71-5805

Duratek™

140 Stonendge Drive
Columbia, South Carolina 29210
803-256-0450
www duratekinc.com

Mr. E. William Brach, Director
Spent Fuel Project Office
Office of Nuclear Material Safety and Safeguards
U.S. Nuclear Regulatory Commission
Washington, DC 20555

October 03, 2002
E&L-049-02

Dear Mr. Brach:

SUBJ: SAFETY ANALYSIS REPORT FOR MODEL NO. 3-55, REV. 3

Duratek Inc. respectfully submits the enclosed application for the subject revision to the Safety Analysis Report (SAR) for the CNS 3-55 Certificate of Compliance No. 5805.

This proposed amendment requests a change to the cask vent plug gasket material; as the material currently specified (Anchor Tauril) is no longer available. The replacement material (Garlock 9850) has comparable characteristics relative to resistance to high temperature and high pressure. References to "Anchor Taurıl" have been replaced with "Garlock 9850" within the SAR text (Pages 3-23, 3-26, and 4-3) and drawings (Drawing Nos. MOD-100 and 0999-C-08).

In addition to the changes noted above, the following changes are also requested to Drawing No. 0999-C-08:

- Revise callout for the 1/16" o-ring for the optional plug in the cask vent to include "or equal".
- The "threads per inch" callout for the blind tapped hole located in the center of the vent plug was corrected – from 12 to 13.

Also, editorial revisions have been made to SAR text (Page 1-9) to reflect and agree with drawing changes approved under a previous submittal.

To facilitate your review of the drawing changes, "marked up" copies of SAR Drawing Nos. 0999-C-08, Rev. 9 and MOD-100, Rev. 14 have been included in attachments 5 and 6. The changes have been circled in red.

No change to packaging contents is being requested, and no changes to the operating and maintenance sections (Chapters 7 and 8 respectively) are required as a result of the proposed changes.

If you or members of your staff have any questions about the application, please feel free to contact Shayne Merritt at (803) 758-1838.

Sincerely,

Patrick L. Paquin
General Manager

NMSS01

Attachments:
(1) Directory of Changes for Incorporating Revision 4 CNS 8-120B Safety Analysis Report
(2) Revision 3 Text Change Pages
(3) Drawing No. MOD-100 Revision 14 (3 copies)
(4) Drawing No. 0999-C-08 Revision 9 (3 copies)
(5) "Marked Up" Copy of Drawing No. MOD-100 Revision 13 (1 copy)
(6) "Marked Up" Copy of Drawing No. 0999-C-08 Revision 8 (1 copy)

Attachment One

Directory of Changes for Incorporating Revision 3 of the CNS 3-55 Safety Analysis Report

Remove These Pages From Rev. 2	Insert These Rev. 3 Pages
Cover Sheet	Cover Sheet
1-9	1-9
3-23	3-23
3-26	3-26
4-3	4-3
Chapter 9 Cover – "List of Drawings for CNS 3-55 Shipping Cask"	Chapter 9 Cover – "List of Drawings for CNS 3-55 Shipping Cask"
Drawing No. MOD-100 Revision 13	Drawing No. MOD-100 Revision 14
Drawing No. 0999-C-08 Revision 8	Drawing No. 0999-C-08 Revision 9

Attachment Two

SAFETY ANALYSIS REPORT

For

MODEL CNS 3-55 TYPE B SHIPPING PACKAGING

REVISION 3

OCTOBER 2002

Submitted by:

Duratek, Inc
140 Stoneridge Dr.
Columbia, S.C. 29210

The vent hole in the closed end of the cask is plugged by a 6.00 inch long, lead filled 1.00 inch schedule 40 stainless steel pipe, welded to a circular cover cap plate, 1.5 inch thick by 7.375 inches O.D., sealed with a 1/8 inch thick gasket of sheet packing and a 3/8" silicone o-ring. The assembly is fastened with four 0.50 inch by 2.00 inch bolts.

This vent plug assembly may also contain the following optional configuration: A recessed plug valve stem sealed with a 1/16 inch by 3/16 inch silicone o-ring. The stem is threaded 7/16-14 NC and can be opened to a diagonal ¼-18 NPT threaded sampling port for test pressure gauge or vent sampling. The sample port is plugged with a ¼ inch NPT male pipe plug when not in use. The valve stem is closed by turning in to full stop. The radial o-ring on the end of the stem in conjunction with the other o-rings shown on Drawing No. 0999-C-08 seal the containment. A 1-1/2 inch by 3 inch by 1/8 inch stainless cover plate with a 1/16 inch neoprene gasket retained by (6) 8-32 by ¼ inch stainless steel bolts covers the recessed valve stem hole and the test port hole when not in use or in transport.

Total material shield thickness of closed end of the cask is 3.125 inches of steel and 5.25 inches of lead.

The cylindrical cavity liner and the cylindrical outer shell, at the open end of the cask, are welded to a 1.25 inch ring plate, 50.50 inches O.D. by 36.625 inches I.D., T-304 stainless steel.

3.5.6.2 Performance Evaluation of Cask Drain and Vent

The thermal performance of the drain vent valve and vent plug (in center of cask top) will be adequate when subjected to fire test conditions. The drain line will be sealed with a vent valve designed to relieve at a pressure of 25 psig. (Reference Appendix 3.6.3.)

The vent assembly in the center of the cask top consists of a lead filled steel plug insert in the vent opening and a 1 ½ inch thick plate bolted to the top to secure the plug insert. A Garlock 9850 flat gasket (or equivalent) will be used to seal the vent plate to the cask body. This gasket is rated at a temperature and pressure of 900°F and 2000 psig, respectively. This material will provide a satisfactory seal under the fire test conditions. (Reference Appendix 3.6.2).

High Temp Compressed Graphite or Carbon Fiber Gasketing

Typical Physical Properties*

		G-9900	9800	9850
Color		Mahogany	Black	Black
Composition		Graphite with nitrile	Carbon with SBR	Carbon with nitrile
Temperature[1]	Maximum	+1000°F (+540°C)	+900°F (+480°C)	+900°F (+480°C)
	Minimum	-40°F (-40°C)	-40°F (-40°C)	-40°F (-40°C)
	Continuous max.	+650°F (+340°C)	+650°F (+340°C)	+650°F (+340°C)
Pressure[1]	psig	2000	2000	2000
	(bar)	(138)	(138)	(138)
P x T, max.[1] (psig x °F)	1/32", 1/16"	700,000	700,000	700,000
(bar x °C)	(0 8 mm, 1.6 mm)	(25,000)	(25,000)	(25,000)
	1/8"	350,000	350,000	350,000
	(3.2 mm)	(12,000)	(12,000)	(12,000)
Sealability (ASTM F37B)[2]				
ASTM Fuel A	ml/hr	0.1	0.1	0.1
Nitrogen	ml/hr	0.1	0.1	0.1
Creep Relaxation (ASTM F38)	%	9	15	15
Compressibility Range (ASTM F36)	%	7-17	7-17	7-17
Recovery (ASTM F36)	min. %	65	55	56
Fluid Resistance (ASTM F146)				
ASTM #1 Oil at +300°F (+150°C)				
Thickness increase	range %	0-5	0-10	0-5
Weight increase	max. %	10	20	10
ASTM IRM #903 Oil at +300°F (+150°C)				
Thickness increase	range %	0-10	15-40	0-10
Tensile loss	max. %	35	65	35
ASTM Fuel A at +70-85°F (+20-30°C)				
Thickness increase	range %	0-5	0-10	0-5
Weight increase	max. %	7	20	7
ASTM Fuel B +70-85°F (+20-30°C)				
Thickness increase	range %	0-10	5-20	0-10
Weight increase	max. %	15	20	15
Tensile Strength across grain (ASTM F152)	psi	1800	1500	1800
	(N/mm^2)	(12)	(10)	(12)
Density	lbs/ft^3	110	105	105
	(g/cm^3)	(1.76)	(1.68)	(1.68)
Gas Permeability (DIN 3535 Part 4)[3]	cc/min	0.015	0.015	0.015

Notes:

[1] When approaching maximum pressure or continuous operating temperature, or 50% of maximum PxT, consult Garlock Engineering

[2] ASTM F37B Sealability
ASTM Fuel A (isooctane)
Gasket load = 500 psi (3 5 N/mm^2), Int pressure = 9 8 psig (0 7 bar)
Nitrogen
Gasket load = 3000 psi (20 7 N/mm^2), Int pressure = 30 psig (2 bar)

This is a general guide and should not be the sole means of selecting or rejecting this material ASTM test results in accordance with ASTM F-104, properties based on 1/32" (0 8mm) sheet thickness

[3] DIN 3535 Part 4 Gas Permeability, cc/min (1/16" thick)
Nitrogen
Gasket load = 4640 psi (32 N/mm^2), Int pressure = 580 psig (40 bar)

All styles are furnished with an anti-stick parting agent as standard

*** Values do not constitute specification limits**

4.1.3 (continued)

The closed end of the cask vent plug assembly contains a 1/8-inch thick Garlock 9850 (or equivalent) gasket to provide the seal for the vent plug assembly.

4.1.4 Closure

The cask closure assembly has a tapered sidewall penetrating into the inside diameter of the cask cavity which centers the closure with a close fit with less clearance than the closure bolts-to-bolt hole clearances.

The closure assembly is secured to the cask body assembly by (12) 1.50-inch diameter bolts, equally spaced, around the assembly flange and the cask retaining flange. These bolts are fabricated of AISI-4140 chrome-moly steel, 160,000 pounds U.T.S. These bolts are torqued to 75 ft.-lbs.(lubricated). Eight bolts are threaded 1-1/2- 8 UNC and four bolts, 1-1/2- 6 UN.

4.2 Requirements for Normal Conditions of Transport

4.2.1 Release of Radioactive Material

The CNS 3-55 cask is designed to assure no release of radioactive material in excess of limits prescribed in the NRC Regulatory Guide 7.4, "Leakage Tests on Packages for the Shipment of Radioactive Materials."

Table 4.2.1 shows the radiological limitations on a releasable medium that could transport radioactivity through leaks, if any exist, in the containment system. Appendix 4.4 summarizes the derivation of the limits given in the table. Provided these limits are not exceeded, compliance of the CNS 3-55 package with the requirements of the NRC Regulatory Guide 7.4 is assured. In accordance with Regulatory Position, Paragraph C of this

9.0 DRAWINGS

LIST OF DRAWINGS FOR CNS 3-55 SHIPPING CASK

Drawing Number		Drawing Name
MOD-100	Rev. 14	Modification of VNDB Cask (LS-6000-1)
C-111-D-0001	Rev. –	3-55 Cask Shield Ring
C-111-E-0002	Rev. 2	CNS 3-55 Lid Detail
MOD-139-1	Rev. K	VNDB Shipping and Storage Cask Engineering Reference Drawing
MOD-140	Rev. C	VNDB Shipping and Storage Cask Closure Detail
MOD-124	Rev. 5	VNDB Skid Assembly
0999-D-07	Rev. 8	Cask, Shock Absorber Detail for Top Cover, Bottom, & Trunnions
0999-C-08	Rev. 9	Vent
C-110-D-5001	Rev. 1	Sunshade for 3-55 Transport Cask

Attachment Three

THIS PAGE IS AN OVERSIZED DRAWING OR FIGURE,

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NOTE: Because of this page's large file size, it may be more convenient to copy the file to a local drive and use the Imaging (Wang) viewer, which can be accessed from the Programs/Accessories menu.

SHT 2 OF 5 | A

MODIFICATION INSTRUCTIONS:

1. DWG. NO. LS-6000-1 SHEET 1:

   REMOVE ITEM NO. 11. THIS ITEM TO BE FLUSH WITH ITEM NO. 1.

   DWG. NO. LS-6000-1 SHEET 2:

   REMOVE ITEM NOS. 12, 14, 15, 16, 18, 19, 22, AND 23.

   THESE ITEMS TO BE FLUSH WITH ITEM NO. 1.

2. DWG. NO. LS-6000-1 SHEET 2:

   ITEM NO. 13 TO BE CUT TO 4.50 DIM. REMOVE BURRS. (SEE DWG. NO. MOD-100 SHEET 1 VIEW "A" AND SECTION H-H.)

3. DWG. NO. LS-6000-1 SHEET 2:

   ITEM NO. 12 TO BE PLUG WELDED SEALED BOTH ENDS (TO BE FLUSH WITH ITEM NO. 1). (SEE DWG. NO. MOD-100 SHEET 1 SECTION F-F.)

4. DWG. NO. LS-6000-1 SHEET 2:

   (a) ADD ITEM NO. 104 LOCATE AND WELD PER DWG. NO. MOD-100 SHEET 1 SECTIONS D-D AND H-H. HOLES TO BE IN ALIGNMENT AFTER WELDING (TYPICAL 4 PLACES).

   (b) ADD ITEM NO. 106 LOCATE AND WELD PER DWG. NO. MOD-100 SHEET 1 SECTIONS D-D AND H-H. HOLES TO BE IN ALIGNMENT AFTER WELDING (TYPICAL 4 PLACES).

   (c) ADD ITEM NOS. 119 AND 104 LOCATE AND WELD PER DWG. NO. MOD-100 SHEET 1 SECTIONS C-C AND H-H. HOLES TO BE IN ALIGNMENT AFTER WELDING (TYPICAL 8 PLACES). ADD ITEM NO. 105 LOCATE AND WELD

REV. LET.	REVISIONS	BY	DATE	REV. LET.	REVISIONS	BY	DATE
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—	—	N 9954	MOD-100	14

SHEET 2 OF 5 SHEETS

SHT 3-5 | A

5. DWG. NO. MOD-100 SHEET 1:

(a) ADD ITEM NO. 125. LOCATE AND WELD PER DWG. NO. MOD-100 SHEET 1.

(b) ADD ITEM NO. 128 TO ITEM 125 USING FOUR 1-8 UNC x 1.88 LONG BOLTS.

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MODIFICATION INSTRUCTIONS
VNDB CASK (LS-6000-1)

ACCT. NO. N 9954

DWG. NO. MOD-100 | 14

SHEET 3 OF 5 SHEETS

PER DWG. NO. MOD-100 SHEET 1 SECTIONS C-C AND H-H. HOLES TO BE IN ALIGNMENT AFTER WELDING (TYPICAL 8 PLACES).

6. DWG. NO. LS-6000-1 SHEET 2:

DRILL SIX 0.75-DIA. HOLES ON AN 8.00-DIA. ON THE CENTER LINE OF ITEM NO. 13. DRILL THROUGH ITEM NO. 1 ONLY! PLUG WELD ITEM NO. 17 TO ITEM NO. 1 (TYPICAL 6 HOLES). TYPICAL 2 PLACES. (SEE DWG. NO. MOD-100 SHEET 1 VIEW "A" AND SECTION H-H .)

7. DWG. NO. LS-6000-1 SHEET 2:

ADD ITEM NOS. 101 AND 102 TO ITEM NO. 13 (2 PLACES). LOCATE AND WELD PER DWG. NO. MOD-100 SHEET 1 VIEW "A" AND SECTION H-H.

8. DWG. NO. LS-6000-1 SHEET 2:

ADD ITEM NOS. 107 AND 108, 2 REQUIRED EACH. LOCATE AND TACK WELD THESE ITEMS INTO POSITION PER DWG. NO. MOD-100 SHEET 1 VIEW "E" AND SECTIONS G-G AND H-H. MAKE ALL 0.50 FILLET WELDS FIRST. THEN MAKE THE 0.50 BEVEL "V" WELDS. FINISH WELDS AND MATCH FINISH DIRECTION (TYPICAL 4 PLACES).

9. DWG. NO. LS-6000-1 SHEET 1:

ADD ITEM NO. 116 TO ITEM NO. 3 (BASE PLATE) AND WELD PER DWG. NO. MOD-100 SHEET 1 SECTION H-H.

10. DWG. NO. LS-6000-1 SHEET 2:

(a) ADD ITEM NOS. 109 AND 114 TO ITEM NO. 3. POSITION THESE ITEMS AND WELD PER DWG. NO. MOD-100 SHEET 1 SECTION H-H.

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ACCT. NO. N 9954 | DWG. NO. MOD-100 | 14

(b) ADD ITEM NO. 110. LOCATE AND WELD PER DWG. NO. MOD-100 SHEET 1 SECTION H-H. NOTE: CAUTION MUST BE APPLIED AS TO INSURE PROPER ALIGNMENT BETWEEN ITEM NOS. 115, 111, 110, AND 114 (SECTION H-H).

(c) ADD ITEM NO. 115 TO ITEM NO. 111. POSITION ITEM NO. 115 WITH CAUTION TO INSURE PROPER ALIGNMENT WITH ITEM NOS. 110 AND 114. WELD PER DWG. NO. MOD-100 SHEET 1 SECTION H-H.

11. DWG. NO. LS-6000-1 SHEET 1:

ITEM NO. 120 REPLACES ITEM NO. 5 FOUR PLACES. SEE DWG. NO. MOD-100 SHEET 1 SECTIONS D-D AND H-H.

12. DWG. NO. LS-6000-1 SHEET 1:

ITEM NO. 121 REPLACES ITEM NO. 6 EIGHT PLACES. SEE DWG. NO. MOD-100 SHEET 1 SECTIONS C-C AND H-H.

13. DWG. NO. LS-6000-1 SHEET 1:

ITEM NO. 118 REPLACES ITEM NO. 15. SEE DWG. NO. MOD-100 SHEET 1 SECTION H-H.

14 DWG. NO. LS-6000-1 SHEET 1:

ITEM NO. 118 REPLACES ITEM NO. 13 (BOLTS). SEE DWG. NO. MOD-100 SHEET 1 SECTION H-H.

15. DWG. NO. LS-6000-1 SHEET 1:

ITEM NOS. 30, 17, 2, AND 14 NOT USED. (SEE DWG. NO. MOD-100 SHEET 1 SECTION H-H FOR REPLACEMENT ITEMS.)

16. DWG. NO. MOD-100 SHEET 1:

ADD ITEM NO. 122. LOCATE AND WELD PER SECTIONS H-H AND G-G.

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ACCT. NO.	DWG. NO.	
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SHEET 5 OF 5 SHEETS

Attachment Four

THIS PAGE IS AN OVERSIZED DRAWING OR FIGURE,

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Attachment Five

THIS PAGE IS AN OVERSIZED DRAWING OR FIGURE,

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SHT 2 OF 5 | A

MODIFICATION INSTRUCTIONS:

1. DWG. NO. LS-6000-1 SHEET 1:

   REMOVE ITEM NO. 11. THIS ITEM TO BE FLUSH WITH ITEM NO. 1.

   DWG. NO. LS-6000-1 SHEET 2:

   REMOVE ITEM NOS. 12, 14, 15. 16, 18, 19, 22, AND 23.

   THESE ITEMS TO BE FLUSH WITH ITEM NO. 1.

2. DWG. NO. LS-6000-1 SHEET 2:

   ITEM NO. 13 TO BE CUT TO 4.50 DIM. REMOVE BURRS. (SEE DWG. NO. MOD-100 SHEET 1 VIEW "A" AND SECTION H-H.)

3. DWG. NO. LS-6000-1 SHEET 2:

   ITEM NO. 12 TO BE PLUG WELDED SEALED BOTH ENDS (TO BE FLUSH WITH ITEM NO. 1). (SEE DWG. NO. MOD-100 SHEET 1 SECTION F-F.)

4. DWG. NO. LS-6000-1 SHEET 2:

   (a) ADD ITEM NO. 104 LOCATE AND WELD PER DWG. NO. MOD-100 SHEET 1 SECTIONS D-D AND H-H. HOLES TO BE IN ALIGNMENT AFTER WELDING (TYPICAL 4 PLACES).

   (b) ADD ITEM NO. 106 LOCATE AND WELD PER DWG. NO. MOD-100 SHEET 1 SECTIONS D-D AND H-H. HOLES TO BE IN ALIGNMENT AFTER WELDING (TYPICAL 4 PLACES).

   (c) ADD ITEM NOS. 119 AND 104 LOCATE AND WELD PER DWG. NO. MOD-100 SHEET 1 SECTIONS C-C AND H-H. HOLES TO BE IN ALIGNMENT AFTER WELDING (TYPICAL 8 PLACES). ADD ITEM NO. 105 LOCATE AND WELD

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ACCT. NO. N 9954 | DWG. NO. MOD-100 | 13

SHEET 2 OF 5 SHEETS

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5. DWG. NO. MOD-100 SHEET 1:

(a) ADD ITEM NO. 125. LOCATE AND WELD PER DWG. NO. MOD-100 SHEET 1.

(b) ADD ITEM NO. 128 TO ITEM 125 USING FOUR 1-8 UNC x 1.88 LONG BOLTS.

REV. LET	REVISIONS	BY	DATE

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VNDB CASK (LS-6000-1)

ACCT. NO. N 9954

DWG. NO. MOD-100 | 13

PER DWG. NO. MOD-100 SHEET 1 SECTIONS C-C AND H-H. HOLES TO BE IN ALIGNMENT AFTER WELDING (TYPICAL 8 PLACES).

6. DWG. NO. LS-6000-1 SHEET 2:

DRILL SIX 0.75-DIA. HOLES ON AN 8.00-DIA. ON THE CENTER LINE OF ITEM NO. 13. DRILL THROUGH ITEM NO. 1 ONLY! PLUG WELD ITEM NO. 17 TO ITEM NO. 1 (TYPICAL 6 HOLES). TYPICAL 2 PLACES. (SEE DWG. NO. MOD-100 SHEET 1 VIEW "A" AND SECTION H-H .)

7. DWG. NO. LS-6000-1 SHEET 2:

ADD ITEM NOS. 101 AND 102 TO ITEM NO. 13 (2 PLACES). LOCATE AND WELD PER DWG. NO. MOD-100 SHEET 1 VIEW "A" AND SECTION H-H.

8. DWG. NO. LS-6000-1 SHEET 2:

ADD ITEM NOS. 107 AND 108, 2 REQUIRED EACH. LOCATE AND TACK WELD THESE ITEMS INTO POSITION PER DWG. NO. MOD-100 SHEET 1 VIEW "E" AND SECTIONS G-G AND H-H. MAKE ALL 0.50 FILLET WELDS FIRST. THEN MAKE THE 0.50 BEVEL "V" WELDS. FINISH WELDS AND MATCH FINISH DIRECTION (TYPICAL 4 PLACES).

9. DWG. NO. LS-6000-1 SHEET 1:

ADD ITEM NO. 116 TO ITEM NO. 3 (BASE PLATE) AND WELD PER DWG. NO. MOD-100 SHEET 1 SECTION H-H.

10. DWG. NO. LS-6000-1 SHEET 2:

(a) ADD ITEM NOS. 109 AND 114 TO ITEM NO. 3. POSITION THESE ITEMS AND WELD PER DWG. NO. MOD-100 SHEET 1 SECTION H-H.

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ACCT. NO. N 9954 | DWG. NO. MOD-100 | 13

(b) ADD ITEM NO. 110. LOCATE AND WELD PER DWG. NO. MOD-100 SHEET 1 SECTION H-H. NOTE: CAUTION MUST BE APPLIED AS TO INSURE PROPER ALIGNMENT BETWEEN ITEM NOS. 115, 111, 110, AND 114 (SECTION H-H).

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11. DWG. NO. LS-6000-1 SHEET 1:

ITEM NO. 120 REPLACES ITEM NO. 5 FOUR PLACES. SEE DWG. NO. MOD-100 SHEET 1 SECTIONS D-D AND H-H.

12. DWG. NO. LS-6000-1 SHEET 1:

ITEM NO. 121 REPLACES ITEM NO. 6 EIGHT PLACES. SEE DWG. NO. MOD-100 SHEET 1 SECTIONS C-C AND H-H.

13. DWG. NO. LS-6000-1 SHEET 1:

ITEM NO. 118 REPLACES ITEM NO. 15. SEE DWG. NO. MOD-100 SHEET 1 SECTION H-H.

14 DWG. NO. LS-6000-1 SHEET 1:

ITEM NO. 118 REPLACES ITEM NO. 13 (BOLTS). SEE DWG. NO. MOD-100 SHEET 1 SECTION H-H.

15. DWG. NO. LS-6000-1 SHEET 1:

ITEM NOS. 30, 17, 2, AND 14 NOT USED. (SEE DWG. NO. MOD-100 SHEET 1 SECTION H-H FOR REPLACEMENT ITEMS.)

16. DWG. NO. MOD-100 SHEET 1:

ADD ITEM NO. 122. LOCATE AND WELD PER SECTIONS H-H AND G-G.

REV. LET.	REVISIONS	BY	DATE
A	WAS SHT 4 OF 4 SHTS		

REV. LET.	REVISIONS	BY	DATE

MAT'L. (COMMERCIAL TOLERANCES APPLY)

BATTELLE MEMORIAL INSTITUTE
505 KING AVE.
COLUMBUS 1, OHIO

TOLERANCE UNLESS OTHERWISE NOTED			NEXT ASSY.	NO REQ'D
FRAC ±	ANG ±	DEC		

	DRAWN	CHECKED	PROJ APP
BY	Seibel		
DATE	5-17-68		
DIV.	748		

TITLE: MODIFICATION INSTRUCTIONS VNDB CASK (LS-6000-1)

SCALE	K-G	ACCT. NO.	DWG. NO.	
—	—	N9954	MOD-100	13

SHEET 5 OF 5 SHEETS

Attachment Six

THIS PAGE IS AN OVERSIZED DRAWING OR FIGURE,

THAT CAN BE VIEWED AT THE RECORD TITLED: DWG. NO. 0999-C-08, REV. 8 VENT WITHIN THIS PACKAGE...OR, BY SEARCHING USING THE DOCUMENT/REPORT NUMBER 0999-C-08

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