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Project Title/Work Order Assembly Procedure for Column Cutting Platform		EDT No. 609371 ECN No. NA

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MAR 16 1995

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1. EDT

609371

2. To: (Receiving Organization) Distribution		3. From: (Originating Organization) Special Projects 71650/N2B2K		4. Related EDT No.: NA	
5. Proj./Prog./Dept./Div.: Equipment Removal System		6. Cog. Engr.: M. J. Ostrom		7. Purchase Order No.: NA	
8. Originator Remarks: This supporting document describes the assembly procedure for the Column Cutting Platform and Elevation Support.				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:	

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	WHC-SD-WM-DA-184 3/15/95 WHC-SD-WM-PROC-018		0	Assembly Procedure, Column Cutting Platform		1	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	

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1	1	Cog. Mgr. CE Hanson	<i>CE Hanson</i>	3/14/95	H5-09				
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18. <i>Mike J. Ostrom</i> MJ Ostrom Signature of EDT Originator Date 3-6-95		19. <i>CE Hanson</i> CE Hanson Authorized Representative for Receiving Organization Date 3/14/95		20. <i>CE Hanson</i> CE Hanson Cognizant Manager Date 3/14/95		21. DOE APPROVAL (if required) Ctrl. No. ☐ Approved ☐ Approved w/comments ☐ Disapproved w/comments	
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BD-7400-172-2 (04/94) GEF097

BD-7400-172-1

RELEASE AUTHORIZATION

Document Number: WHC-SD-WM-PROC-018, Rev. 0

Document Title: Assembly Procedure for Column Cutting Platform

Release Date: 3/16/95

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

APPROVED FOR PUBLIC RELEASE

WHC Information Release Administration Specialist:

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3/16/95

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SUPPORTING DOCUMENT		1. Total Pages 6
2. Title Assembly Procedure for Column Cutting Platform	3. Number WHC-SD-WM-PROC-018 WHC-SD-WM-DA-184	4. Rev No. 0
5. Key Words assembly procedure column cutting 241SY101 pump removal	6. Author Name: R. D. Routh <i>R.D. Routh</i> Signature Organization/Charge Code 71650/N2B2K	
7. Abstract This supporting document describes the assembly procedure for the Column Cutting Platform and Elevation Support. The Column Cutting Platform is a component of the 241-SY-101 Equipment Removal System. It is set up on the deck of the Strongback Trailer to provide work access to cut off the upper portion of the Mitigation Pump Assembly (MPA). The Elevation Support provides support for the front of the Storage Container with the Strongback at an inclined position.		
8. RELEASE STAMP <div style="border: 1px solid black; padding: 10px; text-align: center;">OFFICIAL RELEASE BY WHC DATE MAR 16 1995</div>		

ASSEMBLY PROCEDURE
FOR
COLUMN CUTTING PLATFORM

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ASSEMBLY PROCEDURE FOR COLUMN CUTTING PLATFORM

1.0 INTRODUCTION

This supporting document describes the assembly procedure for the Column Cutting Platform and Elevation Support. The Column Cutting Platform is a component of the 241SY101 Equipment Removal System. It is set up on the deck of the Strongback Trailer to provide work access to cut off the upper portion of the Mitigation Pump Assembly (MPA). The Elevation Support provides support for the front of the Storage Container with the Storage Container and Strongback at an inclined position. The upper portion of the MPA must be cut off to install the Containment Caps on the Storage Container. The Storage Container must be maintained in an inclined position until the Containment Caps are installed to prevent any residual liquids from migrating forward in the Storage Container.

2.0 SUMMARY OF RESULTS

The Column Cutting Platform components and assembly are shown on the drawing H-2-83755, *64" Diameter Transport Assembly Removal Support* (WHC, 1994b). The structural design analysis for the Column Cutting Platform is located in Supporting Document WHC-SD-WM-DA-168. The Column Cutting Platform has been assembled and used in mock-up testing in accordance with the *Operability Test Procedure, 241SY101 Equipment Removal System* (WHC, 1994a).

3.0 DISCUSSION

Prior to assembling the Column Cutting Platform, verify all components shown on the drawing H-2-83755 are on hand. Inspect components for visible damage. Do not proceed with assembly if any component is damaged. Verify the threaded portion of bolts are clean and undamaged. Do not add lubricant to the bolt threads beyond the as-delivered condition from the manufacturer.

Hoisting and rigging of Column Cutting Platform components is conducted in accordance with *Hanford Site Hoisting and Rigging Manual* (DOE-RL 1993). Protection of personnel assembling the Column Cutting Platform is provided in accordance with the *Industrial Safety Manual* (WHC 1992).

4.0 SYSTEM DESCRIPTION

The Column Cutting Platform and Elevation Support are assembled and installed according to the following procedure. (All bolting should be ASTM A-325 material, "snug tight" and can be reused at the engineer's discretion.)

- 1) Rig the two (2) 15/16-inch lifting holes on the Elevation Support.
- 2) Lift the Elevation Support onto the front lateral support on the Hydraulic Trailer. Align the eight (8) bolt holes on the Elevation Support with the eight (8) bolt holes on the mounting plates on the front lateral support. Insert eight (8) 1-8 UNC 2A x 2-1/4 bolts in the aligned tapped bolt holes. Tighten the bolts snug tight.
- 3) Align the bolt hole in the top of each of the two (2) L3x3x5/16 angle braces with the bolt hole in each of the two (2) mounting plates on the Elevation Support. Insert two (2) 3/4-10 UNC 2A x 2-1/4 bolts with 3/4-inch flat washers through the aligned holes. Secure the bolts with 3/4-10 UNC 2B nuts and 3/4-inch flat washers. Do not tighten the bolts.
- 4) Align the front bolt holes in the mounting feet of each of the two (2) angle braces with the two (2) bolt holes in the Hydraulic Trailer deck, on the edge of the two (2) W30x191 Trailer beams. Insert four (4) 3/4-10 UNC 2A x 2-1/4 bolts with 3/4-inch flat washers through the aligned holes. Secure the bolts with 3/4-10 UNC 2B nuts and 3/4-inch flat washers. Tighten all six (6) angle brace bolts snug tight.
- 5) Erect scaffolding, railings and ladder in the configuration shown on the drawing H-2-83755. Secure scaffolding to Hydraulic Trailer using tie-down straps attached to D-rings on front and sides of Hydraulic Trailer.

NOTE: Container shall rest on the Elevation Support during transportation.

5.0 REFERENCES

- DOE-RL, 1993, *Hanford Site Hoisting and Rigging Manual*, DOE-RL-92-36, U. S. Department of Energy Richland Field Office, Washington.
- WHC, 1992, *Industrial Safety Manual*, WHC-CM-4-3, Westinghouse Hanford Company, Richland, Washington.
- WHC, 1994a, *Operability Test Procedure 241SY101 Equipment Removal System*, WHC-SD-WM-OTP-168, Westinghouse Hanford Company, Richland, Washington.
- WHC, 1994b, *64" Diameter Transport Assembly Removal Support*, drawing H-2-83755, Westinghouse Hanford Company, Richland, Washington.