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NOTE: All WTP Interface Partner concurrence signatures found on the following page shall be obtained prior to approval of this ICD.

Approved by:

Mark Braccia

Print Name

Signature

ICD 14 Team Lead and Principal Author

Issue Status: Approved



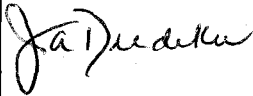

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NOTE: This document defines current service needs, future needs, and service gaps. The identified service levels do not represent contractual obligations between service recipient and providers. Future contractual and funding actions to close service gaps will be accomplished by integration between the federal offices as part of the budget planning process.

WTP Interface Partner Concurrence

Interface Owners (IOs) including DOE-ORP and DOE-RL when appropriate, will sign ICD concurrence sheets indicating their concurrence with the ICD contents. These concurrence signatures signify that the ICD accurately reflects current contract baselines, except as indicated in Appendix A, Open ICD Issues and Actions. This ICD shall not be approved until all concurrence signatures on this page have been obtained.

Organization	Position	Name	Signature	Date
WTP	ICD 14 Interface Owner	Ray Patterson		10/9/12
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NOTE: This document defines current service needs, future needs, and service gaps. The identified service levels do not represent contractual obligations between service recipient and providers. Future contractual and funding actions to close service gaps will be accomplished by integration between the federal offices as part of the budget planning process.

History Sheet

Rev	Date	Reason for revision	Revised by
A	16 Jul 2001	Issued for ORP Concurrence	A Kruger
0	14 Mar 2002	Provided for ORP Contracting Officer to Issue as Operative ICD. Upon issuance, this document will supersede BNFL-5193-ID-14 Revision 6.	A Kruger
1	15 Nov 2002	Provided for ORP Contracting Officer to issue as Operative ICDs.	A Kruger
2	15 Nov 2003	Annual update. Incorporated ICFs: 24590-WTP-ICF-ENG-02-005, Establishment of IHLW Transportation Cask Lid Critical Dimensions in Support of WTP Procurement Actions; 24590-WTP-ICF-ENG-03-002, Establishment of IHLW Transportation Cask Critical Dimension in Support of WTP Construction Activity; 24590-WTP-ICF-ENG-03-004, IHLW Canister Receipt/Retrieval Throughput; 24590-WTP-ICF-ENG-03-005, IHLW Canister Design Basis for TOC Projects Contact Dose Rates.	A Kruger
3		<p>Periodic update. Transitioned tracking of all Issues and Action Items to the Action Tracking System (ATS) as follows:</p> <p>Issue I14-31 → 24590-WTP-ATS-QAIS-07-852, Resolve contractual inconsistencies regarding IHLW Acceptance defined in the WTP and TFC contracts</p> <p>Issue I14-32 → 24590-WTP-ATS-QAIS-07-852, Resolve contractual inconsistencies regarding IHLW Acceptance defined in the WTP and TFC contracts</p> <p>Action A14-1 → 24590-WTP-ATS-QAIS-07-783, IHLW transportation cask delivery and pickup schedule</p> <p>Action A14-2 → 24590-WTP-ATS-QAIS-07-784, IHLW product transfer procedures and protocols</p> <p>Action A14-3 → 24590-WTP-ATS-QAIS-07-820, IHLW product sample protocol</p> <p>Action A14-4 → 24590-WTP-ATS-QAIS-07-787, Handling equipment information</p>	M Braccia

Revision Description

ICD Section	Description
Cover Sheet	Added Contract Deliverable Number in accordance with 24590-WTP-GPP-MGT-003, Rev 2, Interface Control Procedure, Appendix A, Interface Control Document Format.
Table 1, Item 5, DOE Col	Due to the transition of all ICD Action Items and Issues to the Action Tracking System (ATS), Deleted the following:
Sect 2.1	- Note from Section 1.2
Sect 2.2.1	- Former Section 5, Issues
Sect 2.3.3	- Appendix A Closed Issues
Sect 5	- Appendix B Out-Year Action Items
App A & B	
Sect 1.1 & Throughout	Changed all references to "on-site interim storage facilities" and "canister storage building" to "Interim Hanford Storage" facility and all references to "ISF" to "IHS" to reflect current plan.
Sect 1.1	Provided clarification for the term IHLW and deleted phrase that stated that the DOE would accept the IHLW.
Sect 1.1	Added the following to the second paragraph, first sentence, "and the Washington Dangerous Waste Regulations at WAC 173-303". Also provided clarification by splitting the second sentence into two separate sentences.
Sect 1.1 & 3	Added the following sentence to the second paragraph, "WTP will implement DOE O 435.1 in accordance with 24590-WTP-PL-MG-03-002, DOE Order 435.1 Implementation Plan (BNI 2003e)." Added 24590-WTP-PL-MG-03-002, DOE Order 435.1 Implementation Plan to the References Section.
Sect 1.1	Deleted the following sentence from the third paragraph because it was redundant to Section 2.1, "The physical interface is the truck entrance into the WTP facility and the transportation cask containing the IHLW canister."
Sect 1.1	Inserted the following as new fourth paragraph for clarity, "This ICD addresses the physical interfaces related to the IHLW product for transport and disposal. The administrative interface addressed by this ICD is limited to the documentation necessary to ship the IHLW from WTP to the IHS. This ICD does not address IHLW production documentation beyond what is required for transport and acceptance of the IHLW product at the IHS and the national repository."
Sect 1.2	Deleted the following text referring to bolded words in Table, "The bold words represent items controlled by DOE-ORP. Any modification to the bold words requires the specific approval of the DOE-ORP contracting officer" because the contracting officer no longer signs the document. Also deleted the bold feature from all text in Table 1.
Sect 1.2 Table 1	Added the following to Table 1, Row 2, Column 2, "The TOC will prepare, submit and get approval for a permit from the State of WA., Dept. of Ecology to store the HLW, as a co-operator, per WAC 173-303."
Sect 1.2 Table 1	Provided clarification in Table 1, Row 2, Column 3 that, "DOE will be the owner and co-operator on the facility permit for the IHS, per WAC 173-303".
Sect 1.2 Table 1	Added the following statement to Table 1, Row 3, DOE column: "Provide required IHLW documentation to TOC for storage."
Sect 1.2 Table 1	Deleted TOC Activity IDs to limit call-out of specific TOC activity ID #s to Section 2.3, Interface Schedule.
Sect 1.2 Table 1	Deleted former row 7 for DOE-requested samples because it was deleted from the WTP Contract.

Revision Description

ICD Section	Description
Sect 1.2 Table 1	Added new row 8 for TOC to develop the on-site transportation authorization documents for IHLW product, WTP to provide needed information to produce these documents, and DOE to review and approve the documents.
Sect 1.2 Table 1, Row 9 & Sect 2.2.1, Item 9 & Figure 1	Added Ecology to the list of organizations that will be notified if a non-conforming IHLW product is identified.
Throughout & Sect 2	Deleted reference to Issue 14-31 and added a statement in Section 2 that work scope to accommodate rejected canisters needs to be identified and directed to appropriate Contractors.
Sect 2.1	<p>First paragraph, provided clarification as to the precise physical interface point as follows: “The physical interface occurs in the IHLW Canister Export Truck Bay when the transport trailer loaded with the transportation cask containing the IHLW canister is engaged by the TOC provided transport tractor.”</p> <p>Deleted the following sentence, “The transfer of an IHLW canister into the TOC supplied transportation cask will be in the WTP HLW facility cask-handling tunnel” since it is not directly pertinent to the physical interface.</p>
Sect 2.1	Added the following sentence in order to provide a trail to the pertinent ATS Item, “See 24590 WTP ATS-QAIS-07-0787, ICD-14 Action A14-04, Handling Equipment Information.”
Sect 2.1	Third paragraph, updated information regarding TOC development of the IHS as Project T3W14 to replace Project W464. Deleted the following statement because it was meaningless, “The WTP final design efforts ended in July 2002.”
Sect 2.1.1	Updated HLW canister design drawings.
Sect 2.1.3	<p>Modified bulleted statement for WTP calculation 24590-HLW-ZOC-30-00011 to state that the calculation determines dose rates using project ‘nominal’ source terms and as such cannot be used for personnel dose determinations, but it is acceptable for equipment dose. Deleted the following sentence: “This calculation (and future revisions) may be used by TOC projects as an input to the design basis for facilities that support IHLW transportation and storage.”</p> <p>Added the following statement under the “Transportation cask” bullet: PIER No. 24590-WTP-PIER-MGT-12-0230-D, Rev. 0, Action 6, states “Based on results of action 5 [Therefore, the current road design does not allow sufficient clearance under the pipe rack for the HLW canisters to exit the building.], re-work road or increase height of pipe rack.” Since TOC is responsible for transporter design, close coordination between TOC and WTP is necessary in order to set appropriate road to utility rack clearance (See Open Item 0004). Also added new Open Item 004, “Close coordination between TOC and WTP is necessary in order to set appropriate road to utility rack clearance on the exit side of the HLW Driveway. (See 24590-WTP-PIER-MGT-12-0230-D, Rev. 0)”</p> <p>Added the following bulleted statement: “The WTP calculation 24590-HLW-ZOC-30-00016, Rev B, incorporates the latest project source terms to ensure that the bulk shielding at the WTP HLW Vitriification Facility provides adequate shielding to comply with ALARA principles and with the Radiological Area Classification scheme. The conclusion of this calculation is that the maximum bulk shielding required in the HLW facility is 47 inches of concrete, which is needed in areas where multiple glass canisters are handled/stored.”</p> <p>Modified the fifth bulleted statement of the second set of bullets to read as follows:</p> <ul style="list-style-type: none"> • Regarding the IHLW canister, the WTP Contract states, “The maximum heat generation rate for any single canister shall not exceed 1500 watts per canister when delivered to DOE.” Nonetheless, the IHS will be designed for a maximum individual canister heat load of 600 watts (RPP-23674) consistent with the direction from DOE-ORP to TOC. This is based on a projected actual canister maximum heat load of 525 watts, as described in CCN 064648. Furthermore, analyses based on recent WTP and TOC calculations (SVF-2432, IHS Source Term, 2012,

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ICD Section	Description
Sect 2.1.3 cont.	Washington River Protection Solutions) indicate the projected actual canister heat load will not exceed 250 watts. Deleted last sentence in Section 2.1.3 because it was meaningless (The diligence to these values is exercised by the verification activities by ICD Action Team at each revision of the DRD.)
2.2	Second paragraph, first sentence, added the words, "...or other transportation documentation..." to account for other required shipping documentation other than the shipping manifest.
2.2	Second paragraph, modified to reflect the fact that de-listing (IHLW) must be negotiated with Ecology.
Sect 2.2.1, Fig 1	Removed all information pertaining to IHLW sampling, because it was removed from the contract. Clarified flowpath of non-conforming items.
2.2.2	Deleted the following text: "This requires a maximum time of 12 days for DOE interim acceptance of the waste product canister. Canisters will be picked up within 1 day (24 hours) following ORP notification of interim acceptance." because it is no longer relevant or accurate. Updated entire section based on current references.
2.3	Added the following Note: NOTE: What is reflected here is current baseline. The WTP contractor has been directed to re-baseline and re-plan. All milestones will be updated accordingly.
Sect 2.4	Deleted last sentence in Section 2.4, "An incompatibility may exist in the surface contamination limits from the contractually imposed guidance documents" because it is no longer true.
Sect 2.7, Table 2	Moved the following two entries: IHLW Transportation Cask (BNI 2001d, Attachment 1) Transportation Cask Yoke (BNI 2001d, Attachment 1) from Interfacing Organization Drawings to WTP Documents because even though the attachments are drawings of TOC equipment, they are contained in a BNI document with a CCN number.
Former Sect 3	Deleted former Section 3, Sample Interface Information, because specific sampling information was removed from the Contract. WTP is responsible for having the capability to take IHLW samples, but beyond that there are no WTP IHLW contractual sampling requirements.
Sect 3	Updated the following references: <ul style="list-style-type: none"> • BNI. 2004b. HLW Vitrification Design Proposal Drawing Mechanical Sequence Grapple, 24590 HLW M0-30-00012, Rev 1. 17 May 2004. Bechtel National, Inc., Richland, WA, USA. • BNI. 2004a. Unshielded Dose Rates from Major Components/Tanks at the High Level Waste Facility, 24590-HLW-Z0C-30-00011, Rev C. 23 February 2004. Bechtel National, Inc., Richland, WA, USA. • BNI. 2008. System Description for HLW System HEH Canister Handling, 24590-HLW-3YD HEH-00001, Rev 2. 29 September 2008. Bechtel National, Inc., Richland, WA, USA. • DOE O 460.1B. 2003. Packaging and Transportation Safety. US Department of Energy, Washington, DC, USA. • DOE. 2007. Waste Acceptance System Requirements Document (WASRD), DOE/RW 0351P, Rev 5. US Department Of Energy, Office of Civilian Radioactive Waste Management, Washington, DC, USA. • DOE. 2008. Quality Assurance Requirements and Description for the Office of Civilian Radioactive Waste Management (QARD), DOE/RW 0333P, Rev 20. US Department of Energy, Office of Civilian Radioactive Waste Management, Washington, DC, USA.

Revision Description

ICD Section	Description
Sect 3	<p>Replaced the following reference:</p> <ul style="list-style-type: none"> • BNI. 2003c. IHLW Product Compliance Plan, 24590-WTP-PL-RT-03-002, Rev 0. 15 May 2003. Bechtel National, Inc., Richland, WA, USA. <p>with:</p> <ul style="list-style-type: none"> • BNI. 2009. IHLW Waste Form Compliance Plan for the Hanford Tank Waste Treatment and Immobilization Plant, 24590-HLW-PL-RT-07-0001, Rev 3. 23 June 2009. Bechtel National, Inc., Richland, WA, USA.
Sect 3	<p>Replaced the following references:</p> <ul style="list-style-type: none"> • BNI. 2002k. HLW Detail Test Canister 3/8 Wall, 24590-HLW-M0-30-00001005, Rev 1. 14 November 2002. Bechtel National, Inc., Richland, WA, USA. • BNI. 2002l. HLW Detail Test Canister 3/8 Wall, 24590-HLW-M0-30-00001006, Rev 1. 13 November 2002. Bechtel National, Inc., Richland, WA, USA. <p>with:</p> <ul style="list-style-type: none"> • BNI. 2010a. WTP HLW Canister Assembly Drawing (3/8 in. Wall), 24590-HLW-MX-30-00010001, Rev 0. 23 December 2010. Bechtel National, Inc., Richland, WA, USA. • BNI. 2010b. WTP HLW Canister Detail Drawing (3/8 in. Wall), 24590-HLW-MX-30-00010002, Rev 0. 21 December 2010. Bechtel National, Inc., Richland, WA, USA. • BNI. 2010c. WTP HLW Canister Weldment Drawing (3/8 in. Wall), 24590-HLW-MX-30-00010003, Rev 0. 21 December 2010. Bechtel National, Inc., Richland, WA, USA. • BNI. 2010d. WTP HLW Canister Lid Detail Drawing (3/8 in. Wall), 24590-HLW-MX-30-00010004, Rev 0. 21 December 2010. Bechtel National, Inc., Richland, WA, USA.
Sect 3	<p>Deleted the following references:</p> <ul style="list-style-type: none"> • BNI. 2002a. Analytical Laboratory Design Requirements: WTP Sampling and Analysis Plan, 24590-WTP-PL-PR-01-004, Rev 3.. 24 September 2003. Bechtel National, Inc., Richland, WA, USA. • CH2. 2000. Storage and Disposal Program Product Sampling Support, RPP-6227. 19 July 2000. CH2M HILL Hanford Group, Inc., Richland, WA, USA. <p>because sampling is no longer addressed in this ICD and these references are not called out.</p>
Throughout	<p>Removed (most) references to Project W-464 (CSB) and replaced them with references to Project T3W14 (IHS). Some W-464 references were retained since the associated documents are still called out by the <i>Immobilized High-Level Waste Interim Hanford Storage System Specification</i>, RPP 23674, Rev. 1.</p>
All	<p>Reformatted entire document in accordance with 24590-WTP-GPP-MGT-003, Rev 2, Interface Control Procedure. Rev bars were not used for formatting changes; however, they were used for all changes recorded above.</p>

Acronyms and Abbreviations

ALARA	as low as reasonably achievable
BNFL	British Nuclear Fuels Limited
BNI	Bechtel National, Incorporated
Bq/m ²	becquerels per square meter
CAP	corrective action plan
CFR	<i>Code of Federal Regulations</i>
CH2	CH2M HILL Hanford Group, Inc.
°F	degrees Fahrenheit
DOE	U.S. Department of Energy
DOE-ORP	U.S. Department of Energy, Office of River Protection
DOE-RL	U.S. Department of Energy, Richland Operations Office
dpm/100 cm ²	disintegrations per minute per 100 square centimeters
HLW	high-level waste
ICD	Interface Control Document
IHLW	immobilized high-level waste
IHS	Interim Hanford Storage
ILAW	immobilized low-activity waste
kg	kilogram
LAW	Low-Activity Waste
mrem/hr	millirem per hour
MTG/day	metric tons of glass per day
QA	quality assurance
QARD	Quality Assurance Requirements and Description
RAMI	Reliability, Availability, Maintainability, and Inspectability
RCRA	<i>Resource Conservation and Recovery Act of 1976</i>
RPP	River Protection Project
TBD	to be determined
TFC	Tank Farm Contractor
TL	Technical Lead
TOC	Tank Operations Contractor
USC	United States Code
WAC	<i>Washington Administrative Code</i>
WAPS	Waste Acceptance Product Specifications
WASRD	Waste Acceptance System Requirements Document
WTP	Hanford Tank Waste Treatment and Immobilization Plant

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1 Interface Description

1.1 Interface Definition

The River Protection Project (RPP) – Hanford Tank Waste Treatment and Immobilization Plant (WTP) will receive high-level waste (HLW) feed from the Tank Operations Contractor (TOC) for treatment. The treatment will immobilize this waste along with materials (such as radionuclides) that are separated from low-activity waste (LAW) feed. After immobilization, the HLW product (immobilized HLW or IHLW) will be sealed in canisters that will be placed in interim permitted storage, by the TOC, for eventual shipment to a national geologic repository.

The Interim Hanford Storage (IHS) facility will be designed and operated according to the standards established by 42 USC 6901 et seq., *Resource Conservation and Recovery Act of 1976 (RCRA)* and the Washington Dangerous Waste Regulations at WAC 173-303. In addition, the WTP product will comply with Chapter II, section M.(1), of the DOE Manual 435.1 1, *Radioactive Waste Management Manual*. TOC and IHS will comply with DOE O 435.1, *Radioactive Waste Management*. WTP will implement DOE O 435.1 in accordance with 24590-WTP-PL-MG-03-002, DOE Order 435.1 Implementation Plan (BNI 2003e). This interface control document (ICD) addresses aspects of the transfer of immobilized high-level waste (IHLW) from the WTP to the TOC, including contractual requirements and waste acceptance criteria.

The onsite transportation cask is the device used to contain the IHLW canister during transport from the WTP to the IHS.

This ICD addresses the physical interfaces related to the IHLW product for transport and disposal. The administrative interface addressed by this ICD is limited to the documentation necessary to ship the IHLW from WTP to the IHS. This ICD does not address IHLW production documentation beyond what is required for transport and acceptance of the IHLW product at the IHS and the national repository.

1.2 Functional Requirements

Table 1 (on the following page) presents the top-level interface requirements for each organization with responsibility for a part of this interface. Column 1 presents WTP interface responsibilities identified in the WTP baseline. Column 2 presents TOC interface responsibilities identified in the TOC baseline. Column 3 presents interface actions for DOE or other Hanford Site contractor necessary to support this interface.

Table 1 Requirements for Immobilized High-Level Waste Interface

The Waste Treatment Plant Contractor Shall...	The Tank Farms Contractor Shall...	DOE Will...
1 Provide requested information to DOE-ORP and TOC needed for DOE owned storage facility design, permitting activities, and authorization basis activities.	1 Provide the WTP Contractor updated technical information for transport vehicle transportation cask, and design requirements for loading the cask.	1 No action
2 Provide a facility for physical transfer of the canistered IHLW waste form.	2 Provide a facility and equipment for receipt, physical transfer, and placement of the canistered waste form for interim storage pending transfer to the national geologic repository. The TOC will prepare, submit and get approval for a permit from the State of WA., Dept. of Ecology to store the HLW, as a co-operator, per WAC 173-303.	2 DOE will be the owner and co-operator on the facility permit for the IHS, per WAC 173-303.
3 Provide required IHLW documentation to DOE in accordance with WTP contract.	3 Provide storage for IHLW documentation. Provide TOC approved IHS Waste Acceptance Criteria.	3 Approve the IHS Waste Acceptance Criteria. Provide required IHLW documentation to TOC for storage.
4 Provide the loan of one non-radioactive IHLW canister to the TOC for safety, acceptance, and operational testing.	4 Provide one transportation cask and transport trailer to WTP Contractor for training and commissioning purposes.	4 No action
5 Receive an empty transportation cask from the TOC. Unload the transportation casks from the transport vehicle, place the accepted IHLW canister in the transportation cask and return the loaded transportation cask to the transport vehicle.	5 Provide transport vehicle. Provide transportation cask to the WTP Contractor-designated transfer facility in compliance with 10 CFR 835, <i>Occupational Radiation Protection</i> (external surface contamination).	5 No action
6 Notify the TOC that the loaded IHLW transportation cask is ready for pickup and provide access for TOC's transportation equipment to accomplish physical pickup.	6 Pickup the loaded transportation cask from the WTP Contractor-designated transfer facility.	6 No action
7 Provide lag storage with a minimum capacity to accommodate 45 canisters.	7 Provide a surge transportation capacity to accommodate the excess capacity stored in the lag storage area of the WTP. (Current design is a capacity that is based upon 6 MTG/day production at the WTP.)	7 No action
8 Provide information to TOC as requested to support preparation of on-site transportation authorization documents for IHLW product.	8 Develop the on-site transportation authorization documents for IHLW product.	8 Review and approve the on-site transportation authorization documents for IHLW product.
9 Respond to any DOE notice of non-conformity based on IHLW product compliance. Participate in negotiations for the disposition of non-conformity based on IHLW product compliance.	9 Notify the DOE, Ecology, and WTP of non-conformity of IHLW based upon IHS acceptance criteria. Respond to any DOE notice of non-conformity based on IHS waste acceptance criteria. Participate in negotiations for the disposition of non-conformity.	9 Notify the WTP Contractor that DOE accepts the IHLW, or that DOE has identified a non-conformity. If a non-conformity is identified, DOE will also notify Ecology. Participate in negotiations for the disposition of non-conformity.
10 Acknowledge receipt of interruption of service notification.	10. Notify the WTP and DOE-ORP in case of an interruption of service.	10 Notify the Contractors in advance of scheduled interruption of services.

2 IHLW Interface Information

This section provides interface information related to the IHLW product that is produced at the WTP and transferred to the TOC after notification of acceptance by the DOE-ORP.

2.1 Physical Interfaces

The physical interface occurs in the IHLW Canister Export Truck Bay when the transport trailer loaded with the transportation cask containing the IHLW canister is engaged by the TOC provided transport tractor. Transportation cask drawings, specifications, and procedures need to be provided by the TOC to the WTP to complete the definition of this interface (See Open Item 0003).

The WTP Contractor has described the method used to make the physical transfer at the treatment facility of the canister into the cask in the *System Description for HLW System HEH Canister Export Handling*, 24590-HLW-3YD-HEH-00001 (BNI 2011). A tabular summary of the documents and drawings offering additional definition to the interface is in Table 2.

To facilitate parallel detailed design efforts by the TOC and WTP Contractor, key conceptual design information must be identified and documented. This key information exchange to support detailed design was identified. The TOC is developing IHS as Project T3W14 (WRPS 2012b). Conceptual Design was completed in June 2012. The design leads for the TOC and WTP Contractor have agreed to identify the crucial parts and hardware (BNI 2001b). See 24590-WTP-ATS-QAIS-07-0787, ICD-14 Action A14-04, Handling Equipment Information. The interface partners will support the bounding specifications and critical need dates for the identified structures, systems, and components (per the Action Table in BNI 2003c).

2.1.1 Design Features for IHLW Canister

The IHLW canister includes design features that allow for handling the canister. The current design configuration is described in the following WTP Contractor design drawings:

- 24590-HLW-MX-30-00010001, Rev 0 (BNI 2010a)
- 24590-HLW-MX-30-00010002, Rev 0 (BNI 2010b)
- 24590-HLW-MX-30-00010003, Rev 0 (BNI 2010c)
- 24590-HLW-MX-30-00010004, Rev 0 (BNI 2010d)

2.1.2 Design Features for IHLW Canister Grapple for the Load-out/Shipping Facility

A common grapple design will minimize overall project costs. The WTP is designated (BNI 2001b) as the lead organization for the IHLW grapple design. The current grapple design is based on the system in place at the West Valley Demonstration Project and is described in the WTP drawing 24590-HLW-M0-30-00012, Rev 1 (BNI 2004b).

2.1.3 Design Features for IHLW Transport Vehicle and Onsite Transportation Cask

The TOC has the lead on the design and responsibility to provide the IHLW cask and conveyance. The IHLW cask provides containment and shielding for the transportation of the IHLW product on the Hanford Site. The WTP Contractor is using the following TOC conceptual design criteria for the

transport vehicle (WRPS 2012a) and transportation cask (WRPS 2012a) as the design basis for IHLW canister/cask handling systems and transport system interface design activities:

- Transport vehicle
 - Less than 60 ft in length
 - Less than 10 ft in width
 - Loading surface for transportation cask will be approximately 2.0 ft from ground.
- Transportation cask
 - Outer diameter not including lifting trunnions is 4 ft.
 - Overall height including the cask lid pintle shall not exceed 207 7/8 in. (transportation cask only). The design of the cask lid pintle, excluding the length of the pintle shaft, shall conform to the geometry shown in RPP-12364, Rev 0, Figure 4.3 in Appendix A.1 (WRPS 2012a). The vertical clearance between the lowest shoulder of the pintle head and the top of the loosened cask lid bolts shall be at least 2 in. (Details are in Attachment 1 of the ICF; BNI 2002.)

PIER No. 24590-WTP-PIER-MGT-12-0230-D, Rev. 0, Action 6, states “Based on results of action 5 [Therefore, the current road design does not allow sufficient clearance under the pipe rack for the HLW canisters to exit the building.], re-work road or increase height of pipe rack.” Since TOC is responsible for transporter design, close coordination between TOC and WTP is necessary in order to set appropriate road to utility rack clearance (See Open Item 0004).
 - Weight of loaded transportation cask and lid shall not exceed 87,500 lb.
 - Weight of empty transportation cask, including appurtenances, shall not exceed 78,261 lb (BNI 2003b).
 - Cask lid weight shall not exceed 5500 lb (BNI 2002).

The following conceptual design criteria and assumptions for the onsite transportation and onsite interim storage are being used by the TOC (Project T3W14) (WRPS2012) for transportation cask and transporter design:

- The transportation cask will be designed to be removable from transport trailer.
- Each transportation cask will accommodate one IHLW canister.
- The transportation cask will be transported in a vertical orientation with the cask opening on the top of the cask.
- The TOC is designated design lead on the transport cask yoke (BNI 2001d). The grapple used in the IHS for hoisting and moving the IHLW canisters will be the same design as the grapple used in the WTP HLW Facility. WTP has lead on the design of the grapple (see section 2.7 Table 2).

- Regarding the IHLW canister, the WTP Contract states, “The maximum heat generation rate for any single canister shall not exceed 1500 watts per canister when delivered to DOE.” Nonetheless, the IHS will be designed for a maximum individual canister heat load of 600 watts (RPP-23674) consistent with the direction from DOE-ORP to TOC. This is based on a projected actual canister maximum heat load of 525 watts, as described in CCN 064648. Furthermore, analyses based on recent WTP and TOC calculations (SVF-2432, IHS Source Term, 2012, Washington River Protection Solutions) indicate the projected actual canister heat load will not exceed 250 watts.
- The WTP calculation 24590-HLW-ZOC-30-00011, Rev C, *Unshielded Dose Rates From Major Components/Tanks at the High Level Waste Facility* (BNI 2004a), section 5.6 and Appendix F, determines dose rates using project ‘nominal’ source terms and as such cannot be used for personnel dose determinations, but it is acceptable for equipment dose.
- The WTP calculation 24590-HLW-ZOC-30-00016, Rev B, incorporates the latest project source terms to ensure that the bulk shielding at the WTP HLW Vitrification Facility provides adequate shielding to comply with ALARA principles and with the Radiological Area Classification scheme. The conclusion of this calculation is that the maximum bulk shielding required in the HLW facility is 47 inches of concrete, which is needed in areas where multiple glass canisters are handled/stored.

IHS-Specific design criteria will be developed for the transportation system later as the IHS design evolves. RPP-8236 (*Packaging Design Criteria (Onsite) Project W 464, Immobilized High Level Waste Transportation System*) was developed for an earlier iteration of interim onsite storage. Although this specification is suitable for use in concept development, it should be noted that it is not IHS-specific design criteria.

2.2 Administrative Interfaces

This section describes the administrative activities necessary to ensure the proper execution of the physical interfaces associated with transfer of the IHLW product from WTP Contractor to the TOC for transport to the IHLW IHS.

The administrative interface for IHLW will be the location where the driver will receive the shipping manifest or other transportation documentation allowing for the transport of the loaded transportation cask. Each contractor is responsible for RCRA compliance within their respective facility. It is proposed that the IHLW is to be delisted prior to production. If the IHLW is delisted, then no RCRA manifesting requirements apply.

The respective organizations’ design processes include integrated safety management principles and are communicated through the interface in the identified configuration-managed documents listed in Table 2.

Each contractor’s design processes incorporate reliability, availability, maintainability, and inspectability (RAMI) requirements. These requirements are included in the design to ensure that the interface requirements, documented in this ICD, are met. Consequently, there are no RAMI requirements that must be managed across the interface.

No new hazards or accident scenarios are to be introduced through this interface that are not adequately controlled by the interface partners and through controls placed across this interface. The physical and administrative controls to mitigate these risks using a graded approach are to be adequately addressed through requirements on each partner’s authorization basis and no additional physical and administrative controls are deemed necessary.

Each contractor is responsible for QARD (DOE 2008) compliance within their respective facility. The certification documentation required by the IHLW Waste Form Compliance Plan for the Hanford Tank Waste Treatment and Immobilization Plant [BNI 2009] supports the management of the administrative interface by addressing the TOC/WTP QA-Office of Civilian Radioactive Waste Management interface requirements. No items or activities require management across the interface (BNI 2001d).

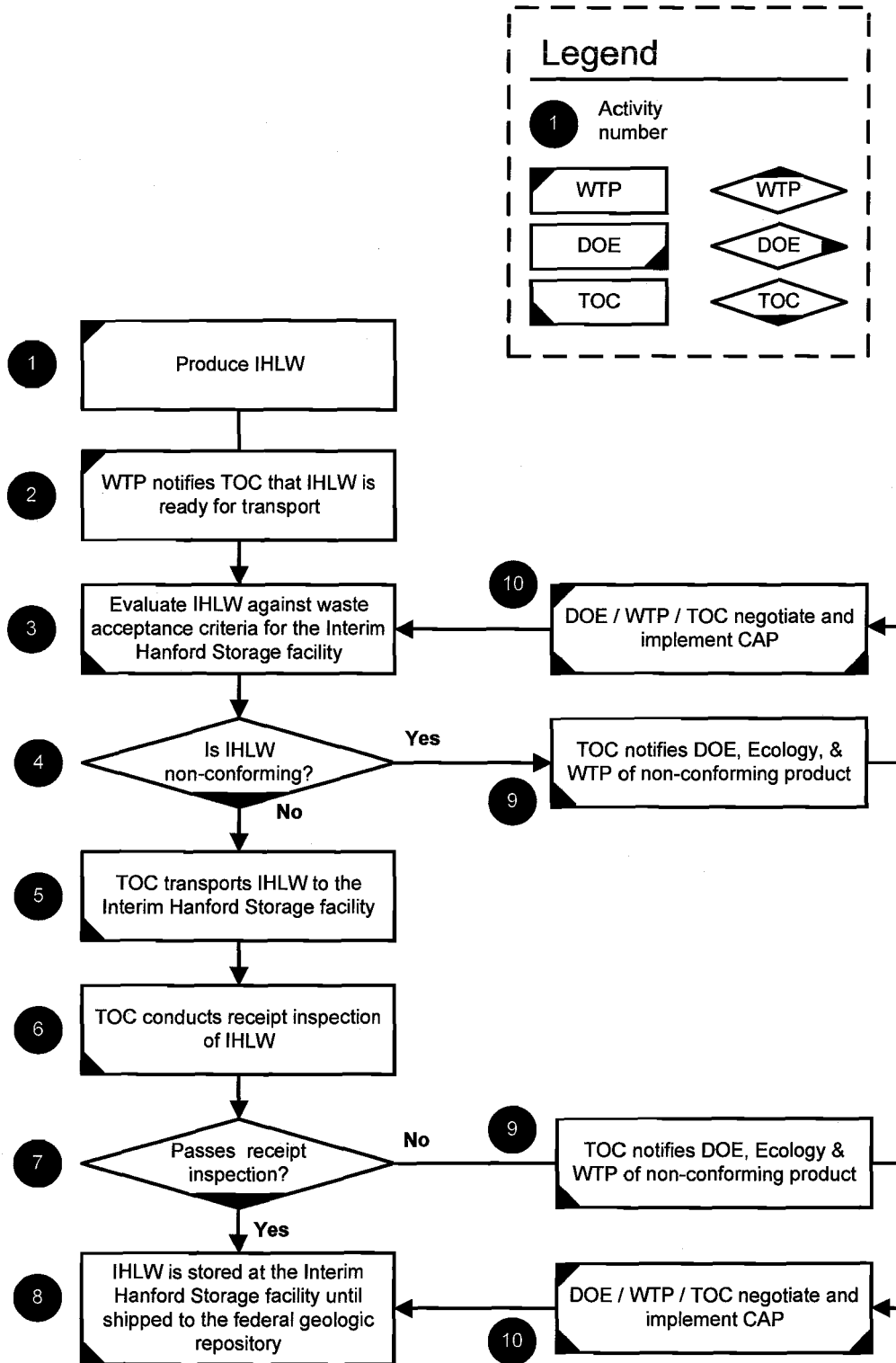
Deactivation considerations are the responsibility of the respective contractors (BNI 2003d).

2.2.1 Interface Logic

This section provides a description of the activities that will take place during the IHLW product acceptance and transfer process. Description numbers correspond with the ICD-14 logic diagram found in Figure 1 on the following page.

- 1 **Produce IHLW** – WTP Contractor will receive and treat the HLW to produce IHLW in compliance with the WTP contract (DOE 2000). Production record documentation generated during production activities will be prepared in conformance with the requirements defined in the IHLW Waste Form Compliance Plan for the Hanford Tank Waste Treatment and Immobilization Plant [BNI 2009].
- 2 **WTP notification of TOC for transport** – The WTP Contractor will notify the TOC that the IHLW canister is ready for transport.
- 3 **Evaluate IHLW** – TOC will evaluate the IHLW against the waste acceptance criteria established for the IHS (see Open Item 0001).
- 4 **Is IHLW non-conforming?** – If the IHLW product does not meet the receipt requirements in the IHS Waste Acceptance Criteria, the IHLW product will be identified as non-conforming. TOC will notify DOE and WTP of the non-conformance as soon as is practical.
- 5 **TOC transport IHLW to IHS** – The TOC will accept custody of the transporter trailer with loaded transportation cask. When TOC accepts custody of the transporter trailer with loaded transportation cask, the TOC assumes responsibility for all transporter trailer and transportation cask activities. The TOC will unload the transportation cask and canister at the IHS.
- 6 **TOC conduct receipt inspection** – The TOC will determine if the IHLW product meets receipt requirements in the IHS Waste Acceptance Criteria.
- 7 **Passes receipt inspection?** - If the IHLW product does not meet the receipt requirements in the IHS Waste Acceptance Criteria, the IHLW product will be identified as non-conforming. TOC will notify DOE and WTP of the non-conformance as soon as is practical.
- 8 **Store IHLW product at the IHS facility** - If the IHLW product meets the IHS Waste Acceptance Criteria and passes receipt inspection, the IHLW product will be stored at the IHS.
- 9 **TOC notifies DOE, Ecology, and WTP of non-conforming product** - If the TOC determines that a “non-conforming” product has been produced (as in Item 4 or 7 above), the non-conforming IHLW product shall be segregated and a Corrective Action Plan (CAP) shall be prepared for DOE-ORP approval for the non-conforming IHLW product.
- 10 **DOE / WTP / TOC Negotiate and implement a CAP** - A CAP shall be prepared that describes how to convert the non-conforming condition to a non-standard condition, with the latter condition enabling the IHLW product to be acceptable for on-site interim storage.

Figure 1 ICD-14 Logic Diagram



2.2.2 Interface Capacity

The current contract design capacity of the WTP is based on 7.5 MTG/day and the treatment capacity (defined as a product of the facility design capacity multiplied by the integrated facility availability factor) is 5.25 MTG/day (DOE 2000). The WTP HLW Facility will support a combined design capacity of 6 MTG/day with the original two melters and 7.5 MTG/day with two replacement melters, with a minimum facility availability factor of 70%. The IHS Facility must be able to accommodate an average rate greater than 1.74 canisters per day at the 5.25 MTG/day treatment capacity. This corresponds to 635 canisters per year (WRPS 2012a).

2.3 Interface Schedule

The DOE-ORP-approved baseline schedules for the TOC and WTP contain the interface milestones and integrated schedule for this ICD. Activity IDs referenced are from the respective contractor's approved baseline. *Note: The early date represents the earliest planning date for the activity to begin and should be verified with the contractor's currently approved schedules.*

NOTE: What is reflected here is current baseline. The WTP contractor has been directed to re-plan. All milestones will be updated accordingly.

2.3.1 Milestone 14 A – IHLW Cask and Trailer Available for Commissioning and Training -

This milestone represents the planned availability of a cask and trailer to utilize for WTP commissioning and training. For the WTP Contractor, it represents the planned date for commencing cold commissioning operations including training of operators. For the TOC, it represents that the cask and trailer are available to the WTP Contractor.

Contractor	Act ID	Title	Early Date
WTP	5HHC2CD14A	IHLW Cask and Trailer available for Training (ICD14A)	Per re-plan
TOC	TBD	IHS Transportation Cask & Trailer for Training	TBD

2.3.2 Milestone 14 B – Initiate Transfer of 1st IHLW Product -

This milestone represents the planned date to begin transfer of IHLW product. For the TOC, it represents the planned date to pick up and store IHLW in the IHS. For the WTP, it represents the planned date to begin hot commissioning of the HLW vitrification facility.

Contractor	Act ID	Title	Early Date
WTP	5HHC4CD14B	Initiate Transfer of 1st IHLW Product (ICD14B)	Per re-plan
TOC	TBD	Accept IHLW Product	TBD

2.3.3 Milestone 14 C – IHLW Canister (Non-Radioactive) Available for Training -

The WTP will provide one IHLW canister with non-radioactive waste product to the TOC for acceptance, operational testing, and training purposes (BNI 2001a).

Contractor	Act ID	Title	Early Date
WTP	5HHC2CD14C	IHLW Canister (Non-Rad) Available Training (ICD14C)	Per re-plan
TOC	TBD	Receive HLW Canister from WTP for Training	TBD

2.4 Acceptance Criteria

There are a number of documents that impose interface responsibilities on the WTP Contractor, TOC, and DOE concerning the acceptance of the IHLW product. Acceptance in each of these documents may not refer to a common process. Criteria for acceptance of IHLW at the national geologic repository is set forth in the *Waste Acceptance System Requirements Document (WASRD)* (DOE 2007), *Waste Acceptance Product Specifications for Vitrified High-Level Waste Forms (WAPS)* (DOE 1996), and *Quality Assurance Requirements and Description for the Civilian Radioactive Waste Management Program (QARD)* (DOE 2008). The IHLW product shall meet the requirements in the WASRD, WAPS, and the QARD. The WASRD is the senior requirements document and defines the minimum set of requirements and associated limits for acceptance of the IHLW product in the proposed geologic repository. The WAPS establishes the minimum set of product requirements for the IHLW product. The QARD establishes the minimum QA requirements for the IHLW product.

To facilitate subsequent disposal at the national geologic repository, the IHLW product must have the RCRA hazardous characteristic listed codes removed. The process to delist the IHLW (WTP Deliverable 7.9, Table C.5-1.1 [DOE 2000]) is supported by activities to prepare and submit the delisting package. The delisting package was delivered by DOE-ORP to the United States Environmental Protection Agency and to the Washington State Department of Ecology in December 2006 (BNI 2006).

Waste acceptance criteria and contract requirements are addressed separately in the IHLW Waste Form Compliance Plan for the Hanford Tank Waste Treatment and Immobilization Plant [BNI 2009]. DOE Order 435.1, *Radioactive Waste Management*, and the WAPS define the acceptability criteria for treatment, storage, and disposal facilities for the IHS. The DOE *Radioactive Waste Management Manual* (DOE M 435.1-1) requires the TOC and WTP compliance with the WAPS and WASRD.

2.5 WTP Acceptance Criteria

The acceptance documentation for the IHLW product is defined in Specification 13 of the WTP contract (DOE 2000). The WTP method for compliance with each requirement is set forth in the IHLW Waste Form Compliance Plan for the Hanford Tank Waste Treatment and Immobilization Plant [BNI 2009] including compliance with the Revised Code of Washington as promulgated through the Washington Administrative Code (WAC 173-303) and Chapter II, section M.(1), of DOE M 435.1-1.

2.6 Interim Hanford Storage Facility Acceptance Criteria

The TOC is obligated to comply with DOE O 435.1 (WRPS 2012a). DOE O 435.1 defines technical and administrative requirements for acceptance of waste at treatment, storage, and disposal facilities (such as

the IHLW IHS), including those traceable to the Washington Administrative Code and the *Resource Conservation and Recovery Act of 1976* (42 USC 6901). The order states: "All radioactive waste shall be managed in accordance with the requirements of DOE M 435.1-1, Radioactive Waste Management Manual." Acceptance criteria for IHLW IHS as imposed by DOE O 435.1 shall be identified by the TOC.

2.7 Configuration Management Items

This section identifies the specific referenced documents that further define the physical and/or administrative details of the interface. Interface impacting changes to the documents listed in the following table shall be agreed to by the impacted parties prior to approving the changes. The following table provides a tabular summary of these referenced documents.

Table 2 IHLW Interface Configuration Management Items

WTP Documents	Interfacing Organization Documents
<i>Unshielded Dose Rates From Major Components/Tanks at the High-Level Waste Facility</i> (BNI 2004a) <i>IHLW Waste Form Compliance Plan for the Hanford Tank Waste Treatment and Immobilization Plant</i> [BNI 2009] <i>IHLW Transportation Cask</i> (BNI 2001d, Attachment 1) <i>Transportation Cask Yoke</i> (BNI 2001d, Attachment 1)	<i>Immobilized High-Level Waste Interim Hanford Storage System Specification</i> (RPP-23674, Rev. 1) (WRPS 2012a) IHS Waste Acceptance Criteria to be developed
WTP Drawings	Interfacing Organization Drawings
<i>HLW Canister (3/8" in. Wall) Design Drawings:</i> <ul style="list-style-type: none"> • 24590-HLW-MX-30-00010001, Rev 0 (BNI 2010a) • 24590-HLW-MX-30-00010002, Rev 0 (BNI 2010b) • 24590-HLW-MX-30-00010003, Rev 0 (BNI 2010c) • 24590-HLW-MX-30-00010004, Rev 0 (BNI 2010d) <i>HLW Vitrification Design Proposal Drawing Mechanical Sequence Grapple</i> , 24590-HLW-M0-30-00012, Rev 1 (BNI 2004b)	<i>IHLW Transporter</i> (RPP-8236) (CH2 2001) <i>Conceptual Cask and Required Pintle Profile Drawing</i> , Figure 4-3 (RPP-12364, page A.1-23) (CH2 2002)

As documents bearing interface-affecting specifications are prepared by each of the contractors, they will be included in Table 2.

3 References

The following references for this interface are available from the publishing organization document control system (WTP, Hanford Site, or DOE), or from the Internet (for codes, including Washington Administrative Code, CFR, USC, and DOE orders). A copy may be requested by contacting the appropriate interface team member.

42 USC 6901, et seq., *Resource Conservation and Recovery Act of 1976*. US Congress, Washington, DC, USA.

BNFL. 2000. ICD-14/15 Working Group Meeting Minutes, CCN 012556. 22 March 2000.

BNI. 2001a. ICD-14 Working Group Meeting Minutes, CCN 020511. 9 May 2001. Bechtel National, Inc., Richland, WA, USA.

BNI. 2001b. ICD-14 Working Group Meeting Minutes, CCN 023802. 9 October 2001. Bechtel National, Inc., Richland, WA, USA.

BNI. 2001c. ICD-14 Working Group Meeting Minutes, CCN 024139. 17 October 2001. Bechtel National, Inc., Richland, WA, USA.

BNI. 2001d. ICD-14 Working Group Meeting Minutes, CCN 024404. 25 October 2001. Bechtel National, Inc., Richland, WA, USA.

BNI. 2002. *Establishment of IHLW Transportation Cask Lid Critical Dimensions in Support of WTP Procurement Actions*, 24590-WTP-ICF-ENG-02-005. 31 December 2002. Bechtel National, Inc., Richland, WA, USA.

BNI. 2003a. *ICD-14 & 15 Working Groups Meeting*, CCN 049297. 10 January 2003. Bechtel National, Inc., Richland, WA, USA.

BNI. 2003b. *Establishment of IHLW Transportation Cask Critical Dimension in Support of Construction Activity*, 24590-WTP-ICF-ENG-03-002. February 2003. Bechtel National, Inc., Richland, WA, USA.

BNI. 2003c. *ICD-14 & 15 Working Groups Joint Meeting*, CCN 064648. 25 July 2003. Bechtel National, Inc., Richland, WA, USA.

BNI. 2003d. ICD-14 DRR-I Comment Disposition Meeting, CCN 071521. 3 October 2003. Bechtel National, Inc., Richland, WA, USA.

BNI. 2003e. *DOE Order 435.1 Implementation Plan*, 24590-WTP-PL-MG-03-002, Rev 0. 17 November 2003. Bechtel National, Inc., Richland, WA, USA.

BNI. 2004a. *Unshielded Dose Rates from Major Components/Tanks at the High Level Waste Facility*, 24590-HLW-Z0C-30-00011, Rev C. 23 February 2004. Bechtel National, Inc., Richland, WA, USA.

BNI. 2004b. *HLW Vitrification Design Proposal Drawing Mechanical Sequence Grapple*, 24590-HLW-M0-30-00012, Rev 1. 17 May 2004. Bechtel National, Inc., Richland, WA, USA.

BNI. 2006. CCN 150916. Letter from R.J. Schepens, Manager ORP to Ecology and EPA. *Milestone M-62-03, Delisting Petition for Immobilized High Level Waste (IHLW.)* January 10, 2007. Bechtel National, Inc., Richland, WA, USA.

BNI. 2009. *IHLW Waste Form Compliance Plan for the Hanford Tank Waste Treatment and Immobilization Plant*, 24590-HLW-PL-RT-07-0001, Rev 3, 23 June 2009. Bechtel National, Inc., Richland, WA, USA.

BNI. 2010a. *WTP HLW Canister Assembly Drawing (3/8" Wall)*, 24590-HLW-MX-30-00010001, Rev 0. 23 December 2010. Bechtel National, Inc., Richland, WA, USA.

BNI. 2010b. *WTP HLW Canister Detail Drawing (3/8" Wall)*, 24590-HLW-MX-30-00010002, Rev 0. 21 December 2010. Bechtel National, Inc., Richland, WA, USA.

BNI. 2010c. *WTP HLW Canister Weldment Drawing (3/8" Wall)*, 24590-HLW-MX-30-00010003, Rev 0. 21 December 2007. Bechtel National, Inc., Richland, WA, USA.

BNI. 2010d. *WTP HLW Canister Lid Detail Drawing (3/8" Wall)*, 24590-HLW-MX-30-00010004, Rev 0. 21 December 2010. Bechtel National, Inc., Richland, WA, USA.

BNI. 2011. *System Description for HLW System HEH Canister Export Handling*, 24590-HLW-3YD-HEH-00001, Rev 3. 15 November 2011. Bechtel National, Inc., Richland, WA, USA.

CH2. 2001. *Packaging Design Criteria (Onsite) Project W-464, Immobilized High-Level Waste Transportation System*, RPP-8236, Rev 0. CH2M HILL Hanford Group, Inc., Richland, WA, USA.

CH2. 2002. *Project W-464, Immobilized High-Level Waste Interim Storage Facility Preliminary Design Report*, RPP-12364, Rev 0. CH2M HILL Hanford Group, Inc., Richland, WA, USA.

DOE M 435.1-1. 2001. *Radioactive Waste Management Manual*. US Department of Energy, Washington, DC, USA.

DOE O 435.1 Change 1. 2001. *Radioactive Waste Management*. US Department of Energy, Washington, DC, USA.

DOE O 460.1B. 2003. *Packaging and Transportation Safety*. US Department of Energy, Washington, DC, USA.

DOE. 1996. *Waste Acceptance Product Specifications for Vitrified High-Level Waste Forms (WAPS)*, DOE/EM-0093, Rev 2. US Department of Energy, Office of Environmental Management, Washington, DC, USA.

DOE. 2000. Contract No. DE-AC27-01RV14136, as amended by Modification A029, 25 April 2003, *Design, Construction, and Commissioning of the Hanford Tank Waste Treatment and Immobilization Plant*. US Department of Energy, Richland, WA, USA.

DOE. 2007. *Waste Acceptance System Requirements Document (WASRD)*, DOE/RW 0351P, Rev 5. US Department Of Energy, Office of Civilian Radioactive Waste Management, Washington, DC, USA.

DOE. 2008. *Quality Assurance Requirements and Description for the Office of Civilian Radioactive Waste Management (QARD)*, DOE/RW-0333P, Rev 20. US Department of Energy, Office of Civilian Radioactive Waste Management, Washington, DC, USA.

WAC 173-303. 2009. *Dangerous Waste Regulations*, Washington Administrative Code.

WRPS. 2012a. *Immobilized High-Level Waste Interim Hanford Storage System Specification*, RPP-23674, Rev. 1. January, 2012. Washington River Protection Solutions, Richland, WA, USA.

WRPS. 2012b. *Interim Hanford Storage Conceptual Design Report*, RPP-RPT-52176, Rev 0. June 15, 2012. Washington River Protection Solutions, Richland, WA, USA.

Appendix A - Open ICD 14 Issues and Actions

Issue / Action #	Tracking #	Issue / Action	Baseline (In-Out-N/A)		Page(s)
			WTP	TOC	
A14-04	24590-WTP-ATS-QAIS-07-0787	Handling Equipment Information	In	In	3

Appendix B - ICD 14 Issues and Actions Closed Since Last Revision

Issue / Action #	Tracking #	Issue / Action	Date Closed	Resolution
None				

Appendix C - ICD 14 Open Items List

NOTE: 24590-WTP-PL-MG-01-001, Interface Management Plan defines ICD Issues as one of two things; 1) Incompatibilities between contractor baselines and, 2) Incomplete interfaces. ICD Actions are defined as discreet activities engaged to resolve ICD Issues. There are items that do not fit the description of ICD Issues or ICD Actions found in the IMP that still require tracking. This does not mean these items are unimportant. The following list is a way of tracking these items to resolution. Depending on events related to these items, some of these items may be elevated to become ICD Issues or ICD Actions and others may be closed and removed from this list in future revisions to ICD 14. When an item on this list is closed, the resolution will be recorded in the Status column and it will appear in the next revision of ICD 14 with the resolution. In the revision after that, the item will be removed from the list, since it will have become part of the historical record.

Item #	Description	Source	Status
0001	The waste acceptance criteria for the Interim Hanford Storage facility need to be established.	C. Rieck	OPEN
0002	Work scope to accommodate non-conforming canisters needs to be identified and directed to appropriate Contractors.	W. Abdul	OPEN
0003	Transportation cask drawings, specifications, and procedures need to be provided by the TOC to the WTP to complete the definition of this interface.	S. Arm	OPEN
0004	Close coordination between TOC and WTP is necessary in order to set appropriate road to utility rack clearance on the exit side of the HLW Driveway. (See 24590-WTP-PIER-MGT-12-0230-D, Rev. 0)	W. Watson (TOC) J. Booth (WTP)	OPEN