

A 04 126/78

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50-335

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SUBJECT:

LTR 3 ENCL 3

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.

PLANT NAME: ST LUCIE #1

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THE UNITED STATES OF AMERICA  
DEPARTMENT OF THE ARMY  
OFFICE OF THE CHIEF OF STAFF  
WASHINGTON, D. C. 20315

MEMORANDUM FOR THE CHIEF OF STAFF  
SUBJECT: [Illegible]

DATE: [Illegible]

REFERENCE: [Illegible]

1. [Illegible]

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REGULATORY DOCKET FILE COPY



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 Slewing

The attached information outlines the St. Lucie Unit 1 CEA guide tube slewing 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*

Robert E. Uhrig  
Vice President

REU/MAS/mb

Attachment

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

781160145

4001  
5/3



## 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.



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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.

The first part of the document discusses the importance of maintaining accurate records of all transactions. It emphasizes that proper record-keeping is essential for the integrity of the financial system and for the ability to detect and prevent fraud.

In the second part, the document outlines the various methods used to collect and analyze data. It describes the process of gathering information from different sources and how this data is then used to identify trends and patterns.

The third part of the document focuses on the role of technology in modern data analysis. It discusses how advanced tools and software have enabled more complex and efficient analysis of large datasets.

In the fourth part, the document addresses the challenges of data security and privacy. It highlights the need for robust security measures to protect sensitive information from unauthorized access and misuse.

The fifth part of the document discusses the importance of data quality and the steps taken to ensure that the data used in analysis is accurate and reliable.

In the sixth part, the document explores the future of data analysis and the potential for new technologies to further enhance the field.

The final part of the document provides a summary of the key findings and conclusions drawn from the research. It reiterates the importance of a systematic and rigorous approach to data analysis.