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Project Title/Work Order Acceptance Test Procedure, 241-SY-101 Flexible Receiver System, Phase I Testing		Date 1/23/95
		EDT No. 609851
		ECN No. NA

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2. To: (Receiving Organization) See Distribution List		3. From: (Originating Organization) Nuclear Analysis and Characterization		4. Related EDT No.: NA	
5. Proj./Prog./Dept./Div.: 241-SY-101		6. Cog. Engr.: G. A. Ritter		7. Purchase Order No.: NA	
8. Originator Remarks: See attached Acceptance Test Report for the 241-SY-101 Flexible Receiver System Phase I Testing for your approval.				9. Equip./Component No.: NA	
				10. System/Bldg./Facility: 241-SY-101	
11. Receiver Remarks:				12. Major Assm. Dwg. No.: NA	
				13. Permit/Permit Application No.: NA	
				14. Required Response Date: ASAP	

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1	1	Cog. Eng.	GA Ritter	1/27/95	H0-38	OSTI	(2)	1/27/95	L8-07		
1	1	Cog. Mgr.	CE Hanson	1/27/95	H5-09						
1	1	QA	ML McElroy	1/27/95	S1-57						
1	1	Safety	LS Krogsrud	1/27/95	R3-08						
		Env.									
		Proj/Prog.									
1	1	Other	MJ Ostrom	1/27/95	H5-68						

18. Signature of EDT Originator G. A. Ritter 1/27/95		19. Authorized Representative Date for Receiving Organization C. E. Hanson 1/27/95		20. Cognizant/Project Engineer's Manager H. Toffer 1/27/95		21. DOE APPROVAL (if required) Ltr. No. ☐ Approved ☐ Approved w/comments ☐ Disapproved w/comments	
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RELEASE AUTHORIZATION

Document Number: WHC-SD-WM-ATR-091, Rev. 0

Document Title: Acceptance Test Report, 241-SY-101 Flexible Receiver System, Phase I Testing

Release Date: 2/06/95

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

APPROVED FOR PUBLIC RELEASE

WHC Information Release Administration Specialist:

V. L. Birkland
V.L. Birkland

2/6/95

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SUPPORTING DOCUMENT		1. Total Pages 13
2. Title Acceptance Test Report, 241-SY-101 Flexible Receiver System, Phase I Testing	3. Number WHC-SD-WM-ATR-091	4. Rev No. 0
5. Key Words Phase I mitigation retrieval system 241-SY-101 leak test flexible receiver	6. Author Name: G. A. Ritter Signature Organization/Charge Code 8D520/N2B2K	
7. Abstract This report summarizes the results of the leak testing of the 241-SY-101 Flexible Receiver System Containment Bag performed at the bag manufacturer's facility. This acceptance test verified the sealing integrity of the containment bag to ensure that release of waste and aerosols will be minimized during the removal of the test mixer pump from tank SY-101.		
		8. RELEASE STAMP OFFICIAL RELEASE 38 BY WHC DATE FEB 06 1995

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**ACCEPTANCE TEST REPORT
241-SY-101 FLEXIBLE RECEIVER SYSTEM
PHASE I TESTING**

1.0 INTRODUCTION

This document summarizes the results of the phase I acceptance test of the 241-SY-101 Flexible Receiver System (FRS). This acceptance test consisted of a pressure-decay/leak test of the containment bag to verify that the seams along the length of the bag had been adequately sealed. The sealing integrity of the FRS must be verified to ensure that the release of waste and aerosols will be minimized during the removal of the test mixer pump from Tank 241-SY-101. The FRS is one of six major components of the Equipment Removal System, which has been designed to retrieve, transport, and store the mixer pump. This test encompasses test requirements for the Phase I test as defined in WHC-SD-WM-TP-257, *Test Plan for Qualification Testing of the 241-SY-101 Flexible Receiver System*.

This acceptance test was performed at Lancs Industries in Kirkland, Washington on January 17, 1995. The test was witnessed by a WHC Quality Assurance representative and the FRS cognizant engineer. Funding for this test was provided by the 101-SY Hydrogen Mitigation Program.

2.0 DESCRIPTION OF TEST

This acceptance test consisted of a pressure-decay/leak test of the containment bag during the fabrication phase to demonstrate that the seams along the length of the bag have been adequately sealed. The acceptance criteria for the test is that the bag pressure shall remain above 75% of the initial pressure of 2,500 Pa (10 inches H₂O) for 1 hour.

To prepare the bag for the leak test, the ends of the bag were fabricated approximately 0.6 m (2 feet) longer than the final bag length. Long metal bars were used to roll up the ends of the bag and clamps were attached to secure the metal bars in place and form a seal. A calibrated pressure gage was connected to an inflation/deflation valve on one end of the bag and the bag was inflated to 2,500 Pa (10 inches H₂O). A calibrated thermometer was then attached to the center of the bag and the pressure inside the bag was allowed to stabilize for 3 - 4 hours.

The initial time, pressure and temperature were recorded and the inflated bag was allowed to sit for 1 hour. At the end of 1 hour, the pressure and temperature were recorded and the results were evaluated using a temperature compensation factor of +/- 200 Pa (0.8 inches H₂O) for every 0.6 °C (1 °F) of temperature gain/loss. The test procedure given in Appendix A describes the test in more detail. Appendix B contains the certificates of calibration for the manometer and thermometer used for this acceptance test. Following the test, the bag ends were cut to the specified length and the bag fabrication was completed.

MASTER

3.0 TEST RESULTS

The test results, taken from Appendix C, are summarized in the table below. The uncertainties on the pressure and temperature measurements are $\pm 1\%$ and $\pm 0.15\text{ }^{\circ}\text{C}$ ($\pm 0.25\text{ }^{\circ}\text{F}$), respectively. The bag pressure loss was 375 Pa (1.5 inches H_2O) without temperature compensation. Subtracting 200 Pa (0.8 inches H_2O) for the $0.6\text{ }^{\circ}\text{C}$ ($1\text{ }^{\circ}\text{F}$) temperature increase, the pressure loss was 575 Pa (2.3 inches H_2O).

	Time	Pressure Reading Pa (inches H_2O)	Temperature $^{\circ}\text{C}$ ($^{\circ}\text{F}$)
Initial	10:35 a.m.	2375 (9.5)	12.8 (55)
Final	11:35 a.m.	2000 (8.0)	13.3 (56)

4.0 CONCLUSIONS

The bag temperature-compensated pressure loss of 575 Pa (2.3 inches H_2O) was below the acceptance criteria of 625 Pa (2.5 inches H_2O) and the test results were therefore found to be acceptable. The bag manufacturer estimates that 80 - 90% of the pressure loss is attributed to leakage around the bag inflation valve where the pressure gage was connected. A leak detector was applied over the entire bag during the pre-tests and no leakage was found. Furthermore, the leak rate corresponding to this pressure loss is very small when compared to the acceptable leak rate of the completely assembled FRS. The sealing integrity of the assembled FRS is verified in phase III testing.

5.0 REFERENCES

- WHC, 1994, *Test Plan for Qualification Testing of the 241-SY-101 Flexible Receiver System*, WHC-SD-WM-TP-257, Westinghouse Hanford Company, Richland, Washington.
- WHC, 1995a, *Flexible Receiver Drawing Tree*, drawing H-2-821385, Rev. 0, Draft, Westinghouse Hanford Company, Richland, Washington.
- WHC, 1995b, *Flexible Receiver Bag Assembly*, drawing H-2-821391, Rev. 0, Draft, Westinghouse Hanford Company, Richland, Washington.

APPENDIX A - SUPPLIER ACCEPTANCE TEST PROCEDURE

P.O. #WM1-XVV-417302
DWG #H-2-821391 REV 0

CALIBRATED INSTRUMENTS:

1. THERMOMETER	MFR TAYLOR / MODEL 6071-1 / SERIAL #KGB61494A
2. MANOMETER	MFR AMETER / MODEL G 22704 / SERIAL #KGB122194

PRETEST BAG:

1. ATTACH CALIBRATED MANOMETER AND INFLATE BAG TO 10" H₂O.
2. APPLY LEAK DETECTOR TO ALL SEAMS & TIE-PATCHES AND INSPECT ENTIRE BAG FOR LEAKS.
3. REPAIR ANY LEAKS WITH A CLOUED OR HEAT SEALED PATCH.
4. REINFLATE TO 10" H₂O AND RETEST ALL REPAIRS.

FINAL TEST BAG:

1. REATTACH CALIBRATED MANOMETER AND INFLATE BAG TO 10" H₂O.
2. ATTACH CALIBRATED THERMOMETER TO CENTER SIDE OF BAG. ALLOW PRESSURE IN BAG TO STABILIZE. (3-4 HOURS)
3. REGULATE PRESSURE TO 10" H₂O, RECORD TEMPERATURE, DATE AND TIME ON BAG PER DWG, AND BEGIN TEST.
4. ALLOW BAG TO SIT FOR 1 HOUR. RECHECK AND RECORD PRESSURE, TIME AND TEMPERATURE ON BAG.
5. EVALUATE FND RESULTS USING TEMPERATURE COMPENSATION FACTOR OF +.8" WATER FOR EVERY 1°F OF TEMPERATURE GAIN AND -.8" WATER FOR EVERY DEGREE OF TEMPERATURE LOSS.
6. IF AFTER COMPENSATING FOR CHANGE IN TEMPERATURE THE NET LOSS OF PRESSURE DOES NOT EXCEED 2.5" H₂O, THE BAG HAS PASSED. RECORD ALL RESULTS AND COMPLETE TEST REPORT.
7. IF AFTER COMPENSATING FOR CHANGE IN TEMPERATURE, THE NET LOSS OF PRESSURE EXCEEDS 2.5" H₂O, REINFLATE BAG TO 10" H₂O, APPLY LEAK DETECTOR TO IDENTIFY ANY LEAKS AND CONSULT WITH THE Q.C. SUPERVISOR AS TO HOW TO AFFECT PATCHING THE BAG OR IN THE EVENT OF A CATASTROPHIC FAILURE, WHETHER TO ATTEMPT TO REWORK OR MERELY SCRAP THE BAG.
8. IN THE EVENT A BAG FAILS THE FINAL TEST AND REQUIRES REWORKING, THE NATURE OF THE FAILURE AND REWORK ARE TO BE REFLECTED ON THE TEST REPORT AS WELL AS THE RESULTS OF THE RETEST.

NOTE: HEAT SEALED PATCHES USING 8-12 MIL CLEAR OR WHITE PVC OR WHITE HERCULITE OF THE SAME TYPE AS THE BAG IS PREFERRED, BUT IF NECESSARY, VINYL CEMENT BY RH PRODUCTS TYPE RH-66 MAY BE USED AT THE DISCRETION OF THE Q.C. SUPERVISOR TO ADHERE PATCHES.

PLANT:
12704 NE 12th Street, Kirkland, WA 98034 8397
206/823-6534 FAX 206/820-6184

FIELD OFFICE:
3890 Post Rd., Suite 6, Warwick, RI 02886
401/828 0302 FAX 401/864-2341

APPENDIX B - CERTIFICATES OF CALIBRATION FOR INSTRUMENTATION

Branom Instrument Co.*Manufacturers' Representatives
& Master Distributors
SINCE 1947***BRANOM
INSTRUMENTATION**

1-800-767-6051

Certificate of CalibrationTO: **Lancs**DATE OF CALIBRATION: **12-21-94**RECALL DUE IN **12 MONTHS**MODEL NO. **G22704**SERIAL NO. **KGB122194**

This is to certify the above listed instrument meets or exceeds all published specifications and has been calibrated using standards whose accuracies are traceable to the National Institute of Standards and Technology.

Applicable NIST test report numbers are as follows:

STANDARDS USED IN CALIBRATION:

MODEL **Ametek**

SERIAL #

75585DUE DATE **9-95**CAL PROCEDURE: To mfg specs $\pm 1\%$ full scale

IN CAL AS RECEIVED:

The tests were conducted at:

a temperature of **73°F** and a relative humidity of **41%**Date **December 21, 1994**

Certified By:

Lance MerrellP.O. No. **8134**
Q.A. Manager **Troy Perkins****MANOMETER**
0-30" H₂O

APPENDIX C - SUPPLIER ACCEPTANCE TEST REPORT

TEST REPORT

PURCHASE ORDER # WMH-XVV-417302DRAWING # H-2-821391 REV 0 SHTS 1-5 PART # 2SERIAL # 1ADATE OF TEST 1/17/95START TIME 10:35 AMSTOP TIME 11:35 AM

	START	STOP	LOSS/GAIN
AIR PRESSURE H ₂ O"	9.5" H ₂ O	8.0" H ₂ O	LOSS 1.5"
TEMPERATURE	55°F	56°F	GAIN 1°

NOTE: DEPENDING ON WHETHER THE TEMPERATURE HAS LOST/GAINED, USE THE FOLLOWING FORMULA TO DETERMINE THE FINAL PRESSURE.

CONVERSION FORMULA:

PRESSURE LOSS/GAIN - (TEMP. GAIN X .8) = ADJUSTED PRESSURE LOSS/GAIN

$$\text{LOSS } 1.5 - (\text{GAIN } 1^\circ \times .8) = \text{2.3}^\circ \text{ H}_2\text{O LOSS}$$

PRESSURE LOSS/GAIN + (TEMP. LOSS X .8) = ADJUSTED PRESSURE LOSS/GAIN

$$\text{_____} + (\text{_____} \times .8) = \text{_____}$$
IF THE BAG HAS LOST LESS THAN 2.5" H₂O IT HAS PASSED.TESTED BY K. S. [Signature] DATE 1/17/95WITNESSED BY [Signature] DATE 1/17/95

IN THE EVENT THE BAG HAS LOST MORE THAN 2.5" H₂O IT HAS FAILED. NOTIFY Q.C. SUPERVISOR FOR DISPOSITION OF ANY FAILED BAG. THE FOLLOWING IS TO BE COMPLETED BY THE Q.C. SUPERVISOR DETAILING THE FINDINGS AS TO THE CAUSE, SEVERITY AND REPAIR OF THE FAILURE. ATTACH A SUPPLEMENTAL TEST REPORT FOR THE RETESTING.

* 1 MAJOR PATCH WHERE REINFORCEMENT PATCH IS SEALED IN. HEAT SEALED

REPAIR.

* APPROXIMATELY $\frac{1}{2}$ DOZEN SMALL PINHOLES GLUE PATCHED.

* MOST OF PRESSURE LOSS IS ATTRIBUTABLE TO LEAK AROUND INFLATION SLEEVE

WHICH IS NOT PART OF BAG AND WHICH WILL BE CUT OFF AFTER TEST.

PLANT:
12704 NE 124th Street, Kirkland, WA 98034 8397
206/823 6634 FAX 206/820 6784

FIELD OFFICE:
3890 Post Rd., Suite 6, Warwick, RI 02886
401/828-9392 FAX 401/884 2341

APPENDIX D - SUPPLIER CERTIFICATE OF COMPLIANCE

SUPPLIER CERTIFICATION AND RELEASE

(1) Supplier and Address LANCS INDUSTRIES, INC. 12704 NE 124TH ST. KIRKLAND, WA 98034		(2) Item Name/Description/Quantity SUB-ASSEMBLY CONTAINMENT BAG, 67"DIA X 57'LONG TO DWG H-2-821391 REV 0 SHTS 1-5 AND SPEC. HS-BS-0015 PART NUMBER 2 1 EACH	
(3) Purchase Order No./Item No. & Modification P.O. #WWH-XVV-417302 ITEM NO. 1			
(4) Drawing No., Revision DWG #H-2-821391 REV 0 PART #2 SHTS 1-5		(5) Specification No. & Revision SPEC #HS-BS-0015	
(6) Quantity Released 1 EACH	(7) Serial Numbers of Released Items 1 A		
(8) ASME Code N/A Section Class Code Issue Addenda/Supplements			
(9) Quality Assurance Standard/Revision/Amendments N/A			
(10) Applicable Design Changes & Waivers N/A		(11) Applicable Approved Nonconformance Reports N/A	
(12) Supplier's Certification of Compliance The configuration of this equipment is in accordance with the above-listed documents except as noted below: Records which provide objective evidence supporting this certification have been transmitted to the Purchaser and/or are in Seller's possession and are available for review by the purchaser upon request. ASME Certificate No. <u>N/A</u> Expiration Date <u>N/A</u> <u>Kevin Bylin</u> (Signed) <u>QUALITY CONTROL SUPERVISOR</u> (Title) <u>JANUARY 17, 1995</u> (Date) KEVIN BYLIN			
(13) Shipping Release		Shipped to WHC ☐ Consigned to Supplier Other ☐ P.O. No. Supplier's Address	
Order Complete ☐			
Equipment is Released for Shipment.			
(14) ☐ Attachments	<u>B. A. [Signature]</u> Signed WHC QA Representative		<u>1-17-94</u> Date

A-7310-111 (06/91)