



Category 14, AP14, Item 4 *Cart A*
PRODUCTION
PROCEDURE COVER SHEET

#238-3




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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BISCO APPROVAL SIGNATURES							
	Original Issue	Rev. 1	Rev. 2	Rev. 3	Rev. 4	Rev. 5	Rev. 6
Author	 F.J. BARTA						
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Page 1 of 8

K-301



PRODUCTION PROCEDURE

TITLE: FABRICATION - BISCO FLEXIBLE BOOT

SP - 504

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

FOR INFORMATION ONLY

3.1

3.2

3.3

3.4



TITLE: FABRICATION - BISCO FLEXIBLE BOOT

SP - 504

3.5

3.6

3.7

4.0 BISCO WORK SHEET

4.1 For applications in the English System, utilize 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).



PRODUCTION PROCEDURE

TITLE: FABRICATION - BISCO FLEXIBLE BOOT

SP - 504

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.

5.3





PRODUCTION PROCEDURE

TITLE: FABRICATION - BISCO FLEXIBLE BOOT

SP - 504

5.4



5.5 The BISCO Flexible Boot Work Sheet, Form FB-1 shall be completed.

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

5.6



PRODUCTION PROCEDURE

LOCATION - BISCO FLEXIBLE BOOT

SP - 504

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

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



PRODUCTION PROCEDURE

TITLE: FABRICATION - BISCO FLEXIBLE BOOT

SP - 504

5.0 ASSEMBLY HARDWARE

6.1 BISCO Clamps

The type and quantity of ~~clamps~~ ^{ONLY} for the two diameters of each boot shall be determined. Utilize BISCO chart FB-2, "Boot Clamp Size Requirements".

6.2 BISCO Sealants and Cements

The type and quantity of BISCO sealants/cements shall be ~~de-~~ ^{ONLY} termined by BISCO management as required by the customers specifications for each boot installation. See BISCO Installation Procedure SP-505.

6.3 BISCO Bolt-on-Flanges

Unless otherwise specified, the customer shall provide installed mounting flanges for boot application. If supplied, see Procedure SP 505-A.

7.0 STORAGE 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.



PRODUCTION PROCEDURE

TITLE: FABRICATION - BISCO FLEXIBLE BOOT

SP - 504

- 7.2 Where applicable, sealants and cements shall be stored 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