

	<h1 style="margin: 0;">Specification Change Notice</h1>	Page 1 of 2  CHANGE DOCUMENT NO. 24590-LAW-3PN-LMP-00002
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JOB NO. 24590	TITLE FOR CHANGE NOTICE Update Seismic Clamp Installation		
DOCUMENT NUMBER	REV	DOCUMENT NUMBER	REV
24590-LAW-3PS-LMP-T0002	1		

PART OF DESIGN CHANGE PACKAGE (DCP)?  Yes  No      DCP No.: \_\_\_\_\_      Rev: \_\_\_\_\_

**JUSTIFICATION FOR CHANGE**

Is the change associated with a Q SSC?       Yes       No  
 If yes, was margin reduced?       Yes       No  
 If margin was reduced provide Calculation or MAJ number:  
 Justification:  
 The spring compression distance as indicated in this change was determined by the structural analysis group to provide the required force loading for seismic motion. This SCN is issued concurrently with calculation 24590-LAW-M2C-LMP-00002 to provide this technical basis.

Supersedes Change Document       Yes       No

**REQUIREMENTS REVIEW**

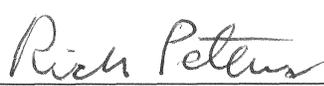
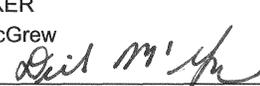
Client Approval Required       Yes       No      Interface Resolution Required \*       Yes       No

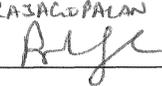
*Address any "yes" answers in the description*

**DESCRIPTION OF CHANGE**

Specification Changes Retroactive       Yes       No

Change Section 4.12 as shown in markup on following page.

ORIGINATOR ORG/Discipline – Rich Peters 	CHECKER Dick McGrew 
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Approval(s)			
Title LAWMECH EGS P. RAJAGOPALAN 	Title N/A	Title N/A	Title N/A

**Date (inserted by final approver):** 11/19/15

Please note that source, special nuclear, and byproduct materials, as defined in the Atomic Energy Act of 1954 (AEA) are regulated at the U. S. Department of Energy (DOE) facilities exclusively by DOE acting pursuant to its AEA authority. DOE asserts that pursuant to AEA, it has sole and exclusive responsibility and authority to regulate source, special nuclear, and byproduct materials at DOE-owned nuclear facilities. Information contained herein on radionuclides is provided for process description purposes only.

4.11.6 Construction to move the melter North, align the North East Seismic Pin slots and install the Seismic Pin (24590-QL-POA-MQR0-00001-02-00015) through Seismic Pin Support Frame and into the mating Seismic Pin Rail Slot. Note: Construction to monitor the East/West position of the wheels during Melter movement to ensure the wheel to rail overlap does not exceed 0.25”.

4.11.7 Construction to install the North West Seismic Pin (24590-QL-POA-MQR0-00001-02-00015) through North West Seismic Pin Support Frame and into the mating Seismic Pin Rail Slot, install Shims (items 58, 59, and 60 of WTP-M-11950) as required to fill the space between the Seismic Pin Support Frame and the melter base, and snug tighten Bolts (items 21 of WTP-M-11950).

4.11.8 Construction to measure the “Melter Discharge Spout centerlines relative to as-built LAW Container centerline with the Elevator in the lifted/pour position” for the purpose of documenting the alignment.

**Hold Point 25** - Contractor to verify the “Melter Discharge Spout centerlines relative to as-built LAW Container centerline with the Elevator in the lifted/pour position” are within tolerance IAW 24590-WTP-FC-M-12-0350 based on Construction’s documentation.

Note: If the alignment exceeds the tolerance specified in 24590-WTP-FC-M-12-0350, the melter may be moved North or South by installing another combination of Shims (items 58, 59, and 60 of WTP-M-11950) between the Seismic Pin Support Frame and the melter base after Contractor approval.

4.11.9 Construction to tighten Bolts (items 21 of WTP-M-11950) and install Nuts (items 61 of WTP-M-11950) IAW WTP-M-11950

4.12 Installing Base Seismic Clamp Assemblies (items 23 of WTP-M-11950)

THIS SCN

~~4.12.1 Construction to tighten Nut (item 3 of WTP-M-11715) until Belleville washers (items 6 of WTP-M-11715) are fully compressed on each Base Seismic Clamp Assembly.~~

4.12.1

~~4.12.2 Construction to install the 10 Base Seismic Clamp Assemblies, Bolts, and Washers (items 23, 24, and 25 of WTP-M-11950) to the melter base IAW WTP-M-11950.~~

~~4.12.3 Construction to loosen the adjustment Nut (item 3 of WTP-M-11715) on each Base Seismic Clamp Assembly until the resulting compressed height of the stacked Belleville Washers (item 6 of WTP-M-11715) is equal to 75% of the uncompressed height specified on WTP-M-11715 within a tolerance of +0.0/-0.03 inches.~~

~~4.12.4 Construction to verify the end of the Seismic Retainer is touching the side of the melter rail and the Nut should be loose. If this is not the case, insert stainless steel shim material (minimum 5 1/2” by 5 1/2”) as needed between the Seismic Retainer and the melter rail to achieve the prescribed height while maintaining the compressed height. Tighten the two Nuts (items 3 of WTP-M-11715) together without disturbing the preload on the Belleville Washers.~~

4.12.2 Shim as necessary between seismic retainer head and melter rail to achieve a final spring compression set on each seismic clamp assembly of 0.258 +/- 0.010 inch, with jam nuts (item 3) locked in place with a minimum total gap of 3/8 inches between nut (item 3) and washer (item 5) and the Clamp Frame (item 1).