

**HENRY PRATT COMPANY**  
creative engineering for fluid systems  
401 SOUTH HIGHLAND AVENUE · AURORA, ILLINOIS 60607

May 30, 1985

Mr. James G. Keppler  
United States Nuclear Regulatory Commission  
Region III  
799 Roosevelt Road, Building 4  
Glen Ellyn, IL 60137

Reference: Pratt letter dated May 23, 1985

Dear Mr. Keppler:

Henry Pratt Company wishes to amend the above subject letter to include Loctite Grade 242 (formerly designated as CV) as an acceptable material.

A copy of the letter being sent to all of the listed utilities this date is attached.

Very truly yours,

*Bruce R. Cummins*

B. R. Cummins  
Quality Assurance Manager

BRC/np  
Enclosure

CC: R. D. Nelson, HPCO  
A. K. Wilson, HPCO  
W. G. Bingham, Bechtel Power Corp.

Re: B/HP-E-51078  
MOC 380678

Daniel Warsing, Limitorque

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PDR ADOCK 05000528  
S PDR

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MAY 31 1985

  
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INFORMATION LETTER (REF. NRC IE CIRCULAR NO. 80-12)

Arizona Public Service has reported that during testing of the containment purge system at Palo Verde Nuclear Generating Station, a Henry Pratt Company valve failed to open when the driven gear on the valve shaft (spline) had become disengaged from the valve shaft. This valve was installed with a Limitorque operator oriented with the motor on the bottom (below the horizontal axis). This is a similar occurrence to that reported in NRC IE Circular No. 80-12.

In view of the reported condition at Palo Verde Nuclear Generating Station, Pratt recommends inspection of all actuator valve shaft connections where the actuator is oriented below the horizontal regardless of actuator manufacturer.

Valve shaft to actuator spline or lever connections are designed with a press-fit keyway connection. Additionally it is Pratt shop practice to apply Loctite adhesive at the time of factory assembly.

INSTRUCTION:

It is noted that many jobsites remove the actuator from the valve for installation, reorientation, examination, repair, replacement, etc. Loctite Grade 242 (formerly designated as CV) or 271 (formerly designated as AV) should be applied to all four sides of the key prior to reassembly if valve/operator connection is broken for any reason. Loctite Grade 277 is also acceptable although its higher shear strength may make its disassembly more difficult.



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May 30, 1985

Quality Assurance Manager  
Arizona Public Service/Palo Verde  
P.O. Box 21666 Mail Station 3003  
Phoenix, AZ 85036

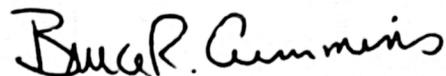
Dear Sir:

Attached please find Henry Pratt Company Information Letter dated May 30, 1985 relating to an Arizona Public Service 10CFR Part 21 Report to the NRC.

Your company has been included in a list furnished to the NRC by Pratt as known users of Pratt valves with Limitorque operators.

Pratt records indicate that 105 valve/Limitorque motor operator assemblies were furnished to you.

Very truly yours,



B. R. Cummins  
Quality Assurance Manager

BRC/np  
Enclosure