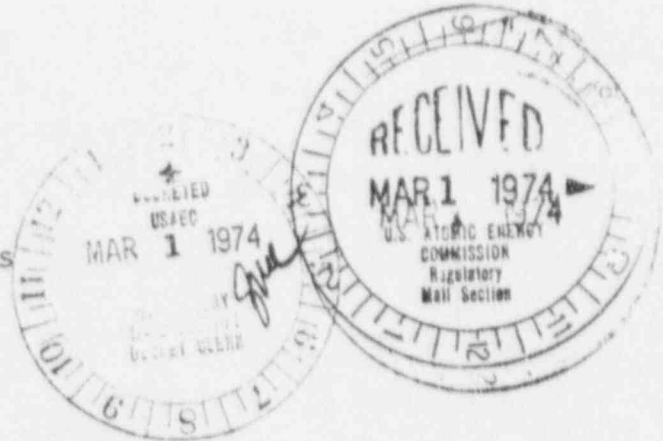


**NSP****NORTHERN STATES POWER COMPANY**

Minneapolis, Minnesota 55401

February 25, 1974

Mr. D. J. Skovholt  
Assistant Director for Operating Reactors  
Directorate of Licensing  
United States Atomic Energy Commission  
Washington, D. C. 20545



Dear Mr. Skovholt:

MONTICELLO NUCLEAR GENERATING PLANT  
Docket No. 50-263 License No. DPR-22

#### Hydraulic Shock Suppressors and Restraints

Pursuant to our November 30, 1973, report, all shock suppressors on safety related systems located outside primary containment have been inspected externally on a monthly basis. Rebuilding of these units, to provide ethylene propylene internal parts and high temperature, high pressure, leakproof oil fill fittings having Buna-N seats, has been completed. Additionally, all units located within primary containment were inspected externally on February 17, 1974. Inspection results, corrective measures and other information requested in your letter to Mr. L O Mayer, dated October 1, 1973, are contained in this report.

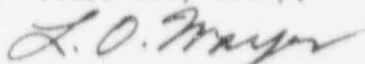
External inspection of the units in the drywell identified four units (SS-1BR, 4BR, 6AR and 8AR) which had indications of possible oil loss as observed by changes in the relative positions of the main piston rod and accumulator position indicator rod. No evidence of significant oil loss was found when the external portions of the units were examined. None of the four units were inoperable. Oil was added to these units and no leakage was observed during the following 24 hours. It is possible that the indications of oil loss were due to redistribution or leakage of air trapped in the suppressors during the initial oil filling operation. External inspection of the units outside primary containment identified slight oil loss from two units prior to rebuilding, however, neither of the two units had sufficient oil loss to render the unit inoperable. During the rebuilding program numerous units were found to have seal and metal parts damage due to the presence of foreign materials such as dirt, rust and metal chips. The "as-found" conditions of the rebuilt units are summarized in the attached Table I - Shock Suppressors Internal Inspection Results".

9105070410 740225  
PDR ADOCK 05000263  
P PDR

1647

As noted in our letter of November 30, 1973, four units located within the drywell were provided thermocouples for determining the temperature environment. Additionally other units were provided temperature sensitive indicating tapes. Analysis of temperature data over the past several months indicates that the temperatures range from 98°F to 140°F with an average temperature of 115°F.

Yours very truly,



L. O. Mayer, PE  
Director of Nuclear Support Services

LOM/mm

Attach.

cc: JG Keppler  
G Charnoff  
Minnesota Pollution Control Agency  
Attn: E. A. Pryzina

TABLE I - SHOCK SUPPRESSOR INTERNAL INSPECTION RESULTS

<u>Unit</u>	<u>Location</u>	<u>Date of Last Maintenance</u>	<u>As Found Condition</u>	<u>Corrective Action</u>
SS-21	RHR	Original Installation	Scored cylinders and stuck piston rings.	Honed and polished cylinders. Installed spare piston, rod, and rings.
SS-22	RHR	Original Installation	Scored cylinders, foreign material in accumulator, and back-up washer missing.	Honed and polished cylinders.
SS-23	RHR	Original Installation	Found in good condition.	
SS-24	RHR	Original Installation	Found in good condition.	
SS-25	RHR	Original Installation	Found in good condition.	
SS-26	RHR	August 1973	Found in good condition.	
SS-27	RHR	Original Installation	Scored and pitted cylinder.	Replaced with new unit.
SS-28A	RHR	Original Installation	Found in good condition.	
SS-28B	RHR	Original Installation	Found in good condition.	
SS-29	RHR	Original Installation	Found in good condition.	
SS-30	RHR	Original Installation	Found in good condition.	
SS-31	RHR	Original Installation	Scored piston and cylinder.	Honed and polished cylinder.
SS-32A	RHR	Original Installation	Found in good condition.	
SS-32B	RHR	Original Installation	Found in good condition.	
SS-33	RHR	Original Installation	Scored piston and cylinder with a misaligned nose seal.	Honed and polished cylinder. Realigned seal.
SS-34	RHR	Original Installation	Found in good condition.	
SS-35	HPCI	August, 1973	Found in good condition.	

TABLE I - SHOCK SUPPRESSOR INTERNAL INSPECTION RESULTS (Cont'd.)

<u>Unit</u>	<u>Location</u>	<u>Date of Last Maintenance</u>	<u>As Found Condition</u>	<u>Corrective Action</u>
SS-36A	HPCI	Original Installation	Scored cylinder and dirty oil.	Honed and polished cylinder.
SS-36B	HPCI	August, 1973	Found in good condition.	
SS-37	HPCI	Original Installation	Scored cylinder and dirty oil.	Honed and polished cylinder.
SS-38A	RCIC	Original Installation	Scored cylinder.	Honed and polished cylinder.
SS-38B	RCIC	Original Installation	Scored cylinder, piston loose on shaft and dirty oil.	Substituted a unit from a non-safety related system.
SS-40	HPCI	November, 1973	Not rebuilt since previously provided EP parts.	
SS-41	Core Spray	November, 1973	Not rebuilt since previously provided EP parts.	
SS-42	HPCI	Original Installation	Found in good condition.	

FILE:

FROM: Northern States Power Co. Minneapolis, Minn. L. O. Mayer		DATE OF DOC 2-25-74	DATE REC'D 3-1-74	LTR X	MEMO	RPT	OTHER
TO: D. J. Skovholt		ORIG 1 signed	CC 39	OTHER	SENT AEC PDR XXX SENT LOCAL PDR XXX		
CLASS UNCLASS	PROP INFO	INPUT	NO CYS REC'D 40	DOCKET NO: 50-263			
XXX							

DESCRIPTION:

Ltr furn info re inspection of snubbers  
trans the following....

ENCLOSURES:

Table: Titled Shock Suppressor Internal  
Inspection Results

DO NOT REMOVE

ACKNOWLEDGED

PLANT NAME: MONTICELLO

(40 cys attachment rec'd)

FOR ACTION/INFORMATION 3-1-74 GMC

BUTLER(L)	SCHWENCER(L)	✓ ZIEMANN(L)	REGAN(E)
W/ Copies	W/ Copies	W/ 5 Copies	W/ Copies
CLARK(L)	STOLZ(L)	DICKER(E)	
W/ Copies	W/ Copies	W/ Copies	W/ Copies
GOLLER(L)	VASSALLO(L)	KNIGHTON(E)	
W/ Copies	W/ Copies	W/ Copies	W/ Copies
KNIEL(L)	SCHEMEL(L)	YOUNGBLOOD(E)	
W/ Copies	W/ Copies	W/ Copies	W/ Copies

INTERNAL DISTRIBUTION

REG FILE	TECH REVIEW	DENTON	LIC ASST	A/T IND
✓ AEC PDR	✓ HENDRIE	GRIMES	✓ DIGGS (L)	BRAITMAN
OGC, ROOM P-506A	✓ SCHROEDER	GAMMILL	GEARIN (L)	SALTZMAN
MUNTZING/STAFF	✓ MACCARY	KASTNER	GOULBOURNE (L)	B. HURT
✓ CASE	KNIGHT	BALLARD	LEE (L)	✓ PLANS
GIAMBUSSO	PAWLICKI	SPANGLER	MAIGRET (L)	✓ MCDONALD
BOYD	SHAO		SERVICE (L)	DUBE w/Input
MOORE (L)(BWR)	STELLO	ENVIRO	SHEPPARD (E)	INFO
✓ DEYOUNG(L)(PWR)	HOUSTON	MULLER	SMITH (L)	C. MILES
✓ SKOVHOLT (L)	NOVAK	DICKER	TEETS (L)	B. KING
P. COLLINS	ROSS	KNIGHTON	WADE (E)	
DENISE	IPPOLITO	YOUNGBLOOD	WILLIAMS (E)	
✓ REG OPR	TEDESCO	REGAN	WILSON (L)	
✓ FILE & REGION(3)	LONG	PROJECT LDR	S. REED (L)	
MORRIS	LAINAS			
STEELE	BENAROYA	HARLESS		
	VOLLMER			

EXTERNAL DISTRIBUTION

✓ 1 - LOCAL PDR MINNEAPOLIS, MINN.	(1)(2X10)-NATIONAL LAB'S	1-PDR-SAN/LA/NY
1 - DTIE(ABERNATHY)	1-ASLBP(E/W Bldg, Rm 529)	1-GERALD LELLOUCHE
1 - NSIC(BUCHANAN)	1-W. PENNINGTON, Rm E-201 GT	BROOKHAVEN NAT. LAB
1 - ASLB(YORE/SAYRE/	1-CONSULTANT'S	1-AGMED(Ruth Gussman)
WOODARD/"H" ST.	NEWMARK/BLUME/AGBABIAN	RM-B-127, GT.
✓ 16 - CYS ACRS <del>XXXX</del>	1-GERALD ULRIKSON...ORNL	1-RD..MULLER..F-309 GT
Sent to Lic Asst Diggs 3-1-74		