

7/8-SC3

**B BUNGE CORPORATION (INDIANA)**

R. R. 2 BOX 113  
LOGANSPOUT, INDIANA 46947

April 22, 1980

John W. Cooper, Ph.D., Chief  
Regional Licensing Section  
Material Licensing Branch  
Division of Fuel Cycle & Material Safety

Dear Dr. Cooper:

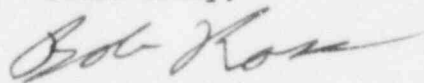
In regards to your letter dated February 14, 1980, and the follow-up letter dated April 1, 1980, concerning our application for a By-product Material License (Control #02844):

Item 1 - The gauge is mounted on a hopper on top of a vessel. Entrance to this hopper would be impossible during normal operation. However, it is possible (although extremely difficult) for someone to enter the hopper from the vessel during a maintenance shutdown situation. To insure employee safety we have developed the attached procedure to lock out the source before vessel entry. I am also enclosing a copy of our normal vessel entry permit procedure.

Item 2 - All relocation, maintenance, repair, or disposal of the gauge will be done by Texas Nuclear in Austin, Texas.

Don McCain, who originally filed the permit application, is no longer with Bunge Corporation (Indiana). Bob Ross has filled Don's position and he will directly supervise the use of the byproduct material.

Yours truly,



Bob Ross  
Operations Manager

nh

Enc: 2

cc: Brian Peterson  
Dick Farmer  
Conrad Ihrie  
Bob Seaton  
Bill Shepler  
Jim Isley

8008110061

lepp.

APR 25 1980



MEMORANDUM

TO: All Superintendents

DATE: April 18, 1980

FROM: Bob Ross

SUBJECT: LOCK-OUT PROCEDURE FOR TEXAS NUCLEAR SEALED SOURCE DEVICE  
LOCATED IN THE EXTRACTION FEED HOPPER

In order to use our Texas Nuclear device which regulates the extractor speed according to the rate of flakes entering the extractor feed hopper, we must have a permit from the Atomic Energy Commission. One of the purposes of requiring a permit is to insure that the user is aware of all the safety precautions necessary in using these devices.

Periodically the permit must be renewed. As part of the renewal process, we have been asked for a lock out procedure to insure that no one will be exposed to radiation by entering the extractor feed hopper while the source is open.

Therefore, effective April 18, 1980, and to continue in effect until further notice from the Operations Manager, the following procedure will be used before anyone enters the extractor or extractor feed hopper.

1. The Operations Superintendent will lock out the extractor.
2. The Operations Superintendent will close the source shield and lock it shut.
3. A confined vessel entry permit will be made out and signed by the Operations Manager as per the Bunge Corporation Safety Department Procedures.

If you have any questions or comments concerning this procedure, please see me.

  
Bob Ross



# SAFETY PROCEDURES BUNGE CORPORATION

## Vessel Entry

### Purpose

The purpose of this procedure is to outline minimum requirements for entry and working in a closed chamber or confined space. It is designed to protect a person from such hazards as oxygen deficiency and hazardous gases.

### I. General

1. A closed vessel shall be any chamber or confined space with limited access which presents a hazard to personnel.  
Examples:
  - a. Extractor, DT, tanks, tank cars, hoppers, etc.
  - b. Equipment with any moving internal devices.
  - c. Moving equipment such as a dryer cooler, bean conditioner.
2. The operating procedures of each plant shall include a list of closed vessels.
3. A vessel entry permit shall be completed prior to entry. Any emergency condition such as a hexane release, fire alarm, etc., cancels the permit and personnel shall leave the vessel.
4. The vessel entry permit shall be posted near the vessel entry point. Completed permits shall be retained in the plant's safety file.
5. Permits are stocked in the Operational Standards and Compliance Division - Safety Department.

### II. Specific Rules and Instructions for Vessel Entry Permit (numbered items correspond to those on permit form) (Appendix A)

1. Isolate the vessel by disconnecting all lines. If disconnecting cannot be done, alternate means of isolation shall be shown on the permit.
2. The vessel shall be taken out of service by following the Company Lockout (Safety Procedure F-2).



## SAFETY PROCEDURES BUNGE CORPORATION

### Vessel Entry

3. Clean (purge) the vessel of all hazardous materials and empty all liquids.
4. Provide breathable atmosphere in the vessel. If natural draft from removal of manholes is not adequate, forced ventilation shall be applied. Note: Do not blow plant compressed air into chamber.
5. The atmosphere in the vessel shall be checked prior to entry and every hour thereafter. Respiratory equipment shall be worn in oxygen deficient atmosphere. (Safety Procedure E-3)

<u>Test</u>	<u>Limit</u>
Oxygen	18% (Volume) Minimum
Flammable Gases	0% Maximum Explosimeter

6. A safety harness or safety belt shall be worn. Lanyards shall be kept available at all times.

If a ladder is required for entry, it shall remain securely in place while work is being performed.

7. Respiratory equipment shall be provided for each employee entering vessel.
8. Lighting inside vessel shall be limited to:
  - a. Dry cell flashlight (Class I Group D)
  - b. Lo-Volt light.

Receptacles and disconnects shall remain outside vessel.

9. All additional safety equipment and clothing shall be specified for special conditions and jobs.
10. A safety man equipped with a self-contained breathing mask and flashlight shall be required at point used by employees to enter vessel.



## SAFETY PROCEDURES BUNGE CORPORATION

### Vessel Entry

11. A back-up safety man shall be designated and shall be immediately available by:
  - a. Verbal contact.
  - b. Alarm device such as a freon horn.

When respiratory equipment is required due to lack of oxygen in vessel, the back-up man shall be within verbal distance only.

12. Exceptions to the procedure shall be noted. Every effort shall be made to prepare a vessel in accordance with the procedure and avoid exceptions.
13. The permit shall be approved by the Operations Manager or designate.
14. Employees entering the vessel, the safety man and back-up man shall sign the permit.



# SAFETY PROCEDURES BUNGE CORPORATION

## Appendix A

Bunge Corporation  
SPD-Plants

### Vessel Entry Permit

Effective

Date \_\_\_\_\_

Time \_\_\_\_\_

Vessel To Be Entered? \_\_\_\_\_

Description of Work \_\_\_\_\_

1. How was vessel isolated? \_\_\_\_\_

2. Vessel Locked Out? (Safety Procedure F-2) \_\_\_\_\_

3. How Was Vessel Cleaned? (Purged) \_\_\_\_\_

4. Adequate Ventilation? \_\_\_\_\_ How Provided? \_\_\_\_\_

5. Atmospheric Tests: (Repeat Every Hour)

Time

Oxygen

Explosimeter

Initials

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6. Safety Harness or Belt? \_\_\_\_\_ Lanyard Attached? \_\_\_\_\_ Ladder? \_\_\_\_\_

7. Respiratory Equipment for Employee(s)? \_\_\_\_\_ Safety Man? \_\_\_\_\_

8. Type Lighting? \_\_\_\_\_ Electrical Equipment? \_\_\_\_\_

9. Other Safety Equipment \_\_\_\_\_

10. Safety Man-Flashlight? \_\_\_\_\_ Type Warning Device \_\_\_\_\_

11. Number of Men-In Vessel? \_\_\_\_\_ Vessel \_\_\_\_\_ Back-up \_\_\_\_\_

12. Exception to Procedure \_\_\_\_\_

13. I have physically inspected this vessel and am satisfied that it is safe for entry.

Approved: \_\_\_\_\_

Operations Manager or Designate

\_\_\_\_\_  
Date

14.

Employee(s) Entering

Safety Man

\_\_\_\_\_  
Back-up Man