



**UNITED STATES  
NUCLEAR REGULATORY COMMISSION**  
REGION II  
245 PEACHTREE CENTER AVENUE NE, SUITE 1200  
ATLANTA, GEORGIA 30303-1257

July 28, 2015

Gary J. Laughlin, Chief Nuclear Officer  
and Head of Operations  
URENCO USA  
P.O. Box 1789  
Eunice, NM 88231

**SUBJECT: LOUISIANA ENERGY SERVICES, URENCO USA FACILITY – NUCLEAR  
REGULATORY COMMISSION INTEGRATED INSPECTION REPORT NUMBER  
70-3103/2015-003**

Dear Mr. Laughlin:

This refers to the inspections conducted during the second quarter of calendar year 2015, at the Louisiana Energy Services (LES), URENCO USA facility, located in Eunice, New Mexico. (Inspection Report No. 70-3103/2015-003 enclosed.) The purpose of the inspections was to determine whether activities authorized under the license were conducted safely and in accordance with U.S. Nuclear Regulatory Commission (NRC) requirements, and to follow up on previously identified issues. The enclosed report presents the results of these inspections.

During these inspections, the NRC staff examined activities conducted under your license as they relate to public health and safety to confirm compliance with the Commission's rules and regulations, and with the conditions of your license. Within these areas, the inspections consisted of selected examination of procedures and representative records, observations of activities, and interviews with personnel.

The inspections covered the following areas: Operational Safety, Nuclear Criticality Safety, Maintenance and Surveillance, and Quality Assurance. No findings of significance were identified.

In accordance with Title 10 of the *Code of Federal Regulations* 2.390 of the NRC's "Agency Rules of Practice and Procedure," a copy of this letter and its enclosure will be made available electronically for public inspection in the NRC Public Document Room or from the Publicly Available Records System (PARS) component of NRC'S Agencywide Documents Access and Management System (ADAMS). ADAMS is accessible from the NRC Web site at <http://www.nrc.gov/reading-rm/adams.html> (the Public Electronic Reading Room).

G. Laughlin

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If you have any questions, please call me at 404-997-4629.

Sincerely,

***/RA/ D. Hartland for***

Marvin D. Sykes, Chief  
Projects Branch 1  
Division of Fuel Facility Inspection

Docket No. 70-3103  
License No. SNM-2010

Enclosure:  
NRC Inspection Report No. 70-3103/2015-003  
w/Attachment: Supplementary Information

cc: (See page 3)

G. Laughlin

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**U. S. NUCLEAR REGULATORY COMMISSION**

**REGION II**

Docket No: 70-3103

License: SNM-2010

Report No: 70-3103/2015-003

Licensee: Louisiana Energy Services, L.L.C. (LES)

Facility: URENCO USA, National Enrichment Facility (NEF)

Location: Eunice, NM 88231

Inspection Dates: April 1 through June 30, 2015

Inspectors: M. Toth, Fuel Facility Inspector, DFFI (Section A.1)  
C. Read, Fuel Facility Inspector, DFFI (Sections A.2 and A.4)  
A. Matos-Marín, Construction Inspector, DCI (Sections C.2-C.4)  
P. Carman, Construction Inspector, DCI (Sections C.2-C.4)  
B. Adkins, Senior Fuel Facility Inspector, DFFI (Sections A.3 and C.1)  
T. Sippel, Fuel Facility Inspector, DFFI (Section A.3)  
D. Anderson, Fuel Facility Inspector, DFFI (Section A.3)  
G. Goff, Fuel Facility Inspector, DFFI (Section B.1)

Approved by: M. Sykes, Chief  
Projects Branch 1  
Division of Fuel Facility Inspection

Enclosure

## **EXECUTIVE SUMMARY**

Louisiana Energy Services, L.L.C., (LES), URENCO USA (UUSA)  
NRC Integrated Inspection Report 70-3103/2015-003  
April 1 through June 30, 2015

This is a quarterly integrated inspection report that documents announced, routine inspections that were conducted by NRC regional inspectors during normal shifts in the areas of operational safety, maintenance and surveillance, nuclear criticality safety, and quality assurance, and to follow up on previously-identified issues. During the inspection period, normal production activities were ongoing. These announced, routine inspections consisted of a selective examination of procedures and representative records, observations of activities, walkdowns of items relied on for safety (IROFS), and interviews with licensee personnel.

### **Safety Operations**

- The IROFS reviewed were properly implemented and maintained in order to perform their intended safety function. (Paragraph A.1)
- The systems, structures, and components designed to support safe operation of Autoclaves 4 and 5 in Separations Building Module 1003 were properly constructed and tested. (Section A.2)
- The Nuclear Criticality Safety program was implemented in accordance with the license Safety Analysis Report and regulatory requirements. (Section A.3)
- The inspectors determined that IROFS C23 was properly implemented for Cascades 5.5 through 5.8 in order to perform its intended safety function. (Paragraph A.4)

### **Facility Support**

- The Maintenance and Surveillance of Safety Controls program was implemented in accordance with the license application and regulatory requirements. (Section B.1)

### **Other Areas**

- Unresolved Item (URI) 2014-005-001, Criteria for Changes to Licensing Basis Documents, was discussed. (Section C.1)
- IROFS related to the Instrumentation and Control Systems of Autoclaves 4 and 5 were properly constructed and tested. (Section C.2)
- Mechanical components of Autoclaves 4 and 5 were properly constructed and tested. (Section C.3)
- Conditions adverse to quality were identified and resolved appropriately. (Section C.4)

Attachment: Supplementary Information

## **REPORT DETAILS**

### **Summary of Plant Status**

The Louisiana Energy Services, URENCO USA Facility, enriches uranium hexafluoride (UF<sub>6</sub>) for the fabrication of low-enriched fuel assemblies used in commercial light water reactors. During the inspection period, normal production activities were ongoing. Construction and testing in some areas of Separation Building Modules (SBMs) 1003 and 1005 and other applicable process areas continued in preparation for future operation of additional cascades and equipment.

#### **A. Safety Operations**

##### **1. Operational Safety (Inspection Procedure (IP) 88020)**

###### **a. Inspection Scope and Observations**

The inspectors interviewed staff and reviewed records associated with the Cylinder Receipt and Dispatch Building (CRDB) and the SBM process areas. The inspectors selected a sample of safety controls, including a selection of sole administrative IROFS, from the Product Takeoff System, Liquid Effluent Collection and Transfer System (LECTS), and UF<sub>6</sub> cylinder handling to review. The inspectors determined that the safety controls were being adequately implemented and properly communicated as described in the Integrated Safety Analysis (ISA) Summary and the Safety Analysis Report (SAR).

The inspectors performed field walkdowns and procedure reviews for selected engineering controls and confirmed IROFS were present and capable of performing their intended safety functions. The inspectors verified the physical presence of passive and active engineered safety controls against approved Piping and Instrumentation Diagrams (P&IDs), evaluated the material condition of safety controls to determine their operational readiness, and verified that potential accident scenarios were covered as written within the ISA Summary.

The inspectors reviewed operating procedures and determined that required actions as identified in the SAR were correctly transcribed into written operating procedures. The inspectors evaluated procedural revisions to ensure changes maintained compliance with the regulations and license commitments. The inspectors confirmed that surveillance requirements and required actions as identified in the Operating Requirements Manual (ORM) adequately implemented the requirements of the IROFS as described in the ISA Summary.

The inspectors interviewed operators and technicians responsible for handling and transport of UF<sub>6</sub> cylinders onsite and determined that they were adequately implementing the required safety controls associated with sole administrative IROFS. Additionally, the inspectors observed operators' and technicians' performance in the field and determined that they were adhering to applicable safety procedures and Conduct of Operations procedural requirements. The inspectors reviewed the procedures and



postings applicable to the tasks being observed and determined that these procedures and postings were current, reflected safety controls, and were followed by the operators and technicians.

Through interviews and document reviews, the inspectors verified that the licensee conducted preventive maintenance, calibration, and periodic surveillances as required by the SAR for the selected safety controls.

The inspectors reviewed a selection of corrective action program (CAP) entries since the last Operational Safety inspection and determined that the licensee was identifying operational safety problems at an appropriate threshold and entering them into the CAP system. Also, the inspectors evaluated the actions associated with the CAP and determined that the completed corrective actions were adequate.

b. Conclusion

No violations of NRC requirements were identified.

2. Plant Operations (IP 88020) Verification that the systems structures and components designed to support operation of Autoclaves 4 and 5 in SBM 1003 met license requirements prior to allowing operation of the autoclaves

a. Inspection Scope and Observations

The inspectors conducted in-office and onsite reviews of revised licensing documents and procedures to ensure they were updated and adequately reflected the future operation of Autoclaves 4 and 5 in SBM 1003. The inspectors confirmed that appropriate changes were made to the ISA Summary and SAR to include Autoclaves 4 and 5. The following IROFS and their associated Boundary Documents (BDs) and ORMs were reviewed by the inspectors.

IROFS 10	Design Feature to Maintain Product Liquid Sampling Autoclave Leak Tight Integrity
IROFS 11	Automatic Trip of the Autoclave Heater and Fan on Autoclave High Internal Air Temperature
IROFS 12	Automatic Trip of the Autoclave Heater and Fan on Autoclave High Internal Air Pressure
IROFS 28	Design Feature to Maintain Product Liquid Sampling Autoclave Leak Tight Integrity

The IROFS that were in place for Autoclaves 1-3 in SBM-1001 were also used for Autoclaves 4 and 5 in SBM-1003.

The inspectors reviewed the design, calculations, and equipment associated with IROFS 11 and 12, relating to the trip of the autoclave heater and fan on high internal air temperature and pressure, respectively. The inspectors verified IROFS 11 and 12 were adequately designed and tested. The inspectors reviewed the testing records for IROFS 11 and observed a functional test of IROFS 12 while onsite. The inspectors

confirmed the autoclave heater and fan tripped as designed. Also during the onsite review, the inspectors observed a surveillance test of IROFS 10 which leak-tested the door seal. The inspectors verified that IROFS 10 was an acceptable test for the door seal and that the seal is checked each time the door is opened. The inspectors walked down the components associated with IROFS 28 and discussed sample manifold connections and testing with an operator.

b. Conclusion

No findings of significance were identified.

3. Nuclear Criticality Safety (IPs 88015, 88016, and 88017)

a. Inspection Scope and Observations

The inspectors evaluated the adequacy of the licensee's nuclear criticality safety (NCS) program and analyses to ensure the safety of fissile material operations. The inspectors reviewed selected NCS documents to verify whether the criticality safety of risk-significant operations was ensured through sufficient engineered and administrative controls, whether the approved safety margin was maintained, and whether the program was carried out by properly trained and qualified personnel. The NCS analyses demonstrated adequate identification and control of criticality hazards to ensure operations within subcritical limits through appropriate limits on controlled parameters. The inspectors interviewed the NCS manager, three NCS engineers, and an NCS support staff member about the NCS program. The inspectors also interviewed additional staff and a manager about operations and controls. The inspectors reviewed aspects of selected NCS-related IROFS, including IROFS 30a, 30b, 30c, 45, 55a, and 55b, to confirm that the IROFS, as implemented, would ensure operations remained within the safety basis of the NCS analysis.

The inspectors interviewed NCS staff, observed NCS staff perform a weekly nuclear criticality safety inspection (NCSI), reviewed the annual NCS audit and self-assessment, and reviewed aspects of procedures and commitments to verify that the licensee was meeting its commitments as identified in the SAR. The inspectors reviewed a sample of NCSIs completed since the last inspection (NCSI-14-0041, NCSI-15-0014) to confirm that areas of the facility were being appropriately inspected and that issues were being identified and resolved. Specific to the NCSI that was observed for the LECTS, the inspectors verified that the NCS engineer opened event reports, checked the facility condition, checked operating logs, reviewed postings, reviewed the last NCSI of that area, and reviewed requirements of the NCS evaluation to ensure that operations were being conducted within the bounds of the analysis.

The inspectors interviewed licensee engineers and technicians about the criticality alarm system (CAS), including the system's logic, setpoints, detector placement, reliability, and evacuation plans to confirm that the CAS meets the requirement of American Nuclear Society (ANS) 8.3 and 10 CFR 70.24. The inspectors verified that the system design, detector type, and alarm signal were uniform across the site. The CAS detectors and logic were tested in accordance with the requirements of ANS 8.3.

The inspectors performed plant walkdowns of the product takeoff system, LECTS, cylinder handling operations in the CRDB, the chemistry lab, and the CAS system in SBM 1005 focusing on the implementation of NCS controls and IROFS. The inspectors interviewed NCS engineers and operations staff before and during walkdowns to confirm that NCS-related controls were installed or being implemented in a way that performs the safety function specified in the associated NCS evaluation or analysis (e.g. NCS-CSA-006, NCS-CSA-016) and were adequate to ensure safety.

The inspectors reviewed the licensee's most recent trend report ("2015 1st Quarter Trend Report") and the licensee's response to a selection of NCS-related internally reported events (e.g.: ER 2014-743, ER 2014-1006). The inspectors interviewed licensee staff concerning the events and associated corrective actions to confirm that appropriate corrective actions were assigned and completed.

b. Conclusion

No violations of NRC requirements were identified.

4. Plant Operations (IP 88020) Verification that the systems structures and components designed to support operation of Cascades 5.5 through 5.8 met license requirements prior to initiation of feed

a. Inspection Scope and Observations

The inspectors reviewed records associated with the IROFS C23 for the verification of Cascades 5.5 through 5.8. The inspectors determined that the design features for IROFS C23 for the TC 21 centrifuges were adequate to minimize releases and were being adequately implemented and properly communicated as described in the ISA Summary.

The inspectors confirmed that the reviewed passive engineered controls were present and capable of performing their intended safety function. The inspectors reviewed the procedure applicable to the operational validation of IROFS C23 and determined that the procedure was current, reflected the safety controls, and was followed by the operators and technicians.

Through interviews and document reviews, the inspectors verified that the licensee conducted calibration and surveillance activities as required by the ISA Summary and the commercial grade dedication (CGD) process for IROFS C23. The inspectors also reviewed the CGD package for each cascade to verify compliance with applicable procedures and license requirements.

b. Conclusion

No violations of NRC requirements were identified.

B. Facility Support

1. Maintenance and Surveillance of Safety Controls (IP 88025)

a. Inspection Scope and Observations

The inspectors interviewed managers and supervisors to evaluate maintenance and surveillance program activities. The inspectors verified that IROFS and safety controls were maintained and tested to ensure availability and reliability to perform the intended safety function.

The inspectors verified that the licensee's work/configuration control program had provisions to ensure adequate pre-job planning and preparation of work packages to support maintenance and surveillance activities. The inspectors reviewed maintenance and surveillance work packages for accuracy and to ensure that test packages challenged and verified operability of IROFS and safety controls. The inspectors verified that post-maintenance testing and calibrations, as specified by the procedure, were adequately performed prior to restoring IROFS and other safety equipment to operational status.

The inspectors toured the Maintenance and Testing Equipment (M&TE) laboratory and found testing and calibration equipment to be within calibration and properly marked and stowed. The inspectors also noted that the licensee maintained an electronic spreadsheet which provided notification of upcoming required equipment maintenance and calibrations. The storage procedure for controlling spare parts associated with IROFS was adequately implemented.

The inspectors walked down the CAS. The inspectors observed the power supplies and condition of the components of the CAS. The inspectors confirmed the condition of the components to be adequate.

During a tour of the chemistry lab, the inspectors verified that the standards for measuring the percentage of hydrogen in incoming shipments of vacuum pump oil per IROFS 30a were within the proper calibration and properly stored.

The inspectors observed maintenance work activities on IROFS 11 (a resistance temperature detector and its associated logic) and determined that the work activity was conducted in accordance with licensee requirements and approved procedures. The completed work package was adequately reviewed by the licensee prior to returning the equipment to service.

The inspectors reviewed the licensee's CAP to verify that performance issues relating to the maintenance and surveillance of IROFS and safety controls were entered into the CAP and evaluated the adequacy of corrective actions taken. Based on a review of event reports, the licensee was taking adequate corrective actions after identifying failed or degraded safety controls.

b. Conclusion

No findings of significance were identified.

## C. Other Areas

### 1. Follow-up on Previously Identified Issues

#### a. (Discussed) Unresolved Item (URI) 2014-005-001: Criteria for Changes to Licensing Basis Documents

In 2014, the NRC opened a URI while evaluating additional information related to the licensee's programs for managing changes to licensing basis documents. As a follow-up to this URI, the inspectors reviewed additional licensing basis document changes to determine if the licensee was adequately implementing their change management programs and applied proper thresholds for when NRC pre-approval was required. The following changes were reviewed: Configuration Change (CC)-EG-2013-0144, CC-QA-2012-0003, CC-RW-2013-0003, Licensing LBDRC-13-0015, and LBDRC-12-0001. As a result of their review, the NRC concluded that the licensee adequately implemented their change management programs including changes to the SAR through license condition (LC)-30. Specifically, the inspection focused on changes associated with NCS and structural design, but did not involve other regulated programs such as environmental, security, quality assurance, emergency preparedness, or LC-30 changes that involve other safety disciplines (e.g. fire). Changes associated with these programs will be inspected during future inspections.

### 2. Instrumentation and Control Systems (IP 88140)

#### a. Inspection Scope and Observations

The inspectors conducted direct observation of completed work and as-built verification of instrumentation and control (I&C) components to determine whether the installation and calibration of IROFS related to Autoclaves 4 and 5 complied with applicable requirements. Specifically, IROFS 11 and 12, which relate to the fail-safe systems used to trip the heater and fan on high internal air pressure or high internal air temperature to ensure the integrity of the product liquid sample autoclave, were inspected.

The inspectors observed the completed installation of instrumentation components for IROFS 11 and 12 to determine whether the following areas were in accordance with applicable NRC requirements and licensee commitments:

- the location and configuration were in accordance with the latest approved design drawings,
- the specified instrument components and associated items were used,
- the components were correctly and permanently identified,
- instrument components and associated items maintained adequate physical and electrical independence between redundant parts,
- IROFS protection systems and normal plant control systems were adequately separated and isolated from each other, and
- wiring and terminations were installed in compliance with construction drawings and specifications.

The inspectors reviewed records associated with the design, procurement, installation, and acceptance of Autoclaves 4 and 5 to determine whether technical requirements for IROFS 11 and 12 were adequately addressed in specifications, drawings, purchase orders, work plans, and inspection plans. In addition, the inspectors reviewed and evaluated quality records to verify that work was performed by trained personnel and properly documented in accordance with applicable requirements and procedures.

Records reviewed included:

- design change documents to determine whether the licensee controlled and documented these changes for engineering review, approval and subsequent incorporation into the final as-built drawings;
- receipt inspection records to verify that receipt inspection documents properly and uniquely identified received instrument components, and that applicable engineering and functional specifications were met;
- training records of personnel identified as the craft performing the site acceptance tests and surveillances for IROFS 11 and 12, to determine if craft were trained and qualified;
- surveillance/calibration procedures and result datasheets to verify whether trip points were set at appropriate values in accordance with engineering calculations;
- M&TE calibration records and the qualification of laboratories that performed the calibration of M&TE to verify that M&TE used were qualified at the time of use, and;
- event reports to verify that nonconforming conditions were identified and controlled in accordance with approved procedures.

b. Conclusion

No violations of NRC requirements were identified.

3. Mechanical Components (IP 88136)

a. Inspection Scope and Observations

The inspectors reviewed a sample of documents for procurement, receipt inspection, fabrication, installation, and testing activities related to the Autoclaves 4 and 5 pressure vessels to determine if associated components met the licensee's Quality Level -1 (QL-1) criterion, commercial grade dedication requirements of the Quality Assurance Program Description (QAPD), and safety requirements identified in the license. The inspectors focused on verifying IROFS related to Autoclaves 4 and 5 were implemented into construction documents and the installation of Autoclaves 4 and 5. Specifically, IROFS 10 and IROFS 28, which relate to the pressure vessel leak tight integrity and the ability to withstand seismic and tornado missile events, were inspected.

The inspectors reviewed engineering calculations ARC-971, Seismic Evaluation of Sholtz Autoclave Quality Level – QL1, and ARC-972, Failure Mode and Effects Analysis of the Sholtz Autoclaves Quality Level – QL1, to determine whether the critical characteristics and acceptance criteria identified in the Autoclaves (AC) 4 and 5 Commercial Grade Dedication Plans (CGDPs) were consistent with the engineering analysis and safety functions required by IROFS 10, IROFS 28, and the SAR.

The inspectors reviewed engineering calculation ARC-991, ASME VIII Pressure Vessel Design Calculation for the Autoclave Quality Level – QL1, to determine whether design calculations for pressure boundary integrity were in accordance with the general and specific requirements of ASME Boiler and Pressure Vessel Code (BPVC), Section VIII, Division 1, including requirements for lethal service.

The inspectors reviewed commercial grade dedication plan CGDP-010-0047, Pressure Vessel, Stillage, Skid & Pipe Train Assembly, for AC4 and AC5 purchased from Scholz Maschinenbau GmbH & Co.KB. This CGDP was related to the safety functions identified in IROFS 10 and IROFS 28 which include design features to maintain Autoclave leak tight integrity. The inspectors performed equipment walkdowns and reviewed records associated with the installed mechanical components. The inspectors' review included:

- equipment walkdowns to verify installed conditions met applicable specifications, location, and acceptance criteria;
- vendor drawings and M&TE records to determine if dimensions documented in surveillance reports and the CGDP met acceptance criteria;
- hydrostatic pressure test records and ASME Form U-1A Manufacturer's Data Reports to ensure ASME BPVC, Section VIII, Division 1 requirements were met;
- pressure vessel material and weld filler material Certified Material Test Reports (CMTRs) to determine if the chemical and mechanical requirements of ASME BPVC, Section II were met;
- weld drawings to verify a sample of final welds met the correct size and configuration;
- ultrasonic and hardness test reports to determine if material met required mechanical properties and dimensions;
- leak test maintenance work orders; and
- event reports and engineering change requests to verify nonconforming conditions were identified, evaluated, and controlled in accordance with approved procedures

The inspectors reviewed CGDP-010-0026, ASC and Scholz Autoclave Door Seals. This CGDP related to the ability of the AC4 and AC5 o-ring door seal to provide a pressure boundary seal. The critical characteristics (CCs) identified in the CGDP required verification of critical dimensions, material type, and material hardness. The inspectors reviewed associated receipt inspection plans, receipt inspection reports, and CMTRs. The inspectors verified the licensee adhered to the receipt inspection procedures identified in the QAPD. The inspectors reviewed records confirming that required material characteristics and other specification requirements were met.

The inspectors reviewed CGDP-010-0054, Scholz Autoclave Penetration Seals. This CGDP related to the leak tight integrity of Scholz and Douglas electrical seal penetrations. The CCs identified in the CGDP required verification of critical dimensions, material type, and leak tightness test. The inspectors reviewed associated receipt inspection plans, receipt inspection reports, and CMTRs. The inspectors reviewed the leak test work orders performed to support this CGDP. The inspectors also reviewed ER 2014-554, which related to the calibration methods used during receipt inspections of the Douglas electrical seal penetrations. The licensee's evaluations were reviewed, as well as corrective actions, and associated calibration certificates.

The inspectors reviewed a sample of QL-1 work plans related to the installation of Autoclaves 4 and 5. The inspectors verified that special processes were controlled in accordance with the approved QAPD. The inspectors verified that the installation was performed in accordance with the approved work plans, designs, and specifications and that installation requirements such as proper location, placement, orientation, torquing of bolts, and hold points were observed and met. When welding was performed, the inspectors verified welder performance qualification records and continuity logs. The inspectors reviewed weld data cards and weld maps and compared these with final welded conditions.

b. Conclusion

No violations of NRC requirements were identified.

4. Quality Assurance: Problem Identification, Resolution, and Corrective Action (Construction, Pre-Licensing and Operation) (IP 88110)

a. Inspection Scope and Observations

The inspectors reviewed a sample of event reports (ERs) related to activities involving Autoclaves 4 and 5. The inspectors determined that the licensee was identifying and correcting conditions adverse to quality in accordance with the licensee's QAPD. The inspectors verified that the licensee reports to management the results of reviews conducted on corrective action reports and initiates corrective actions as necessary. The inspectors reviewed supporting evaluations and documentation associated with the sample of event reports.

b. Conclusion

No violations of NRC requirements were identified.

D. Exit Meeting

The inspection scope and results were presented to members of the licensee's staff at various meetings throughout the inspection period and were summarized on May 7, May 12, May 15, May 16, and June 17, 2015, with Jay Laughlin, management, and staff. No dissenting comments were received from the licensee. Proprietary information was discussed, but not included in the report. Formal exit meetings were not held for the operational safety reviews of Cascades 5.5 through 5.8. The results of the operational safety reviews of Autoclaves 4 and 5 and Cascades 5.5 through 5.8 were communicated in the authorization letters associated with each operational safety review.



## **SUPPLEMENTARY INFORMATION**

### **1. KEY POINTS OF CONTACT**

<u>Name</u>	<u>Title</u>
J. Blackshear	Work Control Manager
M. Conaley	ISA/NCS Engineering Manager
S. Cowne	Head of Compliance
A. Johnson	Licensing and CAP manager
I. Korbitz	Operations Support C&A Supervisor
P. Larskolsint	Logistics Manager
J. Laughlin	Head of Operations and Chief Nuclear Officer
D. Lemmons	Supervisor – Core Equipment Engineering
P. Lorskulsint	Logistics Manager
S. Magill	Maintenance Manager
R. Medina	Licensing Engineer
K. Miller	Systems Engineering Supervisor
J. Muth	Recycling Manager
R. Page	Plant Projects Manager
C. Pantoya	Electrical Maintenance Supervisor
J. Rickman	Licensing Engineer
S. Scott	Plant Engineering Manager
R. Shaffer	Shift Operations Manager
R. Shelton	M&TE Manager
C. Slama	Licensing Project Manager
O. Torres	QA Supervisor
B. Wood	Maintenance Support Supervisor

Other licensee employees contacted included chemists, engineers, technicians, production staff, and office personnel.

### **2. LIST OF ITEMS OPENED, CLOSED, AND DISCUSSED**

#### Discussed

70-3103/2014-005-01      URI      Criteria for Changes to Licensing Basis Documents  
(Section D.1)

### **3. INSPECTION PROCEDURES USED**

IP 88015, Nuclear Criticality Safety Program  
IP 88016, Nuclear Criticality Safety Evaluation and Analyses  
IP 88017, Criticality Alarm Systems  
IP 88020, Operational Safety  
IP 88025, Maintenance and Surveillance of Safety Controls  
IP 88070, Plant Modifications  
IP 88110, Quality Assurance: Problem Identification, Resolution, and Corrective Action  
(Construction, Pre-Licensing and Operation)  
IP 88136, Mechanical Components  
IP 88140, Instrumentation and Control Systems

#### 4. **DOCUMENTS REVIEWED**

##### Records:

Purchase Order 4500049500

Receipt Inspection Plan for P.O. 4500049500

Purchase Requisition 1000055383

Training Records for Senior Container Handler, QC Inspector, and PCES Maintenance Sr. Craft

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 CA-3-1000-01, Performance Improvement Program, Rev. 33  
 EG-3-3100-06, Integrated Safety Analysis Process, Rev. 12  
 EG-3-4200-03, Preparation and Control of Engineering Calculations, Rev. 6  
 EG-3-5200-01, IROFS27e Structural Inspection Surveillance, Rev. 8  
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 MA-3-1000-01, Preventative Maintenance Implementation and Change Process (SAP Order Type PM2) (QL-3 only), Rev. 8  
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 MA-3-1000-18, Calibration of Torque Wrenches  
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ORM 3600-31, Maintain Subcritical Geometry of Product Cylinders, Rev. 1

NEF-BD-10, Design Features to Maintain Product Liquid Sampling Autoclave Leak Tight Integrity, Rev. 4

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NEF-BD-36c, Limit Cylinder Mover to Electric or Diesel with < 280L Fuel Load, Rev. 6

NEF-BD-38, Limit Cylinder Fill Mass to Ensure Cylinder Integrity Once Per Shift, Rev. 6

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Maschinenbau SCHOLZ GmbH & Co KG, 252891/2200.4b, Axle Journal

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Maschinenbau SCHOLZ GmbH & Co KG, 253286/701.3c, Adapter Plates  
 Maschinenbau SCHOLZ GmbH & Co KG, 253288/701.3b, Jack Head with Journal  
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