

SECTION 3

TECHNICAL SPECIFICATION

FOR

DOT STRONG TIGHT CONTAINER (STC) - 90 CU. FT.,

FOR NEVADA TEST SITE (NTS) LOW-LEVEL WASTE (LLW)

ST-90-N

9/20/2000

[Signatures on file]

2	9/20/00	Revise bolt, TID and security hole size and location, dimensional tolerances, handle design, lid forklift bracket, and other minor editorial corrections	JR McNutt	TC Tharp	JW Goskowicz	EJ Najmola
1	3/6/00	Revised to Specify Welding of ID Plate	JR McNutt	JW Goskowicz	JR McNutt	EJ Najmola
0	6/11/99	Issued for Use	WF Carden	LS Jones	WF Carden	WR Zulliger
REV	DATE	REASON FOR REVISION	ORIGINATOR	CHECKER	LEAD ENGINEER	PROJ. ENGR/ES



Bechtel Jacobs Company LLC

ENVIRONMENTAL MANAGEMENT - MANAGEMENT & INTEGRATION PROJECT

JOB NO. **23900**

SPECIFICATION NO.: **SPM-000000-A001**

SHEET 1 of 16

**TECHNICAL SPECIFICATION SPM-000000-A0001 FOR
DOT STRONG TIGHT CONTAINER - 90 CU. FT.,
FOR NEVADA TEST SITE LOW-LEVEL WASTE
ST-90-N**

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**TECHNICAL SPECIFICATION SPM-000000-A001 FOR
DOT STRONG TIGHT CONTAINER - 90 CU. FT.,
FOR NEVADA TEST SITE LOW-LEVEL WASTE
ST-90-N**

1.0 GENERAL

This specification covers the requirements for a metal container that can be utilized for the packaging of low specific activity (LSA) and surface-contaminated objects (SCO) radioactive material in exclusive use transportation, which meets the Department of Transportation (DOT) requirements for a strong tight container (STC) and industrial packaging, Type IP-1. This container shall be designated as the ST-90-N, Strong Tight Metal Container for NTS Low-Level Waste.

1.1 Description:

Rectangular metal container, painted, with metal lid, gasketed lid, bolted closure, and permanently fixed skid runners, 72 inch x 46 inch x 47 inch ID (nominal) overall dimensions (90 cubic feet internally), Department of Transportation (DOT) strong tight container (STC) and industrial packaging, Type IP-1, in compliance with DOT regulations [Title 49 Code of Federal Regulations (CFR)] referenced in this specification.

1.2 References:

1.2.1 DOT - 49 CFR Part 173.24 and 173.410 [STC] and 173.411(a) and (b)(1) [IP-1]

- 1.2.2 American Society for Testing and Materials (ASTM) A-36
- 1.2.3 American Society for Testing and Materials (ASTM) A-569
- 1.2.4 American Society for Testing and Materials (ASTM) D-1056-67
- 1.2.5 American Welding Society (AWS) D1.1, "AWS Structural Welding Code"
- 1.2.6 American Welding Society (AWS) D1.3, "AWS Sheet Metal Welding Code"
- 1.2.7 American Society for Nondestructive Testing, Recommended Practice SNT-TC-1A, Dec. 1988
- 1.2.8 American Welding Society, Specification for Qualification and Certification of Welding Inspectors, 1988 Edition
- 1.2.9 Society of Automotive Engineers (SAE) J-18-XE42

1.3 Submittals:

A listing of the documentation that must be addressed in the SELLER'S response or that must be provided after subcontract award and prior to fabrication is given below.

1.3.1 Container design drawings shall be submitted **prior to fabrication** for BUYER review. BUYER will provide design drawing comments and or revisions. SELLER shall issue a final container design drawing for BUYER review **prior to fabrication**. Container design drawings submitted for review shall include at a minimum:

- Standard engineering drawing dimensioning for manufacturing purposes,
- Container engineering drawings shall include as a separate drawing a depiction of the sheet steel bending diagrams which shall indicate the sheet steel size, required sheet steel cuts, and sheet steel bends which shall be utilized in the fabrication process for each of the container panels.
- All container welds shall be clearly identified and appropriately annotated to indicate the size and type of weldment used in the container fabrication.
- All container design features, such as, lid lifting bracket, closure mechanisms, forklift base channels, etc. shall be clearly identified and dimensionally annotated to indicate specific design characteristics.
- State the container design internal container dimensions, waste volume capacity in cubic feet (ft³), container burial volume in cubic feet (ft³), design payload capacity in pounds (lb), and maximum design loaded gross weight in pounds (lb).

1.3.2 SELLER shall submit **prior to fabrication** a copy of their Welding Procedure Qualification Records (PQRs) and Welder Performance Qualification Records (WPQRs including updates).

- 1.3.3** SELLER shall provide certification, **prior to fabrication** of the container, that the container design meets the design load capacity, design stack height, one (1) foot drop and vibration tests. Certification shall be in the form of engineering structural calculations, test results or reports, or by submission of engineering drawings for an approved (by whom) container fabrication design that has prior regulatory authority acceptance and meets the stipulated design characteristics and dimensional requirements of this specification. If the required prototype tests have not been performed, provide a test plan and schedule for review . **BUYER written authorization to begin fabrication will be given after certified test results have been received and accepted by BUYER. Fabrication shall not commence until authorization has been given by BUYER..**
- 1.3.4** SELLER shall submit **prior to fabrication** the material specification for all container steel.
- 1.3.5** SELLER shall submit **prior to fabrication** the material specification for lid gasket material.
- 1.3.6** SELLER shall submit **prior to fabrication** the recommended bolt torque for proper lid closure.
- 1.3.7** SELLER shall submit **prior to fabrication** their procedure for random container selection and fabrication lot size determination for BUYER review as specified in section 3.7.2 of this specification.
- 1.3.8** All manufacturing deviations and non-conformance to the **BUYER** specifications must be documented to the **BUYER**, and a request for waiver or deviation submitted with specific details, and approved by the **BUYER prior to delivery** of the container. **All SELLER Container Deviation Requests and Non-Conformance Reports shall be provided to the BUYER.**
- 1.3.9** Container specific documentation shall be provided **upon delivery** of each container. The specified container documentation shall be identified to the unique container fabrication serial number, be complete, and authenticated by a cognizant representative of the SELLER'S quality control section. One (1) copy of each set of documentation specifically identifying the inspected container(s) shall be submitted with each shipment received by the BUYER. **Container specific documentation shall include the following, at a minimum:**
- 1.3.9.1** SELLER'S inspection records for the following:
- Dimensions inspected meet specifications/drawing requirements.
 - Paint minimum dry film thickness (DFT) verification results for the container's primer and finish coat (2.5-mil minimum on all interior and exterior surfaces).
 - Inspection results for the condition of the following container components: container closure mechanism, lid lift attachment on the container lid.
- 1.3.9.2** Certificate of Compliance (CoC) to this Specification shall be provided by the SELLER on SELLER letterhead paper and signed by employee of the SELLER stating that:
- The SELLER has manufactured the ST-90 containers in accordance with the BUYER specification.

- The SELLER certifies that the equipment utilized to determine the tare weight is part of a routine calibration system and that the scale used has been calibrated to be accurate within plus (+) or minus (-) two (2) pounds.
- The SELLER determination of the standard deviation for those containers randomly sampled for the tare weight average.
- The SELLER certifies that the container as designed and manufactured meets the structural requirements of Section 2.2 and passes the Drop Test, Stack Test and Vibration Tests required in Section 3.2.6.

2.0 PRODUCTS

2.1 Construction Materials:

- 2.1.1** *Body:* 12-gauge (minimum) low carbon hot rolled sheet steel meeting ASTM-A569 specifications, or equivalent; i.e., ASTM A-36.
- 2.1.2** *Lid:* 12-gauge (minimum) low carbon hot rolled sheet steel meeting ASTM-A569 specifications, or equivalent; i.e., ASTM A-36.
- 2.1.3** *Lid Gasket:* Closed cell neoprene foam gasket material, 3/8 inch x 1 inch, ASTM D-1056-67, SAE-J-18-SCE42 medium durometer with self-adhesive backing on one side; or company approved equal gasket material.
- 2.1.4** *External/Internal Support:* Any required external and internal support to be fabricated from channel or angle steel meeting requirements of ASTM-A-36.

2.2 Structural Requirements:

- 2.2.1** *Payload Capacity:* 10,000-lb net weight (4,545.5 kg).
- 2.2.2** *Stack Height:* Containers, loaded to design load capacity and closed for shipment, must have the capability of being stacked a maximum of three (3) high. Containers shall be capable of supporting a uniformly distributed load of 3,375 pounds/square-foot per 49 CFR 178.815.
- 2.2.3** *One (1) Foot Drop Test:* Containers, loaded to design load capacity and closed for shipment, must have the capability of being dropped on a flat surface from a height of one (1) foot, three consecutive times without loss of contents. A slight discharge from a closure upon impact is not considered to be a failure of the container provided no further leakage occurs. Point of impact, as much as possible, shall be the entire bottom of the container. This test is to simulate rough handling by a forklift. All remaining parameters for this test shall be per 49 CFR 178.810.
- 2.2.4** *Vibration Test:* Containers, loaded to design load capacity and closed for shipment must have the capability to withstand a one (1) hour vibration test per 49 CFR 178.819.

2.3 Container Dimensional Design:

2.3.1 Container Dimensions (Nominal):

	Container (itself)*	Lid
Length	72.0 inches OL	72.25 inches IL
Width	46.0 inches OW	46.25 inches IW
Height	47.0 inches OH	Tolerance variations must allow sufficient clearance between lid and sidewalls so that the painted surfaces do not bind on removal or placement of lids on the containers.
*(Excludes external channel/angle bracing/closure attachments, etc.)		

Allowable container fabrication design tolerances shall be within +/- 1/4 inch of the dimensions shown on the container drawings, as approved by the BUYER, or as specifically specified elsewhere in the specification.

Container shall be constructed in such a manner as to maintain the outside container dimensions within +/- 3/4 inch when loaded to the design load capacity of 10,000 lb net.

2.3.2 Skid Runners: Each container shall be fabricated with four (4) each skid runners welded to the container bottom plate to provide sufficient clearance under the container to allow enough room to accommodate the standard sized forks of a forklift without requiring additional blocking beneath the container. The skid runners shall extend the full width of the container and fully support the sides of the container.

Skid Runners shall be channel steel, and not "I" beams. The two (2) center skid runners shall be spaced such that the forklift blades of a standard 10,000 - 12,000 lb capacity forklift can be adjusted to fit inside and be enclosed by these two (2) runners.

2.4 Container Closure and Sealing Requirements:

2.4.1 Lid Construction: The container lid shall incorporate a bolted lid closure method; with angle channels mounted on the sides of the lid, and the top edge of the container. Bolts, 3/8 inch (minimum) x 1-1/2 inch, shall close the container by bolting down on the sides of the container/angle channel with sufficient clearance between lid angle channel and container angle channel to compress the gasket without the bolt channels coming into contact with each other.

2.4.1.1 Lid shall be bolted with twelve (12) bolts, three (3) each per container side, with two (2) flat and one (1) lock washer.

2.4.1.2 Bolt holes shall be three (3) inches, nominal, from the corners of the containers, as measured equally from the center bolt holes in the container, to assure bolt hole alignment. Bolt hole pattern shall be symmetrical along both the short and long center axis of the container.

2.4.1.3 Container bolt holes shall be oblong holes in the box angle a minimum of 5/8 inch diameter, a minimum of 3/4 inch long with the long axis parallel to the long sidewall of the box. Lid bolt holes shall be oblong holes in the lid angle a minimum of 5/8 inch diameter, a minimum of 3/4 inch long with the long axis perpendicular to the long sidewall of the lid.

- 2.4.1.4** Stainless steel (SS) bolts and nuts shall be utilized or plated bolts/nuts having stronger torque resistance than the same size SS bolts/nuts.
- 2.4.1.5** For delivery, lids shall be bolted with two (2) bolts; one (1) at center of each short side; balance of the required bolts, nuts, and washers shall be shipped in a bag inside each container.
- 2.4.2** *Lid Forklift Brackets:* Brackets (two 2-3/4 inch high x 7 inch wide x 2 inch long 12 gauge sheet metal straps) shall be incorporated into the lid design to provide a means by which the lid can be safely manipulated during container opening and closure with a standard size forklift. The requirement for the lid-lifting bracket to comply with 49 CFR 173.410(b) is waived¹.
- 2.4.2.1** Forklift bracket shall be designed only for the purpose of lifting the lid. Lid shall be stenciled with the words "Brackets to be used for lifting lid only."
- 2.4.2.2** Forklift bracket shall be permanently affixed to the container lid by welding.
- 2.4.2.3** Forklift bracket is not designed to lift an empty, filled, or partially filled container.
- 2.4.2.4** Forklift brackets are to consist of two metal straps welded to the lid, two-inches wide each, along the centerline of the lid, parallel to short side of container. Forklift brackets are for insertion of a single forklift blade for lid lifting purposes only. Brackets shall be of 12-gauge metal, capable of being flattened by hammer before transport.
- 2.4.3** *Lid Handles:* Shall be incorporated into the lid design to provide a means by which the lid can be easily manipulated during container opening and closure. Lid handle design shall comply with 49 CFR 173.410 and incorporate the following –
- 2.4.3.1** Lid handles shall be designed only for the purpose of lifting the lid weight.
- 2.4.3.2** Lid handles shall be designed to be removable but shall not be designed in such a manner that the handle detaches from the lid during normal use.
- 2.4.3.3** Four handles shall be provided on each lid, two on each side of the lid's short dimension.
- 2.4.3.4** Lid handles shall be ergonomically positioned to avoid undue worker strain during routine lid handling operations.
- 2.4.3.5** Lid handles shall have a minimum clearance of 3 inches between the lid and the bottom of the handle to allow sufficient grasping room for a worker's hand.
- 2.4.3.6** Suggested handle design would consist of an approximately 3/8 inch bent rod designed to drop straight down through the lid and body angle steel along the container side so as not to interfere with container stacking. (See Attachment #2B)

¹ A DOE exception has been granted by the DOT. However, the balance of 49 CFR 173.410 does apply -- ref. Section 1.1

2.4.4 *Lid security and tamper indicating closure devices:* Two (2) 1/2 inch diameter holes shall be provided on the opposite corners of the short ends of the box and lid angle steel to install a padlock and a tamper-indication device (TID) to monitor and control access to the waste container. Suggested hole locations are noted on Attachment #2A.

2.4.5 *Gasket materials* shall be glued secure to the lid, such that it provides a continuous sealing surface around the entire circumference of the lid/container contact surface, including the corner joints.

An option, **ONLY**, if specifically stated in the agreement, the previously specified gasket material shall be provided separately with each container and have an adhesive backing to provide for ease of application by the BUYER's container end user. Each container's gasket material shall be placed inside the container, in a roll, when shipped to the BUYER's facility.

2.5 Container Finish Requirements:

2.5.1 All container edges and/or surfaces shall be fabricated to minimize sharp edges and protrusions; any edges that do exist on the container shall be ground to minimize personal hazards.

2.5.2 All container interior and exterior surfaces shall be prepared and cleaned of all solvent residue, oil, and other materials prior to painting to ensure adequate paint bonding, uniformity, and proper mil thickness without paint running.

2.5.3 All container interior and exterior surfaces, including skid runners, shall be painted with two coats of the base finish paint coating, which shall be a rust proof, lead-free, epoxy paint. Total paint thickness, for both initial and final paint finish coatings, shall be a minimum of 2.5 to 3 mil dry film thickness (DFT) on all surfaces.

2.5.4 Paint color to be blue, Polyamide Epoxy, PPG 97-11 or equivalent, unless stated otherwise in the contract.

2.5.5 Finished, painted surfaces upon visual inspection shall appear smooth and free of any visible pits or imperfections.

2.5.6 Painted surfaces shall be allowed time to completely dry prior to placement of the lid onto the box to prevent the lid and gasket from adhering to the box at the time of initial container usage at the Company's facility.

2.6 Container Identification:

2.6.1 *Location:* SELLER fabrication data shall be legibly marked, at a minimum, on one of the container long dimensions (front or back) and on one of the container short dimensions (either side), with a stainless steel plate (in the 6 x 4 inch range), mounted in the upper left hand corner.

2.6.2 *Identification Marking Specifications:* SELLER fabrication data shall be permanently affixed to the container in the specified locations in accordance with the following:

2.6.2.1 Identification marking on the plate shall be stamped permanently into the plate surface, and shall be sharp, durable, and capable of being easily read (preferable with black background letters). The lettering height for the identification marking shall be in the range of 3/8 to 5/8 of an inch.

2.6.2.2 The container identification plate shall be welded to the container by a method that shall not have any detrimental effects on the container integrity.

2.6.3 *Container Data Markings:* The fabrication data to be included on each container as specified above should include, at a minimum, the following information:

- SELLER Fabrication Facility Name
- BUYER Purchase Order Number
- Year of Manufacture
- Container Lot Number - marking separately on the container is allowable, in plate proximity
- Container Serial Number
- Container Tare (empty) Weight (lb)
- Container Maximum Net Weight (lb) [10,000 lb]

2.7 Tare Weight Determination:

2.7.1 Scales for determining Tare Weights shall be certified, and capable of weighing within plus (+) or minus (-) two (2) pounds.

2.7.2 The tare weight shall be determined for a lot of containers by randomly selecting five (5) percent of the lot, with a minimum of five (5) containers, weighing the containers, then averaging the weight for the lot.

A lot shall be defined as a batch/quantity of containers made all in the same production run, with the same batch of material, and identified on the container by the lot number (with the serial number) for each order of containers purchased by BUYER.

2.7.3 The container tare weight shall be marked to the nearest one (1) pound.

3.0 EXECUTION

3.1 Container Design and Fabrication:

3.1.1 Container design concept shall be per Attachment No. 2A, 2B and 2C, to this specification. Any container design modifications/revisions must be submitted in writing, and approved in writing by the BUYER prior to the manufacture of any containers.

3.1.2 Container fabrication shall be such that no weld seams shall be used to piece together smaller pieces of material to fabricate the main box structural panels. Additionally, no through weld seams shall be allowed across any of the main box structural panels on the four (4) container sides, lid, or bottom other than those welds required at the container corners to join interfacing panels.

3.2 Quality:

3.2.1 The BUYER shall have the right of access to witness the manufacturing process involved in the fabrication of the requested containers.

3.2.2 The BUYER shall be notified within a minimum of 10 working days in advance of the initial container fabrication, in accordance with this specification, to allow for the opportunity at the BUYER's discretion to witness container fabrication at a mutually agreeable date and time.

3.2.3 All welding procedures and welder certifications shall be in accordance with requirements of AWS D1.1, "AWS Structural Welding Code," AWS D1.3, "AWS Sheet Metal Welding Code, as applicable.

3.2.4 Weld container inspection shall consist of the following:

- A visual inspection of one hundred percent (100%) of each container's welds (both container and lid) shall be performed in accordance with AWS D1.1, Section 6 or AWS D1.3, Section 7, and documented accordingly. Acceptance criteria are per AWS D1.1, Section 8.15.1 or AWS D1.3, Section 4.5.
- Examination Personnel Certification Requirements--personnel performing visual examination of welds shall be currently certified either as an AWS CWI or in accordance with the requirements of SNT-TC-1A, or work under direct supervision of an SNT-TC-1A Level II, III, or CWI. If certified to SNT-TC-1A, satisfy the training and experience requirements by time spent in weld examination related work. (Reference: AWS QC-1, Specification for Qualification and Certification of Welding Inspectors, 1988 edition.)

3.2.5 The SELLER shall have established or initiate a mechanism by which each manufactured container is assigned a container fabrication serial number that shall allow for the tracking of container fabrication through the entire manufacturing process.

3.2.6 A prototype container shall be fabricated and tested to certify that the container passes the Drop Test per 49 CFR 178.810, the Stack Test per 49 CFR 178.815, and the Vibration Test per 49 CFR 178.819. The container shall be filled with sand or soil up to 95 percent of its volume capacity for all three (3) tests.

- The Drop Test method of 49 CFR 178.810 shall be modified to drop the container a distance of one (1) foot with the point of impact being the flat bottom of the container. The drop test shall be performed a minimum of three (3) times on the same container.
- The Stack Test method shall be performed with a uniformly distributed load of 3,375 pounds per square foot (minimum of 77,625 pounds) uniformly distributed over the 72-inch x 46-inch container lid.

- The Vibration Test method shall be performed without modification per 49 CFR 178.819.

3.2.7 The BUYER may perform shop inspections at the SELLER fabrication facility for approved drawings, procedures, welder certifications, materials, workmanship, suspect/counterfeit parts, and documentation prior to container shipment. The SELLER will be notified in advance of the shop inspection and the inspection times will be established and mutually agreeable between the SELLER and the BUYER representatives.

3.2.8 The SELLER shall notify the BUYER upon fabrication completion of the first lot of containers prior to painting. The BUYER's inspector shall be afforded the opportunity to perform first article weld fabrication container source inspection prior to container painting. Any identified deficiencies shall be corrected prior to painting. The BUYER's inspector will be notified of container deficiency correction and be allowed the opportunity to re-inspect the containers prior to container painting.

3.3 Packaging And Handling:

3.3.1 *Container Storage at the Seller's Facility:* Container storage shall be in such a manner as to ensure the inside of the containers shall remain dry and no accumulated moisture shall be present in the containers prior to shipment to the BUYER.

3.3.2 *Container Packaging for Shipment:* Each container shall be packaged in a manner to ensure safe delivery and comply with all carrier's regulations.

- Containers loaded for shipment to the BUYER shall be tied down in such a manner so as to avoid any damage and/or distortion to the container during transportation that would cause design tolerances to be exceeded.
- Containers shall be packaged for shipment to the BUYER in such a manner as to ensure the inside of the containers remains dry during transport.

3.4 Receipt Inspection:

3.4.1 *Final acceptance:* Final Acceptance of each shipment received at the BUYER's site will be based upon completion of an acceptable Receiving Inspection and upon the BUYER's verification that the following documentation requirements have been met:

- Container Documentation (For Each Container) as prescribed in Section 1.3.9 of this specification.
- Container Data Markings as prescribed in Section 2.6.3 of this specification.

3.4.2 *Receiving Inspection:* The receiving inspection will be performed using Attachment 1 of this specification, the ***Receiver Inspection Quality Control (QC) Checklist for Incoming Containers***. Verification that no shipping damage has been incurred during transport to the BUYER is included. Minor paint scratches will not be reason for rejection.

Attachment # 1
RECEIVER INSPECTIONS:

{tc "RECEIVER INSPECTIONS:"\l}BUYER will perform the following inspections on incoming containers to determine whether the containers meet quality standards and the requirements of this specification. BUYER is not limited to the below inspections to determine quality and specification conformance. Conformance will be indicated by a Y or N in the yes/no column, and negative responses documented and attached to the checklist.

This Checklist is to be reproduced for QC Inspections.

Receiver Inspection Quality Control (QC) Check-list for Incoming Containers:			
	<i>QC Conformance</i>	<i>Y/N</i>	<i><< "No's" are to be documented, and attached to this checklist.</i>
1	Dimensions		Containers meet nominal dimensions stated in ¶ 2.3.1 of specification.
2	Container Lids		Lids fit containers without binding sidewalls, easily removable.
3	Lid Closures		Closure boltholes are aligned; bolts (12) supplied, with nuts & washers. TID and Padlock holes are provided and aligned also.
			Closure bolts are SS or plated, 3/8-inch minimum, 1-1/2 inch (¶ 2.4.1.4).
4	Exterior/Interior		All surfaces painted blue, inside skid runners, per ¶ 2.5.4 of specification
			No significant scratches, corrosion, dents, bare metal areas, etc.
5	Lid Bracket		Forklift bracket permanently installed on the lid per ¶ 2.4.2.2 of specification.
6	Lid Handles		Four lid handles, provided; handles removable per ¶ 2.4.3 of specification.
7	Lid Gasket		Gasket in good condition; no tears, etc.; and securely glued in and around lid - no gaps.
8	Exterior Bracing		All welds "in-tack" (no breaks) and showing no corrosion in seams, etc.
9	Name Plates		Two each SS ID name plates on each container; located and marked per ¶ 2.6.3 of the specification; securely welded to the container sides.
10	Skid Runners		Four each forklift steel skid runners permanently mounted on bottom & extend the full width of container, per ¶ 2.3.2 of specification.
11	COC		Certificate of Compliance provided in accordance with ¶ 1.3.9.2
Drawing. / Id Number _____		P. O. Number _____	
Total Units Received _____		Inspection Method: Visual	
Sample Size: [Based on ANSI/ASQC Z1.4-1993]		MFG. Certification/Test Report Received: _____	
Inspector: _____		If additional comments are provided on back, check yes _____.	
Date: _____			

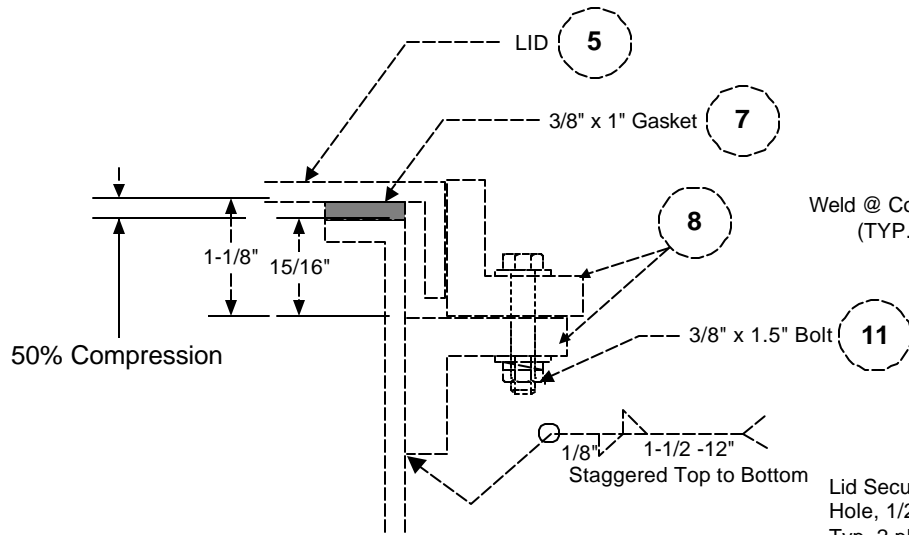
This QC inspection check list shall be accomplished for each order, based on random samples of the received containers, by QC personnel to determine manufacturer's conformance to the specified packaging specifications.

NOTES

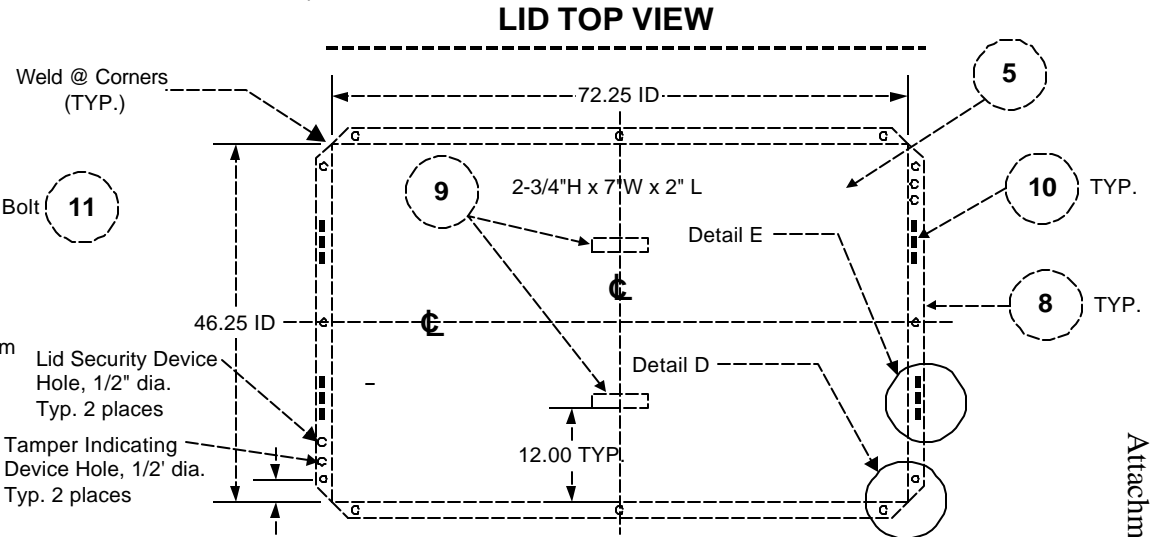
All welding symbols denote minimum requirements.

Denotes item listed on Equipment List, Attachment #2C

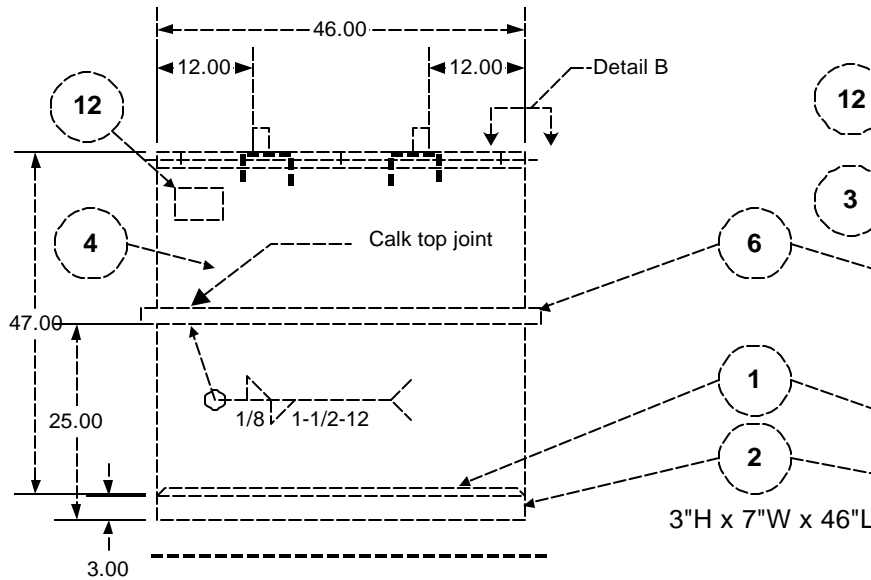
Subcontractor is responsible for verifying Subcontractor's design will meet all requirements of this specification.



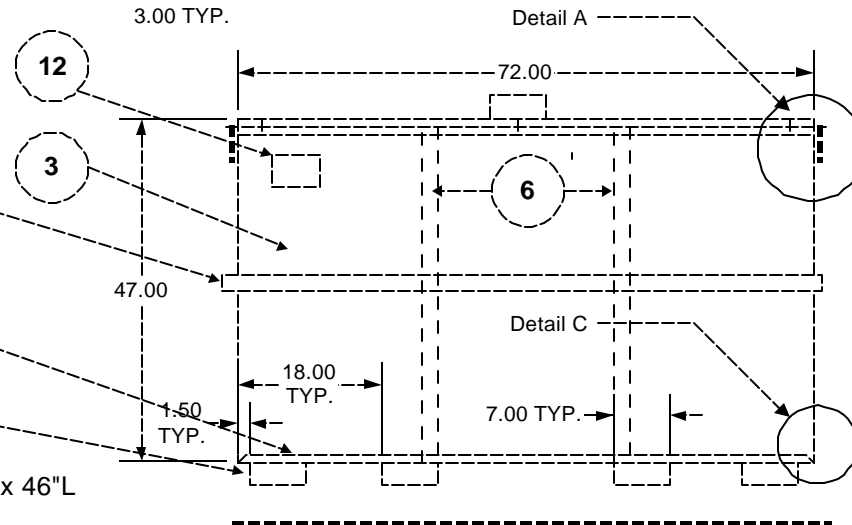
DETAIL "A"
Not to Scale



LID TOP VIEW



SIDE VIEW



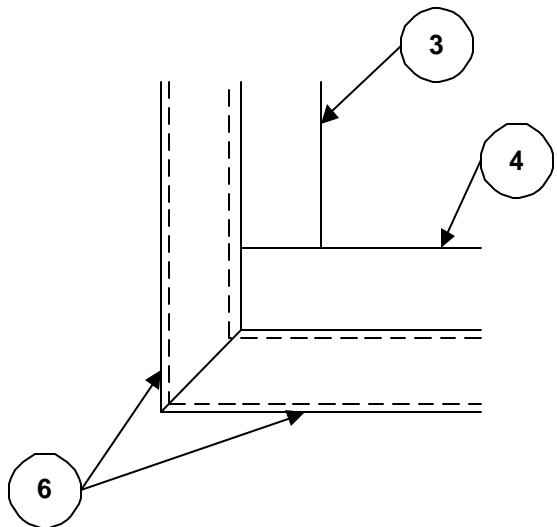
FRONT VIEW

STRONG-TIGHT CONTAINER (STC) - 90 CU. FT. NTS

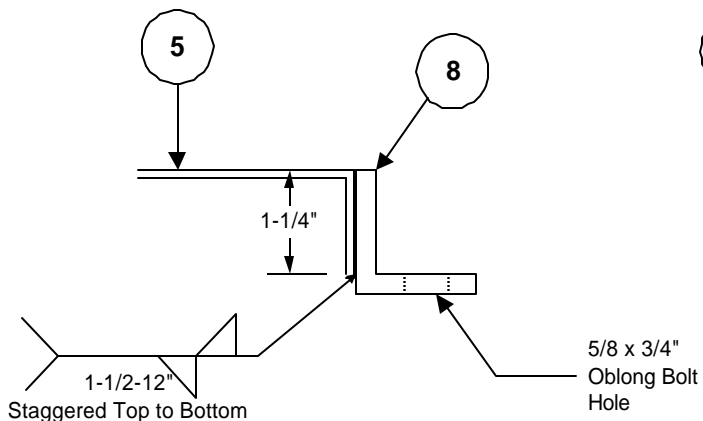
Specification No. SPM-000000-A001
Not to Scale, All Dimensions in Inches

Attachment # 2 A

Technical Specification
SPM-000000-A001
Revision 2
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DETAIL "B" JOINT DETAILS

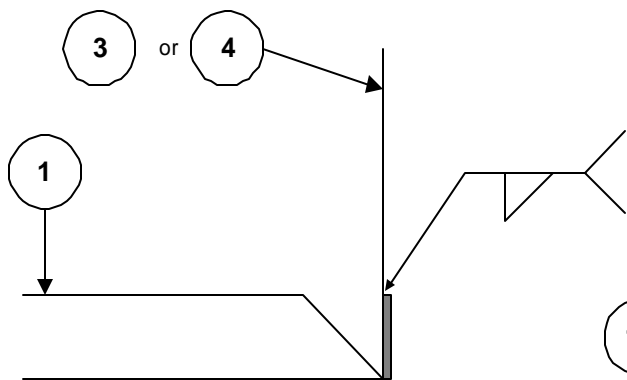


DETAIL "D" LID to ANGLE ATTACHMENT

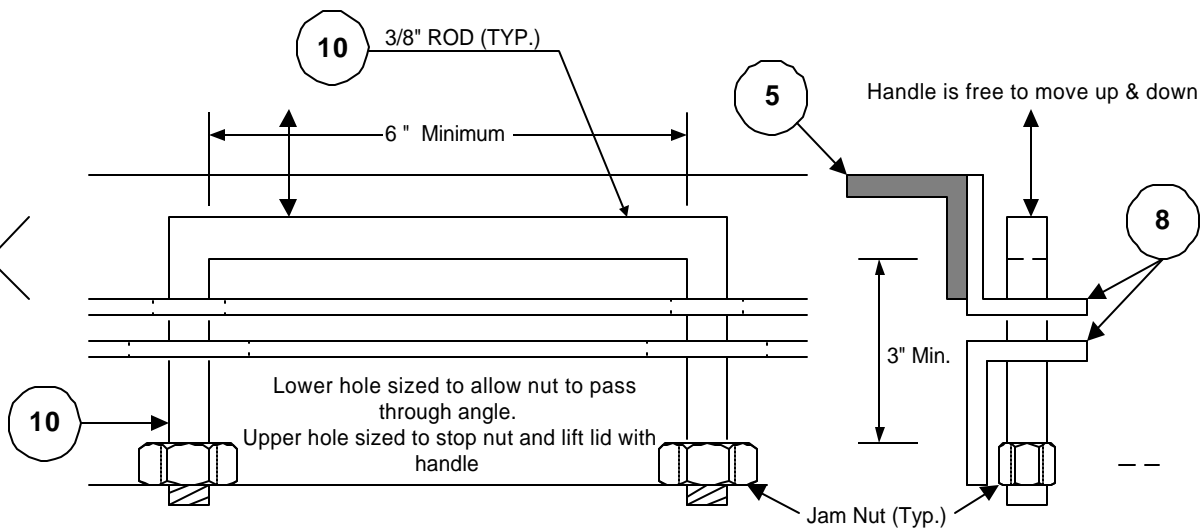
Denotes item listed on Equipment List, Attachment #2C

All welding symbols denote minimum requirements.

Subcontractor is responsible for verifying Subcontractor's design will meet all requirements of this specification.



DETAIL "C" BOTTOM WELD



DETAIL "E" LID HANDLE

Attachment # 2 B

STRONG-TIGHT CONTAINER (STC) - 90 CU. FT. NTS
Specification No. SPM-000000-A001
Not to Scale, All Dimensions in Inches

Attachment #2 C
EQUIPMENT LIST

No.	Qty.	Description	Material	
1	1	Bottom Assembly	ASTM-A569 Steel	
2	4	Bottom Channel, 3"H x 7"W x 46"L	ASTM-A569 Steel	
3	2	Side Plate	ASTM-A569 Steel	
4	2	End Plate	ASTM-A569 Steel	
5	1	Top Assembly	ASTM-A569 Steel	
6	-	Rectangular Tubing, 1" x 2"	ASTM-A-36 Steel	
7	-	Gasket. 3/8" x 1"	ASTM D-1056-67 SAE-J-18-SCE42	
8	-	Angle, 1-1/4' x 1-1/4" x 3/16" or Angle, 1-1/2' x 1-1/2" x 3/16"	ASTM-A-36 Steel	
9	2	Forklift Lid Bracket, 3"H x 7"W x 2"L	ASTM-A569 Steel	
10	4	Lid Handle Assembly	3/8" Bent Rod threaded each end, with two (2) jam nuts per Detail E, Attachment #2B.	
11	12	Bolt, 3/8" x 1-1/2"L, with two (2) matching flat washers, one (1) lock washer and nut	Stainless Steel or Plated Steel	
12	2	Container Identification Plate per ¶ 2.6.3	Stainless Steel Plate 6" x 4"	
13	-	Paint, blue	Polyamide Epoxy, PPG 97-11 or equivalent	