



UNITED STATES
NUCLEAR REGULATORY COMMISSION
REGION III
799 ROOSEVELT ROAD
GLEN ELLYN, ILLINOIS 60137

PDR

JUL 11 1979

Docket No. 50-341

The Detroit Edison Company
ATTN: Mr. Edward Hines, Assistant
Vice President and Manager
Quality Assurance
2000 Second Avenue
Detroit, MI 48226

Gentlemen:

The enclosed IE Bulletin No. 79-15 is forwarded to you for action.
A written response is required. If you desire additional information
regarding this matter, please contact this office.

Sincerely,

for James G. Keppler
Director

Enclosures:

1. IE Bulletin No. 79-15
2. Listing of IE Bulletins
Issued in Last 12 Months

cc w/encl:

Central Files
Director, NRR/DPM
Director, NRR/DOR
PDR
Local PDR
NSIC
TIC
Ronald Callen, Michigan Public
Service Commission
Eugene B. Thomas, Jr.,
Attorney

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U.S. NUCLEAR REGULATORY COMMISSION
OFFICE OF INSPECTION AND ENFORCEMENT

REGION III

July 11, 1979

IE Bulletin No. 79-15

DEEP DRAFT PUMP DEFICIENCIES

Description of Circumstances:

On October 20, 1978, Commonwealth Edison Company reported that manufacturing deficiencies had been identified in new high pressure core spray, low pressure core spray, and residual heat removal pumps manufactured by Ingersoll-Rand (I-R) Company, Cameron Pump Division.

Each of these pumps is a vertical turbine pump with impellers located in bowls in a sump or a self contained barrel. The motor (prime mover) is located at the highest pump elevation to take into account maximum flooding at the site or space considerations. The suction is at the lower end of the pump while the discharge head is just below the driver. Bearings supporting the vertical shaft segments (usually 5 to 10 segments) are either self lubricated, force fed (lubricated by fluid being pumped), or oil lubricated and maintained within their own isolated system. These pumps are designated as "Deep Draft". Figures 1&2 show typical outlines of such pumps.

The internal deficiencies, identified through dimensional and visual inspections were as follows:

Low Pressure Core Spray Pumps (I-R Model No. 29APKD-5) (Date of Manufacture - February 1973)

- . Loose impeller bolts and bolts improperly staked
- . Loose key - keyway fit
- . Excessive runout on pump shaft
- . Bearing showed wear
- . Bearing clearance exceeded recommended tolerance
- . Coupling thread galled
- . Wear ring clearance out-of-specification
- . Impeller-to-shaft clearance out of specification
- . Cracks found in second-and-third-stage impellers
- . Stuffing box bushings were severely galled

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High Pressure Core Spray Pumps (I-R Model No. 12X20KD) (Date of Manufacture - September 1972)

- . Bearing clearance exceeded recommended tolerance
- . Wear ring clearance out-of-specification
- . Bearings showed wear

DUPLICATE DOCUMENT

Entire document previously entered into system under:

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