

PROCUREMENT SPECIFICATION FOR 20- FT x 10-FT x 9-FT DOT SPECIFICATION 7A TYPE A CONTAINER

Prepared for the U.S. Department of Energy
Assistant Secretary for Environmental Management

Contractor for the U.S. Department of Energy
under Contract DE-AC06-08RL14788



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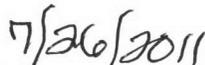
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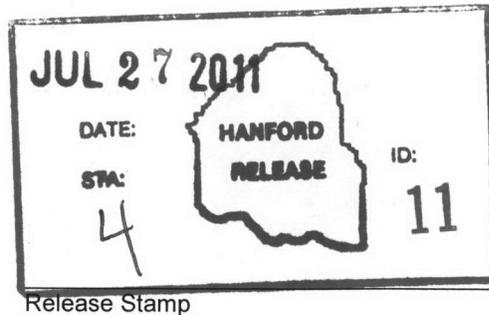
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PROCUREMENT SPECIFICATION FOR 20-FT X 10-FT X 9-FT DOT SPECIFICATION 7A TYPE A CONTAINER (CATALOG ID 658658-3)

1.0 GENERAL

- 1.1 SAFETY CLASS/QUALITY LEVEL:** General Service/Quality Level (QL) 3.
- 1.2 QUALITY ASSURANCE (QA) CLAUSES:** B16, B52, B73, B76, B82.
- 1.3 COMMON NAME:** DOT Specification 7A Type A Container.
- 1.4 COMPONENT USAGE:** U.S. Department of Transportation (DOT) container for the transport and storage of solid radioactive contaminated materials.
- 1.5 ABBREVIATIONS:** The abbreviations listed below, when used in this Specification, have the following meaning:

ANSI	American National Standards Institute
AWS	American Welding Society
ASME	American Society of Mechanical Engineers.
CFR	Code of Federal Regulations
CMTR	Certified Material Test Reports
MSDS	Material safety data sheet

1.6 CODES, STANDARDS, AND REGULATIONS:

Unless otherwise approved or shown, the following codes, standards, and regulations of the latest issue at the time of the bid shall apply.

10 CFR §820, "Procedural Rules for DOE Nuclear Activities," *Code of Federal Regulations*, as amended.

10 CFR §830.122, "Quality assurance criteria." *Code of Federal Regulations*, as amended.

49 CFR 173, "Shippers—General Requirements for Shipments and Packaging's," *Code of Federal Regulations*, as amended.

49 CFR §173.24, "General Requirements for packaging and packages"

49 CFR §173.24b, "Additional general requirements for bulk packagings"

49 CFR §173.410, "General Design Requirements"

49 CFR §173.412, "Additonal design requirements for Type A packages"

49 CFR §173.461, "Demonstration of Compliance with Tests"

49 CFR §173.465, "Type A Packaging Tests"

49 CFR §178.350, "Specification 7A; general packaging, Type A"

ASTM B 633-98e1, 1998 or later edition, "Standard Specification for Electrodeposited Coatings of Zinc on Iron and Steel", *American Society of Testing and Materials*, West Conshohocken, Pennsylvania.

AWS D1.1, 2008 or later edition, "Structural Welding Code - Steel - 21st Edition", *American Welding Society*, Miami, FL.

AWS D1.3, 2008 or later edition, "Structural Welding Code - Sheet Steel - 5th Edition", *American Welding Society*, Miami, FL.

FED-STD-595, 1994 or later edition, "Colors Used in Government Procurement (STD and Color Samples)", *Standardization Division, Federal Supply Service, General Services Administration*, Washington, D.C.

2.0 ITEM SPECIFICATIONS

- 2.1 DOT Specification 7A, Type A, carbon steel container having a minimum payload capacity of 15,876 kg (35,000 lb). A top opening design having a gasketed bolted closure. The lid shall include four (4) 4-in. grout ports. The container bottom shall be equipped with skids and/or fork pockets to facilitate handling with a forklift when empty and a crane when loaded. The intended payload for transport and storage in this container is Material Form No. 4 and is described below:
- Material Form No. 1: Solids--any particle size
 - Material Form No. 2: Solids--large particle size only (e.g., sand, concrete, debris, soil, etc.)
 - Material Form No. 3: Solids--objects with no significant or removable contamination. (For definition see 49 CFR 173.443, Contamination control.)
 - Material Form No. 4: Solids as described in Form No. 3 above, including large, bulky, dense objects with sharp and obtrusive members or components, but having Form No. 1 and/or No. 2 as dispersible contaminants associated with the material (e.g., steel plates, motors, valves, steel pipes, concrete blocks, etc.).
- 2.2 The container shall have nominal *internal* dimensions of 20 ft L x 10 ft W x 9 ft H with a tolerance of $\pm \frac{1}{2}$ -inch.
- 2.3 All welds shall conform to AWS D1.1 and/or D1.3 as appropriate. Seal welds, whether internal or external shall be continuous and smooth (without ridges, peaks, and/or sharp points). All welding shall be performed and inspected in accordance with American Welding Society Codes and Standards, 1996 editions or later.

- 2.4** The container lid shall include features that allow lifting by use of a crane and/or a forklift using forklift pockets. The forklift pockets (internal dimensions) shall be 18-in wide by 8.5-in tall \pm 0.5 inches spaced so that the center to center dimension is 60-in \pm 2-inches and that they extend the width of the lid. The lid-lifting components shall be capable of being disabled during transport, or be designed with strength equivalent to that required for lifting attachments per 49 CFR §173.410(b), which requires a minimum safety factor of three against yielding for a fully loaded container. In addition, the lifting attachments must be designed so that failure of any lifting attachment under excessive load would not impair the ability of the package to meet the requirements as a DOT 7A Type A package. These lifting attachments may be located on either the top or the four sides of the lid; however the lifting attachments shall not protrude so as to interfere with stacking of the container.
- 2.5** Four (4) grout ports shall be included in the lid of the container, one near each corner. The grout ports shall be located away from the edge of the lid to be protected from damage, but within 6 to 24 inches of the edge to allow access without getting on the lid. The grout ports shall be 4-in. 150 lb class (minimum) threaded pipe flanges or couplings welded or otherwise secured to the lid. A plug or blind flange installed to seal it for transport to the BUYER. The grout ports shall not negatively impact the integrity of the container and be part of the qualified configuration. The four grout ports specified for this container design shall be provided with some type of contamination control feature that can be easily broken by grout flow (e.g., a plastic sheet taped to the underside of each grout port, foil rupture disk, etc.).
- 2.6** The container shall be equipped with six filter ports; two on each side of the container and one on each end. The filter ports shall be $\frac{3}{4}$ in. with $\frac{3}{4}$ -14 National Pipe Straight Mechanical (NPSM) threads. The filter ports shall not extend beyond or protrude past the closure flange or external stiffeners on the inside or outside of the container. The SUPPLIER shall supply six (6) Rieke® Vise Grip II $\frac{3}{4}$ " Plated Plugs with EPT Gasket (Buna-N is not acceptable). They are to be placed in a bag and placed inside of the container along with the closure hardware and gaskets.
- 2.7** All gaskets shall meet the requirements for a DOT Type A packaging as specified in 49 CFR §173.412. The gasket material shall be flexible cellular Ethylene/Propylene/Diene / Monomer (EPDM) or Neoprene type material and meet ASTM D 1056 Type 2, Class A, Grade 2 or 3 or Buyer-approved alternative. The gasket shall retain its sealing abilities across a minimum temperature range of -40 to 70 °C (-40 to 158 °F).
- 2.8** There shall be a bolted closure to prevent loss or dispersal of the contents. High-strength fasteners (i.e., Grade 5, 8, ASTM 325 fasteners) are required. Fasteners shall exhibit grade marks and manufacturer's identification symbols (headmarks) as required by the Standard. Any fasteners supplied with headmarks matching those identified in Attachment A, "Suspect/Counterfeit Fastener Headmark List" shall be deemed to be unacceptable under the terms of this purchase order (PO).

Washers shall be provided in accordance with good commercial practices. The closure system shall be reusable and resist atmospheric corrosion by electroplating per ASTM B 633, FE/Zn 5, Type 3 or Buyer-approved equivalent method. These closure devices shall not protrude so as to interfere with stacking of the container.

The design may include guide pins to facilitate bolt hole lineup. The bolt holes shall be slotted for ease of bolt hole line up. In addition, the closure system shall include a feature that indicates whether or not the container has been opened (i.e., tamper indication).

- 2.9** The exterior coating shall be white, resistant to impacts, abrasions, scratches, and of a nature that ensures positive adhesion of a self-adhesive label such as a bar code or DOT label. The paint system may be alkyd enamel (melamine) or polyester based. The color shall be similar to Federal Standard 595 "Colors," color 17875 gloss, 27875 satin, or 37875 flat.

The interior coating shall be a corrosion-preventive primer at a minimum and any color is acceptable as long as it can be visually inspected for defects.

Paint coverage must be uniform and free of holidays, blisters, cracks, or de-lamination (e.g., peeling). Furthermore, the coatings shall expand, contract, and flex with the container without cracking. Preparation of the substrate and application of the coating shall be in accordance with the manufacturer's recommendations.

- 2.10** The container bottom shall be designed to allow manipulation by a forklift when empty and a crane when loaded. If forklift pockets are used, they shall be spaced appropriately beneath the bottom of the container. The pockets shall be designed such that forklift forks having a maximum spread of 2.1m (7 ft) can be utilized. The internal width of the fork pockets shall be of 35.5 cm \pm 12.7 mm (14 in. \pm 1/2 inch), and the internal height of the fork pockets shall be a minimum of 11.4 cm \pm 12.7 mm (4.5 in. \pm 1/2 inch). In addition, the forklift pockets shall pass completely through the base structure of the container so that lifting may be achieved by use of devices being inserted from either side of the container (e.g., forklift forks or lifting straps/chains via use of a crane). Container lift points shall meet the requirements of 49 CFR §173.410(b), which requires a minimum safety factor of three against yielding when the packaging is fully loaded with contents. This design must not interfere with stacking the container.

- 2.11** The SUPPLIER shall stencil and/or label the following markings on the upper left portion of all four (4) sides of the container. All characters shall be a minimum of 2.54 cm (1 in.) high, legible, permanent, and in a contrasting color so as to be readily apparent and understood. Stencil paint shall be Federal Standard 595 FS 37100. Manufacturer's name and address may be 1.27 cm (1/2") if approved by the BUYER.

Max gross weight (kg): XXXX
 (lb): XXXX
Tare weight (with lid) (kg): XXXX
 (lb): XXXX

Lid weight (kg): XXXX
(lb): XXXX

“USA DOT 7A Type A”

Manufacturer’s name and address

Manufacturer’s serial number

MM/YY (date of manufacture)

Purchase Order # (Buyer to provide)

NOTE: XXXX weights to be determined by manufacturer and supplied as built. Container weights shall be accurate to $\pm 4\%$. The tare weight represents the assembled container including the lid and all closure hardware. The max gross weight equals the tare weight, of the container plus the payload.

- 2.12** The Seller shall stencil “For Lifting Lid Only” on the lid next to each lifting attachment, if applicable (refer to Section 2.4). The size of the lettering and the colors shall be in accordance with 2.11.
- 2.13** For items provided under this P.O. having a limited shelf life, the material must have greater than six months of available shelf life at the time of shipment to the Buyer.
- 2.14** The Contractor shall take steps necessary to ensure the container is clean and the inside free of debris or foreign material (e.g., dust; particulates generated from welding, grinding, and sanding; or small parts). To ensure that the inside of the containers remain clean and free of any foreign material during shipment to the Buyer, the containers shall be shipped with the lid secured to the body of the container with a minimum of four (4) fasteners. The containers shall be vented to allow the containers to breathe to prevent them from pressurizing or developing a vacuum. This can be accomplished by using vent plugs with small holes drilled through them, filters, or by spacing the lid off the body of the container.
- 2.15** Closure Instruction Label: Each container shall have a label with the closure instructions printed on it. The closure labels shall be applied approximately 5.5 feet from the ground level of container on each of the containers long sides. The print shall be a minimum font size of 14 points. Labels shall be moisture resistant, suitable for outdoor use, and have a minimum service temperature of -40 to 70 °C (-40 to 158 °F). The label shall be difficult to remove requiring the use of tools or solvents to do so. At a minimum the label shall include the following information:
- Lid bolts and nuts torque value, tolerance, and torque sequence
 - NucFil-013 and NucFil-019DS torque values: For gross weight < 900 lbs 10 ± 2 ft-lbs and > 900 lbs 15 ± 2 ft-lbs.
 - $\frac{3}{4}$ -14 Rieke Plug 15 ± 2 ft-lbs.
 - Remove the shipping plugs, normally plastic or metal with a hole drilled in them, and replace with plugs and/or filters as appropriate.
 - 4” grout plug torque value, tolerance and/or 4” blind flange bolt torque and tolerance

3.0 CAPACITY/RATINGS

The estimated payload (contents) intended for transport is 15,876 kg (35,000 lb). The Seller shall identify the approved gross weight based on the provided design and the container tare weight.

4.0 PERFORMANCE REQUIREMENTS

The container must meet or exceed the requirements of a DOT Specification 7A, Type A container in accordance with 49 CFR §178.350. The results of the test specified in 49 CFR §173.465 shall be provided in a final test report that clearly identifies each requirement and how it is met. Use of analytical evaluations and the methodology shall be approved (see Section 7.1.2 and 7.4.3) in writing by the Buyer.

5.0 PERSONNEL REQUIREMENTS

Personnel involved with the design, fabrication, qualification, inspection, and/or handling of these containers or documentation associated with these containers shall be qualified, certified, and trained as required in accordance with the Contractor's Quality Assurance Program.

6.0 ENVIRONMENTAL, SAFETY, HEALTH, AND QUALITY REQUIREMENTS

The Contractor shall perform work safely, in a manner that ensures adequate protection for employees, the public, and the environment, and shall be accountable for the safe performance of work. The Contractor shall comply with, and assist the Buyer in applicable laws, regulations and directives.

- 6.1 The Contractor shall perform all work in accordance with his own safety procedures and in compliance with local, state, and federal requirements.
- 6.2 The Contractor shall be responsible for performing quality workmanship and shall conduct the quality control measures necessary to ensure work conforms to requirements of this Purchase Order.

Equipment requiring calibration shall be periodically calibrated in accordance with manufacturer tolerances to assure reliable results. The standard used to calibrate the equipment shall be traceable to the National Institute of Standards and Technology or other nationally recognized standard. Measuring and Test Equipment (M&TE) shall be selected based on the type, range, accuracy, and tolerance needed to accomplish inspections and tests in conformance with the specified requirements of this Purchase Order. When calibrated M&TE is used to verify conformance to the requirements of this

Purchase Order, the M&TE unique identifier, range, accuracy (increments) and calibration expiration date shall be recorded on the inspection and test reports.

6.3 Where software is used for calculations or analysis the following requirements apply:

1. The SUPPLIER shall identify the software and version used or applied. NQA-1 Requirement 3 402(e).
2. The SUPPLIER shall provide documented verification (performed by competent individual(s) or group(s)) that all computer software utilized in analysis activities produces correct solutions for the encoded mathematical models within defined limits for each parameter employed. NQA-1 Requirement 3 401(a); 801.1; 801.3; 801.4; NQA-1 PART II SUBPART 2.7 102 Definitions; NQA-1 PART II SUBPART 2.7 Software Configuration Management.
3. The SUPPLIER shall identify the process by which the data used in computer software applications is transferred into the software function and manipulated. The SUPPLIER shall also identify the propensity and for data degradation in the gathering/transferring process to include all calibration calculations performed by the software (line loss calculations, etc.) to mitigate errors. NQA-1 Requirement 3 402(b)(e)(d); 801.1; 801.2; NQA-1 PART II SUBPART 2.7 102 Definitions; 402.1 Software Design Verification.
4. The SUPPLIER shall define the quality assurance methodology applied to software design, development, and/or procurement efforts, e.g. NQA, EEE, or ISO commercial practices. The SUPPLIER shall also identify what industry standard or commercial practice methodology is followed for software lifecycle management to software testing (verification and validation), include reporting and documenting software errors, and version change control. NQA-1 Requirement 3 100, 402 (f); 501(a)(b)(c); 501.1; 600. NQA-1 PART II SUBPART 2.7 102 Definitions; 402.1 Software Design Verification; 404 Acceptance Testing; 405 Operation; 406 Maintenance.
5. When subcontracting software functions necessary to meet the requirements of the PO, the SUPPLIER is required to invoke all applicable above mentioned software quality assurance requirements on the contractor. 10 CFR 830 Subpart A, Ensuring Subcontractor and Supplier Quality.

6.4 Procurement Quality Clauses

B16 – Source Inspection – All items are subject to inspection at the SUPPLIER's facility or sub-tier SUPPLIER's facility by a BUYER's quality assurance/quality control representative. SUPPLIER shall notify BUYER at least 5 days in advance of the time items will reach any inspection hold point established by the BUYER in the procurement package.

B52 – Inspection and Test Report – The SUPPLIER shall submit legible, reproducible copies of Inspection/Test Reports. The report(s) shall include the following:

1. Identification of the applicable inspection and/or test procedure utilized.
2. Resulting data for all characteristics evaluated, as required by the governing inspection/test procedure.
3. Traceability to the item inspected/tested (i.e., serial number, part number, lot number, etc.).
4. Signature of the SUPPLIER's authorized representative or agency which performed the inspections/tests.

One copy of the documentation, unless otherwise specified, shall accompany the applicable item(s) shipped.

B73 – Control of Graded Fasteners - The provisions stated below are the minimum Department of Energy requirements for high strength graded fasteners produced in compliance with national consensus standards (e.g., SAE, ASTM, ASME).

1. Fasteners shall exhibit grade marks and SUPPLIER's identification symbols (headmarks) as required in the specifications referenced in the Purchase Order/Contract Order.
2. Any fasteners supplied with headmarks matching those displayed on the attached Suspect/Counterfeit Fastener Headmark list, or facsimiles thereof, shall be deemed to be unacceptable under the terms of this Purchase Order/Contract Order.
3. The SUPPLIER shall provide a legible and reproducible copy of the SUPPLIER's Certified Material Test Reports (CMTR). These CMTRs shall report the values of the actual chemical and physical tests performed on the represented fastener lot/material heat. Fastener packaging/ labeling shall be traceable by lot number or other positive means to the CMTRs.
4. Fasteners shall be inspected to verify compliance with the Purchase Order/Contract Order requirements. Additionally, fasteners may also be subjected to destructive testing.
5. The SUPPLIER shall provide a Certificate of Conformance which must certify conformance and traceability of supplied materials to the subject Purchase Order/Contract Order. The document must be legible and reproducible.

B76 – Procurement of Potentially Suspect or Counterfeit Items - Notwithstanding any other provisions of this agreement, the SUPPLIER warrants that all items provided to the BUYER shall be genuine, new and unused unless otherwise specified in writing by the BUYER. SUPPLIER further warrants that all items used by the SUPPLIER during the performance of work for the Hanford Site, include all genuine, original, and new components, or are otherwise suitable for the intended purpose. Furthermore, the SUPPLIER shall indemnify the BUYER, its agents, and third parties for any financial loss, injury, or property damage resulting directly or indirectly from material, components, or parts that are not genuine, original, and unused, or not otherwise suitable for the intended purpose. This includes, but is not limited to, materials that are defective, suspect, or counterfeit; materials that have been provided under false pretenses; and

materials or items that are materially altered, damaged, deteriorated, degraded, or result in product failure.

Types of material, parts, and components known to have been misrepresented include (but are not limited to) fasteners; hoisting, shackles, turnbuckles, cable clamps, wire rope, rigging, and lifting equipment; cranes; hoists; valves; pipe and fittings; electrical equipment and devices; plate, bar, shapes, channel members, and other heat treated materials and structural items; welding rod and electrodes; and computer memory modules. The SUPPLIER's warranty also extends to labels and/or trademarks or logos affixed, or designed to be affixed, to items supplied or delivered to the BUYER. In addition, because falsification of information or documentation may constitute criminal conduct, the BUYER may reject and retain such information or items, at no cost, and identify, segregate, and report such information or activities to cognizant Department of Energy officials.

SUPPLIER shall provide a written statement that "all items furnished under this Purchase Order/Contract Order are genuine (i.e., not counterfeit) and match the quality, test reports, markings and/or fitness for use required by the Purchase Order/Contract Order. The statement shall be on SUPPLIER letterhead and signed by an authorized agent of the SUPPLIER.

Any materials furnished as part of this Purchase Order/Contract Order which have been previously found to be suspect/counterfeit by the Department of Energy shall not be accepted. For further information on suspect/counterfeit items, reference the Department of Energy (DOE) Guide DOE G 414.1-3.

DOE Guide web address,

<http://www.directives.doe.gov/pdfs/doe/doetext/neword/414/g4141-3.pdf>

B82 – Recommended Spare Parts Listing - The SUPPLIER shall submit, with or prior to item shipment, a recommended spare parts list. The list shall provide the name and address of the original SUPPLIER of the replacement part, and the part's drawings, specification, or catalog identity including applicable change or revision information.

6.5 Other Quality Clauses

Nonconformance Documentation and Reporting – All nonconformances identified at the SUPPLIER's facility with a proposed disposition of "Accept" or "Repair" shall be approved by the BUYER before any corrective action is taken by the SUPPLIER on the nonconformance. All non-conformances shall be assigned a unique identifier.

Accept: A disposition that a nonconforming item will satisfactorily perform its intended function without repair or rework.

Repair: A disposition requiring the processing of a nonconforming item so that its characteristics meet the requirements listed in the disposition statement of the nonconformance report.

Non-conformances shall be documented by the SUPPLIER on the SUPPLIER's nonconformance form. After documenting the nonconformance, disposition and technical justification, the form shall be forwarded to the BUYER.

After the recommended disposition has been evaluated by the BUYER, the form shall be returned to the SUPPLIER with a disposition of approval or rejection. The SUPPLIER may take corrective action on the nonconformance only after the form is approved.

All applicable accept, and repair non-conformance's, shall be documented and submitted on the SUPPLIER's Certificate of Conformance.

The SUPPLIER's nonconformance form shall be shipped with the affected item.

Identification of Age Control Items (Gasket Material Only) – The gasket material provided under this P.O. shall have a minimum of six months of shelf life remaining at the time of shipment to the Buyer. The Supplier shall identify the gasket material, having limited shelf life, with the cure date or date of manufacture and the expiration date. The Supplier shall specify any storage temperatures, humidity and environmental conditions which should be maintained for the gasket material.

Certified Weld Inspector (CWI) – SUPPLIER personnel performing weld inspections shall be certified as a Certified Weld Inspector (CWI) in accordance with the requirements specified in AWS QC-1. The following documentation shall be submitted prior to the start of fabrication:

1. Current AWS CWI certificates
2. Current and valid visual acuity examination.
3. Visual weld inspection procedures.

Approval shall be obtained from the SUPPLIER prior to acceptance of the first container.

Welding Procedures and Qualifications – Welding procedures and personnel shall be qualified in accordance with the applicable AWS or ASME specifications as specified in the Purchase Order/Contract Order. Prior to BUYER acceptance of the first containers, the SUPPLIER shall submit for BUYER approval copies of all welding procedures, Procedure Qualification Records, and Welder Qualification Records to be employed in the performance of this Purchase Order/Contract Order.

Changes and revisions to welding documentation shall be submitted to the BUYER for review and approval prior to use. When subcontracting any portion of this Purchase Order/Contract Order, the SUPPLIER is required to invoke the applicable quality assurance program requirements on the subcontractor.

Certificate of Conformance - The SUPPLIER shall provide a legible/reproducible Certification of Conformance. SUPPLIER's authorized representative responsible for quality shall sign the Certification of Conformance.

Certification of Conformance shall contain all the requirements identified in Section 7.4:

One copy of the documentation, unless otherwise specified, shall accompany the applicable item shipped. For subsequent shipments on this Purchase Order/Contract order, reference may be made to documentation provided with earlier shipments, instead of duplicating such documentation.

7.0 DATA SUBMITTAL REQUIREMENTS

Legible reproducible documentation is required. A copy of the electronic media [e.g., Microsoft® (MS) Word®, Adobe® Acrobat® portable document format (PDF)] is preferred if available. If electronic media is not available, *two copies* of each of the following items shall be provided with the proposal:

7.1 Proposal Data Submittal

1. Container design/assembly drawings that include but are not limited to approximate dimensions (internal and external), volume capacity, container tare weight, maximum payload weight, maximum gross weight, materials of construction, gauge thickness of carbon steel, and details of the closure system.
2. Supporting test reports and/or engineering evaluations and any necessary test documentation (i.e., Type A performance tests, structural evaluations (FEA), lifting attachments, vibration, stack test, and closure procedures) to show compliance with 49 CFR §173.465. Engineering evaluations must be completed using conservative formulas from recognized standards and/or engineering evaluation and any other necessary test documentation (e.g., structural (Finite Element Analysis [FEA]), lifting attachments, vibration, stack test and closure procedure) to demonstrate that the design meets 49 CFR §173.412. The free drop and stack tests 49 CFR §173.465(c) and (d) should be physically tested; all other requirements may be tested or evaluated.

7.2 Prefabrication Submittal

The following shall be provided to the Buyer for approval prior to fabrication:

1. Gasket material specifications and a copy of the Material Safety Data Sheets (MSDS) for the SUPPLIER recommended gasket adhesive.
2. Final design drawings: These drawings shall provide the necessary details to fabricate the containers which include sizes, dimensional tolerance block, AWS weld symbols, general notes, weld and weld material requirements, seal/gasket material, and surface finishes.
3. Fabrication schedule and delivery schedule.

4. Weld procedures and welder qualification reports for review and approval.
5. Documentation for the certification of the SUPPLIER's Certified Weld Inspector (CWI) for review and approval.
6. Draft of closure instruction label for approval (Section 2.15).
7. Identification of paint system to be used, copy of technical bulletin regarding the paint system, and the applicable MSDS.

7.3 Fabrication Submittal

The following shall be provided to the Buyer for approval during fabrication:

1. Notification of container testing date(s) five (5) working days prior to performance of the test.
2. Notification of final assembly inspection date(s) five (5) working days prior to performing and shipment to the Buyer.
3. Submittal of any nonconformance's requiring an accept-as-is or repair disposition for Buyer approval.

7.4 Shipment Data Submittal

Legible reproducible documentation is required. A copy of the electronic media (e.g., MS Word, Adobe Acrobat PDF) is preferred if available. If electronic media is not available, *two copies* of each of the following items shall be provided with each order/shipment.

1. Manufacturer's Certificate of Conformance showing the following.
 - a. BUYER's PO number.
 - b. Container serial number.
 - c. Quantity of containers provided.
 - d. Certifying statement that the container(s) meet(s) the PO requirements.
 - e. A written statement that items furnished under this PO are genuine (i.e., not counterfeit) and match the quality, test reports, markings, and/or fitness for use required by the PO (B76).

- f. If no non-conformances are generated, state as such on the CoC, otherwise they must be listed on the CoC.
 - g. Statement documenting that each container was welded per AWS D1.1 and AWS D1.3 as applicable inspected as required to verify compliance.
 - h. Includes any approved changes, waivers, or deviations applicable to the containers supplied.
 - i. Statement that each container “complies with the requirements of 49 CFR 178.350.
 - j. SUPPLIER’s authorized representative responsible for quality shall sign the Certificate of Conformance.
2. The final as-built container drawings (8½ in. x 11 in. minimum).
3. The final test report and/or engineering evaluations and any necessary test documentation included, but not limited to, Type A performance tests, structural evaluations (FEA), lifting attachments, vibration, stack test, and closure procedures to show compliance with 49 CFR §173.465.
4. B73 Control of Graded Fasteners. The fastener supplier shall provide a Certificate of Conformance that certifies conformance and traceability of supplied materials to the subject PO.
5. Gasket replacement instructions to include removal, surface preparation, and installation.
6. Container closure instructions, which shall include torque values and tightening sequence.
7. Identify expiration date and environmental storage conditions for items having a limited shelf life.
8. B52 Inspection and Test Report. The report shall be legible and reproducible and shall include the following
 - Identification of applicable inspection, and/or test procedure utilized (weld inspection, critical dimensions, and leak test).
 - Resulting data for all characteristics evaluated, as required by the governing inspection/test procedure.
 - Traceability to items inspected or tested, (i.e., serial number, part number etc).
9. B82 Recommended Spare Parts Listing.

8.0 SHIPPING REQUIREMENTS

All of the requirements identified below shall be adhered to unless the Buyer indicates otherwise.

- The container shall be shipped with the lid secured to the body of the container.
- The gaskets shall not be installed, but shall be secured inside a weatherproof plastic bag along with the Rieke plugs and closure hardware that shall be placed inside the container and tied to a closure bolt.
- All closure hardware installed on the container shall be secured to prevent vibration-induced loosening during transportation.
- The container shall be protected from damage during handling and transportation activities, and secured to the transport vehicle in a manner that will not mar or damage the coating.
- Tie-down straps must not be allowed to come into direct contact with coated surfaces during transport.
- The container may be tarped to provide protection from inclement weather and road hazards encountered during transport to the Buyer's facility. Tarping shall be secured to prevent damage to the coating from tarp movement during transportation.
- Grout and vent ports in the container shall be protected from egress of debris prior to shipment.
- Container must be vented to allow barometric breathing.

NOTE: If shipping plugs are used, closure instructions must require that they be removed and that the provided plug(s) installed and/or appropriate filters installed.

NOTE: Minor scratches and/or scuffs to the coating are acceptable as long as the substratum metal is not damaged.

**ATTACHMENT A
SUSPECT/COUNTERFEIT FASTENER HEADMARK LIST**

Headmark List			
All Grade 5 and Grade 8 Fasteners of Foreign Origin Which Do Not Bear Any Manufacturers' Headmarks:			
	Grade 5		Grade 8
Grade 5 Fasteners with the Following Manufacturers' Headmarks:			
MARK	MANUFACTURER	MARK	MANUFACTURER
 J	Jinn Her (TW)	 KS	Kosaka Kogyo (JP)
Grade 8 Fasteners with the Following Manufacturers' Headmarks:			
MARK	MANUFACTURER	MARK	MANUFACTURER
 A	Asahi Mfg (JP)	 KS	Kosaka Kogyo (JP)
 NF	Nippon Fasteners (JP)	 RT	Takai Ltd (JP)
 H	Hinomoto Metal (JP)	 FM	Fastener Co of Japan (JP)
 M	Minamida Sleybo (JP)	 KY	Kyoel Mfg (JP)
 MS	Minato Kogyo (JP)	 J	Jinn Her (TW)
	Hollow Triangle Infasco (CA TW JP YU) (Greater than 1/2 inch dia)		
 E	Daiel (JP)	 UNY	Unytite (JP)
Grade 8.2 Fasteners with the Following Manufacturers' Headmarks:			
		MARK	MANUFACTURER
		 KS	Kosaka Kogyo (JP)
Grade A325 Fasteners (Bennet Denver Target Only) with the Following Headmarks:			
		MARK	MANUFACTURER
Type 1		A325 KS	Kosaka Kogyo (JP)
Type 2			
Type 3			

NOTE: Any bolt on this list should be treated as defective without further testing.

**ATTACHMENT B
SUBMITTAL SUMMARY**

Checklist for 20x10.5x9 DOT Specification 7A, Type A Containers	Review			
	Acc.	Rej.	Init.	Date
Proposal Data Submittal (One time only)				
Container design/assembly drawings that include but are not limited to approximate dimensions (internal and external), volume capacity, container tare weight, maximum payload weight, maximum gross weight, materials of construction, gauge thickness of carbon steel, and details of the closure system.				
Supporting test reports and/or engineering evaluations and any necessary test documentation to show compliance with 49 CFR §173.465. Engineering evaluations must be completed using conservative formulas from recognized standards. Examples of this documentation are acceptable if actual results are not available.				
Identification of paint system to be used, copy of technical bulletin regarding the paint system, and the applicable MSDS.				
Prefabrication Submittal				
Gasket material specifications and a copy of the MSDS for the SUPPLIER recommended gasket adhesive.				
Final design drawings: These drawings shall provide the necessary details to fabricate the containers which include sizes, dimensional tolerance block, AWS weld symbols, general notes, weld and weld material requirements, seal/gasket material, and surface finishes.				
Fabrication and delivery schedules				
Welder procedures and welder qualification reports for review and approval				
Documentation for the certification of the SUPPLIER'S Certified Weld Inspector (CWI) for review and approval				
Draft of closure instruction label for approval				
Fabrication Submittal				
Notification of container testing date(s) five (5) working days prior to performance of the test.				
Notification of final assembly inspection date(s) five (5) working days prior to performing and shipment to the BUYER.				
Submittal of any nonconformance's requiring an accept-as-is or repair disposition for BUYER approval				
Shipment Data Submittal				
Manufacturer's Certificate of Conformance showing the following: <ul style="list-style-type: none"> a. BUYER's Purchase Order (PO)/Contract Order (CO) number. b. Container serial number(s). c. Quantity of containers provided. d. Certifying statement that the container(s) meet(s) the PO requirements. e. A written statement that items furnished under this PO/Contract Order are genuine (i.e., not 				

Checklist for 20x10.5x9 DOT Specification 7A, Type A Containers	Review			
	Acc.	Rej.	Init.	Date
<p>counterfeit) and match the quality, test reports, markings (Appendix A), and/or fitness for use required by the PO/CO (B76).</p> <p>f. If no non-conformances are generated, state as such on the CoC, otherwise they must be listed on the CoC.</p> <p>g. Statement documenting that each container was welded per AWS D1.1 and/or D1.3 and inspected as required to verify compliance. Statement that each container "complies with the requirements of 49 CFR 178.350.</p> <p>h. SUPPLIER's authorized representative responsible for quality shall sign the Certificate of Conformance.</p> <p>NOTE: One CoC may contain multiple units/items.</p>				
The final as-built container drawings (8½ in. x 11 in. minimum)				
The final test report and/or engineering evaluations and any necessary test documentation included, but not limited to, Type A performance tests, structural evaluations (FEA), lifting attachments, vibration, stack test, and closure procedures to show compliance with 49 CFR §173.465.				
B73 Control of Graded Fasteners. The fastener SUPPLIER shall provide a Certificate of Conformance that certifies conformance and traceability of supplied materials to the subject PO.				
Identify expiration date and environmental storage conditions of items having a limited shelf life, and that these items were maintained in accordance with the storage conditions while in possession of the SUPPLIER.				
Gasket replacement instructions to include removal, surface preparation, and installation				
Container closure instructions, which shall include torque values and tightening sequence				
Identify expiration date and environmental storage conditions for items having a limited shelf life				

Checklist for 20x10.5x9 DOT Specification 7A, Type A Containers	Review			
	Acc.	Rej.	Init.	Date
<p>B52 Inspection and Test Report. The report shall be legible and reproducible and shall include the following</p> <ul style="list-style-type: none"> • Identification of the applicable inspection, and/or test procedure utilized (weld inspection, critical dimensions, and leak test). • Resulting data for all characteristics evaluated, as required by the governing inspection/test procedure. • Traceability to items inspected or tested, (i.e., serial number, part number etc). 				
<p>B82 Recommended Spare Parts Listing. The SUPPLIER shall submit, with the item shipment, a recommended spare part list. The list shall provide the name and address of the original SUPPLIER of the replacement part and the part's drawing, specification, or catalog identity including applicable change or revision information. NOTE: Only needed once.</p>				