

August 28, 1981  
L-81-374

Office of Nuclear Reactor Regulation  
Attention: Mr. Darrell G. Eisenhut, Director  
Division of Licensing  
U. S. Nuclear Regulatory Commission  
Washington, D. C. 20555

Dear Mr. Eisenhut:

RE: Turkey Point Units 3 & 4  
Docket Nos. 50-250 & 50-251  
Steam Generator Repair Project -  
Special License Conditions

Please find attached the following documents relating to removal of the used steam generator lower assemblies from the Turkey Point Unit #3 Containment Building:

Process Sheet #81-236,	Rev. 0
Process Sheet #81-237,	Rev. 0
Process Sheet #81-238,	Rev. 0
Bechtel FSK-C-210,	Rev. 0
Bechtel FSK-C-211,	Rev. 0
Bechtel FSK-C-212,	Rev. 0
Bechtel FSK-C-213,	Rev. 0
Bechtel FSK-C-214,	Rev. 0
Bechtel FSK-C-215,	Rev. 0
Bechtel FSK-C-216,	Rev. 0
Bechtel FSK-C-219,	Rev. 0
Bechtel FSK-C-220,	Rev. 0
Bechtel FSK-C-221,	Rev. 0
Bechtel FSK-C-222,	Rev. 0



These documents are being submitted to you in accordance with the requirements of the "Special License Conditions," Section 9, of Amendment No. 69 to Facility Operating License No. DPR-31 and Amendment No. 61 to Facility Operating License No. DPR-41. Section 9 of the "Special License Conditions" requires submittal of this information prior to movement of the used steam generator lower assemblies (SGLA) from the containment building. The present Construction Schedule shows removal of the first used SGLA from containment occurring on or around October 1, 1981.

Very truly yours,

Robert E. Uhrig  
Vice President  
Advanced Systems & Technology

REU/JEM/ras

cc: Mr. J. P. O'Reilly, Region II  
Harold F. Reis, Esquire

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S111

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PDR ADDCK 05000250  
PDR

PROCESS  
SHEET



P.S. No. 81-236

Unit 3

PCM 77-54B

CWO A-189

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System STEAM GENERATOR LOWER ASSEMBLY "A"

Safety Related ☐

Non-Safety Related ☒

PREPARED BY

DATE

EST. START DATE

BLDG

AREA

ELEV

G. W. Stokes

7-15-81

SCOPE

LOWER ASSEMBLY REMOVAL, TRANSPORTING, PLACING IN STORAGE

SEQUENCING  
REQUIRED

Yes

No

☒

☐

REV	DATE	REV. DESCRIPTION	PFE	QC	QA	CS	PNSC	REV	DATE	REV. DESCRIPTION	PFE	QC	QA	CS	PNSC
0	7-23-81	Issued for construction													

ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	* INSP POINTS	PFE	DATE	QC	DATE
	<p>This Process Sheet details the procedure by which the Steam Generator Lower Assembly will be removed from its installed position to outside the containment onto a Lowboy, transported to storage compound, and placed inside.</p> <p>PREREQUISITES</p> <p>1.0 Nuclear Plant Supervisor authorization to commence work.</p> <p>Signature _____ Date _____</p> <p>2.0 Verify PC/M has been reviewed and approved.</p> <p>3.0 Verify R.W.P. has been issued.</p>	<div>PRELIMINARY</div>						

WORK COMPLETED  
& PS CLOSED:

PFE

DATE

QC

DATE

CS

DATE

## PROCESS SHEET

PS No. 81-236

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ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	* INSP POINTS	PFE	DATE	QC	DATE
4.0	Verify storage compound or laydown area ready to receive lower assembly.			S			N/A	
5.0	Verify back fill of ramp is complete.	5177-074-C-6		S			N/A	
6.0	Verify concrete ramp is complete.	5177-074-C-64		S			N/A	
7.0	Verify equipment hatch modification complete.	5177-074-C-70		S			N/A	
8.0	Verify transfer bridge steel installed and complete.	5177-074-C-71		S			N/A	
9.0	Verify structural steel and micellaneous steel removal complete.	5177-074-C-28		S				
10.0	Verify concrete removal complete enough for steam generator removal.	5177-074-C-27		S				
11.0	Ensure transporting system is in proper working order, braking system, tire pressure.			S				
12.0	Verify steam generator insulation removed and exterior surface deconed.			S				
13.0	Verify instrument lines and small pipe have been disconnected.			S				

ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	* INSP POINTS	PFE	DATE	QC	DATE
14.0	Ensure adequate clearance through the containment. Check Pettibone clearance.			S			N/A	
15.0	Inspect and verify rigging equipment is in proper condition - Hillman rollers, up ending skid, spreader beam, winch cables, slings, shackles, jacking equipment, low profile saddles and snatch blocks.			S			N/A	
15.1	Verify spreader beam has been load tested, 110% of lift weight.			H			N/A	
16.0	Verify top cover plate has been installed and accepted.	5177-074-P-310		H			N/A	
17.0	Verify lifting lugs have been installed on top cover plate and M.T.'d.	FSK-C-219		H			N/A	
18.0	Verify scaffolding and enclosure panels are clear for lifting steam generator.			S			N/A	
19.0	Verify steam generator seismic ring girder will lift free.			S			N/A	
20.0	Verify the Polar crane has had a pre-lift inspection and run in performed.			S			N/A	
21.0	Lower girth cutting operation will notify rigging superintendent for appropriate time to connect rigging to lower assembly.			S			N/A	

## PROCESS SHEET

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ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	* INSP POINTS	PFE	DATE	QC	DATE
	WORK ACTIVITIES							
22.0	Bolt trunnion flanges and connect rigging to steam generator lower assembly, hoist rigging until slings are snug.	FSK-C-210 FSK-C-168		S			N/A	
23.0	Verify the spreader beam is level and the rigging is plumb, snug up the bolts on the latch plates.			S			N/A	
24.0	Establish voice communications between flagman and polar crane operator.			S			N/A	
25.0	Take a strain on load recheck rigging, verify the slings are properly seated.			S			N/A	
26.0	Cutting shall provide shims in open cut to prevent gap from re-sealing.			S			N/A	
27.0	Once cut is complete lift steam generator a few inches above channel head and install Herculite over bottom of steam generator.			S			N/A	
28.0	Clear all personnel from lifting zone, except for those doing actual rigging operation. Notify safety and H.P.			S			N/A	
29.0	Hoist steam generator so ring girder clears top of shield wall at El. 68'. Cut ring girder, unbolt and remove from lower assembly.	5177-074-C-42 P.S. 81-239		S			N/A	

## PROCESS SHEET

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ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PFE	DATE	QC	DATE
30.0	Hoist steam generator above all obstacles and move it into position over top of bottom cover plate.			S			N/A	
31.0	Lower steam generator down within a few inches of cover plate.			S			N/A	
32.0	Cover plate to be on three pieces of wood cribbing. Lower steam generator down until wood begins to crush then stop. Protect wood with Raficell.			S			N/A	
33.0	Weld out bottom cover plate. Verify installation complete.	5177-074-P-310		H			N/A	
34.0	Move lower assembly into position and install Westinghouse up ending skid. Verify installation is correct.	Westinghouse DWG. 1600E61		H			N/A	
35.0	Hoist steam generator and move it in line with a 18" center line of E.Q. hatch.			S			N/A	
36.0	By means of trolley, transport steam generator to end of bridge girders (crane stops). Lower steam generator within about 2 feet of transfer bridge.	FSK-C-211		S			N/A	
37.0	Hook four part line to up ending skid.	FSK-C-211 FSK-C-221		S			N/A	

## PROCESS SHEET

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ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PFE	DATE	QC	DATE
38.0	Pull steam generator over transfer bridge and lower down onto bridge.	FSK-C-211		S			N/A	
39.0	Travel with trolley toward center of bridge and lower with Polar crane hook. Use four part line to pull steam generator through hatch.	FSK-C-212		S			N/A	
40.0	Place 1" plate, Hillman rollers, and restriction bar at equipment hatch.	FSK-C-212 FSK-C-222		S			N/A	
41.0	Pull steam generator through E.Q. hatch onto Hillman rollers. Remove restriction bar and continue pulling.	FSK-C-212 FSK-C-213		S			N/A	
42.0	Once steam generator top cover plate is at edge of slab at 30'-6" stop pulling, lower steam generator onto cribbing at 30'-6".	FSK-C-213		S			N/A	
43.0	Remove rigging from trunnions and shackle into lifting lugs on top cover plate.	FSK-C-213		S			N/A	
44.0	With Polar crane, lift steam generator off cribbing at El. 30'-6", continue pulling with four part line until steam generator center of gravity is approximately 8' from outside face of containment wall.	FSK-C-214		S			N/A	
45.0	Lower top shield plate onto cribbing on transfer bridge. Disconnect four part line.	FSK-C-214		S			N/A	

## PROCESS SHEET

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ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PFE	DATE	QC	DATE
46.0	Pick bottom of steam generator with 300 ton P & H crane and place on cribbing.	FSK-C-214		S			N/A	
47.0	Remove Westinghouse up ending skid and install Westinghouse low profile saddles, spacer beam, and Hillman roller.	FSK-C-214 FSK-C-222		S			N/A	
48.0	Verify low profile saddles have been installed properly.			S			N/A	
49.0	Pick bottom of steam generator with 300 ton P & H crane, remove cribbing, lower steam generator onto saddles. Check alignment of steam generator in hatch. Pre-position if necessary. Disconnect Polar crane.	FSK-C-214		S			N/A	
50.0	Hook four part line to pulling lugs on front of low profile saddles. Continue pulling steam generator until center of gravity is approximately 14' from edge of slab.	FSK-C-214		S			N/A	
51.0	Disconnect four part line from saddle, rig steam generator for picking up with 300 ton P & H crane.	FSK-C-214		S			N/A	
52.0	Position 300 ton P & H crane and Talbert trailer as shown.	FSK-C-216		S			N/A	
53.0	Take strain on the load and check rigging, sling seated, rigging plumb, pick steam generator from slab.							



## PROCESS SHEET

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ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	* INSP POINTS	PFE	DATE	QC	DATE
Cond't 53.0	place steam generator on Talbert trailer.	FSK-C-214 FSK-C-215 FSK-C-216		S			N/A	
54.0	Tie steam generator down to Talbert trailer and check.	FSK-C-215		S			N/A	
56.0	Verify tie down arrangement of steam generator.	FSK-C-215		S			N/A	
57.0	Transport steam generator over east haul road to steam generator storage compound or laydown area.			S			N/A	
58.0	Travel shall be controlled, speed maintained less than 5 M.P.H.			S			N/A	
59.0	Walk 300 ton P & H crane to storage compound.			S			N/A	
60.0	Set up Talbert trailer and P & H crane for unloading as shown.	FSK-C-216		S			N/A	
61.0	Rig steam generator for lifting with P & H crane and snug up rigging.			S			N/A	
62.0	Unbolt low profile saddles.			S			N/A	
63.0	Lift steam generator clear of Talbert trailer. swing 90° and place on cribbing.	FSK-C-216		S			N/A	

## PROCESS SHEET

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ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PFE	DATE	QC	DATE
64.0	Walk crane toward storage compound within 12 inches of wall.			S			N/A	
65.0	Snug up rigging, re-check, hoist steam generator above compound wall, swing 90°, lower and place on storage saddles.			S			N/A	
66.0	Release rigging from steam generator.			S			N/A	
67.0	Close out Process Sheet.			S			N/A	

PROCESS  
SHEET



P.S. No. 81-237 Unit 3 PCM 77-54B CWO A-189

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System STEAM GENERATOR LOWER ASSEMBLY "B"

Safety Related ☐

Non-Safety Related ☒

PREPARED BY

DATE

EST. START DATE

BLDG

AREA

ELEV

G. W. Stokes

7-15-81

SCOPE

LOWER ASSEMBLY REMOVAL, TRANSPORTING, PLACING IN STORAGE

SEQUENCING  
REQUIRED

Yes

No

☐

☐

REV	DATE	REV. DESCRIPTION	PFE	QC	QA	CS	PNSC	REV	DATE	REV. DESCRIPTION	PFE	QC	QA	CS	PNSC
0	7-23-81	Issued for construction													

ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PFE	DATE	QC	DATE
1.0	<p>This Process Sheet details the procedure by which the Steam Generator Lower Assembly will be removed from its installed position to outside the containment onto a Lowboy, transported to storage compound, and placed inside.</p> <p>PREREQUISITES</p> <p>Nuclear Plant Supervisor authorization to commence work.</p> <p>Signature _____ Date _____</p>	<div style="border: 2px solid black; padding: 5px; text-align: center; font-weight: bold;">PRELIMINARY</div>						
2.0	Verify PC/M has been reviewed and approved.							
3.0	Verify R.W.P. has been issued.							

WORK COMPLETED  
& PS CLOSED:

PFE

DATE

QC

DATE

CS

DATE

## PROCESS SHEET

PS No. 81-237

Page 2 of 9

ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PPE	DATE	QC	DATE
4.0	Verify storage compound or laydown area ready to receive lower assembly.			S			N/A	
5.0	Verify back fill of ramp is complete.	5177-074-C-6		S			N/A	
6.0	Verify concrete ramp is complete.	5177-074-C-64		S			N/A	
7.0	Verify equipment hatch modification complete.	5177-074-C-70		S			N/A	
8.0	Verify transfer bridge steel installed and complete.	5177-074-C-71		S			N/A	
9.0	Verify structural steel and micellaneous steel removal complete.	5177-074-C-28		S				
10.0	Verify concrete removal complete enough for steam generator removal.	5177-074-C-27		S				
11.0	Ensure transporting system is in proper working order, braking system, tire pressure.			S				
12.0	Verify steam generator insulation removed and exterior surface deconed.			S				
13.0	Verify instrument lines and small pipe have been disconnected.			S				

## PROCESS SHEET

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ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	* INSP POINTS	PPE	DATE	QC	DATE
14.0	Ensure adequate clearance through the containment. Check Pettibone clearance.			S			N/A	
15.0	Inspect and verify rigging equipment is in proper condition - Hillman rollers, up ending skid, spreader beam, winch cables, slings, shackles, jacking equipment, low profile saddles and snatch blocks.			S			N/A	
15.1	Verify spreader beam has been load tested, 110% of lift weight.			H			N/A	
16.0	Verify top cover plate has been installed and accepted.	5177-074-P-310		H			N/A	
17.0	Verify lifting lugs have been installed on top cover plate and M.T.'d.	FSK-C-219		H			N/A	
18.0	Verify scaffolding and enclosure panels are clear for lifting steam generator.			S			N/A	
19.0	Verify steam generator seismic ring girder will lift free.			S			N/A	
20.0	Verify the Polar crane has had a pre-lift inspection and run in performed.			S			N/A	
21.0	Lower girth cutting operation will notify rigging superintendent for appropriate time to connect rigging to lower assembly.			S			N/A	

## PROCESS SHEET

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ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	* INSP POINTS	PFE	DATE	QC	DATE
	WORK ACTIVITIES							
22.0	Bolt trunnion flanges and connect rigging to steam generator lower assembly, hoist rigging until slings are snug.	FSK-C-210 FSK-C-168		S			N/A	
23.0	Verify the spreader beam is level and the rigging is plumb, snug up the bolts on the latch plates.			S			N/A	
24.0	Establish voice communications between flagman and polar crane operator.			S			N/A	
25.0	Take a strain on load recheck rigging, verify the slings are properly seated.			S			N/A	
26.0	Cutting shall provide shims in open cut to prevent gap from re-sealing.			S			N/A	
27.0	Once cut is complete lift steam generator a few inches above channel head and install Herculite over bottom of steam generator.			S			N/A	
28.0	Clear all personnel from lifting zone, except for those doing actual rigging operation. Notify safety and H.P.			S			N/A	
29.0	Hoist steam generator so ring girder clears top of shield wall at El. 68'. Cut ring girder, unbolt and remove from lower assembly.	5177-074-C-42 P.S. 81-240		S			N/A	

## PROCESS SHEET

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ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PFE	DATE	QC	DATE
30.0	Hoist steam generator above all obstacles and move it into position over top of bottom cover plate.			S			N/A	
31.0	Lower steam generator down within a few inches of cover plate.			S			N/A	
32.0	Cover plate to be on three pieces of wood cribbing. Lower steam generator down until wood begins to crush then stop. Protect wood with Raficell.			S			N/A	
33.0	Weld out bottom cover plate. Verify installation complete.	5177-074-P-310		H			N/A	
34.0	Move lower assembly into position and install Westinghouse up ending skid. Verify installation is correct.	Westinghouse DWG. 1600E61		H			N/A	
35.0	Hoist steam generator and move it in line with a 18° center line of E.Q. hatch.			S			N/A	
36.0	By means of trolley, transport steam generator to end of bridge girders (crane stops). Lower steam generator within about 2 feet of transfer bridge.	FSK-C-211		S			N/A	
37.0	Hook four part line to up ending skid.	FSK-C-211 FSK-C-220		S			N/A	

## PROCESS SHEET

PS No. 81-237

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ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	* INSP POINTS	PFE	DATE	QC	DATE
38.0	Pull steam generator over transfer bridge and lower down onto bridge.	FSK-C-211		S			N/A	
39.0	Travel with trolley toward center of bridge and lower with Polar crane hook. Use four part line to pull steam generator through hatch.	FSK-C-212		S			N/A	
40.0	Place 1" plate, Hillman rollers, and restriction bar at equipment hatch.	FSK-C-212 FSK-C-222		S			N/A	
41.0	Pull steam generator through E.Q. hatch onto Hillman rollers. Remove restriction bar and continue pulling.	FSK-C-212 FSK-C-213		S			N/A	
42.0	Once steam generator top cover plate is at edge of slab at 30'-6" stop pulling, lower steam generator onto cribbing at 30'-6".	FSK-C-213		S			N/A	
43.0	Remove rigging from trunnions and shackle into lifting lugs on top cover plate.	FSK-C-213		S			N/A	
44.0	With Polar crane, lift steam generator off cribbing at El. 30'-6", continue pulling with four part line until steam generator center of gravity is approximately 8' from outside face of containment wall.	FSK-C-214		S			N/A	
45.0	Lower top shield plate onto cribbing on transfer bridge. Disconnect four part line.	FSK-C-214		S			N/A	



## PROCESS SHEET

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ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PFE	DATE	QC	DATE
46.0	Pick bottom of steam generator with 300 ton P & H crane and place on cribbing.	FSK-C-214		S			N/A	
47.0	Remove Westinghouse up ending skid and install Westinghouse low profile saddles, spacer beam, and Hillman roller.	FSK-C-214 FSK-C-222		S			N/A	
48.0	Verify low profile saddles have been installed properly.			S			N/A	
49.0	Pick bottom of steam generator with 300 ton P & H crane, remove cribbing, lower steam generator onto saddles. Check alignment of steam generator in hatch. Pre-position if necessary. Disconnect Polar crane.	FSK-C-214		S			N/A	
50.0	Hook four part line to pulling lugs on front of low profile saddles. Continue pulling steam generator until center of gravity is approximately 14' from edge of slab.	FSK-C-214		S			N/A	
51.0	Disconnect four part line from saddle, rig steam generator for picking up with 300 ton P & H crane.	FSK-C-214		S			N/A	
52.0	Position 300 ton P & H crane and Talbert trailer as shown.	FSK-C-216		S			N/A	
53.0	Take strain on the load and check rigging sling seated, rigging plumb, pick steam generator from slab rotate boom out and							

## PROCESS SHEET

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ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PFE	DATE	QC	DATE
Cond't 53.0	place steam generator on Talbert trailer.	FSK-C-214 FSK-C-215 FSK-C-216		S			N/A	
54.0	Tie steam generator down to Talbert trailer and check.	FSK-C-215		S			N/A	
56.0	Verify tie down arrangement of steam generator.	FSK-C-215		S			N/A	
57.0	Transport steam generator over east haul road to steam generator storage compound or laydown area.			S			N/A	
58.0	Travel shall be controlled, speed maintained less than 5 M.P.H.			S			N/A	
59.0	Walk 300 ton P & H crane to storage compound.			S			N/A	
60.0	Set up Talbert trailer and P & H crane for unloading as shown.	FSK-C-216		S			N/A	
61.0	Rig steam generator for lifting with P & H crane and snug up rigging.			S			N/A	
62.0	Unbolt low profile saddles.			S			N/A	
63.0	Lift steam generator clear of Talbert trailer, swing 90° and place on cribbing.	FSK-C-216		S			N/A	

## PROCESS SHEET

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ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	* INSP POINTS	PFE	DATE	QC	DATE
64.0	Walk crane toward storage compound within 12 inches of wall.			S			N/A	
65.0	Snug up rigging, re-check, hoist steam generator above compound wall, swing 90°, lower and place on storage saddles.			S			N/A	
66.0	Release rigging from steam generator.			S			N/A	
67.0	Close out Process Sheet.			S			N/A	

PROCESS  
SHEET



P.S. No. 81-238 Unit 3 PCM 77-54B CWO A-189 Page 1 of 9

System STEAM GENERATOR LOWER ASSEMBLY "C"  
Safety Related ☐  
Non-Safety Related ☒

PREPARED BY G. W. Stokes DATE 7-15-81 EST. START DATE BLDG AREA ELEV

SCOPE LOWER ASSEMBLY REMOVAL, TRANSPORTING, PLACING IN STORAGE SEQUENCING REQUIRED Yes ☐ No ☐

REV	DATE	REV. DESCRIPTION	PFE	QC	QA	CS	PNSC	REV	DATE	REV. DESCRIPTION	PFE	QC	QA	CS	PNSC
0	7-23-81	Issued for construction													

ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PFE	DATE	QC	DATE
1.0	<p>This Process Sheet details the procedure by which the Steam Generator Lower Assembly will be removed from its installed position to outside the containment onto a Lowboy, transported to storage compound, and placed inside.</p> <p>PREREQUISITIES</p> <p>Nuclear Plant Supervisor authorization to commence work.</p> <p>Signature _____ Date _____</p>	<div>PRELIMINARY</div>						
2.0	Verify PC/M has been reviewed and approved.							
3.0	Verify R.W.P. has been issued.							

WORK COMPLETED & PS CLOSED: PFE DATE QC DATE CS DATE

## PROCESS SHEET

PS No. 81-238

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ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PFE	DATE	QC	DATE
4.0	Verify storage compound or laydown area ready to receive lower assembly.			S			N/A	
5.0	Verify back fill of ramp is complete.	5177-074-C-6		S			N/A	
6.0	Verify concrete ramp is complete.	5177-074-C-64		S			N/A	
7.0	Verify equipment hatch modification complete.	5177-074-C-70		S			N/A	
8.0	Verify transfer bridge steel installed and complete.	5177-074-C-71		S			N/A	
9.0	Verify structural steel and miscellaneous steel removal complete.	5177-074-C-28		S				
10.0	Verify concrete removal complete enough for steam generator removal.	5177-074-C-27		S				
11.0	Ensure transporting system is in proper working order, braking system, tire pressure			S				
12.0	Verify steam generator insulation removed and exterior surface deconed.			S				
13.0	Verify instrument lines and small pipe have been disconnected.			S				

## PROCESS SHEET

PS No. 81-238

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ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PFE	DATE	QC	DATE
14.0	Ensure adequate clearance through the containment. Check Pettibone clearance.			S			N/A	
15.0	Inspect and verify rigging equipment is in proper condition - Hillman rollers, up ending skid, spreader beam, winch cables, slings, shackles, jacking equipment, low profile saddles and snatch blocks.			S			N/A	
15.1	Verify spreader beam has been load tested, 110% of lift weight.			H			N/A	
16.0	Verify top cover plate has been installed and accepted.	5177-074-P-310		H			N/A	
17.0	Verify lifting lugs have been installed on top cover plate and M.T.'d.	FSK-C-219		H			N/A	
18.0	Verify scaffolding and enclosure panels are clear for lifting steam generator.			S			N/A	
19.0	Verify steam generator seismic ring girder will lift free.			S			N/A	
20.0	Verify the Polar crane has had a pre-lift inspection and run in performed.			S			N/A	
21.0	Lower girth cutting operation will notify rigging superintendent for appropriate time to connect rigging to lower assembly.			S			N/A	

## PROCESS SHEET

PS No. 81-238

Page 4 of 9

ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PFE	DATE	QC	DATE
	WORK ACTIVITIES							
22.0	Bolt trunnion flanges and connect rigging to steam generator lower assembly, hoist rigging until slings are snug.	FSK-C-210 FSK-C-168		S			N/A	
23.0	Verify the spreader beam is level and the rigging is plumb, snug up the bolts on the latch plates.			S			N/A	
24.0	Establish voice communications between flagman and Polar crane operator.			S			N/A	
25.0	Take a strain on load recheck rigging, verify the slings are properly seated.			S			N/A	
26.0	Cutting shall provide shims in open cut to prevent gap from re-sealing.			S			N/A	
27.0	Once cut is complete lift steam generator a few inches above channel head and install Herculite over bottom of steam generator.			S			N/A	
28.0	Clear all personnel from lifting zone, except for those doing actual rigging operation. Notify safety and H.P.			S			N/A	
29.0	Hoist steam generator so ring girder clears top of shield wall at El. 68'. Cut ring girder, unbolt and remove from lower assembly.	5177-074-C-42 81-241		S			N/A	

## PROCESS SHEET

PS No. 81-238

Page 5 of 9

ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PFE	DATE	QC	DATE
30.0	Hoist steam generator above all obstacles and move it into position over top of bottom cover plate.			S			N/A	
31.0	Lower steam generator down within a few inches of cover plate.			S			N/A	
32.0	Cover plate to be on three pieces of wood cribbing. Lower steam generator down until wood begins to crush then stop. Protect wood with Raficell.			S			N/A	
33.0	Weld out bottom cover plate. Verify installation complete.	5177-074-P-310		H			N/A	
34.0	Move lower assembly into position and install Westinghouse up ending skid. Verify installation is correct.	Westinghouse DWG. 1600E61		H			N/A	
35.0	Hoist steam generator and move it in line with a 18° center line of E.Q. hatch.			S			N/A	
36.0	By means of trolley, transport steam generator to end of bridge girders (crane stops). Lower steam generator within about 2 feet of transfer bridge.	FSK-C-211		S			N/A	
37.0	Hook four part line to up ending skid.	FSK-C-211 FSK-C-220		S			N/A	



ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PFE	DATE	QC	DATE
38.0	Pull steam generator over transfer bridge and lower down onto bridge.	FSK-C-211		S			N/A	
39.0	Travel with trolley toward center of bridge and lower with Polar crane hook. Use four part line to pull steam generator through hatch.	FSK-C-212		S			N/A	
40.0	Place 1" plate, Hillman rollers, and restriction bar at equipment hatch.	FSK-C-212 FSK-C-222		S			N/A	
41.0	Pull steam generator through E.Q. hatch onto Hillman rollers. Remove restriction bar and continue pulling.	FSK-C-212 FSK-C-213		S			N/A	
42.0	Once steam generator top cover plate is at edge of slab at 30'-6" stop pulling, lower steam generator onto cribbing at 30'-6".	FSK-C-213		S			N/A	
43.0	Remove rigging from trunnions and shackle into lifting lugs on top cover plate.	FSK-C-213		S			N/A	
44.0	With Polar crane, lift steam generator off cribbing at El. 30'-6", continue pulling with four part line until steam generator center of gravity is approximately 8' from outside face of containment wall.	FSK-C-214		S			N/A	
45.0	Lower top shield plate onto cribbing on transfer bridge. Disconnect four part line.	FSK-C-214		S			N/A	

## PROCESS SHEET

PS No. 81-238

Page 7 of 9

ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PFE	DATE	QC	DATE
46.0	Pick bottom of steam generator with 300 ton P & H crane and place on cribbing.	FSK-C-214		S			N/A	
47.0	Remove Westinghouse up ending skid and install Westinghouse low profile saddles, spacer beam, and Hillman roller.	FSK-C-214 FSK-C-222		S			N/A	
48.0	Verify low profile saddles have been installed properly.			S			N/A	
49.0	Pick bottom of steam generator with 300 ton P & H crane, remove cribbing, lower steam generator onto saddles. Check alignment of steam generator in hatch. Pre-position if necessary. Disconnect Polar crane.	FSK-C-214		S			N/A	
50.0	Hook four part line to pulling lugs on front of low profile saddles. Continue pulling steam generator until center of gravity is approximately 14' from edge of slab.	FSK-C-214		S			N/A	
51.0	Disconnect four part line from saddle, rig steam generator for picking up with 300 ton P & H crane.	FSK-C-214		S			N/A	
52.0	Position 300 ton P & H crane and Talbert trailer as shown.	FSK-C-216		S			N/A	
53.0	Take strain on the load and check rigging sling seated, rigging plumb, pick steam generator from slab.							

## PROCESS SHEET

PS No. 81-238

Page 8 of 9

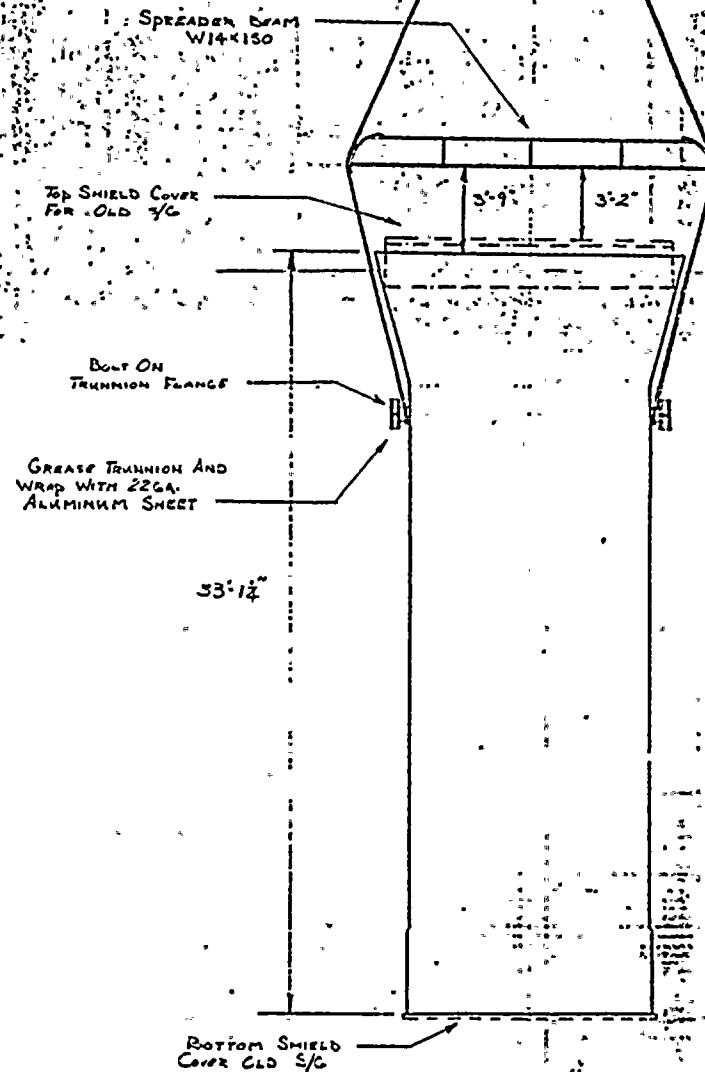
ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PFE	DATE	QC	DATE
Cond't 53.0	place steam generator on Talbert trailer.	FSK-C-214 FSK-C-215 FSK-C-216		S			N/A	
54.0	Tie steam generator down to Talbert trailer and check.	FSK-C-215		S			N/A	
56.0	Verify tie down arrangement of steam generator.	FSK-C-215		S			N/A	
57.0	Transport steam generator over east haul road to steam generator storage compound or laydown area.			S			N/A	
58.0	Travel shall be controlled, speed maintained less than 5 M.P.H.			S			N/A	
59.0	Walk 300 ton P & H crane to storage compound.			S			N/A	
60.0	Set up Talbert trailer and P & H crane for unloading as shown.	FSK-C-216		S			N/A	
61.0	Rig steam generator for lifting with P & H crane and snug up rigging.			S			N/A	
62.0	Unbolt low profile saddles.			S			N/A	
63.0	Lift steam generator clear of Talbert trailer, swing 90° and place on cribbing.	FSK-C-216		S			N/A	

## PROCESS SHEET

PS No. 81-238

Page 9 of 9

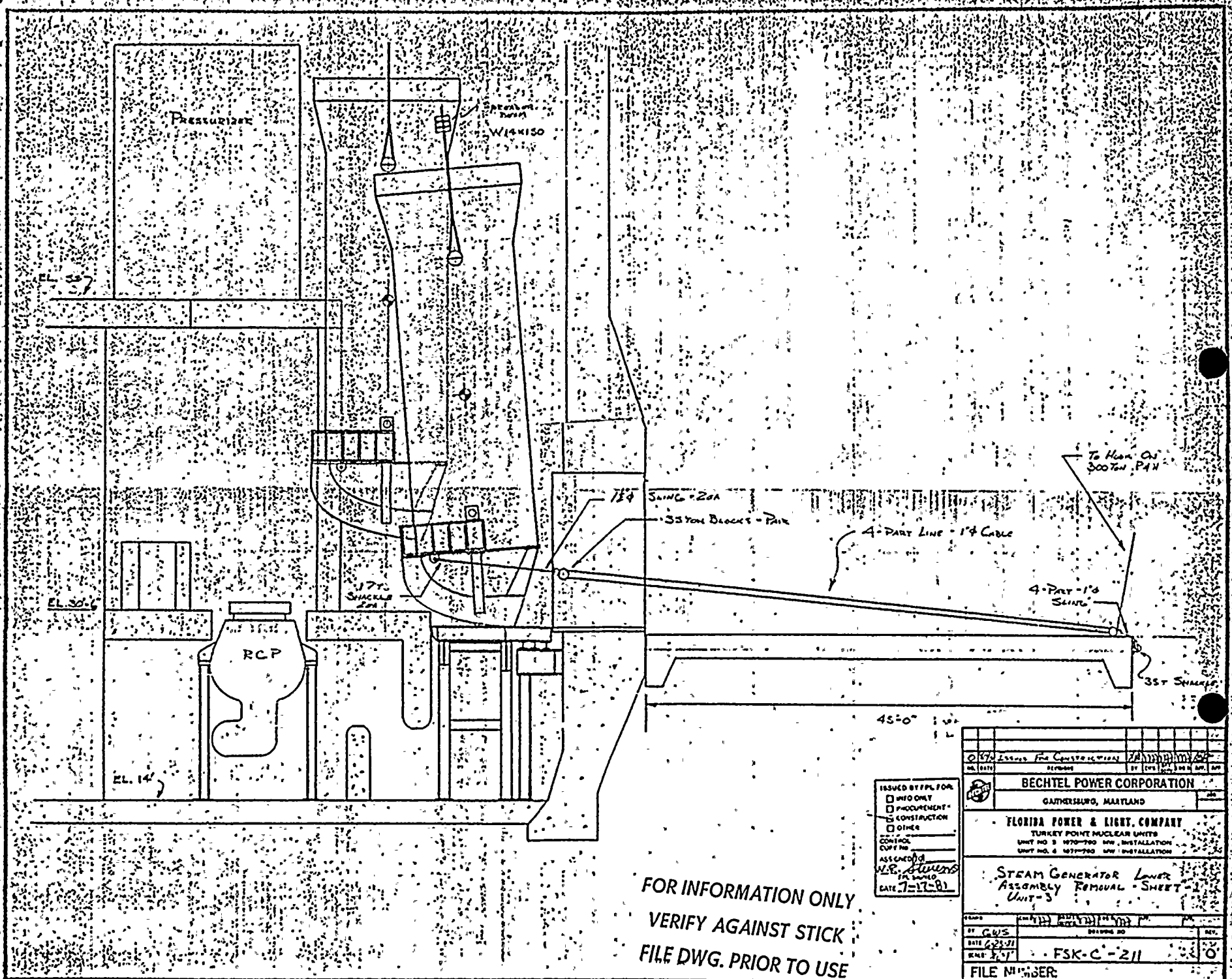
ITEM NO.	WORK/INSPECTION ACTIVITY	INSTALLATION DOCUMENT	REV	*INSP POINTS	PFE	DATE	QC	DATE
64.0	Walk crane toward storage compound within 12 inches of wall.			S			N/A	
65.0	Snug up rigging, re-check, hoist steam generator above compound wall, swing 90°, lower and place on storage saddles.			S			N/A	
66.0	Release rigging from steam generator.			S			N/A	
67.0	Close out Process Sheet.			S			N/A	



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 CONTROL  
 CLIP NO.  
 ASSIGNED BY  
 DATE 7-17-81

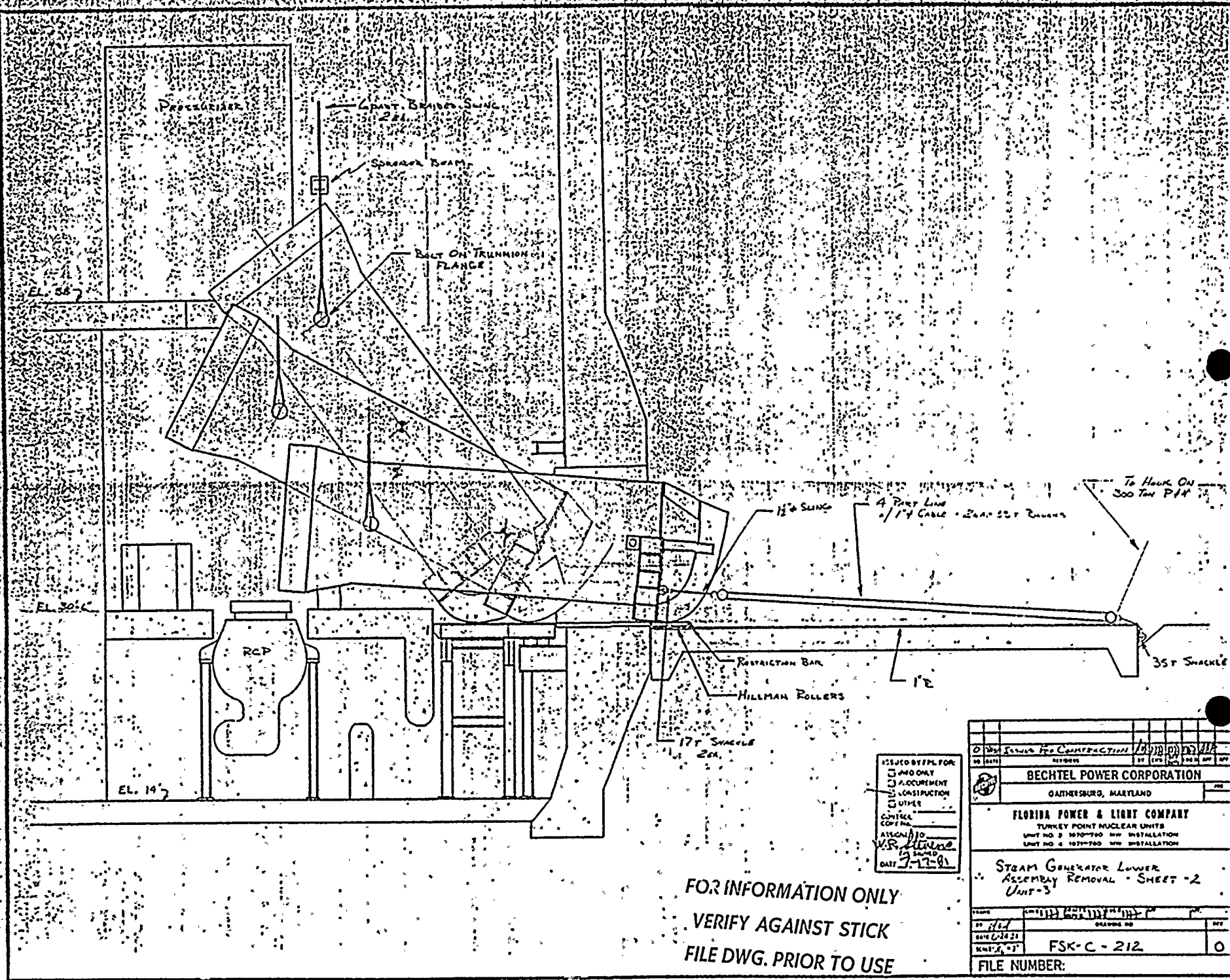
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REVISION		BY 10/10/81	
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GAITHERSBURG, MARYLAND			
FLORIDA POWER & LIGHT COMPANY			
TURKEY POINT NUCLEAR UNIT			
UNIT NO. 3 1070750 MW INSTALLATION			
UNIT NO. 4 1070750 MW INSTALLATION			
STEAM GENERATOR LOWER			
ASSEMBLY RIGGING			
DATE 7-17-81	BY 10/10/81	DATE 7-17-81	BY 10/10/81
FILE NUMBER: FSK-C-210		0	

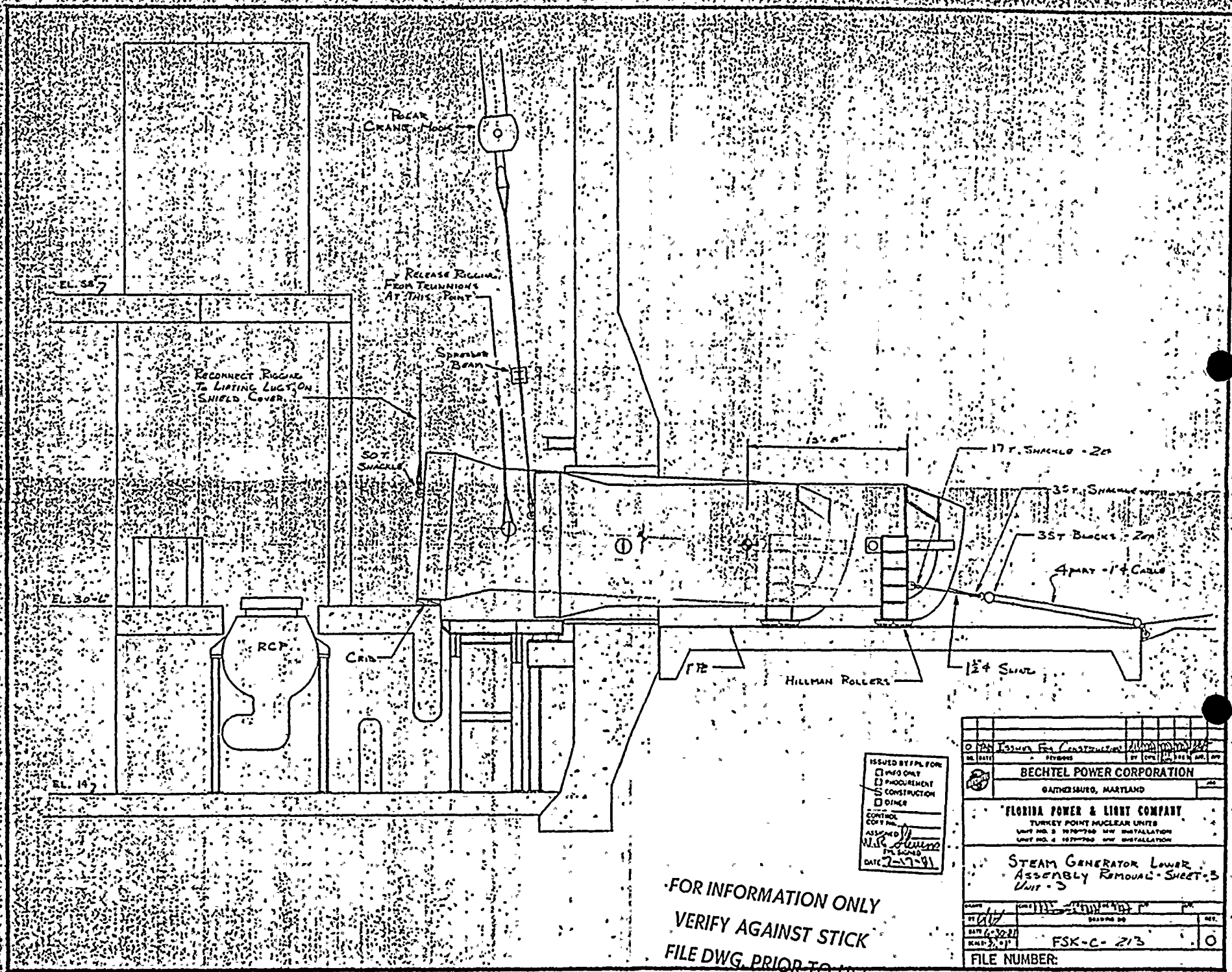


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<input type="checkbox"/> OTHER	
ASSIGNED TO	
DATE	7-17-81

0.572 Issues For Construction	
BY	DATE
BECHTEL POWER CORPORATION	
GATHERSBURG, MARYLAND	
FLORIDA POWER & LIGHT COMPANY	
TURKEY POINT NUCLEAR UNIT	
UNIT NO. 3 1970-790 MW INSTALLATION	
UNIT NO. 3 1971-790 MW INSTALLATION	
STEAM GENERATOR Lower	
Assembly Removal - SHEET	
UNIT-3	
BY	DATE
BY	DATE
BY	DATE
FSK-C-211	
FILE NUMBER	

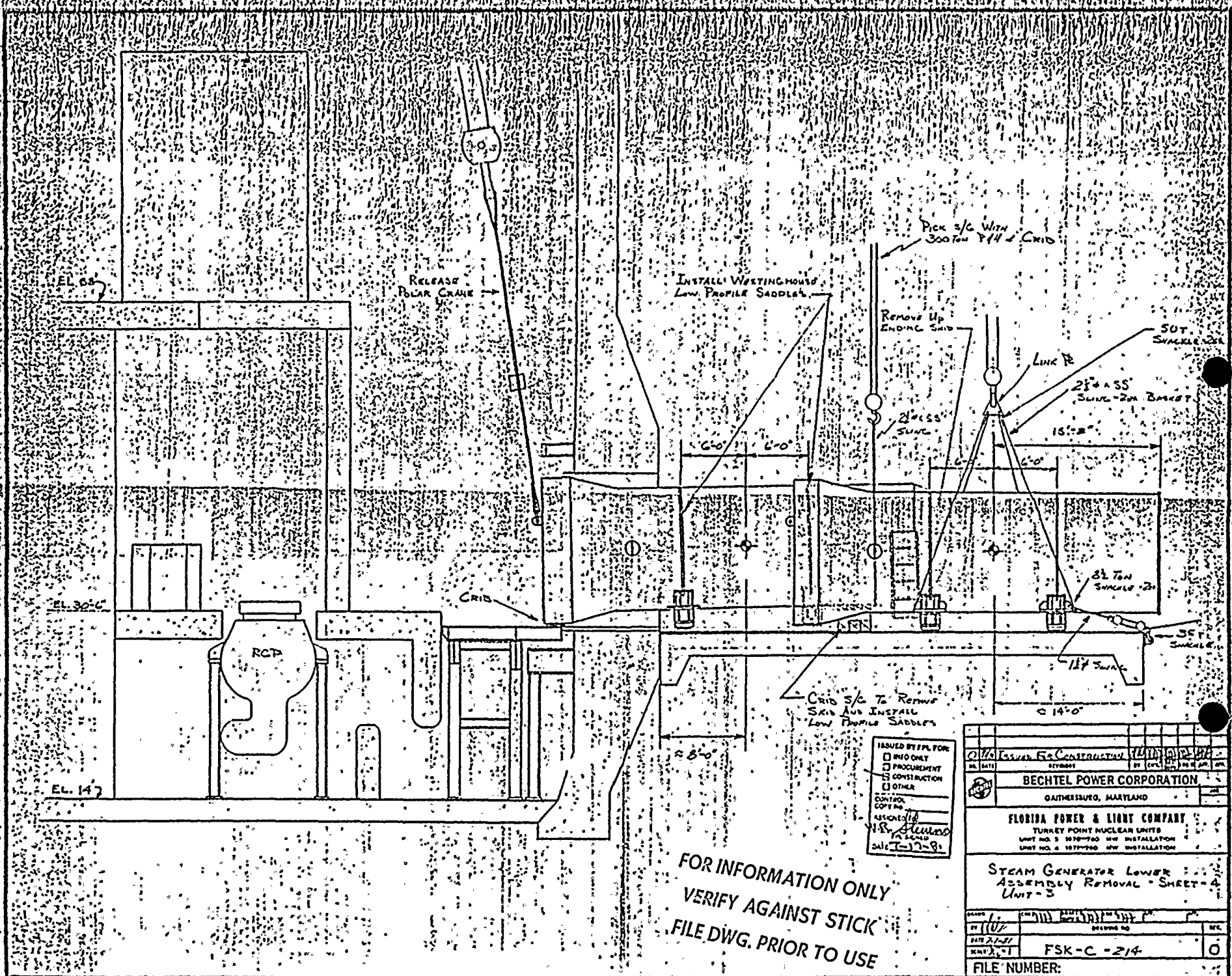




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CONTROL	
COPY NO.	
ASSIGNED	
DATE	2-27-91

ISSUED BY/PL FOR		DATE	
BECHTEL POWER CORPORATION		GAITHERSBURG, MARYLAND	
FLORIDA POWER & LIGHT COMPANY			
TURKEY POINT NUCLEAR UNIT			
UNIT NO. 3 1070-750 MW INSTALLATION			
UNIT NO. 4 1070-750 MW INSTALLATION			
STEAM GENERATOR LOWER			
Assembly Removal - SHEET 3			
Unit - 3			
NAME	UNIT	DATE	REV.
BY: <i>dlw</i>	11/13/91	11/13/91	0
DATE: 6-30-91	SKETCH: 3-01	FSK-C-213	0
FILE NUMBER:			





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☐ PROCUREMENT

☐ CONSTRUCTION

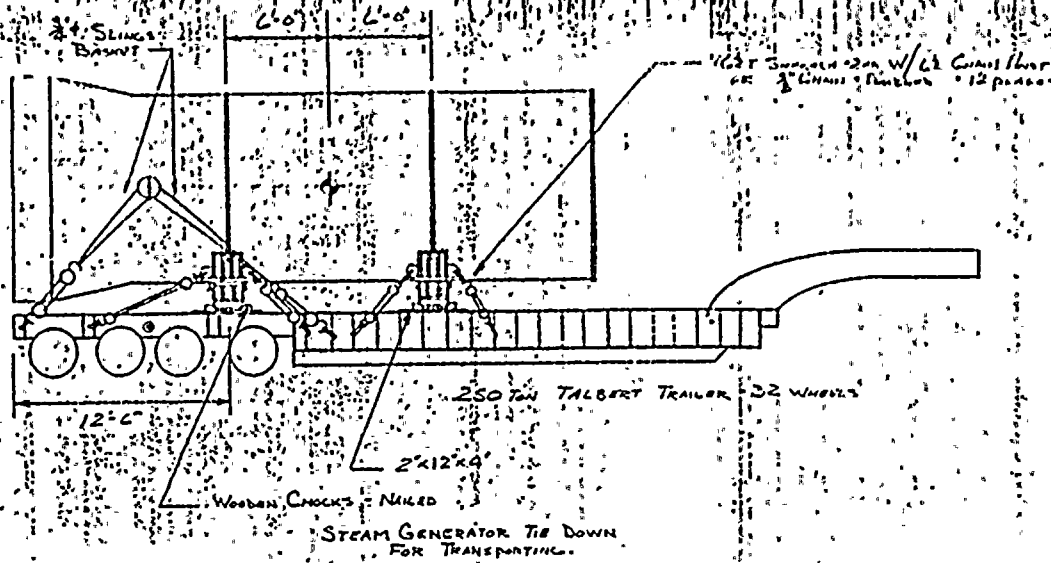
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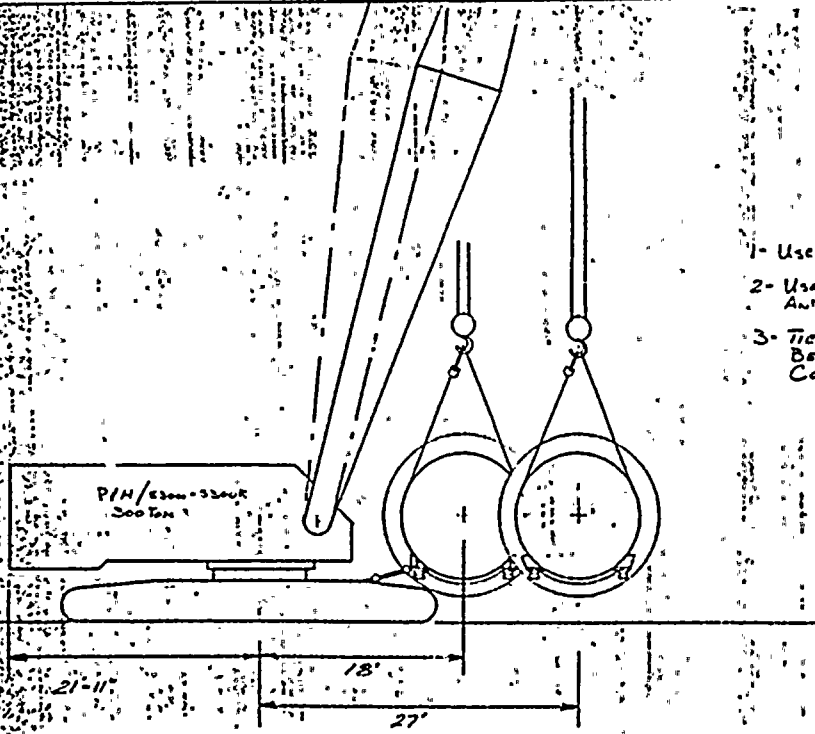
ASSIGNED TO

DATE 1-2-81

FLORIDA POWER & LIGHT COMPANY	
TURKEY POINT NUCLEAR UNIT	
UNIT NO. 3	UNIT NO. 4
1070-760	1070-760
NEW INSTALLATION	NEW INSTALLATION
STEAM GENERATOR LOWER ASSEMBLY REMOVAL - SHEET - 4	
UNIT - 3	
DATE 1-2-81	DESIGNED BY
FILE NO. 1	FSK-C-214
FILE NUMBER:	



- Primary Equipment List, For Steam  
 Generator Lower Assembly Remover  
 1- 2nd Floor Main Area Main Area  
 2- 250 Ton Talbert Trailer  
 3- 345 H.P. V.S. Main Tank  
 Prime Mover  
 4- 300 Ton P.H. Cranes, Crane  
 5300 - 5300 - R

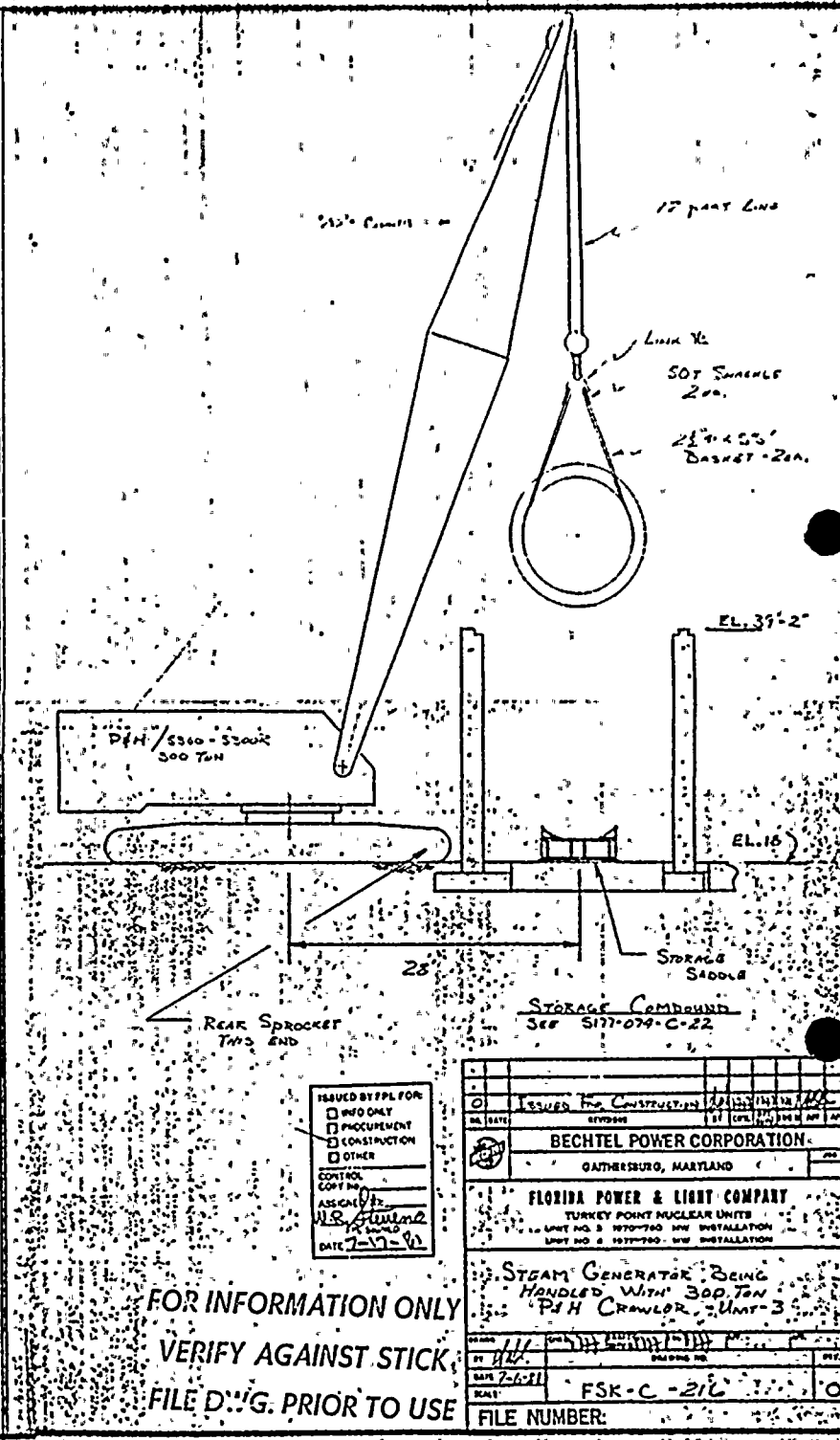
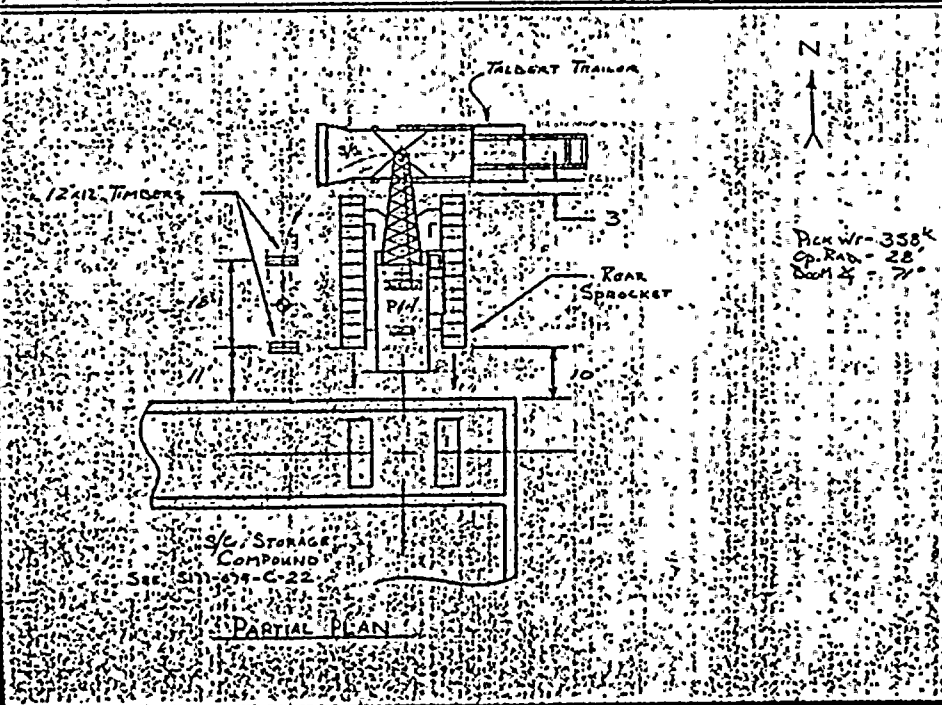
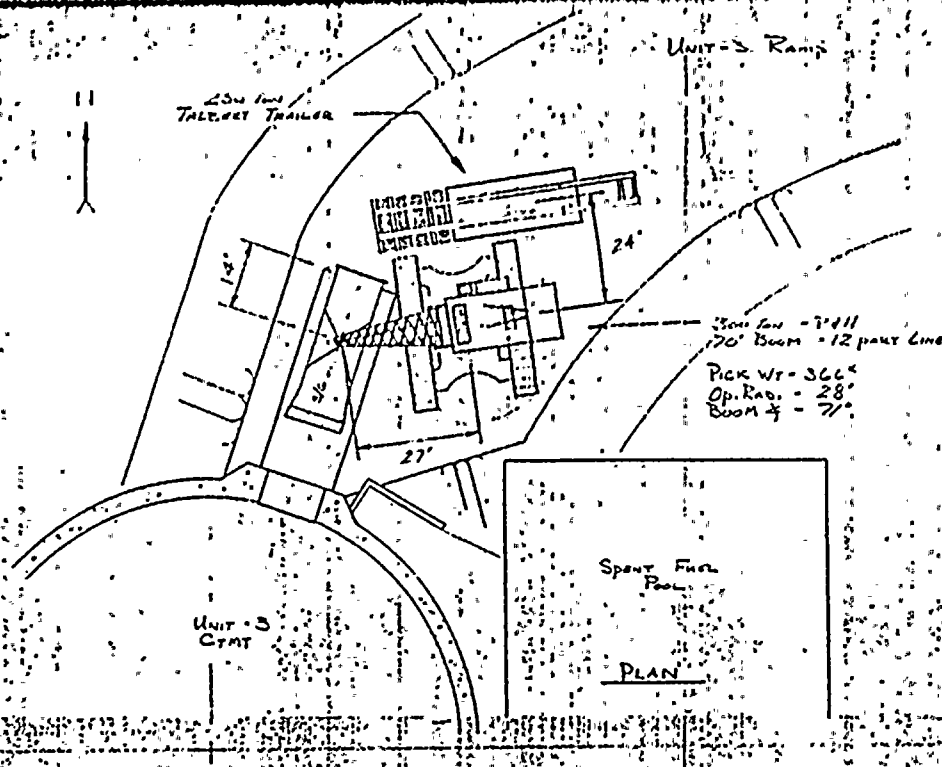


- 1- Use 18' For Walking With Load
- 2- Use 27' For Booming Out And Peeling 3/4 ON TALBERT TRAILER
- 3- Tie 1/2 OFF TO CRANE BEFORE WALKING - 62 Chain Coming Along - 2ea

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 FILE DWG. PRIOR TO USE

ISSUED BY FOR:	
<input type="checkbox"/>	DESIGN
<input type="checkbox"/>	PROCUREMENT
<input type="checkbox"/>	CONSTRUCTION
<input type="checkbox"/>	OTHER
CONTROL COPY NO.	
DATE 7-17-81	

O'Dell Engineering Co. Construction		10/11/1981	
BY DATE		BY DATE	
BECHTEL POWER CORPORATION			
GATHERSBURG, MARYLAND			
FLORIDA POWER & LIGHT COMPANY			
TURKEY POINT NUCLEAR UNIT			
UNIT NO. 3 1970-780 SHW INSTALLATION			
UNIT NO. 3 1970-780 SHW INSTALLATION			
STEAM GENERATOR TIE DOWN TO TALBERT TRAILER & LIFTING WITH 300 TON P.H.			
DATE	BY	DATE	BY
11/1/81	11/1/81	11/1/81	11/1/81
DATE 7-17-81		DATE 7-17-81	
BY 11/1/81		BY 11/1/81	
FSK-C-215		0	
FILE NUMBER:			





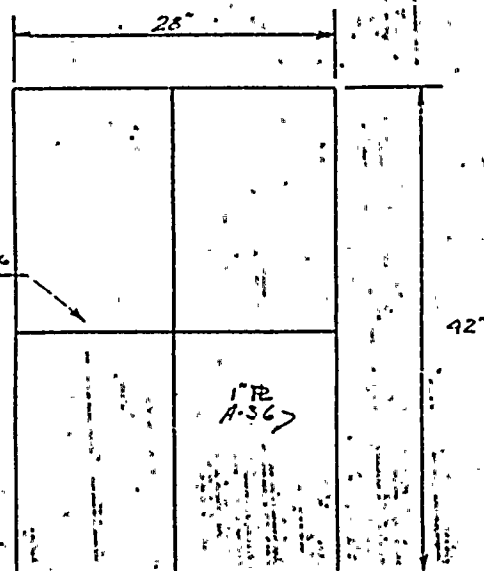
SEQUENCING REQUIRED,  
SEE WELDING ENGINEERING  
PRIOR TO STARTING

2 1/2"  
TYP. & FOR EYE

HILMAN ROLLERS  
MODEL - SXOT - 4GA  
400 TON

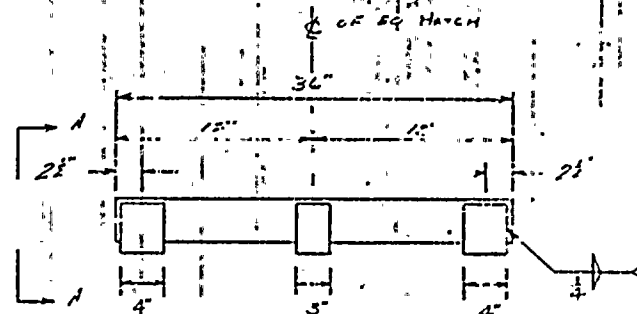
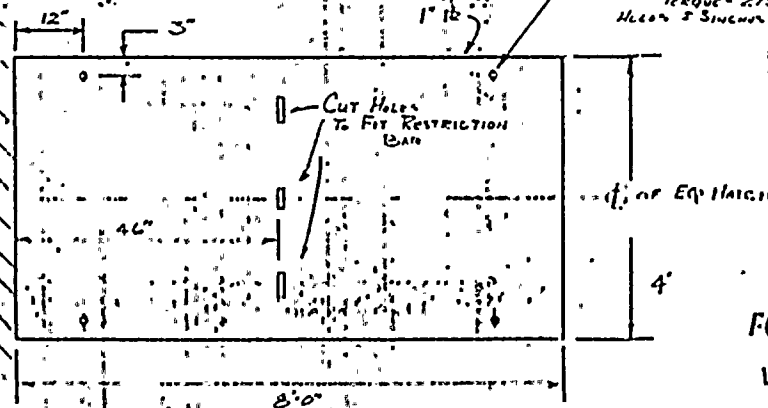
NO. 5 PAD EYE  
ONE EACH CORNER

EQ HATCH  
O.F. OF CTRY

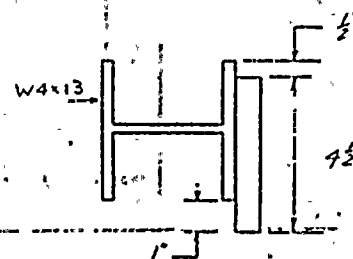


TOP VIEW

SECTION B-B



RESTRICTION BAR



SECTION A-A

NOTES:

1. ALL MATERIALING ASTM A-36
2. WELDING TO BE IN ACCORDANCE WITH AWS D1.1-77

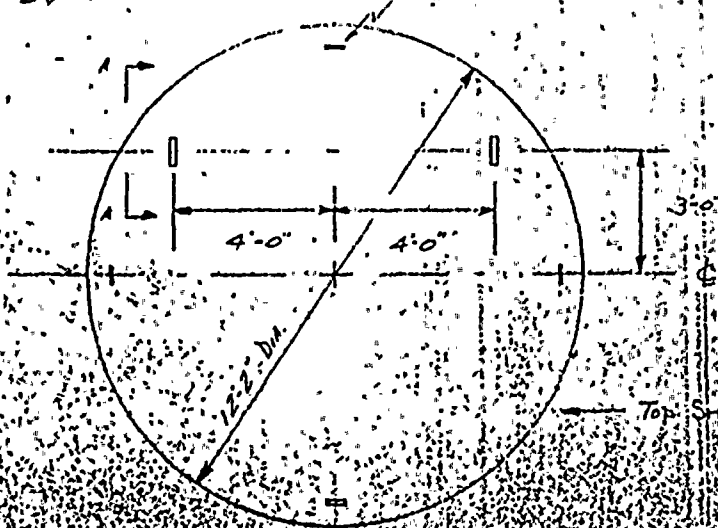
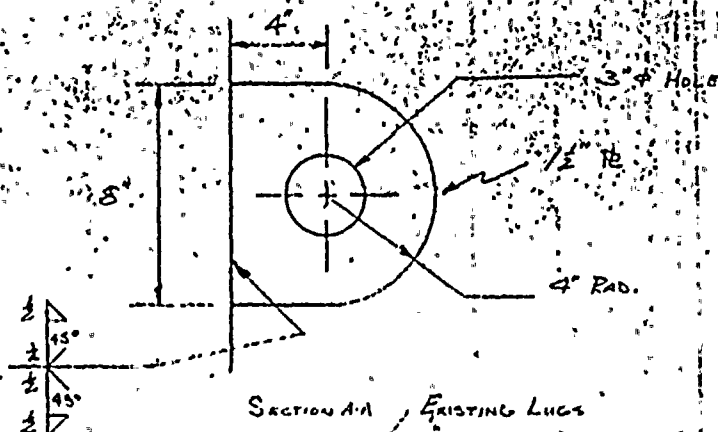
REVIEWED BY	DATE
DESIGNED BY	DATE
CHECKED BY	DATE
APPROVED BY	DATE
W.R. HILMAN	DATE 1-17-81

ITEM	DESCRIPTION	QUANTITY	UNIT
1	RESTRICTION BAR	1	EA
2	HILMAN ROLLER	4	EA
3	PAD EYE	4	EA
4	WELDING	1	EA
5	WELDING	1	EA
6	WELDING	1	EA
7	WELDING	1	EA
8	WELDING	1	EA
9	WELDING	1	EA
10	WELDING	1	EA

SEE WELDING ENG FOR NDE REQTS

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ISSUED FOR CONSTRUCTION	
BECHTEL POWER CORPORATION	
GAITHERSBURG, MARYLAND	
FLORIDA POWER & LIGHT COMPANY	
TURKEY POINT NUCLEAR UNIT	
UNIT NO. 2 1070-700 MW INSTALLATION	
DATE 1-17-81 1070-700 MW INSTALLATION	
HILMAN ROLLER AND RESTRICTION BAR FABRICATION	
DATE 1-17-81	FILE NUMBER: FSK-C-222



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 ASSIGNED BY \_\_\_\_\_  
 W.R. Stevens  
 DATE 7-17-91

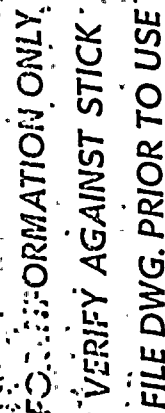
NOTES:

1. Plate Shall Be ASTM A-36
2. 3 SPS Required
3. Welds To Be In Accordance With AWS D1.1-77

WELDING REQUIREMENTS			
WELD TYPE	WELDING PROCESS	WELDING POSITION	WELDING SPEED
WELD TYPE	WELDING PROCESS	WELDING POSITION	WELDING SPEED
WELD TYPE	WELDING PROCESS	WELDING POSITION	WELDING SPEED
WELD TYPE	WELDING PROCESS	WELDING POSITION	WELDING SPEED
WELD TYPE	WELDING PROCESS	WELDING POSITION	WELDING SPEED
WELD TYPE	WELDING PROCESS	WELDING POSITION	WELDING SPEED
WELD TYPE	WELDING PROCESS	WELDING POSITION	WELDING SPEED
WELD TYPE	WELDING PROCESS	WELDING POSITION	WELDING SPEED
WELD TYPE	WELDING PROCESS	WELDING POSITION	WELDING SPEED
WELD TYPE	WELDING PROCESS	WELDING POSITION	WELDING SPEED

SEE WELDING ENG. FOR AWS D1.1-77

ISSUED FOR CONSTRUCTION		DATE	BY	CHKD	APP
BECHTEL POWER CORPORATION					
GAITHERSBURG, MARYLAND					
FLORIDA POWER & LIGHT COMPANY					
TURKEY POINT NUCLEAR UNIT					
UNIT NO. 3 1970-760 MW INSTALLATION					
UNIT NO. 4 1977-760 MW INSTALLATION					
LIFTING LUGS FOR STEAM GENERATOR LOWER ASSEMBLY					
DATE	BY	CHKD	APP	FILE NO.	REV
DATE 7-17-91	BY FSK	CHKD	APP	FILE NO. 219	REV 0
FILE NUMBER:					



- 1-Plate To Be Norm. A-36
- 2-Welds To Be In Accordance With AWS D1.1:77
- 3-ELECTRODES To Be E-7018

PERSONAL INFORMATION		CONTACT INFORMATION	
NAME (LAST, FIRST, MIDDLE)	DATE OF BIRTH	PHONE NUMBER	EMAIL ADDRESS
JOHN DOE	12/15/1980	555-123-4567	john.doe@email.com
ADDRESS (STREET, CITY, STATE, ZIP)			
123 MAIN ST, ANYTOWN, CA 90210			
EMPLOYMENT INFORMATION	EDUCATION	REFERENCES	
CURRENT EMPLOYER	DIPLOMA / DEGREE	NAME	RELATIONSHIP
ABC COMPANY	BACHELOR'S	JOHN SMITH	BOSS
PREVIOUS EMPLOYERS			
DEF CORP			
EDUCATIONAL INSTITUTIONS			
UNIVERSITY OF CALIFORNIA			
TECHNICAL SKILLS			
PROFICIENCY LEVEL			
EXPERIENCE			
REMARKS			

SEE W202 ENG FOR HQG RATIO

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ASSIGNED TO  
*V.R. Stevens*  
 FPL SIGNID  
 DATE *7-17-81*

0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99																																																																																																				
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July 21, 1982  
L-82-295

Mr. Harold R. Denton, Director  
Office of Nuclear Reactor Regulation  
U. S. Nuclear Regulatory Commission  
Washington, D.C. 20555

Dear Mr. Denton:

RE: Turkey Point Units 3 & 4  
Docket Nos. 50-250, 50-251  
FSAR Update

Florida Power & Light has completed an update of the Turkey Point Units 3 & 4 Final Safety Analysis Report in accordance with 20 CFR 50.71(e). The required thirteen copies of the updated Report are being submitted separately.

Due to the large amount of changes which have occurred during the ten years of plant operation, there are several changes which still require verification. These consist of changes to the description of the Waste Disposal System, and verification should be complete by August 30, 1982.

Paragraph (2) of the above regulation requires an identification of changes made under the provisions of 10 CFR 50.59 but not previously reported to the Commission. In the "questions and answers" section of the NRC Generic Letter 81-06 dated February 26, 1981, the staff indicated that this first submittal should be a "clean" document without identification of changes. Following this guidance, we have not marked the changes made in accordance with 10 CFR 50.59.

Florida Power & Light submits changes made under the provisions of 50.59 in an annual submittal covering the period of July 1 of one year to June 30 of the next. Descriptions of the plant changes/modifications which were completed prior to June 30, 1981, were submitted to the Commission in these annual submittals. This year's report, covering the period from July 1, 1981 through June 30, 1982 is scheduled to be submitted by September 1, 1982. In order to avoid duplicate reporting for this first update, we intend to meet the FSAR update requirement for change identification by means of this annual 50.59 submittal.



Mr. Harold R. Denton  
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July 21, 1982

It should be noted that all plant change/modifications made to Turkey Point Units 3 & 4 as of the cut off date of January 22, 1982, have been included in the FSAR update.

Very truly yours,

A handwritten signature in cursive script, appearing to read "Robert E. Uhrig".

Robert E. Uhrig  
Vice President  
Advanced Systems & Technology

REU/PLP/cab

Attachment

cc: Harold F. Reis, Esquire

STATE OF FLORIDA )

**SS.**

COUNTY OF DADE )

- Robert E. Uhrig , being first duly sworn, deposes and says:

That he is Vice President of Florida Power &  
Light Company, the herein;

That he has executed the foregoing document; that the statements made in this said document are true and correct to the best of his knowledge, information, and belief, and that he is authorized to execute the document on behalf of said

Robert E. Uhrig

Subscribed and sworn to before me this

21 day of July, 1982

Cheryl L. Fredrick  
NOTARY PUBLIC, in and for the County of Dade,  
State of Florida

My commission expires:

Notary Public, State of Florida at Large  
My Commission Expires October 30, 1983  
Bonded thru Maynard Bonding Agency