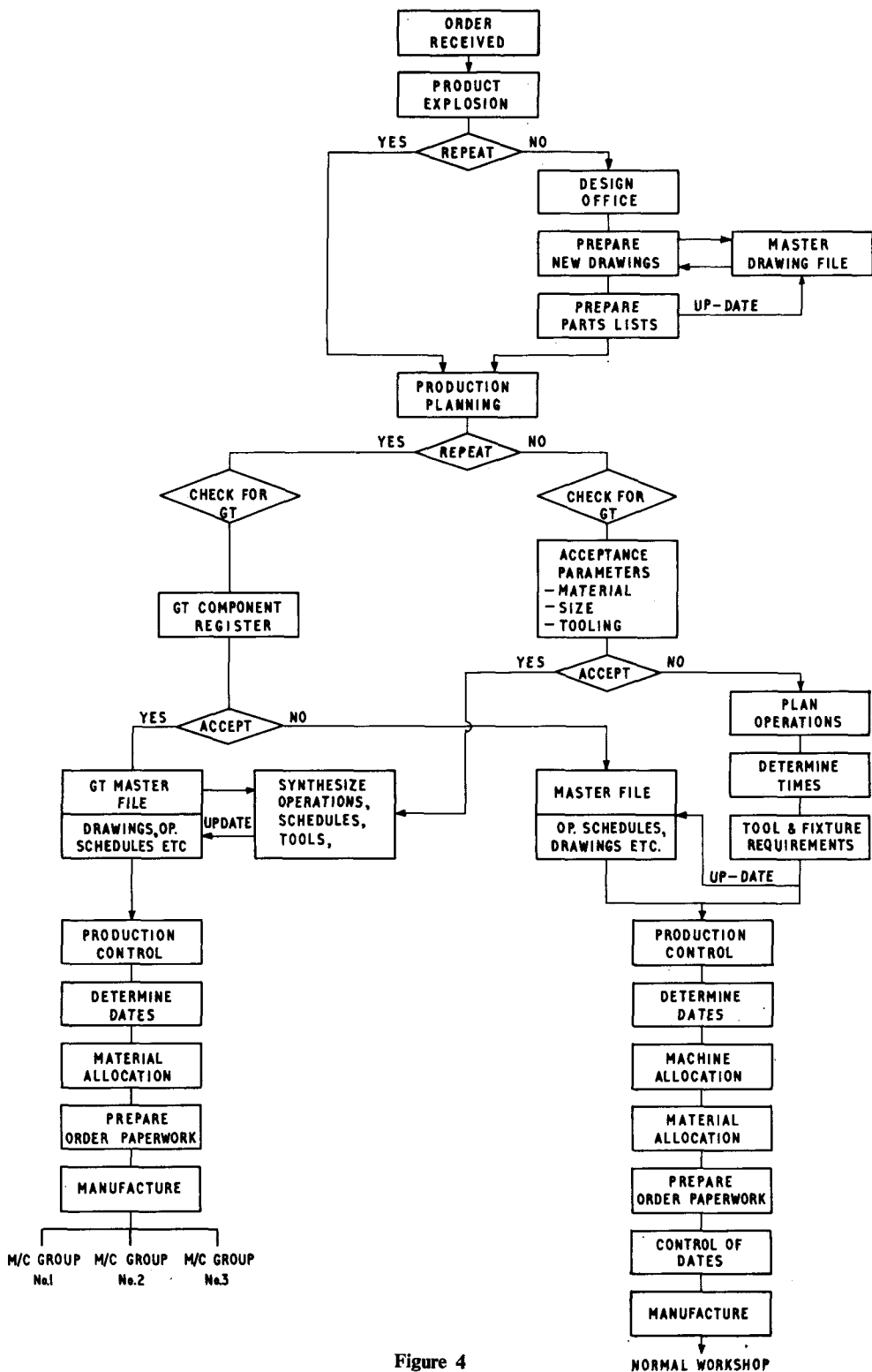


Figure 4

parts are brought together by the use of a classification system. The random nature of the original drawing numbers and component description shows that they could not have been used to identify the component relationships. An interesting point is that two completely identical components have been designed and that in the previous year 87 had been manufactured to one drawing number and 1 to the other. Similarly an examination of the allowed setting times show a variation of $2\frac{1}{2}x$, and the allowed machining times a variation of $7\frac{1}{2}x$. This is not an indictment on the particular company for inefficiency in the production planning office but an indication that before classifying their product they had no means of identifying even simple components related by shape.

In establishing groups of machine tools capable of producing a defined family of components the production process has been more clearly defined in terms of capacity and location than is ever possible in a functional workshop. Because of this the ability to control the production process becomes greatly simplified, and with a suitably developed system the instructions to a machine group for a specified production period need be no more than a list of component identification numbers with the quantities required off each. So long as the raw material arrives at the right time and the work load is within the machine group's capacity all the remaining information and equipment to produce them will be available within the machine group.

However, it must be accepted that a disciplined approach to the control of the machine groups must be established. Each new order must be exploded into its component parts, each of these coded, and examined against the existing machine groups' parameters. Decisions must be made as to the acceptability of a new component within an existing group and if necessary the group parameters and tooling extended to accept it. The lay-out of a model system to suit these requirements is shown in Fig. 4.

The effects of applying Group Technology in a company can be very significant. Total component manufacturing times are invariably reduced by a factor of 4 or 5, machine setting times are also reduced on average by about 70%.

However, the major benefits occur as the full effects of the technique is extended into the management structure of the organisation. The following results reflect some of the effects in Serck-Audco Ltd., Newport, who apply Group Technology principals across the total management structure of the organisation.

Finished Stock — Reduced by 44%
= £550,000

Average Manufacturing Time — Down
from 12 weeks to 4 weeks

Value of Despatches/Employee — Up
from £2,220 to £3,105

Average Income/Employee — Up 35%

A full description of the company's application is described in *Production Planning & Control* (H.M.S.O.).

Group Technology is a technique which can have a far reaching effect on manufacturing economics in industries requiring component parts in small batches. Each application will be completely individual to a particular company and must be developed within the company by personnel fully conversant with the product and the skills available within the production environment.

In the limit the success of Group Technology within a company and the benefits gained will totally reflect the vision and tenacity of the senior management responsible for its implementation for without these qualities innovation is not possible.

Harwell computer services

A range of new services for industry is now available from Harwell in multi-access computer system technology; systems analysis and design (software); using computer methods to solve optimisation and scheduling problems.

From January 1970 the main computer complex alone will consist of a large IBM 360 Model 75 multiplexed to over 200 typewriter terminals via satellite computers and multiplexers

The experience of designing, operating and improving the system and of using sophisticated computer methods to solve problems effectively and cheaply provides the expertise on which the services are based.

Enquiries about these services should be made to Mr. T. D. Phillips, The Computer Manager, AERE, Harwell, Didcot, Berks. (Tel.: Abingdon 4141 ext. 3227)

**U.K.A.E.A. SCIENTIFIC AND
TECHNICAL NEWS SERVICE**
U.K. and U.S.S.R.
collaborate on fusion

The results of a successful example of international scientific collaboration are announced in an article in the centenary edition of *Nature*, published on 31st October, 1969. British and Russian scientists are co-operating on a ZETA-like nuclear fusion experiment known as TOKAMAK at the Kurchatov Institute in Moscow, and the article describes the results of precise measurements of temperature made by a small team from the U.K.A.E.A.'s Culham Laboratory using an advanced technique perfected at Culham.

These results show that the gas within the device is well confined at temperatures reaching 10 million degrees for times exceeding 1/20 second with a density about 1/10 of that required for a nuclear fusion reactor. The experiment confirms that conditions in TOKAMAK approach most closely those required for a fusion reactor, in which energy would be obtained in a controlled fashion from the fusion of hydrogen atoms to give a new source of power for the world.

Since 1958 there has been a full exchange of information between all countries working in this field and progress has been measured on an international scale. Hitherto these exchanges have been both by visits and reports; scientists have also been exchanged between some of the U.S.S.R. and U.K. laboratories. The present collaboration, which started in March this year, is the first investigation in which teams of Soviet and British scientists have worked together on an experimental research project in the nuclear energy field. A continuing programme of collaboration with the U.S.S.R. is now anticipated on fusion research.

The aim of this research is to establish the possibility of producing power from the controlled fusion of the atomic nuclei of light elements such as hydrogen. The method envisaged for achieving fusion power is to confine an extremely hot gas of hydrogen isotopes so that energy is released by thermonuclear reactions between the atomic nuclei. The crux of the problem is to find means of isolating

the gas at the required density and temperature (about 100 million degrees centigrade) from the walls of its containing vessel for long enough for a net gain in energy from the nuclear reactions to be released. The only way envisaged for confining this high temperature gas (known as a plasma) is by the use of magnetic fields. It is the shape of the magnetic field which distinguishes the type of fusion systems currently being studied in fusion laboratories throughout the world and TOKAMAK is one such system.

If controlled fusion can be achieved a new and widely available fuel could supplement or replace fossil fuels and uranium as a source of power.

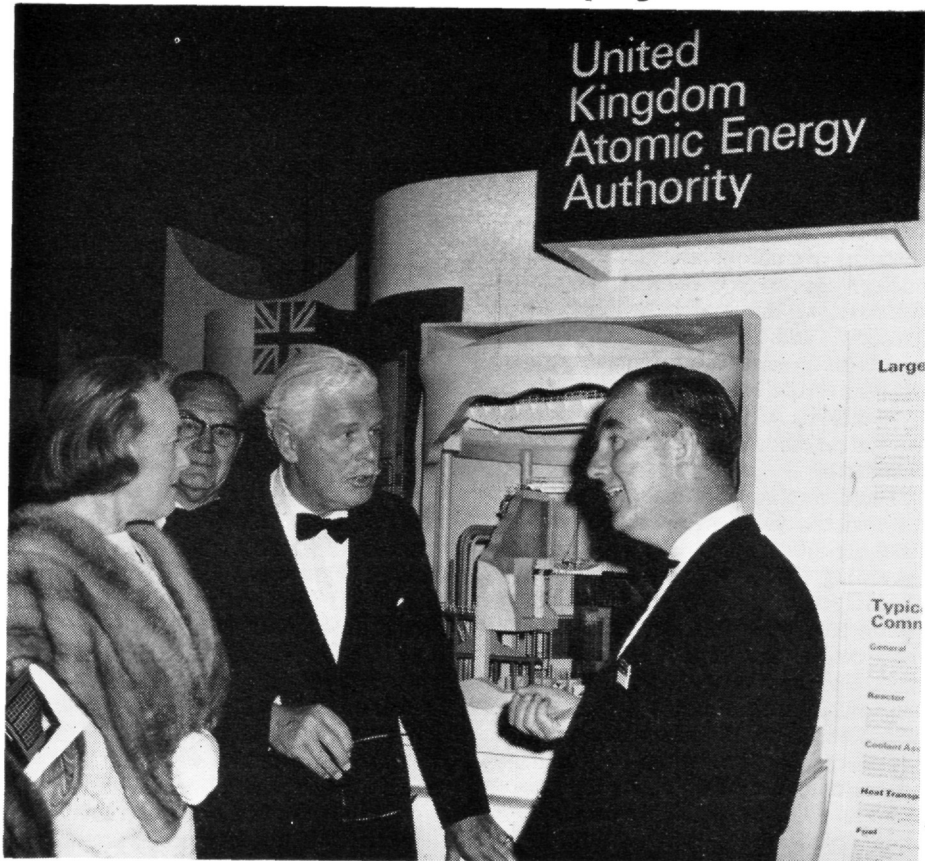
Background notes

The Culham scientific team engaged in these experiments comprises: Dr. N. J. Peacock (Leader), Mr. M. J. Forrest and Mr. P. D. Wilcock. The team spent several months in Moscow, where they were joined by Dr. D. C. Robinson, who is spending a full year at the Kurchatov Institute.

The accurate measurements of temperature and densities of the hot gas within TOKAMAK, on which interpretation of this Russian experiment has depended, have been carried out by the British team using a technique developed by them for a number of Culham experiments. This technique depends on lasers which give out powerful pulsed beams of monochromatic light. The plasma is irradiated with the laser light and the spectrum of the laser photons scattered by the plasma is recorded. A specially designed spectrometer, with associated electronics, analyses this scattered light; from its spectral distribution and intensity the electron temperature and density at any point in the plasma volume can be readily obtained, more accurately than by any other known method. This intricate apparatus, assembled at Culham and weighing five tons, was flown to Moscow on 16th March this year.

TOKAMAK is the generic name for a series of toroidal pinch devices at the Kurchatov Institute. TOKAMAK 3 is the largest (2 metres major diameter and 20 cm. minor diameter) plasma confinement device in which a toroidal discharge,

Visitors to A.E.A. Melbourne display



On the Authority's stand at the Expo Electric exhibition in Melbourne, Australia, in October, Dr. G. R. Bainbridge (right), Assessments Manager in the Technical Operations Directorate of the Authority's Reactor Group, discusses the steam-generating heavy water reactor with Sir Rohan Delacombe, Governor of Victoria. A model of the reactor is behind them.

On the left is Lady Delacombe and in the background Dr. W. H. Connolly, Chairman and General Manager of the State Electricity Commission of Victoria.

carrying about 100 kA, is stabilized by a very strong longitudinal magnetic field. The discharge current both heats and confines the plasma.

The proposals for collaboration were initiated in discussions between Dr. R. S. Pease, Director of Culham Laboratory, and Academician Arsimovich, who is in charge of this work at the Kurchatov Institute.

30th October, 1969

The A.E.A. in Sydney

The U.K.A.E.A. had a small stand in the British exhibition at the International Trade Fair in Sydney, 16th-25th October, which showed that Britain has produced

more electricity from nuclear power than the rest of the world combined.

The stand featured the Steam Generating Heavy Water Reactor, Britain's newest power station system, which has been operating successfully for nearly two years now at Winfrith (near Bournemouth) in Dorset. Larger versions of this system have been designed with outputs of 450 to 600 megawatts.

A design team of engineers from Australia was attached for about a year recently to the U.K.A.E.A.'s reactor design headquarters at Risley in Lancashire to investigate the possible use of S.G.H.W.R.'s in Australia.

There were models of the S.G.H.W.R. and fast reactor systems on the stand

and a display of fuel elements. Britain is one of the world's largest manufacturers of nuclear reactor fuel, which the U.K.A.E.A. sell all over the world.

Inspection and quality techniques displayed

The UKAEA participated in Inspex '69, the 3rd Exhibition and Conference on Inspection and Quality Control in the Engineering and Allied Industries, at the Royal Horticultural Society's Halls, London, S.W.1., 10th-13th November, with a display of advanced techniques in inspection, metrology, nondestructive testing and analytical services, all of which are available to industry.

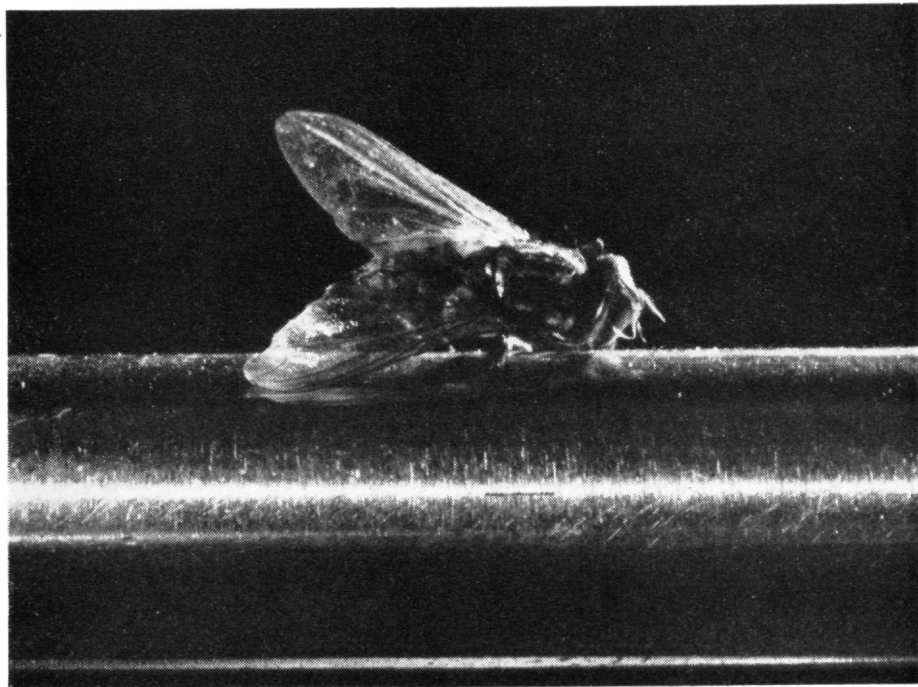
Two of the Authority's establishments, A.E.R.E. Harwell, and RFL Springfields, were represented on the stand.

A.E.R.E., Harwell: Over more than 20 years Harwell has built up an unrivalled range of resources and expertise covering most quality control fields and these are now available for use, in confidence, by

industrial companies who need information, advice or assistance.

The range of expertise and facilities available to industry from Harwell was illustrated on the stand by work of the Nondestructive Testing Centre, the Mechanical Standards Laboratory (together with the Winfrith Mechanical Standards Laboratory), the Analytical Research and Development Unit and the Physico-Chemical Measurements Unit.

These displays described the services provided by the units and showed equipment which has been developed. The Analytical R & D Unit, for instance, showed an electrohydraulic crusher for small samples and an X-ray milliprobe analyser, and also featured activation analysis techniques. The NDT Centre showed a Delayed Ultrasonic Pulse Echo Thickness Gauge for measuring the thickness of components while they are being machined; a precision on thickness of 0.0001" (2.5 microns) can be achieved for materials such as mild steel. This is obtained by measuring the flight time of a pulse of ultrasound to 1 nanosecond



At Inspex '69, the Reactor Fuel Element Laboratories, Springfields, described a simple spark machine method to produce defects in pieces of tubing. The defects are of known size and shape and are used to calibrate ultrasonic testing equipment. The size of one of these defects is shown in the photograph—the dark line in the band of light immediately beneath the house-fly (included to show scale).

using electronic circuits originally developed for nuclear physics time-of-flight experiments.

RFL Springfields: The inspection techniques needed in developing nuclear fuel elements are usually in advance of those required in most industrial operations. These techniques can now be made available to industry and range from non-destructive testing of 1mm diameter balls to the alignment of a 1,600 ton extrusion press.

The exhibits covered the inspection of small bore internal weld profiles, simple statistical metrology, the manufacture and inspection of NDT calibration standards, and circumference and circumferential strain measurement.

This last exhibit showed a transducer attached to a radial grating which rotates on an air bearing; this system measures the radius of a tube and the angle of rotation. Computer calculation for cumulative arc values gives the circumference of the tube. For the measurement of plastic strain, a 0.5 mm grid pattern is etched on the specimen. By measuring the lengths between the grid lines before and after a test, strain value can be determined.

A.E.A. Reports available

THE titles below are a selection from the November, 1969, "U.K.A.E.A. list of publications available to the public". This list is obtainable free from the Librarian, A.E.R.E., Harwell, Didcot, Berkshire. It includes titles of all reports on sale, translations into English, books, periodical articles, patent specifications and reports which have appeared in the published literature. It also lists the Depository Libraries in the U.K. and the countries with official atomic energy projects which receive copies of U.K.A.E.A. unclassified reports.

AEEW-M 912

Proportional Counters for Measuring Plutonium-239 'In Vivo'. The Choice of Counting Gas and the use of Pulse Shape Discrimination Techniques. By R. A. Pike and D. Ramsden. August, 1969. 9pp. H.M.S.O. 2s. 6d.

AEEW-R 641

Noise Spectra Measured on the Dragon Reactor Primary Heat Exchangers. By J. D. Cummins. September, 1969. 10pp. H.M.S.O. 6s.

AEEW-R 648

Measurement of Relative Conversion Ratio and Fast Fission Ratio in Low Enrichment Oxide Lattices. By G. A. Barnett, C. B. Besant, M. F. Murphy and W. H. Taylor. August, 1969. 30pp. H.M.S.O. 6s.

AERE-R 5792

The Measurement of Small Dimensional Changes by Neutron Radiography. Progress Report. By R. S. Matfield, G. Constantine and S. C. Alexander. July, 1969. 53pp. H.M.S.O. 12s.

AERE-R 5944 (Vol. 1)

The Interactions Between Dislocations and Point Defects. Proceedings of a Symposium Held at Harwell, July 4th-12th, 1968. Volume 1. Part 1. Theoretical Considerations. Part 2. Dislocation Pinning. Edited by B. L. Eyre. December, 1968. 285pp. H.M.S.O. 39s.

AERE-R 5944 (Vol. 2)

The Interactions Between Dislocations and Point Defects. Proceedings of a Symposium Held at Harwell, July 4th-12th, 1968. Volume 2. Part 3. Dislocation Climb. Edited by B. L. Eyre. March, 1969. 286pp. H.M.S.O. 44s.

AERE-R 5944 (Vol. 3)

The Interactions Between Point Defects and Dislocations. Proceedings of a Symposium Held at Harwell, July 4th-12th, 1968. Volume 3. Part 4. Mechanical Properties. Part 5. General Discussion. By B. L. Eyre. December, 1968. 258pp. H.M.S.O. 34s.

AERE-R 6011

A Primary Standard of Gas-Flow Measurement. By G. V. Evans, R. Spackman and J. C. D. Gardiner. September, 1969. 12pp. H.M.S.O. 3s.

AERE-R 6052

A Neutron Diffraction Study of Carbon Fibres. By R. N. Sinclair, A. Wedgwood, D. H. C. Harris and P. A. Egelstaff. June, 1969. 10pp. H.M.S.O. 3s. 6d.

AERE-R 6138

A High Intensity Isotope Separator Ion-Source. By J. H. Freeman. July, 1969. 7pp. H.M.S.O. 3s. 6d.

AERE-R 6163

An Improved Method for the Determination of Plutonium by Alpha Counting. By A. J. Wood and G. W. C. Milner. August, 1969. 13pp. H.M.S.O. 2s. 6d.

AERE-R 6165

The Destructive and Non-Destructive Analysis of Vanadium for Carbon by γ Activation. By J. S. Hislop and D. A. Wood. August, 1969. 16pp. H.M.S.O. 3s.

IN PARLIAMENT

Oxidation problem

13th October, 1969

MR. JUDD asked the Minister of Power whether he will make a statement on the recent technical difficulties which have led to a reduction in power output at nuclear power stations in Great Britain.

MR. BENN: Oxidation of certain minor steel components at a greater rate than anticipated has occurred at six of the Central Electricity Generating Boards seven operational Magnox type nuclear stations: Bradwell, Hinkley "A", Trawsfynydd, Dungeness "A", Sizewell and Oldbury. The rate of oxidation is influenced by the temperature of the coolant gas inside the reactor which has therefore been reduced slightly to slow down the rate of oxidation.

Production from these stations will be reduced by about 400 MW, approximately 1 per cent. of the C.E.G.B.'s maximum output capacity. With present plant margins the C.E.G.B. foresee no threat to supplies this winter. All the stations affected remain in continuous operation and are, I understand, still exceeding their design load factors of 75 per cent. I am satisfied that they can continue to operate safely at the reduced temperatures.

I have satisfied myself that with help from the U.K.A.E.A. and the nuclear consortia the Generating Board are investigating the full consequences of the problem and ways in which to restore the lost output. I have the Board's assurance that A.G.R. stations will not be affected as they operate in a much higher temperature range for which special steel components are being provided.

16th October, 1969

MR. KELLEY asked the Minister of Technology what is the estimated loss of revenue arising from the need to operate Magnox nuclear power stations at low capacity because of the corrosion of parts of the reactors recently discovered.

MR. HAROLD LEVER: As stated in the reply to the Member for Portsmouth, West (Mr. Judd) on 13th October, the six Magnox stations affected by oxidation are still in continuous operation at above their design load factor. As the Board are confident of maintaining supplies there should be no loss of revenue.

Fast breeder reactor

17th October, 1969

MR. G. ELFED DAVIES asked the Minister of Technology when, taking into account the delays to the prototype fast breeder reactor mentioned in paragraphs 159 and 160 of the Atomic Energy Authority's Annual Report for 1968-69, he now expects the first commercial-scale reactor of this kind to be in operation.

MR. HAROLD LEVER: The delay is due to difficulties encountered in welding the biological shield roof and is not connected with the fast reactor system. The prototype is expected to be completed at the end of 1972 and it is estimated that a commercial fast reactor could be ordered to come into operation towards the end of the 1970s.

Power costs

20th October, 1969

MR. KELLEY asked the Minister of Technology if he will withhold permission for the building of any more nuclear power stations until the first commercial scale advanced gas-cooled reactor station has operated long enough for the running costs to be proved.

MR. HAROLD LEVER: No. The Government have been satisfied that the A.G.R.s will generate base load electricity at lower cost than conventional stations. To withhold permission for the construction of further A.G.R.s would delay unacceptably the reduction of the cost of electricity and the further development of nuclear power.

Winfrith S.G.H.W.R.

20th October, 1969

MR. CLIFFORD WILLIAMS asked the Minister of Technology what was the total cost, including loss of revenue, of the delays to the Winfrith S.G.H.W. reactor reported in Paragraphs 151 and 152 of the 1968-69 Report of the United Kingdom Atomic Energy Authority.

MR. BENN: The cost of rectifying the plant was about £6,000; the further cost arising from fuel failures is not easily assessed. The estimated revenue that might otherwise have been obtained is £200,000. A load factor of 45 per cent. for the first year of operation of this prototype reactor is considered to be a very satisfactory achievement.

The prototype S.G.H.W. reactor at

Winfrith was not constructed solely to generate electricity, but to afford an opportunity to solve any development problems that might be thrown up. Achieving a high standard of water purification was part of the development programme. The time lost as a result of malfunctioning of the purification plant enabled other desirable experimental and engineering work to be carried out.

Dragon reactor

22nd October, 1969

MR. CLIFFORD WILLIAMS asked the Minister of Technology what was the total cost including any loss of revenue, of the delays to the DRAGON reactor reported in Paragraph 150 of the 1968-69 Report of the United Kingdom Atomic Energy Authority.

Mr. Wedgwood Benn: The Atomic Energy Authority operate this experimental reactor on behalf of the O.E.C.D. DRAGON Project. The reactor is not used for the production of electricity and its irradiation space is not sold; there is, therefore, no revenue. I am informed by the management of the DRAGON Project that the necessary cost of replacement of a complete set of heat exchangers, to which reference is made in the A.E.A.'s Annual Report, was of the order of £60,000.

Atomic Energy Board

22nd October, 1969

MR. NEAVE asked the Minister of Technology when he proposes to set up the proposed Atomic Energy Board.

Mr. Benn: This will require legislation. Issues for which the proposed board will be responsible are now being covered by the Atomic Energy Authority's Reactor Policy Committee, and a Reactor Export Committee which has been established.

Ground rules

22nd October, 1969

MR. EADIE asked the Minister of Technology why Her Majesty's Government agreed to change the ground rules for estimating the costs of the nuclear power stations now being built, in view of the fact that no commercial station using the advanced gas-cooled reactor has yet operated.

Mr. Alan Williams: My hon. Friend

will be aware from the Answer he received on 25th March, that it is the Central Electricity Generating Board who have primary responsibility for determining the ground rules, but the Government were aware that the change was under consideration.

Dungeness B

22nd October, 1969

MR. ASHTON asked the Minister of Technology when the Dungeness B Nuclear Power Station is now expected to be in operation; and what delay this represents by comparison with the original estimate.

Mr. Harold Lever: In 1972. The first unit is expected to be delayed by at least 18 months and the second by about a year.

Mr. Ashton asked the Minister of Technology what was the original estimate of the cost per unit of electricity sent out from the Dungeness B nuclear power station; and what is the present estimate on the basis of the same ground rules.

Mr. Harold Lever: The initial estimate (0.46d./kWh) was given in paragraph 68 of Cmnd. 2798. There is no up-to-date estimate on the original ground rules, but the C.E.G.B.'s latest estimate using their revised ground rules is 0.56d./kWh as stated in the reply given to my hon. Friend on 13th March, 1969.

Nuclear reactor exports

22nd October, 1969

MR. HORDERN asked the Minister of Technology what action is being taken by his Department to encourage exports of British nuclear reactor systems.

Mr. Benn: A Reactor Export Policy Committee on which my Department and others is represented has been set up with the U.K.A.E.A., the U.K.A.E.A. Production Group (later to become the Nuclear Fuel Company) and the two nuclear design and construction companies as members.

In this way the fullest assistance and support can be provided.

Coal replacement

22nd October, 1969

MR. G. ELFED DAVIES asked the Minister of Technology what loss of annual business to the coal industry is represented

by the nuclear power stations now operating; and what are their excess costs by comparison with coal-fired stations in the coalfields built at about the same time.

Mr. Harold Lever: It is calculated that the output of nuclear power stations in 1968-69 was equivalent to 8 million tons of coal, but it would be misleading to assume that coal stations would necessarily have been built if there had been no nuclear stations. The earliest nuclear stations under the first nuclear programme were less economic than contemporary conventional stations but the later ones to come into operation have base-load costs similar to those of contemporary coal-fired stations in the same part of the country.

Chapelcross

22nd October, 1969

MR. EADIE asked the Minister of Technology what are the final figures for the cost of the breakdown of the reactor in the Chapelcross nuclear-powered station, including the loss of revenue.

Mr. Alan Williams: Remedial work on No. 2 reactor at Chapelcross has cost £400,000. The reactor recommenced electricity generation in mid-July this year, by which time the loss of electricity sales revenue was £2.3 million against which may be set savings in fuel costs which cannot yet be assessed. It is not yet operating at full power and the final loss of revenue will depend on its future performance.

Isotope-powered electrical generators

5th November, 1969

MR. LUBBOCK asked the Minister of Technology if he will give a general direction to the Atomic Energy Authority to discuss isotope-powered electrical generators with new potential licensees, now that the Authority's existing partners are terminating their agreement.

Mr. Alan Williams: A direction would not be necessary or appropriate. The exploitation of isotope-powered electrical generators is a matter within the day-to-day responsibility of the Atomic Energy Authority.

A.G.R. export prospects

10th November, 1969

MR. PATRICK MCNAIR-WILSON asked

the Minister of Technology if he will give details of the number of inquiries which have been received for the supply of advanced gas-cooled reactors to other countries.

Mr. Alan Williams: At the present time, five countries have reasonably firm nuclear power projects, of a size for which the A.G.R. system would be suitable, and the nuclear design and construction companies are in touch. In addition, licences for the A.G.R. have been taken out by German and Japanese firms.

Nuclex data sheets

Copies of the following data sheets produced by the U.K.A.E.A. for the Nuclex '69 exhibition in Basle, Switzerland, 6th-11th October, are available from Public Relations Branch, U.K.A.E.A., 11, Charles II Street, London, S.W.1.

A.E.R.E. Harwell.

A.E.R.E. research reactors in support of reactor projects.

Automatic potentiometric titration apparatus.

A radiometric scanner with polychromatic display.

Industrial uses of gamma radiation.

Power from radioisotopes.

Compatible nuclear electronic equipment (CAMAC).

A.W.R.E. Aldermaston.

Low energy heavy ion accelerator.

Reactor Engineering Laboratory, Risley.

Flux distortion flowmeters for P.F.R.

Saddle-coil EM flowmeter.

Automatic plugging meters.

Electromagnetic differential pressure gauge.

Sodium level measurement in P.F.R.

Reactor Fuel Element Laboratories, Springfield.

Out-of-pile loop tests for C.A.G.R.s.

Out-of-pile loop tests for S.G.H.W.R.s

Reactor Development Laboratories, Windscale.

A.G.R. heat transfer.

The C.A.G.R. handling test rig.

Dounreay Experimental Reactor Establishment.

Fast reactor development in the U.K.

Sodium water reaction work at Dounreay.

Courses at Harwell

THE following courses are due to be held at the Post-Graduate Education Centre, A.E.R.E., Harwell, Didcot, Berks. Further information and enrolment forms can be obtained on application. The fees shown are exclusive of accommodation.

Two-Phase Heat Transfer

5th to 9th January, 1970 (at A.E.E. Winfrith)

1st to 5th June, 1970

Should be of particular value to engineers and scientists working in the field but may also appeal to those requiring an introduction to two-phase heat transfer.

The subject is approached in a fundamental way and although its application to nuclear reactors problems has some emphasis, the material presented is useful to those requiring a knowledge of the problems inherent in two-phase heat transfer and of current solutions, theories and developments. The lectures are given by experts in their subjects. Fee: £40.

Modern Physical Techniques in Materials Technology

12th to 16th January, 1970

19th to 23rd October, 1970

Arranged in conjunction with the Institute of Physics and the Physical Society and the Metals and Metallurgy Trust.

Presents an opportunity to scientists engaged in research and development to familiarise themselves with seventeen different modern physical techniques of vital importance in materials technology. Lectures are given by specialists actively engaged in these fields.

The basic principles of each technique are outlined, together with the scope and limitations, and the course presents an overall picture of the inter-relation of the techniques and of their applications in the physical sciences. Fee: £40.

Radioisotope Methods in Chemistry

26th January to 13th February, 1970

Intended for chemists employed in pure or applied research who need a basic introduction to radioisotope methods coupled with specialised information in particular chemical fields.

Students will be encouraged to suggest experiments which they wish to carry out in the third week. Fee: £120.

Advanced Radiological Protection

16th February to 13th March, 1970

For the experienced health physicist to extend his understanding of the underlying philosophy and scientific bases of his profession. Attention is also given to the managerial and professional responsibilities of the health physicist. The subjects covered include many of those dealt with in the Post-Graduate Radiological Protection Course but emphasise more advanced aspects and modern developments.

The topics include more advanced lectures on radiation physics, dosimetry and modern developments in radiation detection. The practical work comprises syndicate studies in place of laboratory work, to provide participants with an opportunity to conduct joint exercises with their professional colleagues from other establishments and countries and so obtain a very wide perspective of their profession. Fee: £160.

Seminar on Harwell's Multi-access Computing System

18th and 19th February, 1970

13th and 14th May, 1970

The objective is to describe and discuss the multi-access computing facilities developed at Harwell for use on the IBM system/360 computer. The system is designed to operate efficiently with conventional batch-processing. Participants are given the opportunity to use it. Lectures describe how it is implemented, giving particular emphasis on what is required for similar systems to be implemented on other computers. Fee: £16.

Pressurised Equipment

9th to 13th March, 1970

For designers of graduate level who are concerned with pressurised equipment in a research and development environment.

Covers the following broad aspects of the subject:

Design of vessels, seals, joints, flanges; other practical aspects of design; materials and the effects of special environments; recent work on fracture mechanics and high pressure engineering.

Lectures are given by specialists from Harwell and Risley, from Government and industrial research and design establishments and from a University. Fee: £40.

Process Instrumentation

9th to 20th March, 1970

28th September to 9th October, 1970

For those of graduate level working on the instrumentation of process plant, nuclear reactors and scientific apparatus or who have a direct interest in the subject. Most of the lectures are given by specialists from U.K.A.E.A. establishments.

Demonstrations illustrate some of the lectures and there are visits to process plants. The emphasis of each visit is on the problems of instrument installation and maintenance in service. Fee: £80.

Radiological Protection

16th to 20th March, 1970

8th to 12th June, 1970

9th to 13th November, 1970

Lectures, demonstrations and practical work designed to give some experience in the safe handling of radioisotopes. While it is assumed that students are normally graduates in science or engineering, or hold equivalent qualifications, such qualifications are not considered essential to attendance. This course is intended to be of use to "competent persons" since it contains information about safety precautions when using x-rays, industrial use of radioisotopes, instrumentation and the

regulations applicable to the use of ionising radiations.

The practical work is to familiarise students with simple measurements and calculations associated with radiological protection. Fee: £40.

Science and Mathematics Teachers

6th to 10th April, 1970

These courses for science and mathematics teachers, which may also be of interest to teachers in Colleges and Departments of Education, are intended to give a background knowledge of current developments in some of the subjects investigated at Harwell.

For science teachers the course covers some applications of nuclear physics, and is introduced by lectures providing a short account of recent nuclear physics research and the experimental apparatus involved. Other lectures include: physics, engineering and uses of nuclear reactors, materials research, developments in analytical science, applications of electronics and radioisotopes, and controlled fusion research. For mathematics teachers the course comprises a series of lectures on practical mathematics at Harwell, with particular reference to the impact of computers on problems encountered in scientific research. Fee: £5.

INDEX

January — December, 1969

- | | | | |
|---|-------------|---|--------|
| Absolute calibration of vacuum gauges | p. 115 | Anglo-Brazilian collaboration | p. 2 |
| Accelerators | | Anglo-Dutch collaboration | p. 3 |
| 300 GeV | p. 35 | Anglo-German collaboration | p. 3 |
| | pp. 120/124 | Anglo-U.S.S.R. co-operation | p. 118 |
| Adams, Dr. J. B. | | | p. 317 |
| <i>Director of CERN</i> | p. 119 | APACE Centre | p. 25 |
| | p. 277 | <i>courses</i> | p. 54 |
| Advanced Gas-cooled Reactors (A.G.R.) | p. 90 | | p. 178 |
| | p. 296 | <i>exhibition</i> | p. 175 |
| <i>exhibits at NUCLEX</i> | p. 267 | APEX goniometer | p. 115 |
| <i>ground rules</i> | p. 154 | Argon arc image furnace | p. 114 |
| | p. 322 | Artery drill | p. 106 |
| <i>operating experience</i> | pp. 9/20 | Artificial kidneys | p. 107 |
| <i>two new stations</i> | p. 309 | Atmospheric pollution | p. 50 |
| A.E.R.E., <i>see</i> Atomic Energy Research | | Atom 69 | p. 284 |
| Establishment, Harwell | | Atomic Energy Board | p. 322 |
| A.G.R., <i>see</i> Advanced Gas-cooled Reactors | | Atomic Energy Establishment, Winfrith | |
| Aldermaston, <i>see</i> Atomic Weapons Research | | <i>(See also DRAGON and Steam Generating Heavy Water Reactor)</i> | |
| Establishment | | <i>Mechanical Standards Laboratory</i> | p. 197 |
| Analytical Research and Development | | <i>Royal visit to</i> | p. 214 |
| Unit (Harwell) | p. 110 | | p. 216 |
| <i>exhibits at Inspex</i> | p. 319 | Atomic Energy Research Establishment, | |
| Anderson, Miss M. A., <i>M.B.E.</i> | p. 31 | Harwell | |
| Anglo-American co-operation | p. 55 | <i>Analytical Research and Development</i> | |
| Anglo-Austrian co-operation | p. 150 | Unit | p. 110 |

A.E.R.E. cont.			
<i>Calibration service</i>	p. 197	Brazil	
CAMAC	pp. 79/81	<i>buys six reactors</i>	p. 238
	p. 242	<i>São Paulo exhibition</i>	p. 53
<i>carbon fibres</i>	p. 151		p. 110
	p. 193	British Nuclear Design & Construction Ltd. (BNDC)	p. 54
<i>Ceramics Centre brochure</i>	p. 246		p. 278
<i>collaboration with Government laboratories</i>	p. 212		p. 281
<i>computer course</i>	p. 195	<i>constituent firms</i>	p. 153
<i>Director</i>	p. 107	Bugey reactor, France	p. 10
<i>exhibits at Inspex</i>	p. 117	Butler, Miss Ruth, <i>B.E.M.</i>	p. 177
<i>Harwell and industrial research</i>	pp. 185/197	B.W.R., <i>see</i> Boiling Water Reactors	
<i>isotope-powered cardiac pacemakers</i>			
<i>isotope separator</i>	p. 275	Calder Hall nuclear power station	
	pp. 102/105	<i>operating experience</i>	pp. 6/22
<i>neutron radiography service</i>	p. 273		p. 282
<i>new programme</i>	p. 280		p. 296
Nondestructive Testing Centre	pp. 155/165	Calibration service	
<i>non-nuclear work</i>	pp. 244/246	<i>Mechanical Standards Laboratories</i>	p. 197
<i>at Nuclex</i>	p. 269	CAMAC	pp. 79/81
<i>Physico-Chemical Measurements Unit</i>	p. 108	<i>sales to U.S.A.</i>	p. 242
<i>Post-Graduate Education Centre Courses</i>	p. 22	Camera, 17-channel rotating disc	p. 114
	p. 92	CANDU reactor	p. 59
	p. 142	Capenhurst	
	p. 263	<i>modifications to plant</i>	p. 36
	p. 272		p. 55
	p. 300		p. 152
	p. 324		p. 279
<i>Programmes Analysis Unit staff</i>	p. 88	Carbon-14	
<i>Summer School in analysis</i>	p. 89	<i>in hydrological studies</i>	p. 44
<i>visits by industrialists</i>	p. 146	<i>in oceanographic studies</i>	p. 47
	p. 176	Carbon fibres	p. 151
Atomic Weapons Research Establishment, Aldermaston			p. 246
<i>APACE Centre courses</i>	p. 25	<i>Harwell's work on</i>	p. 193
	p. 54		
<i>cardiac pacemakers</i>	pp. 100/105	Cardiac pacemakers	pp. 100/105
<i>machine tools</i>	p. 154	Centrifuge technology	pp. 40/42
<i>non-nuclear projects</i>	p. 281		pp. 179/182
Atomic Weapons Research Establishment, Foulness		<i>collaboration with Netherlands and W. Germany</i>	p. 3
<i>MQ 20 pressure transducer</i>	p. 274	Ceramics Centre, Harwell	p. 212
Austria		CERN	
<i>A.E.A. co-operate with</i>	p. 150	<i>300 GeV accelerator</i>	p. 35
Automated Factor VIII equipment	p. 106		pp. 120/124
Automatic plugging meters	p. 305	<i>new Director</i>	p. 119
Automatic potentiometric titration	p. 107		p. 277
Automatic scanning microphotometer	p. 113	Chapelcross nuclear power station	
A.W.R.E., <i>see</i> Atomic Weapons Research Establishment, Aldermaston.		<i>breakdown</i>	p. 55
			p. 323
Benghazi		<i>operating experience</i>	pp. 6/22
<i>desalination plant for</i>	p. 119	<i>recommissioned reactor</i>	p. 279
BEPO			p. 282
<i>closed down</i>	p. 282	Chile	
Berkeley Nuclear Power Station		<i>buys British reactor</i>	p. 31
<i>generating costs</i>	p. 296	Civil Science	
<i>operating experience</i>	pp. 8/20	<i>debate in Commons</i>	pp. 242/246
Birthday Honours	p. 177	Combustibili Nucleari	p. 33
BNDC, <i>see</i> British Nuclear Design & Construction Ltd.		Commercial fast reactor (CFR)	p. 70
Boilers		Compact high voltage power unit	p. 306
<i>in gas-cooled reactors</i>	p. 20	Computational Physics Conference	
Boiling Water Reactors (B.W.R.)	p. 59	<i>proceedings</i>	p. 309
<i>installed capacity</i>	p. 7	Computers	
Borehole logging	p. 45	<i>APACE centre courses</i>	p. 25
Bradwell nuclear power station			p. 54
<i>comparison with Hunterston B</i>	pp. 60/62	<i>course at Harwell</i>	p. 178
<i>operating experience</i>	pp. 8/20	<i>desk top</i>	p. 107
		<i>and statute book</i>	p. 115
		Concrete pressure vessels	p. 55
		<i>in Hunterston B</i>	p. 60
		<i>symposium on</i>	p. 42
			p. 74

Connah's Quay nuclear power station		Dungeness B <i>cont.</i>	
<i>application for consent</i>	p. 237	<i>costs</i>	p. 87
C-spring deflection gauge	p. 113	<i>progress</i>	p. 125
Culcheth Laboratory			p. 54
<i>to be closed</i>	p. 279		p. 88
Culham Laboratory	p. 243	E.D.F. reactors, Chinon	p. 322
<i>collaboration with Russia</i>	p. 118		p. 9
<i>fusion programme</i>	p. 317	Eickhoff, Dr. K. G., <i>M.B.E.</i>	p. 12
<i>plasma physics summer school</i>	p. 284	Electricity demand	p. 177
<i>progress</i>	p. 78	<i>expected rise</i>	p. 63
<i>staff</i>	p. 281	<i>and growth of nuclear power</i>	pp. 286/299
<i>superconductivity project</i>	p. 89	Electrodialysis	p. 27
<i>superheated plasma containment</i>	p. 239	<i>Harwell and industry</i>	p. 189
<i>survey of machining and forming</i>	p. 4	<i>Libya</i>	p. 119
Cyclotrons	p. 147	Electrohydraulic crusher	p. 114
<i>conferences</i>	p. 144	Electromagnetic differential pressure	
	p. 145	<i>gauge</i>	p. 304
		E.N.E.A., <i>see</i> European Nuclear Energy	
Danckwerts, Prof. P. V., <i>F.R.S.</i>	p. 119	Agency	
DAPHNE	p. 283	E.N.E.L. (Ente Nazionale per l'Energia	
Davidson, A. S., <i>M.B.E.</i>	p. 177	Elettrica)	p. 78
Dental drill	p. 107	Engineering Group	
Dental materials	p. 106	<i>disbanded</i>	p. 78
Desalination			p. 279
<i>A.E.A. programme</i>	p. 116	Engineering tribology	p. 109
<i>and combined A.G.R.</i>	p. 247	Enrico Fermi nuclear power station	
	p. 262	<i>performance</i>	p. 8
<i>dual-purpose plants</i>	p. 28	Enzyme assay	p. 150
<i>Harwell and industry</i>	pp. 189/190	E.S.O.N.E. (European Standards of	
<i>in Libya</i>	p. 119	Nuclear Electronics Committee)	p. 79
<i>in the U.K.</i>	p. 87	EURATOM	
<i>overseas contracts</i>	p. 281	<i>plutonium for</i>	p. 242
<i>progress</i>	p. 182	European Nuclear Energy Agency	
<i>R & D</i>	p. 27	<i>and fast breeder reactors</i>	p. 121
	p. 87	Exhibitions	
D.F.R., <i>see</i> Dounreay Fast Reactor		APACE Centre at Cadex 69	p. 175
DIDO	p. 283	<i>Inspex 69</i>	p. 319
DIMPLE	p. 283	<i>I.R.P.A. at Brighton</i>	p. 271
Disney, H. V., <i>C.B.E.</i>	p. 78		p. 302
D.M.T.R., <i>see</i> Dounreay Materials		<i>Medical Instrumentation</i>	p. 176
Testing Reactor		<i>Melbourne Expo Electric</i>	p. 238
Dodewaard reactor, Netherlands			p. 306
<i>A.E.A. fuel for</i>	p. 241	<i>Nuclex 69</i>	pp. 267/271
Double screened transformers	p. 115		pp. 303/305
Dounreay Experimental Reactor		<i>Oceanology 69</i>	p. 115
Establishment		<i>Physics Exhibition</i>	pp. 112/115
<i>Prime Minister's visit to</i>	p. 237	<i>São Paulo, Brazil</i>	p. 53
<i>progress</i>	p. 125		pp. 110/111
Dounreay Fast Reactor (D.F.R.)	pp. 67/69	<i>Sydney Trade Fair</i>	p. 238
<i>commercial contracts</i>	p. 149		p. 318
<i>electricity generated</i>	p. 25		
<i>fuel experiments in</i>	p. 279		
<i>restored to power</i>	p. 282		
Dounreay Materials Testing Reactor		Fairey Engineering Ltd.	
(D.M.T.R.)		<i>reactor sales to Brazil</i>	p. 238
<i>closure</i>	p. 150	<i>reactor sales to Chile</i>	p. 31
	p. 183	Fast breeder reactors	p. 151
	p. 282		p. 201
Dounreay mixer settler	p. 143		pp. 279/280
DRAGON reactor	p. 61	<i>benefits and characteristics</i>	p. 65
	p. 121	<i>commercial designs</i>	p. 54
<i>continuation of project</i>	p. 1		pp. 59/74
<i>fluidised bed furnace</i>	p. 145	<i>fuel requirements</i>	p. 125
<i>heat exchanger replacement costs</i>	p. 322		p. 26
<i>Tenth Anniversary</i>	pp. 215/236		p. 298
Dungeness A nuclear power station		Fast reactor irradiation conference	p. 146
<i>operating experience</i>	pp. 8/20	Fast reactor physics conference	p. 34
Dungeness B nuclear power station	pp. 9/12	Fessenheim reactors, France	p. 10
<i>comparative costs</i>	p. 205	Film catalogue	
	p. 206	<i>new edition</i>	p. 271
<i>contract</i>	p. 56	Finiston, Dr. H. M., <i>F.R.S.</i>	p. 119

Fish farming		Generating costs	p. 124
<i>at Hunterston</i>	p. 91	<i>comparative figures</i>	p. 90
Fluidised bed furnace	p. 144		p. 248
Flux distortion flowmeters	p. 304	<i>trend</i>	p. 73
Fracture toughness symposium	p. 175	Geological surveys	p. 247
France		GLEEP	p. 283
<i>experience with gas-cooled reactors</i>	pp. 6/22	Glueckauf, Dr. E., <i>F.R.S.</i>	p. 119
Franklin, Dr. Norman		Graphite	
<i>new A.E.A. Member</i>	p. 29	<i>in gas-cooled reactors</i>	p. 17
Freezing process	p. 28	Greece	
<i>Harwell and industry</i>	p. 189	<i>nuclear reactor for</i>	p. 150
Fuel			p. 182
<i>A.E.A. and U.S. sales collaboration</i>	p. 178		p. 239
<i>annual station requirements</i>	p. 205		p. 262
<i>experiments in D.F.R.</i>	p. 279	Ground water investigations	pp. 44/45
<i>for Dodewaard reactor</i>	p. 241	Group Technology	pp. 310/316
<i>in gas-cooled reactors</i>	p. 17	Group Technology Centre	p. 165
<i>irradiation in S.G.H.W.R.</i>	p. 308		p. 241
<i>planning future enrichment plants</i>	pp. 36/42	Grove, Dr. W. P., <i>C.B.E.</i>	p. 177
<i>Production Group exhibits on</i>	p. 269	Gulf General Atomic	
<i>reprocessing of Italian</i>	p. 33	<i>A.E.A. fuel sales collaboration</i>	p. 178
	p. 78		
<i>reprocessing for Spain</i>	p. 213	Hartlepool (Seaton Carew) nuclear power	
<i>from Tokai-mura</i>	p. 265	<i>station</i>	p. 10
Fuel company	p. 278		p. 35
Fuel elements			p. 284
DRAGON	pp. 225/229	<i>costs</i>	p. 2
<i>gas sampling by laser</i>	pp. 166/173		p. 125
Fuel logistics	p. 64	Harwell, <i>see</i> Atomic Energy Research	
Fuel services		Establishment	
<i>for Italy</i>	p. 33	Harwell 7000 Series	p. 81
<i>for Oskarshamn</i>	p. 284	Health physics	
Fuel supplies	p. 124	<i>Imperial College summer school</i>	p. 24
Fusion	p. 4	Heat Transfer and Fluid Flow Service	p. 195
<i>Anglo-U.S.S.R. collaboration</i>	p. 118	Heavy ion accelerator	p. 307
	p. 317	Heavy Water Reactors	
<i>plasma physics summer school</i>	p. 78	<i>installed capacity</i>	p. 7
<i>progress</i>	p. 281	HECTOR	p. 283
	p. 284	HELEN reactors	
		<i>Brazilian order</i>	p. 238
		HERALD reactor	
		<i>Brazilian order</i>	p. 238
		<i>for Chile</i>	p. 31
Gamma camera	p. 107	HERO	p. 283
Gamma spectrometer NIS 292	p. 53	Heysham nuclear power station	
Garigliano nuclear power station		<i>approval for</i>	p. 309
<i>performance</i>	p. 8	High intensity stress measurement	p. 114
<i>reprocessing fuel for</i>	p. 33	High temperature chemical technology	p. 33
	p. 78	High Temperature Reactors	p. 297
Gas centrifuge process	pp. 40/42	DRAGON <i>Project</i>	pp. 215/236
	p. 77	Hill, Dr. J. M.	
	p. 89	<i>Knighthood</i>	p. 177
	p. 125	Hinkley Point A nuclear power station	
	p. 148	<i>operating experience</i>	pp. 8/20
<i>debate in Commons</i>	pp. 179/182	Hinkley B nuclear power station	p. 10
<i>progress</i>	p. 151		p. 12
Gas circulators		<i>costs</i>	p. 282
<i>in gas-cooled reactors</i>	p. 19	Holographic visual displays	p. 113
Gas-cooled reactors		Honours and awards	
<i>A.E.A. programme</i>	p. 279	<i>Birthday Honours</i>	p. 177
<i>experience with</i>	pp. 6/22	<i>New Year Honours</i>	p. 31
<i>design evolution</i>	p. 10	HORACE	p. 283
<i>installed capacity</i>	p. 7	Hunterston A nuclear power station	
<i>world list of</i>	p. 9	<i>fish farming at</i>	p. 91
Gas mains		<i>operating experience</i>	pp. 8/13
<i>radioactive tracers in</i>	pp. 126/140	<i>siting</i>	p. 184
Gas sampling		Hunterston B nuclear power station	pp. 10/12
<i>of fuel elements by laser</i>	pp. 166/173	<i>comparison with Bradwell</i>	pp. 60/62
Generating capacity		<i>construction</i>	p. 55
<i>installed in W. Europe and U.K.</i>	p. 60	<i>costs</i>	p. 148
<i>by reactor type</i>	p. 61	Hutcheon, J. M., <i>O.B.E.</i>	p. 31

Hydrology		Medical infra-red scanner	p. 107
<i>isotope applications in nuclear instruments</i>	pp. 43/45 p. 45	Medical Instrumentation Exhibition Melbourne	p. 176
		<i>A.E.A. at Expo. Electric</i>	p. 238 p. 306 p. 114
Imperial College, London		Metastable ion detector	
<i>health physics summer school</i>	p. 24	Meteorology	
Indicating manometer	p. 114	<i>isotope applications in</i>	pp. 48/50
Industrial research at Harwell	pp. 185/197	Millimetre wave interferometer	p. 114
Infra-red spectrometry	p. 108	Modulation polarograph	p. 113
Inspex '69	p. 319	Moisture measurement	
Integrating nephelometer	p. 111	<i>conference on</i>	p. 52
International Radiation Protection Association		Morgan, Dr. F., <i>O.B.E.</i>	p. 177
<i>Congress</i>	p. 271 p. 302	Mössbauer spectrometers	p. 113
		MQ 20 pressure transducer	p. 274
		Multi-stage flash distillation (M.S.F.)	p. 27
		<i>A.E.A. development programme</i>	p. 189
"Inventions and designs licensed to industry"			
<i>new editions</i>	p. 308		
Ion exchange conference	p. 176	NESTOR	p. 283
Ion implantation	p. 113	Netherlands	
I.R.P.A., <i>see</i> International Radiation Protection Association		<i>A.E.A. fuel for</i>	p. 241
Isotope current meters	p. 48	Neutron activation analysis service	p. 195
Isotope separator	p. 275	Neutron radiographic service	p. 273
Italy		Neutron soil moisture gauge	p. 45
<i>E.N.E.L. stations performance</i>	p. 8	New Year Honours	p. 31
		Non-destructive testing	pp. 155/165
		Nondestructive Testing Centre, Harwell	pp. 155/165
Japan		<i>enquiries</i>	p. 195
<i>A.E.A. team visits</i>	p. 178	<i>exhibits at Inspex</i>	p. 319
<i>Windscale reprocesses fuel from</i>	p. 265	<i>neutron radiography service</i>	p. 273
Jose Cabrera nuclear power station (Zorita reactor)		<i>programme on ultrasonic probes</i>	p. 212
<i>A.E.A. reprocesses fuel</i>	p. 213	Nuclear electronic equipment standards	pp. 79/81
JUNO	p. 283		pp. 198/211
		Nuclear energy, peaceful use of	
		Nuclear Enterprises Ltd.	
		<i>CAMAC sales</i>	p. 242
Kronberger, Dr. Hans		Nuclear fission	p. 58
<i>new A.E.A. Member</i>	p. 29 p. 277	Nuclear fuel cycle	p. 205
		Nuclear fusion reactors	
		<i>conference</i>	p. 32
		Nuclear generation	
		<i>comparative tables</i>	p. 198 p. 199
Lasers		Nuclear industry	
<i>gas sampling by</i>	pp. 166/173	<i>Consortia</i>	p. 153
Latina nuclear power station	p. 33	<i>new reactor company</i>	p. 30
<i>A.E.A. reprocesses fuel</i>	p. 78	<i>reorganisation of</i>	p. 3
<i>operating experience</i>	pp. 8/20		p. 56
Lead shielding			p. 281
<i>conference</i>	p. 2		p. 81
"Leven Fisher", M.V.		Nuclear Installations Act, 1965	
<i>and carriage of irradiated fuel</i>	p. 265	Nuclear Installations Bill	
Libya		<i>debate in Commons</i>	pp. 81/87
<i>desalination plant</i>	p. 119	Nuclear magnetic resonance spectro-	
LIDO	p. 283	<i>metry</i>	p. 109
Lightfoot, T. C., <i>M.B.E.</i>	p. 31	Nuclear power	
Liverpool College of Technology		<i>the growth of demand for</i>	pp. 286/299
<i>radiochemistry course</i>	p. 76 p. 99	Nuclear powered airships	p. 239
		Nuclear Power Group, The (T.N.P.G.)	p. 30
			p. 278
Magneto-hydro-dynamic power	p. 25		p. 281
Marcoule reactors, France	pp. 9/10 p. 12	<i>constituent firms</i>	p. 153 p. 177
			p. 205
Marine Technology Support Unit (MATSU)	p. 115	Nuclear power programme	
Marshall, Dr. W.		<i>list of sites</i>	p. 153
<i>Director of Research Group</i>	p. 117	Nuclear power stations	
Materials Technology Bureau		<i>advantages of</i>	p. 296
<i>enquiries</i>	p. 195	<i>AGR capacity</i>	p. 309
Mechanical Standards Laboratories	p. 197	<i>amortisation period</i>	p. 125
<i>leaflet on</i>	p. 236	<i>annual fuel requirements</i>	p. 205
Medical endoscopes, dual viewing	p. 106	<i>breakdowns</i>	p. 183

Nuclear power stations <i>cont.</i>			
<i>comparative core dimensions</i>	p. 65	Pressure vessels	
<i>comparison with coal-fired</i>	p. 203	<i>in gas-cooled reactors</i>	p. 19
<i>Connah's Quay</i>	p. 322	<i>report on</i>	p. 147
<i>construction costs in U.K.</i>	p. 237	Pressurised Water Reactors (P.W.R.)	p. 59
<i>exports</i>	p. 209	<i>installed capacity</i>	p. 7
<i>future operating role of</i>	p. 322	Production Group	
<i>generating capacity by reactor type</i>	pp. 248/262	<i>fuel sales</i>	p. 33
<i>generation costs</i>	p. 199	<i>and Nuclear Fuel Company</i>	p. 322
<i>generating costs in U.K.</i>	p. 2	<i>at Nuclex exhibition</i>	p. 304
	p. 205	Programmes Analysis Unit, Harwell	p. 88
	p. 207		p. 190
<i>increased assumed life of</i>	p. 322	Proportional sampler	p. 242
<i>oxidation of steel in</i>	p. 282	Prototype Fast Reactor (P.F.R.)	p. 113
<i>percentage of electricity generated</i>	p. 322	<i>additional costs</i>	p. 69
<i>safety and siting symposium</i>	p. 321	<i>delays</i>	p. 184
<i>siting policy</i>	p. 198		p. 152
<i>technological advances</i>	p. 31		p. 280
Nuclear propulsion	p. 2		p. 282
	p. 5		p. 321
<i>study</i>	p. 246	<i>exhibits at Nuclex</i>	p. 269
Nuclex '69	p. 296	<i>progress</i>	p. 5
<i>U.K. exhibits at</i>	p. 151	P.W.R., <i>see</i> Pressurised Water Reactors	
	pp. 267/271		
<i>U.K.A.E.A. papers</i>	p. 303	Radiation and Man	
<i>U.K.A.E.A. publications</i>	p. 305	<i>second international congress</i>	p. 2
	p. 305	Radioactive areas	
	p. 323	<i>surface materials for</i>	p. 148
Oceanography		Radiochemical Centre, Amersham	
<i>isotope applications in</i>	pp. 45/48	<i>increased turnover</i>	p. 278
Oceanology '69	p. 115	<i>joint company</i>	p. 282
Oldbury nuclear power station		<i>new catalogue</i>	p. 76
<i>opening ceremony</i>	p. 238	Radiochemistry course	
<i>operating experience</i>	pp. 9/20	<i>at Liverpool College of Technology</i>	p. 76
Orfordness, Suffolk			p. 99
<i>future of</i>	p. 183	Radiography	
	p. 279	<i>non-destructive testing</i>	pp. 160/161
Organic mass spectrometry	p. 109	Radioisotopes	
Oskarshamn nuclear power station		<i>in environmental and ocean sciences</i>	pp. 43/51
<i>A.E.A. reprocess fuel from</i>	p. 284	<i>in sea-bed tracing</i>	p. 115
<i>"Otto Hahn"</i>	p. 120	<i>tracers in gas mains</i>	pp. 126/140
		<i>uses</i>	p. 194
Package irradiation plants	p. 194	Radioisotopes Catalogue	p. 76
Peach Bottom nuclear power station	p. 9	Radiological Protection Board	p. 90
Penney, Lord, O.M.	p. 213	Reactor Export Committee	p. 322
P.F.R., <i>see</i> Prototype Fast Reactor		Reactors	
Physico-Chemical Measurements Unit	p. 108	<i>U.K.A.E.A. list of</i>	p. 283
Physics Exhibition	pp. 112/115	<i>Rennie, C. A., C.M.G.</i>	p. 31
Plasma confinement experiments	p. 112	Research Group	
Plasma focus experiment	p. 112	<i>Director</i>	p. 117
Plasma physics		Reverse osmosis	p. 28
<i>summer school</i>	p. 78	<i>Harwell and industry</i>	p. 189
PLUTO	p. 283	Royal Society	
Plutonium	p. 200	<i>Fellows</i>	p. 119
<i>in fast reactors</i>	p. 65	Rushby, W. E., B.E.M.	p. 31
<i>for Germany</i>	p. 242		
<i>I.A.E.A. safeguards</i>	p. 53	Saddle-coil flowmeter	p. 270
<i>supplies</i>	p. 124		p. 304
<i>from Zorita station</i>	p. 213	St. Laurent reactors, France	p. 10
Plutonium-238		São Paulo exhibition	p. 110
<i>in cardiac pacemaker</i>	p. 102	Science and Technology Act, 1965	p. 188
Post-Graduate Education Centre, Harwell		Scotland	
<i>courses</i>	p. 22	<i>uranium prospecting</i>	p. 5
	p. 92	Seaton Carew nuclear power station,	
	p. 142	<i>see</i> Hartlepool	
	p. 263	Select Committee on Science and	
	p. 272	<i>Technology</i>	
	p. 300	<i>reactor programme report</i>	p. 4
	p. 324	Semiconductor radiation detectors	p. 106
Press Conference		S.G.H.W.R., <i>see</i> Steam Generating Heavy	
<i>Chairman's speech</i>	pp. 277/281	<i>Water Reactor</i>	

Short range radio telemetry system	p. 106	U.K.A.E.A. <i>cont.</i>	
Silicon-32		<i>civil R & D expenditure</i>	p. 284
<i>in hydrological studies</i>	p. 44	<i>civil research programmes</i>	p. 89
Siting symposium		<i>co-operation with Austria</i>	p. 150
<i>of nuclear power stations</i>	p. 31	<i>Engineering Group dissolved</i>	p. 78
Sizewell A nuclear power station		<i>expenditure</i>	p. 154
<i>operating experience</i>	pp. 8/20		p. 182
Sizewell B nuclear power station	p. 35	<i>exports of fuel services</i>	p. 33
<i>approval for</i>	p. 309		p. 279
Sodium		<i>future programme</i>	p. 278
<i>properties of</i>	p. 66	<i>fuel for Netherlands</i>	p. 241
Sodium instrumentation		<i>medical engineering</i>	pp. 100/107
<i>for P.F.R.</i>	p. 304	<i>meetings with Japan</i>	p. 178
Sodium level measurement	p. 304	<i>new Members</i>	p. 29
Soil moisture probe	p. 75	<i>non-nuclear work</i>	p. 244
Sol-gel projects			p. 284
<i>at Harwell</i>	p. 191	<i>power station for Greece</i>	p. 150
Spain			p. 182
<i>A.E.A. reprocesses fuel for</i>	p. 213		p. 239
Springfields	p. 279		p. 262
<i>exhibits at Inspex</i>	p. 319	<i>reactor programme</i>	p. 284
Steam Generating Heavy Water Reactor		<i>reactors, table of</i>	p. 283
(S.G.H.W.R.)		<i>reorganisation of</i>	pp. 3/4
<i>advantages of</i>	p. 297	<i>reports available</i>	p. 24
<i>commercial designs</i>	p. 284		p. 51
<i>costs of delays to</i>	p. 321		p. 74
<i>first year</i>	p. 26		p. 116
<i>fuel irradiation in</i>	p. 282		p. 141
Stewart, J. C. C.	p. 308		p. 173
<i>new appointment</i>	p. 2		p. 184
	p. 277		p. 240
"Stream Fisher", M.V.			p. 264
<i>carrying irradiated fuel</i>	p. 78		p. 276
Superconducting materials			p. 299
<i>test facility at Culham</i>	p. 239		p. 320
Superheated plasma containment	p. 4	<i>reprocesses fuel for Italy</i>	p. 78
Surgical implants, corrosion of	p. 107	<i>reprocesses fuel for Oskarshamn</i>	p. 285
Sydney Trade Fair		<i>reprocess fuel for Spain</i>	p. 213
<i>A.E.A. stand at</i>	p. 238	<i>requirements for separative work</i>	pp. 36/42
	p. 318	<i>research costs</i>	p. 152
		<i>sales</i>	p. 284
		<i>staff, assets and income</i>	p. 54
Technological co-operation in Europe			p. 57
<i>Commons debate</i>	pp. 120/124		p. 247
Thorium	p. 64		p. 279
Thyopac-3	p. 308	Ultra-centrifuge	pp. 40/41
T.N.P.G., <i>see</i> Nuclear Power Group, The		Ultrasonic probes	p. 212
Tokai-mura nuclear power station		Ultrasonic testing	p. 162
<i>operating experience</i>	pp. 6/22	Uranium	
<i>reprocessing irradiated fuel from</i>	p. 265	<i>corrosion and protection of</i>	pp. 93/99
TCKAMAK 3	p. 317	<i>demand for</i>	p. 246
Tracers, radioactive		<i>estimated demand to 2000 A.D.</i>	p. 202
<i>in gas mains</i>	pp. 126/140		p. 204
Trawsfynydd nuclear power station		<i>for fast reactors</i>	p. 26
<i>operating experience</i>	pp. 8/20	<i>from sea water</i>	p. 91
Tribology		<i>from Zorita station</i>	p. 213
<i>report</i>	p. 147	<i>price of</i>	p. 148
<i>symposium on</i>	p. 264	<i>prospecting in Scotland</i>	p. 5
	p. 306	<i>supplies of</i>	p. 151
Tritium			p. 153
<i>in hydrological studies</i>	pp. 43/45	<i>survey in Wales</i>	p. 35
Troon, Scotland		Uranium, enriched	
<i>experimental desalination plant</i>	p. 116	<i>enrichment plants</i>	pp. 36/42
Tuohy, T., C.B.E.	p. 31		p. 77
<i>At São Paulo exhibition</i>	p. 111	<i>gas centrifuge co-operation</i>	p. 52
			pp. 179/182
		<i>supplies of</i>	p. 124
U.K.A.E.A.		U.S.S.R.	
<i>Anglo-American fuel sales</i>	p. 178	<i>collaboration on fusion</i>	p. 118
<i>Annual Report</i>	pp. 277/285		p. 317

VERA	p. 283	Winfrith, <i>see</i> Atomic Energy Establishment,	
VIPER	p. 283	Winfrith	
Wales		Work Study School, Risley	
<i>uranium survey in</i>	p. 35	<i>courses</i>	p. 236
Wantage Research Laboratory		Wylfa nuclear power station	p. 153
<i>to be closed</i>	p. 279		p. 296
Weir Westgarth		X-ray grating spectrograph	p. 114
<i>Troon establishment</i>	p. 116	X-ray machine, low energy	p. 115
Welding research	p. 91		
Windscale Works		ZEBRA (zero energy breeder reactor assembly)	
<i>reprocessing capacity</i>	p. 213	<i>safeguarded plutonium in</i>	p. 53
	p. 266	ZENITH	p. 283
	p. 284	Zorita nuclear power station	
<i>separation plant</i>	p. 279	<i>A.E.A. reprocesses fuel for</i>	p. 213

TITLES OF MAIN ARTICLES

January

A review of experience with gas-cooled reactors

R. V. Moore to The American Nuclear Society in Washington, D.C.

February

Planning for future enrichment plants

C. Allday, D. G. Avery and R. B. Kehoe to a symposium on Nuclear Fuel Utilisation in Milan.

Growth potential for isotope applications in environmental and ocean sciences

D. B. Smith to the International Conference on The Constructive Uses of Atomic Energy, in Washington, D.C.

March

The process of nuclear fission

Dr. J. E. Lynn to the Annual Meeting of the American Physical Society in New York.

Fast breeder reactor power stations

R. V. Moore to a meeting of the Société Royale Belge des Ingénieurs et des Industriels in Brussels.

April

The corrosion and protection of uranium

by Dr. S. Orman of A.W.R.E., Aldermaston.

A.E.A. work in medical engineering

May

The use of radioactive tracers in gas mains

by R. W. N. Cameron and M. J. F. Olden of the South Western Gas Board to the Institution of Gas Engineers in Bristol.

A mobile system for measuring flow in a gas distribution network

C. G. Clayton, G. V. Evans, R. Spackman and I. W. Webb to the Institution of Gas Engineers in Bristol.

June

Non-destructive testing

R. S. Sharpe to the Ninth Commonwealth Mining and Metallurgical Congress in London.

Gas sampling of fuel elements by laser piercing techniques

by W. Lilley.

July

Harwell and industrial research

The Maurice Lubbock Memorial Lecture by Dr. W. Marshall to the Department of Engineering Science, University of Oxford.

The peaceful use of nuclear energy

Dr. M. Davis to the Turkish Economic Research Foundation International Seminar on Technology and Economic Development, at Istanbul.

August

The DRAGON Project 1959-1969

September

Civil Science

Debate in the House of Commons.

The future operating role of nuclear power stations

by G. R. Bainbridge and C. Beveridge.

October

The U.K. at Nuclex 69

November

15th Annual Report and Press Conference

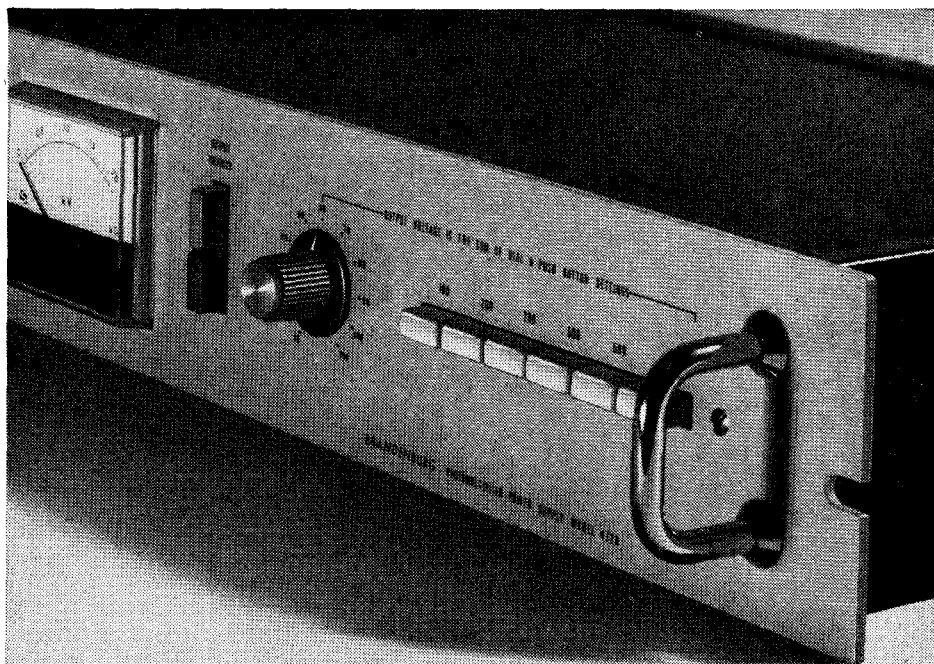
The growth of demand for energy and the role of nuclear power

P. J. Searby to the International Atomic Energy Agency Symposium on nuclear energy costs and economic development, in Istanbul.

December

Group Technology

by D. Bennett, Senior Project Engineer, the Group Technology Centre, U.K.A.E.A., Blacknest.



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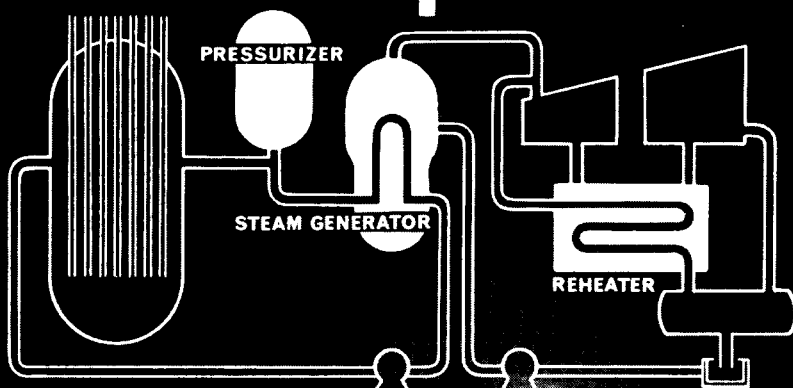
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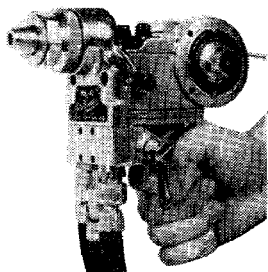
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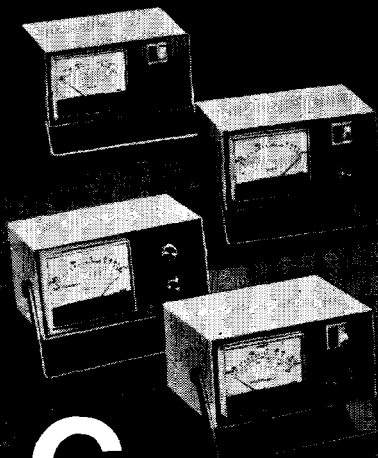
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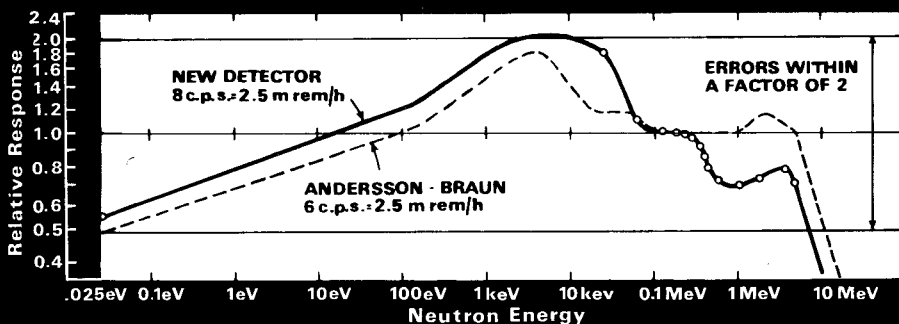
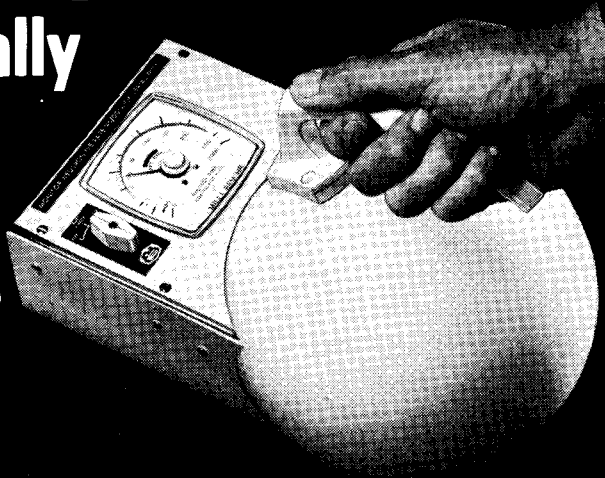
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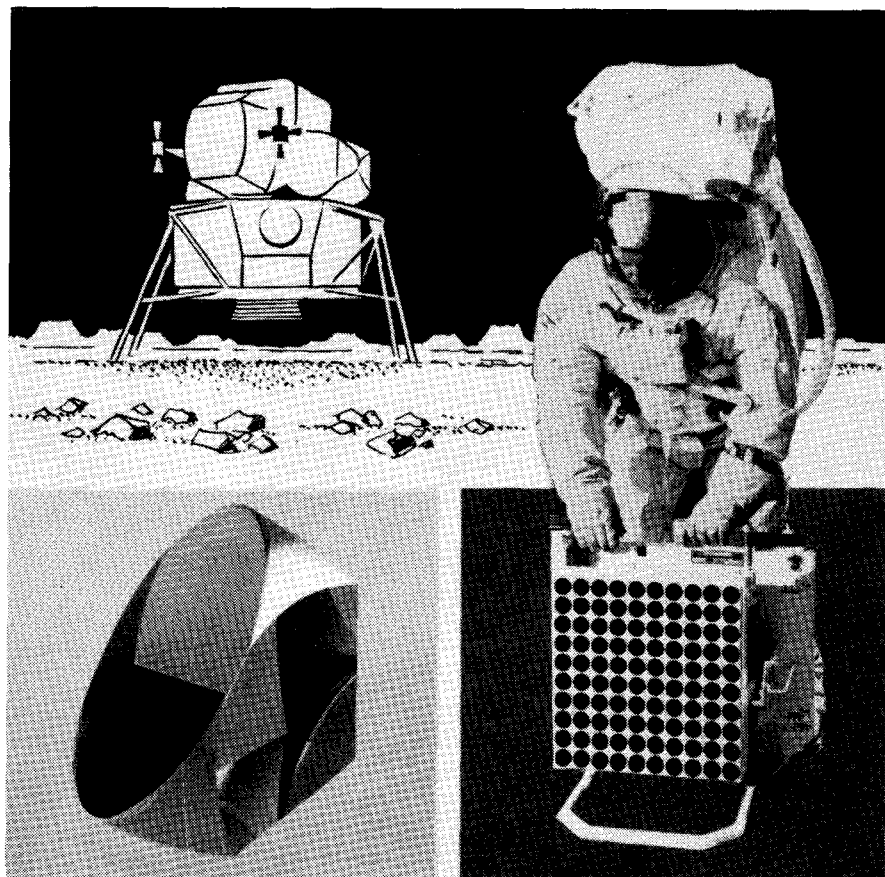
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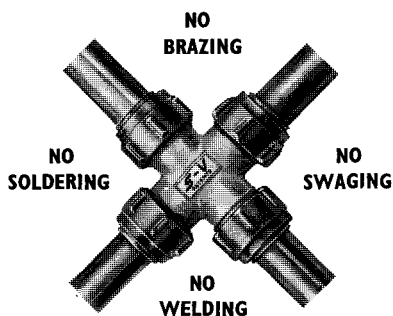
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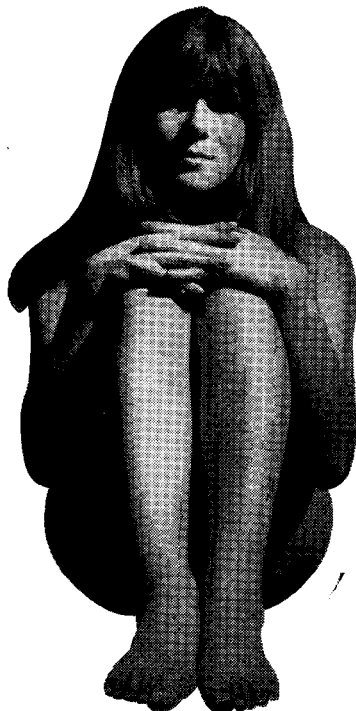


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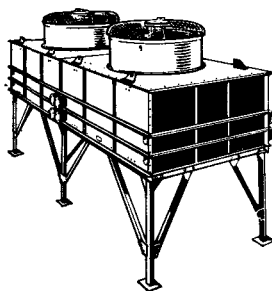
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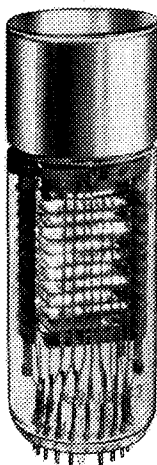
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