

PDR 71-6400



Department of Energy
Richland Operations Office
P.O. Box 550
Richland, Washington 99352



MAY 07 1980

Mr. Charles E. MacDonald, Chief
Transportation Certification Branch
Division of Fuel Cycle and Material Safety
Nuclear Regulatory Commission
Washington, D. C. 02055

Dear Mr. MacDonald:

CERTIFICATE OF COMPLIANCE NO. 6400 REVISION 8

This is in response to your letter dated February 29, 1980, concerning the above subject. In that letter, you requested certain information concerning the subject package. Attached please find a copy of the report to us from our contractor, Westinghouse Hanford Company. The container noted in that report is the only loaded Super-Tiger which we have delivered to a carrier since February 28, 1978. Should you have any questions concerning this material, please contact our Mr. J. M. Peterson (FTS 444-6731).

Very truly yours,

T. R. Fitzsimmons, Director
Facilities and Site Services Division

FSS:JMP

Attachment

RECEIVED

WE WANT

THIS DOCUMENT CONTAINS
POOR QUALITY PAGES

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8051429

April 14, 1980

Director, FFTF Project Office (5)
Department of Energy
Richland, Washington 99352

APR 14 1980

APR 14 1980

SUPER TIGER SHIPPING CONTAINER INSPECTION

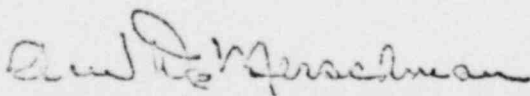
Reference: Letter, CC Carlisle to JB Yasinsky, same subject, dated March 18, 1980

HEDL has one Model No. 6400 "Super Tiger" radioactive material shipping container, Serial No. HO-64-15860, Manufacturer's No. 122-740-310.

Fuels Quality Engineering has prepared an Annual Inspection and Test Plan, No. RSC-ANN-ST, and a Biennial Inspection and Test Plan, No. RSC-BIEN-ST applicable to this container. Physical inspection of the HEDL Model 6400 container has been performed to the standards specified in the test plans.

The test plans are designed to ensure that all items important to the safety of the container are inspected. The periodic inspection plans do not require that every dimension and tolerance be checked against the container drawings. Only those dimensions which relate to safety and serviceability are checked during routine inspections.

Copies of Inspection and Test Plans RSC-ANN-ST and RSC-BIEN-ST are attached for your information.



A. W. DeMerschman
Manager

bn

Attachments

1. Test Plan RSC-ANN-ST
2. Test Plan RSC-BIEN-ST

DOE/RL - JM Peterson

INSPECTION AND TEST PLAN FOR
 SUPER TIGER
 ANNUAL PERIODIC INSPECTION
 OF
 RADIOACTIVE MATERIALS SHIPPING CONTAINERS

Annual

REVISION 0

MAY 1979

PLAN NO. RSC-ANN-ST

PREPARED BY *K. R. Welsch* DATE 5-24-79
 K. R. Welsch
 Fuels Quality Engineering

APPROVED BY *E. K. Cleveland* DATE 6/1/79
 E. K. Cleveland, Manager
 Fuels Quality Engineering

APPROVED BY *J. M. Francis for TMF* DATE 6/12/79
 J. M. Francis, Manager
 Fuels Quality Control

APPROVED BY *D. W. Engel* DATE 6/19/79
 D. W. Engel, Manager
 Nuclear Materials Management

APPROVED BY *L. A. Pember* DATE 6-7-79
 L. A. Pember, Manager
 Postirradiation Testing

DISTRIBUTION: EK Cleveland W/A-99 FS. Smith W/C-39
 JM Francis W/A-99 *RL Schumacher W/A-99
 WJ Gruber W/A-72 *308 FQC Techs (2) W/C-17
 DW Engel W/C-39 KR Welsch W/A-99
 LA Pember W/A-72
 *Controlled Copies

QA STATUS: Accept () Reject () Hold ()

List Nonconformances Pending: _____
 _____ Disposition _____ Date Completed _____
 _____ Disposition _____ Date Completed _____
 _____ Disposition _____ Date Completed _____

Q.C. Inspector _____
 Final Acceptance _____ Date _____

INSPECTION AND TEST PLAN FOR
SUPER TIGER
ANNUAL PERIODIC INSPECTION
OF
RADIOACTIVE MATERIALS SHIPPING CONTAINERS
REVISION 0
MAY 1979
PLAN NO. RSC-ANN-ST

Any nonconforming condition found on this shipping container shall be cause for a Nonconformance Report form (54-7310-104). Each container is to be used inspected individually, not on a lot basis. Notify the Cognizant Q.A. Engineer prior to first usage of this plan.

The 'reference or test methods' defined within the plan are of the minimum precision permitted. Alternate methods, with greater precision, may be substituted without FQE approval. Where substitutions are made, approval must be obtained from the FQC Lead Engineer. Substitutions must be documented by lining out the original method, inserting the alternate method, and having the approving Engineer initial and date the change.

FQC shall verify the reports and tests are completed.

A corrosion resistant metal tag indicating expiration date of the most recent periodic inspection shall be firmly and securely affixed by FQC in a conspicuous location on the body of the container. Where permanent attachment of the metal tag would damage the component, or make contamination cleaning difficult, other durable methods of marking the container shall be used.

INITIAL RELEASE AND CHANGE CONTROL RECORD

RSC-ANN-ST

REVISION NO.	DATE	CHANGE DESCRIPTION	AFFECTED PAGES	RELEASE DOCUMENT
0	MAY 1979	ORIGINAL ISSUE	ALL	

LOT NO. _____
 PART NO. _____
 SERIAL NO. _____

INSPECTION AND TEST PLAN
 No. RSC-ANN-ST

ANNUAL PERIODIC INSPECTION

PART DESCRIPTION: SUPER TIGER						H/S NO. ---	DWG. NO. S7B-71134 H-3-39887 & 32106	
ITEM NO.	SPEC; SECTION OR DWG; VIEW	CHARACTERISTIC	REFERENCE OR TEST METHODS	INSPECTION DENSITY	QA STAMP	DATE	DATA RECORDING	COMMENTS/ NONCONFORMANCES
1.	RDT E 12-7T & Drawings	CONFORMANCE TO DRAWINGS						
1a.	H-3-39887 (Zone A-11)	Hinge Pins (4 places)	Visual (1X)	100%				
1b.	32106 (Zone E-2)	Bolts (10 places)	Visual (1X)	100%				
1c.	32106 Note 11	Internal Cavity - panels flat within 3/16"	Straight Rule Feeler Gage	100%			Information Only	
1d.	32106 Note 12	External Container - panels flat within 1/4"	Straight Rule Feeler Gage	100%			Information Only	
1e.	32106 Note 7	Closed Vents - installed plastic plug (10 places)	Visual (1X)	100%				
2.	RDT E 12-7T 4.4.1.a	SURFACE CONDITION - painted surfaces (free of cracks, chips or blisters)						
2a.	32106 (Zone D-3) Note 5	Container Body (Exterior)	Visual (1X)	100%				
2b.	32106 (Zone D-5)	Door (Exterior)	Visual (1X)	100%				
2c.	32106 (Zone D-3)	Inside Cavity (76"x76"x172")	Visual (1X)	100%				
2d.	32106 (Zone D-5)	Door (Inside Surface)	Visual (1X)	100%				

LOT NO. _____
 PART NO. _____
 SERIAL NO. _____

INSPECTION AND TEST PLAN
 No. RSC-ANN-ST

REVISION _____
 PAGE 2

ANNUAL PERIODIC INSPECTION

PART DESCRIPTION:		SUPER TIGER		HMS NO. ---		DMG. NO. SAG-771 H-3-33387 & 32106		COMMENTS/ NONCONFORMANCES	
ITEM NO.	SPEC; SECTION OR Dwg; VIEW	CHARACTERISTIC	REFERENCE OR TEST METHODS	INSPECTION DENSITY	CA STAMP	DATE	DATA RECORDING		
3.	RDT E 12-7T 4.4.1.e	CLOSURE DEVICES - (threads uniform & free of burrs)							
3a.	32106 (Zone E-2)	1-8 UNC (120-160 KSI) (10 places)	Visual (1X)	100%					
4a.	RDT E 12-7T 4.4.1.f	ALIGNMENT DEVICES - (functional & not deformed)	Visual (1X)	100%					
4b.	32106	1" DIA Dowel Pin (4 places)	Visual (1X)	100%					
5.	RDT E 12-7T 4.4.1.g RDT F 8-11 4.7 & App. A.3	LIFTING LUGS & EYES - 1) misalignment, wear or other deformation 2) affecting strength engagement guides and retainers soundly operable							
5a.	32106 (Zone E-1)	STD I.S.C. Corner Castings (8 places)	Visual (1X)	100%					
6.	RDT E 12-7T 4.4.1.j	REUSEABLE GASKETS - no visible deterioration or damage	Visual (1X)	100%					
7.	RDT E 12-7T 4.4.1.1	LEAK TIGHTNESS -							
7a.	32106 Note	Inner Cavity - to insure water tightness	Functional Test	100%					
8.	RDT E 12-7T	Cleanliness	Visual (1X)	100%					

INSPECTION AND TEST PLAN FOR
 SUPER TIGER
 BIENNIAL PERIODIC INSPECTION
 OF
 RADIOACTIVE MATERIALS SHIPPING CONTAINERS

Biennial

REVISION 0

MAY 1979

RSC-BIEN-ST

PREPARED BY K. R. Weisch DATE 5-24-79
 K. R. Weisch
 Fuels Quality Engineering

APPROVED BY E. K. Cleveland DATE 6/11/79
 E. K. Cleveland, Manager
 Fuels Quality Engineering

APPROVED BY J. N. Francis DATE 6/12/79
 J. N. Francis, Manager
 Fuels Quality Control

APPROVED BY D. W. Engel DATE 6/12/79
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BIENNIAL PERIODIC INSPECTION
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RADIOACTIVE MATERIALS SHIPPING CONTAINERS

REVISION 0

MAY 1979

RSC-BIER-ST

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RSC-BIEN-ST

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0	MAY 1979	ORIGINAL ISSUE	ALL	

BIENNIAL PERIODIC INSPECTION

ITEM NO.	SPEC; SECTION OR FIG; VIEW	CHARACTERISTIC	REFERENCE CR TEST METHODS	INSPECTION DENSITY	QA STAMP	DATE	DATA RECORDING	COMMENTS/ NONCONFORMANCES	IWS NO.	
									---	---
SUPER TIGER										
1.	RDT E 12-7T 4.4.2.a	WELDS - Subject to Stress								ENG. NO. SRB-7115 HD-39887 & 32106
1a.	32106 (Zone E-1)	Container - Corners, Top & Bottom	Liquid Penetrant (HEDL-PT-1000)	100%						
1b.	32105 (Zone E-5)	End Cover - Corners, Top & Bottom	Liquid Penetrant (HEDL-PT-1000)	100%						