RELEASE AUTHORIZATION

Document Number: WHC-SD-WM-WP-289, REV.0

Document Title: Engineering Work Plan for Container Venting System
Drill Press Assembly Troubleshooting

Release Date: October 7, 1994

* * * * *

This document was reviewed following the
procedures described in WHC-CM-3-4 and is:

APPROVED FOR PUBLIC RELEASE

* * * * *

WHC Information Release Administration Specialist:

Jamara Kohn for Chris Willingham

C. Willingham
(Signature)

October 7, 1994
(Date)

MASTER

A-6001-400 (07/94) WEF256

DISTRIBUTION OF THIS DOCUMENT IS UNLIMITED

Engineering drawings for this project
are identified as CAPE-3103.
Inquiries may be directed to:

Office of Scientific and
Technical Information
P. O. Box 62
Oak Ridge, TN 37831

SUPPORTING DOCUMENT		1. Total Pages 10
2. Title Engineering Work Plan for Container Venting System Drill Press Assembly Troubleshooting		3. Number WHC-SD-WM-WP-289
		4. Rev No. 0
5. Key Words Container Venting System, Drill Press, Press Plate		6. Author Name: M. C. Prather <i>M. C. Prather</i> 10/6/94 Signature Organization/Charge Code 8D250/A1E53
<p>10/7/94 CW APPROVED FOR PUBLIC RELEASE</p>		
7. Abstract A drill press assembly has been fabricated for the Container Venting System (CVS). The drill bit assembly has bound in the press plate in previous revisions of this design. This work plan is for troubleshooting the current drill press to ensure that it doesn't bind.		
<p>8. PURPOSE AND USE OF DOCUMENT - This document was prepared for use within the U.S. Department of Energy and its contractors. It is to be used only to perform, direct, or integrate work under U.S. Department of Energy contracts. This document is not approved for public release until reviewed.</p> <p>PATENT STATUS - This document copy, since it is transmitted in advance of patent clearance, is made available in confidence solely for use in performance of work under contracts with the U.S. Department of Energy. This document is not to be published nor its contents otherwise disseminated or used for purposes other than specified above before patent approval for such release or use has been secured, upon request, from the Patent Counsel, U.S. Department of Energy Field Office, Richland, WA.</p> <p>DISCLAIMER - This report was prepared as an account of work sponsored by an agency of the United States Government. Neither the United States Government nor any agency thereof, nor any of their employees, nor any of their contractors, subcontractors or their employees, makes any warranty, express or implied, or assumes any legal liability or responsibility for the accuracy, completeness, or any third party's use or the results of such use of any information, apparatus, product, or process disclosed, or represents that its use would not infringe privately owned rights. Reference herein to any specific commercial product, process, or service by trade name, trademark, manufacturer, or otherwise, does not necessarily constitute or imply its endorsement, recommendation, or favoring by the United States Government or any agency thereof or its contractors or subcontractors. The views and opinions of authors expressed herein do not necessarily state or reflect those of the United States Government or any agency thereof.</p>		<p>10. RELEASE STAMP</p> <div style="border: 1px solid black; padding: 5px; text-align: center;"> OFFICIAL RELEASE BY WHC DATE OCT 07 1994 <i>Sta 6</i> </div>
9. Impact Level Q		

DISCLAIMER

Portions of this document may be illegible in electronic image products. Images are produced from the best available original document.

WHC-SD-WM-WP-289
Revision 0

ENGINEERING WORK PLAN
FOR CONTAINER VENTING SYSTEM
DRILL PRESS ASSEMBLY
TROUBLESHOOTING

October 1994

M. C. Prather

Westinghouse Hanford Company
P.O. Box 1970
Richland, Washington 99352

Engineering drawings for this project
are identified as CAPE-3103
Inquiries may be directed to:

Office of Scientific and
Technical Information
P. O. Box 62
Oak Ridge, TN 37831

CONTENTS

1.0	INTRODUCTION	3
2.0	SCOPE	3
2.1	OBJECTIVES	3
2.2	DELIVERABLES	3
3.0	DESCRIPTION	3
3.1	PHYSICAL DESCRIPTION	3
3.2	ENGINEERING TASKS	4
3.3	VERIFICATION	4
3.4	PROCUREMENT TASKS	4
4.0	ORGANIZATION	4
5.0	SCHEDULE	5
6.0	COST ESTIMATE	5
7.0	QUALITY ASSURANCE	5
8.0	REFERENCES	5
APPENDIX A		A-1

**ENGINEERING WORK PLAN
FOR CONTAINER VENTING SYSTEM
DRILL PRESS ASSEMBLY
TROUBLESHOOTING**

1.0 INTRODUCTION

A drill press assembly has been fabricated for the Container Venting System (CVS). The drill bit assembly has bound in the press plate in previous revisions of this design. This work is to troubleshoot the current drill press to ensure that it doesn't bind.

2.0 SCOPE

2.1 OBJECTIVES

While the exact resolution is not known, the drill press will be modified as needed in order to operate it without binding. This will include assembling the drill press and evaluating the fit, correcting the fit as necessary, and operating the drill to verify that it does not bind.

2.2 DELIVERABLES

The deliverables are the modified drill press and an Engineering Change Notice (ECN) to the design documents showing the as-built system.

3.0 DESCRIPTION

3.1 PHYSICAL DESCRIPTION

The drill press is shown on Drawing H-2-821681, Rev. 1, as modified by ECNs 186913 and 186914, with the exception that the press plate 1.000 diameter hole true position is .003 instead of .001 (NCR 052108). A copy of H-2-821681 (with ECN changes redlined and identified by ECN number) is included as an attachment to this work plan and is marked "development control." The drawing will be redlined during the troubleshooting process as parts are modified in accordance with Westinghouse Hanford Company Controlled Manual WHC-CM-6-1, Engineering Practice EP-2.4, Development Control Requirements. Once the troubleshooting is complete and the drill press operates without binding, the drawing will be revised by ECN to reflect the design changes.

3.2 ENGINEERING TASKS

WHC Engineering shall perform the following engineering tasks:

- . Direct the operation of the drill press.
- . Sign and date next to each redline change of the development control drawing, prior to fabrication of new parts or modification of the existing drill press assembly.
- . Revise the design documents by ECN to reflect the design changes.

3.3 VERIFICATION

ICF Kaiser Hanford Company Quality Control (QC) will verify dimensions as needed during the course of the troubleshooting to assist in as-building. QC will perform a final dimensional inspection of the modifications (using the redlined development control drawing as the reference).

Quality Assurance (QA) verification of operation of the drill press assembly is not required, since this is development work. An operational test procedure (Simmons 1994) will be performed on the final CVS system, at which time QA will verify operation of the drill press assembly.

3.4 PROCUREMENT TASKS

The existing drill press assembly as described in Section 3.1 will be provided by WHC. The air supply (max 90 PSI) and fittings to run the drill will be provided by the shop. During troubleshooting, additional materials may be required. Procurement responsibilities will be determined at that time. Work Order E20027 includes \$500.00 for the shop to use for material if needed.

4.0 ORGANIZATION

The cognizant engineer for this work is M. C. Prather. The cognizant manager is E. J. Renkey.

Operation of the drill press and fabrication of prototype parts will be performed at the 200W Area ICF Kaiser Hanford Company Fabrication Shop under the direction of WHC Engineering. The shop contact is the manager, J. L. Poe. Shop work will be performed under Fabrication Request J-10 MCP-9/29/94.

5.0 SCHEDULE

It is estimated that this work will be complete by October 25, 1994..

6.0 COST ESTIMATE

The ICF Kaiser Hanford Company work is under Work Order E20027. The authorized amount is \$4000.00 (including \$500.00 for materials).

WHC Engineering support will be under Work Order A1E53, which is being used for cognizant engineering support for development and testing of the entire CVS system.

7.0 QUALITY ASSURANCE

This work plan and the J-10 fabrication request have a Q approval designator. Modifications to prevent jamming will not affect the safety function or margin of safety (the press plate and adaptors themselves do not perform a safety function). The J-10 fabrication request will designate this work safety class 3.

8.0 REFERENCES

Simmons, C. C., 1994, *Operability Test Procedure for Container Venting System, CH-TRU Waste Characterization Program*, WHC-SD-WM-OTP-125, Westinghouse Hanford Company, Richland, Washington.

APPENDIX A