

MEMO ROUTE 5		See me about this.	Concurrence.	For action.
Form AEC-93 (Rev. May 14, 1947) AECM 0240		Note and return.	For signature.	For information.
TO (Name and unit)		INITIALS	REMARKS	
RO Chief, FS&EB RO:HQ (4) Licensing (4) DR Central Files Region I			Northern States Power Company Monticello 50-263	
		DATE		
TO (Name and unit)		INITIALS	REMARKS	
Region II PDR Local PDR NSIC DTIE				
		DATE		
TO (Name and unit)		INITIALS	REMARKS	
F. Rizzo, RO:HQ A. Roisman				
		DATE		
FROM (Name and unit)		REMARKS		
G. Fiorelli RO:III		Attached is a copy of licensee's reply dated June 10, 1974, to RO Bulletin 74-4.		
PHONE NO.		DATE		
		7-12-74		

USE OTHER SIDE FOR ADDITIONAL REMARKS

GPO : 1971 O - 445-469

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NORTHERN STATES POWER COMPANY

MINNEAPOLIS, MINNESOTA 55401

June 10, 1974

Mr J G Keppler, Regional Director
Directorate of Regulatory Operations
Region III
799 Roosevelt Road
Glen Ellyn, Illinois 60173

Dear Mr Keppler:

MONTICELLO NUCLEAR GENERATING PLANT
Docket No. 50-263 License No. DPR-22

In accordance with Item B.3 of Directorate of Regulatory Operations
Bulletin 74-4 the following information is submitted:

- a. The temporary second stage piston stem locking nut modifications described in the bulletin were completed on April 24, 1974.
- b. The attached table summarizes other Target Rock relief valve modifications which have been completed on the eight valves presently installed. It is our understanding that there are no other recommended modifications.

Yours very truly,

L J Wachter, Vice President
Power Production & System Operation

LJW/ma

cc: J F O'Leary, Directorate of Licensing
G Charnoff
Minnesota Pollution Control Agency
Attn: E A Pryzina

Attachment

JUN 12 1974

Summary of Modifications Made to the Original Design of
Target Rock Safety/Relief Valves at the Monticello Nuclear Generating Plant

Summary of Change

1. Increased the size of the orifice in the second stage piston from 0.016 inch diameter to 0.035 inch diameter and increased the size of the orifice in the main valve piston from 0.0625 inch diameter to 0.076 inch diameter.

This modification decreases the closing time of the valves and reduces the pressure reset band.

2. The set-pressure adjusting springs were replaced with springs manufactured from A-286 alloy.

This change was made to preclude drifting of valve setpoint due to relaxation of the adjusting spring.

3. New main discs were installed. The new discs were manufactured with stellite coated stems making them more resistant to galling.

This change was initiated following a reset failure of one valve due to severe galling of the main disc stem.

4. The bellows leakage detection pressure switches were replaced with switches having adjustable settings.

This change was initiated to correct a design deficiency in the bellows leakage detection system. This deficiency would have prevented a small, but significant, leak from being detected and result in an alteration of the valve trip setting.

5. The stainless steel pilot stems were replaced with monel stems.

The pilot stems were replaced to produce valve lift pressures essentially the same with both nitrogen and steam.

References

Monticello Semi-Annual
Operating Report No. 2,
p. VII-4.

Monticello Semi-Annual
Operating Report No. 3,
p. VII-7.

Monticello Semi-Annual
Operating Report No. 3,
p. VII-4.

Monticello Semi-Annual
Operating Report No. 4,
p. IV-2.

Letter from L O Mayer,
NSP, to A Giambusso,
USAEC-DL, dated July 28,
1972.

Summary of Change

References

6. The piston rings on both stages were replaced with rings of greater hardness and the diameter of the main pistons were reduced.

The piston rings were replaced and the main piston diameters reduced to increase piston ring life.

7. Milled 2 circular grooves in the main piston hub assembly, drilled a drain passage through the main piston hub assembly and through the valve body on the inlet side, doweled the main piston hub assembly to the valve body and removed the filter assembly from the first stage pilot sensing line.

These modifications prevent delays in valve opening due to steam condensation in the area above the main operating piston or in the sensing line.

8. The stainless steel air operator glands were replaced with silicone bronze glands.

This modification was made to increase the operational reliability of the air operator.

Letter from L O Mayer,
NSP, to J F O'Leary,
USAEC-DL, dated August 1,
1973.