RELEASE AUTHORIZATION

Document Number: WHC-SD-TP-WP-001, Rev. 0

Document Title: CNS 1-13G Cask Lid Support Work Plan

Release Date: 2/17/95

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WHC Information Release Administration Specialist:

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2/17/95

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SUPPORTING DOCUMENT

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1. Total Pages **67**

2. Title

CNS 1-13G Cask Lid Support Work Plan

3. Number

WHC-SD-TP-WP-001

4. Rev No.

0

5. Key Words

K Basins
Work Plan

6. Author

Name: S. R. Crow

S.R. Crow 2/15/95

Signature

Organization/Charge Code W84100

E16856
LHB

7. Abstract

N/A

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8. RELEASE STAMP

OFFICIAL RELEASE 21 BY WHC DATE FEB 17 1995 <i>Sta: 21</i>
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CNS 1-13G CASK LID SUPPORT WORK PLAN

MASTER

February 16, 1995
S. R. Crow
Packaging Engineering

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1.0 WORK DESCRIPTION

This work plan covers fabrication and load testing of one CNS 1-13G Cask Lid Support Frame, per the attached drawing.

2.0 SPECIAL CONDITIONS

The support frame is considered to be developmental equipment and as such may be fabricated in accordance with the engineering requirements and responsibilities identified in WHC-CM-6-1, Standard Engineering Practices, EP-2.4 "Development Control Requirements."

3.0 WORK ORDER NUMBER

Work Order E37282 in the amount of \$3500 has been issued to fund this work. Overtime, as necessary, has been authorized to ensure that the support frame will be delivered within the requested schedule.

4.0 INSPECTION/FABRICATION/TESTING CRITERIA

The support frame shall be fabricated, inspected, and tested in accordance with DOE-RL-92-36, Hanford Site Hoisting and Rigging Manual, Section 11.0 "Below-the-Hook Lifting Devices." All welds shall be visually inspected, per AWS D1.1. All load bearing welds shall be magnetic particle inspected before and after load testing, per AWS D1.1. The support frame shall be load tested to 125 percent of rated capacity (rated capacity is 2400 pounds). To do the load test on the frame, pick the frame with the 3000-pound load attached and then set it down on something to support the weight at the four ends of the W4 X 13 Beams. This is the point where the frame with the lid attached will be supported in the loadout chute area.

The 1-inch shackle shown on the development control drawing, has a SWL of 17,000 pounds and will need to be load tested at 34,000 pounds since this is part of a Critical Lift at the K Basin. This will be performed by the K Basin riggers and will be supplied before the support frame load test.

5.0 MATERIAL REQUIREMENTS

Materials shall meet the requirements for Safety Class 3, approval designator SQ. CMTR's are required for all materials. Materials will be provided by WHC. The point of contact for the materials is T. A. Delucchi, 376-3116.

6.0 DELIVERY DATE

A final acceptance and load test is required by February 24, 1995. WHC will provide a released as-built drawing of the support frame by February 22, 1995 to allow final acceptance to occur prior to the completion date.

7.0 WHC CONTACTS

Technical direction for the effort shall be provided by S. R. Crow (376-5388). Load-test direction will also be provided by A. R. Shearer (373-4874).

8.0 DELIVERY INSTRUCTIONS

The completed support frame with documentation shall be delivered to J. J. Jernberg at the K Basins (Bldg. 190K), 373-5790.

F

E

D

C

B

A

EXISTING ALIGNMENT PINS
(2 PLCS)

LIFTING FIXTURE
SEE DETAIL

ANCHOR SHACKLE
McMASTER-CARR
#3558T54 OR EQUAL

EXISTING SHIPPING CASK
CHEM-NUCLEAR SYSTEMS
MODEL #1-13G

1" CHAMFER
(2 PLCS)

Ø1/2" THRU

DETAIL "A"

SCALE 1/4"

LIFTING ARRANGEMENT

SCALE 1 1/2" = 1'-0"