



**Department of Energy**  
**National Nuclear Security Administration**  
Washington, DC 20585

00-0002123

November 17, 2000

RECEIVED  
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DNF SAFETY BOARD

The Honorable John T. Conway  
Chairman  
Defense Nuclear Facilities Safety Board  
625 Indiana Avenue, N.W.  
Suite 700  
Washington, D.C. 20004

Dear Mr. Chairman:

Enclosed is a copy of the Final Change Order (FCO) requiring the use of Inconel 718 capscrews to secure the flange on the AL-R8 Sealed Insert (SI) for all future container assembly procurements. This FCO is a deliverable to you under Commitment 5.1.1 of the Department's Recommendation 99-1 Implementation Plan (IP). As discussed in the IP, the Department will incorporate this new corrosion-resistant capscrew into the AL-R8 SI design to replace carbon steel capscrews. Procurement of the initial lot of Inconel 718 capscrews was initiated on September 29, 2000, with an expected delivery in February 2001.

If you have any questions concerning this information, please contact me at (202) 586-4879 or Tim Evans at (301) 903-3989.

Sincerely,

David E. Beck  
Assistant Deputy Administrator  
for Military Application and  
Stockpile Operations  
Defense Programs

Enclosure

cc w/enclosure:

Mark B. Whitaker; S-3.1



00-2123

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ZNR UUUUU UNCLASSIFIED/N O N W D/NARR  
R 202020Z OCT 00

CHG NO: 20000087PX  
CHG CLS: B  
REV NO: 0  
4277

SUBJECT: FINAL CHANGE ORDER  
ICO NO:  
FROM PX/J.L. ADDINGTON, EXT.  
TO: PX/J.B. RHODES, EXT.

6329  
REFERENCE LEVELS RELATED RELEASES DISTRIBUTION ER  
DRAWING

PROGRAM: AL-R8 SI	SIER 980037PX	DOE/AL/NMSPO	S.	ARP	T
		DOE/AAO	D.	KELLY	T
		DOE/AAO	E.	DEMERSON	T
		DOE/AAO	L.	SHAFFER	T
		LL/L125	S.	ABDULLAH	T
		LL/L125	S.	COUTURE	T
		LL/TRILAB	S.	WIHEBRINK	T
		LA/	G.	CARLSON	T
		LA/TRILAB	R.	HENDERSON	T
		PX/850	G.D.	COCKRELL	T
		PX/850	J.L.	ADDINGTON	T
		PX/910	R.	BAKER	T

REASON FOR RELEASE

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TO UPDATE DOCUMENTS WITH RESULTS FROM 718 ALLOY FASTENER STUDIES.

REASON FOR REVISION

DRAWING	DWG	NEW	SUF	NEW	INSP	REPORTING/EFFECTIVITY
NUMBERS	LOC	DA	PA	ISSUE	ALT	REQUIREMENTS
706035	PX	003		H		
TK706035	PX			F		
PQ706036	PX			F		
PS706035	PX			B		

INCORPORATION INSTRUCTIONS & MATERIAL DISPOSITION

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CHANGED PRODUCT WILL BE INCORPORATED BY THE PA AS SOON AS POSSIBLE  
FOLLOWING  
RECEIPT OF NEW PRODUCT. EXISTING PRODUCT MAY BE USED VIA SXR IF THE  
CARBON  
STEEL FASTENERS ARE REPLACED WITH THE 718 ALLOY FASTENER DEFINITION.

REFERENCES & REMARKS

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CHANGES COORDINATED WITH LLNL AND LANL DURING 706035 PRT MEETING OF  
10/05/00-  
10/06/00. CONCURRENCE PROVIDED VIA EMAIL FROM LLNL/S. ABDALLAH AND  
LANL/G.  
CARLSON.

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CHG NO: 20000087PX  
CHG CLS: B  
REV NO: 0

DOC CODE	REVISION	APPROVED BY	AGENCY	ORG	DATE
FCO	0	G.D. COCKRELL	PX	850	10/20/00

DESCRIPTION OF RELEASE

1.0 706035-002 ISSUE G.

1.1 ADD NEW LINE 31400 AS TOOLING DRAWING 13296 ISSUE 0, 718 ALLOY FASTENER DEFINITION.

1.2 CHANGE LINE 30200 FROM 13047 ISSUE 5 TO 13047 ISSUE 6.

2.0 TK706035-001 ISSUE E.

2.1 ADD DATA FROM PARA. 3.2.2. CARBON STEEL DROP TEST TO APPENDIX A.8.

2.2 ADD NEW APPENDIX B WITH DATA FROM 718 ALLOY FASTENER TESTING.

3.0 PQ706035-001 ISSUE E.

3.1 ADD NEW PARAGRAPH 4.4.2.F(LC) PROVIDING 718 ALLOY STUDY REQUIREMENTS INCLUDING THERMAL ANALYSIS AND GALLING STUDY.

3.2 CHANGE APPENDIX G TO H AND APPENDIX F TO G

3.3 ADD THERMAL ANALYSIS AND GALLING STUDY DATA TO APPENDIX G.

3.4 ADD NEW APPENDIX F WITH ATTENDANCE ROSTER AND MINUTES FROM 718 ALLOY FASTENER REVIEW/PRT MEETING.

4. PS706035-000 ISSUE A.

4.1 UPDATE PARA. 4 TEAM MEMBERSHIP TO REFLECT CURRENT PRT MEMBERSHIP.

4.2 IN PARA. 3.2.9.C.7, ADD NOTE STATING "WHEN USING SI CONTAINERS WITH 718 ALLOY FASTENERS, MULTIPLE PASSES WILL BE NECESSARY TO REACH AND MAINTAIN THE 40-50 FT-LBS TORQUE VALUE."

END OF PAGE 2 OF 2/UNCLASSIFIED

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