


**CHEM-NUCLEAR SYSTEMS, LLC**

140 Stoneridge Drive • Columbia, South Carolina 29210 • (803) 256-0450

 February 02, 2001  
 E&L-022-01

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

**REFERENCE: CERTIFICATE OF COMPLIANCE NO. 5805**

Dear Mr. Brach:

**SUBJECT: APPLICATION FOR REVISION OF THE CNS 3-55 CASK SAR DRAWINGS**

Chem-Nuclear Systems respectfully submits our application for amending Certificate of Compliance No. 5805 for the CNS 3-55 cask. This amendment would update the revision level of some of the currently referenced and approved Safety Analysis Report (SAR) drawings for the cask. The drawings have been revised to incorporate additional information and details, which more completely depict the cask's design details. Examples of this information include, addition of weld size callouts, clarification of weld configurations, the designation of "optional" for various features, etc. The following drawings are included herein:

- "Modification of VNDB Cask (LS-6000-1)", MOD-100, updated from Revision level "12" to Revision level "13";
- "Cask Shock Absorber Detail For Top Cover, Bottom and Trunnions", 0999-D-07, updated from Revision level "G" to Revision level "8";
- "Vent", 0999-C-08, updated from Revision level "G" to Revision level "8";
- "CNS 3-55 Lid Detail", C-111-E-0002, updated from Revision level "1" to Revision level "2";
- and
- "VNDB Skid Assembly", MOD-124, updated from Revision level "D" to Revision level "5".

The revised drawings are included in Enclosure 1.

To facilitate your review, the details of the requested changes are specified in the "Table of Changes to Drawings" (Enclosure 2) and a set of marked-up drawings has been included in Enclosure 3.

In addition, a revised SAR cover page and drawing listing have been included in Enclosure 4.

In support of this amendment, we have reviewed the sections of the SAR on the operating procedures, acceptance tests, and maintenance programs and determined that no changes are necessary as a result of incorporating this information into the SAR drawings. No change to packaging contents is being requested.

Should you or the members of your staff have any questions concerning this application, please telephone Mr. Shayne Merritt at (803) 758-1838.

Sincerely,

Patrick L. Paquin  
 General Manager, Engineering and Licensing

Enclosures: As stated

*kl mssd/public*

ENCLOSURE 1

TO CHEM-NUCLEAR SYSTEMS LETTER E&L-022-01

**THREE COPIES OF THE FOLLOWING DRAWINGS**

MOD-100, Revision 13, "Modification of VNDB Cask (LS-6000-1)"

0999-D-07, Revision 8, "Cask Shock Absorber Detail For Top Cover, Bottom and Trunnions"

0999-C-08, Revision 8, "Vent"

C-111-E-0002, Revision 2, "CNS 3-55 Lid Detail"

Mod-124, Revision 5, "VNDB Skid Assembly"

**THIS PAGE IS AN  
OVERSIZED DRAWING  
OR FIGURE,  
THAT CAN BE VIEWED AT  
THE RECORD TITLED:  
MOD-100, REV.13, Sheet 1of 5:  
MODIFICATION OF VNDB CASKS  
(LS-6000-1)**

**WITHIN THIS PACKAGE...OR,  
BY SEARCHING USING THE  
DRAWING NUMBER:  
MOD-100, REV.13, Sheet 1of 5**

**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.**

**D-1**

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

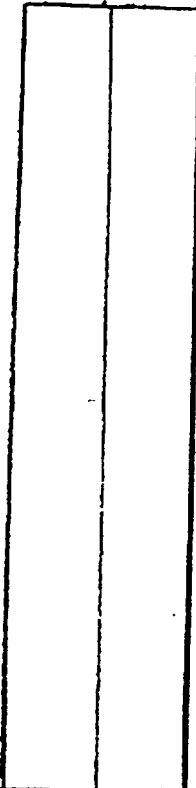
SECTIONS D-D AND H-H. HOLES TO BE IN ALIGNMENT AFTER WELDING

(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



A WAS SHT 2 OF 4							
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REV. LET.	REVISIONS	BY	DATE	REV. LET.	REVISIONS	BY	DATE
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MAT'L (COMMERCIAL TOLERANCES APPLY)

BATTELLE MEMORIAL INSTITUTE  
505 KING AVE.  
COLUMBUS 1, OHIO

TOLERANCE UNLESS OTHERWISE NOTED			NEXT ASSY.	NO. REQ'D.	TITLE		
FRAC	ANG.	DEC			MODIFICATION INSTRUCTIONS		
±	±				VNDB (ASK (LS-6000-1))		
BY	DRAWN	CHECKED	PROJ. APP.	SCALE	K-G	ACCT. NO.	DWG. NO.
	Leibert					N 9954	MOD-100
DATE	5-11-68						13
DIV.	748						

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.

REV. LET.	REVISIONS	BY	DATE	REV. LET.	REVISIONS	BY	DATE
MAT'L (COMMERCIAL TOLERANCES APPLY)				<b>BATTELLE MEMORIAL INSTITUTE</b> 505 KING AVE. COLUMBUS 1, OHIO			
TOLERANCE UNLESS OTHERWISE NOTED			NEXT ASSY.	NO. REQ'D	TITLE		
FRAC.	ANG.	DEC.			MODIFICATION INSTRUCTIONS VNDB CASK (LS-6000-1)		
±	±						
BY	DRAWN	CHECKED	PROJ. APP				
DATE	6-4-68			SCALE	K-G	ACCT. NO.	DWG. NO.
DIV.	748			—	—	N 9954	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.

A WAS SET 5 OF 4 SHYS.											
REV. LET.	REVISIONS			BY	DATE	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.	TITLE					
FRAC	ANG	DEC				MODIFICATION INSTRUCTIONS					
±	±					VNDB CASK (LS-6000-1)					
	DRAWN	CHECKED	PROJ. APP.								
BY	<i>Labat</i>										
DATE	5-17-68			SCALE	K-G	ACCT. NO.	DWG. NO.				
DIV.	748			—	—	N 9954	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).

(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.

A		WAS SHIT 4 OF 4 SHITS									
REV. LET.	REVISIONS			BY	DATE	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		TITLE				
FRAC	ANG	DEC					MODIFICATION INSTRUCTIONS VINDB CASK (LS-6000-1)				
±	±										
	DRAWN	CHECKED	PROJ. APP.								
BY	Sabat										
DATE	5-17-68			SCALE	K-G	ACCT. NO.	DWG. NO.				
DIV.	748			—	—	N 9954	MOD-100		13		

**THIS PAGE IS AN  
OVERSIZED DRAWING  
OR FIGURE,  
THAT CAN BE VIEWED AT  
THE RECORD TITLED:  
0999-D-07, REV. 8;  
CASK SHOCK ABSORBER DETAIL  
FOR TOP COVER, BOTTOM &  
TRUNNIONS**

**WITHIN THIS PACKAGE...OR,  
BY SEARCHING USING THE  
DRAWING NUMBER:  
0999-D-07, REV. 8**

**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.**



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0999-C-08, REV. 8**

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C-111-E-0002, REV. 2:  
CNS 3-55 LID DETAIL**

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DRAWING NUMBER:  
C-111-E-0002, REV. 2**

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MOD-124, REV. 5:  
VNDB SKID ASSEMBLY**

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DRAWING NUMBER:  
MOD-124, REV. 5**

**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.

ENCLOSURE 2

TO CHEM-NUCLEAR SYSTEMS LETTER E&L-022-01

TABLE OF CHANGES TO DRAWINGS

## Table of Changes to Drawings

- MOD-100, Revision 13, "Modification of VNDB Cask (LS-6000-1)"
- 0999-D-07, Revision 8, "Cask Shock Absorber Detail For Top Cover, Bottom and Trunnions"
- 0999-C-08, Revision 8, "Vent"
- C-111-E-0002, Revision 2, "CNS 3-55 Lid Detail"
- Mod-124, Revision 5, "VNDB Skid Assembly"

### MOD-100, Revision 13, "Modification of VNDB Cask (LS-6000-1)"

REF. NO.	ZONE	DESCRIPTION OF CHANGE
1	H8	<b>Section D-D</b> 1. Identified Item 132 2. Added three weld callouts: <ul style="list-style-type: none"> <li>• The weld connecting Item 132 to the cask body.</li> <li>• The weld connecting Item 132 to the bolt ring.</li> <li>• The weld connecting Item 133 to the cask body.</li> </ul>
2	H7	<b>Section D-D</b> 1. Identified Item 133
3	G7	<b>Section D-D</b> Revised the weld callout for the weld connecting the ends of Item 133 to the bolt rings from ½" to 3/8 (for the inboard side only)".
4	H6	<b>Section D-D</b> Added weld callout for the weld connecting the bolt rings to the cask body.
5	F8	<b>Section D-D</b> Revised the weld callout for the weld connecting Item 130 to the cask body from ½" to 3/8 (for the inboard side only)".
6	H6	<b>Section C-C</b> 1. Identified Item 133 2. Added two weld callouts: <ul style="list-style-type: none"> <li>• The weld connecting Item 132 to the cask body.</li> <li>• The weld connecting Item 132 to the bolt ring.</li> </ul>
7	H5	<b>Section C-C</b> 1. Identified Item 132 2. Added two weld callouts: <ul style="list-style-type: none"> <li>• Added weld callout for the weld connecting Item 104 to the cask body.</li> </ul>
8	G5	<b>Section C-C</b> Revised the weld callout for the weld connecting the ends of Item 133 to the bolt rings from ½" to 3/8" (for the inboard side only).
9	F6	<b>Section C-C</b> Revised the weld callout for the weld connecting Item 130 to the cask body from ½" to 3/8 (for the inboard side only)".
10	F5,4	<b>Gusset Detail</b> 1. Changed the gusset "leg" dimensions from 4" to 3" and specified a tolerance of +1/4", -0". 2. Changed the gusset designation from Item 130 to Item 132.

11	F2,1	<p><b>List of Material</b></p> <ol style="list-style-type: none"> <li>Item 130 was changed from cask gussets to lid gussets. The description of the cask gussets was removed and replaced with a reference to the drawing that depicts the lid gussets.</li> <li>Item 132 was added to represent the cask gusset that was previously labeled as 130.</li> <li>Item 133 was not specified in Revision 12. The as found description has been added to the List of Materials.</li> </ol>
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**0999-D-07, Revision 8, Cask Shock Absorber Detail For Top Cover, Bottom, & Trunnions**

REF. NO.	ZONE	DESCRIPTION OF CHANGE
1	N/A	<p><b>“Bottom View”</b></p> <ol style="list-style-type: none"> <li>Specified the ½” eye bolt as the minimum size.</li> <li>Removed the words “used” and “stock” from the callout.</li> <li>Added a 3/8” fillet weld callout to connect the eye bolt to the impact limiter.</li> </ol>
2	N/A	<p><b>“Top View”</b></p> <ol style="list-style-type: none"> <li>Specified the 3/8” eye bolt as the minimum size.</li> <li>Added a 3/8” fillet weld callout to connect the eye bolt to the impact limiter.</li> </ol>

**0999-C-08, Revision 8, Vent**

REF. NO.	ZONE	DESCRIPTION OF CHANGE
1	1 <sup>st</sup> quadrant (upper left)	<ol style="list-style-type: none"> <li>The following callout was added to the center of the exterior side of the vent: “Drill &amp; tap ½-12UNC-2B, 3/8” DP., Optional”.</li> <li>The cover plate was specified as “optional”.</li> <li>The threaded rod was specified as “optional”.</li> </ol>
2	3 <sup>rd</sup> quadrant (lower right)	<ol style="list-style-type: none"> <li>Cover Plate was specified as “optional”.</li> <li>The plug was specified as “optional”.</li> </ol>
3	4 <sup>th</sup> quadrant (upper right)	<ol style="list-style-type: none"> <li>Specified the 7/16” tapped hole in the top of the vent as “optional”.</li> <li>Specified the ¼” NPT hole ( at 45° to vent centerline) as “optional”.</li> <li>Specified the 6” length of the 1” schedule 40s pipe as a “nominal size.”</li> </ol>

**C-111-E-0002, Revision 2, CNS 3-55 Lid Detail**

REF. NO.	ZONE	DESCRIPTION OF CHANGE
1	D4	The length of the longer leg of the lid gusset was revised from 4 1/4” to 4” +1/4”, 0”
2	C4	Added the following note to Detail Item 7: “See Note 4 (flagged).”
3	G2	Replace Part No. 7 information in the Bill of Materials as shown on the drawing.
4	C2	Added flagged note 4 under the “Notes” section.

**MOD-124, Revision 5, VNDB Skid Assembly**

REF. NO.	ZONE	DESCRIPTION OF CHANGE
1	N/A	<b>Section A-A</b> Added a note specifying the lifting attachment options for the skid assembly.

ENCLOSURE 3

TO CHEM-NUCLEAR SYSTEMS LETTER E&L-022-01

MARKED-UP DRAWINGS

FOR INFORMATION ONLY



**THIS PAGE IS AN  
OVERSIZED DRAWING  
OR FIGURE,  
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THE RECORD TITLED:  
MOD-100, REV. 12, Sheet 1 of 5:  
MODIFICATION OF VNDB CASK  
(LS-6000-1)**

**WITHIN THIS PACKAGE...OR,  
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DRAWING NUMBER:  
MOD-100, REV. 12, Sheet 1 of 5**

**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.**

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THAT CAN BE VIEWED AT  
THE RECORD TITLED:  
0999-D-07, REV. G:  
CASK SHOCK ABSORBER DETAIL  
FOR TOP COVER, BOTTOM &  
TRUNNIONS**

**WITHIN THIS PACKAGE...OR,  
BY SEARCHING USING THE  
DRAWING NUMBER:  
0999-D-07, REV. G**

**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.

FIGURE WITHHELD UNDER 10 CFR 2.390

ATCOR INC.			
PEEKSKILL, NEW YORK			
VENT			
<i>J. R...</i>	<i>E. J. ...</i>	<i>...</i>	
...	...	...	
0999-C-08			G

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OR FIGURE,  
THAT CAN BE VIEWED AT  
THE RECORD TITLED:  
C-111-E-0002, REV. 1:  
CNS 3-55 LID DETAIL**

**WITHIN THIS PACKAGE...OR,  
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DRAWING NUMBER:  
C-111-E-0002, REV. 1**

**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.

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THE RECORD TITLED:  
MOD-124, REV. D:  
VNDB SKID ASSEMBLY**

**WITHIN THIS PACKAGE...OR,  
BY SEARCHING USING THE  
DRAWING NUMBER:  
MOD-124, REV. D**

**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.

ENCLOSURE 4

TO CHEM-NUCLEAR SYSTEMS LETTER E&L-022-01

REVISED SAR COVER PAGE AND DRAWING LISTING

SAFETY ANALYSIS REPORT

For

MODEL CNS 3-55 TYPE B SHIPPING PACKAGING

REVISION 2

FEBRUARY, 2001

Submitted by:

Chem-Nuclear Systems, LLC  
140 Stoneridge Dr.  
Columbia, S.C. 29210

9.0 DRAWINGS

LIST OF DRAWINGS FOR CNS 3-55 SHIPPING CASK

<u>Drawing Number</u>		<u>Drawing Name</u>	
MOD-100	Rev. 13	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. 8	Vent	
C-110-D-5001	Rev. 1	Sunshade for 3-55 Transport Cask	