

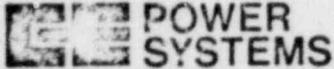
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TERA
PDR

71-9022

70-1100



June 6, 1980

License SNM-1067
Docket 71-9022

U. S. Nuclear Regulatory Commission
Washington, D. C. 20555

Attention: Mr. Charles E. MacDonald, Chief
Transportation Certification Branch
Division of Fuel Cycle & Material Safety

Reference: Letter from Mr. C. E. MacDonald to Mr. H. V. Lichtenberger
dated May 1, 1980; Certificate of Compliance 9022

Gentlemen:

This is in response to your request for additional information to support our consolidated renewal application for Certificate of Compliance No 9022 (Model CE-250-2) dated January 11, 1980.

To preserve the continuity of our application, the drawings and associated changes are submitted in the form of revised pages to our original renewal application as listed below:

Delete Pages

1-2

Appendix 1.3 - CE Drawing
NFM-E-Z2175 Rev. 0 dated
6/13/79 Size "C"

Add Pages

1-2 Rev. 1, 6/6/80

Appendix 1.3 A - CE Drawing
NFM-E-Z2175 Rev. 0 dated
6/13/79 Size "E"

Appendix 1.3 B - A list of
changes between Drawings NPM-
E-3471 and NFM-E-Z2175 and
their safety significance

Very truly yours,

H. V. Lichtenberger
Vice President-Nuclear Fuel
Nuclear Power Systems-Manufacturing

HVL/GAJ/ssb
Enclosures

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1.3 Appendix

- A) Dimensional details of the CE-250-2 shipping container are described in CE Drawing NFM-E-Z2175 Rev. 00 dated 6/13/79.

- B) Changes made between the original drawing submitted, NPM-E-3471, Rev. 0 dated 6/24/74 and drawing NFM-E-Z2175 Rev. 00 dated 6/13/79 are delineated and their safety significance discussed in this section.

Appendix 1.3 B

The following is a list of changes made between our original drawing NPM-E-3471 Rev. 0 dated 6/24/74 and the drawing NFM-E-22175 Rev. 0 dated 6/13/79 submitted in our renewal application. This list includes an explanation of why each revision does not have significant effect on the safety of the CE-250-2 shipping package.

A. To the "Shipping Container" Detail

<u>Drawing Change</u>	<u>Effect on Safety</u>
1. Deleted 4-3/4" TYP requirement between the bottom of the spring clip and the container bottom.	None - the 4-3/4" TYP dimension was redundant.
2. Revised 68-3/4" length requirement to 68-3/8"±1/4" inside dimension.	None - the dimensional change shows the height of the shipping container less the bottom roll ring and to allow for the tolerance build-up of the two 55-gallon drums welded together to form the outer shell of the shipping container.
3. Added a 1-1/8" minimum requirement between the flange ring (Item #24 and the top of the drum lip.	None - this dimension was added for construction purposes to set the location of the flange ring inside the container and to allow for tolerance build-up of the two 55-gallon drums welded together to form the outer shell of the shipping container.
4. Deleted the following note: "Std-1/2-13 UNC-2A x 2" lg-6 req'd". "Nut-1/2-13 UNC-2B-12 req'd".	None - note was redundant; same note was shown elsewhere on the drawing (View B).
5. Added the following note: "Supply Item #19, with a 5/8 - 11 UNC-2A x 4-1/2" long hex socket HD bolt & nut. Drill bolt with 3/32" dia. hole behind nut after assembly for safety wire seal.	None - note was added to incorporate the tamperproof sealing requirement of the clamp ring to the construction drawing.
6. Deleted the following requirement: "tack weld nut to Item 17 TYP 6 places."	None - the note was redundant, the same note was shown elsewhere on the drawing, (View B).
7. Modified the outer barrel assembly drawing to show the indentation of the bottom of the barrel.	None - clarification of the container construction drawing.
8. Added a 6-1/2" dimension to show total height of Item 24, 14, & 11 when assembled.	None - clarification of a container dimension for construction purposes.

A. To the "Shipping Container" Detail (Cont'd)

Drawing Change

- 9) Changed the length from the top of the inner container to the top of Item 11 from 6-1/2" to 6-15/16". Also made this dimension a reference dimension.
10. Added a requirement to grind the seam weld of the shipping container.
11. Deleted the 1/16" recess requirement of the inner container bottom.
12. Changed the clearance dimension between the inner container bottom and the bottom of the shipping container from 4-1/4" to 4-3/16".
13. Increased the diameter of the inner container bottom and changed location of the seam weld.

Effect on Safety

None - clarification of a container dimension for construction purposes.

None - This requirement was added to remove any sharp edges along the seam weld that might injure a person handling the shipping container.

None - change was made for ease of construction. All other construction assembly methods and material were not changed

None - this is a dimensional change due to relocating the bottom of the inner container. (Ref: Paragraph A.11)

None - change was made for ease of construction (Ref: Paragraph A.11)

B. To View "B"

1. Changed "stud-1/2-13 UNC-2A x 2-1/4" - 6 required to hex head bolt 1/2-13 UNC-2A x 1-3/4" - 6 required. Also changed the number of 1/2-13 UNC-2B nuts from 12 to 6.
2. Changed "tack weld to flange-TYP 6 places" to tack weld bolt head to flange - TYP 6 places.

None - change was made for easy construction of the container. Material diameter and type remained the same.

None - clarification of the container construction drawing due to the modifications made in Paragraph B.1.

C. To View "C-C"

1. Changed "screw #5-40 UNC x 3/8 lg and nut #5-40 UNC" to button head socket #10-24 UNC x 3/8 lg and nut #10-24 UNC.
2. Changed cover hole diameter from 3/16" to 1/4" diameter.
3. Added note #5 to section "C-C". This corner may be fabricated by welding the two pieces together (full seam weld required).

None - the increase in bolt size will strengthen the holding force of the vermiculite port cover.

None - made to accommodate stronger screw specified above in Paragraph C1.

None - this change was made for ease of construction of the shipping container.

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D. To View "D"

Drawing Change

1. Deleted the following requirement: "nut may be modified by grinding to a minimum thickness of 3/16".
2. Deleted the following requirements: "stud-1/2-13 UNC-2A x 1-1/8" 1g" "inner nut 1/2-13 UNC-2B" "outer nut 1/2-13 UNC-2B modify"
Replaced the above with the following requirements:
"socket head cap screw 1/2-13 UNC-2A x 3/4" "nut 1/2-13 UNC-2B"
3. Added the requirement to tack weld the nut to the bottom of the flange.

Effect on Safety

None - change was made for ease of construction of the container. See Paragraph D.2.

None - change was made for ease of construction of the container. Material diameter and type remained the same.

None - change was made to allow easier assembly.

E. To "Flange" Detail

1. Changed flange I.D. from 15-1/2" to 15-3/8".
2. Changed cover screw holes from 3/16" to 1/4" diameter.
3. Changed two of the flange opening location dimensions as shown: 2" to 2-1/4" and 4" to 4-1/2".

None - dimensional correction to the drawing.

None - this allows use of stronger screws.

None - dimensional correction to the drawing.

F. Revision to the Bill of Material

1. Changed Item 9 requirement from 1/2" x 1/2" x 1/8" angle iron to 9/16" x 9/16" x 1/8" angle iron.
2. Changed Item 12 requirements from 14-3/4" O.D. x 12" I.D. x 1/8" THK to 14-3/4" O.D. x 1/8" THK.
3. Changed Item 15 requirements from Std. "55-gallon drum", to "55-gallon drum", top NPM-A-T1012, bottom-NPM-A-T1011, Reliable Drum, Milford, CT.
4. Changed Item 19 requirements from "Std. 18 gauge nut & bolt ring" to Std. 17H 12 gauge ring with 5/8 bolt & nut, Hartford Cooperage Co. Hartford, CT.

None - the larger angle iron mated better to the inner container. Results in stronger container.

None - change was made for ease of construction.

None - clarification of Bill of Material

None - this change provides for a stronger clamp ring to hold the cover to the shipping container.

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G. General

Drawing Changes

1. Drawing number was changed from:
NPM-E-3471, Rev. 02 to NFM-E-
Z2175, Rev. 0.
2. Add a layout of the bolt. (Item 26)
to the drawing.
3. Add Note #6 - all dimensions are in
inches unless otherwise specified.
4. Deleted Note #1 and added a full
seam weld designation to the drawing.

Effect on Safety

None - the changing of the drawing
number was made so that the shipping
container drawing could be released
through and controlled by NFM-Windsor's
Central Document Control.

None - change was made for clarifica-
tion of the bolt requirements.

None - change was made for clarifica-
tion of the drawing.

None - clarification of the drawing.

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UNITED STATES
NUCLEAR REGULATORY COMMISSION
WASHINGTON, D. C. 20555

6/16/80

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Richard B. Smith

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