Sta. 4

JUN 19 1997

ENGINEERING DATA TRANSMITTAL

Page 1 of 1
1. EDT 618149

2. To: (Receiving Organization) WRAP 1		3. From: (Originating Organization) WRAP 1		4. Related EDT No.: N/A	
5. Proj./Prog./Dept./Div.: W026/Solid Waste Construction		6. Design Authority/ Design Agent/Cog. Engr.: TL Watson		7. Purchase Order No.: N/A	
8. Originator Remarks: For release				9. Equip./Component No.: N/A	
				10. System/Bldg./Facility: N/A	
11. Receiver Remarks: 11A. Design Baseline Document? ☐ Yes ☒ No				12. Major Assm. Dwg. No.: N/A	
				13. Permit/Permit Application No.: N/A	
				14. Required Response Date: N/A	

15. DATA TRANSMITTED					(F)	(G)	(H)	(I)
(A) Item No.	(B) Document/Drawing No.	(C) Sheet No.	(D) Rev. No.	(E) Title or Description of Data Transmitted	Approval Designator	Reason for Transmittal	Originator Disposition	Receiver Disposition
1	HNF-SD-W026-ATP-030		0	TRU Empty Drum Compactor	Q	2	1	
2	HNF-SD-W026-ATR-030		0	TRU Empty Drum Compactor	Q	2	1	

16. KEY					
Approval Designator (F)		Reason for Transmittal (G)		Disposition (H) & (I)	
E, S, Q, D or N/A (see WHC-CM-3-5, Sec.12.7)		1. Approval 2. Release 3. Information	4. Review 5. Post-Review 6. Dist. (Receipt Acknow. Required)	1. Approved 2. Approved w/comment 3. Disapproved w/comment	4. Reviewed no/comment 5. Reviewed w/comment 6. Receipt acknowledged

17. SIGNATURE/DISTRIBUTION (See Approval Designator for required signatures)											
(G) Reason	(H) Disp.	(J) Name	(K) Signature	(L) Date	(M) MSIN	(G) Reason	(H) Disp.	(J) Name	(K) Signature	(L) Date	(M) MSIN
1	1	Area Manager: TL Watson	<i>TL Watson</i>	6/16/97	T4-52						
1	1	Proj. Engr.: JB Payne	<i>JB Payne</i>	6/16/97	T4-02						
1	1	Cog.Eng.: KJ Leist	<i>KJ Leist</i>	6/16/97	T4-52						
1	1	Cog. Mgr.: RJ Bottenus	<i>RJ Bottenus</i>	6/16/97	T4-52						
1	1	QA: JR McGee	<i>JR McGee</i>	6/16/97	T4-02						
		Safety									
		Env.									

18. JB Payne Signature of EDT Originator 6/16/97		19. RJ Bottenus Authorized Representative for Receiving Organization 6/16/97		20. RJ Bottenus Design Authority/Cognizant Manager 6/16/97		21. DOE APPROVAL (if required) Ctrl. No. ☐ Approved ☐ Approved w/comments ☐ Disapproved w/comments	
--	--	--	--	--	--	---	--

W-026, Acceptance Test Report TRU Empty Drum Compactor (Submittal # 634)

TL Watson

Fluor Daniel Northwest, Inc., Richland, WA 99352
U.S. Department of Energy Contract DE-AC06-96RL13200

EDT/ECN: EDT 618149 UC: 506
Org Code: 04E00 Charge Code: P1JF18
B&R Code: EW3130020 Total Pages: 112

Key Words: ATR, WRAP 1, INET, Glovebox, Transfer Car, Hydraulic Power Unit, HPU

Abstract: On 10/19/96 and 10/21/96, the 06/04/96 version of the Empty Drum Compactor Acceptance Test Procedure was used to perform tests by INET Corporation at the Hanford WRAP facility. The INET compaction components were installed in the Diversified glovebox. The Diversified glovebox and cart and the INET compaction components, EDC HPU and drum centering device constitute the Empty Drum Compactor.

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Release Approval

Date

Approved for Public Release

Submittal 633/634

INET CORPORATION

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PROJECT: HANFORD, WRAP 1 MODULE
RICHLAND, WASHINGTON

EMPTY DRUM COMPACTOR

ACCEPTANCE TEST RESULTS

OCTOBER 19 - 21, 1996

Submittal 633/634
Empty Drum Compactor
Acceptance Test Report
10/28/96

Prepared: H. Miller, INET
Reviewed: G. Rice, INET
Inspected: K. Leist, WEH

On 10/19/96 and 10/21/96, the 6/4/96 version of the Empty Drum Compactor Acceptance Test Procedure was used to perform tests by INET Corporation at the Hanford WRAP facility. The INET compaction components were installed in the Diversified glovebox. The Diversified glovebox and cart and the INET compaction components, EDC HPU, and drum centering device constitute the Empty Drum Compactor.

TEST PROCEDURE

It was agreed, prior to the test, by K. Leist, (Fluor Daniels), PCL, and INET; that the Main purpose of the Acceptance Test was to demonstrate the performance of the Empty Drum Compactor and to find the drum configuration which would provide the best puck. To this end, it was agreed that the bulk of the drum crush tests would use three clips and a double crush to allow maximum release of air trapped in the drum. This was done. Other variables tried were number of clips; manual, or semi-automatic operation, and triple and quadruple crush.

SUMMARY

The equipment operated satisfactorily. Cycle times using the selected double crush mode were under the specified three minutes, except where manual runs were made with extra crushing time. Puck heights with specified 17C drums allow six EDC pucks to be inserted in the overpack.

RESULTS

The EDC met drum compaction specification of 1/6 height when air was allowed to escape. If the drum is perfectly sealed, the air pressure inside gives over 30,000 psi upward force on lid and ram. Relieving the air pressure allowed the EDC to reach the specified height. Three methods were used to allow the air to escape. (1) The seal was taken off the top of one drum lid before compaction. (2) Holes were provided in the lid by removing circular plugs. (3) Some drums were tried with fewer clips in place. This increased the amount of air that could escape past the seal. In all cases drums were crushed at least twice, allowing the air to escape between compaction strokes.

The following table summarizes the results of 50 crushed drums. Twenty seven drums were specified 17C drums, 23 were galvanized drums which have thicker steel walls. The thicker steel drum substitution was authorized by Ken Leist. The Puck Height was measured by hand after the puck was removed from the EDC. The Mode is Auto for Automatic, Semi for Semi-Automatic, or Manual. Most drums had three lid clips securely attached during the test. The drums with three clips had the clips positioned on one half of the lid only.

Drums were positioned off center on the cart by $\frac{1}{4}$ " to $\frac{1}{2}$ " so centering arms had to move the drum to center it.

Result Summary: Double Crush Unless Noted

DRUM	CYCLE TIME (SEC)	PUCK HEIGHT (IN)	MODE	RAM PSI	HOLES IN DRUM	LID CLIPS	REMARKS
1	107	5 ½	Auto	2500	No	3	
2		5 ½	Auto	2500	No	3	
3	106	5 ½	Auto	2500	No	2	
4	107	6 5/16*	Auto	2500	No	4	Clips on 180°

5	107	6 3/8*	Auto	2500	No	5	
6	113	5 3/4	Auto	2500	No	5	
7	104	6 1/16	Auto	2500	No	6	
8	106	5 3/4	Auto	2500	No	4	
9	109	5 7/16	Auto	2500	Yes	3	Holes in top: 2 1/4 + 1 IN
10	107	6 1/16	Auto	2500	No	0	No seal, no clips.
11	105	6 1/8	Auto	2500	No	3	
12	109	6	Auto	2500	No	3	
13	105	6 1/8	Auto	2500	No	3	
14	108	5 1/4	Auto	2500	No	3	
15	111	5 7/16	Auto	2500	No	3	
16	104	6 1/8	Auto	2500	No	0	Gasket in
17	106	6 7/16	Auto	2500	No	3	
18	106	5 3/4	Auto	2500	No	3	
19	107	5 3/8	Auto	2500	No	4	
20	106	6 1/2	Auto	2500	No	4	
21	106	6 1/2	Auto	2500	No	4	
22	106	5 7/8	Auto	2500	No	4	
23	109	6 1/8	Auto	2500	No	4	
24	152	5 3/16	Semi-	2500	No	4	
25	109	5 5/16	Auto	2500	No	4	
26	108	5	Auto	2500	No	4	
27	168	5 3/8	Manual	2500	No	4	3x Crush
28	240	7 1/4*	Manual	2500	No	4	4x Crush
29	200	6 3/16*	Manual	2500	No	6	3x Crush
30	191	6 3/4*	Manual	2500	No	2	3x Crush
31	173	7 1/8*	Manual	2500	No	6	3x Crush
32			Manual	2500	No		Crushed 10/18
33			Manual	2500	No		Crushed 10/18
34		7 1/16*	Auto	2500	No	4	
35	106	7*	Auto	2500	No	4	
36	106	7 1/4*	Auto	2500	No	4	
37	107	6 5/16*	Auto	2500	No	4	
38	106	6 5/16*	Auto	2500	No	4	
39	106	7*	Auto	2500	No	4	
40	118	6*	Auto	2500	No	4	
41	108	6 5/16*	Auto	2500	No	4	
42	105	7*	Auto	2500	No	4	
43	108	7*	Auto	2500	No	4	
44	110	7 1/16*	Auto	2500	No	4	
45	107	6 3/4*	Auto	2500	No	4	
46	107	6 5/8*	Auto	2500	No	4	
47	107	6 7/8*	Auto	2500	No	4	
48	107	6 5/8*	Auto	2500	No	4	
49	107	7*	Auto	2500	No	4	
50	103	7 13/16*	Auto	2500	No	4	

During the tests, data was recorded for each drum except 2 and 32 - 34 . These data listings are contained at the end of this report.

* Galvanized Drums

MEASUREMENTS OF PUCK HEIGHTS

Following is a table showing the measured puck heights. Individual puck heights were measured with a steel tape. In addition, to provided more information, for a sequence of six pucks, the pucks were stacked six high and the height of the stack was measured.

It can be noted that some height reduction is gained in the stack. These measured stack heights (IN.) were $34 \frac{1}{4}$, $33 \frac{3}{4}$ and $34 \frac{5}{16}$. The decrease in stack height from addition of individual puck heights compared to measured stack height + $1/16$ IN, - $2 \frac{1}{4}$ IN, and - $1 \frac{1}{2}$ IN.

17C Painted Unless Noted

DRUM NO.	PUCK HEIGHT (INCHES)
1	$5 \frac{1}{2}$
2	$5 \frac{1}{2}$
3	$5 \frac{1}{2}$
4	$6 \frac{5}{16}^*$
5	$6 \frac{3}{8}^*$
6	$5 \frac{3}{4}$

SUM 1-6 = $34 \frac{15}{16}$ IN.Meas. Ht. 1-6 STACK = $34 \frac{1}{4}$ IN.

7	$6 \frac{1}{16}$
8	$5 \frac{3}{4}$
9	$5 \frac{7}{16}$
10	$6 \frac{1}{16}$

Lunch

11	$6 \frac{1}{8}$
12	6
13	$6 \frac{1}{8}$
14	$5 \frac{1}{4}$
15	$5 \frac{7}{16}$
16	$6 \frac{1}{8}$

SUM 11-16 = $35 \frac{1}{16}$ INMeas. Ht. 11-16 STACK = $33 \frac{3}{4}$ IN.

17	$6 \frac{7}{16}$
18	$5 \frac{3}{4}$
19	$5 \frac{3}{8}$
20	$6 \frac{1}{2}$
21	$6 \frac{1}{2}$
22	$5 \frac{7}{8}$

SUM 17-22 = $36 \frac{7}{16}$ INMeas. Ht. 17-22 STACK = $34 \frac{5}{16}$ IN.

23	$6 \frac{1}{8}$
24	$5 \frac{3}{16}$
25	$5 \frac{5}{16}$
26	5
27	$5 \frac{3}{8}$
28	$7 \frac{1}{4}^*$
29	$6 \frac{3}{16}^*$
30	$6 \frac{3}{4}^*$
31	$7 \frac{1}{8}^*$

* Galvanized (t = .082 - .092 IN.)

Painted (t = .050 - .055 IN.)

Items not tested *

1. Page 6, HPU test plan: Not yet conducted.
2. Page 26, Faults 2-14 not yet tested.
3. Page 27, Noise measurement not taken.

Items Requiring Software Program Modification *

1. Page 24, Auto mode pre-cycle status messages require fixing. "DCD not retracted", "Mold not up", "Ram is not up".
2. Page 26, Fault 1 occurs when puck is on transfer car.

- Will be completed by INET

Drum ED1 - Ram/Mold Height vs Time

Drum ED1 - Ram PSI vs. Height

Drum ED3 - Ram/Mold Height vs Time

Drum ED3 - Ram PSI vs Height

Drum ED4 - Ram/Mold Height vs Time

Drum ED4 - Ram PSI vs Height

Drum ED8 - Ram/Mold Height vs Time

Drum ED8 - Ram PSI vs Height

Submittal 633/634

Original Data

INET Corporation

INET Corporation

Submittal 633 11175:1.05.D.3

Submittal 634 11175:1.05.D.4

Functional Test Procedure (ATP)

Demonstration Test Procedure (ATP)

INET CORPORATION

8450 CENTRAL AVENUE

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SUBMITTAL COVER SHEET

PROJECT: HANFORD, WRAP 1 MODULE
RICHLAND, WASHINGTON

SUBMITTAL NO. 633/634

SPECIFICATION:	11175:	TRU EMPTY DRUM COMPACTOR
SECTION:	1.05.D.3	FUNCTIONAL TEST PROCEDURE (ATP)
SECTION:	1.05.D.4	DEMONSTRATION TEST PROCEDURE (ATP)
SECTION:	3.05	ACCEPTANCE TEST PROCEDURE

INET Corporation Submittal 633 11175:1.05.D.3 Functional Test Procedure (ATP)
 Submittal 634 11175:1.05.D.4 Demonstration Test Procedure (ATP)

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 Submittal 634 11175:1.05.D.4

Functional Test Procedure (ATP)
Demonstration Test Procedure (ATP)

FUNCTIONAL TEST PROCEDURE: TRU EMPTY DRUM ASSEMBLY:

I. INTRODUCTION

The field test of the TRU Empty Drum Compactor Assembly will be performed at the Hanford WRAP facility. The Assembly is composed of the following major equipment items:

1. TRU Empty Drum Compactor (EDC)	provided by INET
2. TRU Empty Drum Compactor Glovebox	provided by Diversified
3. TRU Transfer Car	provided by Diversified
4. Empty Drum Compactor Hydraulic Power Unit (HPU)	provided by INET

The compactor assembly is an integrated and assembled unit housed within the glovebox and includes all hydraulic, electrical, controls and instrumentation necessary to perform the volume reduction of empty 55 gallon radioactive solid waste drums.

Functional tests of all the major components and performance tests of the complete assembly will be performed over the range of operation to assure that the assembly meets the specification. This assembly includes the ram, mold, centering device, HPU, and control components, provided by INET; and the glovebox and transfer car provided by Diversified. These tests are described in the following sections.

II. FIELD TEST PROCEDURE

A. SCOPE

The purpose of this Field Test is to check-out, test, and record the parameters of the Compactor, Glovebox, Transfer Car and HPU and control unit to ensure that the compactor functions as designed and that the integrated assembly meets the specifications. Field start-up and test of drum compaction will be performed by trained INET personnel.

B. PRE-TEST PROCEDURE

The Shop test reports and the inspection reports resulting from the fit-up and assembly of the TRU Empty Drum Compactor Assembly will be reviewed prior to start of functional testing to determine if any potential problem areas exist that require changes or additions to the tests planned.

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Functional Test Procedure (ATP)
Demonstration Test Procedure (ATP)

Hydraulic: A check of all hydraulic piping connections is made to ensure that all tube fittings are properly installed and tight. The screws on all flange connections are checked to verify that they are tight. All pipe runs are checked against the hydraulic schematic piping diagrams for conformance. All valves are verified as being in their proper positions. The hydraulic reservoir is filled with the appropriate hydraulic fluid to the reservoir's designed capacity.

Electrical: All electrical cabinets are assembled and prewired before being connected to the press. All external electrical components are checked for location and wiring.

C. FUNCTIONAL TESTING

Initial Tests

Initial tests will be made to confirm the operation of the separate components. These tests will be carried out separately to assure operation is in accord with the design. A functional test of all electrical, control, software and mechanical components will be performed to assure satisfactory operation of each component specified. The Transfer car with an empty drum will be moved into the glovebox and the test of the drum centering device, the mold, and the ram will be performed.

Electric Motor Functional Test

The two electric motors in the system and their respective driven equipment will be operated for one hour at full capacity. Voltage and ampere readings will be recorded and must be within normal limits during the test period. A typical data sheet is shown in Figure 1.

Functional Test Procedure (ATP)
Demonstration Test Procedure (ATP)

Figure 1

Observer: K. J. Hunt 10/21/96
JR

ACCEPTANCE TEST PROCEDURE

Operate all motors at full capacity for one (1) hour.
Measure and record voltage and amps, temperature

11:45am @ 0 Time:

1. 15 HP HPU
2. 1 HP Circulation

491V V
493
491
on 490V
49349

$$\begin{array}{r} 12.2 / \overset{A}{12.9A} \\ 12.0 / 12.9A \\ 9 / 9 / 1.1A \end{array}$$

I
74°F
74°F oil = 77°F

@ 1 Hour:

1. 15 HP HPU —
2. 1 HP Circulation

105°F tank
oil = 117°F

487/494/490v

 106°F

487/490/490v

~~85° F~~
93° F

+2.0/11.7/125 Apr

- 9/9/10 Apr

INET Corporation

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Submittal 634 11175.1.05.D.4

Functional Test Procedure (ATP)

Demonstration Test Procedure (ATP)

SECTION II

Figure 2

HPU TEST

A. Hydrostatic Test:

Design Pressure _____ Time At 0 Test Pressure (1 -1/2 times design) _____

30 Min. Test Pressure _____

Pass/Fail _____ Test Engineer _____ Date _____

Observer _____ Date _____

B. Hydraulic Piping: 4-Hour Operation Test

System Design Pressure 2500 psi Min. Stable Operating Pressure 2000 psi

Relief valve lifting pressure 2650 psi Low pressure alarm @ N/A

Condition of filters and strainers after: 98 cycles - clean.

Test Engineer J. M. Rice Date 11/7/96

Observer Kendall J. Hall Date 11/7/96

Section 8 only

INET Corporation

Submittal 633 11175.1.05.D.3
Submittal 634 11175.1.05.D.4Functional Test Procedure (ATP)
Demonstration Test Procedure (ATP)

Compactor Assembly Functional Tests

Functional tests will include check-out and operation of the control system, the drum centering device (DCD), the ram and mold operation, transfer car and glovebox performance and capability. The following tests and inspections will be performed (See Figure 3 for typical data sheet):

1. Demonstration of Drum Centering operation.
2. Demonstration of Mold operation.
3. Demonstration of Ram operation
4. Demonstration of Control System operation
5. Demonstration of Operating sequence and control.
6. Demonstration of Transfer Car and Glovebox physical compatibility.
7. Demonstration of Glovebox atmosphere control.
8. Sound Level Measurements
9. Maintenance Accessibility at glovebox windows and gloveports.

Test results will be recorded and the results filled in the Test Section of the Field Traveler Package. Typical data to be obtained are shown in Figures 3 and 4.

Following each test, the DCD, mold, press ram, transfer car anvil and HPU control unit will be inspected for any items of wear, fluid or motor over heating or any non-conformance condition.

Oct-18-96 09:20A

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Functional Test Procedure (ATP)

Demonstration Test Procedure (ATP)

SECTION II

Figure 3

**WRAP
FUNCTIONAL TEST
MECHANICAL DESIGN FEATURES**

Manual Operation

TRU EMPTY DRUM COMPACTOR Tag. 107-CM-07-303

PERFORMANCE TEST AT WRAP

Date 10/19/96Tester HRObserver Kendall [Signature]

Test Each Operation	Pass	No Pass	Problem	Action
Start HPU	✓			
DCD Extend	✓			
Mold Move Down to Drum	✓			
DCD Retract	✓			
Mold Move Down to Anvil	✓			
Ram Move Down to Anvil	✓			
Mold Move Up	✓			
Ram Move Up	✓			

INET Corporation

Submittal 633 11175.1.05.D.3

Functional Test Procedure (ATP)

Submittal 634 11175.1.05.D.4

Demonstration Test Procedure (ATP)

SECTION II

Figure 4

WRAP
ROUTINE MAINTENANCE ACCESSIBILITY

Manual Operation

TRU EMPTY DRUM COMPACTOR Tag. 107-CM-07-303

Date 10/21/96

PERFORMANCE TEST AT WRAP

Tester HRObserver K. Hoffland

Access of hydraulic components for replacement

Comments

1. Filters SEE EXCEPTION #2
2. Seals OK K. Hoffland
3. Instruments * SEE EXCEPTION #1
4. Valves OK. K. Hoffland

* EXCEPTION:

1. DCO & MOULD POSITION SENSORS DIFFICULT TO MAINTAIN.
2. ROTATE FILTER ON TOP OF HAU SO CAN GET FILTER OUT
ANGLED DOWN
3. Lube requirements for wheels.
4. Ram Position Sensor does not maintain alignment. Extraction operation currently does
not provide routine access.

6/4/96

D. CONTROL SYSTEM TESTS

Cycle Tests

After the individual equipment component function tests are completed, control system tests will be carried out. These functional tests will include:

1. Demonstration of operating sequences and control.
2. Demonstration of Control System operation
3. Demonstration of status and diagnostic information provided to operators.

All control system functions necessary for operation of the DCD, mold and ram operations will be checked out and verified using the Allen Bradley PLC and the Plant Control System (PCS). The programmable controller test will verify operation of solenoid, limit, and proximity switches, and that all safety features and interlocks are operative as designed. Cycle tests will be performed in all modes, i.e. manual, semi-automatic and full automatic at operating pressures. Sensor operation will be monitored. Tables II-A through II-H, listed below describe the control functions which are included and will be tested.

Table II Summary

- A. General Modes Messages
- B. Automatic Mode - PreCycle Status Messages
- C. Automatic Mode - Status Messages
- D. Local Semi-Automatic Mode Messages
- E. Manual Mode Command Messages
- F. Manual Mode Status Messages
- G. Fault Status Messages
- H. Safety Interlocks

INET Corporation Submittal 633 11175:1.05.D.3
 Submittal 634 11175:1.05.D.4

Functional Test Procedure (ATP)
Demonstration Test Procedure (ATP)

TABLE II-A

General Modes Messages

1. **INITIAL POWER UP - PRESS RESET (F20)** - The TRU Empty Drum Compactor PLC has started to execute program instructions. Press F20 to continue operation.
2. **NO CONTROL POWER** - No TRU Empty Drum Compactor movements can occur before the Control Power is applied. PLC input does not detect a voltage.
3. **OFF MODE - NOT AT HOME POSITION** - The TRU Empty Drum Compactor is in the Off mode, but is not in the home position (as defined below).
4. **OFF MODE - AT HOME POSITION** - The TRU Empty Drum Compactor is in Local Off mode and is at Home position, i.e., the TRU Empty Drum Compactor is in Home position when the Drum Centerer is retracted, the Mold is up, and the Piston is up.
5. **ALREADY AT HOME POSITION** - The TRU Empty Drum Compactor is being commanded to move to the home position, but it is already in the home position.
6. **GOING TO HOME POSITION** - The TRU Empty Drum Compactor is being commanded to move to the home position.
7. **MANUAL MODE** - The TRU Empty Drum Compactor is in Manual mode, but is not being commanded to move at this time.

INET Corporation

Submittal 633 11175:1.05.D.3

Submittal 634 11175:1.05.D.4

Functional Test Procedure (ATP)

Demonstration Test Procedure (ATP)

TABLE II-B

Automatic Mode - PreCycle Status Messages:

1. READY TO RECEIVE TRANSFER CAR - The TRU Empty Drum Compactor is ready to begin a fully automatic cycle, as soon as the transfer car is detected.
2. DCD NOT RETRACTED - The Drum Centering Device (DCD) must be retracted before an automatic sequence can be initiated.
3. MOLD IS NOT UP - The Mold must be retracted before an automatic sequence can be initiated.
4. RAM IS NOT UP - The ram must be retracted before an automatic sequence can be initiated.
5. PUCK READY TO TRANSFER - Transfer Car with puck can go to unloading glovebox.

TABLE II-C

Automatic Mode - Status Messages:

1. DCD EXTENDING - The DCD is extending and centering the drum on the anvil.
2. DCD RETRACTING - The DCD is moving to the retracted position.
3. MOLD IS GOING DOWN - The mold is moving toward the down position.
4. RAM IS CRUSHING - The ram is moving toward the down position.
5. MOLD IS GOING UP - The mold is moving toward the up position.
6. RAM IS GOING UP - The ram is moving toward the up position.

INET Corporation

Submittal 633 11175:1.05.D.3

Submittal 634 11175:1.05.D.4

Functional Test Procedure (ATP)

Demonstration Test Procedure (ATP)

TABLE II-D

Local Semi-Automatic Mode Messages:

1. WAITING FOR CENTER COMMAND (F1) - This is the first of three semi-automatic mode steps. The operator must press the F1 key to initiate the Center Drum Step. The drum on the Transfer Car will be centered.
2. WAITING FOR CRUSH COMMAND (F3) - This is the second of three semi-automatic mode steps. The operator must press the F3 key to initiate the Crush Step. The drum currently on the anvil will be crushed.
3. WAITING FOR RETRACT COMMAND (F5) - This is the third of three semi-automatic mode steps. The operator must press the F5 key to initiate the release Step. The crushed puck will be ejected from the mold onto the transfer car.

TABLE II-E

Manual Mode Command Messages:

1. DCD EXTENDING - The DCD is moving to center the drum
2. DCD RETRACTING - The DCD is moving to retract.
3. MOLD IS GOING UP - The mold is moving to the up position.
4. MOLD IS GOING DOWN - The mold is being manually commanded to move to the down position.
5. RAM IS GOING UP - The ram is moving to the up position.
6. RAM IS CRUSHING - The ram is moving to the down position.

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Submittal 633 11175.1.05.D.3

Submittal 634 11175.1.05.D.4

Functional Test Procedure (ATP)

Demonstration Test Procedure (ATP)

TABLE II-F

Manual Mode Status Messages:

1. DCD IS ALREADY RETRACTED - The DCD is being commanded to retract, but the DCD is already retracted.
2. MOLD IS ALREADY UP - The mold is being commanded to move to the up position, but the mold is already in the up position.
3. MOLD IS ALREADY DOWN - The mold is being commanded to move to the down position, but the mold is already in the down position.
4. RAM IS ALREADY UP - The ram is being commanded to move to the up position, but the ram is already in the up position.
5. RAM IS ALREADY DOWN - The ram is being commanded to move to the down position, but the ram is already in the down position.
6. MOLD IS NOT UP - The DCD cannot be commanded to extend until the mold is up.
7. RAM IS NOT UP - The DCD cannot be commanded to extend until the ram is up.
8. DCD NOT RETRACTED - The mold and the ram cannot move down until the DCD is retracted.
9. DCD ALREADY EXTENDED - The DCD is being commanded to extend, and it is already extended.

INET Corporation	Submittal 633 11175.1.05.D.3	Functional Test Procedure (ATP)
	Submittal 634 11175.1.05.D.4	Demonstration Test Procedure (ATP)

TABLE II-G

Fault Status Messages:

Medium Level Faults:

FAULT 1 - TRANSFER CAR RECEIVED WITH NO DRUM - A transfer car is in the glovebox, but no drum was detected.

FAULT 2 - HPU PUMP MOTOR AUX CONTACT FAILURE - The PLC tried to turn on the HPU motor starter, but the contact was not detected.

FAULT 3 - HPU FAN AUX CONTACT FAILURE - The PLC tried to turn on the HPU heat exchanger fan motor, but the contact was not detected.

FAULT 4 - P1 FILTER PRESSURE IS TOO HIGH - The P1 filter pressure contact was detected.

FAULT 5 - P2 FILTER PRESSURE IS TOO HIGH - The high filter pressure contact was detected.

FAULT 6 - HPU OIL TEMP IS TOO HIGH - The ram pump high oil temperature contact was detected.

FAULT 7 - HPU OIL IS LOW - The ram pump low oil level contact was detected.

FAULT 8 - DCD ARMS TOOK TOO LONG RETRACTING - The proximity switch located at the retracted position of the DCD was not detected even after the DCD was commanded to retract for an adequate duration.

FAULT 9 - DCD ARMS TOOK TOO LONG EXTENDING - The proximity switch located at the extended position of the DCD was not detected even after the DCD was commanded to extend for an adequate duration.

FAULT 10 - MOLD TOOK TOO LONG GOING UP - The mold did not go up far enough even after the mold was commanded up for an adequate duration, or the mold distance sensor is not properly calibrated.

FAULT 11 - MOLD TOOK TOO LONG GOING DOWN - The mold did not go down far enough even after the mold was commanded down for an adequate duration, or the mold distance sensor is not properly calibrated.

INET Corporation	Submittal 633 11175.1.05.D.3	Functional Test Procedure (ATP)
	Submittal 634 11175.1.05.D.4	Demonstration Test Procedure (ATP)

TABLE II-G (Continued)

Fault Status Messages:

Medium Level Faults:

FAULT 12 - RAM TOOK TOO LONG GOING UP - The ram did not go up far enough, or the ram distance sensor is not properly aligned.

FAULT 13 - RAM TOOK TOO LONG CRUSHING - The ram did not go down far enough, or the ram distance sensor is not properly aligned.

FAULT 14 - MACHINE WAS PAUSED IN AUTO FOR TOO LONG - The TRU Empty Drum Compactor had a fault during an automatic cycle that was not cleared in time.

High Level Faults:

- **FAULT 20 - CONTROL POWER NOT ON** - The control power contact was not detected.

FAULT 21 - PLC LOW BATTERY - The PLC battery is low.

FAULT 22 - PLC PROCESSOR FAULT - A problem was detected by the PLC. This requires PLC service and/or replacement.

FAULT 23 - REMOTE SOFTWARE INITIATED E-STOP - The operator in the Plant Control Room halted the machine remotely.

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Submittal 633 11175.1.05.D.3

Functional Test Procedure (ATP)

Submittal 634 11175.1.05.D.4

Demonstration Test Procedure (ATP)

TABLE II-H

SAFETY INTERLOCKS

- GR 1. Mold cannot be lowered beyond point where top of drum just enters Mold while Drum Centering Device (DCD) is energized.
2. ~~RAM~~ Ram cannot be lowered until Mold is fully lowered.
- GR 3. DCD cannot be actuated unless the Mold is fully raised.
4. ~~COMP~~ Compaction cycle cannot commence without a permissive signal from the Plant Control System (PCS). *Allen OK*
- GR 5. ~~MOLD~~ Mold shall be interlocked to ensure that it cannot crush a drum that is not centered
- GR 6. Controller memory must be protected by a keylock or a password.

The results of all pre-operation tests and measurements specified in Section II will be recorded.

After completion of the functional and cyclic tests of ram, mold, DCD and HPU/control system; and the semi-automatic and automatic modes have demonstrated proper, repeatable operation with the transfer car in the glovebox, the Demonstration/Acceptance Tests described in Section III will be performed.

* if drum is positioned within 1/4 of center on transfer car

Exception #1: ** keylock or password protection of manual mode screen is acceptable solution

Exception #2: *** Perform item 4 with SII.

Exception #3: DRUM TRANSFER CAR IS NOT FUNCTIONING CORRECTLY. THE CAR DOES NOT STOP CORRECTLY. OUT OF INET SCOPE - SYSTEM DESIGN BY DIVERSIFIED METAL PRODUCTS.

INET Corporation Submittal 633 11175.1.05.D.3
 Submittal 634 11175.1.05.D.4

Functional Test Procedure (ATP)
 Demonstration Test Procedure (ATP)

III. DEMONSTRATION/ACCEPTANCE TEST PROCEDURE

A. GENERAL

A minimum of 50 drums will be supplied for demonstration acceptance tests. The Acceptance Test requires test of 50 drums in sequence. The following sequence is suggested, but can be changed. Five drums will be crushed in Manual Mode, followed by crushing ten drums in semi-automatic mode, followed by crushing twenty drums in full automatic mode.

Test data will be recorded. All these compaction runs will be made in sequence. If the sequence is interrupted due to a problem with the compactor equipment, the sequence will be restarted.

B. CALIBRATIONS

Calibration of the monitored value of hydraulic pressure will be obtained using a pressure gauge with at least 1% accuracy over the range from 0 psig to 3000 psig. Height of the ram and mold will be calibrated with inside micrometers. Calibration points will include closed to fully open.

All test drums will be numbered, the drum lid on each drum will be clearly marked with drum number.

C. MEASURING AND RECORDING DATA

Measurements of hydraulic pressure, and position of ram and mold will use outputs from the sensors used in normal operation. These measurements will be recorded and plotted using the sensor outputs as inputs to a computer. The computer will plot the data, i.e. height vs. pressure, and record the digital values. Drums will be compacted in the agreed sequence.

VISUAL INSPECTION

After each drum is crushed a visual inspection will be made. The inspection will look for leaks, temperature rise, smoke, mechanical damage, obvious misalignment, or component failure. If no problems are seen by visual inspection, the next drum will be compacted and another visual inspection will be made. This process will continue until all 50 drums are compacted.

If visual inspection reveals one of the problems noted above, the problem will be corrected and a new test series will be initiated. The system must compact 20 drums continuously in automatic with no problems or failures to pass the demonstration and be accepted.

INET Corporation	Submittal 633 11175.1.05.D.3	Functional Test Procedure (ATP)
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FUNCTIONAL (Will be done prior to Demonstration/Acceptance Test)

Electrical:

Start/stop to verify rotation

Programmable Controller Test:

Check operation of solenoid, limit, level, filter, and hot oil switches
safety features, and interlocks are operative as designed.

Cycle Test

Operate in manual mode
Operate in semi-automatic mode
Operate in automatic mode

COMPACTOR DEMONSTRATION

Compact 50 empty drums in accordance with the cycle discussed in Section III-A

Provide test data and plots for review and approval (see Section III, Figure 1, for typical data sheet.)

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Submittal 633 11175.1.05.D.3

Functional Test Procedure (ATP)

Submittal 634 11175.1.05.D.4

Demonstration Test Procedure (ATP)

SECTION III

Figure 1

TRU EMPTY DRUM COMPACTOR,
ASSEMBLY

Tag No. 107-CM-07-303

ACCEPTANCE TEST

Date: 10/19/96
 Recorder: JFR
 Operator: JFR
 Customer: Kenda/Hoffman 3 drums.

17-C drum

1. Record Data Required Below
2. Record Ram Position. vs. Hyd. Press

Drum No.	Mode	No. C Clamps	Drum Modifi- cation	Start Time	End Time	Meas. Max Press.	Puck Height	Visual Inspect
----------	------	-----------------	---------------------------	---------------	-------------	------------------------	----------------	-------------------

Computer Logged

1	auto	3					5 1/2	
2		3					5 1/2	
3		2					5 1/2	
4		4					6 5/16	G = galvanized
5		5					6 3/8	G
6		5					5 3/4	
7		6					6 1/4	
8		4					5 3/4	
9		3					5 7/16	
10		0					6 1/16	
11		3					6 1/8	
12		3					6	
13		3					6 1/8	
14	auto	3					5 1/4	

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Functional Test Procedure (ATP)

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Demonstration Test Procedure (ATP)

SECTION III (Continued)

Figure 1

1. Record Data Required Below
2. Record Ram Position, ys, Hyd. Press

Observer Kenton 10/21

Drum No.	Mode	No. C Clamps	Drum Modifi- cation	Start Time	End Time	Meas. Max Press.	Puck Height	Visual Inspect
----------	------	-----------------	---------------------------	---------------	-------------	------------------------	----------------	-------------------

Computer Logged

15	auto	3					5 ⁷ / ₁₆	
16		0					6 ¹ / ₈	
17		3					6 ⁷ / ₁₆	
18		3					5 ³ / ₄	
19		4					5 ³ / ₈	
20		4					6 ¹ / ₂	
21		4					6 ¹ / ₂	
22		4					5 ⁷ / ₈	
23	auto	4					6 ¹ / ₈	
24	semi-	4					5 ³ / ₁₆	
25	auto	4					5 ⁵ / ₁₆	
26	auto	4					5 ⁵ / ₁₆	
27	manual	4					5 ³ / ₈	
28		4					7 ¹ / ₄	G
29		6					6 ³ / ₁₆	G
30		2					6 ³ / ₄	G
31	manual	6					7 ¹ / ₈	G
32	manual							
33	manual							
34	auto	4					7 ¹ / ₁₆	G

D25 = 5⁵/₁₆ / 5⁰²⁶ =

} previous test

Oct-18-96 09:23A

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Submittal 633 11175:1.05.D.3

Functional Test Procedure (ATP)

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Demonstration Test Procedure (ATP)

SECTION III (Continued)

Figure 1

1. Record Data Required Below
2. Record Ram Position, vs. Hyd. Press

Observer *Kjha 10/18/96*

Drum No.	Mode	No. C Clamps	Drum Modifi- cation	Start Time	End Time	Meas. Max Press.	Puck Height	Visual Inspect
----------	------	-----------------	---------------------------	---------------	-------------	------------------------	----------------	-------------------

Computer Logged

35		4x					7	G
36		4					7 1/4	G
37		4					6 15/16	G
38		4					6 15/16	G
39		4					7	G
40		4					6	G
41		4					6 15/16	G
42		4					7	G
43		4					7	G
44		4					7 1/16	G
45		4					6 3/4	G
46		4					6 5/8	G
47		4					6 7/8	G
48		4x					6 5/8	G
49		4x					7	G
50		4x					7 13/16	G

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GLOVEBOX LEAK TEST

At a later date when the glovebox is sealed, glovebox leak performance tests will be carried out by others.

EQUIPMENT SIGN-OFF REPORT

At the successful conclusion of all required acceptance tests, an Equipment Sign-Off Report (See Appendix-II) shall be filled out and signed by an authorized representative of the buyer accepting the INET supplied equipment.

INET Corporation

Submittal 633 11175.1.05.D.3

Functional Test Procedure (ATP)

Submittal 634 11175.1.05.D.4

Demonstration Test Procedure (ATP)

APPENDIX I

DATA SHEET

WRAP

TRU EMPTY DRUM COMPACTOR CONTROLS WRAP FIELD TEST

SAFETY FEATURES/INTERLOCK CHECK

Date 10/21/96Tester JRObserver: KJ 10/21/96

1. Test each item in Tables II-A through II-G to determine it operates properly and gives proper message.

A. General Modes	Pass	No Pass	Problem	Action
1. Initial Power Up - Press Reset (F20)	✓			
2. No Control Power	✓			
3. Off Mode - Not at Home Position	✓			
4. Off Mode - At Home Position	✓			
5. Already At Home Position	✓			
6. Going to Home Position	✓			
7. Manual Mode	✓			
B. Automatic Mode - PreCycle Status Messages				
1. Ready to Receive Transfer Car	✓			
2. DCD Not Retracted	✓	✓	Fixed 11/7/96	Fix Logic
3. Mold is Not Up	✓	✓	Fixed 11/7/96	Fix Logic
4. Ram Is Not Up	✓	✓	Fixed 11/7/96	Fix Logic
5. Puck Ready to Transfer	✓			
C. Automatic Mode - Status Messages				
1. DCD Extending	✓			
2. DCD Retracting	✓			
3. Mold Is Going Down	✓			
4. Ram Is Crushing	✓			
5. Mold Is Going Down	✓			
6. Ram Is Going Up	✓			

MOLD goes up slow

MOLD & RAM goes up

Fixed B2, B3, B4 JR

INET Corporation Submittal 633 11175.1.05.D.3
 Submittal 634 11175.1.05.D.4

Functional Test Procedure (ATP)
 Demonstration Test Procedure (ATP)

APPENDIX-1 (Continued)

DATA SHEET

WRAP

TRU EMPTY DRUM COMPACTOR CONTROLS TEST AT WRAP
 SAFETY FEATURES/INTERLOCK CHECK

Date 10/21/96Tester GRObserver Kjebul 10/21/96

D.	Local Semi-Automatic Mode	Pass	No Pass	Problem	Action
1.	Waiting For Load Command (F1)	✓			
2.	Waiting For Crush Command (F3)	✓			
3.	Waiting For Retract Command (F5)	✓			
E.	Manual Mode Command				
1.	DCD Extending	✓			
2.	DCD Retracting	✓			
3.	Mold Is Going Up	✓			
4.	Mold Is Going Down	✓			
5.	Ram Is Going Up	✓			
6.	Ram Is Going Down <i>Crushing</i>	✓			
F.	Manual Mode Status				
1.	DCD is Already Retracted	✓			
2.	Mold Is Already Up	✓			
3.	Mold Is Already Down	✓			
4.	Ram Is Already Up	✓			
5.	Ram Is Already Down	✓			
6.	Mold Is Not Up	✓			
7.	Ram Is Not Up	✓			
8.	DCD Not Retracted	✓			
9.	DCD Already Extended	✓			

~~DCD Extending~~~~DCD Retracting~~

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Submittal 633, 11175, 1.05.D.3

Functional Test Procedure

Submittal 634, 11175, 1.05.D.4

Demonstration Test Procedure

APPENDIX-I (Continued)

DATA SHEET

WRAP

TRU EMPTY DRUM COMPACTOR CONTROLS SHOP TEST AT WRAP
SAFETY FEATURES/INTERLOCK CHECK

Date 11/7/96Tester JRObserver K111/9/96 All bad
#21,22

G.	Fault Status Messages (Continued)	Pass	No Pass	Problem	Action
	Medium Level Faults:				
fc ok	Fault 1 - Transfer Car Received With No Drum	ok at start of cycle	still logic for stop at 2nd of cycle		change Logic
2nd Aux Contact	Fault 2 - HPU Pump M.S. Not On	✓	✓	Filter Pump	rewire aux contact
1st Aux Contact	Fault 3 - HPU Fan M.S. Not On	✓			
Short Contact	Fault 4 - P1 Filter Pressure Is Too High	✓			
Short Contact	Fault 5 - P2 Filter Pressure Is Too High	✓			
Low Temp	Fault 6 - HPU Oil Temp Is Too High		✓	Fault to clear	add timer
Raise Sensor	Fault 7 - HPU Oil Is Low	✓			
Shorten Timer	Fault 8 - DCD Arms Took Too Long Retracting	✓			24sec.
Shorten Timer	Fault 9 - DCD Arms Took Too Long Extending	✓			24sec.
Shorten Timer	Fault 10 - Mold Took Too Long Going Up	✓			30sec.
Shorten Timer	Fault 11 - Mold Took Too Long Going Down	✓			30sec.
Shorten Timer	Fault 12 - Ram Took Too Long Going Up	✓			90sec.
Shorten Timer	Fault 13 - Ram Took Too Long Crushing	✓			90sec.
raise feeding Auto wait	Fault 14 - Machine Was Paused In Auto For Too Long	✓			30sec.
	High Level Faults:				
	Fault 20 - Control Power Dropped Out	✓			
	Fault 21 - PLC Low Battery				
	Fault 22 - PLC Processor Fault				
	Fault 23 - Remote Software Initiated E-Stop	✓			

fc ok ** Filter pump aux contact did not cause fault - Fixed 11/7/96 JR

fc ok 6/4/96

** Fault occurs when cooler turns on - add timer to delay

fault until cooler has had time to bring temp down Fixed 11/1/96

CENTERING PRESS. = 100 PSI WRAP

31 drums.

P10

EDC ACCEPTANCE TEST

AUTO MADE UNLESS NOTED IN "REMARKS"

GRAPH SHEET

11/2
by J. Mills

subject EMPTY DRUM COMPACTIONDate OCT. 19, 1996

TIME	DRUM	NO CLIPS	SPACING	PUCK HEIGHT (IN)	CENTER DEPT.	REMARKS
10:20	ED 1	3	90°	5 1/2	.090"	NO LOAD
	ED 2	3	90°	5 1/2	.012"	
	ED 3	2	180°	5 1/2	.013"	
10:35	ED 4	4	60°	6 1/16	.015"	CLIPS at 0°/90° GALV. DRUM
	ED 5	5	60°	6 3/8	.012"	1/2" OFF CENTER WEST
	ED 6	5	60°	5 3/4	.010"	1/2" OFF CENTER WEST
	17-C	GALV. DRUM	WALL THICKNESS	A ~ .090"	1.5mm	
	"	"	"	B ~ .082"	1.4mm	
	17-C	PAINT	"	PAINT ~ .075" (BLACK)		
	14mm, 17C	"	"	PAINT ~ .055" (BLUE)		
	WEIGH DRUMS:	GALV	ED 4	60.8 LB		
		PAINT	ED 3	54.8 LB		
		GALV.	ED 5	61.0 LB		
	CHECK SPEC SHEET - OMS FOR 17-C					
	PER	KEN KIST				NOT - GALV.
11:	ED 7	6	60°	6 1/16	.041"	PAINTED DRUMS (ED 7)
	8	4	90°	5 7/8	.041"	DRUM 1/2" OFF CENTER
	9	3	90°	5 1/16	.009"	HOLE IN TOP (2 1/2") (1 1/2")
	10	0		6 1/8	.011"	ALSO 5/16" - NO CLIP
	#			6 1/8		
1:00			LUNCH			
	11	3	90°	6 1/8		
	12	3	90°	6 1/8		
	13	3	90°	6 1/8		
	14	3	90°	5 7/8		
	15	3	90°	5 7/8		
	16	0		5 1/2		
	17	3	90°	6 1/8		
	18	3	90°	6 1/8		
	19	4	90°	6 1/8

WRAD
LDC ACCEPT TEST

P10

GRAPH SHEET

P 20

By H. MILLER

Object

Date, 19

	DRUM	No. CLIPS	SPACING	(IN) PICK LET	CENTRAL DEPR.	REMARKS
1:55	20	4	60°	6 1/2"	.009"	
	21	4	60°	6 1/2"		
	22	4	60°	5 7/8"		
	STICKED WEIGHT OF STK PICKS ABOVE = $\frac{57}{2} \times 34 \frac{1}{8} / 34 \frac{1}{2}$					
2:00	23	4	60°	6 1/8"		
	24	4	60°	5 1/2", 5 3/16"		SEMI-AUTO. MODE
2:20	25	4	60°	5 1/4", 5 1/16"	.010"	
	26	4	60°	4 13/16", 4 15/16", 5		LTC 1.3 mm
2:30	27	4	60°	5 7/16", 5 3/8"		MANUAL 3 CRUSHES
	28	4	60°	6 1/8", 6 1/8", 7 1/4"		CALIBRATED DRUMS 4X CRUSH
2:55	29	4	60°	6 3/16"		5.8 3X CRUSH
	30	2	180°	4 3/4"		
3:10	31	4	60°	7 3/16", 7 1/8"		u

Submittal 633/634

Complete Recorded Data

INET Corporation

D01.DOC

10/19/96,10:2:23,359,0,374,7	10/19/96,10:3:19,-1,0,48,2408
10/19/96,10:2:24,355,0,374,7	10/19/96,10:3:20,-1,0,48,2409
10/19/96,10:2:25,344,0,374,9	10/19/96,10:3:21,-1,0,47,2410
10/19/96,10:2:26,343,0,374,9	10/19/96,10:3:22,0,0,49,638
10/19/96,10:2:27,341,0,374,129	10/19/96,10:3:23,0,0,51,42
10/19/96,10:2:28,329,0,369,168	10/19/0,10:3:24,0,0,51,10
10/19/96,10:2:29,313,0,363,63	10/19/96,10:3:25,0,0,51,7
10/19/96,10:2:30,286,0,362,12	10/19/96,10:3:26,0,0,51,7
10/19/96,10:2:31,255,0,361,9	10/19/96,10:3:27,0,0,51,7
10/19/96,10:2:32,225,0,360,10	10/19/96,10:3:28,0,0,51,7
10/19/96,10:2:33,193,0,358,10	10/19/96,10:3:29,0,0,51,7
10/19/96,10:2:34,166,0,357,10	10/19/96,10:3:30,0,0,51,7
10/19/96,10:2:35,134,0,355,10	10/19/96,10:3:31,0,0,51,7
10/19/96,10:2:36,103,0,352,10	10/19/96,10:3:32,0,0,49,772
10/19/96,10:2:37,71,0,349,10	10/19/96,10:3:33,0,0,46,2380
10/19/96,10:2:38,41,0,344,7	10/19/96,10:3:34,0,0,45,2510
10/19/96,10:2:39,13,0,339,7	10/19/96,10:3:35,0,0,45,2517
10/19/96,10:2:40,2,0,333,229	10/19/96,10:3:36,0,0,45,2517
10/19/96,10:2:41,0,0,324,241	10/19/96,10:3:37,0,0,45,2519
10/19/96,10:2:42,0,0,318,755	10/19/96,10:3:38,0,0,45,2519
10/19/96,10:2:43,0,0,313,762	10/19/96,10:3:39,0,0,45,2519
10/19/96,10:2:44,0,0,305,695	10/19/96,10:3:40,0,0,45,2517
10/19/96,10:2:45,0,0,297,843	10/19/96,10:3:41,0,0,45,1993
10/19/96,10:2:46,0,0,287,656	10/19/96,10:3:42,12,0,45,151
10/19/96,10:2:47,0,0,278,717	10/19/96,10:3:43,40,0,46,24
10/19/96,10:2:48,0,0,269,780	10/19/96,10:3:44,85,0,47,18
10/19/96,10:2:49,0,0,260,793	10/19/96,10:3:46,129,0,48,20
10/19/96,10:2:50,0,0,251,909	10/19/96,10:3:47,177,0,48,20
10/19/96,10:2:51,0,0,243,978	10/19/96,10:3:48,220,0,51,413
10/19/96,10:2:52,0,0,233,1001	10/19/96,10:3:49,248,0,66,448
10/19/96,10:2:53,0,0,223,802	10/19/96,10:3:50,274,0,80,371
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10/21/96,14:52:54,0,0,137,1538	10/21/96,14:53:50,362,0,300,495
10/21/96,14:52:55,-1,0,129,1542	10/21/96,14:53:51,362,0,316,502
10/21/96,14:52:56,-1,0,120,1681	10/21/96,14:53:52,362,0,332,508
10/21/96,14:52:57,-1,0,111,1868	10/21/96,14:53:53,362,0,349,514
10/21/96,14:52:58,-1,0,102,2023	10/21/96,14:53:54,362,0,366,397
10/21/96,14:52:59,-1,0,93,2220	10/21/96,14:53:55,362,0,372,30
10/21/96,14:53:0,-1,0,88,2304	10/21/96,14:53:56,362,0,373,7
10/21/96,14:53:1,-1,0,85,2295	
10/21/96,14:53:2,-1,0,84,2300	
10/21/96,14:53:3,-1,0,82,2315	
10/21/96,14:53:4,-1,0,80,2364	
10/21/96,14:53:5,-1,0,79,2381	
10/21/96,14:53:6,-1,0,78,2385	
10/21/96,14:53:7,-1,0,78,2386	
10/21/96,14:53:8,-1,0,77,2389	

WRAP ACCEPTANCE TEST PROCEDURE
EXCEPTION LOG

HNF-SD-W026-ATR-030, Rev. 0, Page 90
HNF-SD-W026-ATR-030, Rev 0 Page 90

Tracking #: 456

ATP_YN : N

ICF KEH ATP# :

Exception : 1

Test : Empty Drum
Compactor

Revision :

Step : III Fig 3.2

Equipment Tag #: 107-HU-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator :

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

Sensor wiring on HPV not sheathed in conduit.

Exception Disposition :

Review spec. and update as required in the field.

Exception Status :

Exception Closed By :

Date :

APPROVAL OF RESOLUTION

Contractor Representative: _____ Date: _____

WHC Projects Representative: _____ Date: _____

WHC NFS Representative: _____ Date: _____

NFS = New Facility Startup

ICF KEH Representative: _____ Date: _____

EXCEPTION LOG

Tracking #: 457

ATP_YN : N

ICF KEH ATP# :

Exception : 2

Test : Empty Drum
Compactor

Revision :

Step : F-7 Interlock 5 Equipment Tag #: 107-HU-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator :

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

"Mold shall be interlocked to ensure that it cannot crush a drum not centered." Interlock is provided only by "DCD not fully extended" permissive and only works in auto mode.

Exception Disposition :

Add a mechanical switch to ensure interlock operation in auto, semi-auto modes.

Exception Status :

Not a specification requirement. JFR 11/20/96

Exception Closed By :

Date :

11/20/96

APPROVAL OF RESOLUTION

Contractor Representative:

Date: 11-20-96

WHC Projects Representative:

Date: 11/20/96

WHC NFS Representative:

Date:

NFS = New Facility Startup

ICF KEH Representative:

Date: 12/4/96

WRAP ACCEPTANCE TEST PROCEDURE
EXCEPT. ON LOG

Tracking #: 458

ATP_YN : N

ICF KEH ATP# :

Exception : 3

Test : Empty Drum
Compactor

Revision :

Step : F-7 Interlock 4 Equipment Tag #: 107-HU-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator :

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

Compaction cycle cannot commence without permissive signal from PCS" interlock was not tested.

Exception Disposition :

Test in field.

Exception Status :

Tested in Field and closed.

Exception Closed By :

Randolph Heid

Date :

11/20/96

APPROVAL OF RESOLUTION

Contractor Representative:

[Signature]

Date:

11/20/96

WHC Projects Representative:

Randolph Heid

Date:

11/20/96

WHC NFS Representative:

NFS = New Facility Startup

Date:

ICF KEH Representative:

Paul S. McElroy

Date:

12/4/96

WRAP ACCEPTANCE TEST PROCEDURE EXCEPTION LOG

Tracking #: 459

ATP_YN : N ICF KEH ATP# :

Test : Empty Drum
Compactor

Exception : 4

Revision :

Step : F-7 Interlock 3 Equipment Tag #: 107-HU-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator:

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

"DCD cannot be actuated unless mold fully raised." Interlock does not operate in manual mode.

Exception Disposition :

Reprogram to operate in manual mode.

Exception Status :

Software modified & tested in field.

Exception Closed By :

Kendall Hunt

Date :

11/20/96

APPROVAL OF RESOLUTION

Contractor Representative:

[Signature]

Date: *11-20-96*

WHC Projects Representative:

Kendall Hunt

Date: *11/20/96*

WHC NFS Representative:

NFS = New Facility Startup

Date:

ICF KEH Representative:

Paul S. McElroy

Date: *12/4/96*

WRAP ACCEPTANCE TEST PROCEDURE
EXCEPTION LOG

Tracking #: 460

ATP_YN : N ICF KEH ATP# :

Test : Empty Drum
Compactor

Exception : 5

Revision :

Step : F-7 Interlock 2 Equipment Tag #: 107-HU-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator:

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

The interlock which "RAM cannot be lowered until mold is fully lowered" operates only in auto mode.

Exception Disposition :

Reprogram to operate in semi-auto mode.

Exception Status :

Reprogrammed to require password to lower Ram past mold in manual mode.
Demonstrated in Field.

Exception Closed By :

Kathleen Linklater

Date :

11/20/96

APPROVAL OF RESOLUTION

Contractor Representative:

Greg Jones

Date:

11/20/96

WHC Projects Representative:

Kathleen Linklater

Date:

11/20/96

WHC NFS Representative:

NFS = New Facility Startup

Date:

ICF KEH Representative:

Paul S. McElmury

Date:

12/4/96

WRAP ACCEPTANCE TEST PROCEDURE
EXCEPT ION LOG

Tracking #: 461

ATP_YN : N ICF KEH ATP# :

Test : Empty Drum
Compactor

Exception : 6

Revision :

Step : F-7 Interlock 1 Equipment Tag #: 107-HU-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator :

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

The interlock where the "mold cannot be lowered beyond point where top of drum enters mold while DCD is energized" does not work in manual mode.

Exception Disposition :

Reprogram the interlock in manual mode.

Exception Status :

Software modified and demonstrated in field

Exception Closed By :

Date :

APPROVAL OF RESOLUTION

Contractor Representative:

Date: 11-20-96

WHC Projects Representative:

Date: 11/20/96

WHC NFS Representative:

Date:

NFS = New Facility Startup

ICF KEH Representative:

Date: 12/4/96

WRAP ACCEPTANCE TEST PROCEDURE
EXCEP: ON LOG

Tracking #: 462

ATP_YN : N

ICF KEH ATP# :

Test : Empty Drum
Compactor

Exception : 7

Revision :

Step : F-7 Fault 23

Equipment Tag #: 107-HU-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator:

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

Fault 23 (Remote Software Initiated E-stop) not tested.

Exception Disposition :

Test on site.

Exception Status :

Demonstrated in Field.

Exception Closed By :

Richard Leist

Date :

11/20/96

APPROVAL OF RESOLUTION

Contractor Representative:

[Signature]

Date: *11/20/96*

WHC Projects Representative:

Richard Leist

Date: *11/20/96*

WHC NFS Representative:

NFS = New Facility Startup

Date: _____

ICF KEH Representative:

Paul S. MSL

Date: *12/9/96*

WRAP ACCEPTANCE TEST PROCEDURE EXCEPTION LOG

Tracking #: 463

ATP_YN : N

ICF KEH ATP# :

Exception : 8

Test : Empty Drum
Compactor

Revision :

Step : F-7 Fault 22 Equipment Tag #: 107-HU-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator:

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

Fault 22 (PLC Processor Fault) cannot be tested without adding a processor fault.

Exception Disposition :

Do not test.

Exception Status :

Demonstrated active logic monitoring this fault and Allen Bradley logic documentation

Exception Closed By :

Kerolick

Date :

11/20/96

APPROVAL OF RESOLUTION

Contractor Representative:

[Signature]

Date: *11-20-96*

WHC Projects Representative:

Kerolick

Date: *11/20/96*

WHC NFS Representative:

NFS = New Facility Startup

Date:

ICF KEH Representative:

Paul S. McElroy

Date:

12/4/96

WRAP ACCEPTANCE TEST PROCEDURE EXCEPTION LOG

Tracking #: 464

ATP_YN : N

ICF KEH ATP#:

Test : Empty Drum
Compactor

Exception : 9

Revision :

Step : F-7 Fault 21

Equipment Tag #: 107-HU-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator:

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

Fault 21 not tested. Test not possible without putting a dead battery into the PLC.

Exception Disposition :

Do not test.

Exception Status :

Demonstrated active logic monitoring and Allen Bradley logic documentation.

Exception Closed By :

Rachel J. Hest

Date :

11/20/96

APPROVAL OF RESOLUTION

Contractor Representative:

[Signature]

Date: *11/20/96*

WHC Projects Representative:

Rachel J. Hest

Date: *11/20/96*

WHC NFS Representative:

Date:

NFS = New Facility Startup

ICF KEH Representative:

Paul S. MESSinger

Date:

12/9/96

9:36:26 AM, 7/30/96

WRAP ACCEPTANCE TEST PROCEDURE
EXCEPTION LOG

Tracking #: 465

ATP_YN : N

ICF KEH ATP# :

Test : Empty Drum
Compactor

Exception : 10

Revision :

Step : Fig 7.1.H.7

Equipment Tag #: 107-HU-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator:

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

The "DCD is not retracted" message is not demonstrated.

Exception Disposition :

Reprogram the message and demonstrate in the ATP.

Exception Status :

Demonstrated in Field

Exception Closed By :

Kadell Hand

Date :

11/20/96

APPROVAL OF RESOLUTION

Contractor Representative:

[Signature]

Date: *11-20-96*

WHC Projects Representative:

Kadell Hand

Date: *11/20/96*

WHC NFS Representative:

NFS = New Facility Startup

Date: _____

ICF KEH Representative:

Paul S. McElroy

Date: *12/9/96*

ATP_YN : N ICF KEH ATP# :

Test : Empty Drum
Compactor

Exception : 12

Revision :

Step : Fig 7.1.H.5 Equipment Tag #: 107-HU-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator:

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

The "RAM is already down" message is not demonstrated.

Exception Disposition :

Reprogram the message and demonstrate in the ATP.

Exception Status :

PLC reprogrammed JGR 11/20/96

Exception Closed By :

Rodney Hunt

Date :

11/20/96

APPROVAL OF RESOLUTION

Contractor Representative:

Harry

Date: 11/20/96

WHC Projects Representative:

Rodney Hunt

Date: 11/20/96

WHC NFS Representative:

NFS = New Facility Startup

Date:

ICF KEH Representative:

Paul S. McElroy

Date: 12/4/96

EXCEPTION LOG

Tracking #: 468

ATP_YN : N

ICF KEH ATP# :

Exception : 13

Test : Empty Drum
Compactor

Revision :

Step : Fig 7.1.B.4

Equipment Tag #: 107-HU-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator:

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

The "RAM is not up" interlock/message is not demonstrated.

Exception Disposition :

Incorporate the interlock and message. Demonstrate in the ATP.

Exception Status :

Demonstrated in Field

Exception Closed By :

Kendrick Hunt

Date :

11/20/96

APPROVAL OF RESOLUTION

Contractor Representative:

Greg

Date: 11/20/96

WHC Projects Representative:

Kendrick Hunt

Date: 11/22/96

WHC NFS Representative:

NFS = New Facility Startup

Date: _____

ICF KEH Representative:

Paul S. McElroy

Date: 12/4/96

WRAP ACCEPTANCE TEST PROCEDURE
EXCEPTION LOG

Tracking #: 469

ATP_YN : N ICF KEH ATP# :

Test : Empty Drum
Compactor

Exception : 14

Revision :

Step : Fig 7.1.B.2 Equipment Tag #: 107-HU-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator :

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

"DCD not retracted" message not demonstrated.

Exception Disposition :

Program the message into the software and demonstrate in the field.

Exception Status :

Demonstrated in Field

Exception Closed By :

Kendall J. Hunt

Date :

11/20/96

APPROVAL OF RESOLUTION

Contractor Representative:

[Signature]

Date: *11/20/96*

WHC Projects Representative:

Kendall J. Hunt

Date: *11/20/96*

WHC NFS Representative:

NFS = New Facility Startup

Date: _____

ICF KEH Representative:

Paul S. McElroy

Date: *12/4/96*

ATP_YN : N

ICF KEH ATP# :

Exception : 15

Test : Empty Drum
Compactor

Revision :

Step : Fig 7.I.A.10

Equipment Tag #: 107-HU-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator:

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

Remote mode not demonstrated.

Exception Disposition :

Test, demonstrate in the field.

Exception Status :

Demonstrated in Field

Exception Closed By :

Randall Hunt

Date :

11/20/96

APPROVAL OF RESOLUTION

Contractor Representative:

[Signature]

Date: *11/20/96*

WHC Projects Representative:

Randall Hunt

Date: *11/20/96*

WHC NFS Representative:

NFS = New Facility Startup

Date: _____

ICF KEH Representative:

Paul S. Messing

Date: *12/4/96*

WRAP ACCEPTANCE TEST PROCEDURE EXCEPT ION LOG

Tracking #: 471

ATP_YN : N ICF KEH ATP# :

Test : Empty Drum
Compactor

Exception : 16

Revision :

Step : Fig 7.I.A.9 Equipment Tag #: 107-HU-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator:

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

Remote set-up mode not tested.

Exception Disposition :

Demonstrate in the field as part of Spec 13021 ATP.

Exception Status :

*PCL Responsibility - Not INET
Required not in spec.*

Exception Closed By :

Robert J. Hart

Date :

11/20/96

APPROVAL OF RESOLUTION

Contractor Representative:

[Signature]

Date: *12-4-96*

WHC Projects Representative:

Robert J. Hart

Date: *11/20/96*

WHC NFS Representative:

NFS = New Facility Startup

Date: _____

ICF KEH Representative:

Paul S. McElroy

Date: *12-9-96*

WRAP ACCEPTANCE TEST PROCEDURE EXCEPT N LOG

Tracking #: 472

ATP_YN : N

ICF KEH ATP# :

Exception : 17

Test : Empty Drum
Compactor

Revision :

Step : Fig 7.1.A.8

Equipment Tag #: 107-HU-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator :

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

Auto mode does not provide the "Double Crush" crushing method developed during testing.

Exception Disposition :

Revise the operating software to incorporate the "Double Crush" feature. Once complete, demonstrate the mode function as part of the ATP.

Exception Status :

Software modified and demonstrated in Field

Exception Closed By :

Keshuk Jha

Date :

11/20/96

APPROVAL OF RESOLUTION

Contractor Representative :

[Signature]

Date: *11-20-96*

WHC Projects Representative :

Keshuk Jha

Date: *11/21/96*

WHC NFS Representative :

Date: _____

NFS = New Facility Startup

ICF KEH Representative :

Paul S. Messinger

Date: *12/4/96*

WRAP ACCEPTANCE TEST PROCEDURE EXCEPTION LOG

Tracking #: 473

ATP_YN: N

ICF KEH ATP#:

Exception : 18

Test : Empty Drum
Compactor

Revision :

Step : Sec III Fig 3.8 Equipment Tag #: 107-HU-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator:

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

Noise abatement not performed.

Exception Disposition :

Perform in field.

Exception Status :

Demonstrated in Field - noted in ATP. J. Hunt
70dB @ 3 ft. Will be Substantiated with ATR

Exception Closed By :

Kendall J. Hunt

Date : 11/20/96

APPROVAL OF RESOLUTION

Contractor Representative:

[Signature]

Date: 11/20/96

WHC Projects Representative:

Kendall J. Hunt

Date: 11/20/96

WHC NFS Representative:

NFS = New Facility Startup

Date:

ICF KEH Representative:

Paul S. McElroy

Date: 12/1/96

ATP_YN : N

ICF KEH ATP# :

Exception : 19

Test : Empty Drum
Compactor

Revision :

Step : Fig 6

Equipment Tag #: 107-CM-07-303

Specification Section : 11175

Test Witness/Author : Leist

Test Operator:

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

Access for lubrication of the mold wheels and the drum centering device is not defined.

Exception Disposition :

Define lubrication needs, an if lubrication is required, determine the method to perform the lubrication.

Exception Status :

Lubrication was completed 11/20/96. No further lubrication is required, per 11/23/96
Reference 11/23/96 letter to Ken Leist which states the above. Letter to be submitted
as 637.1

Exception Closed By :

Randall J. Smith

Date :

12/4/96

APPROVAL OF RESOLUTION

Contractor Representative:

Greg Lin

Date:

12-4-96

WHC Projects Representative:

Randall J. Smith

Date:

12/4/96

WHC NFS Representative:

NFS = New Facility Startup

Date:

ICF KEH Representative:

Bruce Young
Paul M. Elmy

Date:

11-23-96
12-4-96

WRAP ACCEPTANCE TEST PROCEDURE
EXCEPT ICF KEH ATP# :

Tracking #: 475

ATP_YN : N

ICF KEH ATP# :

Test : Empty Drum
Compactor

Exception : 20

Revision :

Step : Fig 6

Equipment Tag #: 107-CM-07-303

Specification Section : 11175

Test Witness/Author : Leist

Test Operator:

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

RAM, mold position switches are attached with small fasteners.

Exception Disposition :

Replace the fasteners with types which can be assembled, disassembled with gloves.

Exception Status :

Fastener design demonstrated and approved. Fastener design to be detailed on the drawings and included with design package.

Exception Closed By :

Kirkland J. V.

Date :

11/22/96

APPROVAL OF RESOLUTION

Contractor Representative:

[Signature]

Date: *12-3-96*

WHC Projects Representative:

Kirkland J. V.

Date: *7/1/22/96*

WHC NFS Representative:

NFS = New Facility Startup

Date:

ICF KEH Representative:

Paul S. McElhenny

Date: *12/4/96*

WRAP ACCEPTANCE TEST PROCEDURE
EXCEP: ON LOG

Tracking #: 476

ATP_YN : N ICF KEH ATP# :

Test : Empty Drum
Compactor

Exception : 21

Revision :

Step : Fig 6 Equipment Tag #: 107-CM-07-303

Specification Section : 11175

Test Witness/Author : Leist

Test Operator :

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

The drum centering device switches and the drum present sensor are not visible through the workstation windows.

Exception Disposition :

Revise the attachment method to permit sensor attachment, adjustment, and replacement through the workstation gloves.

Exception Status :

Fastener design demonstrated and approved and used from glove ports.

Exception Closed By :

Randall J. Hunt

Date :

11/22/96

APPROVAL OF RESOLUTION

Contractor Representative:

Henry J. Hunt

Date: *12-3-96*

WHC Projects Representative:

Randall J. Hunt

Date: *11/22/96*

WHC NFS Representative:

NFS = New Facility Startup

Date: _____

ICF KEH Representative:

Paul S. McElhenny

Date: *12/4/96*

WRAP ACCEPTANCE TEST PROCEDURE
EXCEPTION LOG

Tracking #: 477

ATP_YN : N

ICF KEH ATP# :

Exception : 22

Test : Empty Drum
Compactor

Revision :

Step : II Fig 2

Equipment Tag #: 107-HV-07-304

Specification Section : 11175

Test Witness/Author : Leist

Test Operator:

Responsible Company: PCL

Responsible Subcontractor : INET

Responsible Individual: Linklater

Exception Description :

The HPV test was not completed.

Exception Disposition :

This test will be performed in the field.

Exception Status :

Part a) is complete.
Test was performed on 11-23-96 (see attached) Ram pressure
was tested at 3000 PSI. (Bj) JLP

Exception Closed By :

Date :

APPROVAL OF RESOLUTION

Contractor Representative: _____

Date: _____

WHC Projects Representative: _____

Date: _____

WHC NFS Representative: _____

Date: _____

NFS = New Facility Startup

ICF KEH Representative: _____

Date: _____

9:36:26 AM, 7/30/96

WRAP ACCEPTANCE TEST PROCEDURE - EXCEPTION LOG

Tracking #:

ATP_YN: ICF KEH ATP#:

Test:

Exception:

Step: Equipment Tag #:

Revision:

Specification Section:

Test Witness/Author:

Test Operator:

Responsible Company:

Responsible Subcontractor:

Responsible Individual:

Exception Description:

EDC RAM Position Sensor with spring-loaded wire. Spool is not accurate enough

Exception Disposition:

INET replaced sensor with ultrasonic sensor

Exception Status:

Sensor installed, tested and calibrated

Exception Closed By:

Date: 4/11/97

APPROVAL OF RESOLUTION

Contractor Representative:

Gene Rin INET Corporation

Date: 4/11/97

WHC Projects Representative:

Date:

WHC NFS Representative:

Date: 4/11/97

NFS = New Facility Startup

ICF KEH Representative:

Date: