

STEAM GENERATOR NOZZLE DAM CHECKOUT, INSTALLATION AND REMOVAL

FOR INFORMATION ONLY

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| REV. | REASONS FOR REVISION | DATE |
|---|--|--|
| 0 | New Frocedure | 03/19/86 |
| 1 | New Frocedure Incorporated TCP 86-1 Biennial per OP15-85/12/16 Incorporated field comments, cover sheet, INPO (87)MA6.1 | 03/28/86 |
| 2 | Biennial per OP15-85/12#16 | 10/13/86 |
| 3 | Incorporated field comments, | 03/25/88 |
| | cover sheet, INPO (87)MA6.1 | and the second se |
| 4 | Change torque in Step 4.1.1a. | 10/03/88 |
| | change Steps 4.1.1b through h | |
| Construction of the second | to reflect field comments | |
| | Separate Completion Sheets for Hot and Cold legs, add | |
| | for Hot and Cold legs, add | |
| | data sheet. | |
| 5 | Respond to QA Surveillance | 11/07/88 |
| ana tana mangkan di sandera | finding 1-88-15. Change steps 4.1.5, 4.2.2, 4.3.5 add new | |
| and the second has been allowed | 4.1.5, 4.2.2, 4.3.5 add new | |
| and the second se | figures 1 and 2. Add step 4.2.3 per IEN 88-36, commitment 15378 dealing with hot | |
| 6 | Add step 4.2.3 per IEN 88-36, | |
| and distinction of production | commitment 15378 dealing with hot | |
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| ROCEDURE NO | | REVISION | PAGEN | | | | |
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| VEGP | 25270-C | 6 | | 2 of 15 | | | |
| | | | | | | | |
| 1.0 | PURPOSE | | | | | | |
| | This procedu checkout, in Generator No | nre provides instruction and remo ozzle Dams. | ctions for oval of the | the Steam | | | |
| 2.0 | PRECAUTIONS | AND LIMITATIONS | | | | | |
| 2.1 | If only portions of the procedure are required: | | | | | | |
| 2.1.1 | Contact the | Maintenance Forema | n. | | | | |
| 2.1.2 | Use only the | e steps that apply. | | | | | |
| 2.1.3 | Document the "Comple | e steps used in the tion" or "Data" She | "Comments" et. | section of | | | |
| 2.1.4 | N/A the ste | ps that were not us | ed, | | | | |
| 2.2 | Steps in th sequence on | is procedure may be ly: | performed | out of | | | |
| 2.2.1 | With prior | approval of the Mai | ntenance F | oreman. | | | |
| 2.2.2 | If they do | not violate the int | ent of the | procedure. | | | |
| 2.2.3 | Are documented in the "Comments" section of the "Completion" Sheet. | | | | | | |
| 2.3 | Take approp material in | riate action to min | nimize entr | y of foreign | | | |
| 2.3.1 | Steam gener | ator channel head. | | | | | |
| 2.4 | "Safe Work | rering a vessel en Procedures For Clo is followed. | sure Proced sed Vessels | ure 00258-C, And Wet | | | |
| 2.5 | see Procedu | or zones requiring are 00254-C, "Plant s Control". | documented Housekeep: | accountability Ing And | | | |
| 2.6 | Maintain a 20427-C, " Control". | rea cleanliness in Maintenance Cleanli | accordance ness And Ho | with Procedure ousekeeping | | | |

| Fadica INS FRU3.0PREREQ3.1Prior3.1.1Hold P "Data"3.1.2The MW3.2Manway3.3RCS ha place Cleara3.4Ensure tube 13.5Ensure Spaces3.6Ensure "Safe Spaces3.7Ensure days p3.8Ensure tinstal | nce And Tagging". secondary side is eakage to a minim channel head has | ted. IF SO F IATION WORK F IAL CONDITION , notify QC is ed on the "Co s a QC hold p ragms removed mid loop and h Procedure of s drained as um. | FOLLOW THE PERMIT. |
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| 3.6 Ensure "Safe Spaces 3.7 Ensure 3.8 Ensure days p 3.9 Ensure instal | | been draine | d |
| "Safe Spaces 3.7 Ensure 3.8 Ensure days p 3.9 Ensure instal | | Court Grantie | SA 4 |
| 3.8 Ensure days p 3.9 Ensure instal | Work Procedures Fo , Wet Locations an | or Enclosed | r Procedure 00258-C Vessels, Confined |
| days p 3.9 Ensure instal | cleanliness class | s is marked | on MWO. |
| instal | nozzle dams have rior to use. | been hydro | tested within the 9 |
| 4.0 CHECKO | Section 4.1 has lation. | been complet | ed prior to |
| HOME CONTRACTOR | UT, INSTALLATION | AND REMOVAL | |
| 4.1 CHECKO | UT | | |
| 4.1.1 Perfor */* as for | | n hydro test | of the nozzle dam |
| a. 1 | lace nozzle dam o | nto test fix step 4.2.8) | ture and torque to 175 ± 25 ft.1bs. |

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| | | NOT | ES | |
| | | recommen | thru h are ided for fil cture with w | |
| | | from pro fixture overpres | teps may be ovided the t is not ssurized and ely filled. | est |
| | | relief valve fixture. | next to pre | essure gage at top of |
| | | w er supply | | om of test fixture and est inlet valve |
| | d. Clos at b wate | ottom of test | drain valve fixture to | and open inlet valve fill fixture with |
| | | water has fi flow through | | ixturg and begins to valve: |
| | (1) | Close inlet | valve at bo | ttom first. |
| | (2) | Close relief | valve at t | op. |
| | f. Open pres | inlet valve sure to 26 ps | at bottom sig. | s needed to bring |
| | g. Clos | e inlet valve | e and hold p | pressure for 5 minutes. |
| | (1) | Note any los | ss of press | ire on Data Sheet. |
| | h. Oper | bottom drain | n valve. | |
| | i. Open | n top relief | valve. | |
| | | ove nozzle dan any damage. | m from fixt | ure and inspect gasket |
| | | t results are p is less tha | | provided test pressure 5 minutes. |
| 4.1.2 */* | Visually | check for mi | ssing parts | |
| 4.1.3 */* | | ver surface f and obvious w | | fects such as holes, |

| */* 4.1.5 4.1.6 */* 4.1.6 4.1.6 4.1.7 4.1.7 4.1.7 che */* 4.1.8 che */* 4.1.9 che */* to | Hold de retains position prior Bolts will be insert ck retain ely on c ure 1. ck Belle act and ing. ck nozzl separat | ing blocks oned with u to installa #6 and #16 e loose in ion through ning blocks over surface wille washe positioned le dam gaske tions. N Bolt holes s | ill thread in both di pper threa ition. are not to retainer to manway. to ensure te, and are ers to ensure two per bo et for lar OTE may be cle | freely through rections and will be d engaged in the block be engaged but instea to allow easier that they move a oriented as shown on ure that they are olt with convex sides ge cuts, cracks, and |
|---|--|--|--|--|
| $\frac{*/*}{4.1.5}$ $\frac{4.1.5}{fre}$ $\frac{4.1.6}{fre}$ $\frac{4.1.6}{fre}$ $\frac{4.1.7}{fac}$ $\frac{4.1.7}{fac}$ $\frac{4.1.8}{t}$ $\frac{4.1.8}{cle}$ $\frac{4.1.9}{cle}$ | Hold de retains position prior Bolts will be insert ck retain ely on c ure 1. ck Belle act and ing. ck nozzl separat | own bolts w ing blocks oned with u to installa #6 and #16 e loose in ion through ning blocks over surface wille washe positioned te dam gaske ions. N Bolt holes s | ill thread in both di pper threa ition. are not to retainer to manway. to ensure te, and are ers to ensure two per bo et for lar OTE may be cle | rections and will be d engaged in the block be engaged but instea to allow easier a that they move a oriented as shown on ure that they are olt with convex sides ge cuts, cracks, and aned with |
| 4.1.5 Che $\frac{4.1.5}{\frac{1}{\pi}}$ Che $\frac{4.1.6}{\frac{1}{\pi}}$ Che $\frac{4.1.7}{\frac{1}{\pi}}$ Che $\frac{4.1.7}{\frac{1}{\pi}}$ Che $\frac{4.1.8}{\frac{1}{\pi}}$ Che $\frac{4.1.9}{\frac{1}{\pi}}$ Che $\frac{1}{\pi}$ Che | retain: position prior Bolts will bo insert ck retain ely on co ure 1. ck Belle act and ing. ck nozzl separat | ing blocks oned with u to installa #6 and #16 e loose in ion through ning blocks over surface wille washe positioned le dam gaske tions. N Bolt holes s | in both di pper threa ition. are not to retainer to manway. a to ensure te, and are two per bo et for lar OTE may be cle | rections and will be d engaged in the block be engaged but instea to allow easier a that they move a oriented as shown on ure that they are olt with convex sides ge cuts, cracks, and aned with |
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| 4.1.5 Che */* fig 4.1.6 Che */* int fac 4.1.7 Che */* ply 4.1.8 Che */* cle 4.1.9 Che */* cle | will b insert ck retai ely on c ure 1. ck Belle act and ing. ck nozzl separat | e loose in ion through ning blocks over surface ville washe positioned le dam gaske ions. N Bolt holes stainless s | retainer to manway. to ensure te, and are ers to ensure two per bo et for lar OTE may be cle | a that they move a oriented as shown on ure that they are olt with convex sides ge cuts, cracks, and |
| */* fre 4.1.6 Che */* int 4.1.7 Che */* ply 4.1.8 Che */* Che */* fac 4.1.9 Che */* for | ely on c ure 1. ck Belle act and ing. ck nozzl separat | over surface positioned le dam gaske tions. N Bolt holes stainless s | ers to ensu two per bo et for lar OTE may be cle | a oriented as shown on ure that they are olt with convex sides ge cuts, cracks, and |
| <pre>*/* int fac 4.1.7 Che */* ply 4.1.8 Che */* 4.1.9 Che */* to for </pre> | act and ing. ck nozzl separat B | positioned le dam gask tions. N Bolt holes stainless s | two per bo et for lar OTE may be cle | olt with convex sides ge cuts, cracks, and aned with |
| <u>*/*</u> ply <u>4.1.8</u> Che <u>*/*</u> Cle <u>4.1.9</u> Che <u>*/*</u> to fo | separat E | ions. N Bolt holes stainless s | OTE may be cle | aned with |
| <u>*/*</u> Cle <u>4.1.9</u> Che <u>*/*</u> to fo | 5 | Bolt holes stainless s | may be cle | aned with |
| */* Cle 4.1.9 Che */* to fo | 5 | stainless s | may be cle | aned with |
| <u>*/*</u> Cle <u>4.1.9</u> Che <u>*/*</u> to fo | | rotating th | e brush co | by unterclockwise. |
| <u>*/*</u> to fo | | down ring ecessary. | for damage | d or dirty bolt holes. |
| | prevent | erify that separation exceptions: | while har | is bonded to the dam, dling, with the |
| | | asket will s of each i | | nded within 1 to 5 aight edge. |
| b. | The g | asket will | not be bor | nded to the hinge area. |
| 4.2 NO | ZZLE DAM | INSTALLATI | ION | |
| | | 1 | NOTE | |
| | | Cold leg no installed hot leg no: | before ins | must be talling |
| | rify tha en met. | t Prerequi | sites and | Initial Conditions hav |
| | | | | |

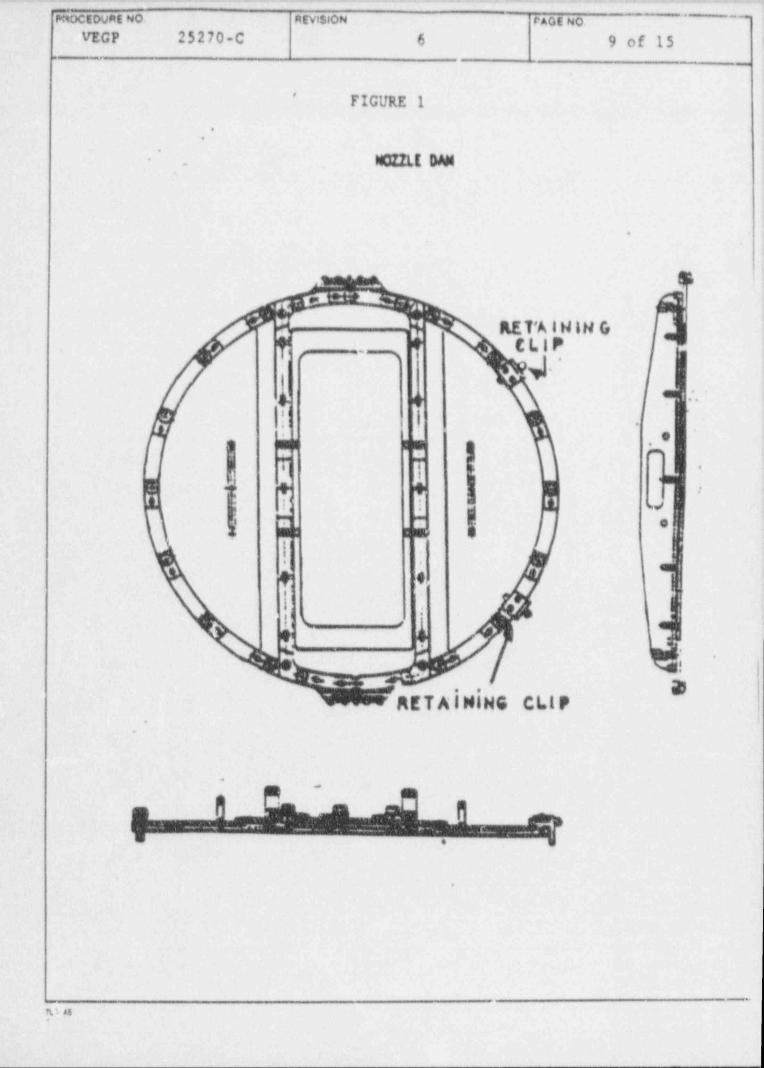
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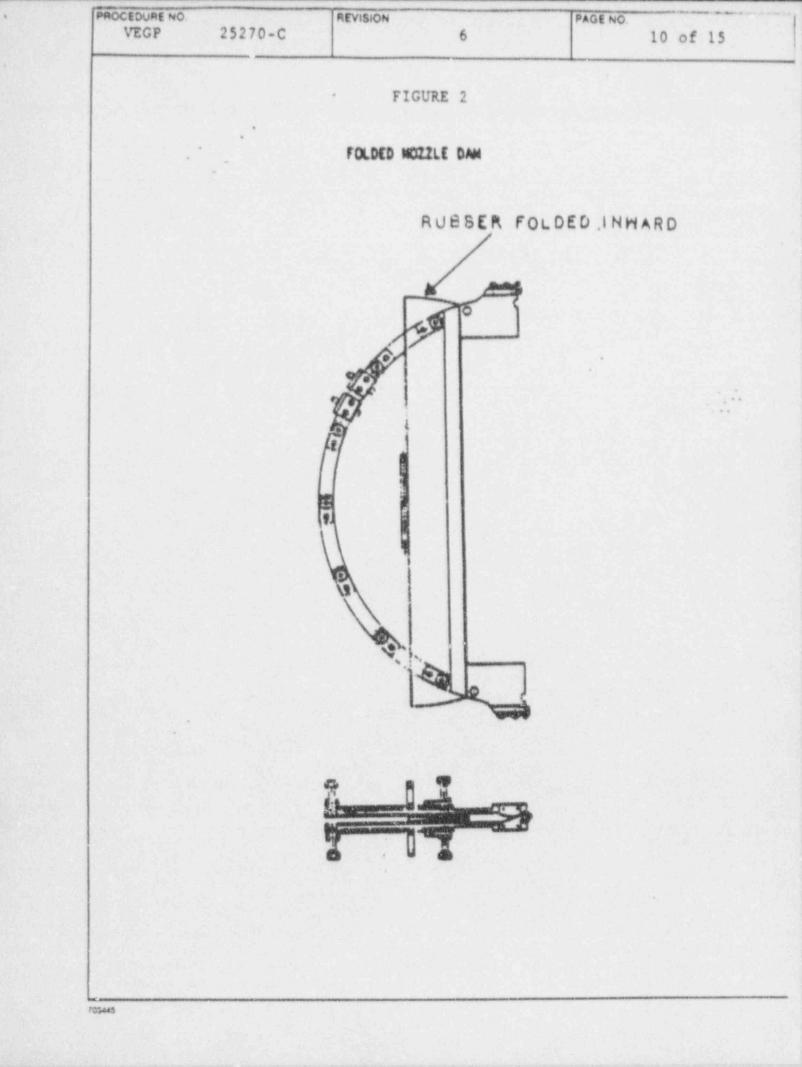
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| | | 6 | | 6 of 15 |
| | and mechanism in a | | | |
| Shif | t Superv | visor of | work to b | e perfort.ed. |
| a ve ing | nt path the hot | for the leg path | hotlegs i hs. (Commi | ls provided prior to ltment 15738) |
| ldin gask | g cover et is fo | as shown | n in figu ward. | ire 2, ensuring |
| | | | | into channel head with hinges up. |
| | r and po a bolt b | | it on hold | d down ring while |
| olts | in hold | es 3, 9, | 13, and 1 | 19 but do not |
| emai | ning bol | lts in f | olding se | ction but do not |
| | piece on on hol | | | o the channel head |
| gage | remain | ing bolt | s in hold | down ring. |
| | | NOTE | | |
| 8 | 11 bolt | s. A se by torg | ary to to al may be uing ever | |
| ig wi | th bolt 75 ± 25 | number ft. 1bs. | 1 and mov overlapp | ing clockwise torque ing back to 1. |
| th a | ill twen | ty bolts | iam is typ torqued, oper insta | only installed only every other illation. |
| | o adjace Figure l | | will be | left untorqued. |
| | | NOTE | | |
| | determin Foreman thicknes | ed by Ma based on s, site | aintenance n gasket condition | |
| | 1 | determin Foreman thicknes | determined by Ma Foreman based on thickness, site | Actual torque is to be determined by Maintenance Foreman based on gasket thickness, site condition and prior experience. |

| PROCEDURE NO VEGP | 25270-C 6 PAGE NO |
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| 4.2.11 */* | Check nozzle dams for leakage immediately following reactor cavity flooding |
| | Some leakage is acceptable provided it c exceed channel head draining capability. |
| 4.3 | NOZZLE DAM REMOVAL |
| | NOTE |
| | Hot leg nozzle dam must be removed before removing cold leg nozzle dam. |
| 4.3.1 */* | Verify that all tools and debris are removed from channel head prior to nozzle dam removal. |
| 4.3.2 */* | Verify that the primary system has been drained to mid loop. |
| 4.3.3 | Loosen all hold down bolts so that they are completely disengaged from the nozzle ring but still retained on the jam. |
| 4.3.4 */* | Verify that all parts are intact and will not fall into the nozzle upon nozzle dam removal. |
| 4.3.5 | Pass center section of the nozzle dam out of the channel head. Fold folding cover as shown in figure 2 ensuring rubber gasket is folded inward. |
| 4.3.6 | Remove the folding cover from the channel head. |
| 4.3.7 */* | Visually check the channel head to ensure that all tools and materials have been removed. |
| 4.4 */* | Notify Shift Supervisor that required maintenance is complete. |
| 5.0 | ACCEPTANCE CRITERIA |
| 5.1 | Maintenance performed using this procedure is acceptable when: |
| 5.1.1 | The "Completion" Sheet is properly filled out. |
| 5.1.2 | Deviations from the procedure data and recommended settings have been reviewed on a case-by-case basis with the Maintenance Foreman. |

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| 5.1.3 | | have been ident the "Completion | | e "Comments" |
| 5.1.4 . | The "Compl | etion" Sheet has | been approv | ved. |
| 5.1.5 | Maintenanc for condit | e Work Orders ha ions evaluated a | ve been wri is needing a | tten and submitted ttention. |
| 6.0 | REFERENCES | | | |
| 6.1 | PROCEDURES | | | |
| 6.1.1 | 20427-C, | "Maintenance Cle Control" | anliness An | d Housekeeping |
| 6.1.2 | 00258-C, | "Safe Work Proce Confined Spaces | dures For E , Wet Locat | inclosed Vessels, tions And Systems" |
| 6.1.3 | 00304-C, | "Equipment Clear | ance And Ta | gging" |
| 6.1.4 | 00254-C, | "Plant Housekeep | oing And Cle | anliness Control" |
| 6.2 | WESTINGHOU | SE PROCEDURES | | |
| 6.2.1 | X6A211-43 | "Steam Generator Instruction Man | r Primary No hual" | zzle Dam |
| 6.2.2 | X6AB11-44 | "Pre-Installation Generator Nozz | on Hydro-Tes le Dam" | t Of Steam |
| 6.2.3 | X6AB11-45 | "Steam Generator Installation/R | r Primary No emoval Proce | ozzle Dam edure" |
| 6.3 | Commitment | 15378 - IEN 88 | -36) | |
| | | | | |

END OF PROCEDURE TEXT





| VEGP 25270-C 6 11 of 11 DATA SHEET 1 DATA SHEET 1 NOZZLE DAM HYDROTEST DATA SHEET 1.0 STATIO TEST The following Nozzle Dams were pressurized and stabilized to 26/psig Pressure loss did not exceed 2 psig in 5 minutes. INITIAL/DATE NITIAL/DATE NITIAL/DATE NITIAL/DATE NITIAL/DATE NITIAL/DATE NOZZLE Dam # | PROCEDURE | NO. | REVISION | and dependence of the Property of the Property of | | PAGE NO. | and the product of the state of |
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| 1.0 STATIO TEST Interfective construction of the state o | VEGP | 25270-C | | 6 | | | 11 of 15 |
| NOZZLE DAN HYDROTEST DATA SHEET 1.0 STATIO TEST The following Nozzle Dams were pressurized and stabilized to 26/psig Pressure loss did not exceed 2 psig in S minutes. INITIAL/DATE INITIAL/DATE NOZZLE Dam # OK | | | | | | | |
| 1.0 STATIC TEST Interfective for the second 2 pairs in 5 minutes. INITIAL/DATE INITIAL/DATE< | | | DATA S | HEET 1 | | | |
| The following Nozzle Dams were pressurized and stabilized to 26/psig Pressure loss did not exceed 2 psig in 5 minutes. INITIAL/DATE INITIAL/DA Nozzle Dam #OK/ Failed/ Nozzle Dam #OK/ Failed/ S.0 SIGE-OFF The Nozzle Dams identified above were hydrotested in accordance with Procedure 25270-C, Any exceptions/problems are noted above. PERSON PERPORMING TEST | | | NOZZLE DAM HYDR | OTEST DA | TA SHEET | | |
| Pressure loss did not exceed 2 psig in 5 minutes. INITIAL/DATE INITIAL/DATE Nozzle Dam # OK / Stom # OK / Stom # OK / Nozzle Dam # OK / Stom # OK / Stom # / / Nozzle Dam # / Stom # | 1.0 | STATIC TEST | | | | | |
| Nozzle Dam # OR / Failed / Sice-OFF The Nozzle Dams identified above were hydrotested in accordance with Procedure 25270-C, Any exceptions/problems are noted above. PERSON PERFORMING TEST | | The following Noz Pressure loss did | zle Dams were p not exceed 2 p | ressuriz sig in 5 | ed and sta minutes. | abilized | to 26/psig. |
| Nozzie Dam # OK / Failed / StGB-OFF | | | | INI | TIAL/DATE | | INITIAL/DATH |
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| Nozzle Dam # OK / Failed / 2.0 COMMENTS/RESOLUTIONS | | Nozzle Dam # | | 0K | 1 | Failed | 1 |
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| Nozzle Dam #OK/ Failed/ 2.0 COMMENTS/RESOLUTIONS | | | | | | | |
| 2.0 COMMENTS/RESOLUTIONS 3.0 SIGE-OFF The Notale Dame identified above were hydrotested in accordance with Procedure 25270-C. Any exceptions/problems are noted above. PERSON PERFORMING TEST | | | | | | | |
| 3.0 SIGE-OFF The Nozzle Dama identified above were hydrotested in accordance with Procedure 25270-C. Any exceptions/problems are noted above. PERSON PERFORMING TEST | | | | | enteren date et ante | | |
| The Nozzle Dame identified above were hydrotested in accordance with Procedure 25270-C. Any exceptions/problems are noted above. PERSON PERFORMING TEST | 2.0 | COMMENTS/RESOLUTI | UNS | | | | |
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| The Nozzle Dame identified above were hydrotested in accordance with Procedure 25270-C. Any exceptions/problems are noted above. PERSON PERFORMING TEST | | Presidential frames and the set of the set | The other fact that the state of the state o | | LE ANDRES STORE AND STORE CAN | | |
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| The Nozzle Dame identified above were hydrotested in accordance with Procedure 25270-C. Any exceptions/problems are noted above. PERSON PERFORMING TEST | 2.0 | STOR ARE | | | | | |
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| VEGP | 25270-C | | 6 | 2.12 | | 11 of 15 |
| | | | | | | |
| | | DATA SHI | ET 1 | | | |
| | | NOZZLE DAM HYDROT | TEST DAT | TA SREET | | |
| 1.0 | STATIC TEST | | | | | |
| | The following Noza Pressure loss did | the Dams were prent | ssurize lg in 5 | ed and st minutes. | abilized | to 26/psig. |
| | | | INI | TIAL/DATE | | INITIAL/DAT |
| | Nozzle Dam # | | 0K | / | Failed | 1 |
| | Nozzle Dam 4 | ter tells, etcalester to tradicate | 0K | 1 | Failed | 1 |
| | Nozzl= Dam # | and the second second second second second second | OK | 1 | Failed | 1 |
| | Nozzle Dam # | | OK | 1 | | 1 |
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| | Nozzle Dam # | | | 1 | | 1 |
| | Nozzle Dam # | | | / | | 1 |
| | Nozzle Dama # | | | 1 | | 1 |
| | Nozzle Dam # | | | 1 | | |
| 2.0 | COMMENTS / RESOLUTIO | | | | 101100 | / |
| | CONTRACTO / RESOLUTION | 785 | | | | |
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| 3.0 | SIGS-OFF | | | | | |
| 3.0 | STOR-OFF | | | | | |
| | The Nozzle Dams in Procedure 25270-C | dentified above w Any exception | were hy s/probl | drotested ems are n | in accor oted abov | dance with ve. |
| | | | | | | |
| | PERSON PERFORMING | TEST | | | | |
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COLD LEG

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COMPLETION SHEET 1

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| PROCEDURI | | REVISION | | SHEET | |
| 25270-C 6 | | | | 1 of | 2 |
| TAG NO. | | DESCRIPTIO | N | | |
| SERIAL NO | | Steam Gene MANUFACTUR | rator Nozzl | | |
| NUMBER IN | | PAROTACIUR | 6 K | COLD | LEG |
| TEST EQUI | IPMENT USED | M&TE [] | Safety Related/QC Hold Po Non-Safety Related | | |
| PROCEDURI | DESCRI | PTION | MAINT. INIT/DATE | HOLD POINT (Yes/No) | QC INIT/DAT |
| 4.1.1 | Pre-installs test | ation hydro | / | | |
| 4.1.2 | Check for mi parts | lssing | | - | / |
| 4.1.3 | Check for de | efects | | | / |
| 4.1.4 | Check hold d | iown bolts | / | | 1 |
| 4.1.5 | Check retain | ing blocks | | - | 1 |
| 4.1.6 | Check Belley washers | ville | / | - | / |
| 4.1.7 | Check gasket | 1. Sec. 1. Sec | / | | / |
| 4.1.8 | Check hold d | lown ring | / | an out any submerse of the | / |
| 4.1.9 | Verify gasks | t bonded | | | / |
| 4.2.1 | Prerequisite | s met | | WATER POWERED AND | 1 |
| 4.2.2 | Notify Shift | Supervisor | / | Process relational data and a | 1 |
| 4.2.10 | Torque to 17 | 75 ± 25 ft-1bs | / | - | 1 |
| 4.2.19 | Check for 1 | eaks | / | | 1 |
| | | | | | |

| PRO | CEDURE NO. VEGP | 25270-C | REVISION | 6 | PAGE NO. | 13 of 15 |
|-----|---------------------|------------------------------|-----------------|---------------------|---------------------------|-----------------|
| | COLD LEG | | COLD | LEG SHEET 1 | Sheet | 2 of 2 |
| | PROCEDURE STEP - | DESCRIP | TION | MAINT. INIT/DATE | HOLD POINT (Yes/No) | QC INIT/DATE |
| | 4.3.1 | Tools and de removed | bris | | | |
| | 4.3.2 | Primary syst drained to p | tem nid loop | | *** | / |
| | 4.3.4 | Verify parts | intact | / | | / |
| | 4.3.7 | Visually che head | eck channel | 1 | | 1 |
| | 4.4 | Notify Shift | t Supervisor | | | 1 |
| | Comments/ | additional ho | old points: | | | 1.1. |
| | | | | | | |
| | QC has re | | | or hold point | | gnature DATE |

VEGP

HOT LEG

| | | HOT LE | G | ALC: 8 V. 8 V | | | |
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| PROCEDURE 25270-C TAG NO. SERIAL NO. TEST EQUIPMENT USED | | REVISION 6 DESCRIPTION | | SHEET 1 of 2 | | | |
| | | | | | | | |
| | | Steam Generator Nozzle Dam MANUFACTURER HOT LEG | | | | | |
| | | | | | | | |
| | | METE [] |] Safety Related/QC Hold Poin] Non-Safety Related | | | | |
| | | PROCEDURE STEP DESCRIP | | TION | MAINT. INIT/DATE | HOLD POINT (Yes/No) | QC INIT/DATE |
| 4.1.1 | Pre-installation hydro test | | / | - | | | |
| 4.1.2 | Check for missing parts | | | | / | | |
| 4.1.3 | Check for defects | | | - | | | |
| 4.1.4 | Check hold down bolts | | / | | / | | |
| 4.1.5 | Check retaining blocks | | | HANN'' TYYYYY I'N KARAN | / | | |
| 4.1.6 | Check Belleville washers | | | | / | | |
| 4.1.7 | Check gasket | | | - | | | |
| 4.1.8 | Check hold do | own ring | | COLOR OF COLOR OF COLOR | / | | |
| 4.1.9 | Verify gasket | t bonded | | - | | | |
| 4.2.1 | Prerequisites met | | | | | | |
| 4.2.2 | Notify Shift Supervisor | | | | / | | |
| 4.2.3 | Ensure vent path | | | - | | | |
| 4.2.9 | Torque to 17 | 5 ± 25 ft-1b | 8/ | - | | | |
| 4.2.10 | Check for leaks | | 1 | - | / | | |

VEG?

HOT LEG

| PROCEDURE | | HOT LEG REVISION | | SHEET | | |
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| 25270-C TAG NC. | | 6 1 of 2 DESCRIPTION | | | <u> </u> | |
| SERIAL NO. TEST EQUIPMENT USED | | Steam Generator Nozzle Dam MANUFACTURER HOT LEG | | | | |
| | | METE [] | Safety Related/QC Hold Poin Non-Safety Related | | | |
| PROCEDURE STF.P | DESCRIPT | ION | MAINT. INIT/DATE | HOLD POINT (Yes/No) | QC INIT/DATE | |
| 4.1.1 | Pre-installation hydro test | | | - | | |
| 4.1.2 | Check for missing parts | | | | | |
| 4.1.3 | Check for defects | | | ***** | | |
| 4.1.4 | Check hold down bolts | | | suppression data diversion of | / | |
| 4.1.5 | Check retaining blocks | | | | / | |
| 4.1.6 | Check Belleville washers | | | | / | |
| 4.1.7 | Check gasket | | | | 1. | |
| 4.1.8 | Check hold do | wn ring | | - | | |
| 4.1.9 | Verify gasket | bonded | | - | / | |
| 4.2.1 | Prerequisites met | | | www.combination.org.up | / | |
| 4.2.2 | Notify Shift Supervisor | | | ak starter procession dates | | |
| 4.2.3 | Ensure vent p | mach | | - | | |
| 4.2.9 | Torque to 175 | 5 ± 25 ft-1bs | | | | |
| 4.2.10 | Check for leaks | | / | | 1 | |

| CEDURE NO. VEGP | 25270-C | REVISION | 6 | PAGE NO. | 15 of 15 |
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| HOT LEG | | COMPLETE SI | HEET 1 | | |
| PROCEDURE STEP | DESCRIP | TION | MAINT. INIT/DATE | HOLD POINT (Yes/No) | QC INIT/DATE |
| 4.3.1 | Tools and de removed | bris | | | / |
| 4.3.2 | Primary system drained to mid loop | | | | |
| 4.3.4 | Verify parts | intact | | | |
| 4.3.7 | Visually check channel head | | | | / |
| 4.4 | Notify Shift | Supervisor | / | | / |
| | | | | | |
| | an a | | | | an P. Commission of the Annual Construction of the Annual Constru |
| QC has re APPROVEL |) () DISAPP | ROVED () | COMPLETED | Sig | mature DATE |