

James Walker	Joining Cover Bridge Piece Method	Date: Jun 27, 2013 Reaffirmed 2023	Rev: 3	Page: Page 1 of 1	Document No: OPI 121 Approved by: Operations Manager
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REASON FOR UPDATE: Reformatting of Document & Change of Ownership

ASSOCIATED DOCUMENTS: FMP Ref: [FMP 20](#)

1. PURPOSE

- 1.1** To provide a procedure for the method of baking / inspection of the bridge onto springs for Magnox outer flask seals.

2. SCOPE

- 2.1** This document applies to all those involved with the method of baking / inspection of the bridge onto springs for Magox outer flask seals.

3. RESPONSIBILITY

- 3.1** The Operations Director is responsible for updating and communicating the details within this procedure.

4. PROCEDURE

- Yellow polymeric sleeving to conform to MIL-DTL-23053/SC Class 1 (e.g. polyolefin)
1. Lay the covered spring on a flat metal surface, with the desired cover piece centrally over the spring join.
 2. Ensure that the covered spring is heated for 7 + - 2 Minutes at 150° + - 5°c in the appropriate baking oven.
 3. Allow time for the spring to cool to room temperature prior to handling and ensuring no damage has occurred to the cover during baking.
 4. Fully cooled springs to be returned into its traceable black bag for storing prior to measurement and fitting into seals.