

Category H, APIH, Hamy Carl A : PRODUCTION PROCEDURE COVER SHEET

#238-3

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Procedure No.		Dated	Revision No.		
SP 504		Sept. 26, 1979	-0-		

TITLE:

FABRICATION - BISCO FLEXIBLE BOOT

SUBJECT: METHOD OF LAY-OUT AND FABRICATION OF THE BISCO

FLEXIBLE BOOT

SCOPE OF CURRENT REVISION:

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	Original Issue	Rev. I	Rev. 2	Rev. 3	Rev. 4	Rev. 5	Rev. 6
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Information in this record was deleted

in accordance with the Freedom of Information

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1.0 PURPOSE

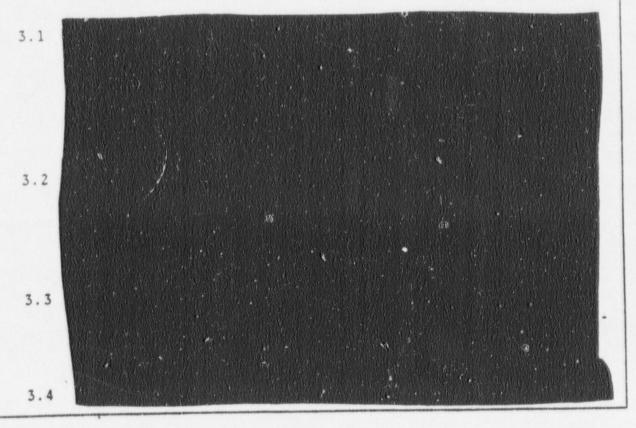
1.1 To establish the standard methods for the fabrication and handling of BISCO flexible boots.

2.0 SCOPE

2.1 Provide the method and criteria for the fabrication, storage and shipping of BISCO Flexible Boots with assembly hardware.

3.0 APPLICABLE MATERIALS

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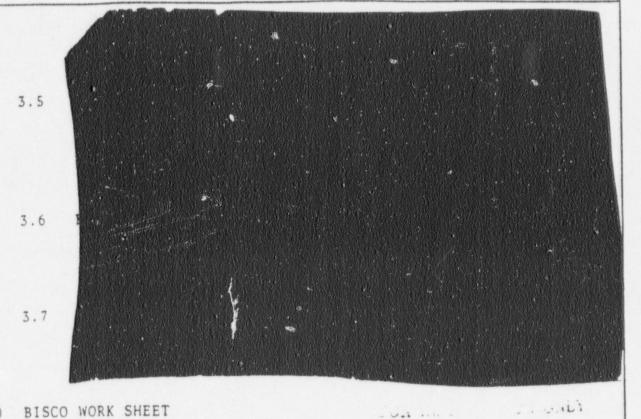


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BISCO WORK SHEET 4.0

- For applications in the English System, utilize 4.1 Forms FB-1, FB-2 and FB-3.
- 4.2 For applications in the Metric System, utilize Forms FB-1A, FB-2A and FB-3.
- 4.3 *For Flexible Radiation Penetrations Seals, utilize Form FB-IRC (English System) or Form FB-IRA (Metric System).

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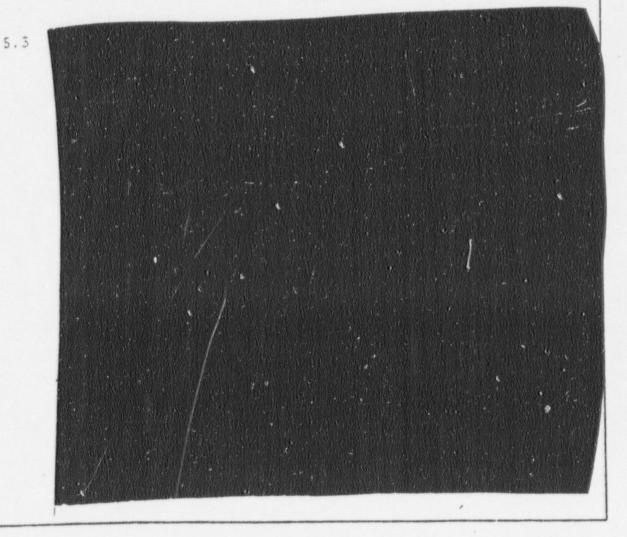


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5.0 BOOT FABRICATION

- 5.1 The fabrication of BISCO Flexible Boots shall be in accordance with established BISCO formulations and methods.
- 5.2 The tabulation of necessary measurements shall be in accordance with customer specifications and requirements.



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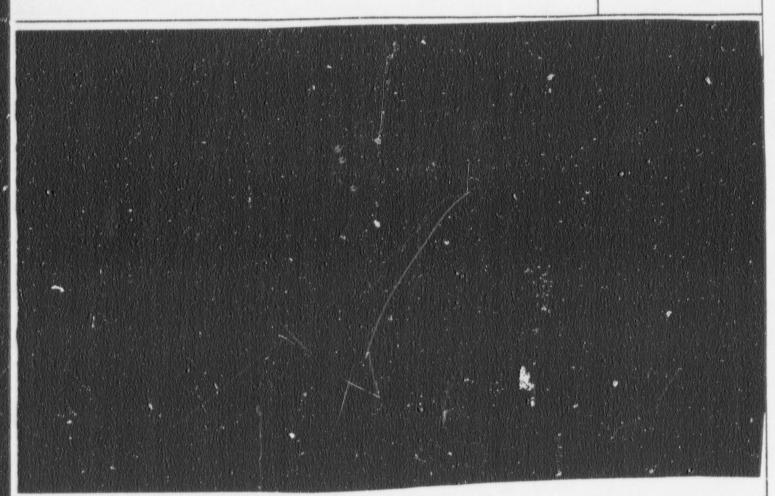


- The BISCO Flexible Boot Work Sheet, From FB-1 shall be 5.5 completed.
 - 5.5.1 The BISCO Form FB-1 shall be checked/verified prior to the cutting operation.

5.6

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BISCO Flexible Boot Work Sheet, From FB-1 shall be pleted.

.1 The BISCO Form FB-1 shall be checked/verified prior to the cutting operation.



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TITL	.E:	FABRICATION - BISCO FLE	XIBLE BOOT	SP- 504			
5.0 ASSEMBLY HARDWARE							
	6.1	BISCO Clamps	The type and quar for the two diame boot shall be det BISCO chart FB-2, Requirements".	eters of each termined. Utilize			
	6.2	BISCO Sealants and Cements	The type and quar sealants/cements termined by BISCO required by the of fications for each tion. See BISCO Procedure SP-505	shall be de- management as customers speci- ch boot installa- Installation			
	6.3	BISCO Bolt-on-Flanges	Unless otherwise customer shall pomounting flanges tion. If supplicedure SP 505-A.	rovide installed for boot applica-			
7.0	STOR	AGE REQUIREMENTS					

7.1 Fabricated BISCO Boots and associated assembly hardware

shall be stored in their original containers in an enclosed area protected from the environmental elements.



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Where applicable, sealants and cements shall be stored 7.2 in their original unopened containers at or below 90F (32 C) and shall have a shelf life as indicated in the original manufacturers specifications.

8.0 SHIPPING AND IDENTIFICATION

8.1 Shipping

All material to be shipped to site shall be packaged utilizing standard packaging and adequately protected from environmental contamination, damage and loss in transit.

8.2 Identification

All material identification shall be accomplished by use of labels, stamping, stenciling, printing or tagging. All marking shall be clear.

- 8.2.1 The identification/coding of material shall be cross-referenced on the BISCO shipping list which shall be enclosed with the shipment.
- 8.2.2 All identification/coding of material shall conform, if applicable, to customers contractual requirements.

END OF TEXT