A 04/26/78

REGULATORY INFORMATION DISTRIBUTION SYSTEM (RIDS)
DISTRIBUTION FOR INCOMING MATERIAL 50-335

REC: REID R W
NRC

ORG: UHRIG R E
FL PWR & LIGHT

DOCDATE: 04/21/78
DATE RCVD: 04/26/78

DOCTYPE: LETTER NOTARIZED: NO
SUBJECT:
FORWARDING APPLICANT"S OUTLINES OF SUBJECT FACILITY, UNIT 1 CEA GUIDE TUBE SLEEVING PROCEDURES...AND ADVISING OF APPLICANT"S INTENTIONS TO SUBMITT COMBUSTION-ENGR REPT CEN-90(F)-P BY 04/28/78.

COPIES RECEIVED
LTR 3 ENCL 3

PLANT NAME: ST LUCIE #1

REVIEWER INITIAL: XJM
DISTRIBUTOR INITIAL:

********** DISTRIBUTION OF THIS MATERIAL IS AS FOLLOWS **********

GENERAL DISTRIBUTION FOR AFTER ISSUANCE OF OPERATING LICENSE.
(DISTRIBUTION CODE A001)

FOR ACTION: BR CHIEF REID**W/7 ENCL

INTERNAL:
REG FILE**W/ENCL
I & E**W/2 ENCL
HANAUER**W/ENCL
EISENHUT**W/ENCL
BAER**W/ENCL
EEB**W/ENCL
J. MCGOUGH**W/ENCL
NRC PDR**W/ENCL
OELD**LTR ONLY
CHECK**W/ENCL
SHAO**W/ENCL
BUTLER**W/ENCL
J COLLINS**W/ENCL

EXTERNAL:
LPDR'S
FT PIERCE, FL**W/ENCL
TIC**W/ENCL
NSIC**W/ENCL
ACRS CAT B**W/16 ENCL

DISTRIBUTION: LTR 40 ENCL 39
SIZE: 1P+2P

CONTROL NBR: 781160145

MF 4
GI

********** THE END **********

FLORIDA POWER & LIGHT COMPANY

April 21, 1978
L-78-144

Office of Nuclear Reactor Regulation
Attention: Mr. R. W. Reid, Director
Operating Reactors Branch #4
Division of Operating Reactors
U. S. Nuclear Regulatory Commission
Washington, D. C. 20555

Dear Mr. Reid:

Re: St. Lucie Unit 1
Docket No. 50-335
CEA Guide Tube Sleeving

The attached information outlines the St. Lucie Unit 1 CEA guide tube sleeving procedures. The procedures described are essentially those that have been used on the Calvert Cliffs-1 and Millstone-2 fuel assemblies.

Within the next few days we expect to receive Combustion-Engineering's report CEN-90(F)-P, "St. Lucie Unit 1 Reactor Operation with Modified CEA Guide Tubes." The report will be similar to the reports for Calvert Cliffs-1 and Millstone-2. We anticipate forwarding the report to your office by April 28, 1978. We will advise you of any change in our schedule.

Very truly yours,

Robert E. Uhrig
Vice President

REU/MAS/mb

Attachment

cc: Mr. James P. O'Reilly, Region II
Harold F. Reis, Esquire

781160145

A001
S
3/3

ATTACHMENT

Re: St. Lucie Unit 1
Docket No. 50-335
CEA Guide Tube Sleeving

OUTLINE OF SLEEVING PROCEDURES

I. Dry sleeving in new fuel racks

A. Sleeving Installation

Once an assembly is chosen for sleeving, a guide tube inspection tool will be used to check the guide tubes for interferences which would hamper sleeve insertion. If no interference is found, a sleeve will be placed in each of the five guide tubes. A sleeve tamping tool will then be used to push the sleeve into the guide tube.

B. Guide Tube Expansion

A guide tube expansion tool, suspended from a load cell, will be lowered into the guide tube a specified distance. The guide tube sleeve will then be expanded into the guide tube by using a hydraulic expansion tool. The expansion tool will be carefully lifted out of the guide tube while monitoring the load cell reading.

C. Sleeve Expansion

A sleeve expansion tool, suspended from a load cell, will be lowered into the guide tube a specified distance. The guide tube sleeve will then be expanded into the guide tube by using a hydraulic expansion tool. Following the first expansion, the expansion tool will be raised one inch and the expansion sequence repeated. Following the second expansion, three more expansion operations will be performed, with each one being one inch above the previous expansion. The expansion tool will be carefully lifted out of the guide tube while monitoring the load cell reading.

Immediately following installation of the five sleeves in an assembly, the potential for interference with CEA motion will be checked with a full length sleeve gauge and then with a five-finger CEA checking tool. Each sleeve will then be tested for resistance to a specified withdrawal load by using a sleeve withdrawal tool and load cell.

Re: St. Lucie Unit 1
Docket No. 50-335
CEA Guide Tube Sleeving

II. Wet sleeving in spent fuel pool. Underwater lights and a TV camera will be used for monitoring underwater operations.

A. CEA Removal (if necessary)

A CEA removal tool, suspended from a load cell, will be used to carefully lift the CEA out of the fuel assembly. CEAs will be temporarily stored in fuel assemblies not designated for sleeving and will be reinserted in the proper assemblies according to the Cycle 2 loading pattern.

B. Sleeving Installation

Same as for dry sleeving.

C. Guide Tube Expansion

Same as for dry sleeving.

D. Sleeve Expansion

Same as for dry sleeving except there will be only three expansion sequences instead of five.