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ENGINEERING CHANGE NOTICE

Page 1 of 2

1. ECN 658765

Proj. ECN

2. ECN Category (mark one) Supplemental <input type="checkbox"/> Direct Revision <input checked="" type="checkbox"/> Change ECN <input type="checkbox"/> Temporary <input type="checkbox"/> Standby <input type="checkbox"/> Supersedure <input type="checkbox"/> Cancel/Void <input type="checkbox"/>	3. Originator's Name, Organization, MSIN, and Telephone No. Margaret K. Martin 376-3452 SNF Storage Project MSIN: L6-58		4. USQ Required? <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	5. Date 5/18/00
	6. Project Title/No./Work Order No. <i>HMF30121</i> SNF Storage Subprojects		7. Bldg./Sys./Fac. No. 212-H	8. Approval Designator SNQ
	9. Document Numbers Changed by this ECN (includes sheet no. and rev.) <i>105363/CA30</i> HNF-SD-SNF-PLN-021, Rev. 0 <i>via 5/30</i>		10. Related ECN No(s). N/A	11. Related PO No. N/A
12a. Modification Work <input type="checkbox"/> Yes (fill out Blk. 12b) <input checked="" type="checkbox"/> No (NA Blks. 12b, 12c, 12d)	12b. Work Package No. N/A	12c. Modification Work Completed N/A Design Authority/Cog. Engineer Signature & Date	12d. Restored to Original Condition (Temp. or Standby ECNs only) N/A Design Authority/Cog. Engineer Signature & Date	

13a. Description of Change

13b. Design Baseline Document? Yes No

HNF-SD-SNF-PLN-021, Rev. 0 (Warehouse Plan for the Multi-Canister Overpacks and Baskets):

This revision replaces Rev. 0 in its entirety. Revision 1 updates include the deletion of receipt inspection for the MCO Baskets. Revision 1 also includes the larger boxes being received that contain 2 MCO Shells each.

Parallel processing of this document and USQ-like Screening is authorized, since this document has little impact on the MCO Topical Report, HNF-SD-SNF-SARR-005.
Signed *Louis Goldmann* *5/23/2000*
Louis Goldmann—MCO/Basket Design Authority, Date

USQ Numbers: *CVD-00-1027*
CSB-00-1031
K-00-0796
(jda per telecon w/ R.E. Smith)

14a. Justification (mark one) Criteria Change <input type="checkbox"/> Design Improvement <input checked="" type="checkbox"/> Environmental <input type="checkbox"/> Facility Deactivation <input type="checkbox"/> As-Found <input type="checkbox"/> Facilitate Const. <input type="checkbox"/> Const. Error/Omission <input type="checkbox"/> Design Error/Omission <input type="checkbox"/>	14b. Justification Details Editorial changes made to clarify requirements. Periodic updates to the Warehouse Plan are required to reflect evolving requirements and information.
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15. Distribution (include name, MSIN, and no. of copies)

See attached distribution sheet.

RELEASE STAMP

MAY 30 2000

DATE: _____
STA: 15

HANFORD
RELEASE

ID: (20)

ENGINEERING CHANGE NOTICE

Page 2 of 2

1. ECN (use no. from pg. 1)

658765

16. Design Verification Required

- Yes
 No

17. Cost Impact

ENGINEERING

- Additional \$ N/A
Savings \$ N/A

CONSTRUCTION

- Additional \$ N/A
Savings \$ N/A

18. Schedule Impact (days)

- Improvement N/A
Delay N/A

19. Change Impact Review: Indicate the related documents (other than the engineering documents identified on Side 1) that will be affected by the change described in Block 13. Enter the affected document number in Block 20.

<p>SDD/DD <input type="checkbox"/></p> <p>Functional Design Criteria <input type="checkbox"/></p> <p>Operating Specification <input type="checkbox"/></p> <p>Criticality Specification <input type="checkbox"/></p> <p>Conceptual Design Report <input type="checkbox"/></p> <p>Equipment Spec. <input type="checkbox"/></p> <p>Const. Spec. <input type="checkbox"/></p> <p>Procurement Spec. <input type="checkbox"/></p> <p>Vendor Information <input type="checkbox"/></p> <p>OM Manual <input type="checkbox"/></p> <p>FSAR/SAR <input type="checkbox"/></p> <p>Safety Equipment List <input type="checkbox"/></p> <p>Radiation Work Permit <input type="checkbox"/></p> <p>Environmental Impact Statement <input type="checkbox"/></p> <p>Environmental Report <input type="checkbox"/></p> <p>Environmental Permit <input type="checkbox"/></p>	<p>Seismic/Stress Analysis <input type="checkbox"/></p> <p>Stress/Design Report <input type="checkbox"/></p> <p>Interface Control Drawing <input type="checkbox"/></p> <p>Calibration Procedure <input type="checkbox"/></p> <p>Installation Procedure <input type="checkbox"/></p> <p>Maintenance Procedure <input type="checkbox"/></p> <p>Engineering Procedure <input type="checkbox"/></p> <p>Operating Instruction <input type="checkbox"/></p> <p>Operating Procedure <input type="checkbox"/></p> <p>Operational Safety Requirement <input type="checkbox"/></p> <p>IEFD Drawing <input type="checkbox"/></p> <p>Cell Arrangement Drawing <input type="checkbox"/></p> <p>Essential Material Specification <input type="checkbox"/></p> <p>Fac. Proc. Samp. Schedule <input type="checkbox"/></p> <p>Inspection Plan <input type="checkbox"/></p> <p>Inventory Adjustment Request <input type="checkbox"/></p>	<p>Tank Calibration Manual <input type="checkbox"/></p> <p>Health Physics Procedure <input type="checkbox"/></p> <p>Spares Multiple Unit Listing <input type="checkbox"/></p> <p>Test Procedures/Specification <input type="checkbox"/></p> <p>Component Index <input type="checkbox"/></p> <p>ASME Coded Item <input type="checkbox"/></p> <p>Human Factor Consideration <input type="checkbox"/></p> <p>Computer Software <input type="checkbox"/></p> <p>Electric Circuit Schedule <input type="checkbox"/></p> <p>ICRS Procedure <input type="checkbox"/></p> <p>Process Control Manual/Plan <input type="checkbox"/></p> <p>Process Flow Chart <input type="checkbox"/></p> <p>Purchase Requisition <input type="checkbox"/></p> <p>Tickler File <input type="checkbox"/></p> <p><u>N/A</u> <input checked="" type="checkbox"/></p>
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20. Other Affected Documents: (NOTE: Documents listed below will not be revised by this ECN.) Signatures below indicate that the signing organization has been notified of other affected documents listed below.

Document Number/Revision	Document Number/Revision	Document Number/Revision
N/A		

21. Approvals

Signature	Date	Signature	Date
Design Authority <u>L. H. Goldmann</u> <i>[Signature]</i>	<u>5/22/2000</u>	Design Agent _____	_____
Cog. Eng. _____		PE _____	_____
Cog. Mgr. <u>K. E. Smith</u> <i>[Signature]</i>	<u>5/22/00</u>	QA _____	_____
QA <u>C. R. Hoover</u> <i>[Signature]</i>	<u>5/22/00</u>	Safety _____	_____
Safety <u>B. LORENZ for R.E. per telecon</u> <i>[Signature]</i>	<u>5/30/00</u>	Design _____	_____
Environ. _____		Environ. _____	_____
Other _____		Other _____	_____
Design Admin: <u>M. K. Martin</u> <i>[Signature]</i>	<u>5-18-00</u>		
Mat'l Mngr: <u>J. G. Caudill</u> <i>[Signature]</i>	<u>5/30/00</u>		

DEPARTMENT OF ENERGY

Signature or a Control Number that tracks the Approval Signature

ADDITIONAL

S

HNF-SD-SNF-PLN-021
Revision 1

WAREHOUSE PLAN FOR THE MULTI-CANISTER OVERPACKS AND BASKETS

Prepared for the U.S. Department of Energy
Assistant Secretary for Environmental Management

Project Hanford Management Contractor for the
U.S. Department of Energy under Contract DE-AC06-96RL13200

Fluor Hanford
P.O. Box 1000
Richland, Washington

WAREHOUSE PLAN FOR THE MULTI-CANISTER OVERPACKS AND BASKETS

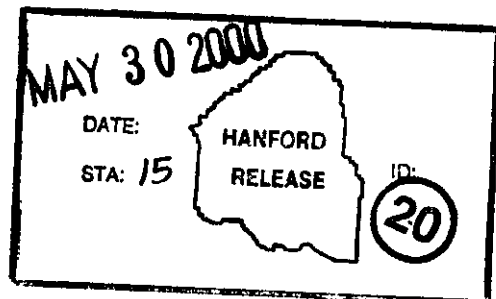
M. K. Martin
Fluor Hanford

Date Published
May 2000

Prepared for the U.S. Department of Energy
Assistant Secretary for Environmental Management

Project Hanford Management Contractor for the
U.S. Department of Energy under Contract DE-AC06-96RL13200

Fluor Hanford
P.O. Box 1000
Richland, Washington



Jamie Aardal 5-30-00
Release Approval Date

Key Words: Multi-Canister Overpack, MCO, K Basin, W Basin, Baskets

Abstract: The Multi-Canister Overpacks (MCOs) will contain spent nuclear fuel (SNF) removed from the K East and West Basins. The SNF will be placed in fuel storage baskets that will be stacked inside the MCOs. Approximately 400 MCOs and 2170 baskets will be fabricated for this purpose. These MCOs, loaded with SNF, will be placed in interim storage in the Canister Storage Building (CSB) located in the 200 Area of the Hanford Site.

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TOTAL PAGES 14

RECORD OF REVISION

(1) Document Number
HNF-SD-SNF-PLN-021

(2) Title
Warehouse Plan for the Multi-Canister Overpacks and Baskets

Change Control Record

(3) Revision	(4) Description of Change - Replace, Add, and Delete Pages	Authorized for Release		
		(5) Cog. Engr.	(6) Cog. Mgr.	Date
0	(7) EDT-628353, 3/27/2000	MK Martin	KE Smith	
1 RS	Complete revision, per ECN-658765	MK Martin 5/30/00	KE Smith 5/30/00	

DISTRIBUTION SHEET

To Distribution	From SNF Storage Subprojects	Page 1 of 1
Project Title/Work Order		Date 5/18/00
Warehouse Plan for the Multi-Canister Overpacks and Baskets, HNF-SD-SNF-PLN-021, Rev. 1		EDT No. N/A
		ECN No. 658765

Name	MSIN	Text With All Attach.	Text Only	Attach./Appendix Only	EDT/ECN Only
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T. L. Collins	X3-85	X			
M. D. Dallas	-H5-33	X			
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WAREHOUSE PLAN
FOR THE
MULTI-CANISTER OVERPACKS AND BASKETS
HNF-SD-SNF-PLN-021

Contract No. KH-8009

May 2000
Revision 1

Prepared By:

Margaret K. Martin

Margaret Martin, Design Administration

5-17-00

Date

Approved By:

| Original Signature on Rev 0 Document

Louis Goldmann, Design Authority

Date

| Original Signature on Rev 0 Document

Clif Hoover, QA Manager, Multi-Canister Overpacks

Date

| Original Signature on Rev 0 Document

George Mata, QA Manager, Multi-Canister
Overpacks Baskets

Date

| Original Signature on Rev 0 Document

Kimball Smith, Storage Subprojects Manager

Date

| Original Signature on Rev 0 Document

Joe Caudill, Manager - Materials Management
Dyncorp Tri-Cities Services, Inc

Date

WAREHOUSE PLAN
FOR THE
MULTI-CANISTER OVERPACKS AND BASKETS
HNF-SD-SNF-PLN-021

Contract No. KH-8009

Approved By (continued):

| Original Signature on Rev 0 Document

William A. Ferree, Senior Director – Logistics
Dyncorp Tri-Cities Services, Inc.

Date

| Original Signature on Rev 0 Document

Richard G. Slocum, Vice President
Dyncorp Tri-Cities Services, Inc.

Date

| Original Signature on Rev 0 Document

Michael D. Dallas, Senior Vice President and
Deputy General Manager
Dyncorp Tri-Cities Services, Inc.

Date

| Original Signature on Rev 0 Document

David S. Kelly, Site Services
Fluor Hanford, Inc

Date

WAREHOUSE PLAN
FOR THE
MULTI-CANISTER OVERPACKS AND BASKETS

HNF-SD-SNF-PLN-021

Prepared for the U.S. Department of Energy
Contract No. KH-8009

May 2000
Revision 1

Warehouse Plan for the Multi-Canister Overpacks and Baskets

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Warehouse Plan for the Multi-Canister Overpacks and Baskets

1.0 INTRODUCTION

The Multi-Canister Overpacks (MCOs) will contain spent nuclear fuel (SNF) removed from the K East and West Basins. The SNF will be placed in fuel storage baskets that will be stacked inside the MCOs. Approximately 400 MCOs and 2170 baskets will be fabricated for this purpose. These MCOs, loaded with SNF, will be placed in interim storage in the Canister Storage Building (CSB) located in the 200 Area of the Hanford Site.

The MCOs consist of different components that will be manufactured by one or more vendors. All MCO components and baskets will be shipped to the Hanford Site Central Stores Warehouse for storage until these components are required at the CSB and K Basins. The MCO fuel storage baskets will be manufactured in the MCO basket fabrication shop located in Building 328 of the Hanford Site 300 Area. The MCO baskets will be inspected at the fabrication shop by MCO Basket Subproject Quality Control personnel before shipment to the Hanford Site Central Stores Warehouse for storage.

The MCO components and baskets will be stored as received from the manufacturer with specified protective coatings, wrappings, and packaging intact to maintain mechanical integrity of the components and to prevent corrosion. The components and baskets will be shipped as needed from the warehouse to the CSB and K Basins.

This warehouse plan includes the requirements for receipt of MCO components and baskets from the manufacturers and storage at the Hanford Site Central Stores Warehouse. Transportation of the MCO components and baskets from the warehouse, unwrapping, and assembly of the MCOs are the responsibility of SNF Operations and are not included in this plan.

2.0 WAREHOUSE REQUIREMENTS

The MCO components and baskets will be handled, and stored in accordance with the Office of Civilian Radioactive Waste Management (OCRWM) Quality Assurance Requirements (Reference 1). OCRWM requires that handling, storage cleaning, packaging, and preservation of items be conducted in accordance with established work and inspection implementing documents or other specified documents. As described in the fabrication specifications for the MCOs and baskets (References 2 and 3 respectively), the manufacturers will package and ship the MCO components and baskets in accordance with ASME NQA-1 Subpart 2.2 Level C storage requirements (Reference 4) which meets the OCRWM requirements. Per ASME NQA-1, items requiring Level C storage must be stored either indoors or in an environment equivalent to indoors. While control of heat and temperature are not required, the items must be stored in fire-resistant, tear-resistant, weather-tight, and well-ventilated buildings or enclosures. The storage area also must be paved or equal and free from flooding. The Hanford Site Central Stores Warehouse exceeds these requirements. The facility is designated an ASME NQA-1 Level B storage area.

2.1 Space Requirements

Approximately 400 MCOs will be fabricated for stabilization and storage of the SNF located in the K Basins. Each MCO will have either 5 baskets with Mark IV fuel or 6 baskets with Mark 1A fuel. Approximately 2170 baskets will be fabricated. MCO components and baskets should be moved from the warehouse at about the same rate that they are received at the warehouse. However, space in the Hanford Site Central Stores Warehouse is being set aside to store 200 MCOs and 1000 baskets to accommodate differences in fabrication and fuel movement schedules. In addition, the Hanford Site Central Stores Warehouse has enough space available to store all 400 MCOs and 2170 baskets if necessary.

Each MCO component and baskets will be shipped in one of eight crate configurations. Table 1 identifies the size and contents of these crates.

Table 1. Shipping Crates

Crate	Contents	Size (H x W x L)	Items per Crate	Estimated Weight per Crate, lbs.	Total # of Crates to be Stored	Total # of Crates
1	Baskets	36" x 36" x 48" ⁽¹⁾	2	1250	500	1085
2	Shells with Locking and Lifting Rings ⁽⁴⁾	36" x 96" x 168" ⁽⁴⁾	2	6000	24	24
3	Shell with Locking and Lifting Ring	36" x 48" x 168" ⁽¹⁾	1	3000	200	352
4	Shield Plug Assemblies	25" x 32" x 32" ⁽³⁾	1	1657	200	400
5	Process Tubes	12" x 12" x 156" ⁽²⁾	20	450	10	20
6	Cover Assemblies	24" x 36" x 60" ⁽³⁾	2	1050	100	200
7	Helicoflex Seals	24" x 30" x 30" ⁽¹⁾	25 ⁽³⁾	15	8	16
8	Miscellaneous Small Parts	24" x 30" x 30" ⁽¹⁾	10 ⁽³⁾	310	20	40

⁽¹⁾ Maximum size the fabricator is allowed.

⁽²⁾ Recommended size for fabricator; however, the fabricator is not constrained by this.

⁽³⁾ Estimated size; the fabricator is not constrained to a particular size.

⁽⁴⁾ The first 48 MCO Shells with Locking and Lifting Rings will be shipped two to a box.

3.0 HANDLING AT WAREHOUSE

MCO components and baskets will arrive at the Hanford Site Central Stores Warehouse on open, flatbed trucks. Components and baskets will be in crates and movable to their

storage location by forklift. Crates containing the long MCO shells with locking and lifting rings will be stored on the floor of the Hanford Site Central Stores Warehouse. These crates will be stacked up to three crates high to minimize storage space requirements. This floor area is rated at 500 lbs. per square foot.

All other crates containing MCO components and baskets will be stored on storage racks located in the warehouse. Each rack storage level is designed to support 4000 lbs. per rack section.

3.1 Incoming MCO Components and Baskets

The MCO components' manufacturer ships all incoming components to the Hanford Site Central Stores Warehouse. Receipt inspection acceptance of the MCO components will be performed and then the components will be placed in the storage location designated for the particular component.

The baskets are being fabricated at the Hanford site and will be packaged and shipped to the Hanford Site Central Stores Warehouse. The MCO baskets will be inspected at the fabrication shop by MCO Basket Subproject Quality Control personnel before shipment to the Hanford Site Central Stores Warehouse for storage. The baskets will be placed directly into the storage location designated for baskets. No receipt inspection acceptance is required for the baskets.

At the Hanford Site Central Stores Warehouse, each crate will be logged into the PassPort computerized tracking system for identification and proper selection of components. Crates will be withdrawn based on component serial numbers, where applicable, or by requested crate as designated by SNF Operations. Materials Management will retain records prepared during the receiving process per governing Hanford site procedures and copies will follow the parts up to usage.

3.2 MCO Components and Baskets – Segregation and Storage

MCO Components and baskets will be separated based on the determined packaging and storage conditions for the given component or basket, or other warehouse constraints. The Hanford Site Central Stores Warehouse management will ensure that components and baskets are arranged and tracked so that withdrawal of specified sets of components and baskets for given shipments to SNF Operations can be rapidly performed.

Cleanliness control and storage of all MCO components and baskets will be maintained in accordance with applicable NQA-1 requirements (Reference 4). Storage records are to be maintained and will be held by Materials Management; copies will follow the components and baskets up to usage.

3.3 Outgoing MCO Components and Baskets

On demand from SNF Operations, the warehoused MCO components and baskets will be collected for transport to the CSB and K Basins as required.

Transportation from the warehouse, unwrapping, and assembly of the MCOs are the responsibility of SNF Operations.

4.0 QUALITY ASSURANCE REQUIREMENTS

Inspection of MCO components and baskets for compliance with fabrication and packaging requirements will be completed at the fabrication site to verify compliance with applicable fabrication specification requirements.

4.1 Incoming MCO Components Inspection

Documentation of QA performed at the manufacturer will accompany each shipment of MCO components. The MCO components will be received at the Hanford Site Central Stores Warehouse, at which time a receipt inspection will be performed by QA to verify the number of components, to identify any damage during shipping, and to assure that the document package is included with the shipment as specified by the governing Quality Assurance Inspection Plan. These inspections will be documented. All deficiencies will be noted in a nonconformance report for each shipment.

4.2 Incoming Baskets Inspection

Baskets, which are fabricated onsite, do not require receipt inspection at the Hanford Site Central Stores Warehouse. The baskets will be placed directly into storage when they arrive at the warehouse.

4.3 Storage Area Oversight

Semi-annual surveillance of the storage areas for the MCO components and baskets will be performed by the MCO Basket Subproject Quality Assurance personnel to assure that storage area requirements are maintained in accordance with the requirements of ASME NQA-1, Subpart 2.2 (Reference 4) and this Plan.

5.0 INVENTORY CONTROL

The PassPort¹ system will be used to track MCO components as they are stored in the Hanford Site Central Stores Warehouse. Each crate containing MCO components and baskets will be assigned a unique catalog identification number that will be logged into the PassPort computerized tracking system for identification and proper selection of components. A material request, which will have the serial numbers of the MCO components or baskets listed in the title field, will identify the crates to be pulled from stock. When crates are shipped from the warehouse, pack slips will be generated by the PassPort system. The pack slip will accompany the crates identifying the components or baskets, and their individual component serial numbers (when applicable) for proper MCO assembly by others.

5.1 Tracking of MCO Components and Baskets

For all received and outgoing MCO components and baskets, entries in the Passport database will be made. SNF Operations will indicate the necessary

¹PassPort is a trademark of Computer Security Products, Inc.

MCO components or baskets on outgoing shipments by serial number (when applicable), or by crate type, for issue when needed. Careful referencing of the serial numbers on parts (where applicable) will be recorded on the material requests when the components are prepared for shipment.

5.2 MCO Components and Baskets Supplies

The facilities consuming MCO components and baskets will coordinate with the Hanford Site Central Stores Warehouse to maintain a constant supply of these parts at the staging/assembly areas.

6.0 MCO COMPONENT WAREHOUSE SPACE COST

The Hanford Site Central Stores Warehouse is funded under Site Services. Therefore, there are no direct storage and handling costs for use of the Hanford Site Central Stores Warehouse to receive and store MCO components and baskets. Costs to transport MCO components and baskets from the Hanford Site Central Stores Warehouse to the K Basins or CSB are the responsibility of SNF Operations.

The Hanford Site Central Stores Warehouse services may be required to vacate the 1163 facility during this warehousing plan. Materials Management has been required to develop and submit a vacate plan to include contingencies. The plan identifies three options for relocating current Hanford Site Central Warehouse Operations. If this vacate plan is initiated, a storage facility has been identified at the Energy Northwest site that will provide the storage needed for the MCO components and baskets. Costs to move MCO components and baskets will be included in the overall costs incurred to relocate Hanford Site Central Stores Warehouse Operations.

7.0 REFERENCES

- 1 DOE/RW-0333P, *Quality Assurance Requirements and Description for the Civilian Radioactive Waste Management Program*, US DOE Office of Civilian Radioactive Waste Management.
- 2 Smith, K. E., *Multi-Canister Overpack Fabrication Specification*, HNF-S-0453, Fluor Daniel Hanford, Inc. Richland, Washington.
- 3 DeVine, D. P., *Specification for Multi-Canister Overpack Basket Fabrication*, HNF-3868, DE&S Hanford, Inc. Richland Washington.
- 4 ASME NQA-1, 1994 Edition, Subpart 2.2, *Quality Assurance Requirements for Packaging, Shipping, Receiving, Storage, and Handling of Items for Nuclear Power Plants*.