

DUKE POWER COMPANY

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January 10, 1984

Mr. James P. O'Reilly, Regional Administrator  
U. S. Nuclear Regulatory Commission  
Region II  
101 Marietta Street, NW, Suite 2900  
Atlanta, Georgia 30303

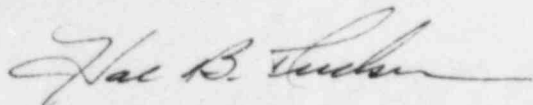
Subject: Oconee Nuclear Station  
Docket Nos. 50-269, -270, -287

Dear Mr. O'Reilly:

In regard to IE Bulletin 81-01 (item 3), Duke Power Company has completed inspections of the Oconee Unit 1, Unit 2, and Unit 3 inaccessible mechanical snubbers. No failures of the inaccessible snubbers were found. Results of the Unit 3 inspection were transmitted in a March 20, 1981 letter from Mr. W. O. Parker, Jr. For clarity, that information (with additional Unit 3 inspection data) will be repeated again in the attached report. Included in the report is a listing of the number of snubbers examined and tested and their grouping by manufacturer name, model number, and size. Portions of the inspection procedure are also included as Attachment 2.

I declare under penalty of perjury that the statements set forth herein are true and correct to the best of my knowledge, executed on January 10, 1984.

Very truly yours,



Hal B. Tucker

JCP/php

Attachment

cc: Mr. J. C. Bryant  
NRC Resident Inspector  
Oconee Nuclear Station

Mr. John F. Suermann  
Office of Nuclear Reactor Regulation  
U. S. Nuclear Regulatory Commission  
Washington, D. C. 20555

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Attachment 1

Oconee Nuclear Station  
Response to IE Bulletin 81-01 Item 3  
Inaccessible Snubber Inspection

All snubbers are manufactured by Pacific Scientific.

	<u>Quantity</u>	<u>Model No.</u>	<u>Stroke</u>	<u>Size</u>
Unit 1				
Total - 7 snubbers	6	307	1/4	4
Inspection completed 08/06/81	1	306	1/2	2½
Unit 2				
Total - 17 snubbers	4	307	1/4	4
Inspection completed 03/02/82	1	306	1/2	2½
	6	307	1/2	2½
	2	306	1	4
	3	307	1	4
	1	307	3	5
Unit 3				
Total - 12 snubbers	12	306	35	6
Inspection completed 02/20/81				

NOTE: Inspection Report No. 50-269/83-24, 50-270/83-24 and 50-287/83-24, transmitted by an August 30, 1983 letter from Mr. H. C. Dance, closed 81-BU-01 concerning the surveillance of mechanical snubbers. Inspector E. H. Brooks stated that "the licensee has completed the portion of the bulletin applicable to Oconee snubbers, i.e., the licensee completed inspection of mechanical snubbers produced by manufacturers other than International Safeguards Corporation (INC)."

DUKE POWER COMPANY  
OCONEE NUCLEAR STATION  
INSPECTION OF INACCESSIBLE PSA MECHANICAL SNUBBERS

1.0 Purpose

The purpose of this procedure is to provide instructions for stroking PSA Mechanical Snubbers to ensure that they are operable and no damage was incurred during installation or plant operation.

2.0 References

2.1 P.S.A. Letter to file 9.3.3.10 dated November 21, 1980

2.2 P.S.A. Instruction Manual No. PS142, Rev. 1

3.0 Personnel Requirements

Refer to work request, section III.

4.0 Safety Considerations

4.1 Health Physics Considerations

4.1.1 Radiation work permit issued if required.

4.2 Equipment Clearance and Isolation

N/A

4.3 Special Safety Considerations

4.3.1 Observe all safety rules while performing work.

4.4 Special Equipment Safety Considerations

4.4.1 Do not use snubbers as steps or hand holds.

4.4.2 Use rigging and special handling tool in the manner necessary to prevent injury to personnel and/or damage to snubber.

4.4.3 When stroking snubber, keep velocity/movement of shaft slow enough to prevent a slap at each end of travel.

5.0 Unit Status

5.1 Unit must be at the shutdown condition.

6.0 Prerequisites

6.1 Contact Shift Supervisor prior to work.

6.2 Contact QC Inspector (if required).

7.0 Repair Parts

N/A

8.0 Special Tools

8.1 Special lifting and handling fixture for large PSA-35 and PSA-100 size.

9.0 Acceptance Requirements

9.1 All load bearing pipe restraint, support restraint and pins secure and capable of carrying design loads.

9.2 Snubber properly oriented and secure in this position.

9.3 The snubber strokes freely thru its full range for all sizes.

10.0 Interference Items

None

11.0 Procedure (Record on appropriate Enclosure 13.2)

11.1 Visual Inspection - Visually observe for any physical damage which may have occurred to the snubber or supporting components. This visual inspection shall include but not necessarily be limited to the information requested on the data forms.

11.1.1 Piston Rod Setting - The piston rod is graduated with numbers. Read and record the setting to the nearest 1/4".

11.1.2 Piston Rod Condition - Check if the rod is bent, cracked, oily, painted or anything else that would cause it not to function properly.

11.1.3 Snubber Condition - Ensure there are no welding arc marks on the snubber.

11.1.4 Retaining devices - Ensure that clevis pins/load studs and any other fasteners are in place and properly secured with cotter pins, snap rings or jam nuts.

11.1.5 Attachments - Ensure that bolts which are attaching brackets/extension pieces are properly torqued and/or safetied.

11.1.6 Snubber Lug - Ensure that the lug (part which contains self-aligning bearing) does not interfere with rear bracket ears and/or pipe clamp area.

## 11.2 Snubber Removal

NOTE: If any damage is observed, DO NOT perform any work on the snubber. Notify the cognizant engineer immediately for evaluation of the problem and action to be taken. If no damage is observed, proceed to the following steps of this procedure.

11.2.1 Verified snubber condition to be serviceable.

11.2.2 Attach rigging as necessary to the snubber body before detaching either end of snubber from brackets.

CAUTION: Since many of the snubbers are located in places which are hard to reach, observe the following:

- A) All safety rules (including the use of safety belts when needed).
- B) Ensure that personnel performing the work attach rigging in a manner which will not result in injury to personnel or damage to snubber.

NOTE: Stroking of sizes 1/4, 1/2, 1, 3 and 10 can be done manually; sizes 35 and 100 will need rigging and/or aid of snubber lifting and handling fixture.

11.2.3 Detach ends of snubber from brackets as needed to allow for extending and retracting of snubber shaft through its full range of travel.

NOTE: When detaching ends of snubber, detach the telescoping tube/shaft end only (if possible) provided there is sufficient room to stroke the snubber in place. Also do not change the setting of any extension piece on the 307 model snubbers.

11.2.4 Manually stroke the snubber through its full range of travel by extending and retracting the snubber shaft for all sizes 1/4, 1/2, 1, 3, 10, 35 and 100. If snubber strokes freely, reconnect the snubber in its proper position and sign off Data Sheet (Enclosure 13.2). If snubber does not stroke freely, inform the cognizant engineer in charge of snubber testing so the problem can be evaluated to determine what further action is required.

11.2.5 Record the reinstalled snubber serial number and piston rod setting.

NOTE: If for some reason, the end cap alignment (for sizes 1/4 and 1/2 only) is not correct, do not try to re-align by using any type physical force

because by rotating piston shaft in this manner will result in damage to the internal parts of the snubber. If end cap requires re-aligning, contact the cognizant engineer (who will instruct in proper way to re-align end cap).

### 11.3 Final Disposition of the Snubber

NOTE: This section to be filled out by the cognizant engineer.

11.3.1 Snubber operability status.

11.3.2 Work Request if repairs are required to be written by cognizant engineer or his designee. N/A if no repairs required.

11.3.3 Snubber returned to operability after necessary repairs. N/A if no repairs required.

### 12.0 Restoration

NOTE: This section to be filled out by the cognizant engineer.

12.1 Notify Shift Supervisor that all snubbers are operable.

12.2 Cognizant engineer has reviewed data sheets and verified the number of inoperative snubbers.

### 13.0 Enclosures

13.1 List of Inaccessible Mechanical Snubbers

13.2 Snubber Data Sheet

13.3 Procedure Sign-off Sheet

13.4 Snubber Sketches