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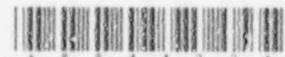
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MP 722.2, CH1	9	1

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Procedure and Form Change Request

(Sheet 1 of 1)

Section 1: Change Initiation Information

Document No.: MP 722.2

Revision No. 9 Change No. 1

Title: Overhaul of Worthington Service Water Pumps

Initiated By: T. McNerney

Change Type: Intent ☒ Non Intent ☐

Reason:

To increase the amount of material that can be removed from the tension bearing shoulder.

One Time Change? YES ☐ NO ☒
OTC requires expiration date or condition

Expiration Date or Condition:

Removed Date:

Section 2: Instructions for Entering Change

Replace pages 38, 46, and 58.

Section 3: Non-Intent Change Interim Approval

Section 3a. Approved by SORC or PORC Member or First Line Supervisor

Signature: _____

Date: _____

Interim Approval

Section 3b. Approved by Shift Manager or SRO Licensed on Unit

Signature: _____

Date: _____

Section 4: Reviews

QA Reviewer Signature: (if required) _____

Date: _____

Independent Reviewer Signature: B. S. S.

Date: 7/17/97

No comments ☒ Attachment 10 from DC 3 not required

→ Safety Evaluation Required?

YES ☐ NO ☒

→ Environmental Review Required?

YES ☐ NO ☒

If either question is answered "YES,"
PORC or SORC review is required.

Section 5: Review and Approval

PORC or SORC
Review Required?

YES ☒ NO ☐

Department Head or Responsible

Individual Signature: B. S. S.

Date: 7/18/97

(Common Department Procedures require
each affected Department Head's signatures)

Date: _____

Date: _____

Section 6: APPROVAL

PORC or SORC

Chairperson Signature: B. S. S.

Meeting Number: 1-97-110

Approval Date: 7-18-97

Effective Date:

7-18-97

DC1 Att 5 Rev 5 (06-03-97)

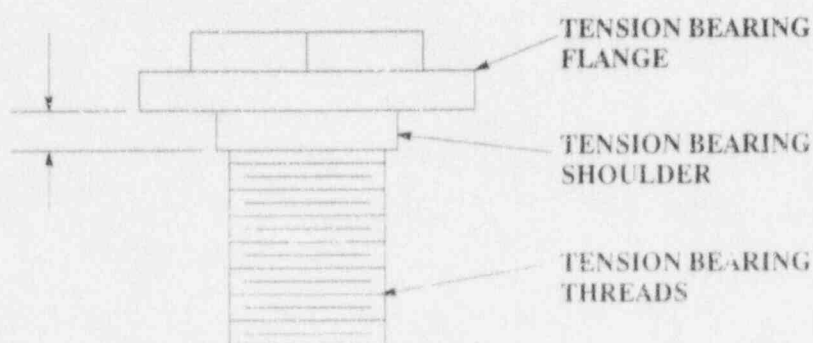
Station Admin Procedures Group OSCAR Report

NOTE

1. Machining of the column pipe flange faces reduces the overall length of the assembled column pipes. This causes the tension bearing shoulder or tension bearing threads to bottom out in the shaft enclosing tube before the tension bearing flange makes adequate contact with the stuffing box flange face. The tension bearing, stuffing box bore, and shaft enclosing tube internal threads must be measured to ensure that the tension bearing can make adequate contact. If necessary, the tension bearing must be machined.
2. The tension bearing can be machined in one of two ways, depending on the location of the interference: the lower end of the tension bearing threads can be machined up to 0.500 inch, or the shoulder above the threads can be machined up to 0.250 inch.

4.5.66 Refer To Figure – 1, and MEASURE dimension between bottom of tension bearing flange and top of tension bearing threads.

Figure – 1. Tension Bearing Contact Check Measurement



4.5.67 MEASURE dimension between top of stuffing box flange and top of shaft enclosing tube.

4.5.68 IF dimension between bottom of tension bearing flange and top of tension bearing threads is *greater than* dimension between top of stuffing box flange and top of shaft enclosing tube, Refer To Attachment 5, and MACHINE tension bearing shoulder *no more than* ~~0.250 inch.~~
0.500 inch.

4.5.69 MEASURE dimension between bottom of tension bearing flange and bottom of tension bearing threads.

Level of Use
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- 6.6.2 Procedure Change Request tracking No. 026, from Unit 1 Maintenance Engineer J. Law
- 6.6.3 Action Request (A/R) 96005504, "Revise MP722.2 to Overhaul all Service Water Pumps as QA"
- 6.6.4 Design Change Notice (DCN) DM1-S-0967-96 "Removal of Additional Upper Column Torque Support/Spider from Service Water Spare Pump"
- 6.6.5 Design Change Notice (DCN) DM1-00-0399-97 "Upper Spider for Service Water Spare Pump and As-Built Features"
- 6.6.6 Design Change Notice (DCN) DM1-00-1267-96 "SWS Pump M4-7B/C/D/Spare Tension Bearing Modification"
- 6.6.7 Design Change Notice (DCN) DM1-00-1266-96 "Lubricating Water Supply Tubing to Tension Nut on Service Water Pump M4-7C & 7D"
- 6.6.8 Design Change Notice (DCN) DM1-01-1267-96 "SWS Pump M4-7B/C/D/Spare Tension and Lineshaft Bearing Modifications"
- 6.6.9 Minor Modification MMOD M1-97547, "Service Water Pump Modifications"
- 6.6.10 Engineering Record Correspondence ER-96-0114, "Temporary Removal of SW Pumps A,B,C, or D."
- 6.6.11 Design Change Notice (DCN) DM1-02-1267-96 "SWS Pumps M4-7B/C/D/Spare - Tension Bearing Modifications" «7/16/97»

7. SUMMARY OF CHANGES

- 7.1 Interim changes 1 and 2 were incorporated. Change 1 added the requirement that the PE department verifies the as-left impeller end play dimension. Change 2 added the requirement to weld all spider adjusting bolts.
- 7.2 The name and scope of this procedure were changed to cover only the Worthington model service water pumps.
- 7.3 Added requirement to cover all pumps as QA per A/R 96005504.
- 7.4 Tension bearing breakaway torque measurement was added.

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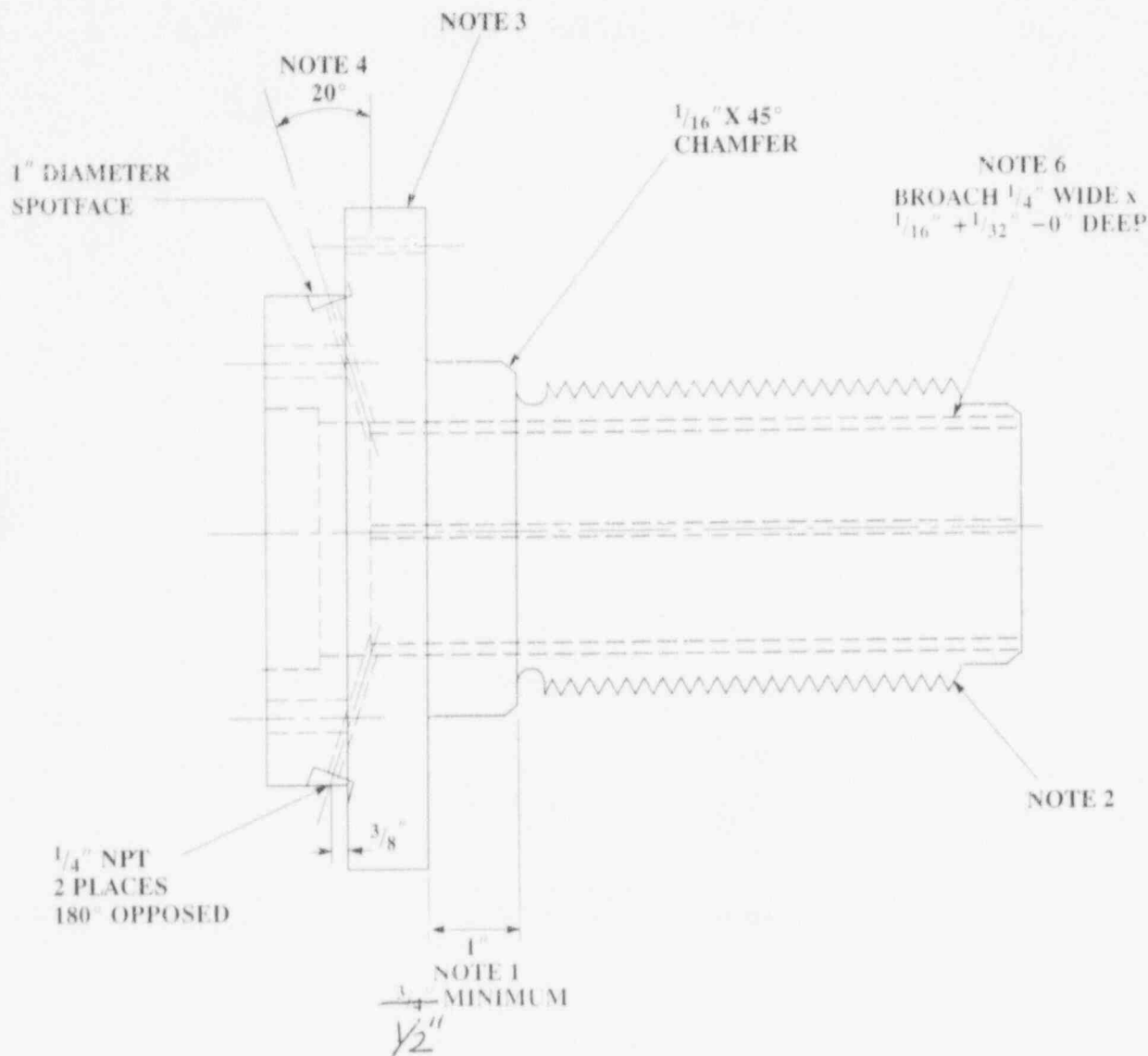
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Attachment 5 Tension Bearing Modification Detail

(Sheet 1 of 2)



NOTES

1. TRIM AS REQUIRED (1/4" MAXIMUM) TO ENSURE TENSION BEARING PRELOAD IS OBTAINED PRIOR TO BOTTOMING OUT ON TOP SHAFT ENCLOSING TUBE. (AMOUNT VARIES DEPENDING ON PUMP COLUMN LENGTHS). MACHINE CHAMFER AFTER TRIMMING.
2. TRIM THREADS AS REQUIRED (1/2" MAXIMUM) TO ENSURE TENSION BEARING PRELOAD IS OBTAINED PRIOR TO BOTTOMING OUT ON SHAFT ENCLOSING TUBE INTERNAL THREADS.
3. SKIM OD TO OBTAIN CONCENTRIC SURFACE AS REQUIRED FOR DIAL INDICATOR DURING COUPLING ALIGNMENT.
4. THESE DIMENSIONS ARE NOT CRITICAL. THE DIMENSIONS SHOWN ARE APPROXIMATIONS.
5. THIS HOLE IS FOR THE INSTALLATION OF A SETSCREW USED FOR PUMP ALIGNMENT.
6. BROACH FOUR FULL LENGTH WATERWAY KEYSLOTS 90° APART. SPECIAL BROACH IN UNIT 1 MAINTENANCE SHOP.

Level of Use
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STOP

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