

Coded Note Number: **T1530**

Revision: **C005**

Date: **November 30, 2015**

Title: **CAPPING AND SEALING OF ORIFICES**

This revision history is provided for convenience and does not alleviate the supplier's responsibility with understanding and complying with the full coded note.

Change from Revision C004 to clarify the required tape for sealing orifices.

Bolded font indicates changed/added content.

[Text deleted] inserted in the document indicates the removal of content.

The orifices (end connections and other openings) for components covered by this purchase order shall be capped and sealed prior to shipment in order to maintain cleanliness and provide maximum protection against damage and contamination during shipment and storage at NNS. Orifices shall be individually capped and sealed. Standard shipping packaging is not an acceptable alternative for capping and sealing of orifices.

Preferred materials for devices used to cap or plug openings are: non-galvanized metal, high-strength rigid plastic, or rubber. However, these materials are required to cover openings on piping components with internal crevices or inaccessible areas (valves, pumps, etc...)

Wood products (including plywood and composites) may be used on items other than piping components with internal crevices or inaccessible areas (valves, pumps, etc...), provided they are weather (moisture) resistant, not susceptible to delaminating, splintering, or premature deterioration. Wood products shall also be durable/strong enough to withstand normal shipping and warehouse type environments (i.e. storage and handling) without degradation in the ability to provide adequate protection against damage and maintain cleanliness of the equipment's internal surfaces and parts.

Additionally, any material used shall not pose a contamination or corrosion hazard. The degree of cleanliness of sealing device in contact with the component shall be equal to that of the component on which it is installed.

Other than devices which are self-securing, such as NP type caps, all other types of closures shall be attached with wire, nylon ties or bolts, and sealed with tape.

For flange mating surface protection, all of the approved flange protective covers mentioned above must be attached to the flange at four or more points evenly spaced around bolt hole circle and/or flange circumference. If nylon ties are used for attachment, their individual tested breaking strength must exceed the weight of the flange. **[Text deleted] If used, sealing tape shall be 3M Performance Plus duct tape 8979N, slate blue in color.** Tape may also be applied around the complete circumference instead

of the four or more individual locations mentioned above. If a flexible flange protector is used then it must be attached with tape. If flanges are not available, seal the orifice with tape of type as noted above.

For protection of weld preps on flanges, fittings and components, the weld preps should be protected with an approved cover that is fixed in place with tape of type as noted above.

Small components, for which capping/sealing of each orifice as directed above cannot be accomplished, or is impractical, may have each orifice sealed with tape as described in the previous paragraphs, or may have the entire component enclosed. Enclosing of small components is acceptable as long as the enclosure provides adequate protection against damage and maintains cleanliness of the component's internal surfaces and parts.

The use of yellow wrapping material and attached yellow protection devices, such as caps and plugs, is strictly prohibited.

Failure to comply with the requirements of this paragraph shall be cause for rejection.