

IAEA SAFETY STANDARDS

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Safety of Nuclear Fuel Reprocessing Facilities

DRAFT SPECIFIC SAFETY GUIDE XXX

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New Safety Guide

IAEA

INTERNATIONAL ATOMIC ENERGY AGENCY

FOREWORD
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Director General

EDITORIAL NOTE

An appendix, when included, is considered to form an integral part of the standard and to have the same status as the main text. Annexes, footnotes and bibliographies, if included, are used to provide additional information or practical examples that might be helpful to the user.

The safety standards use the form 'shall' in making statements about requirements, responsibilities and obligations. Use of the form 'should' denotes recommendations of a desired option.

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DRAFT

1. INTRODUCTION

BACKGROUND

1.1. This Safety Guide on the Safety of Nuclear Fuel Reprocessing Facilities recommends how to meet the requirements established in the Safety Requirements publication on the Safety of Nuclear Fuel Cycle Facilities (Ref. [1]) and supplements and develops those requirements.

1.2. The safety of nuclear fuel reprocessing facilities¹ is ensured by means of their proper siting, design, construction, commissioning, operation including management, and decommissioning. This Safety Guide addresses all these stages in the lifetime of a reprocessing facility as defined in (Refs. [1] and Ref. [1]: Appendix IV), on an industrial scale, with emphasis placed on the safety of their design and operation.

1.3. The radioactivity and radio-toxicity of spent fuel, dissolved spent fuel, fission product solutions, and of plutonium and its solutions is high. Close attention should be paid to ensuring safety at all stages of reprocessing spent fuel. Uranium, plutonium and all waste from reprocessing facilities should be handled, processed, treated and stored safely, to maintain low levels of radiation and minimizing radioactive discharges to the environment and limiting the potential impact of accident on workers, the public and the environment.

OBJECTIVE

1.4. The objective of this Safety Guide is to provide recommendations that, in light of experience in Member States and the present state of technology, should be followed to ensure safety for all stages in the lifetime of a reprocessing facility. These recommendations specify actions, conditions or procedures necessary for meeting the requirements established in (Ref. [1]). This Safety Guide is intended to be of use to designers, operating organizations and regulators for ensuring the safety of reprocessing facility facilities.

SCOPE

1.5. This Safety Guide provides recommendations on meeting the requirements established in (Ref. [1]: Sections 5–10 and Appendix IV). The safety requirements applicable to fuel cycle facilities (i.e. facilities for uranium ore processing and refining, conversion, enrichment, fabrication of fuel including mixed oxide fuel, storage and reprocessing of spent

¹Referred to in this document as “reprocessing facilities”.

fuel, associated conditioning and storage of waste, and facilities for the related research and development) are established in (Ref. [1]). The requirements specifically applicable to reprocessing facilities are established in (Ref. [1]: Appendix IV).

1.6. This Safety Guide deals specifically with:

- The handling of spent fuel;
- Shearing² or decladding³ and dissolution of spent fuel;
- Separation of uranium and plutonium from fission products;
- Separation and purification of uranium and plutonium;
- Production and storage of plutonium and uranium oxides as a feed material to form ‘fresh’ mixed oxide fuel rods and assemblies (MOX), and;
- The initial treatment and handling of the various waste streams.

1.7. The fuel reprocessing processes covered by this Safety Guide are a mixture of high and low hazard, wet and dry processes, including high hazard fine particulate processes and hazardous solid, liquid, gaseous and particulate (dry, air and water borne) wastes and effluents.

1.8. This Safety Guide is limited to the safety of reprocessing facility’s themselves. It does not deal with any impact that the products have on safety for the reactors in which they are to be used or the ancillary process facilities in which wastes and effluents are conditioned, treated, stored or disposed except in so far as all wastes produced should comply with the requirements of (Refs. [1]: paras. 6.31-32, 9.54-9.57, Appendix IV: paras. IV.49-50, IV.80-82 and [8]).

1.9. The implementation of other safety requirements such as those on the legal and governmental framework and regulatory supervision as established in (Ref. [2]). Those on the management system and the verification of safety as established in (Ref. [3]), are not addressed in this Safety Guide. Recommendations on meeting the requirements for the management system and for the verification of safety are provided in (Ref. [4]).

1.10. Sections 3–8 of this Safety Guide provide recommendations on radiation protection measures for meeting the safety requirements established in (Ref. [5]). The recommendations

²Shearing: Cutting spent fuel into short lengths to allow dissolution inside the metallic cladding

³Decladding: Removing the metallic cladding of the spent fuel prior to dissolution.

in this Safety Guide supplement the recommendations on occupational radiation protection provided in (Ref. [6]).

STRUCTURE

1.11. This Safety Guide consists of eight sections and two annexes. These sections follow the general structure of (Ref. [1] and Ref. [1]: Appendix IV). Section 2 provides general safety recommendations for a reprocessing facility. Section 3 describes the safety aspects to be considered in the evaluation and selection of a site to avoid or minimize any environmental impact of operations. Section 4 on safety considerations at the design stage including safety analysis for operational states and accident conditions the safety aspects of radioactive waste management in the reprocessing facility and other design considerations. Section 5 addresses the safety aspects in the construction stage. Section 6 discusses safety considerations in commissioning. Section 7 provides recommendations on safety during operation of the facility, including the management of operations, maintenance, inspection and periodic testing, control of modifications, criticality control, radiation protection, industrial safety, management of waste and effluents, and emergency planning and preparedness. Section 8 provides recommendations on meeting the safety requirements for preparing for the decommissioning of a reprocessing facility. Annex I shows the typical process routes for a reprocessing facility. Annex II provides examples of structures, systems and components important to safety in reprocessing facilities, grouped in accordance with processes in Annex I.

1.12. This Safety Guide contains guidance specific to reprocessing facilities. The recommendations in this guide have been referenced to the corresponding requirements in (Ref. [1]) and other IAEA Safety Standards, where this does not destroy the readability of the text. This Safety Guide covers all the important stages in the lifecycle of a reprocessing facility, including site evaluation, design, construction, commissioning, operation, and preparation for decommissioning. It also considers modifications, maintenance, calibration, testing and inspection as well as emergency preparedness where there is specific guidance. Reference should be made to the referenced documents and other IAEA standards for requirements and guidance on generic topics (such as radioactive wastes or security) that are not specific to reprocessing facilities, in accordance with the structure of the publications for nuclear facilities and operations, prepared by the IAEA.

2. GENERAL SAFETY GUIDELINES FOR A REPROCESSING FACILITY⁴

2.1. In reprocessing facilities, large quantities of fissile, radioactive and other hazardous materials are present (stored, processed and generated) often in easily dispersible forms (e.g. solutions, powders and gases) and sometimes subjected to vigorous chemical and physical reactions. The main risks are criticality, loss of confinement and radiation exposure from which workers, the public, and the environment need to be protected by adequate technical and administrative measures provided during siting, design, construction, commissioning, operation and decommissioning.

2.2. Reprocessing facilities have the potential for serious or major accidents with significant quantities of radioactive material. The potential nuclear and radiation hazard of reprocessing facilities should be considered when implementing the graded approach concept to the facility as detailed in (Ref. [1]: Section 1).

2.3. In normal operation reprocessing facilities produce significant gaseous and liquid effluent volumes with a variety of radioactive and chemical constituents. The facility's processes and equipment should be designed and operated to reduce and recycle these effluents as far as possible and discharges should be optimized by the addition of specific engineering features to remove and reduce activity and toxic chemical levels. The facility (with any associated effluent treatment facilities) should monitor and report discharges and, as a minimum, comply with all regulatory discharge limits (Ref. [8]).

2.4. The specific features of reprocessing facilities that should be taken into account for meeting the safety requirements specified in (Ref. [1]) are:

- The wide range and nature of radioactive source terms;
- The wide range and nature of process chemicals and their reaction;
- The range and nature of fissile material, i.e. criticality in both liquid and solid systems;
- The range of dispersible forms of material present includes:
 - Particulates;
 - Solids: contaminated items, scrap etc.;
 - Liquids: aqueous, organic;
 - Gaseous and volatile species.

⁴ The requirements relating to the safety guidelines for a reprocessing facility are established in (Ref. [1]: Section 2)

2.5. These specific features associated with reprocessing facilities result in a broad range of hazardous conditions and possible events that need to be considered in the safety analysis to assure that they are adequately prevented, detected and/or mitigated.

2.6. For the implementation of defense-in-depth (Ref. [1]: Section 2), the first two levels are the most significant; as the risks should be eliminated mainly by design and appropriate operating procedures (see Sections 4 and 7 below). However all levels of defense-in-re should be addressed (Ref. [1]: paras. 2.4-2.8).

2.7. The design, construction and operation of a reprocessing facility are complex and require well-demonstrated process technologies and engineering knowledge. Reprocessing facility engineering solutions adopted to ensure reprocessing facility safety should be of high quality, proven by previous experience or rigorous (in accordance with a graded approach) tests, research and development, or experience of operating prototypes. This strategy should be applied during the design of the reprocessing facility, development and design of equipment, the construction, operation, modification and preparations for decommissioning of the reprocessing facility, including any upgrading and modernization.

2.8. Due to the anticipated long lifetime of industrial scale reprocessing facilities and taking into account the specific mechanical, thermal, chemical, and radiation conditions of the processes, the potential for ageing and degradation of SSCs requires particular attention, especially for those components judged difficult or impracticable to replace. In selecting and designing reprocessing facility SSCs the processes that could cause the degradation of structural materials should be taken into account. Programmes should be developed and implemented to detect and monitor ageing and degradation processes. These should include provisions for monitoring, inspection, sampling, surveillance and testing and, to the extent necessary, specific design provisions and equipment for inaccessible SSCs.

2.9. Reliability of process equipment should be ensured by application of a rigorous management system (quality assurance and quality control) during specification, procurement, manufacturing, storage (if necessary) and, installation. Inspection and testing should be against unambiguous, established performance standards and expectations

2.10. The control and instrumentation of safety-related systems (facility control system, indicating and recording instrumentation, alarm and communications systems) are very important to reprocessing facility safety. Adequate and reliable controls and appropriate instrumentation should be provided to maintain variables within specified ranges. Where computers or programmable devices are used in safety-related systems, evidence should be

provided that the hardware and software are designed, manufactured, installed and tested appropriately⁵.

2.11. All reprocessing facilities should have alarm systems to initiate full or partial facility evacuation in the case emergencies (criticality, fire, high radiation, etc.).

2.12. Careful consideration should be given to human factors, in control rooms, remote control stations and work locations. This consideration should extend not only to controls, alarms and indicators related to structures, systems and components (SSCs) important to safety and operational limits and conditions (OLCs) but to all control, indication and alarms systems and the control room(s). The ability of operators to clearly interpret and respond decisively to developing situations in the facility is crucial to safety.

2.13. Utility supply services are necessary to maintain the reprocessing facility safety systems in an operational state at all times, and they may also provide services to safety-related systems. It is essential that services for reprocessing facility safety systems should be designed so that, as far as possible, the simultaneous loss of both normal and back-up services will not lead to unacceptable consequences. This should be achieved by a combination of robust design including diverse and redundant supplies. Wherever possible the consequences of loss of motive power to valves etc. should be assessed and the item designed to be “fail-safe”.

2.14. The situations when “shut-down” of the reprocessing facility process is necessary to put the facility in a safe and stable state (no movement or transfer of chemicals and/or fissile materials) should be analyzed, well defined in procedures in accordance with the assessment performed and implemented, depending on the nature or urgency of the hazard or risk. Such situations include potential critically sequence, natural or man-made internal or external events. The subsequent recovery sequences should be similarly analyzed, defined and implemented in a timely manner e.g. the managed recovery/ reduction of fissile material in a multi-stage contactor⁶.

2.15. To maintain the facility in a safe state, some systems should continuously operate or should be restarted within a defined delay after their loss e.g.:

2.16. Active heat removal systems in storage areas to remove decay heat;

2.17. Dilution (gas flow) systems to prevent hazardous hydrogen concentration;

2.18. Safety significant control, instrumentation and utility supply systems.

⁵I.e. In accordance with the established management system. For software this should include verification and validation

⁶Contactors: a liquid-liquid extraction device.

3. SITE EVALUATION⁷

3.1. The site evaluation process for a reprocessing facility will depend on a large number of criteria, which should be ranked in order of safety significance. At the earliest stage of planning a facility, a list of these criteria should be prepared, in accordance with their safety significance, to serve as basis for selecting a list of candidate site. As a minimum all sites chosen must meet those criteria judged essential. In most cases, it is unlikely that a single site can meet all the desirable criteria, and the risks posed by possible, safety significant, external initiating events (e.g. earthquakes, aircraft crashes, fires and extreme weather conditions) will probably dominate the final site evaluation process.

3.2. The potential for releases of radioactive and chemical materials in a reprocessing facility as well as radiation impact during normal operational state and accidental conditions can be larger than from other fuel cycle facilities. For a reprocessing facility potentially significant discharges include:

- Liquid discharges of hazardous materials (radioactive and chemical);
- Liquid borne radioactive particulate or dispersed solvent droplets;
- Gaseous or volatile radioactive material discharges;
- Airborne radioactive or chemotoxic particulate materials.

3.3. Appropriate design and operation should ensure that gaseous, liquid, and particulate releases and direct radiation levels are tolerable⁸ under normal operating conditions. The major hazards in accident conditions that need to be considered are the potential release of highly radioactive gaseous or particulate materials or finely divided plutonium compounds to the atmosphere, in addition the potential for direct radiation due to shielding loss, bulk radioactive material loss or criticality.

3.4. The source terms considered in site selection should include provision for the treatment and interim storage of waste products produced during the lifetime of the facility and for the eventual decommissioning of the facility.

⁷ The requirements and generic guidelines relating to site evaluation for a reprocessing facility are established in (Refs. [1]: Section 5, Appendix IV: para. IV.1, [10], [11], [15], and [16])

⁸Broadly acceptable against national criteria taking into account the site characteristics (dispersion, demographics, environmental conditions etc.).

3.5. The facility design should be optimized taking into account the site characteristics for all potential facility states and the long-term and cumulative impact of the facilities operations.

3.6. The characteristics of the site including the demographic, geological, meteorological and hydrological conditions relevant to the reprocessing facility safety should be monitored from the beginning of the project and over the lifetime of the reprocessing facility (Refs. [10], [11], [15], and [16])

3.7. As reprocessing facilities have long lifetimes and complex decommissioning challenges, consideration should be given to anticipating future changes to site characteristics and the emergency zones (operating, shutdown, decommissioning) for the facility.

INITIAL EVALUATION AND SELECTION

3.8. At the earliest stage of planning a facility, a list of natural and man-induced processes, phenomena and factors and their safety significance should be identified in accordance with safety requirements (Refs: [1] and [1]: Appendix IV).

3.9. Databases on site processes, phenomena and factors at the reprocessing facility site should be provided and continuously updated. The results of site suitability assessments and the decisions taken for siting and the reasons behind those decisions should be fully recorded and kept readily available for the lifetime of the facility.

3.10. National requirements should define essential and desirable siting requirements. Generally a site is considered to be suitable for siting a reprocessing facility if the following conditions are met (as a minimum):

- Compliance with environmental, health and civil defense legislation, fire safety requirements and security requirements;
- Location within the boundaries of a tectonic block, that is not affected by active faults and geodynamic areas;
- Within limit of intensity of maximum earthquake for a site according to national legislation;
- Acceptable long-term stability of the host rock related to transfer and migration of radioactive substances (groundwater);
- Within limit of the possible maximum flood height according to national legislation.

Where necessary the magnitude of external events should be evaluated in accordance with (Refs. [11], [15], and [16]).

3.11. Where all the desirable siting criteria cannot be met, technical and organizational measures to ensure reprocessing facility safety should be provided. The design and operation should accommodate the hazards of operational states and accidental conditions (e.g. earthquake, aircraft crash, fire, extreme weather conditions) relevant to the specific reprocessing facility site characteristics (Refs. [10], [11], [15], and [16]).

3.12. For siting new reprocessing facilities and for operating reprocessing facilities, the site features, which could affect reprocessing facility safety and the factors related to the people and environment that could be adversely affected by reprocessing facility operation, should be surveyed and evaluated in sufficient depth. Account should be taken of all relevant factors that might affect the protection of individuals and populations from radiological risk when assessing the siting of a new facility. Natural and man-made external hazards should be considered if they have the potential to adversely affect the siting decision.

3.13. The factors that should be considered in assessing acceptability of the reprocessing facility site should include the following aspects:

- External natural and man-induced processes, phenomena, and factors at reprocessing facility site and their parameters (Refs. [10], [11], [15], and [16]);
- Potential impacts by existing or planned chemical and (or) nuclear hazardous facilities on the reprocessing facility site;
- Information on local physical data relevant to the dispersion of released radioactivity and its potential effects on people;
- The physical factors affecting the dispersion and accumulation of released radioactivity and the radiological risk to people;
- The location and characteristics of the population around the site;
- The suitability of the site for the engineering and infrastructure requirements of the facility, including capabilities of safe and secure on-site and off-site transport of nuclear fuel, other radioactive and chemical materials (including products if required) and radioactive waste;
- Feasibility of implementation of emergency plans, including evacuation of the personal and population from the affected areas and access for local and national emergency response;

- Security requirements.

3.14. The site's ability to accommodate normal operational releases is of specific importance for reprocessing facilities.

3.15. Engineering and infrastructure criteria that are important for reprocessing facility siting includes the provision of utility supply services (e.g. water, reliable power), transport infrastructure (e.g. railways, roads) and external support and supplies in the case of emergency (including diversity of water supplies).

3.16. The following reprocessing facility site characteristics should be evaluated in accordance with (Refs. [10], [11], [15], and [16]):

- Environmental conditions:
 - Natural phenomena and processes:
 - Geological processes and phenomena such as seismic and tectonic conditions,
 - Hydrological and meteorological processes and phenomena such as flooding, tsunami, coastal processes, tornado, wind, atmospheric precipitation, extreme weather conditions, snowfall, glaze-ice, lightning, etc.
 - Topographical and geotechnical conditions, such as the ground, bearing capacity of soil, faults, erosion, subsidence and deformation of soils, etc.
 - Water and hydraulic conditions, such as rivers, groundwater, etc.
 - Man-made phenomena and processes:
 - Aircraft crashes;
 - Missiles from adjacent facility;
 - External fires,
 - Explosions;
 - Release of explosive, flammable and toxic gases and aerosols, corrosive liquid into surface and groundwater;
 - Transportation routes and their uses;
 - Social conditions such as the demographic situation and population distribution, water use, production and distribution of foodstuffs, etc.

3.17. A reprocessing facility should be sited, designed, constructed, operated and decommissioned considering the identified potential external and environmental impacts of the site.

3.18. Safety of reprocessing facility should be justified for design basis external events⁹ and assessed for beyond design basis external events e.g. for a beyond design basis external earthquake (Refs. [10], [11], [15], and [16]). The interrelation and interdependence of the external and internal impacts should be taken into account. The behavior of SSCs that provide significant mitigation under beyond design basis external event conditions should be evaluated and checked for sufficient safety margin¹⁰ and the possibility of worthwhile changes to increased safety margin and to avoid “cliff-edge¹¹” effects.

3.19. On multi-facility reprocessing facility sites, the hazards from interactions between facilities on the site should be taken into account (see para 3.17). Any hazardous installations that might be affected by an incident at the reprocessing facility should be considered and the possible “domino” effect that might, in turn, have on the reprocessing facility.

ONGOING SITE EVALUATION

3.20. The site characteristics should be appropriately monitored and systematically evaluated during the reprocessing facilities life-cycle. Periodic, on-going site evaluation should be provided of the parameters for natural processes and phenomena and man-induced factors incorporated in the design basis.

3.21. The ongoing site evaluation for reprocessing facility life-cycle should cover the site specific characteristics that are important for safety. These site characteristics should include:

- Meteorological (e.g. precipitation, wind speed/direction, air temperature, humidity);
- Geological and geotechnical (e.g. earthquake zoning, tectonic movement, erosion and surface processes);
- Hydrological (e.g. level of water table, ground water migration);
- Geotechnical (e.g. ground stability, sea coast erosion progression), and;
- Demographic data.

3.22. Any foreseeable variations in the site evaluation data (e.g. planned significant industrial development, infrastructure or urban developments) during the expected life-cycle of a reprocessing facility site should be identified and taken into account. The safety review (periodic safety review or equivalent) should be revised to take account of on- and off-site

⁹See (Ref. [14]) for definitions of these terms.

¹⁰Safety margin: the gap between the stress imposed by DBA level event and the predicted failure point of the SSC.

¹¹Cliff-edge: the sudden, significant loss of the protection or mitigation provided by a SSC for a small change in the imposed “load” or “stress” (i.e. facility condition).

changes that could affect safety on a reprocessing facility site considering ongoing site evaluation data and the development of scientific knowledge and evaluation methodologies.

4. DESIGN¹²

GENERAL

Basic safety functions for reprocessing facilities

4.1. The basic safety functions (Ref. [1]: Appendix IV: para. IV.2) i.e. those functions, the loss of which, may lead to exposure to or releases of radioactive material having possible radiological consequences for workers, the public or the environment are those designed for:

- 1) Confinement of radioactive materials (including removal of decay heat);
- 2) Protection against external exposure;
- 3) Prevention of criticality.

The basic safety functions are further developed in (paras. 4.13-4.56).

Specific engineering design guidance

4.2. The design of reprocessing facilities, because of their expected long service life, substantial inventory of radioactive and radiotoxic materials, including the potential for criticality, aggressive physical and chemical processes, should be based upon the most rigorous application of (Ref. [1]: Section 6) as a high hazard facility, and should pay particular attention to the re-use and recycling of materials to reduce discharges and waste generation.

4.3. For reprocessing facilities, in particular protection of the public and the environment, for normal operations, relies on robust, efficient and effective facility design, particularly for the minimization of effluent arisings and the pre-disposal or pre-discharge treatment of effluents.

4.4. For abnormal states the protection of people and the environment should mainly rely on the prevention of accidents by robust and fault tolerant design providing defense in depth in accordance with a graded approach.

4.5. The following considerations apply:

- The requirements on confinement of radioactive materials as established in (Ref. [1]:

¹² The requirements relating to design for a reprocessing facility are established in (Ref. [1]: Section 6 and Appendix IV: paras. IV.2-IV.52)

paras. 6.37–6.39, 6.52, 6.53 and Appendix IV: IV.21–IV.25). During normal operation, internal dose is avoided by design and the use of personal protection (personal protective equipment, (Ref. [5])) should be avoided as far as possible;

- The requirements on protection against external exposure are established in (Ref. [1]: paras. 6.40–6.42 and Appendix IV: IV.26–IV.30). Owing to the radiation fields associated with high beta-gamma activity, alpha activity and neutron emissions including plutonium, appropriate combinations of requirements on source limitation, shielding, distance and, time are necessary for the protection of workers. Experience in a number of Member States has emphasized the need to pay particular attention to the provisions for maintenance operations.
- The requirements on prevention of criticality as established in (Ref. [1]: paras. 6.43–6.51 and Appendix IV: IV.9 –IV.20). All processes with fissile materials are designed in such a way as to prevent criticality accidents.
- The design requirements on provisions for decommissioning of a reprocessing facility defined in (Ref. [1]: paras. 6.35 and 6.36) should be strictly implemented due to their long operational life, large throughput of radioactive and radiotoxic materials and the cumulative effects of modifications etc.

Other engineering design guidance

4.6. In large and complex facilities such as reprocessing facilities, the design authority should develop a set of standardized designs and conditions for their use, based upon proven experience that can be applied to a wide range of applications. The assessment step should be then to verify the application conditions of these standardized designs. For example, standardized designs should be applied to assure the continuity and integrity of containment, the ventilation of potentially contaminated areas, the transfer of highly active liquids, and the maintenance activities of reprocessing facility units.

4.7. Reprocessing facilities are complex facilities of long operational life, provisions to allow for on-site repair of major equipment should be anticipated as far as reasonably achievable (e.g. space reservation for remote operation, 3D data of the equipment and hot cells etc.).

4.8. The extensive, complex, continuous, multi-stage nature of a reprocessing facility with numerous supporting inter-related ancillary processes, including waste and effluent treatment, with limited buffer between sub-processes and the potential for the fairly rapid development

of some faults place particular emphasis on the application of the ergonomic and human factor requirements stated in (Ref. [1]: paras 6.15 and 6.16).

Design basis accidents, design basis external events and safety analysis

4.9. The definition of a design basis accident (DBA) and design basis external (DBE) event, in the context of fuel cycle facilities, can be found in (Ref. [1]: Annex III: para. III-10). The safety requirements relating to DBAs and DBEs are established in (Ref. [1]: paras. 6.4–6.9).

4.10. The specification of a DBA or DBE (or equivalent) will depend on the facility design and national criteria. However, particular consideration should be given to the following hazards in the specification of design basis accidents for reprocessing facilities:

- Loss of cooling;
- Explosion;
- Nuclear criticality accident;
- Fire;
- External events such as natural phenomena (earthquake, flooding, or tornadoes, etc.);
- Loss of electrical power;
- Aircraft crash.

The events listed in above may occur as a consequence of a postulated initiating event (PIE), selected PIEs are listed in (Ref. [1]: Annex I).

4.11. Reprocessing facilities are characterized by a wide diversity of radioactive materials distributed throughout the facility and by the number of potential events that may result in radioactive releases the environment with the potential for public dose. Therefore, in addition to the use of the DBA concept, operational states and accident conditions of each reprocessing facility process should be assessed on a case by case basis (Ref. [1]: para. 6.9 and Annex III: para. III-10 and III-11).

Structures, systems and components¹³ (SSCs) important to safety

4.12. The likelihood of the design basis accidents (or equivalent) should be minimized, and any associated radiological consequences should be controlled by means of SSCs important to safety (Ref. [1]: paras. 6.5–6.9 and Annex III). Annex II of this Safety Guide presents

¹³SSCs: A general term encompassing all of the elements (items) of a *facility* or *activity* which contribute to *protection and safety*, except *human factors*. **Structures** are the passive elements: buildings, vessels, shielding, etc. A **system** comprises several **components**, assembled in such a way as to perform a specific (active) function. A **component** is a discrete element of a *system* (Ref. [14]).

examples of structures, systems and components and representative events that may challenge the associated safety functions.

SAFETY FUNCTIONS

Confinement of radioactive materials

*Static and dynamic confinement*¹⁴

4.13. “Containment shall be the primary method for confinement against the spread of contamination” (e.g. in areas where significant quantities of radioactive materials are held). “Confinement shall be provided by two complementary containment systems — static (e.g. physical barrier) and dynamic (e.g. ventilation)” (Ref. [1]: Appendix IV: paras IV.21 and IV.22).

4.14. The first static barrier normally consists of process equipment, vessels and pipes, and, in some cases, gloveboxes. The second static barrier normally consists of cells around process equipment or when glove boxes are the first containment barrier of the primary containment, the rooms around the glove boxes itself. The design of the static containment system should take into account openings between different confinement zones (e.g. doors, instrument or pipe penetrations). These openings should be designed with care to ensure that confinement is maintained during operation, especially maintenance (e.g. provision of permanent (or provision for installing temporary) additional barriers (Ref. [1]: Appendix IV: paras. IV.22 and IV.28).

4.15. Reprocessing facilities should be designed to retain liquid leakage from process equipment, vessels and pipes and to recover the volume of liquid to the primary containment (Ref. [1]: Appendix IV: para. IV.38). It is particularly important to pay special attention in both design and operation situations where the first static barrier provides other safety duties e.g. favorable geometry for criticality avoidance or exclusion of air for flammable liquids etc. Great care should be taken when dealing with spills or leaks from liquids streams with high fissile content and to consider effects such as crystallization due to cooling or evaporation of leaked liquors.

4.16. To complement the effectiveness of the static barriers, dynamic containment systems should establish a cascade of pressure between the environment outside the building and the contaminated material inside and across all static barriers within the building as far as possible.

¹⁴ The requirements relating to confinement for a reprocessing facility are established in (Ref. [1]: paras. 6.38 and Appendix IV: paras. IV.21-IV.25).

4.17. The ventilation systems should include, as a minimum, both building (cells and rooms) ventilation system and process equipment (e.g. vessels in a cell) ventilation system.

4.18. The building ventilation systems, including duplication¹⁵, filtration and other discharge control equipment, should be designed and assessed according to the type and design of static barriers (cells, gloveboxes, building), the classification of areas according to the hazards, the nature of potential airborne contamination and the requirements for maintenance (Ref. [1]: Appendix IV: para. IV.23).

4.19. The process equipment ventilation system(s) that creates the lowest pressure within the facility collects and treats most of radioactive gas and particulates generated by the processes. Careful attention should be paid to the need to install effective washing, draining and collection systems to reduce the build-up of contamination and activity and facilitate future decommissioning.

4.20. All filtration stages of the ventilation systems which require testing should be designed in accordance with accepted standards such as those of the International Organization for Standardization (ISO) and the American Society of Mechanical Engineers (ASME), (Ref. [1]: Appendix IV: para. IV.25).

4.21. For the portions of the process involving powders, primary filters should be located as close to the source of contamination as practical (e.g. near the gloveboxes) to minimize the potential build-up of powders in the ventilation ducts. Particular care should be taken with fissile material powders where ventilation duct manifolds may be of less favorable geometry (Ref. [1]: Appendix IV: para. IV.25).

4.22. On-line and standby fans should be provided according to the safety assessment results (Para. IV.27 of Annex III). Alarm systems should be installed to alert operators to system malfunctions resulting in high or low differential pressures. (Ref. [1]: Appendix IV: para. IV.23).

4.23. Fire dampers, to prevent the propagation of a fire through ventilation ducts and to maintain the integrity of firewalls¹⁶, should be installed unless the likelihood of a fire spreading or the consequences of such a fire are acceptably low (Ref. [1]: Appendix IV: para. IV.36).

4.24. At the design stage, provision should be made for the installation of equipment to monitor airborne radioactive material (Ref. [1]: Appendix IV: para. IV.26). The system

¹⁵To permit continuous availability during maintenance, filter changes etc.

¹⁶ Engineered feature specifically designed to prevent, limit or delay the spread of fire

design and the location of monitoring points should be chosen to taking into account the following factors:

- The most likely locations of workers;
- Airflows and air movement within the facility;
- Evacuation zoning and evacuation routes;
- The use of mobile units for temporary controlled areas, e.g. for maintenance.

Protection of workers

4.25. The static barriers (at least one between radioactive materials and operating areas) normally protect workers. Their design should be specified so as ensure the integrity and effectiveness. Their design specifications should include e.g. weld specifications; selection of materials; leak-tightness, specification of penetration seals for electrical and mechanical penetrations; ability to withstand seismic loads, and as appropriate; the ease of carrying out maintenance work (Ref. [1]: Appendix IV: para. IV.21).

4.26. By supplementing the static barriers, dynamic containment systems should be used to minimize the radiation exposure of workers and their exposure to hazardous gases or material that could become airborne in the facility.

4.27. For regularly maintained or accessed items (sampling stations pumps etc.) consideration should be given to their installation in shielded bulges¹⁷ or gloveboxes, adjacent to process cells where required, depending upon the radiation type and level. These reduce the local radioactive inventory and allow for special washing or decontamination features. Their provision should be balanced against the need to obtain representative samples (short sample lines etc.) and the additional waste for decommissioning.

4.28. Where easily dispersed medium active (MA) materials are processed gloveboxes are often the design solution. These should be welded stainless steel enclosures with windows (of suitable materials), arranged either singly or in interconnected groups. Access to equipment inside the glovebox is through holes (ports) fitted with gloves which maintain the containment barrier. Seals on glove box window etc. should be capable of testing for leak tightness in operation and gloves should be replaceable without breaking containment.

4.29. For normal operation, the need for personal protective respiratory equipment should be minimized through careful design of static and dynamic containment systems and of

¹⁷Bulge: typically a shielded, stainless steel, windowless, glovebox type enclosure with mechanically sealed openings to allow for the remote removal of items into shielded transport flask via a shielded docking port.

devices for the immediate detection of low levels of airborne radioactive material¹⁸ see para. 4.25 (Ref. [1]: Appendix IV: para. IV.21).

Protection of the environment

4.30. To the extent required by safety analyses all engineered ventilation discharge points should be equipped with airborne activity reduction equipment designed to provide protection during normal, abnormal and within DBA accident conditions. As far as practicable, the final stage of treatment should normally be located close to the point at which discharges to the environment occurs.

4.31. According to national safety requirements and a graded approach, the design of reprocessing facilities should also provide measures for the uninterrupted monitoring and control of the stack exhaust(s)¹⁹ and for monitoring of the environment around the facility (Ref. [1]: Appendix IV: para. IV.32).

Cooling

4.32. Radioactive decay heat, exothermic chemical reactions (e.g. neutralization of basic solution), and physical heating and cooling/condensation processes may result in:

- Boiling of solutions;
- Changes of state e.g. (melting, concentration, crystallization, water content etc.) relevant to radiological or criticality safety;
- Transition to auto-catalytic (e.g. red-oil) or accelerated or run-away chemical reactions and fires;
- Destruction of components of containment barriers;
- Degradation of radiological protection shielding, and;
- Degradation of neutron absorbers or decoupling devices.

The cooling systems should be designed to prevent environmental releases of radioactive material, exposure of workers and the public, and criticality accidents (e.g. for highly active²⁰ (HA) liquid waste storage vessels and PuO₂ containers), (Ref. [1]: Appendix IV: paras. IV.4 and IV.6). Where practicable, passive cooling should be considered during design

4.33. Cooling capacity, the availability and reliability and the need for emergency power supplies for the cooling systems to remove heat from radioactive decay and chemical reactions are defined in the safety analysis, (Ref. [1]: Appendix IV: paras. IV.4 and IV.5).

¹⁸Careful consideration should also be given to the need to discriminate against natural radioactive species (e.g. radon).

¹⁹ Discharges

²⁰ Also referred to as high level (HL) liquid waste.

Prevention of hazardous concentration levels of gases from radiolysis and other hazardous explosive or flammable materials

4.34. Radiolysis in water (including cooling water) or organic material may result in the production and build-up of degradation products. These products may be flammable/explosive or corrosive and may damage containment barriers. A dilution system should be provided to prevent explosive conditions and the subsequent loss of confinement, resulting from radiolysis in vessels as far as practicable. For containers and other systems, design should take into account potential corrosion and gas production (e.g. for PuO₂ powder or Pu contaminated waste), (Ref. [1]: Appendix IV: IV.33).

4.35. Unstable products from exothermic chemical reactions may result in explosions and loss of confinement. Design requirements, guidance contained in international and national standards and international experience should be used to prevent the build-up of explosive products. The design requirements should address the monitoring and alarming of process parameters and the minimization of inventories in order to prevent chemical explosions (e.g. red oils in evaporators, HN₃ in extraction cycles), (Ref. [1]: Appendix IV: para. IV.33).

4.36. Pyrophoric metals (U or Zircaloy particles from fuel breakdown) may cause fires or explosions. The design should avoid their unexpected accumulation and provide an inert environment as necessary (Ref. [1]: Appendix IV: para. IV.33).

Protection against radiation exposure

4.37. The aim of protection against radiation exposure is to maintain the doses below the target mentioned in para. 4.5 (above) by using the following elements, separately or in combination:

- Limiting the source term (as practicable)
- Shielding the source
- Distancing the source from personnel;
- Limiting the exposure time of personnel;
- Using personal radiation protection (torso & organ shields).

4.38. Dose optimization should also take into account operational constraints on the maintenance staff. Nevertheless it is recommended that the use of time limitation as the main method of dose management is minimized, and that routine wearing of personal protective equipment (shielding) should be avoided

4.39. In a high beta-gamma activity facility (HA units), the design of shielding should consider both source term and location. In a medium or low activity facility, a combination of

source term and location, time and shielding should be utilized for protection of workers for both whole body and extremity doses. A general shielding design guide should be to shield as close as possible to the source.

4.40. The requirements for maintenance including examination, inspection and testing should be considered in the design of equipment installed in HA cells paying particular attention to radiation and contamination levels throughout the lifetime of the reprocessing facility (Ref. [1]: Appendix IV: para. IV.28).

- For the mechanical and electrical parts of HA units: the design of the layout and of the equipment should allow for adequate remote maintenance (e.g. master slave manipulators);
- For the transfers of liquids, non-mechanical means (e.g. air lift or jet with disentrainment²¹ capabilities, or fluidic devices as appropriate) should be preferred or the mechanical items should be designed for remote maintenance (e.g. in connection with the use of shielded equipment maintenance flasks²²).

4.41. Source terms should take into account deposition factors inside pipes and equipment, from processed materials and their daughter products: e.g. particulates, activity coating²³ within pipes (HA sections) and gloveboxes (americium). The potential for the accumulation of radioactive material in the process equipment and secondary systems (e.g. ventilation ducting) during operation should be minimized by design or provision made for its removal.

4.42. In a reprocessing facility process control relies (in part) on analytical data from samples. In order to minimize operational exposure, automatic and remote operation should be preferred for the sampling devices, the sample transfer network to the laboratories and the analytical laboratories (Ref. [1]: para. 6.40).

4.43. Based on national and international regulations and the safety assessment, the radiation protection monitoring system consists of principally:

- Fixed gamma/neutron area monitors and stationary “sniffer”²⁴ for activity monitoring in air (beta/gamma, alpha) for access and/or evacuation purposes;
- Mobile gamma/neutron area monitors and mobile sniffers for activity monitoring in air (beta/gamma, alpha) for personnel protection and evacuation purposes during maintenance and at barriers between normal access and controlled areas;
- Workers (personal) monitors consistent with the radiation type.

²¹A system for separating the liquid from the motive air with minimum carry-over (entrainment) of activity in the air stream.

²²Sometimes referred to as a Mobile Equipment Replacement Cask.

²³Called “plate-out” in some Member States

²⁴Air sampling point/head.

To avoid the inadvertent spread of contamination by personnel, control points with contamination monitoring equipment for workers (feet, hands and working suits) should be located at the exit airlocks and barriers from potentially contaminated areas and to the extent practical, as close to workplaces with contamination hazards (Ref. [1]: para. 6.42).

Criticality Prevention

General

4.44. Criticality hazard should be controlled by design as far as practicable (Ref. [1]: para. 6.43 and Appendix IV: para. IV.10). Where a credible hazard cannot be eliminated the application of the double contingency principle for criticality prevention is the recommended, preferred approach (Ref. [1]: para. 6.45).

4.45. The basis for criticality analysis and calculations are usually the selection of a reference fissile material, a selected control mode(s) and the adoption of conservative assumptions:

- A reference fissile material, taking in to account any uncertainties in the fissile isotope content etc., is defined as a conservative bounding case for the actual fissile material being handled or processed (Ref. [1]: Appendix IV: para. IV.12);
- The control modes used (for the actual or reference fissile material) to prevent criticality accidents are mass, geometry (or shape), concentration (fissile content), moderation and neutron absorption (poison), including reflection and interaction (of units) (Ref. [1]: para. 6.46). These parameters are considered both alone and in combination²⁵ to ensure a reprocessing facility design meets criticality avoidance requirements.

4.46. Those system interfaces at which there is a change in the state of the fissile material or in the criticality control mode should be specifically assessed (Ref. [1]: para. 6.48 and Appendix IV: para. IV. 14). Particular care should also be taken to ensure that all transitional, intermediate or temporary states that occur or could reasonably be expected to occur under all operational or DBA accident conditions are assessed.

4.47. When required by the safety analysis, the prevention of the precipitation of fissile material within solutions should be by e.g.:

- The use of interlocks and preventing permanent physical connection from reagents units to the equipment in which fissile material is located;

²⁵No single limiting (worst case) control parameter alone or in combination with any other limiting parameter(s) results in a k_{eff} greater than its specified, maximum, subcritical value.

- Acidification of cooling loops for the equipment containing nuclear material solutions (to prevent precipitation in case of leakage from the cooling loop into the equipment) and consideration of the need for the cooling loops themselves to be meet subcritical design requirements.

4.48. In a number of locations in reprocessing facility the criticality control mode of equipment containing fissile liquid is by, or includes, geometry or shape of the containment. The overall design should provide for any potential leakage to a criticality safe (secondary) containment. This should drain or have an emptying route to criticality safe vessels, depending on the exact design. The evaluation of such designs should include the potential for such leaks to evaporate and crystallize or precipitate either at the leak site or on nearby hot vessels or lines and consider the need for localized drip trays to recover and direct potential liquid leaks away from hot vessels. Level measurement detectors should also be installed in the drip trays to provide additional defense in depth. The evaluation should include the possibility, for small leaks of hot or high concentration liquids, for evaporation or crystallization to occur local to the leak site and should consider the need for frequent inspection, continuous CCTV and adequate lighting.

4.49. The need for additional design provisions to detect leaks or similar events involving liquids containing fissile solids (slurries) or solid (powder) transfer systems should also be carefully considered and appropriate criticality control measures (in accordance with para. 4.45 above) should be considered.

Criticality Assessment

4.50. The aim of the criticality safety assessment, as required in (Ref. [1]: Appendix IV: para. IV.11) is to demonstrate that the design of equipment and the operating conditions in the reprocessing facility are such that the values of controlled parameters are always maintained in the sub-critical range. One method to accomplish is by determining the effective (neutron) multiplication factor (k_{eff}) which depends mainly on the mass, heterogeneity (distribution) of the fissile materials and the moderation, geometry, density, reflection and nuclear properties of fissile materials themselves. The calculated value of k_{eff} including any allowances for statistical errors or other uncertainties is then compared with the subcritical value specified by the design limit²⁶.

²⁶This value is normally set by or agreed with the Regulatory Authority and is commonly (\leq) 0.95 but may vary with the particular reprocessing facility and application within the reprocessing facility.

4.51. The methods of calculation vary widely in basis and form, and each has its place in the broad spectrum of situations encountered in the field of nuclear criticality safety. The criticality analysis should for normal, abnormal, and DBA facility states, involve:

- The use of a conservative approach with account taken of:
 - Uncertainties in physical parameters, the possibility of worst case moderation conditions and the presence of non-homogeneous distributions of moderators;
 - Plausible operational occurrences and their combinations if they cannot be shown to be independent;
 - Operational states that may result from external hazards.
- The use of appropriate and qualified computer codes (i.e. those that have been compared with benchmarks (validated and verified) to determine the uncertainties in the code in respect of the calculated, effective multiplication factor, k_{eff}) used within their applicable range and with appropriate data libraries of nuclear reaction cross-sections

4.52. An alternative method of analysis is to specify, for physical parameters such as mass, volume, concentration, geometrical dimensions, a 'safe value' as a fraction of their critical value²⁷, and demonstrating that these parameters will always be less than their safe value under all normal, abnormal conditions and DBA conditions.

4.53. In accordance with the criticality safety analysis, instruments specifically intended to detect accumulation of fissile material should be installed. These instruments can also be used to verify the fissile inventory of the equipment during decommissioning.

Design for Criticality Mitigation

4.54. The areas containing fissile material for which criticality accident alarm systems to initiate immediate evacuation are necessary are defined according to national safety requirements and by the criticality safety analysis. The requirements to be applied to the criticality detection systems and associated provisions are defined in (Ref. [1]: para. 6.50).

4.55. The potential for fitting additional shielding, remote operation and other design measures to lessen the hazard of a criticality, should one occur, should be assessed in accordance with the Defense in Depth requirements (Ref. [1]: para. 2.4-2.8 and Appendix IV: para. IV.29).

²⁷The parameter value for $K_{\text{eff}} = 1$.

POSTULATED INITIATING EVENTS

Internal initiating events

*Fire*²⁸

4.56. Fire in reprocessing facilities can lead to the dispersion of radioactive and/or toxic materials by breaching containment barriers or it may cause a criticality accidents by affecting the system(s) or the parameters used for the control of criticality (e.g. change of the dimensions of processing equipment or of the moderating or reflecting conditions, destruction of decoupling devices) or due to the presence of firefighting or suppression media.

4.57. In reprocessing Facilities, fire hazards are associated with the presence of flammable materials such as pyrophoric material, solvents, reactive chemicals, electrical cabling and potentially inflammable shielding in particular when associated with glove boxes (Ref. [1]: Appendix IV: para. IV.33).

Fire hazard analysis

4.58. An important aspect of the fire hazard analysis (Ref. [1]: para. 6.55) for a reprocessing facility, is the identification of areas of the facility that require special consideration. In particular, fire hazard analysis should include:

- Areas where fissile material is processed and stored;
- Process glove boxes, especially those in which plutonium is processed;
- Workshops and laboratories in which flammable or combustible liquids and gas, solvents, resins, reactive chemicals are used and/or stored;
- Areas where pyrophoric metal is processed (e.g. from Zr or U shearing/decladding);
- Areas with high fire loads, such as waste storage areas;
- Rooms housing systems and components important to safety,(e.g. last stages filters of the ventilation systems), whose degradation might have radiological consequences or consequences in terms of criticality that are unacceptable;
- Process control rooms and emergency control rooms;
- Evacuation routes.

4.59. Fire hazard analysis involves systematic identification of the causes of fires, assessment of the potential consequences of a fire and, where appropriate, estimation of the probability of the occurrence of fires. Fire hazard analysis is used to assess the inventory of

²⁸ The requirements relating to fire for a reprocessing facility are established in (Ref. [1]: Section 2) (Ref. [1]: Section 6 and Appendix IV: paras. IV.33-IV.36)

(flammable) fuels and initiation sources and to determine the appropriateness and adequacy of measures for fire protection. Computer modelling of fires should be used in support of the fire hazards analysis as necessary in complex and high hazard applications.

4.60. These analyses can provide valuable information on which it is possible to base design decisions or to identify weaknesses that might otherwise have gone undetected. Even if the likelihood of a fire occurring may seem low, it may well have significant consequences with regard to nuclear safety and, as such, appropriate protective measures should be undertaken (e.g. delineating small, fire compartment,²⁹ areas) to prevent fires or prevent the fire from propagating.

4.61. The analysis of fire hazards should also include a systematic review of the provisions made for preventing, detecting, mitigating and fighting fires.

Fire prevention, detection and mitigation

4.62. Prevention is the most important aspect of fire protection. Reprocessing facilities should be designed to limit fire risks through the incorporation of measures to ensure that fires do not occur and, if they do occur, to detect, limit and contain their spread. Measures for mitigation should be put in place to reduce to a minimum the consequences of fire in the event that a fire breaks out despite preventive measures.

4.63. To accomplish the dual aims of fire prevention and mitigation of the consequences of a fire, a number of general and specific measures should be taken, including the following:

- Minimization of the combustible load of individual areas, including the effects of fire enhancing chemicals such as oxidizing agents;
- Segregation of the areas where non-radioactive hazardous material are stored from the process areas;
- Selection of materials including building materials, process and glovebox components and materials for penetrations, in accordance with their functional requirements and fire-resistance ratings;
- Compartmentalization of buildings and ventilation ducts as far as possible to prevent the spreading of fires;
- Suppression or limitation of the number of possible ignition sources such as open flames or electrical sparks;

²⁹A room or suite of rooms within a firewall, potentially with separate fire detection and firefighting provisions, inventory controls and evacuation procedures

- Consistency of the extinguishing media with the requirements of other safety analyses, especially with the criticality control requirements (Ref. [1]: Appendix IV: para. IV.17).
- The design of ventilation systems should be given particular consideration with regard to fire prevention including the following aspects:
 - Dynamic containment comprises ventilation ducts and filter units which may constitute weak points in the fire protection system unless they are of suitable design;
 - Fire dampers should be mounted in the ventilation system unless the likelihood of a wide-spread fires and fire propagation is acceptably low and their effect on ventilation should be carefully considered;
 - The fire resistance of the filter medium should be carefully considered and spark arrestors should be used to protect filters as necessary;
 - The location of filters and fans should be carefully evaluated for ability to perform during a fire;
 - Careful consideration should be given to the potential need to reduce or stop ventilation flows in the event of a major fire to aid fire control.
- Lines crossing the boundaries of the fire compartments and firewalls (e.g. gases, process, electrical and instrument cables and lines) should be designed to ensure that fire does not spread.

4.64. Evacuation routes for fire and criticality event should be the same as far as possible.

*Explosion*³⁰

4.65. Explosion due to explosive chemicals can cause the release of radioactive materials. The potential for explosions can result from the use of chemical materials (e.g. organic diluents, hydrogen, hydrogen peroxide, and nitric acid), degradation products, pyrophoric materials (e.g. zirconium or uranium particles) or the chemical or radiochemical production of explosive materials (e.g. hydrogen, red oils).

4.66. To prevent the release of radioactive materials resulting from an explosion, in addition to the requirements of (Ref. [1]: para. 6.54), the following provisions to be considered during design should include:

- Maintaining the separation of incompatible chemical materials in normal and abnormal situations (e.g. recovery of leaks);

³⁰ The requirements relating to explosion for a reprocessing facility are established in (Ref. [1]: Section 2) (Ref. [1]: Section 6 and Appendix IV: paras. IV.33-36)

- Controlling parameters (e.g., concentration, temperature) to prevent situations leading to explosion;
- Using of blow-out panels to mitigate the effects of explosions of non-radioactive materials
- Where design options exist consideration should be given to adopting processes with lower potential risk for fire or explosion.

4.67. For the explosion risk of the flammable products resulting from chemical reactions and of the pyrophoric materials, e.g. small particles of zircaloy, see also para. 4.35-4.37.

4.68. Chemicals should be stored in well ventilated locations or racks outside the process or laboratories areas

*Handling events*³¹

4.69. Mechanical or human failures during the handling of radioactive or non-radioactive materials may result in degradation of criticality control, confinement, shielding, associated control or safety systems or reduction of defense in depth. Therefore, a reprocessing facility should be designed to limit the consequences of drops and collisions (e.g. by qualification of containers against the maximum drop, design of floors to withstand the impact of dropped loads, definition of safe travel paths) and, as required, design and administrative measures including human factor analysis and a robust management system to reduce the failure frequency of mechanical handling systems³² (e.g. cranes, carts, etc.).

*Equipment Failure*³³

4.70. A reprocessing facility should be designed to cope with the failure of equipment which would result in a degradation of confinement, shielding, criticality control or reduction of defense in depth. As part of design the fail-safe state of all active components should be assessed and consideration given (in accordance with a graded approach) to the design or procurement of items to ensure that they fail safe. Where no fail safe state can be defined, consideration should be given to eliminating the uncertainty or, where appropriate, strengthening the defense in depth (diversity and independence) to ensure functionality is maintained. These considerations apply mainly to instrument and control (I&C) components but also to mechanical systems such as crane braking systems.

³¹ The requirements relating to handling events for a reprocessing facility are established in (Ref. [1]: Section 2) (Ref. [1]: Appendix IV: para. IV.42)

³² Some Regulatory Authorities have specific requirements for design for “nuclear lifts” e.g. multi-rope cranes, maximum load as a smaller fraction of test load than non-nuclear loads etc.

³³ The requirements relating to equipment failure for a reprocessing facility are established in (Ref. [1]: Section 2) (Ref. [1]: para. 4.2 and Appendix IV: para. IV.37)

4.71. Special consideration should be given to failure of computer systems, computerized control or software, in evaluating failure and fail safe conditions, by application of appropriate national or international codes and standards

*Corrosion, Erosion and Mechanical Wear*³⁴

4.72. The materials of the equipment of reprocessing facilities should be selected to cope as far as possible with the corrosion risk due to the chemical and physical characteristics of the processed gases and liquids. The design of all containment should include a realistic, pessimistic allowance for the combined effects of all degradation mechanisms with particular attention paid to both general and localized corrosion effects due to corrosion, erosion, wear, temperature, thermal cycling, vibration, radiation and radiolysis etc.

4.73. Where cooling circuits are installed, especially in HA systems, the effects of “water-side” corrosion, water chemistry, radiolysis (peroxide production etc.) and stagnant coolant (no cooling required or standby system), should be included in design considerations.

4.74. To fulfil requirements regarding confinement, the potential leaks of the first containment barriers should be collected and recovered (e.g. drip-trays or clad floor and collecting sumps for active cells) When large volumes of HA liquid wastes are stored a safety assessment should be made for the number of empty tanks to be available in case of failure(s). See also (Ref. [1]: para. 6.17).

4.75. The potential effects of corrosion on the dimensions of equipment containing fissile materials should be taken into account in the criticality assessments (e.g. thickness of the walls of process vessels whose criticality control mode is geometry) (Ref. [1]: Appendix IV: para. IV.18). Consideration should also be given to the corrosion of support structures for fixed neutron absorbers and, where absorbers are in the process medium, to corrosion of the absorber itself e.g. packing in evaporator condensers.

4.76. Where possible, in accordance with safety and technical requirements, process parameters, e.g. operating temperature of evaporators, should be adapted to limit the corrosion rate.

*Internal flooding*³⁵

³⁴ The requirements relating to corrosion, erosion and mechanical wear for a reprocessing facility are established in (Ref. [1]: Section 2) (Ref. [1]: para 6.17, Appendix IV. para. IV.18 and IV.38)

4.77. Flooding of fluids (e.g. water, nitric acid) in reprocessing facilities may lead to the dispersion of radioactive materials, to changes in moderation and/or reflection conditions and to the failure of electrically powered safety related devices, failure of or false activation of alarms and trips, and the slowing or stopping of ventilation flows or fans.

4.78. For facilities where vessels and/or pipes containing liquid are present, the criticality analysis should take into account the presence of the maximum credible amount of liquid within the considered room as well as the maximum amount of liquid which could credibly flow from any connected rooms, vessels or pipework.

4.79. Walls (and floors if necessary) of rooms where flooding could occur should be designed to withstand the liquid load and other safety related equipment should not be affected by flooding.

4.80. The potential hydraulic pressure and up-thrust on large vessels, ducting and secondary containment during flooding should be considered in design.

Loss of support systems³⁶

4.81. To fulfil the requirements established in (Ref [1]: para. 6.28) a reprocessing facility is designed to cope with a loss of support systems such as electrical power. The loss of support systems should be considered, in turn, for:

- Individual item of equipment;
- The whole reprocessing facility, and on multi-facility sites;
- Reprocessing facility ancillary and support facilities (e.g. waste treatment and storage) and other site facilities.

4.82. Electrical power supplies to reprocessing facilities should be of high reliability. In the event of loss of normal power, according to the facility status and to the safety analysis requirements, an robust emergency electrical power supply should be provided to relevant Structures, Systems and Components important to safety, including the following (Ref. [1]: Appendix: para. IV:41):

- Heat transportation and removal systems;
- Dilution system for hydrogen generated by radiolysis;
- (Some) exhaust fans of the dynamic containment system;
- Fire detection systems;
- Monitoring systems for radiation protection;
- Criticality accident alarm systems;

³⁵The requirements relating to internal flooding for a reprocessing facility are established in (Ref. [1]: Section 2) (Ref. [1]: Appendix IV: para. IV.39)

³⁶The requirements relating to the loss of support systems for a reprocessing facility are established in (Ref. [1]: Section 2) (Ref. [1]: para 6.28 and Appendix IV: para. IV.40-IV.41)

- I&C associated with the above items;
- Lighting.

4.83. Consideration should be given to the need to provide emergency power for an extended period in the event of major external events and which SSCs and other services should be available in the event of a prolonged support services outage.

4.84. The chronology for restoring electrical power to reprocessing facilities should take account of:

- The design of off-site and on-site electrical networks;
- The interruptions of supply during switching operations, and;
- The initial power demand and supply capabilities and capacity.

When restoring power following the appropriate emergency instructions for (safety) priorities for equipment (e.g. ventilations systems) (Ref. [1]: Appendix IV: para. IV.41).

4.85. The assessments performed for the loss of electrical power supplies or other support services (e.g. cooling, radiolysis, ventilation) should be part of the reprocessing facility design assessment (Ref. [1]: Appendix IV: para. IV.40).

4.86. The loss of general support supplies such as gases for instrumentation and control, cooling water for process equipment, ventilation systems and compressed air may also have consequences for safety. In the design of a reprocessing facility, suitable measures to ensure the supply or other means to ensure safety should be provided, e.g.:

- Loss of pneumatic supply to pneumatically actuated valves. In accordance with the safety analysis, valves should be used that are designed to fail to a safe position (see paras. 4.71-4.72);
- Loss of cooling water may result in the failure of components such as evaporator condensers, diesel generators, and condensers/dehumidifiers in the ventilation system. Adequate back up capacity or independent, redundant supply should be provided in the design.

Use of hazardous chemicals

4.87. For reprocessing facilities conservative assessments of chemical hazards to workers and releases of hazardous chemicals to the environment are made on the basis of the standards used in the chemical industries and the requirements of national regulations, taking into account any potential for radiological or nuclear hazards. Where possible these chemicals should be used, by design, under physical conditions where they are intrinsically safe.

Use of non-atmospheric pressure equipment

4.88. As far as practicable, provisions for in-service testing of equipment installed in controlled areas and cells should be defined according to national requirements on pressurized and/ or sub-atmospheric equipment. If this is not possible, additional safety features should be defined at the design stage (e. g. oversizing with regards to pressure, increased margins) and in operation (e.g. reinforced monitoring of process parameters). The potential consequences of an explosion or leak should be assessed, including during testing, and complementary safety features identified to minimize potential consequences.

External initiating events

Non-nuclear external hazards

4.89 A survey of the external hazards should be carried out prior to the design of a reprocessing facility and as part of any periodic safety assessment or if any significant industrial or transport infrastructure changes are planned (Ref. [1]: para. 6.8).

Earthquake

4.90 Reprocessing facilities should be designed to withstand the design basis earthquakes to ensure that an earthquake motion at the site would not induce unacceptable consequences for the workers, the public and the environment i.e. a seismically induced loss of cooling, or criticality safety functions such as geometry and/or moderation (Ref. [1]: Appendix IV: para. IV.44).

4.91 A detailed seismic assessment (Ref. [10] and [11]) should be made of the reprocessing facility design. The particular features addressed in the assessment include:

- The large “footprint” of reprocessing facilities;
- The variety of processes, the number and complexity of vessels, pipework, cells and gloveboxes providing primary and secondary containment;
- The need for uninterrupted cooling;
- The provision of a numerous different methods and devices for moving solid, liquid and gaseous radioactive materials;
- Extensive active ventilation systems with tall discharge stacks;
- The extensive networks of monitoring instruments and controls, data highways and control room(s);
- The variety of utility and service provisions all with their own safety related seismic design requirements and complex interactions.

4.92 Design calculations on equipment with fissile material and designed with geometry control, and fixed or soluble neutron poison should take into account the potential deformation, displacement or loss of material.

4.93 Emergency control panels should be accessible and operable by staff after a design basis earthquake and equipment required to maintain the reprocessing facility in a safe and stable state and monitor the facility and environment should be tested and qualified using appropriate conservative methodologies including the use of an earthquake simulation platform (Ref. [1]: Appendix IV: para. IV.45).

4.94 Depending on the reprocessing facility site characteristic and location, the potential for a tsunami induced by an earthquake and other extreme flooding events should be assessed (Ref. [1]: Appendix IV: para. IV.46).

External fires and explosions

4.95 Hazards from external fires and explosions could arise from various sources in the vicinity of a reprocessing facility such as petrochemical installations, forests, pipelines, and road, rail or sea routes used for transport of flammable material such as gas or oil (Ref. [1]: para. 6.8).

4.96 The risks associated with such external hazards should be demonstrated to be within acceptable levels by:

- Identify all potential sources of hazards;
- Assess the associated event sequences affecting the facility;
- Evaluate the radiological or associated chemical consequences of any damage;
- Verify that they are within defined acceptance criteria.

4.97. Toxic hazards should also be assessed to verify that specific gas concentrations meet acceptance criteria. It should be ensured that external toxic hazards would not adversely affect the control of the facility.

4.98. A survey should be carried out of potentially hazardous installations and transport operations of hazardous material in the vicinity of the facility. In the case of explosions, risks should be assessed for compliance with overpressure criteria. To evaluate the possible effects of flammable liquids, falling objects (such as chimneys) and missiles resulting from explosions, their possible distance from the facility and hence their potential for causing physical damage should be assessed (Ref. [1]: para. 6.8).

Extreme weather conditions

4.99. A reprocessing facility should be protected against extreme weather conditions by means of appropriate design provisions. These should generally include (Ref. [1]: Appendix IV: para. IV.46):

- The ability to maintain availability of cooling systems during extreme temperatures and other extreme conditions;
- The ability of structures important to safety to withstand extreme weather loads, particular assessment of parts of the facility structure designed to provide containment with little or no shielding function (e.g. alpha active areas);
- Prevention of flooding of the facility;
- Keeping ground water level within the acceptable limits during flooding;
- Safe shutdown of the facility in accordance with the operational limits and conditions and keeping the facility in a safe and stable state.

4.100 Typically, the extreme weather conditions assumed in the design and evaluation of the response of a reprocessing facility are extreme winds, tornadoes, tsunamis, etc. (Ref. [1]: Appendix IV: para. IV.46).

4.101 The general approach should be to use a deterministic, design basis value for each extreme weather condition and to assess the effects of such an event on the safety of the facility. The rules for obtaining the design basis values for use in the assessment are set by local regulations or agreed with the regulator on a case by case basis taking account of national and international guidance (Ref. [1]: Appendix IV: para. IV.46). The design provisions will vary according to the type of hazard and its effects on the safety of the facility. For example, extreme winds are associated with rapid structural loading and thus design provisions for an event involving extreme winds should be the same as those for other events with potentially rapid structural loading, such as earthquakes. However, effects of extreme precipitation or extreme temperatures would take time to develop and hence there may be time for operational actions (dependent upon their analyses) to be taken to limit the consequences of such events (Ref. [1]: Appendix IV: para. IV.46).

Tornadoes

4.102 Measures for the protection of the facility against tornadoes will depend on the meteorological conditions for the area in which the facility is located. The design of buildings and ventilation systems should comply with specific national regulations relating to hazards from tornadoes (Ref. [1]: Appendix IV: para. IV.46).

4.103 Tornadoes are capable of lifting and propelling large, heavy objects (e.g. automobiles or telephone poles). The possibility of impacts from such missiles should be taken into consideration in the design stage for the facility, for both the initial impacts and the effects of secondary fragments arising from striking concrete walls or from other forms of transfer of momentum (Ref [1]: Appendix IV: para. IV.46).

Extreme temperatures

4.104 The potential duration of extreme low or high temperatures should be taken into account in the design of cooling systems and support systems, to prevent unacceptable effects such as:

- Freezing of cooling circuits (including cooling towers and outdoor actuators);
- Adverse effects on building venting, heating and cooling system to avoid poor working conditions humidity excess in the buildings.

Operational actions to limit or mitigate the consequences of such events can only be relied upon if the operators have the necessary information, sufficient time to respond and the necessary equipment. (Ref. [1]: Appendix IV: para. IV.46).

Snowfall and Ice Storms

4.105 The occurrence of extreme snowfalls and freezing rain and their effects should be taken into account in the design and the safety analysis. Snow and ice are generally taken into account as an additional load on the roofs of buildings and, for “glaze” ice, vertical surfaces and utilities. The flooding resulting from snow or ice accumulation and infiltration and a possibility that it leads to damage of equipment important to safety (e.g., electrical systems) should be considered. The neutron reflecting or moderating effect of snow should be considered if relevant. (Ref. [1]: Appendix IV: para. IV.46).

Flooding

4.106 Flooding should be taken into account in the design of a reprocessing facility, taking account of the requirements stated in (Ref. [10]: paras. 3.18-3.32). Attention should be focused on the stability of buildings (e.g., hydrostatic and dynamic effects), water level and, where relevant, the potential for mud slides. In establishing postulated flood events, attention should be focused on parameters (e.g. climatology, terrain) that could impact the magnitude of events. For flooding events attention should be focused on potential leak paths (containment breaks) into active cells and SSCs at risk of damage. In all cases the equipment containing fissile material should be designed to prevent any criticality accident. Gloveboxes

should be designed to be resistant (undamaged and static) to the dynamic effects of flooding and all glovebox penetrations should be above any potential flood levels (Ref. [1]: Appendix: para. IV.46).

Accidental aircraft crash or externally generated missiles hazards

4.107 The likelihood and possible consequences of impacts onto the facility should be assessed by estimating the number of aircraft that come close to the facility, their flight paths, and evaluating the areas vulnerable to impacts, i.e. areas where hazardous material is processed or stored. If the risk is acceptably low, no further evaluations are necessary, otherwise reprocessing facilities should be designed to withstand the design basis impact (Ref. [1]: para. 5.5).

4.108 In evaluating the consequences of impact or the adequacy of the design to resist aircraft impacts, only realistic crash scenarios should be considered. These require the knowledge of such factors as the possible angle of impact or the potential for fire and explosion from aviation fuel. In general, fire cannot be ruled out following an aircraft crash, and so establishing the specific requirements for fire protection and emergency preparedness and response will be necessary (Ref. [1]: para. 5.5).

4.109 The specific industrial environment of reprocessing facilities (e.g. nearby high stack or high speed rotating turbine at a power plant), should be assessed and a safety analysis should assess the consequence of an accident, including impact of the any missiles generated (Ref. [1]: para. 5.5).

Instrumentation and control (I&C)

Instrumentation

4.110 Instrumentation should be provided to monitor the variables and systems of the facility over their respective ranges for:

- (1) Normal operation;
- (2) Anticipated operational occurrences;
- (3) Design basis accidents and, as far as practicable;
- (4) Beyond design basis accidents (design extension conditions).

The aim should be to ensure that adequate information can be obtained on the status of the facility and correct responses can be planned and taken in accordance with operating or emergency procedures or severe accident guidelines as appropriate, for all facility states. In addition, in the event of an accident, that the reprocessing facility can be returned a safe, stable state (Ref. [1]: Appendix IV: para. IV.47).

4.111 Instrumentation should be provided for measuring all the main variables that can affect the processes and the general conditions of the facility (such as radiation doses due to internal and external exposure, criticality control and detection, release of effluents and ventilation conditions) and for obtaining any other information about the facility necessary for its reliable and safe operation. Provision should be made for the automatic measurement and recording of values of parameters important to safety (Ref. [1]: Appendix IV: para. IV.47).

Local instrumentation

4.112 In reprocessing facilities many areas may be impossible or very difficult to access due to high radiation and/ or contamination levels. As far as possible mounting instruments and local indication in such locations should be avoided but this should not interfere with the operators' need to have information at a work location. To aid maintenance of instruments in such environments separate enclosures to protect instrument or personnel as appropriate should be used (Ref. [1]: Appendix IV: para. IV.47).

Sample taking and analysis

4.113 Within the constraints of the availability of capable equipment, its discrimination, reliability and stability, suitable process locations, realistic calibration options and the ergonomics of maintenance and replacement, including dose considerations and timeliness issues, the preference in reprocessing facilities should be for measurement by:

- 1) In-line instruments;
- 2) At-line³⁷ instruments;
- 3) Sampling with local analysis;
- 4) Sampling with distant (central laboratory etc.) analysis.

4.114 In reprocessing facilities the safety of many chemical processes relies on the quality and the timeliness of chemical and radiochemical analysis performed on samples taken from vessels and equipment at strategic points in the processes, e.g. Pu concentration, Pu isotopic composition, solution acidity. For these strategic sample points, all the aspects related to the quality of sample taking and labelling, its proper transfer to the analytical laboratories, the quality of the measurements and their reporting to the facility operators should be documented, and justified as part of the management system (Ref. [1]: Appendix IV: para. IV.47). The use of bar-coding or similar systems should be considered to reduce the opportunity for error.

³⁷Devices that remove a small sample or stream from a process flow or vessel for measurement rather than measuring the bulk flow etc. directly.

4.115 Where applicable the use of automation of sampling systems should be applied. The use of completely automated systems (from sampling request to result receipt) for frequent analytical measurements should be considered where beneficial to safety for avoiding operational exposure, exposure risk and potential human errors (Ref. [1]: para. 6.16 and Appendix IV: para. IV.28).

Control systems

4.116 Passive and active engineering controls are more reliable than administrative controls and should be preferred for control in operational states and in accident conditions. Automatic systems should be highly reliable and designed to maintain process parameters within the operational limits and conditions or to bring the process to a safe and stable state, which is generally a shutdown state³⁸ (Ref. [1]: Appendix IV: para. IV.47).

4.117 When administrative controls are considered an option, the criteria for implementation of automated versus administrative control should be based on response time requirement and careful consideration of the hazards and risk involved. Where the choice of optimum response (from a number of possible choices) is a significant factor in choosing administrative controls (operator action), consideration should be given to providing a simple, active control response and/ or passive design features to limit potential hazards (additional defense in depth).

4.118 Appropriate information should be made available to the operator for monitoring the actuation of and facility response to remote and automatic actions. The layout of instrumentation and the manner of presentation of information should provide the operating personnel with a clear and comprehensive view of the status and performance of the facility. Devices should be installed that provide, in an effective manner, visual and, as appropriate, audible indications of operational states that have deviated from normal conditions and that could affect safety. Specifically information should be displayed in such a way that operators can easily determine if a facility is in a safe state and, if not, readily determine the appropriate course of action to return the facility to a safe and stable state (Ref. [1]: Appendix IV: para. IV.47). [1]).

4.119 For radioactive material and important reagent transfers, where there are no specific safety measures, the following should be adopted, as far as practicable, to allow early detection of operational occurrences as part of defense in depth (Ref. [1]: para. 2.7 and Appendix IV: para. IV.47):

³⁸No radioactive material or liquid movements, with ventilation and (essential) cooling only.

- 1) The use of transfers by batch between unit/building/facilities;
- 2) Characterization of a batch before transfer;
- 3) The use of an authorization procedure requesting that the receiving installation allows the start of transfer and monitoring of the transfer process.

Where transfers are initiated automatically, especially if frequent, consideration should be given to appropriate automatic means of detecting failures to start or stop transfers.

Control rooms

4.120 Control rooms should be provided to centralize the main data displays, controls and alarms for general conditions at the facility. Occupational exposure should be minimized by locating the control rooms in parts of the facility where the levels of radiation are low. For specific processes, it may be useful to have dedicated, localized control rooms to allow the remote monitoring of operations, thereby reducing exposures and risks to operators. Particular consideration should be paid to identifying those events, both internal and external to the control rooms that may pose a direct threat to the operators, to the operation of the control room and to the control of the reprocessing facility itself (Ref. [1]: para. 2.7 and Appendix IV: para. IV.47).

Safety related I&C systems

4.121 The safety related I&C systems for normal operation should include systems for (Ref. [1]: Appendix IV: para. IV.47):

- Criticality control:
 - Depending on the method of criticality control, the control parameters should include mass, concentration, acidity isotopic/ fissile content, quantity of moderators as appropriate (Ref. [1]: Appendix IV: para. IV.11);
 - Specific control parameters required from double contingency or similar analyses e.g. burn-up measurement for spent fuel assemblies/elements before shearing/decladding, when burn-up credit is used in the criticality control or soluble poison concentrations in reagent feeds (Ref. [1]: para 6.45 and Appendix IV.: para. IV.15);
- Process control, the key safety related control systems of concern are those for:
 - Removing decay heat;
 - Diluting hydrogen due to radiolysis and other sources;
 - Vessel levels;
 - Controlling temperature and other conditions to prevent red oil explosions etc.;
- Fire detection systems;

- Glovebox and cell controls:
 - The requirements for glovebox control are established in (Ref. [1]: Appendix II: para. II.25);
 - Monitoring dynamic containment in cells and gloveboxes (see Control of ventilation below);
 - Monitoring cell and glovebox sump levels;
- Control of ventilation:
 - Monitoring and control of differential pressure to ensure that the airflows in all areas of the reprocessing facility are flowing in the correct direction, i.e. towards areas that are more contaminated;
 - Key ventilation (stack) flows for environmental discharge monitoring;
- Control of occupational radiation exposure:
 - External exposure.
 - Sensitive dosimeters with real-time displays and/or alarms should be used to monitor occupational radiation doses;
 - Portable equipment and installed equipment should be used to monitor whole body exposures and exposures of the hands to gamma radiation and neutron emissions.
 - Internal exposure, due to the specific hazards of airborne radioactive materials, the following provisions should be considered:
 - Continuous air monitors to detect airborne radioactive materials should be installed as close as possible to the working areas to ensure the early detection of any dispersion of airborne radioactive materials;
 - Devices for detecting alpha surface contamination should be installed close to the concerned working areas and also close at least to the exits of rooms in which concerned working areas are located;
 - Detectors and interlocks associated with engineered openings (i.e. access controls);
- Control of liquid discharges and gaseous effluents:
 - Monitoring of liquid and gaseous effluents discharges;
 - Monitoring (the operation of) sample system for environmental discharges;
 - Site environmental monitoring systems

SAFETY ANALYSIS

4.122 The safety analysis of reprocessing facilities should assess the variety of hazards and places of where radioactive materials are located (Ref. [1]: paras. 2.6, 2.10-2.12 and 4.24).

4.123 The list of hazards defined in (Ref. [1]: Annex III) should be developed by identifying all postulated initiating events and the resulting event scenarios and carrying out detailed analyses to define appropriate SSCs and OLCs (Ref. [1]: Annex III: Step 3.A).

4.124 For reprocessing facilities the safety analysis should be performed according to (Ref. [1]: Annex III) which should result in:

- Doses to workers and the public during operational states that should be within acceptable limits for operational states;
- Radiological and chemical consequences of DBAs (or equivalent) to the public that should be within the limits specified for accident conditions;
- Final OLCs.

4.125 The use of bounding cases (Ref. [1]: Annex III: para. III-10) has limited application in reprocessing facilities due to variety of equipment used, materials handled and processes employed. These should only be used where the accidents grouped together can be demonstrated to be within a representative bounding case after a thorough analysis. The use of such bounding cases is nevertheless important in reducing unnecessary duplication of safety analyses and should be used when practicable and justified.

Safety analysis for operational states

Occupational radiation exposure and exposure of the public

4.126 At the design stage of a new reprocessing facility, radiation doses should be estimated early-on in the design process and should be iteratively re-calculated and refined as the design proceeds as this allows for the maximum opportunities for does optimization. A common initial approach is to first allocate an internal dose based on experience and then to assess the external radiation protection (shielding, layout etc.).

4.127 The assessment of the external doses should be based on conservative assumptions including the following:

- 1) Calculations with a bounding source term on the basis of:
 - Inventory including activity, energy spectrum, and neutron emission of all radioactive materials, and;

- Accumulation factor (e.g., accounting for deposition of radioactive material inside pipes and equipment);
- 2) Two approaches are possible to assess external doses (Ref. [1]: paras. 2.6, 2.10-2.12 and 4.24):
 - i. Define a limit for dose that will allow any worker to be present without time constraints, and the distance between the source term and the worker, or;
 - ii. Identify and take into account the type of and time required for the work activity to be performed by each worker and the distance between the worker and the source term;
 - 3) Calculations to determine the shielding requirements.

4.128 The calculation of estimated dose for the public should include all the radiological contributions originating in the facility, i.e. direct or indirect (e.g. sky effect or ground deposition) radiation, intake of radioactive material and doses received through the food chain as a result of discharges of radioactive material. The maximum values for each contribution should be used for the dose calculation where a range is calculated. Conservative models and parameters should be used to estimate doses to the public. The doses should be estimated for the representative person(s).

Releases of hazardous chemical materials

4.129 This Safety Guide addresses only those chemical hazards that can give rise to radiological hazards (Ref. [1]: para. 2.2). Facility specific, realistic, robust (i.e. conservative), estimations of purely chemical hazards to workers and release of hazardous chemicals to the environment should be performed, in accordance with the standards applied in the chemical industries (Ref. [1]: paras. 2.6, 2.10-2.12 and 4.24).

Safety analysis for accident conditions

Methods and assumptions for safety analysis for accident conditions

4.130 The acceptance criteria associated with the accident analysis should be defined in accordance with (Ref. [1]: para. 6.5) and with respect to any national regulations and emergency criteria.

4.131 To estimate the on-site and off-site consequences of an accident, the range of physical processes that could lead to a release of radioactive material to the environment should be modelled in the accident analysis and the bounding cases, encompassing the worst consequences should be determined (Ref. [1]: paras. 2.6, 2.10-2.12 and 4.24).

4.132 The following approaches should be considered in the performing the assessment:

- 1) An approach using the bounding case (the worst case approach), with account taken only of those safety features that mitigate the consequences of accidents and/ or that reduce their likelihood. If necessary, a more realistic case can be considered that includes the use of some safety features and some non-safety related features beyond their originally intended range of functions to reduce the consequences of accidents (the best estimate approach).
- 2) An approach using the bounding case (the worst case approach), with no account taken of any safety feature that may reduce the consequences or the likelihood of accidents. This assessment is followed by an assessment of the possible accident sequences, with account taken of the emergency procedures and the means planned for mitigating the consequences of the accident.

4.133 The second case is generally used when the first one cannot be applied to justify the safety of an accident condition.

Assessment of possible radiological or associated chemical consequences

4.134 Safety assessments should address the consequences associated with possible accidents. The main steps in the development and analysis of accident scenarios should include (Ref. [1]: paras. 2.6, 2.10-2.12 and 4.24):

- a. Analysis of the actual site conditions (e.g. meteorological, geological and hydro-geological site conditions) and conditions expected in the future;
- b. Identification of workers and members of the public who could possibly be affected by accidents; i.e. a ‘critical group’ of people living in the vicinity of the facility;
- c. Specification of the accident configurations, with the corresponding operating procedures and administrative controls for operations;
- d. Identification and analysis of conditions at the facility, including internal and external initiating events that could lead to a release of material or of energy with the potential for adverse effects, the time frame for emissions and the exposure time, in accordance with reasonable scenarios;
- e. Specification of the structures, systems and components important to safety that are credited to reduce the likelihood and/ or to mitigate the consequences of accidents. These structures, systems and components that are credited in the safety assessment should be qualified to perform their functions in the accident conditions;
- f. Characterization of the source term (material, mass, release rate, temperature, etc.);

- g. Identification and analysis of intra-facility transport pathways for material that is released;
- h. Identification and analysis of pathways by which material that is released could be dispersed in the environment;
- i. Quantification of the consequences for the representative person(s) and critical group(s) identified in the safety assessment.

4.135 Analysis of the actual conditions at the site and the conditions expected in the future involves a review of site meteorological, geological and hydrological conditions at the site that may influence facility operations or may play a part in transporting material or transferring energy that is released from the facility (Ref. [1]: Section 5).

4.136 Environmental transport of material should be calculated using qualified codes and using data derived from qualified codes, with account taken of meteorological and hydrological conditions at the site that would result in the highest exposure of the public.

4.137 The identification of workers and members of the public (the critical group of maximally exposed off-site individuals) who may potentially be affected by an accident should involve a review of descriptions of the facility and demographic information.

HUMAN FACTOR CONSIDERATIONS³⁹

Human factors in operation, inspection, periodic testing, and maintenance

4.138 Human factors should be considered at the design stage. Factors to be considered include:

- Possible effects on safety of unauthorized human actions (with account taken of ease of intervention by the operator and the system tolerance of human error);
- Potential for occupational exposure.

4.139 Reprocessing facility design should evaluate all work locations under normal facility states, including maintenance, and should identify situations where and when human intervention is required under abnormal and accident conditions with the aim of facilitating the operator's activities and being tolerant to human error. This should include the optimization of the design to prevent or reduce the likelihood of operator error (e.g. locked valves, segregation and grouping of controls, fault identification, logical displays, segregation of process and safety systems and alarms etc.). Particular attention should be paid to situations

³⁹ The requirements relating to the consideration of human factors are established in (Ref. [1]: paras. 6.15 and 6.1).

where operator action is anticipated in DBA and BDBA conditions for emergency and mitigation activities for rapid, fault-free and fault tolerant, problem identification.

4.140 Human factor experts and experienced operators should be involved from the earliest stage of the design. Areas that should be considered include:

- Application of ergonomic requirements to the design of working conditions:
 - The operator – process interface, e.g. electronic control panels displaying all the necessary information and no more;
 - The working environment, e.g. good accessibility to, and adequate space around equipment and suitable finishes to surfaces to allow areas to be kept clean easily;
- Provision of fail-safe equipment and automatic control systems for accident sequences for which reliable and rapid protection is required;
- Good task design and job organization, particularly during maintenance work, when automated control systems may be disabled;
- Facility minimum safety staffing levels should be assessed by the task analysis of the operator responses required during the most demanding occurrences;
- Consideration of the need of additional space and access requirement during the lifetime of the facility;
- Provision of dedicated storage locations for all special tools and equipment;
- Choice of location and clear, consistent and unambiguous labelling of equipment and utilities so as to facilitate maintenance, testing, cleaning and replacement;
- Minimization of the need to use additional means of personal protective equipment and, where it remains necessary, careful attention to their selection and design.

4.141 Consideration should be given to providing computer aided tools to assist operators in detecting, diagnosing and responding to events.

4.142 In the design and operation of gloveboxes, the following specific ergonomic considerations should be taken into account:

- In the design of equipment inside gloveboxes, account should be taken of the potential for conventional industrial hazards that may result in injuries to workers, including internal radiation exposure through cuts in the gloves and/or wounds on the operator's skin, and/or the possible failure of confinement;
- Ease of physical access to gloveboxes and adequate space and good visibility in the areas in which gloveboxes are located;

- Consideration of the requirement for glovebox and glovebox window seal etc. maintenance including the need for PPE during these operations.
- Careful consideration of the number and location of glove and posting ports, with the use of mock-ups and extensive testing of glovebox ergonomics at the manufacturer before delivery recommended;
- The potential for damage to gloves and the provisions for glove, and, where applicable, filter changing.

RADIOACTIVE WASTE MANAGEMENT

4.143 For safety, environmental and economic reasons, the aim of radioactive waste management is to minimize the generation of waste.

The waste management strategy should take account of:

- Environmental impact, public dose, operator dose;
- Local and national regulatory limits;
- National and international guidelines and best practices;
- Economics of the reprocessing facilities operation;
- Available disposal and interim storage routes and their capacities.

It is likely that an outcome of meeting this purpose will be the minimization, as far as practicable, of both the volume and activity of wastes generated in reprocessing facilities (Refs. [4] and [5]).

4.144 Due to the nature and diversity of the composition of spent fuel (structural parts, spectrum of fission products and actinides) and to the chemical processes involved, reprocessing facility activities result in wastes that vary in type and quantity. The design of reprocessing facility should try, as far as practicable, to ensure that all wastes anticipated to be produced during the life cycle of the facility have designated disposal routes. These disposal route need to account for not only the isotopic composition of the waste but also its chemical and physical characteristics (e.g. flammable, heat generating).

4.145 In case of existing disposal routes, the design should establish the characteristics of each of them and provide (or identify) equipment and facilities for characterizing, segregating, directing and transporting, as necessary, waste to the appropriate disposal route.

4.146 The design should accommodate as far as reasonable practicable provisions for the rerouting of effluents and wastes to allow the future use of emerging technologies, improved knowledge and experience, or regulatory changes.

4.147 Gaseous and volatile waste from reprocessing facilities pose a particular challenge in both capturing the waste and its disposal. Future designs of reprocessing facilities should consider addressing this issue and to immobilize, as far as practicable from environmental and economic points of view this waste.

Management of gaseous and liquid releases

4.148 The gaseous effluent discharge from a reprocessing facility should be reduced by process specific ventilation treatment systems, dehumidification (to protect filters) and filtration, which normally consists of a number of high efficiency particulate air (HEPA) filters in series.

4.149 Monitoring equipment such as:

- Differential pressure gauges to identify the requirement for filter changes, and;
- Activity or gas concentration measurement devices and discharge flow measuring devices with continuous sampling;
- Injection and sampling equipment to test filter performance should be installed and used.

4.150 Liquid effluents to be discharged to the environment should be treated to reduce the discharge of radioactive materials and hazardous chemicals. The use of filters, ion-exchange beds or other technology should be considered where appropriate.

4.151 (See Paras. 1.8, 2.3, 4.121, 4.146 and Section 7: Effluent Management also).

Emergency preparedness and planning

4.152 Reprocessing facilities are classified “as facilities for which on-site events (including very low probability events) are postulated that could rise to severe deterministic health effects off the site, or for which such events have occurred in similar facilities.” (Ref. [9]: Table 1: Category I).

4.153 The operating organization of a reprocessing facility is required to develop an emergency plan that takes into account the potential hazards at the facility (Ref. [1]: para. 9.62). The emergency plan and the necessary equipment and provisions should be determined on the basis of selected scenarios for beyond design basis accidents (or the equivalent).

4.154 Reprocessing facility design should take into account the requirements for on –site infrastructure (including the facilities and logistical support) defined in (Ref. [9]: paras. 5.25-5.30), further guidance can be found in (Ref. [12]: Section 5).

4.155 A reprocessing facility should be capable of being brought to a safe and long-term stable state, including maintaining availability of the necessary facility status and monitoring information in and following abnormal and accident conditions (Refs. [9]: para. 4.39 and [1]: paras. 2.6, 6.22-6.24, 9.26). As far as practicable the control room(s) should be designed and located so as to remain habitable during postulated emergencies (e.g. separate ventilation, low criticality event calculated dose). For events that may affect control rooms, e.g. fire, externally generated hazardous chemical releases etc., the control of major reprocessing facility safety functions should be provided by the use of appropriately located (alternative) emergency control panels or emergency control rooms.

4.156 Infrastructure off-site emergency preparedness (e.g. emergency centers) and response infrastructure (medical facilities) should be considered according to the reprocessing facility site characteristics and location (Refs. [9]: paras. 4.78-4.79 and [1]: para. 9.63).

5. CONSTRUCTION

5.1. Reprocessing facilities are complex facilities and regulatory body authorization should be sought in several stages. Each stage should require a hold point and require regulatory agreements in order to proceed to the next stage (Ref. [1]: para. 3.7).

5.2. As large chemical and mechanical facilities the construction of reprocessing facilities should use modularized components, standardized as far as practical. In general this approach will allow better control of quality and testing before delivery to site. This practice should also aid commissioning, operation, maintenance and decommissioning.

5.3. A new reprocessing facility project will involve large number of designers and contractors, over a considerable span of time with the likelihood that design, construction and early commissioning will be taking place simultaneously in different facility sections. The operating organization should put in place adequate procedures as part of a comprehensive management system for control and communication to minimize potential problems and deviations from the design intent as design and construction proceeds. These arrangements should be monitored and regularly audited to ensure they are adequate.

5.4. Consideration should be given to minimizing the number of designers and contractors, as far as practicable, for consistency and standardization which supports safe and effective operation and maintenance. It also eases the process of communication between the external and the operating organizations to ensure knowledge transfer and allowing the operating organization to benefit from the experience more effectively.

5.5. The management system is of specific importance to the ensuring the standards of construction of reprocessing facilities and should be developed, implemented and maintained before and during construction. The management system should address the following provisions:

- Formal design change program (configuration control) to assess modifications to the facility design and construction standards and maintain the consistency with the technical and safety basis and the design of the facility;
- Procurement control to ensure that SSCs (passive and active) meet safety requirements;
- Records maintained to demonstrate that facility was constructed in accordance with design specifications;
- Implementation of proper quality control and assurance systems including clearly labelling of all components, cables, pipes, etc.

5.6. Equipment should be tested and proven at manufacturers' and operators' sites before installation at the facility as far as possible. Testing and verification of specific SSCs important to safety should be performed before construction and installation when appropriate (e.g., verification of shielding efficiency, neutron decoupling devices, geometry for criticality purposes, welding) since this may not be possible or be limited after installation.

5.7. Construction testing (see paras. 6.10, 6.12 and 6.17).

5.8. The construction should use appropriate materials, proven techniques and approved procedures to minimize the occurrence of defects that might affect the required integrity of reprocessing facility structures.

5.9. For structures requiring the highest levels of reliability, assurance of the application of high standards should be verified by inspection and certification, of the personnel (welders etc.), construction methods and the materials used.

5.10. In accordance with the management system frequent formal and informal inspections should take place during the construction of a reprocessing facility and should be used to

demonstrate that the required standard and quality of the work has been achieved. If construction non-conformities that could have a detrimental effect on integrity or significant defects are detected, remedial or corrective measures should be taken to achieve the design safety goals.

EXISTING FACILITIES

5.11. Major construction work or refurbishment at existing reprocessing facilities presents a wide range of potential hazards to operating and construction personnel, the public and the environment. Where major refurbishment or construction work is taking place areas where construction works are in progress should be isolated from other reprocessing facility facilities in operation or already constructed, as far as reasonably practicable, to prevent negative interactions due to the ongoing activities and possible events in the either area, see: Section 7 Operation: Control of Modifications also.

DRAFT

6. COMMISSIONING

6.1. The commissioning process, defined in (Ref. [1]: Section 8) should be completed prior to the operation stage.

6.2. The operating organization should make the best use of the commissioning stage to become completely familiar with the facility. It is the best opportunity to develop a strong safety culture and positive behavioral attitudes throughout the entire organization. This approach should be applied considering the full range of operations:

- During campaigns of fuel reprocessing;
- Start-up and run-down periods;
- Work conducted between campaigns and emergency responses.

6.3. The head of the facility⁴⁰ has responsibility for safety throughout the reprocessing facility. To provide considered advice to the head of the facility, a Safety Committee should be established at this stage (if one has not already been established). The Safety Committee should consider:

- Any changes or modifications required for, or as a result of, commissioning;
- The results of commissioning;
- The facility safety case, and;
- Any modifications to the safety case as a result of commissioning.

6.4. Prior to commissioning the expected values for parameters important to safety to be measured during commissioning should be established as far as is reasonably practicable. These values - along with any uncertainties in their determination and maximum and minimum allowable variations (as appropriate) - should determine the acceptability of commissioning results. Any measurements during commissioning which fall outside the acceptable range should be the subject of retest (and safety assessment, reassessment if confirmed).

6.5. All commissioning tests should be repeated a sufficient number of times and, as necessary under varying conditions, to verify their repeatability. The impact of a failure or

⁴⁰ The title of this person will vary in different Member States. It is the most senior manager with ultimate responsibility for decisions effecting safety at the facility. Where a facility has more than one Safety Committee they may advise managers with safety responsibilities for part of the facility but all should have access to the most senior manager in case of disagreement on safety issues.

error in the measurement or response (the graded approach) should determine the level of assurance required (this should also be established in advance).

6.6. During commissioning, operational limits and normal values for safety significant parameters should be established as well as acceptable variation values due to facility transients and other small perturbations. Considerations in this area should include changing from one facility state to another (at the start and end of a campaign). Such limits and values may include the type, quantity and state of the fuel to be accepted (including such factors as the 'burn up' and duration expired since the fuel was discharged from the reactor).

6.7. This guide addresses only the commissioning of safety related aspects of reprocessing facilities. Performance demonstration and/or process optimization, except in so far as supporting the safety case, SSCs or OLCs is a matter for the operating organization. For reprocessing facilities the verification process defined in the (Ref. [1]: Section 8), should be followed rigorously, due to the high hazard potential and complexity of the facilities. Where possible, lessons learned from the commissioning and operations of similar reprocessing facilities should be sought out and applied.

6.8. Particular attention should be applied to the detection, control and exclusion of foreign material, examples of which include spent welding rods, waste building materials and general debris. This type of material may be inadvertently introduced during construction and one of the objectives of the commissioning process is to locate and remove all such foreign material, whilst enhancing controls to limit further introduction.

6.9. Commissioning typically requires the use of temporary works (such as utility supplies, supports for items of plant and access openings in building structures). The operating organization should establish suitable controls to control the use of temporary works (including the use of the modification process as required). These controls should include establishing a process for registering all such works, appointing a responsible person to oversee the application of the controls, a process to approve the introduction of such works and a process to verify that all such works have either been removed at the end of commissioning or are properly approved to remain in place, as a modification and included in the safety case for operations. Similar requirements apply to the use of temporary electrical or instrument supplies and connections to allow the testing of items isolation or the injection of test signals. Where these temporary changes affect any SSC important to safety a full functional check should be carried out and the results recorded after normal conditions have been restored.

COMMISSIONING PROGRAMME

6.10. Because of the complexity and size of reprocessing facilities it may be appropriate to commission the facility by sections. If this is the case, the operating organization should ensure that sections already commissioned are suitably maintained and that the knowledge and experience gained during commissioning is retained.

6.11. In accordance with the categorization of the SSC, the opportunity for it being altered in any way during subsequent construction or installation, and the extent of testing possible, reassurance or verification tests should also be included in the commissioning programme.

6.12. Consideration should also be given by the Safety Committee to the safety of arrangements for controlling such section by section commissioning and the arrangements for communications between the commissioning and other groups in the facility. The Committee should also consider whether any safety components tested earlier in the programme require reassurance testing prior to the next stage of commissioning (as a check on arrangements in 6.11). This may also apply to recently commissioned sections if there is a significant delay in proceeding to the next stage of commissioning due to e.g. the need for modifications or safety case revision.

6.13. Consideration should be given to the need to sequence the commissioning so that facilities required to support the section being commissioned are able to provide such support at the appropriate time (or suitable alternative arrangements are made). This should involve considerations of “upstream⁴¹” facilities (including supplies of utilities such as electrical power, steam, reagents, cooling water and compressed air), “downstream⁴²” facilities (including waste treatment, aqueous and aerial discharges, environmental monitoring) and “support⁴³” facilities (including automatic sampling benches, sample transfer network, analytical laboratories).

6.14. Where inactive simulates or temporary reagent supplies are introduced for commissioning purposes, care should be taken that these are identical, as far as practicable, (chemically and physically) to the material to be used during operations. If not identical, then the effect of any differences should be rigorously analyzed before approval for use. This analysis should identify any effects on the commissioning results arising from these differences. It should also assess the potential effects of any minor constituents or contaminants which might affect the integrity of the facility over its lifetime.

⁴¹Parts of the fuel cycle facility or site that provide feeds (reagent, utilities etc.) to the section being commissioned

⁴²Parts of the fuel cycle facility or site that accept products or waste from the section being commissioned

⁴³ Parts of the facility ancillary to the section being commissioned but which are required to allow or monitor its operation

6.15. Typically, each stage of commissioning will require regulatory approval in accordance with national regulations, prior to starting and at completion. The operating organization should establish and maintain effective communications with the regulatory authority, so as to ensure full understanding of the requirements and to maintain compliance with those requirements.

6.16. The commissioning programme may vary according to Member States' practices. Nevertheless, the following activities should be performed:

- Confirmation of the shielding and containment/confinement performances;
- Demonstration of criticality detection and alarm system availability;
- Demonstration of the other detection and alarm systems (e.g. fire) availability.

COMMISSIONING STAGES

6.17. For a reprocessing facility, the commissioning should be divided into a number of distinct stages, according to the objectives to be achieved. Typically, this may involve four stages:

Stage 1: Construction testing:

- i. For some SSCs, where verification of compliance may not be possible to the same extent, after construction and installation, testing should take place during construction and installation. This testing should be observed by representative(s) of the operating organization and the outcome should be reported with the first stage of commissioning. Examples of typical items include seismic resistance, wall homogeneity control, pipe welding control, vessel construction control and parameters relevant to various passive SSCs;
- ii. When the direct testing of safety functions is not practically possible, alternative methods of adequately demonstrating their performance should be made in agreement with the national authority, before later stages of commissioning commence. These methods may include the verification and audit of materials; supplier's training records etc. It should be noted that this places further emphasis on the importance of an effective management system;
- iii. Testing of other SSC's may be performed at this stage, in accordance with national requirements;
- iv. In all cases the recommendations of paras. 6.11 and 6.12 should strictly apply.

Stage 2: Inactive or 'cold processing' commissioning:

- i. In this stage, the facility's systems are systematically tested, both individual items of equipment and the systems in their entirety. As much verification and testing as practicable should be carried out because of the relative ease of taking corrective actions in this stage;
- ii. In this stage, operators should take the opportunity to develop the set of operational documents and to learn the details of the systems. Such operational documents should include those related to the operation and maintenance of the facility and those relevant to any anticipated operational occurrences, including emergencies;
- iii. The completion of inactive commissioning also provides the last opportunity of examine the facility under inactive conditions. This is a valuable opportunity to simulate transients or the complete failure of support systems, e.g., ventilation, electrical power, steam, cooling water and compressed air. Such tests and simulations should be used to improve the responses available by comparing the outcomes and responses to those identified in calculations of simulated events;
- iv. This is also a final opportunity to ensure that all required maintenance can be completed, once the facility is active. This is particularly applicable to all hot cells and items of equipment which can only be maintained by remote means. As maintenance is known to be a major contributor to worker doses in reprocessing facilities the opportunity should also be taken to verify active maintenance procedures and controls, optimize dose control arrangements and identify any aids required to simplify or make maintenance quicker;
- v. reprocessing facilities are complex facilities and to avoid any potential error the clear, consistent and unambiguous labelling of rooms, pieces of equipment, systems, components, cables, pipes etc. should be finalized as necessary during inactive commissioning;
- vi. Clear and concise communications between management, supervisors and workers (and between and within different shifts of workers under normal and abnormal circumstances and with the relevant emergency services) is a vital component of overall facility safety. This stage of commissioning provides the opportunity, not only to commission and exercise, but also to become familiar with, these lines of communication. The adoption and training of personnel in use of the full range of human performance techniques is strongly recommended (these may include, International Phonetic Alphabet, three-way communications, pre-job briefing, post-job review, questioning attitude and peer review). This stage of commissioning should also be used to develop a standard format(s) for log books and shift handover procedures and to train and assess personnel in their use;

- vii. Particular attention should also be paid to confirming that all connections have been made as expected. This should involve confirmation that all process lines, service connections and utility lines start and end in the expected places and that they follow the expected routes, as defined in the design documentation. Exceptions which may occur should be assessed for their safety consequences and should then either be corrected or accepted, with suitable approvals and updating of documentation;

Stage 3: Trace active or uranium commissioning:

- i. Natural or depleted uranium should be used in this stage, to avoid criticality risks, to minimize doses due to occupational exposure and to limit possible needs for decontamination. This stage provides the opportunity to initiate the control regimes that will be necessary during active commissioning, when fission products and fissile materials are introduced. Safety tests performed during this commissioning period should mainly be devoted to confinement checking. This should include: (i) checking for airborne radioactive material; (ii) smear checks on surfaces; and (iii) checking for gaseous discharges and liquid releases. Unexpected accumulations of material should also be checked for;
- ii. For the timely protection of workers, all local and personnel dosimetry should be operational with supporting management arrangement when radioactive material is introduced;
- iii. This stage should also be used to provide some measurable verification of items which were previously only calculated theoretically (particularly discharges). The use of tracers⁴⁴ should also be considered to enhance or allow such verification;
- iv. The organization, procedures, systems and facilities (on- and off-site) related to emergency planning and preparedness shall (Ref. [1]: para 9.66) be commissioned before active commissioning, see Section 7: Operation: Emergency planning and preparedness;

Stage 4: Active or 'hot processing' commissioning:

- i. Regulatory permission to operate the facility is generally issued to the operating organization before the start of this stage. In this case, 'hot processing' commissioning will be performed under the responsibility, safety procedures and organization of the operating organization for a fully operational facility. It should be considered part of the operational stage of the facility;

⁴⁴ Tracers - Small quantities of very low active (or inactive) materials that mimic the behaviour of the operational material to determine process parameters

- ii. In any event, during active commissioning, and as far as defined and applicable, the safety requirements valid for the operation stage of the facility should be applied, unless a safety assessment is made to suspend or modify the regime;
- iii. Compared to inactive commissioning, active commissioning requires major changes in the facility control arrangements and staff skills e.g. related to confinement, criticality, cooling and radiation. The management should ensure that both the facility and the workforce are fully ready for the change to active commissioning before it is implemented. For the workforce, the safety culture should be enhanced at that stage so as to ensure safe operation;
- iv. This stage enables the process to be progressively brought into full operation by steadily increasing both the quantity and activity of the spent fuel fed into the facility;
- v. This stage provides further measurable verification of items which were previously only calculated (particularly of dose rates to the workforce and of environmental discharges). The feedback from such measurable verification should be used to inform corrective actions accordingly and to update the assumptions in any estimates and calculations. Such corrective actions may include making changes to the safety case or adding or changing safety features or work practices. All such modifications should be endorsed by the Safety Committee and approved by the head of the facility;

The requirements for this stage are set out in (Ref. [1]: Appendix IV: paras. IV.55-IV.57)).

7. OPERATION

ORGANIZATION OF REPROCESSING FACILITIES

7.1. Given the large scale and complexity of reprocessing facilities, there is a particular need for rigorous control, planning and co-ordination of the work to be undertaken in the facility, whether for operations, routine maintenance, non-routine maintenance – such as may be conducted between campaigns – and projects (modifications). The organization of the reprocessing facility should provide for this need, typically through a consistent and systematic method of approving, planning and coordinating such work (the management system). Provision of accurate and timely information to all those involved should be a further characteristic of such systems. (Ref. [1]: Section 4) defines the requirements for the organization of reprocessing facilities.

7.2. The requirements on staff training, minimum staffing etc. are given in (Ref. [1]: paras. 9.3-9.14, 9.52, 9.53 and Appendix IV: para. IV.67).

7.3. Suitable arrangements should be made to gather, assess and propagate any lessons learned during the Commissioning stage of the facility and, continually, during the Operations stage. Similar arrangements should be put in place to adopt lessons learned from other organizations which operate reprocessing facilities.

7.4. Round the clock continuity of organization should be provided in order to ensure that the appropriate authority is present on the site, with appropriate access to suitably qualified and experienced personnel (whether on-site or available to be called in). This should include operations, engineering, radiation protection, emergency management and others as necessary.

7.5. Related to the complexity and hazard potential, the operating organization should:

- Establish and maintain the quality of the interfaces (field implementation of communication procedures) between:
 - Shift and day operations staff and support staff (especially maintenance, and radiation protection staffs) within the reprocessing facility, as reprocessing facilities typically operate on a 24 hours/ 365 days a year basis even when not processing material;
 - The reprocessing facility and other site facilities particularly waste treatment facilities and utility supplies that are closely coupled to the reprocessing facility. For example: to ensure the effective management of the timing, quality (content) and quantity of transfers, as well as confirming the availability of receipt storage capacity or to ensure that the facility operators have the latest information on the continuity of utility supplies etc.;
 - The reprocessing facility and the on-site radioactive material transport department, if any;
 - The reprocessing facility and any organization engaged to make modifications to the facility (e.g., projects to improve throughput or to provide additional capacity);
 - The reprocessing facility and wider emergency services involved in the reprocessing facility emergency response functions (Ref. [1]: paras. 9.62-9.67);

- Review periodically the operational management structure, training, experience and expertise of reprocessing facility staff (individually and collectively) to ensure that, as far as reasonably foreseeable, sufficient knowledge and experience is available at all times, and in reasonably foreseeable circumstances (e.g., staff absences). The requirement in Para 9.19 Ref [1] for control of organizational change should be extended to include key safety personnel and posts based upon this analysis.

7.6. Due to the size, complexity and hazard potential, the safety committee(s) in reprocessing facilities, as defined in (Ref. [1]: para. 9.15) should be established in a formal manner, sufficiently staffed and should include diverse expertise and appropriate independence.

QUALIFICATION AND TRAINING OF PERSONNEL

7.7. The safety requirements related to the qualification and training of facility personnel are defined in (Ref. [1]: paras. 9.8-9.13). Guidance can also be found in (Ref. [1]: paras. 4.6-4.25).

7.8. The safety risks and hazards for operators, maintenance staff and other personnel such as the decontamination team should be carefully considered when establishing the training programme. The need for training all levels of management should be considered in order for personnel involved in the management and operation to fully understand the complexity and the range of hazards in reprocessing facilities.

7.9. Comprehensive training should cover both automatic and manual operations. Dedicated training facilities should be established as necessary with the training emphasis activities according to their potential safety consequences.

7.10. For manual activities, focus should be put on the following:

- Use of master-slave manipulators and other remote equipment (HA)
- Maintenance, clean down and projects activities which may involve intervention in the active parts of the facility and / or changes to facility configuration,
- Sampling of materials from the facility
- Work within glove boxes (MA).

7.11. For automatic modes of operation, focus should be put on the following:

- Alertness to the possibility of errors in automatic and remote system
- Alertness to unexpected changes (or lack of changes) in key parameters

- The particular differences in operation which may occur during the ramp-up and ramp-down of a campaign
- Responses to be taken in situations which are outside normal (including emergency response actions)

FACILITY OPERATION

Operating documentation

7.12. For reprocessing facilities (Ref. [1]: paras. 9.21-9.27) should be strictly adhered to.

7.13. In order to ensure that, under normal circumstances, the reprocessing facility operates well within its OLCs, a set of operational sub-limits should be defined at lower levels by the operating organization. The resulting margins should be derived from the design considerations and from experience of operating the facility (both during commissioning and in operations) to maximize safety margin whilst minimizing breaches of the sub-limits.

7.14. Authority to make operating decisions should be assigned to suitable management levels in accordance with the OLCs and the operational sub-limits. If a sub-limit or an OLC is exceeded, the appropriate level of management should be informed (Ref. [1]: Appendix IV: para. IV.136). Where immediate decisions or responses are required for safety reasons, the circumstances should be defined, as far as practicable, in procedures and the appropriate shift or day staff trained and authorized to make the required decisions.

7.15. Any excursion outside the sets of sub-limits should be adequately investigated by the operational organization and the lessons learned should be applied to prevent a recurrence.

7.16. Operating documents should be prepared which list all the limits and conditions, and define the procedures to restore the process to within the limits and sub-limits (Ref. [1]: paras. 9.22 and 9.26). Annex II gives examples of parameters which can be used for defining operating limits and conditions.

7.17. Operating procedures should be developed to directly control process operations. To maximize the benefit of the reprocessing facilities robust design, it is vital that well written and concise procedures for the operational state, ramp-up, ramp-down, non-operational and accident conditions should be in place. Operators should be fully trained and assessed, using simulators where appropriate in these procedures.

7.18. The documents prepared should also systematically link to the safety case to ensure that safety requirements are comprehensively implemented in the instructions.

Specific provisions

7.19. The development and maintenance of a feed programme (Ref. [1]: para IV.58) is important to safety in a reprocessing facility. The operating organization should establish organizational responsibility for the feed programme, clear procedures which specify how the feed programme should be managed, provision of independent verification methods, etc.

7.20. Reprocessing facilities are generally designed to accept a specific range of fuel types, with given ranges of burn-up etc. The feed programme should take into account fuel parameters (e.g. irradiation data, initial enrichment, duration of cooling following discharge from the reactor), and facility safety constraints.

7.21. Reprocessing facility process control generally relies on a combination of instrument readings and analytical data from samples. The analytical activities should be managed and operated so as to minimize doses to workers. The waste resulting from these activities should be managed according to established procedures. Analytical instruments and methods should be used under a management system and subject to suitable calibration and verification. Decisions made on the basis of sample analysis should take proper account of the accuracy of the sampling process, analytical methods used and, where relevant, the delay between sampling and result being available.

7.22. Reprocessing facility operation is often divided into campaigns (driven by operational, commercial or safety constraints) and inter-campaigns period (for modifications to equipment, performing maintenance and safeguards purposes). Maintenance is safer during these period but increased interventions result in higher contamination and dose risks. Intensive maintenance periods often require the use of less experienced personnel. The operating organization should take action to address the specific risks of intensive maintenance during inter-campaigns periods, which may include specific training, the allocation of more experienced workers to teams of less experienced personnel, additional supervision of work etc.

7.23. The management system should include provision for a program of facility internal, audits whose purpose is to periodically confirm that the facility is being operated in accordance with operating procedures (including its OLCs). Suitably qualified and

experienced persons should carry out such audits and consideration should be given to using personnel independent of the direct management chain. See also (Ref. [1]: para. 9.71).

7.24. Operator including senior management walk-around's should be specified with the aim of ensuring that as far as practicable all area of the facility are subject to regular surveillance with particular attention paid to the recording, evaluating and reporting abnormal conditions. This programme of walk-around's should include a suitable level of independence (for example, including personnel from other facilities). Examples of conditions to be observed should include:

- Local instrument readings and visual indications relevant to liquid levels or leaks including sump levels, containment and ventilation failure;
- Safety checks having been completed within the specified range of dates (e.g., on access equipment, fire extinguishers and electrical equipment);
- Conditions at access points to supervised areas;
- Number and condition of temporarily restricted access (radiation or contamination) areas;
- Availability and functioning of personnel contamination monitors;
- Accumulation of waste;
- Proper storage of materials and equipment;
- Ready availability of emergency equipment;

7.25. After the batch transfer of process liquids, staff should confirm, as far as practicable, that the volume transferred from the sending vessel corresponds to the volume received (see para 4.119)

7.26. Waste minimization should be an important objective for reprocessing facility management and operators. As part of the management system an integrated waste management plan and supporting procedures should be developed, implemented, regularly reviewed and updated as required. All facility personnel should be trained in the “waste hierarchy”, the plan requirements and the relevant procedures. Waste minimization targets should be set, regularly reviewed and system of continuous improvement (waste volumes in relation to work carried out) should be in place (Ref. [1]. paras 9.5`4-9.56).

7.27. All waste should be treated and stored in accordance with pre-established criteria and the national waste classification scheme and should take into consideration both on-site storage capacity and disposal options. Every effort should be made to characterize the wastes as fully as possible, especially those without a recognized disposal route. The available information characterizing the waste should be held in secure and recoverable archives (Ref. [1]: Appendix IV: paras IV.80 and IV.82).

Exclusion of foreign Material

7.28. Suitable controls should be established to ensure, as far as is reasonably practicable, that foreign material is excluded from the process. These controls should build upon those developed during commissioning and are particularly relevant to maintenance activities and to the supply and delivery of process reagents.

Maintenance, calibration, periodic testing and inspection

Maintenance, (including periodic testing and inspection)

7.29. As reprocessing facilities are large and complex facilities, maintenance should be coordinated and managed to ensure that unanticipated interactions, either with operation or between two maintenance activities will not result in negative safety consequences.

7.30. Process should be put in place to ensure that all maintenance activities are reviewed for evidence of reliability or performance issues. The safety committee should routinely review the reports generated for the most significant SSCs and any other significant findings with consideration of their implications on facility safety. Higher risk, complex or extended maintenance tasks should be regularly reviewed to benefit from lessons learned and to implement constant optimization of doses and environmental discharges

7.31. Prior to any maintenance activities, consideration should be given to radiological checks of the work areas, the need for decontamination and the need for periodic survey during the maintenance period and before return to service

7.32. Maintenance (and any preparatory operations) which involves temporary changes to confinement and/or shielding should always be thoroughly analyzed beforehand, including any temporary or transient stages, to ensure that contamination and doses are acceptable, and appropriate compensatory measures, where possible, and monitoring requirements are defined (See paras. 7.68-7.69)

7.33. During maintenance, isolation between the equipment being maintained and plant in operation or other facilities with radioactive inventory should be ensured as far as reasonably practicable

7.34. For maintenance tasks with high anticipated doses or dose risk, consideration should be given to providing mock-up and/or electronic models of the area, or other training methods, to develop task familiarity, develop operator aids and work techniques to be optimized.

7.35. As far as possible hands-on maintenance should be performed after equipment drain down or cleaned/ decontaminated and, as far as reasonable practicable, washed out, to ensure that active materials are removed and radiation and contamination risks reduced.

Calibration

7.36. The accurate and timely calibration of equipment is important to the safe operation of a reprocessing facility. Calibration procedures and standards should include equipment used by facilities and organizations which support the reprocessing facility, such as analytical laboratories, suppliers of radiation protection equipment, reagent suppliers etc. The operating organization should satisfy itself that such externally supplied or located equipment is properly calibrated at all times.

MODIFICATION CONTROL

7.37. As part of the management system a standard process for any modification should be applied in a reprocessing facility (Ref. [1]: para. 9.35). The process should use a modification control form or equivalent management tool. The facility should prepare procedural guidelines and provide training to ensure that responsible personnel have the necessary training and authority to ensure that projects are carefully considered for the potential hazards during installation (e.g. non-routine crane lifts), commissioning and operation and modification control forms raised as necessary. Conservative decision making should be used when making decisions about modifications.

7.38. The modification control form should contain a description of what the modification is and why it is being made. The main purpose of the modification control form is to provide the basis for a safety assessment of the modification, especially any changes that may affect radiological or criticality safety. The modification control form should be used to identify all the aspects of safety that may be affected by the modification (including procedures and

emergency management) and to demonstrate that adequate and sufficient safety provisions are in place to control the potential hazards both during and after the modification with any temporary or transient stages clearly identified and assessed.

7.39. Modification control forms should be scrutinized by and be subject to approval by qualified and experienced persons to verify that the arguments used to demonstrate safety are suitably robust. This should be considered particularly important if the modification could have an effect on doses to the workers, the public, environment or criticality safety. The depth of the safety arguments and the degree of scrutiny to which they are subjected should be commensurate with the safety significance (potential hazard) of the modification. Review of modification control forms should be by the safety committee or an equivalent committee, with suitable expertise, independent examination and record keeping. Responsibility for the approval and control of modifications should rest with head of the reprocessing facility.

7.40. The modification control form should also specify which documentation and training will need to be updated as a result of the modification (e.g. training plans, specifications, safety assessment, notes, drawings, engineering flow diagrams, process instrumentation diagrams and operating procedures).

7.41. Procedures for the control of documentation and training should be put in place to ensure that, where necessary (as specified in the modification control form), training has been given and assessed and documentation changed before the modification is commissioned and that all (the remaining) documentation and training requirements changes are completed within a reasonable time period following the modification (see para. 7.44 also).

7.42. The modification control form should specify the functional checks (commissioning) that are required before the modified system may be declared fully operational again.

7.43. The modifications made to a facility should be reviewed on a regular basis to ensure that the combined effects of a number of modifications with minor safety significance do not have unforeseen effects on the overall safety of the facility. This may be part of or additional to a periodic safety review or equivalent process.

7.44. No modifications affecting OLCs or SSCs should be put into operation unless new or modified OLCs or SSCs, and training and operating, including maintenance, instructions, as required in the modification control form, are in place and the required number of operators are have been trained in their use.

CRITICALITY SAFETY

7.45. In a reprocessing facility, the procedures and measures for controlling criticality hazards should be strictly applied (Ref. [1]: paras. 9.49 and 9.50 and Appendix IV: paras. IV.66-IV.76).

7.46. Operational aspects of the control of criticality hazards in reprocessing facilities should include:

- Rigidly following the pre-determined feed programme;
- Watchfulness for unexpected changes in conditions that could increase the risk of a criticality accident;
- Training of personnel in the factors affecting criticality as well as in facility procedures related to the avoidance and control of criticality;
- Management of moderating materials, particularly hydrogenated materials;
- Management of mass in transfers of fissile materials where mass control is used;
- Reliable methods for detecting the onset of any of the foregoing conditions;
- Periodic calibration or testing of systems for the control of criticality hazards;
- Evacuation drills to prepare for the occurrence of a criticality and/ or the actuation of a criticality accident alarm.

7.47. For each reprocessing campaign, prior to starting feed to the dissolver, the settings of criticality control instrument alarm parameters should be checked and changed if necessary based on the feed programme of the campaign. The feed programme should be supported by appropriate fuel monitoring instruments, as far as possible and administrative controls, to confirm that the fuel characteristics match the feed programme. All software used to support feed programme calculations should be suitably qualified and verified.

7.48. When burn up credit is used in the criticality safety analysis appropriate burn-up measurements are required and care should be taken to allow for the associated measurement uncertainties.

7.49. In chemical cycles, particular care should be given to the control and monitoring of those stages of the process where fissile materials are concentrated or may be concentrated (e.g. by evaporation, liquid/liquid extraction, or other means such as precipitation/crystallization). A specific concern for reprocessing facilities is the dilution of fissile material solutions and/ or Pu valence changes which can result in hydrolysis and precipitation.

7.50. If identified by the safety analysis, the following issues should be addressed in facility procedures:

- Isolation, often by disconnection and /or suitable locking devices, of water or other reagent wash lines;
- Normal and allowable fissile concentration(s);
- The feed setting and control of reagents (solvent and aqueous) flows;
- The conditioning of fissile solutions (heating/cooling etc.) according to the facility flow sheet (technical basis).

These requirements should be supported by appropriate alarm settings on the instruments for monitoring the feeds and solutions.

7.51. Where there are any uncertainties in the characteristics of fissile materials, conservative values should be used for parameters such as fissile content and isotopic composition. Particular issues may be encountered when carrying out maintenance work and during inter-campaign periods when material or residues from different campaigns may become mixed.

7.52. The requirements for criticality avoidance and conservative decision making may require, in some circumstances (e.g. loss of reagent feed) that the transfer of fissile material within a separation process has to be brought to a sudden stop in accordance with the OLCs, whilst the situation is assessed and recovery planned. As far as possible all such situation should have been anticipated, assessed and included within appropriate procedures including step by step “recovery” procedures to return the facility to a safe and stable state. Nevertheless criticality staff should be involved in all such decisions and should subsequently analyze the event for feedback and learning.

RADIATION PROTECTION

7.53. There should be a management policy to optimize internal and external exposure. It should include the minimization of sources of radiation by all available means and administrative arrangements including the use of time and distance during operations and maintenance activities.

7.54. The operational radiation protection program (ORPP) should take into account the large inventories, the variety of sources, the complexity and size of reprocessing facilities.

7.55. The ORPP should include provisions for detecting changes in the radiation status (e.g. hot spots, slow incremental increases or reductions of radiation/ contamination levels) of equipment (e.g. pipe, vessel, drip-trays, filters), rooms (e.g. contaminated deposits, increase

of airborne activity), or from effluent or environment monitoring. It should also promptly define the problem and identify and implement timely corrective and/ or mitigation actions.

7.56. To complement the radiological protection surveillance network inside and outside the reprocessing facility buildings, regular, routine surveys by trained personnel should be organized to provide, as far as practicable, regular surveillance monitoring of the whole reprocessing facility site. Particular attention should be paid to the recording, labelling/ posting where necessary, evaluating and reporting abnormal radiation level or abnormal situations. The frequency of surveillance should be related to the relative risk of radiation or contamination in the individual survey areas. Consideration should be given by the radiation protection personnel to assigning a frequency of survey to each facility area based upon easily identified boundaries. The use of photographs or drawings of the area/ equipment should be considered to report the survey findings.

7.57. During reprocessing facility operation, radiation protection personnel should be part of the decision making process to apply the dose optimization requirement (e.g. for the early detection and mitigation of hot spots), and for proper housekeeping (e.g. waste segregation, packaging and removal).

Protection against exposure

7.58. During operation (including maintenance) protection against internal and/or external exposure should be provided to optimize dose. Limitation of exposure time and use of additional shielding and remote operations and the use of mock-ups should be considered, if necessary, for training and optimization of complex or high dose task.

7.59. A high standard of housekeeping should be maintained within the facility. Cleaning techniques should be used which do not cause airborne contamination. Waste arising from maintenance or similar interventions should be segregated by type (i.e. disposal route), collected and directed to disposal storage appropriately, in a timely manner.

7.60. Regular radiation and contamination surveys of facility areas and equipment should be carried out to confirm the adequacy of facility containment and cleaning programmes. Prompt investigations should be carried out following increased radiation or contamination levels.

7.61. To aid staff in assessing the risk of any task and in assigning the frequency of routine (contamination/ radiation) surveys (rounds), consideration should be given to assigning facility areas a contamination and/ or radiation classification. These should be based initially on the classifications used in the facility design. The areas and the boundaries between them

should be regularly checked and adjusted to match current conditions. Continuous air monitoring should be carried out to alert facility operators if airborne contamination levels exceed predetermined action levels. The action levels should be set as near as possible to the level normal for the area. Mobile air samplers should be used near contamination sources and at the boundaries of contaminated areas as necessary. Prompt investigation should be carried out following high airborne contamination readings.

7.62. Contamination zones should be delineated with proper posting. Temporary confinement should be used to accommodate the higher levels of contamination (e.g. temporary enclosure with contamination check entry point and dedicated, local ventilation system).

7.63. Good communications between operators, radiation protection personnel, maintenance staff, and more senior management should be established and maintained to ensure timely corrective actions.

7.64. Personnel should be trained to adopt the correct behavior during operational states e.g. training on general and local radiation protection requirements.

7.65. Personnel should be trained in the use of dosimeters and personnel protective equipment (i.e. lead gloves and apron) including dressing and undressing and in self-monitoring. Personal protective equipment should be maintained in good condition, periodically inspected and readily available.

7.66. Personnel and equipment should be checked for contamination and decontaminated, if necessary, prior exiting contaminated areas.

7.67. Careful consideration should be given to the combination of radiological & industrial hazards (oxygen deficiency, heat stress, etc.) with particular attention paid to the risk/ benefit balance for the use of personnel protective equipment, especially air-fed systems.

Recommendations for intrusive maintenance⁴⁵

7.68. Intrusive maintenance is a normal or regular occurrence in reprocessing facilities. The procedures for such work should include:

- a) Estimation of doses for all staff (including decontamination workforce) prior to the work starting;
- b) Preparatory activities to minimize individual and collective doses for all staff , including:
 - Identification of specific risks due to the intrusive maintenance;

⁴⁵Intrusive maintenance: Maintenance involving the significant reduction of shielding, the breaking of static containment or significant reduction of dynamic containment.

- Operations to minimize the source term for local doses e.g. flush out and rinsing of parts of the process;
 - Consideration of the use of mock-ups, remote devices, additional shielding or personnel protective equipment, monitoring devices and dosimeters;
 - Identification of relevant procedures within the work permit, which also defines individual and collective protection requirements e.g. personnel protective equipment, monitoring devices and dosimeters, time and dose limitations;
- c) Measurement of doses during the work;
- If doses (or dose rates) are significantly higher than anticipated, consideration should be given to withdrawing personnel to re-evaluate the work;
- d) Implementation of feedback to identify possible improvements.
- For extended maintenance activities feedback should be applied to the ongoing task.

7.69. Procedures that address the following points should be defined and applied according to level of risk:

- a) A temporary controlled area should be created that includes the work area.
- According to the risk a temporary ventilation system with filtration and/or exhausting to the facility ventilation system should be installed.
 - Additional radiation and/or airborne contamination monitors should be installed as necessary;
- b) Personal protective equipment (e.g. respirators, over-suits etc.) as specified, should be provided at the entry points and used when dealing with potential releases of radioactive materials;
- c) In accordance with assessed the risk, a dedicated trained person(s), usually radiation protection personnel, should be present local to the work place to monitor the radiological, and other safety related conditions with the authority to halt the work and withdraw personnel in case of unacceptable risk (e.g. oxygen deficiency, if air fed equipment is in use). This dedicated person(s) should also provide assistance to the maintenance staff in dressing, monitoring and undressing from personal protective equipment;

These recommendations are applicable when the normal containment barrier is to be reduced or removed as part of maintenance/modification activity.

Monitoring of occupational exposures

7.70. There should be appropriate provisions for the measurement of radiation doses to individuals. Instrumentation should be provided, where appropriate, to give prompt, reliable and accurate indication of airborne and direct radiation in normal operation and accidental conditions.

7.71. Personnel exposures should be estimated in advance and monitored during work activity, using suitably located devices and/ or personal dosimeters (preferably alarmed) where appropriate (see para. 7.75 also).

7.72. The extent and type of monitoring should be commensurate with the expected level of airborne activity, contamination, radiation or the potential for these to change, at the work places.

7.73. Personal dosimeters should be used as necessary, with where available alarms set on dose and dose rate. The type of dosimeter(s) should be chosen in relation to the hazard (see para. 7.76). In areas with a criticality hazard, use of specific dosimeters (criticality 'lockets'), should be considered.

7.74. The selection and use of personal dosimeters and mobile radiation detectors should be adapted to the expected spectrum of radiation energies (alpha, beta/ gamma, neutron) and the physical states (solid, liquid and/or gaseous forms) of radioactive materials.

7.75. Monitoring equipment of local and individual doses and airborne activity for reprocessing facilities should include, as necessary:

- Film, solid trace or electronic beta/ gamma and neutron dosimeters, criticality 'lockets', TLDs (Thermo Luminescence Dosimeter) & Indium foil criticality event detectors;
- TLD extremity dosimeters, for extremity (e.g. finger) doses.
- Mobile activity in air monitors with timely alarm (in maintenance work/tents and temporary enclosures and air locks);
- Mobile air samplers for low level monitoring.

7.76. The methodology for assessing internal dose should be based on timely collection of air sampling data in the workplace, combined with worker occupancy data. Where necessary the relationship between fixed detectors and individual doses should be verified by the use of personal air samplers in preferably, limited duration, sampling campaigns.

7.77. In the event of abnormal radiation or contamination being detected in a room or area, checks of the staff having been present in the area should be carried out and the appropriate

decontamination or medical intervention implemented according to the results. The details of such interventions are outside the scope of this publication.

7.78. In addition to personal and area monitoring routine in-vivo monitoring biological sampling should be implemented according to national regulations. The chemical effect and the radiological effects should be taking into account in surveillance programme as necessary. Periodical lung or whole body count should also be performed to check for internal dose for relevant personnel.

FIRE, CHEMICAL & INDUSTRIAL SAFETY MANAGEMENT

7.79. The potential for fire or exposure and chemical and other industrial risks are significant for reprocessing facilities due to size and complexity of reprocessing facilities, the nature of the materials processed and stored and the processes used.

7.80. The list of conventional non-nuclear hazards found in reprocessing facilities is extensive due to the factors identified above and could include:

- Conventional hazardous chemicals in the process or at storage ;
- Electrical works;
- Fire and explosion ;
- Superheated water and steam ;
- Asphyxiation hazard;
- Dropped loads;
- Falls from elevated working places;
- Noise;
- Dust.

Chemical hazards

7.81. Reprocessing facilities are designed and operated taking into account the need to protect workers from the hazards associated with the use of strong acids and hazardous chemicals throughout the process and the use of organic solvents in the extraction stages.

7.82. In the facility and analytical laboratories, the use of reagents should be controlled by written procedures (nature, and quantity of authorized chemicals) to prevent explosion, fire, toxicity and hazardous chemical interactions.

7.83. Chemicals should be stored in well aerated premise or dedicated, secure storage arrays outside the process or laboratories areas, preferably in low occupancy areas.

7.84. Personnel should be informed of the chemical hazards that exist. Operating personal should be properly trained on the process chemical hazards in order to adequately identify and respond to the problems that may lead to chemical accidents.

7.85. As required by national regulations, a health surveillance programme should be set up to routinely monitor the health of workers who may be exposed to harmful chemicals.

Fire and explosion hazards

7.86. Flammable, combustible, explosive and strongly oxidizing materials, such as organic solvent at the extraction stage, nitric acid throughout and other materials and reagents with relatively low flammability limits are used in the reprocessing facilities. Emergency systems and arrangements to prevent, minimize and detect hazards associated these materials should be properly maintained, and regularly exercised, to ensure that a rapid response can be deployed to any incident and its impact minimized.

7.87. To minimize fire hazard of pyrophoric metals (Zr or U particles), periodic checking and cleaning of shearing hot cells or other location where these materials could accumulate should be implemented.

7.88. The work permit and facility procedures and instructions should include an adequate assessment and, as necessary, a check-sheet on the potential nuclear consequences of fires resulting from activities which involve potential ignition sources, e.g. welding, and should define the precautions necessary for performing the work.

7.89. The prevention and control of waste material accumulations (contaminated and 'clean') should be rigorously enforced to minimize the 'fire load' (potential) in all areas of a reprocessing facility. Auditing for waste accumulations should be an important element in all routine inspection and surveillance activities by all levels of personnel. Periodic inspections by fire safety professionals should be part of the audit programme.

7.90. To ensure efficiency and operability of fire protection systems suitable procedure, training and drills should be implemented including:

- Periodic testing, inspection and maintenance of the devices associated with fire protection systems (fire detectors, extinguishers, fire dampers);
- General and detailed (location specific) instructions and related training for fire fighters;
- Firefighting plans;
- Fire drills, including the involvement of off-site emergency services;
- Training for operating staff and emergency teams.

WASTE AND EFFLUENT MANAGEMENT

7.91. Any waste generated at reprocessing facility should be characterized by physical, chemical and radiological properties to allow its subsequent optimum management, i.e. appropriate treatment, conditioning and selection or determination of a disposal route.

7.92. To the extent possible, the management of waste should ensure that all waste will meet the specifications for existing disposal routes.

Waste management

7.93. A strategy for the management of radioactive waste should be produced and implemented on a reprocessing facility site.

7.94. Operational arrangements should be such so as to avoid the creation of radioactive waste or reduce to a practical minimum the radioactive waste generated (reducing secondary waste generation, recycling and re-use of materials and decontamination of materials). Trends in radioactive waste generation should be monitored and the effectiveness of applied waste minimization measures demonstrated. Equipment, tools and consumable material entering a hot cell, shielded boxes and a glove box should be minimized as far as practicable.

7.95. The accumulation of radioactive waste on site should be minimized, as far as practicable and all accumulated waste should be stored in purpose designed storage facilities designed and operated to equivalent standards as the reprocessing facility itself.

7.96. Characterization and segregation practices for radioactive wastes should be developed and applied to provide a foundation for safe and effective management of these wastes from generation through to disposal.

7.97. The waste collection and treatment should be organized according to pre-established criteria and procedures defined to meet the requirements of defined or planned treatment and disposal routes.

7.98. Consideration should be given to segregating solid waste according to its area of origin as typical of its potential contamination and routes of treatment and disposal. The use of such 'bounding case' sorting criteria should be considered in relation to optimizing operator dose in conjunction with subsequent remote and/ or automatic detailed characterization and, if necessary, waste sorting in dedicated waste facilities.

7.99. Facility decontamination methods should be adopted which minimize primary and secondary waste generation and facilitate the subsequent treatment of the waste e.g. the compatibility of decontamination chemicals etc. with available waste treatment routes.

7.100. As far as reasonably achievable, decontamination should be used for minimizing environmental impact and maximizing nuclear material recovery. Decontamination of alpha contaminated (Pu) waste should be as complete as economically practicable to minimize impact of long lived emitters to the environment, provided recovery routes are available for the decontamination stream.

7.101. Exemption and clearance procedures for waste should be provided according to national regulation. The procedure should be used as fully as practicable, to minimize the volumes of material going to active disposal routes and thus the size of disposal facility required.

7.102. Information about radioactive waste needed for its safe management now or in the future should be recorded and preserved.

Effluents management

7.103. Reprocessing facilities usually have a number of discharge points corresponding either separately or collectively to the specific authorized discharges. The operation organization should establish an appropriate management structure to operate and control each of these discharge points and the overall reprocessing facility discharges.

7.104. For reprocessing facilities, discharge streams should be measured where possible before discharge or where not, in real time. When used, sampling devices and procedures should provide representative and timely results of the real flows to or batch releases into the environment.

7.105. The aim of the operating organizations should be that all discharges are optimized and within, as a minimum, authorized limits. The personnel involved should have the authority to shutdown processes and facilities, subject to safety considerations, when they have reason to believe that these aims may not be met.

7.106. The operating organization should set a list of performance indicators to help monitor and review the discharge optimization programs. The indicators should be related to maximum upper limits, e.g. monthly goals for discharges to the environment.

7.107. Periodic estimate of the impact to the public (representative person(s)) should be made using data on effluent releases and standard models usually agreed with the regulators.

Aerial discharges

7.108. The radioactive gaseous discharges should be treated, as appropriate by dedicated off-gas treatment systems, and HEPA filters.

7.109. After a filter change, tests and/ or verification of the change procedure should be carried out to ensure that filters are correctly seated and provide at least the removal efficiency used or assumed in the safety analyses.

7.110. The efficiency of the last stage of filter before stack release (or as otherwise required by the safety analysis) should be tested as defined in the OLCs.

Liquid discharges

7.111. All liquids collected from the reprocessing facility site (e.g. from rain water, underground water around buildings, process effluents) that have to be discharged into the environment should be assessed and managed according to authorizations.

7.112. The liquid effluent system (collection and discharge piping, temporary storage if any) should be correctly operated, and its effectiveness maintained as part of the reprocessing facility.

7.113. Reprocessing facility liquid discharges authorization usually specify an annual quantity of radioactive emitters and if necessary, effluent physical and chemical characteristics. They may also have further conditions designed to optimize the environmental impact e.g. discharge at high tide, above a minimum river flow etc. Operational measures should be implemented to meet the authorization requirements.

7.114. Where possible, the reprocessing facility should be operated, as far as the design allows, accommodating batch wise discharges, which allow verification of the necessary parameters by sampling and timely analysis prior to release.

EMERGENCY PLANNING AND PREPAREDNESS

7.118. The scale, complexity and the level of potential hazards of reprocessing facilities mean that the emergency planning and preparedness (for protecting workers, the public and the environment in the event of an accidental release) are particularly important. The requirements are defined in (Refs. [1]: paras. 9.62-9.67, [9] and [12]).

7.119. A review of the emergency scenarios should be conducted. The emergency plan should be based on a list of possible accidents with potential radiological or chemical releases consequences (Ref. [1]: para. 9.63). The plan should be coordinated with off-site emergency organizations and submitted to the regulator.

7.120. The plan should take account of any lessons learned from operating experience and from emergencies that have occurred with similar facilities and should be periodically reviewed and updated.

7.121. The emergency plan should include:

- A description of the on-site organization relevant to emergency response;
- The conditions under which an emergency should be declared;
- The arrangements for initial and subsequent assessment of the conditions at the facility and radiological conditions on and off the site;
- Arrangements for minimizing the exposure of persons on and off the site to ionizing radiation and for ensuring medical treatment of casualties;
- Assessment of the state of the facility and the actions to be taken on the site to limit the extent of any radioactive release;
- The chain of command and communication;
- An inventory of the emergency equipment;
- The arrangements for declaring the termination of an emergency.

7.122. The operating organization responsibilities includes:

- Identifying and/or detecting an emergency or hazard;
- Implementing the on-site emergency plan;
- Taking immediate action to mitigate the consequences of the emergency;
- Protecting individuals on the site and within the area controlled by the operator;
- Establishing ongoing communication with off-site officials;
- Providing, if possible, initial radiological monitoring and technical advice.

7.123. Further information on emergency planning and preparedness can be found in Refs. [9] and [12].

8. PREPARATION FOR DECOMMISSIONING

8.1. Requirements and recommendations for the decommissioning of nuclear fuel cycle facilities can be found in (Ref. [13] and [7]).

8.2. Reprocessing facilities should be, sited, designed, constructed, operated (maintained and modified) to facilitate eventual decommissioning, as far as practicable.

8.3. The following measures should be taken during the design, construction and operational stages of a reprocessing facilities life to facilitate eventual decommissioning:

- Design measures to minimize contamination penetrating structures;
- Physical and procedural methods to prevent the spread of contamination;
- Design features to facilitate decommissioning;
- Consideration of the implications for decommissioning when modifications to and experiments on the facility are proposed;
- Identification of reasonably practicable changes to the facility design to facilitate or accelerate decommissioning;
- Comprehensive record preparation for significant activities and events at all stages of the facility's life, archived in a secure and readily retrievable form, indexed in a documented, logical and consistent manner;
- Minimizing the eventual generation of radioactive waste during decommissioning.

8.4. In the event of decommissioning being significantly delayed after a reprocessing facility has shut down for decommissioning, safety measures should be implemented to maintain the reprocessing facility in safe and stable state, including measures to prevent criticality, spread of contamination, fire, and to maintain appropriate radiological monitoring. Consideration should be given for the need for a revised safety assessment for the 'shut down' facility state and to using 'knowledge management' methods to retain the knowledge and experience of operators in a durable and retrievable form.

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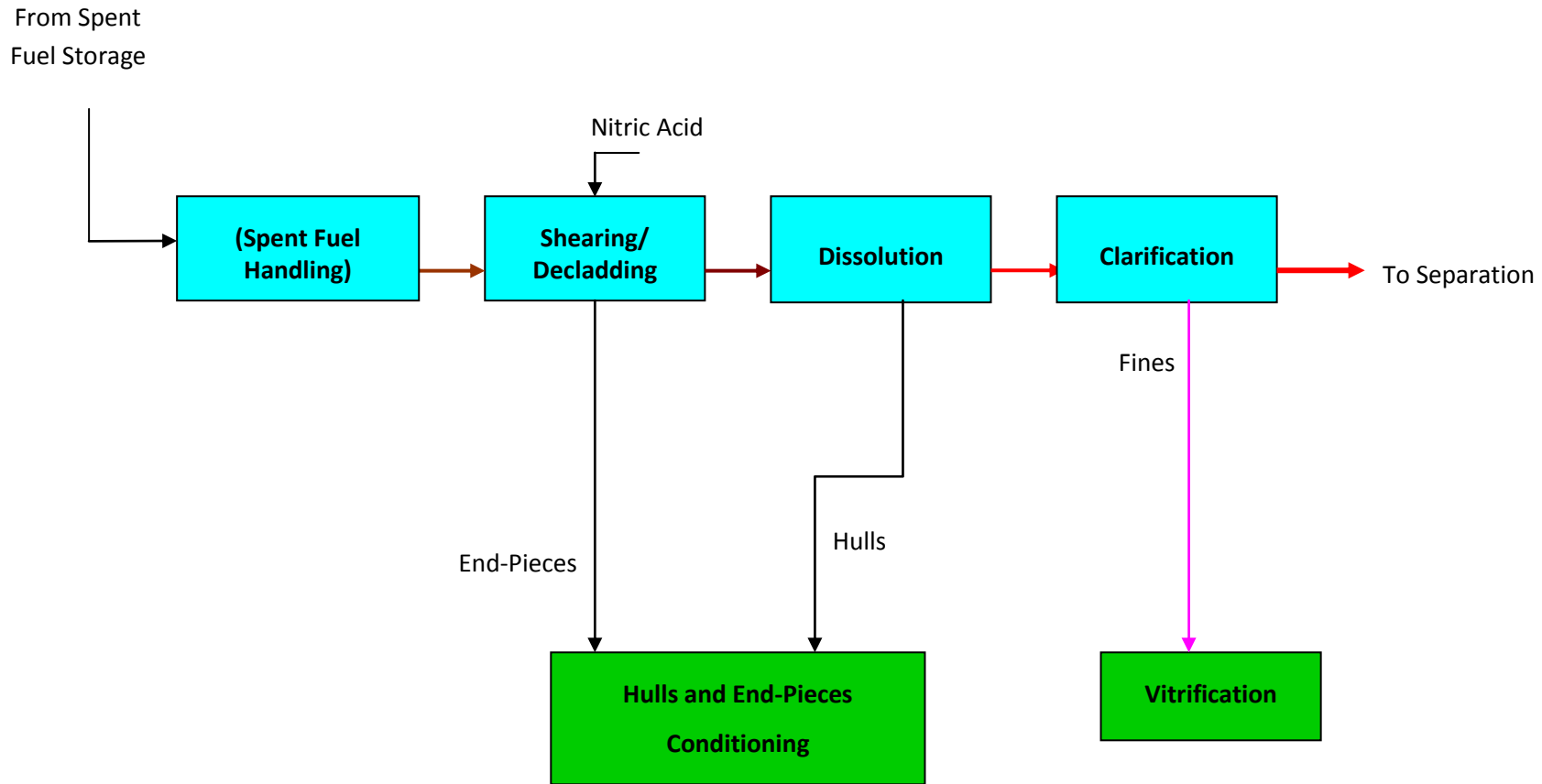
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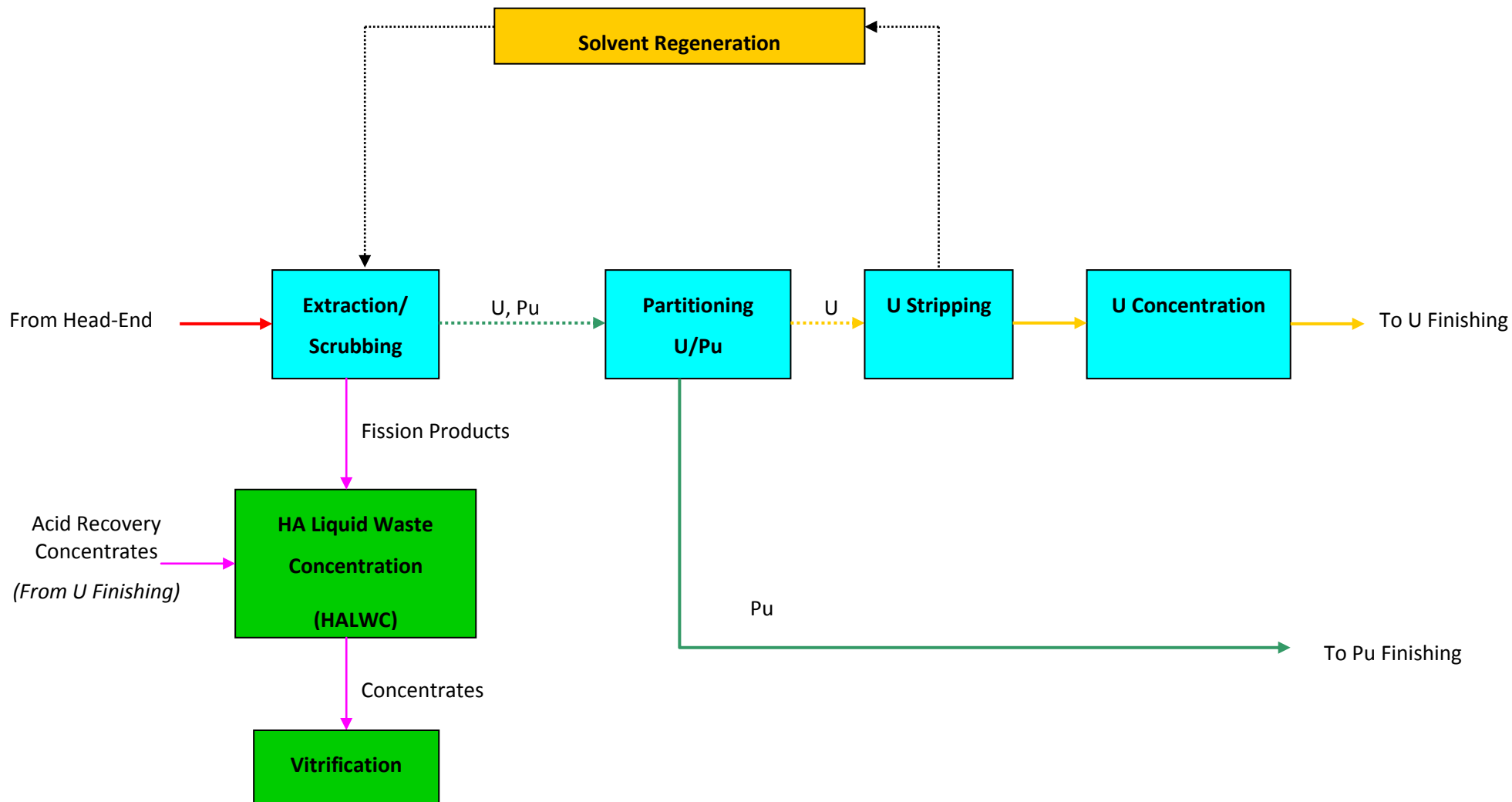
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ANNEX I: REPROCESSING FACILITIES MAIN PROCESS ROUTES

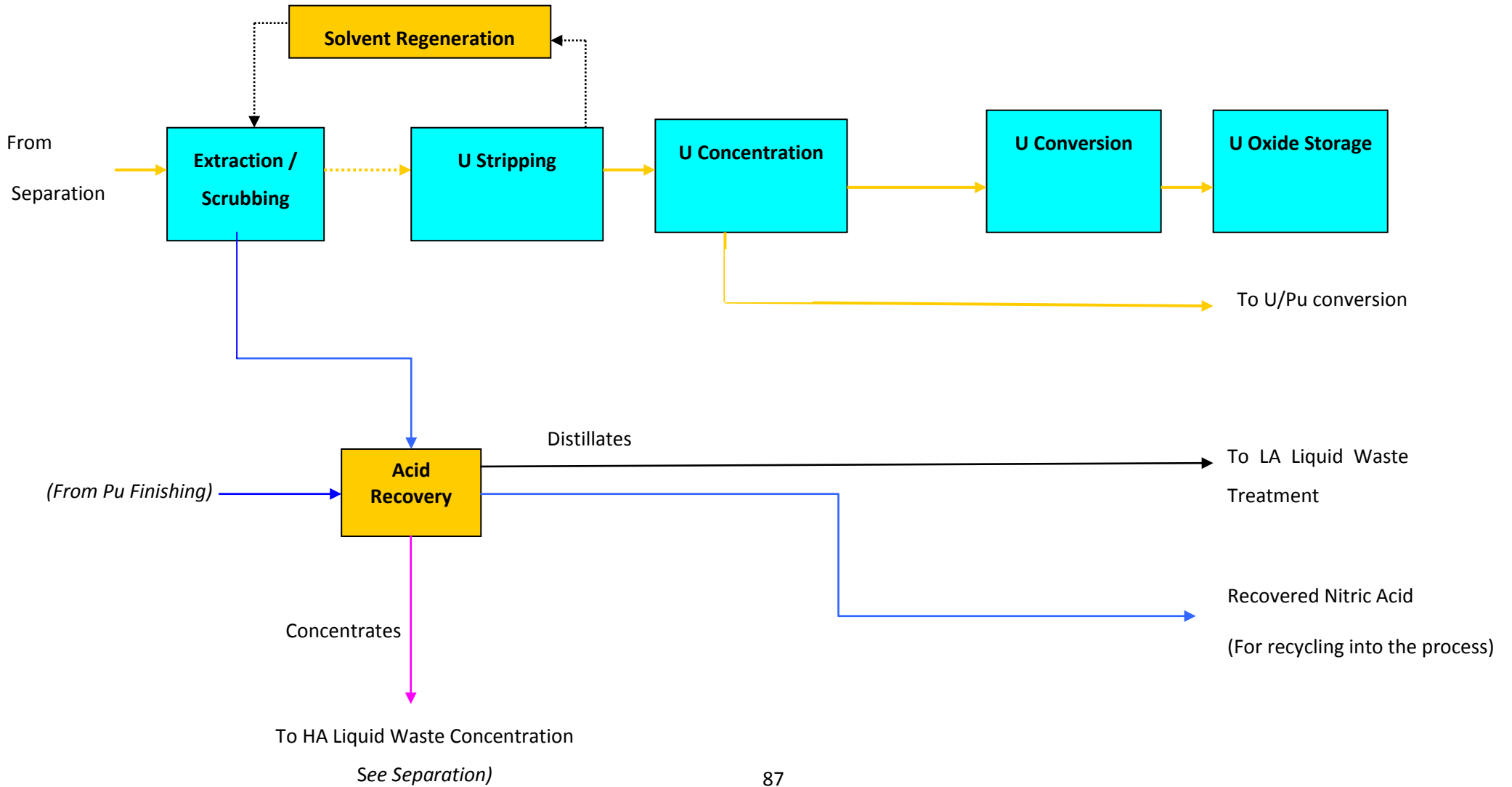
ANNEX I A REPROCESSING FACILITIES MAIN PROCESS ROUTES (HEAD-END)



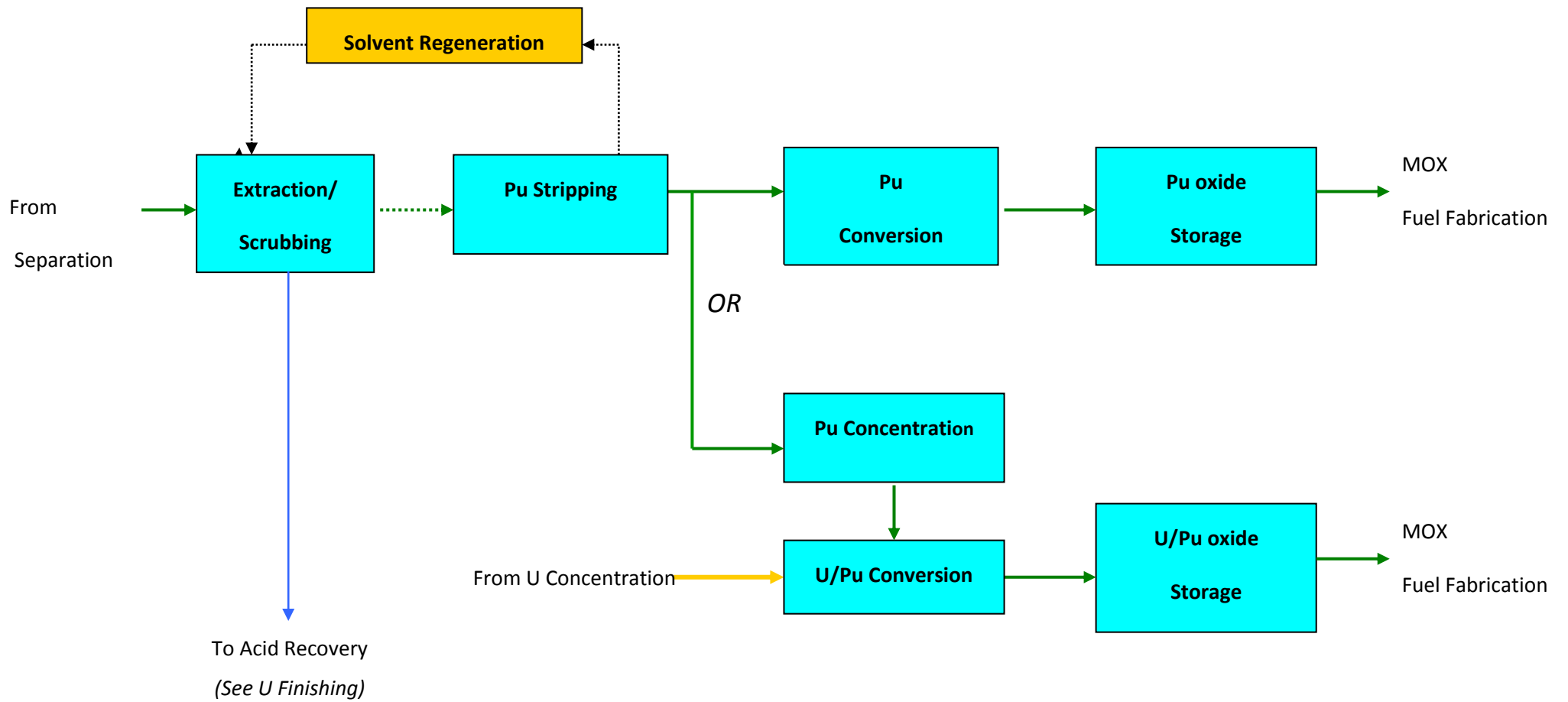
ANNEX I B
REPROCESSING FACILITIES
MAIN PROCESS ROUTES
(SEPARATION)



ANNEX I C
REPROCESSING FACILITIES
MAIN PROCESS ROUTES
(U FINISHING)



ANNEX I D
REPROCESSING FACILITIES
MAIN PROCESS ROUTES
(Pu FINISHING)



ANNEX II: SAFETY FUNCTIONS

MAIN STRUCTURES, SYSTEMS AND COMPONENTS IMPORTANT TO SAFETY, POSSIBLE CHALLENGES TO SAFETY FUNCTIONS AND EXAMPLES OF PARAMETERS FOR DEFINING OPERATIONAL LIMITS AND CONDITIONS FOR REPROCESSING FACILITIES

Basic Safety Functions (SF):

1. Confinement:
 - 1a. Barriers;
 - 1b. Cooling;
 - 1c. Prevention of radiolysis and other hazardous explosive or flammable materials
2. Protection against external exposure
3. Prevention of criticality

HEAD-END PROCESS (See ANNEX 1A)

| Process area | Main SSCs | Consequential events | First challenged SF* | OLC Parameters |
|---------------------|---------------------------------------|-------------------------------|----------------------|---|
| Feeding | Camera, detector | Safety concern in the process | Potential for all | Fuel Assembly identification (Feed programme) |
| | Spent Fuel Burn-up measurement system | Criticality event | 3 | Burn-up value |
| Shearing/Decladding | Shearing machine | Zr Fire | 1c | Cleanliness of the shearing machine |
| | | Criticality event | 3 | |
| Dissolution | See « Vessel » | | 1 | |

| Process area | Main SSCs | Consequential events | First challenged SF* | OLC Parameters |
|-----------------------------------|---|--|----------------------|--|
| | Measurement systems for Temperature, Density, Acidity of the solution | Criticality event | 3 | Temperature, Density, Acidity |
| | Control of the solution poisoning (if required) | Criticality event | 3 | Neutron poison concentration |
| Clarification | See « Vessel » | | 1 | |
| | Analytical measurement | Criticality event in the fines Storage vessel | 3 | H/Pu ratio |
| | Filter cleaning/Centrifuge cleaning systems | Potential release of activity | 1b | Cleaning system parameters |
| Hulls and end-pieces conditioning | Measurement of the fissile materials of contents in hulls | Acceptance by the hulls conditioning facility | 3 | Residual fissile material |
| « Vessel » | Vessels Containing Radioactive Solution | Leakage of Active Solution | 1a | Detection of Leakage (Level Measurement/Sampling in Drip Tray or Sumps, Contamination measurements in Cells and rooms) |
| | Cooling supply system (if any) | Overheating/ Boiling/ Crystallization/ Corrosion | 1b | Flow Rate of Cooling Water, Temperature of active solution |
| | Heating supply system (if any) | Overheating/ Boiling/ Crystallization/ Corrosion | 1a, 1b, 1c | Flow Rate of Heating Fluid, Temperature of active solution |
| | Supply system in air for dilution of radiolysis gases (if any) | Explosion (H2) | 1c | Flow Rate of diluting air for dilution |
| | Level measurement | Overflowing | 1a | Leakage (and safety issues in downstream process) |

| Process area | Main SSCs | Consequential events | First challenged SF* | OLC Parameters |
|--------------|--|----------------------|----------------------|----------------|
| | Pressure measurement (where necessary) | Vessel failure | 1a | Leakage |
| | Measurement of parameters related to criticality control (if needed) | Criticality event | 3 | Specific OLCs |

SEPARATION PROCESS (See ANNEX 1B)

| Process area | Main SSCs | Consequential events | First challenged SF* | OLC Parameters |
|----------------------|-----------------------------------|---|----------------------|---|
| Extraction/Scrubbing | See « Vessel » | | 1 | |
| | Temperature control | Fire (Organics) | 1a | Solution Temperature in mixer settlers or columns |
| | Organics content measurement | Defense in Depth (DiD) for downstream process | 1a | Diluent/ Solvent ratio |
| | Reagents feeding system | Leakage of Pu with FP | 3 | Reagents Flow rate |
| Partitioning U/Pu | Temperature control | Fire (Organics) | 1a | Solution Temperature in mixer settlers or columns |
| | Organics content measurement | Defense in Depth (DiD) for downstream process | 1a | Diluent/ Solvent ratio |
| | Reagents feeding system | Leakage of Pu with FP | 3 | Reagents Flow rate |
| | Neutron measurement at the column | Criticality event (Prevention) | 3 | Neutron measurement along the column |

| Process area | Main SSCs | Consequential events | First challenged SF* | OLC Parameters |
|---------------------------------|---|--|----------------------|--|
| | Critically event detection system | Criticality event (Mitigation) | 3 | Criticality accident alarm system (CAAS) |
| U Stripping/ U concentration | Temperature control | Explosion (Red Oil) | 1a | Temperature |
| | Process parameters control | Explosion (Red Oil) | 1a | Administrative controls |
| Solvent Regeneration | Temperature control | Explosion (Hydrazine) Fire (organics) | 1a | Temperature |
| | Analytical measurement | Explosion (Hydrazine) Fire (organics) | 1a | Administrative controls |
| HA Liquid Waste Concentration | See « Vessel » | | 1 | |
| | Temperature control | Explosion (Red Oil) | 1a | Temperature |
| | Parameter(s) related to the destruction of nitrates | Overpressure | 1a | Administrative controls |

U PRODUCT TREATMENT PROCESS (See ANNEX 1C)

| Process area | Main SSCs | Consequential events | First Challenged SF* | OLC Parameters |
|----------------------------|----------------------------|----------------------|----------------------|-------------------------|
| U Extraction/ Scrubbing | Temperature control | Fire (Organics) | 1a | Temperature |
| | Process parameters control | Fire (Organics) | 1a | Administrative controls |
| U Stripping | Temperature control | Fire (Organics) | 1a | Temperature |
| | Process parameters control | Fire (Organics) | 1a | Administrative controls |
| U concentration | Temperature control | Explosion (Red Oil) | 1a | Temperature |
| | Process parameters control | Explosion (Red Oil) | 1a | Administrative controls |
| U Concentration | See « Vessel » | | 1 | |

| | | | | |
|----------------------|----------------------------|---------------------|----|-------------------------|
| U Oxide storage | See « Vessel » | | 1 | |
| Solvent Regeneration | Temperature control | Fire (Organics) | 1a | Temperature |
| | Analytical measurement | Fire (Organics) | 1a | Administrative controls |
| Acid recovery | Temperature control | Explosion (Red Oil) | 1a | Temperature |
| | Process parameters control | Explosion (Red Oil) | 1a | Administrative controls |

Pu PRODUCT TREATMENT PROCESS (See ANNEX 1D)

| Process area | Main SSCs | Consequential events | First Challenged SF* | OLC Parameters |
|--|------------------------------|-------------------------------|-----------------------------|-----------------------------------|
| Pu Extraction/ Scrubbing/ Stripping | See « Vessel » | | 1, 3 | |
| | Temperature control | Fire (Organics) | 1a | Temperature |
| | Process parameters control | Fire (Organics) | 1a | Administrative controls |
| Pu concentration | Process parameters control | Criticality | 3 | |
| Pu Conversion | Process parameters controls | Criticality | 1c, 3 | Temperature |
| Pu Oxide Storage | Thermal criteria for storage | Potential release of activity | 1a | Temperature, Ventilation flowrate |
| | Storage rack | Criticality | 3 | “Size” (Design, Commissioning) |
| Solvent regeneration | Temperature control | Fire (Organics) | 1a | Temperature |
| | Analytical measurement | Fire (Organics) | 1a | Administrative controls |

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