PDR

71-6400

Babcock & Wilcox

Nuclear Materials Division

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Telephone: (412) 842-0711

July 10, 1980

Mr. Charles E. MacDonald, Chief
Transportation Certification Branch
Division of Fuel Cycle and Material Safety
U.S. Nuclear Regulatory Commission
Washington, D.C. 20555

Docket No. 71-6400

Dear Mr. MacDonald:

Reference is made to your letter dated February 29, 1980 and our subsequent response letter dated April 29, 1980. Pennsylvania Operations (PA Ops) respectfully requests amendment of Certificate of Compliance No. 6400 for the Model 6400 ("Supertiger") shipping container as presented herein.

PA Ops requests that the Certificate be revised to incorporate certain characteristics of our Model 6400 shipping container identified as L-1, NUMEC property tag number 202310.

These certain characteristics were identified as those which did not specifically conform with Protective Packaging Inc. Drawings No. 32106-1, Sheet 1, Revision F, and 32106, Sheet 2; this information had been previously provided in the inspection report attached to our above-mentioned response letter.

These specifically identified characteristics are as follows:

1. Drawing 32106-1 indicates that the "internal cavity panel" is to be flat within 3/16 inch. Our Model 6400 container has side panels in the internal cavity which are flat to within 1 inch, and the floor panel is flat to within 7/16 inch. (Drawing location: G4).

2. Drawing 32106-1 indicates that the "external container panels" are to be flat within 1/4 inch. Our Model 6400 container has said panels which are flat to within 35/64 inch. (Drawing location: G5).

3. Drawing 32106-1 indicates a "dowel pin length" of 2 inches $\pm$ 1/8 inch. Our Model 6400 container has a dowel pin length of 1-3/8 inch. (Drawing location: C4).

4. Drawing 32106-1 indicates a "bolt pocket size" of 6 inches $\pm$ 1/8 inch. Our Model 6400 container has a bolt pocket size of 5-3/4 inches. (Drawing location: C4).

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5. Other general characteristics of our Model 6400:

   a. Inside cavity door contains thirty-four (34) - 1/2 in. diameter bolts.
   b. Inside cavity door has three (3) hinges.
   c. Inside cavity door plate thickness is .255 in.
   d. Inside cavity door gasket thickness is .260 in.
   e. A purge hole is present in the center of the inside cavity door.
   f. Outer container door plate thickness is .370 in.
   g. Outer container door has fourteen (14) - 1 in. diameter bolts.
   h. Outer container door has two (2) hinges with a grease fitting in each hinge.
   i. Plywood on the inside of the outer door is .350 in. thick.
   j. All welds visually examined and appear sound and free of cracks.
   k. Four (4) re-enforcement steel plates are welded on the inside cavity back wall (Refer to the figure provided as Enclosure No. 1).

PA Ops requests that Certificate of Compliance No. 6400 be amended to include these above-described characteristics as acceptable to enable the authorized use of our Model 6400 container.

In addition to the above amendment request, the following is provided for your information.

1. The leak testing of our Model 6400 is given in an internal procedure written specifically for this container, and can be generally described as follows: After the inner cavity door is closed and bolted, a minimum of one pound of Freon gas is introduced into the inner cavity. A Halogen leak detector is used to monitor the seal around the inner cavity door. If a leak rate greater than 3.0×10^{-4} at. cc./sec is detected, then the bolts are retightened and rechecked until an acceptable leak rate of $\leq 3.0 \times 10^{-4}$ at. cc./sec. is achieved.

2. A detailed sketch of the seal for the inner cavity door is provided as Enclosure No. 2 to this letter.

3. On June 3, 1980, PA Ops' Quality Assurance inspected our Model 6400 shipping container for the five (5) conditions described in our above-mentioned response letter dated April 29, 1980. The inspection results are as follows:

   a. The inner surface of the cap (outer door) was scraped, new sealant applied and repainted.

   b. A new silicone rubber gasket was installed on the inner surface of the cap (outer door).

c. The gasket on the inner surface of the closure plate (inner door) was reglued.

e. The inner door gasket mating surface was scraped and repainted. The wood surface adjacent to the mating surface was resealed and painted.

f. The surfaces of the inner liner was repainted.

g. In addition, the external surfaces of the container were repainted.

Your prompt consideration of this amendment request will be appreciated. If you have any questions regarding this correspondence, please contact me.

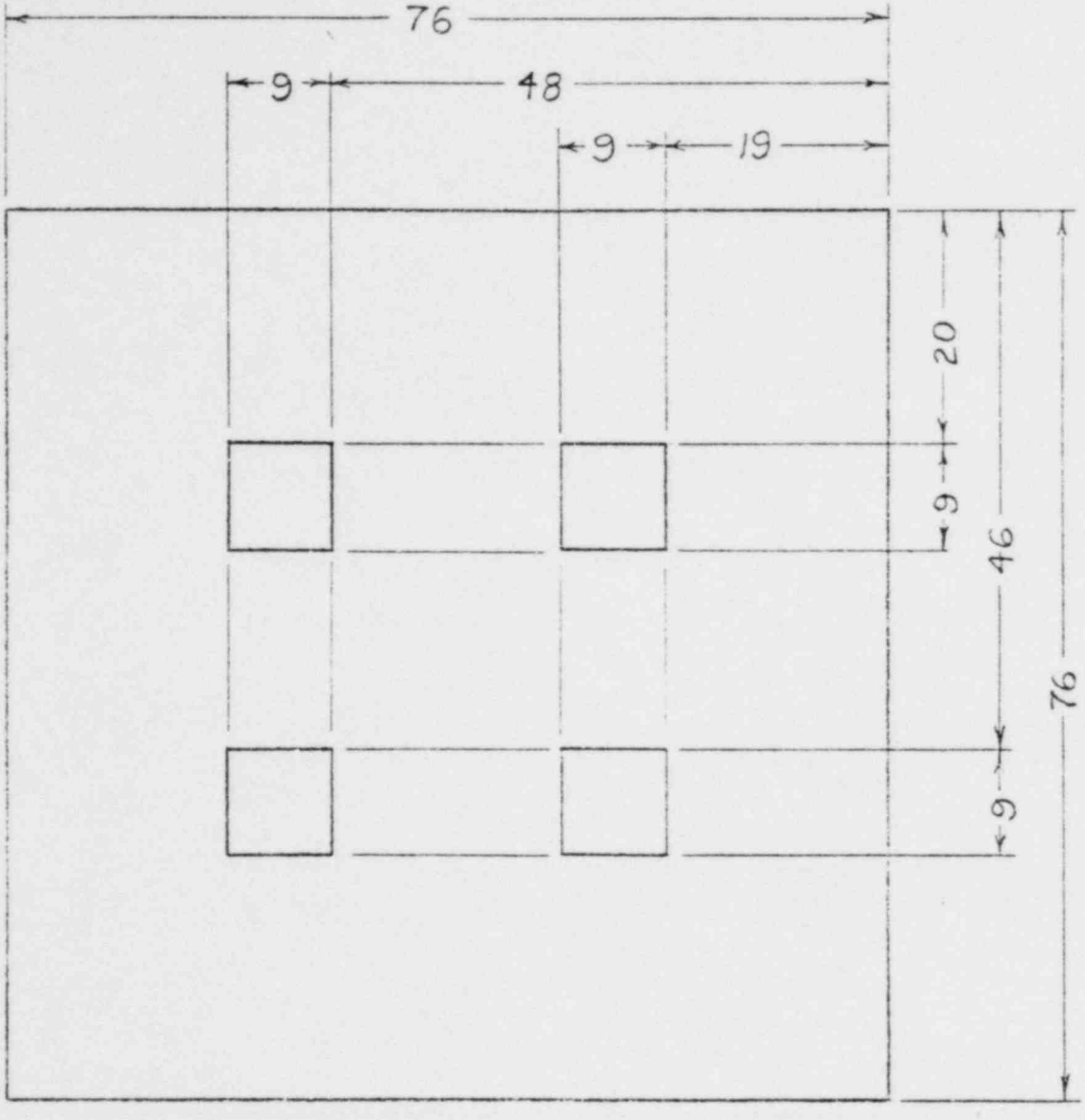
Sincerely,

M A Austin

Michael A. Austin
Manager, Technical Control

MAA/mhb

Attachments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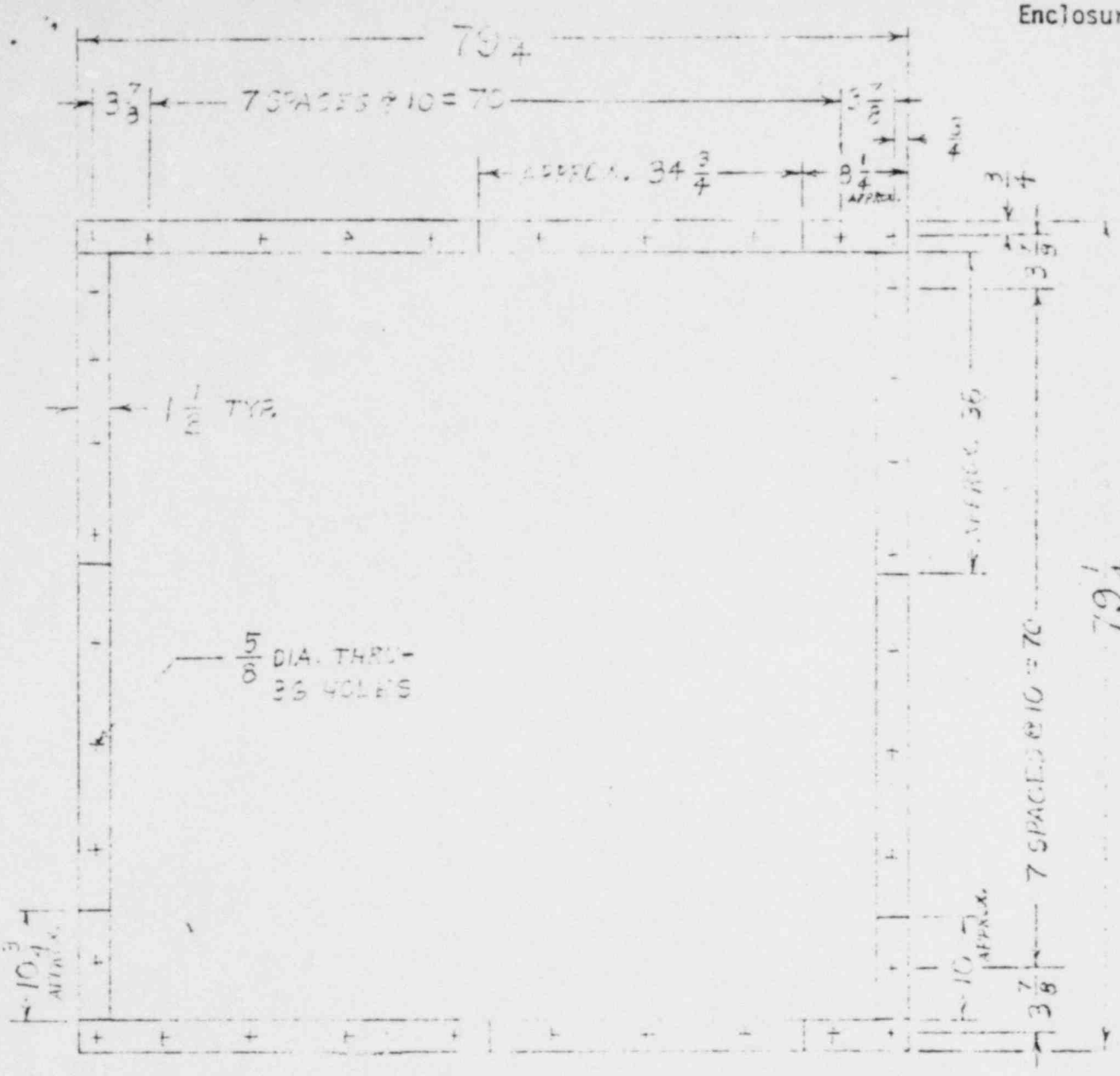
Enclosure 2



SILICONE RUBBER GASKET
1/2 WIDE 1/8 THK.

UNLESS OTHERWISE SPECIFIED.
TOLERANCES:
FRACTIONS ± 1/8

NOTES:
1. ALL JOINTS ARE BUTT.
2. JOINTS AS REQ'D.
3. GASKET TO BE BOND ED TO CAP WITH R.T.V.

JUN 1 3 1980

SUPERTIGER
HINGE DOOR GASKET

SCALE - NTS
DRAWN - [illegible] 6-2-80
APPROVED - [illegible] 6-3-80
[illegible]

10-A-441

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