



# NUCLEAR CONTAINERS, INC.

Chemical & Nuclear - Engineering and Equipment Fabrication

Route 9, Box 2237 — Elizabethton, Tennessee 37643  
Telephone: 615/543-4211 Fax: 615/543-6007

September 10, 1993

United States Nuclear Regulatory Commission  
Washington, DC 20555

Attention: Mr. Charles J. Haughney, Chief  
Storage & Transport Systems Branch  
Division of Industrial & Medical Nuclear Safety

Reference: Docket Number 71-9234

Gentlemen:

Please renew Certificate of Compliance No. 9234 whose current expiration date is December 31, 1993.

Eight copies of NCI Drawing No. DED-206-B, Sheets 1 through 11, Revision 5, are enclosed for insertion into our Safety Analysis Report, Revision No. 1 dated January 11, 1993, and for incorporation into C-o-C 9234 (please acknowledge receipt by completing and returning the attached Drawing Transmittal Sheet). Revision 5 of Drawing No. DED-206-B includes the following two minor changes to Revision 4:

- 1) The gasket thickness was changed in Rev. 4 from 1/2" to 5/8", but cross-sections of the gasket as shown in Sheets 3 and 4 were unchanged and were still shown as 1/2" thickness. Sheets 3 & 4 are corrected in Revision 5 to show the correct 5/8" thickness.
- 2) The minimum thicknesses of primer and total paint were left blank in Note 13, Sheet 11, Revision 4; these values have been inserted in Revision 5 of Note 13.

Very truly yours,

William R. Housholder  
President

Encl. 210061

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PDR ADDCK 07109234  
C PDR

NT01 /

NUCLEAR CONTAINERS, INC.

Drawing Transmittal Sheet  
 Contact - NCI-21PF-1-SARP

To: United States Nuclear Regulatory Comm. Date: 9-10-93

8 copies of the drawings listed below are transmitted herewith for your use. Please mark obsolete revised drawings "VOID". Please acknowledge receipt and completion of the required action by 1) signing and dating in the space below, 2) returning this sheet to the Quality Assurance Department for filing>

Recipient: \_\_\_\_\_ Date: \_\_\_\_\_

DRAWING NO.	REV.	DRAWING NO.	REV.
DED-206-B Sheet 1 thru 11	5		
REMARKS:			

\* The above drawings have been received and Obsolete revisions marked VOID and/or destroyed.

\_\_\_\_\_  
 Quality Assurance Date: \_\_\_\_\_

\* NOTE: Please circle the options you selected.

**FIGURE WITHHELD UNDER 10 CFR 2.390**

TOLERANCES (EXCEPT AS NOTED)	REVISIONS			NUCLEAR CONTAINERS, INC. ELIZABETHTOWN, TENN.		
	NO.	DATE	BY			
DECIMAL	1	7/1/86	WKA	NCI-21PF-1 SHIPPING PACKAGE		
±	2	11/15/88	WKA			
FRACTIONAL	3	3/1/89	WKA	DRAWN BY	SCALE	MATERIAL
± NOTE 5				WKA	3/4"=12"	304 SS
ANGULAR	4	9/29/89	WKA	CHECK'D	DATE	DRAWING NO.
±	5	3/8/93	WKA	WKA	11/15/88	DEC-206-B
				TRACED	APP'D	SHEET 1 OF 11
					WKA	

**FIGURE WITHHELD UNDER 10 CFR 2.390**

TOLERANCES		REVISIONS			NUCLEAR CONTAINERS, INC. ELIZABETHTOWN, TENN.			
(EXCEPT AS NOTED)		NO.	DATE	BY				
DECIMAL		1	7/1/89	WRT	NCI-21PF-1 ASSEMBLY DETAILS			
±		2	11/15/89	WRT				
FRACTIONAL		3	3/1/89	WRT	DRAWN BY	SCALE	MATERIAL	
±	NOTE 5	4	9/29/89	WRT	WRT	1/2" = 12"	304 SS	
ANGULAR		5	3/8/93	WRT	CHK'D	DATE	DRAWING NO.	
±					WRT	6-1-88	DEC-206-B	
					TRACED	APP'D	SHEET 2 OF 11	
						WRT		

# FIGURE WITHHELD UNDER 10 CFR 2.390

TOLERANCES <small>(unless otherwise noted)</small>		REVISIONS		NUCLEAR CONTAINERS, INC. ELIZABETHTOWN, TENN.			
		NO.	DATE	BY			
DECIMAL		1	7/1/88	WRH	TYPICAL ASSEMBLY DETAILS		
FRACTIONAL		2	11/15/88	WRH	MODEL NCL-2195-1 PACKAGE		
NOTE	5	3	3/1/89	WRH	DRAWN BY	SCALE	MATERIAL
ANGULAR		4	9/29/89	WRH	CHK'D	AS STATED	3/4 SS
		5	3/8/93	WRH	TRACED	DATE	DATE
						6-1-88	DED-206-B
						WRH	SHEET 3 OF 11

# FIGURE WITHHELD UNDER 10 CFR 2.390

TOLERANCES (EXCEPT AS NOTED)	REVISIONS			NUCLEAR CONTAINERS, INC. ELIZABETHTOWN, TENN.		
	NO.	DATE	BY			
DECIMAL ±	1	7/1/88	LKA	TYPICAL ASSEMBLY DETAILS		
FRACTIONAL ± NOTE 5	2	11/15/88	LKA	MODEL NCI-21PF-1 PACKAGE		
ANGULAR ±	3	3/1/89	LKA	DRAWN BY LKA	SCALE HALF	MATERIAL 304 SS
	4	9/29/89	LKA	CHK'D LKA	DATE 6/1/88	DRAWING NO. DED-206-B
	5	3/8/93	WRH	TRACED	APP'D LKA	SHEET 4 OF 11

# FIGURE WITHHELD UNDER 10 CFR 2.390

TOLERANCES UNLESS OTHERWISE SPECIFIED		REVISIONS			NUCLEAR CONTAINERS, INC. ELIZABETHTOWN, TENN.		
DECIMAL	FRACTIONAL	NO.	DATE	BY	CHG'D	DATE	DRAWING NO.
±	±	1	7/1/83	WPK			
		2	11/5/88	WPK			
		3	3/1/89	WPK			
		4	0/20/89	WPK			
		5	3/8/93	WPK			
± NOTE 5		DRAWN BY WPK			SCALE 1/2		
ANGULAR		MODEL NGI-21PF-1 PACKAGE			DATE 6-1-98		
±		CHG'D WPK			DRAWING NO. DED-206-B		
		TRACED			SHEET 5 OF 11		

**FIGURE WITHHELD UNDER 10 CFR 2.390**

TOLERANCES <small>(EXCEPT AS NOTED)</small>	REVISIONS			NUCLEAR CONTAINERS, INC. ELIZABETHTOWN, TENN.		
	NO.	DATE	BY			
DECIMAL ±	1			TOGGLE BRACKET CASTINGS AND LIFTING U-BOLTS FOR NCI-21PF-1		
FRACTIONAL ± NOTE 5	2					
ANGULAR ±	4	2/27/85	WJK	DRAWN BY WJK	SCALE AS SHOWN	MATERIAL SS - SEE NOTES
	5	3/8/93	WRH	CHK'D WJK	DATE 9/23/85	DRAWING NO. DED-206-B
				TRACED	APP'D WJK	SHEET 6 OF 11



# FIGURE WITHHELD UNDER 10 CFR 2.390

REVISED & SIGNED SHEET 7 OF 11.

TOLERANCES		REVISIONS			NUCLEAR CONTAINERS, INC. ELIZABETHTOWN, TENN.		
EXCEPT AS NOTED		NO.	DATE	BY			
DECIMAL .XX ± .02		1	7/1/88	WRA	TOGGLE DETAILS		
FRACTIONAL XXX ± .002		2	11/15/88	WRA	MODEL NCI-21PF-1 PACKAGE		
± 1/2		3	3/1/89	WRA	DRAWN BY WRA	SCALE HALF	MATERIAL 17-4PH SS
ANGULAR		4	9/29/89	WRA	CHECK WRA	DATE 6-1-88	DRAWING NO. DED-206-B
±		5	3/8/93	WRA	TRACED	APP'D WRA	SHEET 7 OF 11

**FIGURE WITHHELD UNDER 10 CFR 2.390**

TOLERANCES (EXCEPT AS NOTED)	REVISIONS			NUCLEAR CONTAINERS, INC. ELIZABETHTOWN, TENN.		
	NO.	DATE	BY			
DECIMAL ±	1	7/1/88	WKH	TOGGLE CLOSURE DETAILS MODEL NCI-21PF-1 PACKAGE		
FRACTIONAL	2	11/15/88	WKH			
±NOTE 5	3	3/1/89	WKH	DRAWN BY WKH	SCALE HALF	MATERIAL 304 SS
ANGULAR ±	4	9/29/89	WKH	CHK'D WKH	DATE 6-1-88	DRAWING NO. DED-206-B
	5	3/8/93	WKH	TRACED	APP'D WKH	SHEET 8 OF 11

**BILL OF MATERIALS**

Quantities for one Model NCI-21PF-1 Protective Shipping Package; see Note 1 (Sheet 10) for material specifications. Items specified herein by trade name provide minimum requirements only; equivalent or better items may be substituted.

ITEM	DESCRIPTION (QUANTITY REQUIRED)
Outer Shell	Sheet, 14 Ga x 72" x 91-3/4" (2 ea).
Outer Ends	Plate, 1/4" x 22" x 44" (4 ea).
Inner Shell	Sheet, 16 Ga x 60" x 82-5/8" (2 ea).
Inner Ends	Plate, 1/4" x 16" x 32" (4 ea).
Inner Angles	Angle, 2" x 2" x 1/4" by 91-1/2" length (2 ea).
Support Block Angles	Formed Angle, 1-1/2" x 1-1/2" x 16 Ga Sheet by 7" lengths (16 ea).
Wood Covers (Sides)	Sheet, 14 Ga x 7" x 92" (4 ea).
Wood Covers (Ends)	Sheet, 14 Ga x 5" x 43" (4 ea).
Closure Bands	Flat Bar, 1/4" x 3" by 72" length (6 ea).
Stiffener Rings	Angle, 3" x 3" x 3/8" by 80" length (4 ea).
Bottom Lift Angles	Angle, 3" x 3" x 1/4" by 56" length (2 ea).
Base Plates	Flat Bar, 1/2" x 6" by 43" length (4 ea).
Base Angle Legs	Angle, 2" x 2" x 1/4" by 12" length (8 ea).
Base Gussets	Plate, 1/2" x 2-1/8" x 3-1/8" (2 ea).
Lifting U-Bolts	U-Bolt, 2-3/4" ID made of 3/4" rod with 2-3/8" straights threaded 1-3/4" x 10NC-2A on ends, ASTM A-193, Grade 8 Stainless Steel, ANSI B18.2.1 with proper marking and material certification (4 ea).
U-Bolt Nuts	Nut, 3/4"-10NC-2B, ASTM A-194, Grade 8A Stainless Steel, ANSI B18.2.2.SP, Heavy Hex, with proper marking and material certification (8 ea).
U-Bolt Washers	Lock Washer, 3/4" US Standard (16 ea).
Toggle Assemblies:	See Shts 5, 6, 7 & 8 and Notes 1d, 1e, 1f & 3 (10 ea).
Upper Base*	Plate (formed), 1/4" x 7" x 10" (10 ea).
Upper Bracket*	Flat Bar, 1/2" x 2-1/2" by 6" length (20 ea).
Lower Base*	Plate (formed), 1/4" x 7" x 9" (10 ea).
Lower Bracket*	Flat Bar, 1/2" x 2-1/2" by 5-1/4" lgth (20 ea).
Arm Handle	Pipe (formed), 1-1/4" Sch. 80 x 14" length (10 ea).
Arm Base*	Flat Bar, 1/2" x 2" by 2-3/32" length (10 ea).
Arm Bracket*	Flat Bar, 1/2" x 2" by 4" length (20 ea).
Upper T-Bolt	Casting, 1"-8NC-2A (10 ea).
Lower Swing-bolt	Casting, 1"-8NC-2A (10 ea).
Swing-bolt Pin	Rod, 1" dia. x 2" long (10 ea).
Pivot Bolts	Casting, 1-1/4"-7NC Hex Shoulder Bolt (20 ea).
Coupling Nut	Casting, 1-1/2" Hex x 1"-8NC (10 ea).
Set Screws	Hex Socket Set Screw, 1/4"-20NC-2A x 1/4", Self-Locking Stainless Steel, McMaster Carr No. 90251A533 (30 ea).
Lock-down Pin	Ball Lock Pin, 1/2" dia. x 2-1/2" long, Stainless Steel with ring or T-handle and attaching cable, Carr-Lane No. CL-8-BLP-T-2.5S (10 ea).
Lock-down Bracket	Flat Bar, 1/4" x 1-1/2" by 3-1/4" lgth (20 ea).
Attaching Screw	1/4" Hex Head, Self Tapping SS Screw (10 ea).

\* These items may be investment castings per Notes 1(e) and 3.

ITEM	DESCRIPTION (QUANTITY REQUIRED)
Seal Lug	Pad Eye, 3/4", Stainless Steel, McMaster Carr No. 8892T12 (4 ea).
Lag Screws	1/4" x 2" Hex Head (136 ea).
Boat Nails	Plain Flat Head, #10 x 2-1/2" (100 ea).
Wooden Components:	Oak, moisture content less than 15%. Rails and Cap Boards--Select Grade; laminated components--No. 2 Common or better, see Note 6.
End Block	Cross-lamination 4-3/16" thick using 1-3/8" thick boards per Sheet 3 (4 ea, 150 board-feet).
End Rail	Board, 1-1/2" tk x 4-1/2" x 43" (4 ea, 16 brd-ft).
Upper End Cap	Board, 1" tk x 2-1/2" x 43" (2 ea, 4 board-feet).
Lower End Cap	Board, 5/8" tk x 2-1/2" x 43" (2 ea, 3 board-feet).
Side Rail	Board, 1-1/2" tk x 6-1/2" x 92" (4 ea, 45 brd-ft).
Upper Side Cap	Board, 1" tk x 3-1/2" x 92" (2 ea, 12 board-feet).
Lower Side Cap	Board, 5/8" tk x 3-1/2" x 92" (2 ea, 8 board-feet).
Support Block	Lamination, 6" thick x 5-1/2" x 9" made of five 1-3/8" thick boards, (8 ea, 25 board-feet).
Dowel Rod	Hardwood, 3/4" x 3" long (16 ea).
Wood Glue	Weldwood Waterproof Plastic Resin Adhesive (10 lb).
Nails for laminating	1/8" x 2-1/2" Coated Screw Shank Nails or No. 10 x 2" and No. 10 x 3" Concrete Nails (about 10 lb).
Phenolic Foam	Raw Materials for Fire Resistant Phenolic Foam Insulation per AEC Material and Equipment Specification No. SP-9, Rev. 1 and Supplement K/TL-729, see Notes 8 & 9 (about 260 lb total).
Upper Pad	Neoprene Sponge, 1/2" thick x 6" x 9", medium density, closed cell (4 ea).
Lower Pad	Neoprene, 3/16" thick x 6" x 9", 50 to 60 DurometerA (4 ea).
Rubber Adhesive	Rubber to Metal Cement, 3M No. 051135-08004 (2 oz) or Silicone Adhesive/Caulking described below.
Gasket	Silicone Sponge, 5/8" thick x 1-1/2" wide, medium density, closed cell, rated for continuous use at 400°F (20 feet).
Metal Preparation	PPG Ditzler DX579 MetalPrep (about 1 gallon).
Gasket Primer	Metal Primer, Clear, Albi 487S (about 1 pint).
Silicone Caulking	Silicone RTV Adhesive/Caulking, rated for continuous use at 400°F, Dow Silastic 732 (about 20-oz).
Paint, Fire	Intumescent Fire Retardant Paint, White, Albi 107A (about 1 quart).
Vent Seals	Polyethylene Plugs for 1/4" holes, Caplug No. BPF-1/4 by Protective Closures Co., Buffalo, NY (40 ea).
Paint Primer	Zinc Chromate Epoxy Primer, PPG Ditzler DP40 with DP401 hardner (about 1/2 gallon of each).
Paint	Automotive Polyurathane Enamel, PPG Ditzler DAU system, color per customer (about 2-1/2 gallons mix).

TOLERANCES		REVISIONS		NUCLEAR CONTAINERS, INC.		
EXCEPT AS NOTED		NO.	DATE	ELIZABETHTOWN, TENN.		
DECIMAL		1	7/1/88	WKA	BILL OF MATERIALS	
±		2	11/15/88	WKA	MODEL NCI-21PF-1 PACKAGE	
FRACTIONAL		3	3/1/89	WKA	DRAWN BY	SCALE
± NOTE 5		4	9/29/89	WKA	CHK'D	MATERIAL
ANGULAR		5	3/8/93	WKA	DATE	DRAWING NO.
±					6-1-88	DED-206-B
					APP'D	SHEET 9 OF 11

## NOTES

1. Unless otherwise specified, all metal items shall be as follows:

- (a) Sheet--ASTM A-240, Type 304 or 304L Stainless Steel, #2B Finish.
- (b) Plate--ASTM A-240, Type 304 or 304L Stainless Steel, #1 Finish.
- (c) Angle & Flat Bar--ASTM A276, Type 304 or 304L Stainless Steel, Hot Rolled, Annealed, and Pickled. It is acceptable for flat bar to be fabricated from sheet or plate meeting above specifications.
- (d) Toggle Castings and Swing Pins--Type 17-4PH Stainless Steel, homogenized at  $2100 \pm 25^\circ\text{F}$  for 90 minutes in vacuum and either vacuum or nitrogen cooled to below  $70^\circ\text{F}$ ; solution heat treated at  $1900 \pm 25^\circ\text{F}$  for 60 minutes in vacuum and nitrogen cooled to put material in Condition A; then precipitation hardened by heat treating at  $1100^\circ\text{F}$  for 90 minutes and air cooling to put material in Condition H1100. Machining operations may be done in either Condition A or H1100.
- (e) Toggle Bracket and Base Castings--Type 304 or 304L Stainless Steel.
- (f) Pipe--ASTM A-312, Type 304 or 304L Stainless Steel, seamless or welded, cold drawn, annealed, and pickled. If used, elbows shall be ASTM A-403, Type 304 or 304L Stainless Steel.
- (g) Boat Nails, Lag Screws, Set Screws, Pad Eyes, & Washers--300 Series, 18-8, or 17-4PH Stainless Steel.

2. Certifications and Test Reports:

- (a) Mill test reports must be obtained and maintained on file for all stainless steel raw materials including sheet, plate, angles, flat bar, pipe and pipe fittings, and casting metal for cast toggle components.
- (b) Manufacturer's certifications must be obtained and maintained on file for gasket materials and for lifting U-bolts and nuts.
- (c) All other commercially available items may be purchased without certification, but copies of written purchase orders which stipulate the appropriate specifications must be maintained on file for each such item.

3. All cast toggle components shall be Investment Castings of Type 17-4PH Stainless Steel in the H1100 Condition as specified in Note 1(d) above; toggle brackets and bases may be investment castings of Type 304 or 304L Stainless Steel as specified in Note 1(e) above. All castings shall meet the requirements of Section VIII, Articles UG-24(a)(1) & (5) and UG-24(b) & (c), ASME Boiler and Pressure Vessel Code and shall be examined after heat treating per ASME Code, Section VIII, Appendix VII, Articles UA-80; UA-81(b) & (c); UA-82(a)(1), (2), (4), & (5); UA-83; and UA-84. However, only the first five (5) toggle base and bracket castings of each type from each casting lot shall require radiographic examination per ASME Code, Section VIII, Appendix VII, Articles UA-81(c) and UA-82(a)(1); each base and bracket item to be radiographed must first be sectioned to yield flat plate specimens. All items must be re-examined after any repairs and/or reheat treatment as required by UA-83.

4. Welds:

- (a) Unless otherwise specified, all welds shall be continuous and shall develop the full strength of the weakest member being joined; butt welds shall be full penetration welds. All welds shall be free from cracks and from excessive undercutting, pits, or spatter, and shall not be oxidized beyond normal discoloration which can easily be removed by wire brushing.
- (b) Welds shall only be by GTAW or GMAW processes using welders and welding procedures qualified on P8 materials in accordance with Section IX, ASME Boiler and Pressure Vessel Code. Only Type 308L weld rod and filler materials may be used for welding.
- (c) Do not weld over foam materials; weld over wood only when it has been coated with fire retardant intumescent paint and then use appropriate means to reduce heat to a minimum to protect the wood.
- (d) All stainless steel wire brushes, grinding wheels, and cutting discs which are used for stainless steel shall be used for stainless steel only and shall be so marked. Carbon steel wire brushes shall not be used on stainless steel.
- (e) Welds shall be inspected in accordance with Section V, Article 9 of the ASME Code; the inner liner, outer shell, and wood cover seams shall be inspected visually--linear defects over  $1/16"$  shall be ground out and repaired, other welds shall meet the minimum requirements indicated.

TOLERANCES (EXCEPT AS NOTED)	REVISIONS			NUCLEAR CONTAINERS, INC. ELIZABETHTOWN, TENN.			
	NO.	DATE	BY				
DECIMAL	1	7/1/88	WKA	NOTES & SPECIFICATIONS			
±	2	11/15/88	WKE	MODEL NCI-21PF-1 PACKAGE			
FRACTIONAL	3	3/1/89	WKA	DRAWN BY	SCALE	MATERIAL	
±NOTE 5	4	9/29/89	WKA	CHK'D	DATE	NOTE	
ANGULAR	5	3/8/93	WKA	TRACED	6-1-88	DED-206-B	
±					APP'D	WKA	SHEET 10 OF 11

## NOTES--continued:

## 5. Tolerances; unless otherwise specified:

- (a) Dimensions up to 24" shall be  $\pm 1/16"$ .
- (b) Dimensions greater than 24" shall be  $\pm 1/8"$ .
- (c) Gasket sealing surfaces shall be flat  $\pm 1/16"$  per 3 feet.
- (d) Overall diagonal lengths shall be within  $1/8"$  of each other.

6. All wood shall be inspected to ensure that it is free of rot, end splitting, loose knots, etc. prior to use; Select Grade lumber for rails and cap boards shall essentially be clear lumber with no knots greater than  $1/2"$ . Unacceptable portions may be cut off and discarded, but all boards shall be full length and shall not be spliced lengthwise; each rail or cap board must be a single board. All wood assemblies shall be glued with waterproof plastic resin glue and nailed with coated screw shank nails or concrete nails spaced no more than 6" apart.

7. Paint all wood with two coats of fire retardant intumescent paint prior to installation. Seal all screw and nail penetrations through the inner liner or outer shell with silicone RTV caulking when inserting the screw or nail; wipe off excess RTV caulking.

8. Insulation shall be Fire Retardant Phenolic Foam fabricated in accordance with US AEC Material and Equipment Specification SP-9, Rev. 1 and Supplement K/TL-729. Foam each package in place using 2 or 3 equal pours each for the cover half and the bottom half; weight of finished insulation shall be a minimum of 100 pounds in each half. Install and secure the wooden end block in each half immediately after the last pour has been made. After foaming is complete, inspect all vent holes to ensure that the foam has completely filled all void space; if any voids are found, the end blocks must be removed and foam must be added as needed to fill all voids.

9. After foam has cured, drill out all vent holes to a depth of  $1/4"$  to  $1/2"$  and seal each with a plastic cap-plug set in silicone RTV caulking; wipe away excess caulking and allow to cure.

10. Seal all penetrations in inner and outer shells with Silicone RTV by setting the penetrating item (lag screw, nail, vent plug, or pop rivet) in the uncured RTV and allow to cure per manufacturers instructions.

11. After all penetrations are sealed, remove excessive weld spatter and clean all metal surfaces (especially welds) with metal preparation solution per manufacturer's instructions; use stainless steel wire brushes on weld areas and scrub brushes on remaining 2B finish areas. Rinse thoroughly and dry before proceeding to installation of paint, pads, gaskets and nameplates.

12. If the package is to be painted, apply one coat (0.001" minimum dry primer thickness) of primer to all inner surfaces including cover plates per manufacturer's instructions. If the package is not to be painted, apply one coat of clear metal primer to the areas to which the rubber is to adhere and allow to air dry for one hour at room temperature. Install the silicone sponge gasket by applying a uniform layer (0.015" to 0.030") of silicone RTV caulking to the primed metal surface and applying the gasket using only enough pressure to displace the air but not the adhesive. Seal all joints in the gasket using silicone RTV caulking; wipe away excess caulking and allow to cure. Install the rubber pads using rubber to metal cement per the manufacturer's instructions or use silicone RTV caulking as described above.

13. If package is to be painted, also apply one coat of primer (0.001" minimum dry primer thickness) to all the outer surfaces and apply two coats (0.003" minimum total dry paint thickness) of paint to all inner and outer surfaces. Follow manufacturer's instructions in the application and drying of primer and paint coats.

14. Obtain weights of cover, of bottom, and of assembled package without a cylinder; these weights must include the appropriate weights of nameplates and hardware yet to be attached per the following notes. All weights (in pounds and kilograms) must be recorded and stamped on package name plates per Drawing No. DED-207-A.

15. After assembly of finished package, adjust all toggle closures to securely close the package giving a metal-to-metal seat without requiring excessive closing force; then tighten all set screws in each toggle coupling nut. Lock down each toggle handle using a ball-lock pin.

16. Attach the cable of each ball-lock pin to the lower toggle bracket just above it using a  $1/4"$  self-tapping screw set in silicone caulking.

17. After package assembly and adjustment of toggle closures, apply steel and install nameplates using  $1/8"$  stainless steel pop rivets set in silicone caulking per Note 10. Prepare for shipment.

18. Items specified herein by trade name provide minimum requirements only; equivalent or better items may be substituted.

TOLERANCES RECORD AS NOTED	REVISIONS			NUCLEAR CONTAINERS, INC. ELIZABETHTOWN, TENN.			
	NO.	DATE	BY				
DECIMAL	1	7/1/88	WRH	NOTES & SPECIFICATIONS			
$\pm$	2	11/15/88	WRH	MODEL NCI-21PF-1 PACKAGE			
FRACTIONAL	3	3/1/89	WRH	DRAWN BY	SCALE	MATERIAL	
$\pm$ NOTE 5	4	9/29/89	WRH	CHK'D	DATE	NOTE 1	
ANGULAR	5	3/8/93	WRH	TRACED	6-1-88	DRAWING NO.	
$\pm$					APP'D	DED-206-B	
					WRH	SHEET 11 OF 11	