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1		QA ML McElroy	See ATP Coversheet	S1-57							
1		Safety LS Krogsrud	See ATP Coversheet	R3-08							
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1		Other TC Mackey	See ATP Coversheet	S2-03							
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Ton Hydraulic Trailer

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**This document was reviewed following the
procedures described in WHC-CM-3-4 and is:**

APPROVED FOR PUBLIC RELEASE

WHC Information Release Administration Specialist:

V. L. Birkland

11/16/94

V. L. Birkland

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SUPPORTING DOCUMENT

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2. Title

Factory Acceptance Test Procedure Westinghouse 100
Ton Hydraulic Trailer

3. Number

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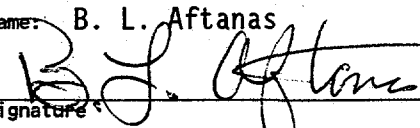
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6. Author

Name: B. L. Aftanas


Signature

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7. Abstract

This Factory Acceptance Test Procedure (FAT) is for the Westinghouse 100 Ton Hydraulic Trailer. The trailer will be used for the removal of the 101-SY pump.

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8. RELEASE STAMP

OFFICIAL RELEASE	21
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<i>Sta. 21</i>	

FACTORY ACCEPTANCE TEST PROCEDURE

WESTINGHOUSE 100 TON HYDRAULIC TRAILER

Submitted by

KAMP Systems
P.O. Box 3243
Ontario, CA 91761

Nov 8, 1994

APPROVALS:

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MASTER

ja

PREFACE

The objective of this acceptance test procedure is to verify that the Westinghouse Hydraulic Trailer meets the WHC-S-0280 Rev. 1, specification(s).

The test director may modify this test procedure during testing as he deems necessary, although all modifications must be approved by Westinghouse representatives.

WARNING:

All signature lines and/or Q.C. approvals must be signed or stamped in sequence as this document is written. Any out of sequence steps could cause damage to equipment, or possible harm to personnel.

If any safety concerns arise during testing, testing may be halted. If testing is halted at any point in testing, return the trailer to a safe and stable condition. When testing is to commence again, perform the necessary steps to prepare the trailer for testing. A safe and stable condition is defined as: Container and strongback lowered to the horizontal position, the hydraulics and systems OFF, and electrical power OFF. The outriggers may be left deployed or retracted as determined by the test director.

SECTION 1.0

REVISION RECORD AND DISCREPANCY SHEET

1.1

SECTION 2.0**REFERENCE DOCUMENTS**
AND
SUPPORT EQUIPMENT**2.1 DRAWINGS/DOCUMENTS**

KAMP Systems dwgs. KSI 5000694 all sheets

REMC0 dwgs. (as provided)

WHC-SD-WM-DA-170, Bolting Sequence for Attaching the Container to the Strong-Back for 241SY101

WHC dwg. H-2-83743

2.2 SUPPORT EQUIPMENT

- 2.2.1 VOM MODEL: _____
- 2.2.2 (1) 10-12" SCALE MODEL: _____
- 2.2.3 STOP WATCH MODEL: _____
- 2.2.4 ELECTRICAL VOLT METER MODEL: _____
- 2.2.5 LASER/THEODOLYTE MODEL: _____
- 2.2.6 (2) BI-FILAR TARGETS MODEL: _____
- 2.2.7 OPTICAL LEVEL MODEL: _____
- 2.2.8 STAND FOR OPTICAL LEVEL
- 2.2.9 AUXILIARY WEIGHT 19,140#(WHC PROVIDED)
- 2.2.10 100 FT. TAPE MEASURE
- 2.2.11 STEP LADDER

2.3 DEFINITIONS

Trailer primary pump is referred to as Pump #1.
Trailer mounted back-up pump is referred to as Pump #2.

SECTION 3.0**SAFETY CHECK AND SAFETY PROCEDURES**

- 3.1 Inspect trailer, strongback and container tube for loose fasteners, missing parts, loose hand tools, etc., and remove all foreign objects that could fall or obstruct test movements.
- 3.2 Clear personnel from immediate test area.
- 3.3 This test shall be performed in compliance with all vendor, state, and federal safety requirements and required personal protective equipment will be worn by all personnel participating in this test and within the perimeter of the test operation, as directed by safety monitor.
- 3.4 Prior to testing, verify that new 2 1/2" \varnothing A325 bolts and 1" \varnothing A325 bolts for the container/strong-back attachment are installed in accordance with WHC-SD-WM-DA-170 bolting procedure.
- 3.5 Verification that safety criteria above has been met.

TEST DIRECTOR:

Signature_____
Date

SAFETY MONITOR:

Signature_____
Date

SECTION 4.0**PRE-OPERATION CHECK OUT**

- 4.1 Record the AC voltage available at the main circuit breaker inside the NEMA 4X box mounted by the main control panel. Verify manual 480V AC 3 Phase Switch is in the OFF position. Verify all primary circuit breakers are in the OFF positions.
Voltage: _____
Q.C.: _____
- 4.2 Verify fluid level in Res. Q.C.: _____
- 4.3 Verify Spirit Levels are attached to trailer.
Q.C.: _____
- 4.4 Verify safety verification step 3.5 has been signed OFF by both test director and safety monitor.
Q.C.: _____
- 4.5 Verify that all pivot points on the cylinder are adequately lubricated.
Q.C.: _____

SECTION 5.0**START UP**

- 5.1 Verify all primary and secondary disconnects are in OFF position.
Q.C.: _____
- 5.2 Connect 480V AC Power Cable to receptacle located adjacent to the manual ON/OFF power switch enclosure.
Q.C.: _____
- 5.3 Uncoil remote control pendant - verify 100 ft. length and connect to the fixed mounted electrical control console receptacle.
Q.C.: _____
- 5.4 Place primary electrical circuit breakers in the "ON" position. Verify proper voltages at the control panel electrical bus within the NEMA 4X enclosure.
Q.C.: _____
- 5.5 Bump Hydraulic Pump #2, by pressing the Pump #2 Motor Start Button located on the main control panel and immediately pressing the red Motor Stop button. Verify that pump #2 rotates in the proper direction.
Q.C.: _____
- 5.6 Energize Hydraulic Pump #2, by pressing the Pump #2 Motor Start Button located on the main control panel. Verify Pump #2 Panel Indicator light is "ON".
Q.C.: _____
- 5.7 Inspect Pump #2 Hydraulic Circuit for leakage and verify no observable leakage. Note: any leakage in section 1.0.
Q.C.: _____
- 5.8 Depress Pump #2 Motor Stop Button and verify Pump #2 Panel Indicator Light is OFF and motor has stopped running.
Q.C.: _____
- 5.9 Bump Hydraulic Pump #1, by pressing the Pump #1 Motor Start Button located on the remote control pendant and immediately pressing the red Motor Stop button. Verify that pump #1 rotates in the proper direction.
Q.C.: _____
- 5.10 Using the Remote Control Pendant, press Pump #1 Motor Start Button. Verify Pump Indicator Light is "ON" at the pendant control.
Q.C.: _____
- Verify Pump #1 is running. Q.C.: _____

- 5.11 Depress Pump #1 Motor Control Stop Button on the Remote Control Pendant. Verify Pump Indicator Light is OFF at the pendant control.

Q.C.: _____

Verify pump #1 has stopped running. Q.C.: _____

- 5.12 Using the Remote Control Pendant, press Pump #2 Motor Start Button. Verify Pump Indicator Light is "ON" at the pendant control.

Q.C.: _____

Verify Pump #2 is running. Q.C.: _____

- 5.13 Depress Pump #2 Motor Control Stop Button on the Remote Control Pendant. Verify Pump Indicator Light is OFF at the pendant.

Q.C.: _____

Verify Pump #2 has stopped running. Q.C.: _____

SECTION 6.0

LEVELING TRAILER

- 6.1 Prior to deployment of outriggers, clear personnel, debris and articles from areas of outrigger path.
Q.C.: _____
- 6.2 Energize Hydraulic Pump #2 at the main control panel and verify Panel Indicator Light is "ON" and Pump #2 is running.
Q.C.: _____
- 6.3 Actuate the Outrigger Deploy valve at the main control panel to deploy the outriggers. Verify outriggers move smoothly to their fully extended positions.
Q.C.: _____
- 6.4 Record system pressure by actuating the Outrigger Deploy valve at the main control panel and reading the pressure gage inboard and to the rear of the main control panel.
PRESSURE: _____ Q.C.: _____

Verify the system pressure is set at or below 2700 psi.
Q.C.: _____
- 6.5 Actuate the Outrigger Deploy valve at the main control panel to retract the outriggers. Verify outriggers move smoothly to their fully retracted positions.
Q.C.: _____
- 6.6 Deploy the outriggers once again and leave all outriggers in their extended positions ready for the leveling cylinder testing.
Q.C.: _____
- 6.7 Outrigger Valves #1 through #4. **"Use CAUTION in this operation as un-wanted and un-necessary loading of trailer could occur"**. Once Sand Shoe has engaged to the ground, only lift the trailer an inch or two before retracting to full up position. Verify valve movement corresponds to outrigger leveling cylinder movement.

#1	EXTEND	- Outrigger	Q.C.:	_____
	RETRACT	"	Q.C.:	_____
#2	EXTEND	"	Q.C.:	_____
	RETRACT	"	Q.C.:	_____
#3	EXTEND	"	Q.C.:	_____
	RETRACT	"	Q.C.:	_____
#4	EXTEND	"	Q.C.:	_____
	RETRACT	"	Q.C.:	_____
- 6.8 Position (1) scale on the trailer sequentially at designated locations. Position surveying device to shoot all positions.
Q.C.: _____

- 6.9 Extend the outrigger cylinders as directed by the trailer manufacturer. Position trailer into a level plane with tires OFF the ground by use of outrigger cylinders and fixed spirit levels. Verify that the designated points are within 0.5 inch elevation with the transit.

<u>Cyl.</u>	<u>Height From Ref.</u>
#1	_____
#2	_____
#3	_____
#4	_____

Trailer level within 0.5 inches Q.C.: _____
 Q.C.: _____

- 6.10 Record spirit level tolerance required to maintain 0.5 inch level of trailer deck.

Spirit Level Tolerance: _____

- 6.11 Verify spirit levels are set and spirit level tolerance is correct.

Q.C.: _____

- 6.12 Extend landing gear until the sand shoes make contact with the ground by actuating landing gear valves 1 and 2. Check spirit levels to verify the trailer is level when landing gear are extended.

Q.C.: _____

- 6.13 Stop pump #2.

Q.C.: _____

SECTION 7.0

FUNCTIONAL/PROOFLOAD TEST

- 7.1 The Functional/Proofload test of the Main Hydraulic Cylinder will be performed in the loaded condition with container mounted onto the strongback, as called out in section 3.5, and test weight attached in accordance with drawing #H-2-83743
- 7.2 In preparation for this test, verify the following:
- 7.2.1 Start pump #1 using remote control pendant. Verify pump #1 is running.
Q.C.: _____
- 7.2.3 The outriggers are all in their extended positions.
Q.C.: _____
- 7.2.4 The Leveling Cylinder Sand Shoes are in contact with the ground and trailer is level as called out in section 6.
Q.C.: _____
- 7.2.5 Personnel are cleared from immediate area.
Q.C.: _____
- 7.2.6 All tools and/or loose objects have been removed from strongback and container.
Q.C.: _____
- 7.2.7 Verify container and test weight are attached properly and all hardware is secure.
Q.C.: _____
- 7.2.8 Record both the ambient temperature and the temperature of the hydraulic fluid.
Ambient temp: _____
Fluid temp: _____
Q.C.: _____
- 7.3 Functional testing of the Main Hydraulic Cylinder may now commence using the remote control pendant.
- Actuate extend cylinder, and raise the strongback approximately (12) inches from its support and stop by depressing the limit switch. Verify the operation of the limit switch. Release the extend cylinder and hold the strongback in this position for a period of (5) minutes. Verify no observable cylinder drift. Return to the horizontal position and verify smooth return and proper positioning/alignment at support points.
Q.C.: _____
Q.C.: _____
- TIME: _____

- 7.4 Actuate extend cylinder, and raise the strongback to the 90 degree position (vertical) and record the total elapsed time.

TIME: _____ Q.C.: _____

After at least 5 minutes, verify stability of system.

TIME: _____ Q.C.: _____

Also verify the following:

- 7.4.1 Smooth operation and proper sequence of the Main Hydraulic Cylinder without any sticking, bumping, jumping, or unplanned starts or stops, through entire travel.

Q.C.: _____

- 7.4.2 Counterbalance valves operate properly such that there is a smooth transition when strongback and container center of gravity passes through vertical.

Q.C.: _____

- 7.4.3 Verify that the main telescoping cylinder shuts OFF automatically when the container reaches the 90° position.

Q.C.: _____

- 7.5 Record fluid temperature. Actuate Retract Cylinder, allowing strongback to lower and container to nest into cradle supports. Record total elapsed time. Verify container interface to cradle support seats properly.

TEMP: _____ Q.C.: _____

TIME: _____ Q.C.: _____

- 7.5.1 Verify smooth operation of the Main Hydraulic Cylinder without any sticking, bumping, jumping, or unplanned starts or stops, through entire travel.

Q.C.: _____

- 7.6 Attach (2) Bi-Filar targets to the strongback positioned to allow vertical measurements of the strongback. Verify targets are attached.

Q.C.: _____

- 7.7 Once again record the fluid temperature and raise the strongback and container to the full vertical position. Record elapsed times.

TEMP: _____ Q.C.: _____

TIME: _____ Q.C.: _____

- 7.8 By use of Laser and targets, measure plumbness of the strongback.

Record port side target positions.

FORWARD/AFT DIM: _____ Q.C.: _____
 INBOARD/OUTBOARD DIM: _____ Q.C.: _____

Record starboard side target positions.

FORWARD/AFT DIM: _____ Q.C.: _____
 INBOARD/OUTBOARD DIM: _____ Q.C.: _____

Verify that a minimum vertical position of 90 degrees vertical is achievable. Q.C.: _____

HOLD STRONGBACK IN THIS VERTICAL POSITION FOR A MINIMUM OF FIFTEEN MINUTES.

- 7.9 Re-measure strongback for target positions.

Record port side target positions.

FORWARD/AFT DIM: _____ Q.C.: _____
 INBOARD/OUTBOARD DIM: _____ Q.C.: _____

Record starboard side target positions.

FORWARD/AFT DIM: _____ Q.C.: _____
 INBOARD/OUTBOARD DIM: _____ Q.C.: _____

- 7.10 Record fluid temperature and return strongback to the horizontal position. Record elapsed time. Verify a smooth transition as strongback and container center of gravity passes through vertical.

TEMP: _____ Q.C.: _____
 TIME: _____ Q.C.: _____

- 7.11 Verify trailer stability has been maintained throughout this entire functional test cycle and that no drift has occurred between steps # 7.8 and 7.9.

Q.C.: _____

- 7.12 Verify strongback and container returns smoothly to the horizontal position and seats properly at the cradle supports.

Q.C.: _____

- 7.13 At remote pendent control, Switch Pump #1 to the OFF position. Verify light out and pump stopped.

Q.C.: _____

- 7.14 At the Remote Pendent Control Panel, switch Pump #2 to the "ON" position. Verify light "ON" and Pump #2 running.

Q.C.: _____

- 7.15 Record fluid temperature. Actuate Extend Cylinder and raise the strongback and container to the full vertical position. Record elapsed times.

TEMP: _____ Q.C.: _____
 TIME: _____ Q.C.: _____

- 7.16 Record fluid temperature. Actuate Retract Cylinder to return the strongback and container to the horizontal position. Record elapsed times.

TEMP: _____ Q.C.: _____
 TIME: _____ Q.C.: _____

During the test cycling, observe for any of the following:

- Smooth transition from horizontal to vertical.
- Smooth transition from vertical to horizontal.
- Container returns smoothly to horizontal cradle position. Any unplanned starts and/or stops through entire travel cycle.

Record any observed discrepancies in Section 1.0.

Q.C.: _____

- 7.17 With strongback and container in their horizontal positions, switch the power OFF to Pump #2. Verify light out and pump stopped.

Q.C.: _____

- 7.18 By use of the Remote Control Pendant start up Pump #1 and lift the strongback and container to a position approximately half way between horizontal and vertical position. At the half way position stop Pump #1, wait a minimum of three (3) minutes and turn on pump #2 using the pendant. Resume lift to vertical position using Pump #2 and Remote Control Pendant. Verify smooth operation throughout this step.

Q.C.: _____

- 7.19 After reaching the vertical position switch pump #2 OFF. Verify pump #2 off.

Q.C.: _____

- 7.20 Start Pump #1 and lower strongback and container to approximately half way between horizontal and vertical position. Stop Pump #1, wait a minimum of three (3) minutes and turn on Pump #2. Resume lowering to horizontal position. Verify smooth operation throughout this step.

Q.C.: _____

This completes the functional testing of the Main Hydraulic Cylinder System.

SECTION 8.0**PROOFLOAD TESTING**

- 8.1 By performing Section 7.0, the Proofload test has been accomplished. Q.C. verify Section 7.0 has been performed.
Q.C.: _____
- 8.2 Visually inspect all primary load carrying members on the container, strongback, and hydraulic trailer for cracked welds or any other signs of structural damage.
Q.C.: _____
- 8.3 Perform MT Testing of designated welds.
Q.C.: _____
- 8.4 Visually inspect all hydraulic system lines and components and verify that no fluid leakage occurred during testing.
Q.C.: _____

SECTION 9.0**ROLLING LOAD TEST**

- 9.1 Hook-up/Couple tractor/jeep to king pin of hydraulic trailer and verify engagement. Q.C.: _____
- 9.2 Retract trailer landing gear to their up-most stored position and verify. Q.C.: _____
- 9.3 Connect Electrical Wiring Harness Coupler to hydraulic trailer, and verify. Q.C.: _____
- 9.4 Connect Air Brake Couplings to hydraulic trailer, and verify. Q.C.: _____
- 9.5 Start up tractor, check-out and verify the following:
- 9.5.1 Running lights turn ON/OFF in correspondence with tractor. Q.C.: _____
- 9.5.2 Brake lights turn ON/OFF in correspondence with brake peddle and tractor brake lights. Q.C.: _____
- 9.5.3 Turn signal lights to blink in correspondence with tractor turn signal lights.
- LEFT TURN SIGNAL: Q.C.: _____
- RIGHT TURN SIGNAL: Q.C.: _____
- 9.5.4 Turn off the tractor. Q.C.: _____
- 9.6 Before Performing the following road test verify the following:
- 9.6.1 Outriggers are in the retracted positions. Q.C.: _____
- 9.6.2 Leveling cylinders are fully retracted up. Q.C.: _____
- 9.6.3 Electrical Power Cable has been disconnected. Q.C.: _____

9.6.4 All loose hand tools or any loose items have been removed from trailer, strongback and container.

Q.C.: _____

9.6.5 Pendant control and cable has been removed and stored.

Q.C.: _____

9.6.6 Bulk weight has been added to system to bring trailer to its designed 200,000 Lbs. rolling load capacity.

Q.C.: _____

9.6.7 Verify that the strongback, container, and added bulk weight is secured to the trailer. (Ref. use trailer tie downs to secure load).

Q.C.: _____

9.7 Rolling Load Test Procedure

9.7.1 Start up tractor and pull trailer forward and backward within the yard as space allows.

Q.C.: _____

9.7.2 Test trailer brakes by causing the trailer to come to an abrupt stop while rolling forward and while rolling backward. Verify all braked trailer wheels lock-up

Q.C.: _____

9.7.3 Verify and log minimum turning radius for hydraulic trailer. Obtain the minimum turning radius by theoretical calculation or by minimum turn demonstrated by pulling trailer into street and backing trailer into yard with a minimum turning maneuver.

MINIMUM TURNING RADIUS: _____

CALCULATED: _____ Q.C.: _____

DEMONSTRATED: _____

9.7.4 Return trailer to Yard and disconnect from tractor.

Q.C.: _____

9.7.5 Visually inspect hydraulic trailer for any signs of structural damage.

Q.C.: _____

9.7.6 MT test trailer welds as designated by manufacturer.

Q.C.: _____

