



January 09, 2020
ACO 20-0001

ATTN: Document Control Desk
Mr. John W. Lubinski, Director
Office of Nuclear Material Safety and Safeguards
U.S. Nuclear Regulatory Commission
Washington, D.C. 20555-0001

**American Centrifuge Plant and American Centrifuge Lead Cascade Facility
Docket Numbers 70-7004 and 70-7003; License Numbers SNM-2011 and SNM-7003**

Annual Summary Report of Facility Changes

Dear Mr. Lubinski:

In accordance with 10 *Code of Federal Regulations* (CFR) 70.72(d)(2) and Nuclear Regulatory Commission Materials License Conditions 16.c.ii (SNM-7003) and 24.c.ii (SNM-2011), American Centrifuge Operating, LLC (ACO) hereby submits a brief summary of the changes required by 10 CFR 70.62(a)(2) for facility changes made during calendar year 2019.

Enclosure 1 provides the summary of facility changes for both the American Centrifuge Lead Cascade Facility and American Centrifuge Plant. The non-consecutive change evaluation numbering in the enclosure is a result of cancelled evaluations.

If you have any questions regarding this matter, please contact me at (740) 897-3859.

Sincerely,

Kelly L. Wiehle
Regulatory Manager

Enclosure: As Stated

MOD4
NMSS20

Mr. John W. Lubinski
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cc:

Y. Faraz, NRC HQ
L. Pitts, NRC Region II
D. Tiktinski, NRC HQ
R. Womack, NRC Region II

Enclosure 1 to ACO 20-0001

**Summary of Facility Changes for the American Centrifuge Lead Cascade Facility
and American Centrifuge Plant for Calendar Year 2019**

**Information Contained Within
Does Not Contain
Export Controlled Information**

Reviewing

Official: #1014, ACO

Date: 1/9/20

**2019 Brief Summary of Changes for the American Centrifuge Lead Cascade Facility (LCF) and
American Centrifuge Plant (ACP)**

| FCE Number PCE Number | Rev. | | Approval Date | Change to SSC? | Documents Modified Due to Change | ISA Summary Update Required? | Reason NRC Preapproval Not Required/Comments |
|----------------------------|--------|---|------------------|-------------------|-------------------------------------|---------------------------------------|---|
| FCE 19-0001 PCE 19-0001 | 0 0 | Title: Revision to 331-06-161, American Centrifuge Program Operations Security Plan and Appointment Letter for OPSEC Coordinator Description of Change: Revised the OPSEC Plan to add references to the Engineering, Procurement, and Construction activities associated with the new DOE High Assay Low Enriched Uranium (HALEU) Demonstration Program as well as made grammatical, editorial, and formatting changes. Reason for the Change: Conducted annual assessment of the OPSEC Plan to meet the requirements provided in the Security Program. | 12/19/2019 | No | 331-06-161 Rev 9 | No | NRC Preapproval Required. |
| FCE 19-0002 N/A | 0 0 | Title: Revision to FBP Procedure FBP-EM-PRO-00040, Request for Helicopter Ambulance Service Description of Change: Revised the procedure to remove the title of Plant Medical Director, updated Appendix A, and added new Appendices B and C. Reason for the Change: Clarify requirements for landing zones and mutual aid locations. | 4/25/2019 | No | FBP-EM-PRO-00040 Rev 5 | No | None of the criteria listed in 10 CFR 70.72(c) are met. |
| FCE 19-0003 N/A | 0 0 | Title: Revision to FBP Procedure FBP-EM-PRO-00041, Criticality and Radiation Emergencies Description of Change: Revised the procedure to modify the Immediate Evacuation Zone distance from an affected radiation area from 200 feet to 180 feet. Reason for the Change: Clarify procedure requirement to comply with DOE approved Technical Safety Requirements. | 5/22/2019 | No | FBP-EM-PRO-00041 Rev 2 | No | None of the criteria listed in 10 CFR 70.72(c) are met. |

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|----------------------------|--------|--|------------------|-------------------|-------------------------------------|---------------------------------------|---|
| FCE 19-0004 PCE 19-0002 | 0 0 | Title: Revision to Procedure ACD4-UW-002, Chemical Treatment for the Boilers Description of Change: Revised the procedure to reflect current site operations for the boilers, and made grammatical, editorial, and formatting changes. Reason for the Change: Clarify procedure requirements. | 6/5/2019 | No | ACD4-UW-002 Chg 4 | No | None of the criteria listed in 10 CFR 70.72(c) are met. |
| FCE 19-0005 PCE 19-0003 | 0 0 | Title: Revision to Procedure ACD4-UA-004, X-6000 Dew Point Monitoring System Operation Description of Change: Revised the procedure to remove portions pertaining to the Water Boy portable dewpoint monitor which is no longer in use. Reason for the Change: Clarify procedure requirements. | 6/17/2019 | No | ACD4-UA-004 Chg 7 | No | None of the criteria listed in 10 CFR 70.72(c) are met. |
| FCE 19-0006 N/A | 0 0 | Title: Revision to FBP Procedure FBP-EM-PRO-00036, Development, Maintenance, and Inspection of Facility Emergency Packets and Emergency Action Plans Description of Change: Revised the procedure to combine surveillances, eliminate the requirement to revise a Facility Emergency Packets or Emergency Action Plan when no requirement modifications are required, eliminate redundant responsibilities for records management/document control, delete a use reference, delete Appendix C; and made grammatical, editorial, and formatting changes. Reason for the Change: Clarify procedure requirements to comply with DOE Order 151.1D. | 6/25/2019 | No | FBP-EM-PRO-00036 Rev 6 | No | None of the criteria listed in 10 CFR 70.72(c) are met. |

| FCE Number PCE Number | Rev. | | Approval Date | Change to SSC? | Documents Modified Due to Change | ISA Summary Update Required? | Reason NRC Preapproval Not Required/Comments |
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| FCE 19-0007 N/A | 0 0 | Title: Revision to FBP Procedure FBP-EM-PRO-00059, Portsmouth Gaseous Diffusion Plant (PORTS) Response to Security Threat Level Changes Description of Change: Revised the procedure to update the responsibilities and actions for the Plant Shift Superintendent, Crisis Manager, and X-300 Console Operator; added a new Attachment A to show the format for a Security Condition (SECON) Emergency Notification; and made grammatical, editorial, and formatting changes. Reason for the Change: Clarify procedure requirements to comply with company expectations. | 8/8/2019 | No | FBP-EM-PRO-00059 Rev 2 | No | None of the criteria listed in 10 CFR 70.72(c) are met. |
| FCE 19-0008 PCE 19-0004 | 0 0 | Title: New Procedure ACD2-MM-005, Government Property Management Description of Change: New procedure provides guidance for establishing and maintaining control of Government Property through an effective Property Management System to ensure adequate life-cycle management of Government Furnished and Funded Property. Reason for the Change: To implement and comply with requirements of the DOE HALEU Contract, Section H.4. | 9/23/2019 | No | ACD2-MM-005 Chg 0 | No | None of the criteria listed in 10 CFR 70.72(c) are met. |
| FCE 19-0009 PCE 19-0005 | 0 0 | Title: Engineering Service Order ESO-2101-0110, X-3001 High Bay Lighting Transformer Modification Description of Change: This Engineering Service Order adds a new isolation transformer that will supply the correct voltage to the X-3001 Trains 3 and 4 high bay lights. With the addition of the isolation transformer, another means of isolating the circuit on the supply side of the transformer became necessary. To achieve this, a secondary breaker was added into the circuit on the supply side of the isolation transformer. Reason for the Change: This addition was required due to the transformer and breaker not being properly scoped and installed as part of a previous project that changed out the Motor Control Center from a 4-wire to 3-wire configuration. | 9/18/2019 | Yes | ESO-2101-0110 Rev 0 | No | None of the criteria listed in 10 CFR 70.72(c) are met. |

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| FCE 19-0010 PCE 19-0006 | 0 0 | Title: Statement of Work SOW-2518-001, ACP Temporary Fuel Station Description of Change: The proposed change is to extend the time of expected operation for the temporary satellite fuel station for an additional 24-months with an expiration date of September 30, 2021. The fuel station consists of a 1,000 gallon fuel storage tank west of the X-7725A on the west side of Plover Avenue. The tank consists of two internal 500 gallon tanks; one for gasoline and one for diesel fuel. The installation was in accordance with SOW-2518-0011, Rev. 0 and its supporting documentation. The installation is not being affected by this change. Reason for the Change: The temporary satellite fuel station is used to provide fueling services to site located equipment and vehicles that support ACP activities. This service eliminated ACP dependence on the former gaseous diffusion plant/FBP fuel pumps and provided the ACP with a more cost efficient method for fueling/re-fueling support equipment and vehicles. | 9/24/2019 | Yes | SOW-2518-0011 Rev 0 | No | None of the criteria listed in 10 CFR 70.72(c) are met. |
| FCE 19-0011 PCE 19-0007 | 0 0 | Title: Deletion of Assistant Plant Shift Superintendent (APSS) from Emergency Response Organization and Cancellation of USEC-02 Emergency Plan Description of Change: Revised the current Emergency Response Organization roles and responsibilities to remove the Assistant Plant Shift Superintendent position and reassign duties to the PSS, with On-Scene Command responsibilities being reassigned to the Fire Commander at the scene. Additionally, revised Chapter 8.0 of the Lead Cascade License Application to remove the requirement to maintain an emergency plan (USEC-02) and corresponding Emergency Plan Implementing Procedures. Reason for the Change: Changes made to conform to DOE's direction to delete the Assistant Plant Shift Superintendent from the minimum staffing Technical Safety Requirements and from the Emergency Response Organization, as well as to transition to a three-tier classification system under a site Emergency Plan to fully comply with DOE Order 151.1D. | 10/17/2019 | No | LA-2605-0001 Chapters 2, 7, 8, and USEC-02 Emergency Plan | No | NRC Preapproval Required. |

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| FCE 19-0012 PCE 19-0008 | 0 0 | Title: Revision to Procedure ACD2-TP-002, Training Program Description of Change: Revised procedure to update the method for Functional Organization Managers to determine required training using Excel spreadsheets downloaded from the now shutdown Actuate reporting system; added Attachment E to provide the file locations and what information is contained in the Excel files; and made grammatical, editorial, and formatting changes. Reason for the Change: Clarify procedure requirements based upon the Actuate reporting system being shut down when Centrus transitioned to the cloud for network program access. | 10/24/2019 | No | ACD2-TP-002 Chg 21 | No | None of the criteria listed in 10 CFR 70.72(c) are met. |
| FCE 19-0013 PCE 19-0009 | 0 0 | Title: Engineering Service Order ESO-2303-0052, X-7726 Centrifuge Training and Test Facility Permanent Ground Fault Interrupter Description of Change: The Engineering Service Order adds a permanent ground fault interrupter in the 480V circuit inside the X-7726 (first floor) where power is connected. Reason for the Change: This change is required to avoid any potential injury or loss of life based upon lessons learned from a near miss accident at our TMC facility in Oak Ridge, Tennessee that resulted from a fault in a similar 480V power hookup to a delivery trailer. | 10/28/2019 | Yes | ESO-2303-0052 Rev 0 | No | None of the criteria listed in 10 CFR 70.72(c) are met. |
| FCE 19-0014 PCE 19-0010 | 0 0 | Title: Engineering Service Order ESO-2501-0024, Install Antenna and Repeater Description of Change: This Engineering Service Order upgrades and modifies the Security Access Control and Alarm System which involves the relocation of the Central Alarm Station as well as the relocation and upgrade of the corresponding radio system. Reason for the Change: To ensure necessary controls are in place for the HALEU Demonstration Program. | 11/5/2019 | Yes | ESO-2501-0024 Rev 0 | No | None of the criteria listed in 10 CFR 70.72(c) are met. |

| FCE Number PCE Number | Rev. | | Approval Date | Change to SSC? | Documents Modified Due to Change | ISA Summary Update Required? | Reason NRC Preapproval Not Required/Comments |
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| N/A PCE 19-0013 | 0 | Title: NCS Code Validation of SCALE 6.2.3 and Cross Section Set v7-252 for Keff Calculations Description of Change: The engineering evaluation (EE-3101-0013) supports the validation of the SCALE 6.2.3 code system to determine bias and bias uncertainty for use in determining the upper subcritical limit which revises the margin of subcriticality for the plant. Reason for the Change: The ACP License Application is being revised to support its license amendment request for the HALEU Demonstration Program. This effort includes updating the NCS validation report and associated NCS program commitments in the license application based on the updated NCS validation report. | 12/3/2019 | Yes | EE-3101-0013 Rev 0 | No | NRC Preapproval Required. |