

Specialty Materials
Honeywell
P.O. Box 430
Highway 45 North
Metropolis, IL 62960
618 524-2111
618 524-6239 Fax

July 2, 2004

UPS: 301-415-8147

U.S. Nuclear Regulatory Commission
Director, Office of Nuclear Material Safety & Safeguards
Attention: Document Control Desk
Mail Stop T-8A33, Two White Flint N, 11545 Rockville Pike
Rockville, MD 20852-2738

Subject: Revised Response to Requested Actions – NRC Bulletin 2003-03:
Potentially Defective 1-Inch Valves For Uranium Hexafluoride Cylinders

Docket No. 40-3392, License No. SUB-526

Discussion

Honeywell Metropolis stopped using Hunt valves in Honeywell cylinders in late March of 2003. Eurodif, one of Honeywell Metropolis' European customers had requested that all Hunt valves be removed from Honeywell cylinders that were planned to ship to France. It was Honeywell's decision at that time to stop using Hunt valves in shipments of all Honeywell cylinders to all customers in light of the complaint from Eurodif, and the IN's issued late in 2002 on this matter.

Customer owned cylinders continue to be filled and shipped from the Metropolis site. Although we shipped customer cylinders in the 3rd quarter of 2003 (within the 12-month transition period) under the mandates of Section D1 of the bulletin, once these shipments that were already in-process were completed, no more Hunt valves were allowed to be shipped from Honeywell. Following section D2 of the bulletin since 3rd quarter of 2003, no customer cylinders have been shipped unless and until any installed Hunt 1-inch valves were replaced with valves from an alternative manufacturer that can verify compliance of the valves with the ANSI N14.1 Standard. Plant processes and procedures have been amended to ban the use of Hunt valves on ANY UF₆ cylinders shipped from Metropolis Works.

Actions

Response - NRC Requested Action A

In reviewing our inventory of 1-inch cylinder valves, Honeywell Metropolis does not have any Hunt valves in its possession.

NM5530
NM5501

Response - NRC Requested Action B

Honeywell Metropolis inventory does not contain any Hunt valves. No Hunt valves will be installed in Honeywell-owned cylinders.

Response - NRC Requested Action C

Honeywell Metropolis does not own any cylinders containing depleted UF₆ therefore no action is required for this section.

Response - NRC Requested Action D

1. Although our intent after receiving the NRC Bulletin 2003-03 was to stop the use of Hunt Valves, in the event any customer cylinders with (CAP) Hunt valves were required to be shipped prior to the end of the 12-month transition period, the following processes were followed to ensure safety. The standard operating procedures pertaining to the handling of UF₆ cylinders with 1-inch valves installed include the following steps per Section D (1) a, b and c. These actions strictly pertain to Customer-owned cylinders since Honeywell no longer uses Hunt valves.

D 1 a. For cylinders with Hunt valves filled prior to the Bulletin and shipped after Bulletin release within the 12-month transition period, test certificates from the owner of the cylinders have been supplied to demonstrate that the valve was successfully subjected to the 100 psig (6.9×10^5 Pa) air test as required by ANSI N14.1 Standard. New non-heeled cylinders fitted with Hunt valves will not be filled until a certificate demonstrating a successful air test has been produced. If a certificate cannot be produced, the valve will be changed prior to filling.

D 1 b. Prior to shipment, each valve is checked with a 110 ft-lb torque wrench to ensure that it is properly closed. The discharge valve cap is also removed and the body inspected for residual UF₆ which would indicate a leaking valve seat. Each valve on non-heeled new cylinders has its packing nut torque checked as per section 6.15.7 of ANSI N14.1. Heeled cylinders have their packing nuts torque per section 6.3.5 of ANSI N14.1.

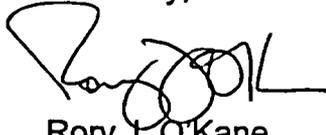
D 1 c. All cylinders have their internal pressure checked following UF₆ freeze out (96 hours post filling) to ensure that the cylinder has a negative pressure. Any cylinders that do not have the proper amount of vacuum are re-evacuated and re-checked prior to shipment.

Response - NRC Requested Action E

Honeywell will retain evidence of the actions taken as a result of the Bulletin. These records will be available on site for inspection by the NRC at any time. For further questions regarding this issue, please contact Michael Ginzel (Health Physics

Supervisor) or Phil Bryan (Nuclear Fuel Services Manager) at 618-524-6349 and 618-524-6245, respectively.

Sincerely,



Rory J. O'Kane
Metropolis Works
Plant Manager

Enclosure

cc:

D. Mays
M. Ginzel

U.S. Nuclear Regulatory Commission (UPS:301-415-7694)
Attention: John Lusher Project Manager
Fuel Cycle Licensing Branch, Mail Stop T-8A33
Two White Flint N, 11545 Rockville Pike
Rockville, MD 20852-2738

Director, Office of Nuclear Materials Safety and Safeguards (UPS:301-415-8144)
Attention: Robert C. Pierson, Director
Division of Fuel Cycle Safety & Safeguards
Office of Nuclear Material Safety & Safeguards
Mail Stop T-8A33, Two White Flint North, 11545 Rockville Pike
Rockville, MD 20852-2738

U.S. Nuclear Regulatory Commission (UPS: 301-415-6334)
Attention: Michael Raddatz,
Fuel Cycle Licensing Branch, Mail Stop T-8A33
Two White Flint North, 11545 Rockville Pike
Rockville, MD 20852-2738

Mr. Douglas Collins, Regional Administrator (UPS: 404-562-4700)
US Nuclear Regulatory Commission, Region II
Sam Nunn Atlanta Federal Center
61 Forsyth Street, S.W., Suite 23T85
Atlanta, GA 30303-8931