

TITLE RCV-7 Shaft Seamed (OCONEE-1)  
RELATED SPRs SPR (WLT) 446, 461

This SPR has been reviewed by Task Engineering Groups and is applicable to  
NSS-\_\_\_\_\_. The following  
is the status and/or resolution of this SPR on other contracts.

REMARKS

RG Brunley

03, 04, 05, 9, 12, 13

This problem will be closed out on general  
basis because 1) it has been assigned to the Top Concern  
Problem list 2) There are other SPRs associated  
with the problem of this valve (SPR 520) and  
3) There is nothing on this particular problem  
HSS- (Seamed shaft) that can be done or has been  
seen elsewhere on this valve. The problem has  
been ~~not~~ properly identified ~~to~~ engineering  
and nuclear services dissatisfaction with  
the rotating stem valve as a spray valve has  
been expressed.

RFP 12/21/74

NSS-\_\_\_\_\_

TRANSMITTAL SLIP  
FIELD OPERATIONS SITE PROBLEM REPORT

\*\*\* CLEARED \*\*\*

To E. J. McConnell (2) For Information  
R. C. Burnley - NSE  
G. E. Kalynych - Sr. Project Manager  
C. C. Plunkett - Contract Admin.  
Central Engineering Files  
E. V. DeCarli - Quality Assurance

FILE: 1242  
Contract 620-00 - 03  
SFR 546  
TITLE RC-VI Shaft  
Scored  
DATE 2-19-74

The attached, cleared SFR is submitted for your information.

TO: \_\_\_\_\_ J. N. Kaelin-Arkansas \_\_\_\_\_  
\_\_\_\_\_ J. P. Kennedy-EMUD \_\_\_\_\_  
\_\_\_\_\_ K. E. Suhrke \_\_\_\_\_  
\_\_\_\_\_ H. J. Worsman \_\_\_\_\_  
\_\_\_\_\_ J. D. Phinney-Met Ed \_\_\_\_\_

Attached is one copy of Site Problem Report No. \_\_\_\_\_ which has been processed on Contract 620-00 \_\_\_\_\_. Your contract or contracts may have the potential for a similar problem. The Site Problem Report is being forwarded for your information and use to prevent problems from recurring on following contracts. A more complete file on the problem is available in the Nuclear Service area.

REMARKS: No maintenance report written  
\_\_\_\_\_  
\_\_\_\_\_

cc:

R. L. Pittman  
NUCLEAR SERVICE SUPPORT ENGINEER

FIELD OPERATIONS SITE 'F' LHM REPORT

To W.C. BUTT - NSE For Action

CONTRACT 620-00 - 03

→ R.J. McConnell - S.D.M.

SFR 546

L. Allen - A.P.M.

TITLE RC-VI Shaft

To J. Kaelin - ARK For Information

Scored

J. Kennedy - SMUD

J. Phinney - Met Ed

DATE 7-18-73

K. Subrke

H.J. Worsham

Date Reply to Be Submitted To  
 Nuclear Service Support Engineer

Action Requested: Upon receipt of the DUKE Main-  
tenance report, the feasibility of exchanging  
the present bonnet with a new bonnet  
(possibly from Unit III) will be determined.

W.C. BUTT IS investigating other  
types of valves which are suitable for  
spray valves i.e. (Copes Vulcan, non rotating  
stem, bellows). Site is requested to fwd  
DUKE maintenance report when its available

R. E. Pittman  
 Nuclear Service Support Engineer

- cc: G. E. Kulysych
- E. G. Ward
- G. M. Olds
- R. T. Schomer
- N. S. Embrey
- J. McFarland
- C. C. Plunkett - Contract Admin.
- Central Engineering Files
- E. V. DeCarli - Quality Assurance

R.G. BURNLEY  
O. Pottsgruber

MAN-HOUR LIMITS	_____
COST LIMITS	_____
CHARGE No.	_____
APPROVED:	<u>R. Allen</u> Project Manager

SITE PROBLEM REPORT

BOCK & WILCOX-NPG

CUSTOMER Duke Power Co CONTRACT NO. 620-003 SPR NO. 546 SPR REV NO. 0

VENDOR Rockwell P.O. NO. 081440 COMP. NO. 28 GROUP NO. 41 SEQ NO.

PRIMARY DOCUMENTS: SPEC NOS. \_\_\_\_\_  
ORG NO. \_\_\_\_\_ EQUIP CODE/LEVEL/DATE \_\_\_\_\_  
QA LEVEL \_\_\_\_\_ QA SPEC NO. \_\_\_\_\_

PRIORITY

1

SITE ENGINEER E.L. Logan EARLY START DATE \_\_\_\_\_ ACTUAL START DATE \_\_\_\_\_ REQ'D COMP. DATE \_\_\_\_\_

TITLE (MAX. 30 SPACES) RC-V1

DESCRIPTION OF PROBLEM REFERENCE: SPR'S 444, 447 & 496.  
VALVE OPERATION ERRATIC ON 7/6/73. SHAFT FOUND TO BE GALLED. SHAFT DRESSED-UP IN PLACE WITH EMERY CLOTH AND VALVE RE-DACKED ON 7/7/73. DURING CHECKOUT ON 7/8/73 THE KEY HOLDING THE GEAR ON THE MOTOR SHAFT WAS FOUND TO BE SHEARED. THE KEY & GEAR WERE REPLACED. OPERATION AT HOT CONDITIONS ON 7/8/73 AM WAS SATISFACTORY. NO PACKING LEAKS.

STATUS-ACTION TO DATE INCLUDING PERSONS CONTACTED, COMMITMENTS MADE, ETC.  
VALVE REPAIRED BY DUKE MAINTENANCE AND RETURNED TO SERVICE. DUKE PREPARING FULL REPORT. WILL TRY TO OBTAIN COPY FOR B&W.

~~REPAIR~~ ACTION ~~REQUIRED~~ BY ~~OPERATOR~~ SITE PERSONNEL.

~~Recommended~~

Consider replacing lantern ring w/packing. Box in yoke for leakage collection

RECOMMENDED ACTION

Duke man write report - other SPR'S cover the valve :: closing this SPR

TITLE	APPROVAL SIGNATURE	DATE	DOCUMENTS AFFECTED	ACTION TAKEN
ORIGINATOR	<u>E.L. Logan</u>	<u>7/9/73</u>	<input type="checkbox"/> Drawings	
SITE CONSTR. REP.			<input type="checkbox"/> Proc Specs	
SITE OPER. MGR.	<u>W.D. Powell</u>	<u>7/10/73</u>	<input type="checkbox"/> Instr Books	
N.S. SUPPORT ENGR.	<u>R.S. Patterson</u>	<u>7/18/73</u>	<input type="checkbox"/> Operating Procedures	
			<input type="checkbox"/> Tech Specs	
			<input type="checkbox"/> P&ID/PI&B	
PROJECT MANAGER			<input type="checkbox"/> Recommended	
			<input type="checkbox"/> Side Change	
DISTRIBUTION		Case Category <input type="checkbox"/> M <input type="checkbox"/> C <input type="checkbox"/> D <input type="checkbox"/> O <input type="checkbox"/> I	With Charge No. _____	Field Change Req <input type="checkbox"/>
SITE OPS MANAGER	RESPONSIBILITY ASSIGN.	Done Completed _____	By: _____	Field Change No. _____
PROJECT MANAGER				
N.S. SUPPORT ENGR.				
COGNIZANT ENGR.	OTHER CONTRACTS AFFECTED	DEVIATIONS		
CONTRACT ADMIN.		<input type="checkbox"/> NONE		
NPG QA		<input type="checkbox"/> SEE REV _____		
FILE 12M2455-3				<u>1/29/74</u>
SPR 546				

THE BABCOCK & WILCOX COMPANY  
POWER GENERATION GROUP

File  
SPR2546

*J.P. Ittner*  
RUP

To: R. R. Beach

From: E. L. Logan *EL*

Subject: Duke Power

Subject: MORE ON 1 RC-4 (RC-V2) and 1 RC-1 (RC-V1)

SPR -

BOS 453-5

File No. or Ref.

Date: 12/18/73

This letter to cover one customer and one subject only

Limit Switch LS-9 was added to the 1 RC-V2 circuit on 12/12/73. (See Fig. 1) The switch was set to stop valve travel at 4 turns of the handwheel from the full closed position. This appears to have solved the opening problem as this valve was opened on 12/16/73 at full temperature and pressure. Now the valve cannot be closed. Two attempts were made on 12/17/73 and both times the overloads tripped. The 15 ft # motor is evidently not strong enough to start the valve toward the closed position.

As you know Duke replaced the yoke bushing on 1 RC-1 ( 1 RC-V1 ) on 11/23/73 (SPR # 570). The replacement bushing was not the correct one as Rockwell had shipped the wrong replacement part to Duke. Duke had planned to replace this bushing during the December outage. The valve became inoperable on 12/16/73. The valve indicates open when commanded open, but system conditions indicate the valve stays closed. If the bushing is stripped as before, it seems the valve would be hung open rather than closed. This problem will have to be investigated during the next Unit I shutdown. Duke has closed 1 RC-3 ( 1 RC-V ) to preclude an open failure of 1 RC-1 causing a plant shutdown as occurred on 11/20/73.

The Unit I pressurizer valve line-up is as follows:

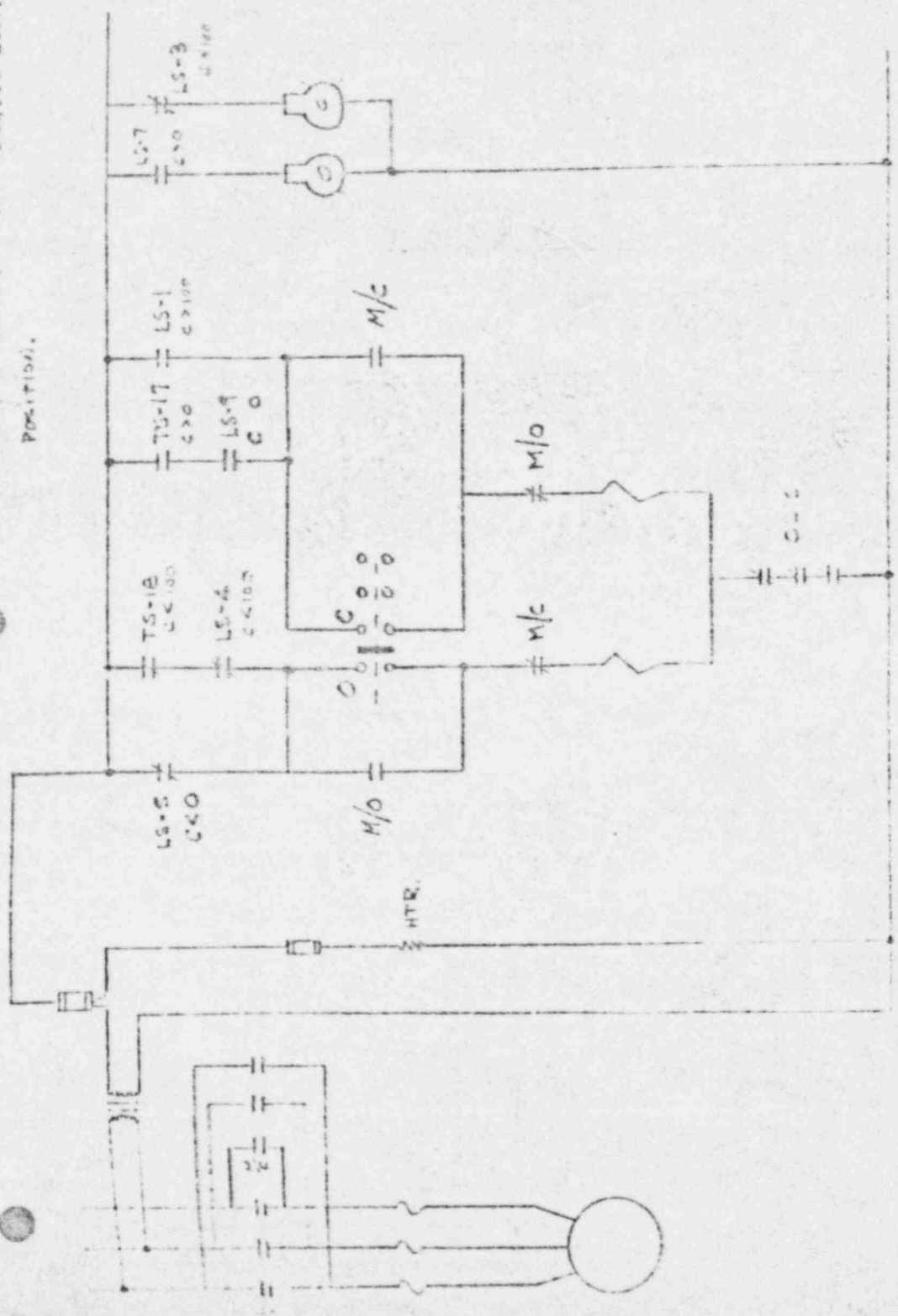
- Spray Valve (RC-1) - Closed and Inoperable
- Spray Block (RC-3) - Closed
- Electromatic Relief (RC-66)- Operable
- Elec. Block (RC-4) - Open and Inoperable

Since 12/15/73 we have been able to obtain comparative RCS and pressurizer boron concentrations. This is in response to SPR-557 and B. A. Karrasch's memo of 11/19/73. Figures 2 and 3 are plots of these values for both Units I and II. The Unit I continuous vent (.1 to .4 gpm) was secured on 12/17/73. Before the system is cooled down, we will investigate for leaking valves, etc. Unit II is indicative of normal operation since a conscious effort has been made to maintain RCS boron concentration constant with only the spray valve bypass flow into the pressurizer.

ELL/bh

- cc: J. P. Ittner ✓ R. G. Burnley
- E. V. Straub E. L. Logan
- C. A. Creacy W. C. Butt
- R. L. Pittman B. Karrasch
- R. J. McConnell

NOTE: LS-9 ADDED 11/13/73 TO STOP  
 TRAVEL BEFORE FULLY TONGUED CLOSED  
 POSITION.



WELLS ENGINEERING

1 RC-4 CONTROL SYSTEM  
 (CWA 222-V2)

FIGURE 1

LOG 403

OCONEG  
UNIT I BOSON

— RCS  
--- PRZE

① STARTED VARYING PAPER LEVEL BETWEEN 220" & 270" @ 0300 12/18/13

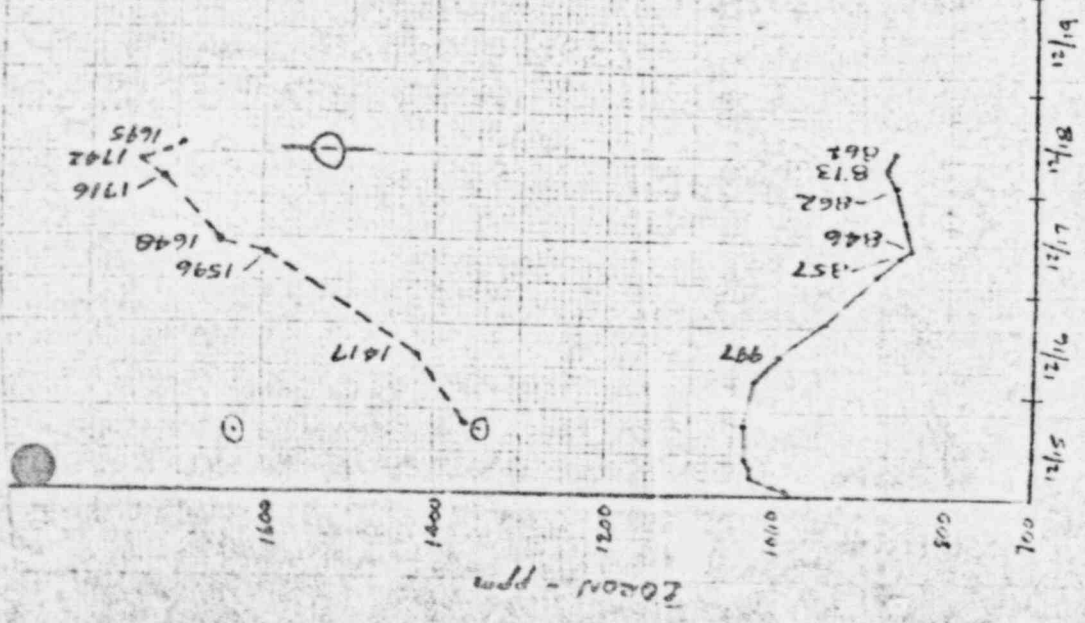


FIGURE 2

LOW

OCONEE  
UNIT II BORON

— RCS  
 --- PREE

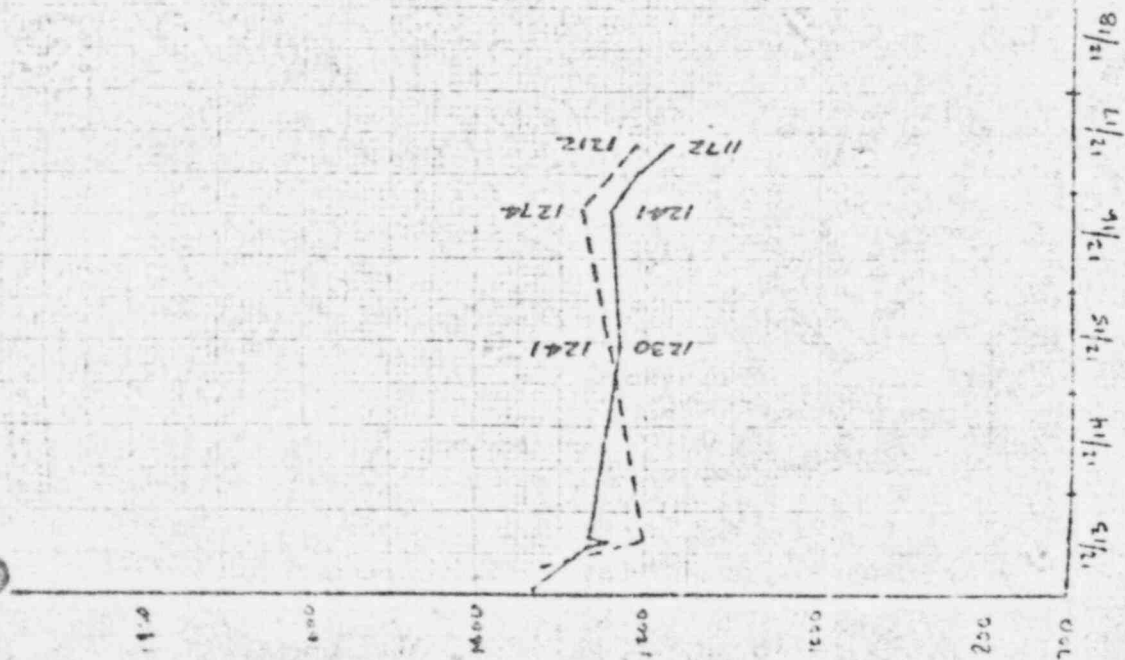


FIGURE 3

LOGAN



# LIMITORQUE CORPORATION

AFFILIATED WITH PHILADELPHIA GEAR CORPORATION

181 South Gulph Road, King of Prussia, Pa. 19406

Telephone (215) 265-3000

Telex-84-6321



*K. FITTMAN*  
Reply to:  
2610 Old Pineville Road  
Charlotte, North Carolina 28210  
Phone: (704) 527-2610

January 2, 1974

# COPY

Babcock & Wilcox  
c/o Duke Power Company  
Oconee Nuclear Station  
P. O. Box 1175  
Seneca, South Carolina 29678

Attention: Mr. Roy Mc Connel

Subject: Pressurizer Spray Valve, Tag RCVI,  
Located at Duke Power Co., Oconee Nuclear Station  
Rockwell Size 2½", Figure 3628M  
Limitorque SMB-2-40, per Mfg. No. 342869D  
Rockwell P.O. 36-29014, Dwg. B-441804

Gentlemen:

The purpose of this letter is to confirm our 'phone conversation of December 31 and to enumerate the immediate and long term actions taken to eliminate the problem encountered at the above valve application.

The immediate action to be taken is:

- A. Continue to utilize the present SMB-2 operator with alterations to the Bellville washers (torque spring package) and motor.
- B. Rewind the motor from 3600 RPM to 1800 RPM.
- C. Change from the present 13-spring washer set (.189" thick -.0787" dish) to a 9-spring washer set (.1378" thick -.0984" dish)
- D. Set the torque switch on both sides, (both scales), at 1½ so the operator will torque out at 93½ at the stem nut.

The immediate action recommendations arose from the need to quickly eliminate the problem within a 3 day span and were based on an actual operating pressure differential of 50 psi where the maximum differential to be encountered would be 200 psi.

(continued)

cc: Mr. Joe Davis, Duke Power Co., Seneca, S.C.  
Mr. Bob Burnley, Babcock & Wilcox, Lynchburg, Va.  
Mr. Ed Logan, Babcock & Wilcox, Seneca, S.C.  
Mr. Tom Stoecker, Rockwell, Raleigh, N.C.  
Mr. Jim Morris, Rockwell, Raleigh, N.C.

The effect of the above modifications will be observable within the next few days and will probably be taken into account by Jim Morris of Rockwell and Bob Burnley of your company in their present long range decision. I say long range since I understand they are contemplating going to a smaller motor and operator on this and a second valve. The time required to manufacture new operators and coordinating their installation at the next downage necessarily make it a long range action.

This immediate action of 12-28 through 12-31 has in essence relied on decreasing the valve stem speed and making the torque cut-out feature more sensitive. With it's success, Jim and Bob may want to consider decreasing the speed on any other similar problem applications by altering gear ratios and altering torque spring packages, and keeping the present operators.

On the part of Limitorque Corporation, our next step is to get in touch with Rockwell and be of service to Jim Morris in his evaluation and action on this valve and operator application.

Very truly yours,

LIMITORQUE CORPORATION

George Cusack  
District Manager

CC:fa

OCONEE  
UNIT II BORON

— RCS  
--- PRE

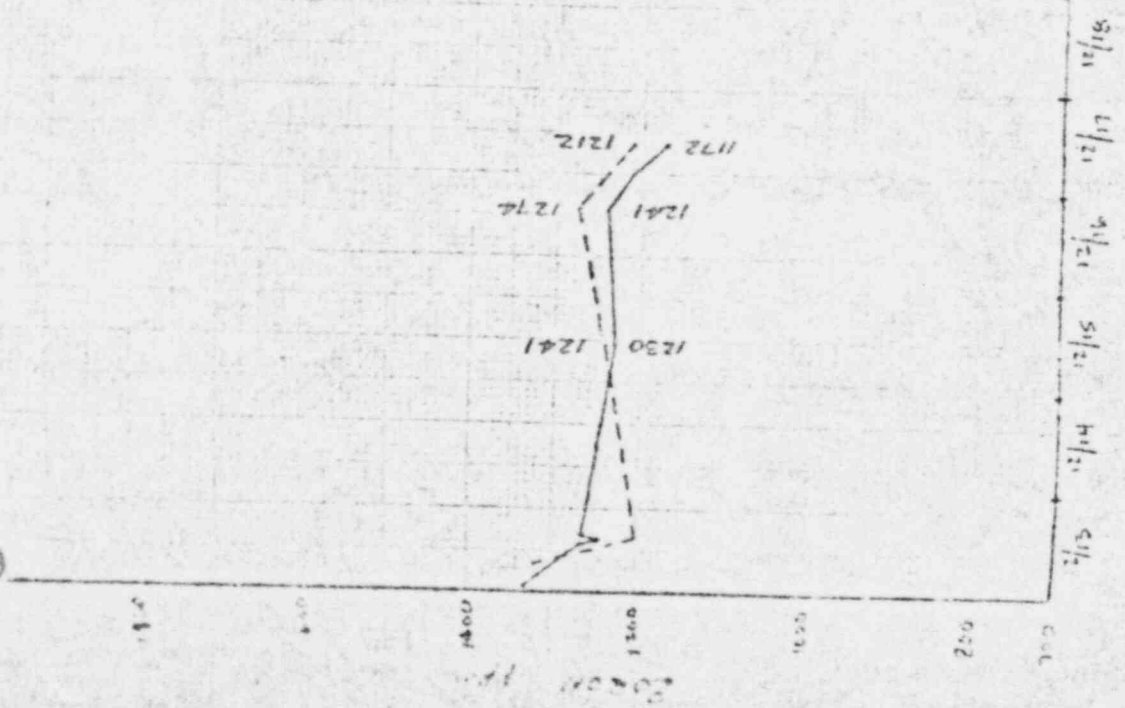


FIGURE 3

LEGAN

# Babcock & Wilcox

Power Generation Group

P.O. Box 1260 Lynchburg, Va. 24505

Telephone: (804) 384-6111

December 28, 1973

SOM 641

Duke Power Company  
Oconee Nuclear Station  
P. O. Box 1175  
Seneca, South Carolina 29678

Subject: RC-VI (Spray Valve) Interim "Fix"

Attention: Mr. J. Ed Smith

Dear Mr. Smith:

RC-VI has experienced a high failure rate. This is apparently due to the forces exerted on it by the high speed operator (SMB-2-40), provided to achieve the desired RCS transient response.

B. & W. has ordered SMB-0-15 operators to replace the current RC-VI operators on all three units, however; the promised delivery on these units is 25 weeks. The smaller operators are permitted by re-evaluation of the required transient response and should improve the performance of RC-VI.

As an interim means of extending the life of the spray valve, B. & W. recommends modifying the existing operator to reduce its power or exchanging it with a lower powered operator.

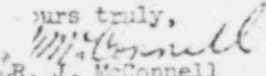
RC-V5 (spray line block valve) is identical to the spray valve but has a smaller operator (SMB-00) as it has no transient response requirements.

Exchanging these operators has been reviewed by B. & W. and would provide an increased reliability for the spray valve at the cost of decreased transient response. As operation with no spray flow has been reviewed by the Station Review Committee and found to be permissible, operation with a slow spray valve should also be acceptable.

RC-V5 is very seldom operated and use of the larger operator should not greatly affect its life. The proper operator would be re-installed when the replacement RC-VI operators became available.

Please note that there is a difference in the motor voltage between the two operators, and the control circuits would also require modification.

We will be glad to review any alternate means of decreasing the power of the RC-VI, which you may find available.

Yours truly,  
  
R. J. McConnell  
Site Operations Manager

RJM/hh

cc: R. R. Beach, The Babcock & Wilcox Company / Established 1867  
G. E. Kulynych and J. P. Ichnar

DOMESTIC WIRE MESSAGE

J.B. Pittman

Do not place message above this line

Do not place message below this line

cc: L. S. Burnley  
R. Pittman

*R. Pittman*

W. T. Bunt, Sr. Buyer

Do not type below this line

Date 12-17-73

1-23-74

TRANSMITTAL SLIP

FIELD OPERATIONS SITE PROBLEM REPORT

To W.C. BUTT - NSE For Action

R.J. McConnell - S.D.M.

L. Allen - A.P.M.

To J. Kaelin - ARK For Information

J. Kennedy - S.M.I.D.

J. Phinney - Met Ed

K. Subrke

H.J. Worsham

CONTRACT 620-00 - 03

SPR 546

TITLE RC-VI Shaft  
Scored

DATE 7-18-73

Date Reply to Be Submitted To  
Nuclear Service Support Engineer

Action Requested: Upon receipt of the DUKE main-  
tenance report, the feasibility of exchanging  
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spray valves i.e. (Copes Vulcan, Non rotating  
stem, bellows). Site is requested to fwd  
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- E. G. Ward
- G. M. Olds
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- C. C. Plunkett - Contract Admin.
- Central Engineering Files
- E. V. DeCarli - Quality Assurance

R.G. BURNLEY  
O. Pottsgruber

R. L. Pittman  
Nuclear Service Support Engineer

MANHOOR LIMITS	_____
COST LIMITS	_____
CHARGE No.	_____
APPROVED:	<u>R. Allen</u> Project Manager

SITE PROBLEM REPORT

BABCOCK & WILCOX-NPG

CUSTOMER Duke Power Co CONTRACT NO. 620-0003 SPR NO. 546 SPR REV. NO. 0

VEHICLE TRUCKWELL P.O. NO. 081480 COMP. NO. 28 GROUP NO. 41 SEQ. NO. \_\_\_\_\_

PRIMARY DOCUMENTS: SPEC NOS. \_\_\_\_\_ PRIORITY \_\_\_\_\_

DWG NO. \_\_\_\_\_ EQUIP CODE/LEVEL/DATE \_\_\_\_\_

QA LEVEL \_\_\_\_\_ QA SPEC NO. \_\_\_\_\_

SITE ENGINEER E. L. LOGAN EARLY START DATE \_\_\_\_\_ ACTUAL START DATE \_\_\_\_\_ REQ'D COMP. DATE \_\_\_\_\_

TIT. E (MAX. 35 SPACES) RC-V1

DESCRIPTION OF PROBLEM REFERENCE: SPR'S 444, 447 & 496.  
VALVE OPERATION ERRATIC ON 7/6/73. SHAFT FOUND TO BE GALLED. SHAFT DRESSED UP IN PLACE WITH EMERY CLOTH AND VALVE RE-DACKED ON 7/7/73. DURING CHECKOUT ON 7/8/73 THE KEY HOLDING THE GEAR ON THE MOTOR SHAFT WAS FOUND TO BE SHEARED. THE KEY & GEAR WERE REPLACED. OPERATION AT HOT CONDITIONS ON 7/9/73 AM WAS SATISFACTORY. NO PACKING LEAKS.

STATUS-ACTION TO DATE INCLUDING PERSONS CONTACTED, COMMITMENTS MADE, ETC.  
VALVE REPAIRED BY DUKE MAINTENANCE AND RETURNED TO SERVICE. DUKE PREPARING FULL REPORT. WILL TRY TO OBTAIN COPY FOR B&W.

~~REPAIR~~ ACTION ~~RECOMMENDED~~ BY ~~OPERATOR~~ SITE PERSONNEL -  
Recommended  
Consider replacing lantern ring w/packing. Box in yoke for leakage collection

RECOMMENDED ACTION

TITLE	APPROVAL SIGNATURE	DATE	DOCUMENTS AFFECTED	ACTION TAKEN
ORIGINATOR	<u>E. L. Logan</u>	<u>7/9/73</u>	<input type="checkbox"/> Drawings	
SITE CONSTR. REP.			<input type="checkbox"/> Proc. Specs	
SITE OPER. MGR.	<u>N. S. Support Engr.</u>	<u>7/10/73</u>	<input type="checkbox"/> Instr. Books	
MS SUPPORT ENGR.	<u>R. L. Pettman</u>	<u>7/13/73</u>	<input type="checkbox"/> Operating Procedures	
			<input type="checkbox"/> Tech Specs	
			<input type="checkbox"/> PSAR/FSAR	
PROJECT MANAGER			<input type="checkbox"/> Recommended	
			<input type="checkbox"/> Sds. Change	
			<input type="checkbox"/> Field Change Sd	<input type="checkbox"/>
			<input type="checkbox"/> Field Change No	_____

DISTRIBUTION SITE OPS MANAGER PROJECT MANAGER N. S. SUPPORT ENGR. COGNIZANT ENGR. CONTRACT ADMIN. NPG QA FILE 1242 <u>455-3</u> <u>SAR 546</u>	Cert Category <input type="checkbox"/> Norm <input type="checkbox"/> C <input type="checkbox"/> D <input type="checkbox"/> O <input type="checkbox"/> L	Auth. Charge No. _____
	RESPONSIBILITY ASSIGN. _____	Date Completed _____ By: _____
	OTHER CONTRACTS AFFECTED _____	DEVIATIONS <input type="checkbox"/> NONE <input type="checkbox"/> SEE REV _____

INSTRUCTIONS FOR FDS-21091 - SITE PROBLEM REPORT

Initiated by Nuclear Service

1. ORIGINATOR - FILL IN: Customer; Contract No.; Vendor; PO No.; Component No.; Group No.; Sequence No.; Drawing No.; Title; Description of Problem; Status; Further Action Required by Other Than Site Personnel; Recommended Action; Approval Signature; Date.
2. SITE OPERATIONS MANAGER - FILL IN: SPR No. and Rev. No.; Priority; Site Engineer; Early Start Date; Required Completion Date; Approval Signature; Date.  
Note: Assign priority No. 1 or 2 defined as follows:  
 1. Implementation must be complete by required completion date to avoid delay in project completion.  
 2. Implementation must be complete by required completion date to obtain maximum project effectiveness.
3. NUCLEAR SERVICE SUPPORT ENGINEER - FILL IN: Primary Documents; Documents Affected; Cost Category; Authorized Charge No.; Responsibility Assignment; Other Contracts Affected.  
 Verify or establish proposed resolution working with appropriate engineering units, purchasing, and others as required.  
 If field change is not required and additional costs (over and above normal nuclear service expenditures) are not to be incurred, take the following steps: (a) Approve SPR, (b) Indicate "Not Required" in space provided for project manager's approval, and (c) Distribute as indicated in step 5 below.  
 If field change is not required but additional costs (over and above normal nuclear service expenditures) are to be incurred, approve SPR and forward to project manager for approval (step 4).  
 If field change is required, see procedure No. NPG-0402-07; obtain field change No. from project manager, and indicate field change No. on SPR.
4. PROJECT MANAGER - Approve SPR and Return to Nuclear Service Support Engineer.
5. NUCLEAR SERVICE SUPPORT ENGINEER - Distribute in Accordance With Procedure No. NPG-0402-04; Initial Action Taken Box (on Support Engineer's File Copy) when Documents Affected Have Been Corrected.
6. SITE OPERATIONS MANAGER - Implement Resolution; Upon Completion, Fill in Actual Start Date, Date Completed, and By.  
Note: If necessary to deviate from the approved SPR, note deviation on approved SPR and obtain revised SPR in accordance with procedure No. NPG-0402-05. Return completed SPR to nuclear service support engineer.

Initiated by B&W Construction Company

1. ORIGINATOR - FILL IN: Customer; Contract No.; Vendor; PO No.; Component No.; Group No.; Sequence No.; Drawing No.; Title; Description of Problem; Status; Further Action Required by Other Than Site Personnel; Recommended Action; Approval Signature; Date.
2. SENIOR CONSTR. CO. SITE REPRESENTATIVE - FILL IN: SPR No. and Rev. No.; Priority; Site Engineer; Early Start Date; Required Completion Date; Approval Signature; Date.  
Note: Assign priority No. 1 or 2 defined as follows:  
 1. Implementation must be complete by required completion date to avoid delay in project completion.  
 2. Implementation must be complete by required completion date to obtain maximum project effectiveness.
3. PROJECT MANAGER - FILL IN: Primary Documents; Documents Affected; Cost Category; Authorized Charge No.; Responsibility Assignment; Other Contracts Affected.  
 Verify or establish proposed resolution working with appropriate engineering units, purchasing, and others as required.  
 If field change is not required and additional costs (over and above normal construction Co. expenditures) are not to be incurred, take the following steps: (a) Approve SPR, and (b) Distribute in accordance with procedure No. NPG-0402-05.  
 If field change is not required but additional costs (over and above normal construction Co. expenditures) are to be incurred, obtain abnormal cost charge No. from contract administration; approve and distribute in accordance with procedure No. NPG-0402-05.  
 If field change is required, see procedure No. NPG-0402-07; assign field change No., have approved and distribute in accordance with procedure No. NPG-0402-05.
4. SENIOR CONSTR. CO. SITE REPRESENTATIVE - Implement Resolution; Upon Completion, Fill in Actual Start Date, Date Completed, and By.  
Note: If necessary to deviate from the approved SPR, note deviation on approved SPR and obtain revised SPR in accordance with procedure No. NPG-0402-05. Return completed SPR to the project manager.