



May 27, 2014
ACO 14-0023

ATTN: Document Control Desk
Ms. Christiana Lui, Director
Division of Security Policy
Office of Nuclear Security and Incident Response
U.S. Nuclear Regulatory Commission
Washington, D.C. 20555-0001

**American Centrifuge Lead Cascade Facility
Docket Number 70-7003; License Number SNM-7003
Submittal of Changed Pages of the Emergency Plan for the American Centrifuge Lead
Cascade Facility**

Dear Ms. Lui:

Purpose

In accordance with 10 *Code of Federal Regulations* (CFR) 70.32(i), American Centrifuge Operating, LLC hereby submits to the U.S. Nuclear Regulatory Commission (NRC) changed pages of the Emergency Plan for the American Centrifuge Lead Cascade Facility as Enclosure 1 of this letter.

Discussion

The changes noted in Enclosure 1 have been reviewed in accordance with 10 CFR 70.32 and have been determined not to decrease the effectiveness of the applicable plan. Revision bars in the right hand margin depict changes from the previous revision submitted to the NRC.

Action

No specific action is requested concerning this submittal.

Ms. Christiana Lui
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Contact

If you have any questions regarding this matter, please contact me at (740) 897-2343.

Sincerely,



Vernon J. Shanks
Regulatory Manager

Enclosure: As Stated

cc: J. Downs, NRC HQ
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Enclosure 1 to ACO 14-0023

Changed Pages of the Emergency Plan for the American Centrifuge Lead Cascade Facility

**Information contained within
does not contain
Export Controlled Information**

**Reviewer: R.S. Lykowski
Date: 1-17-14**

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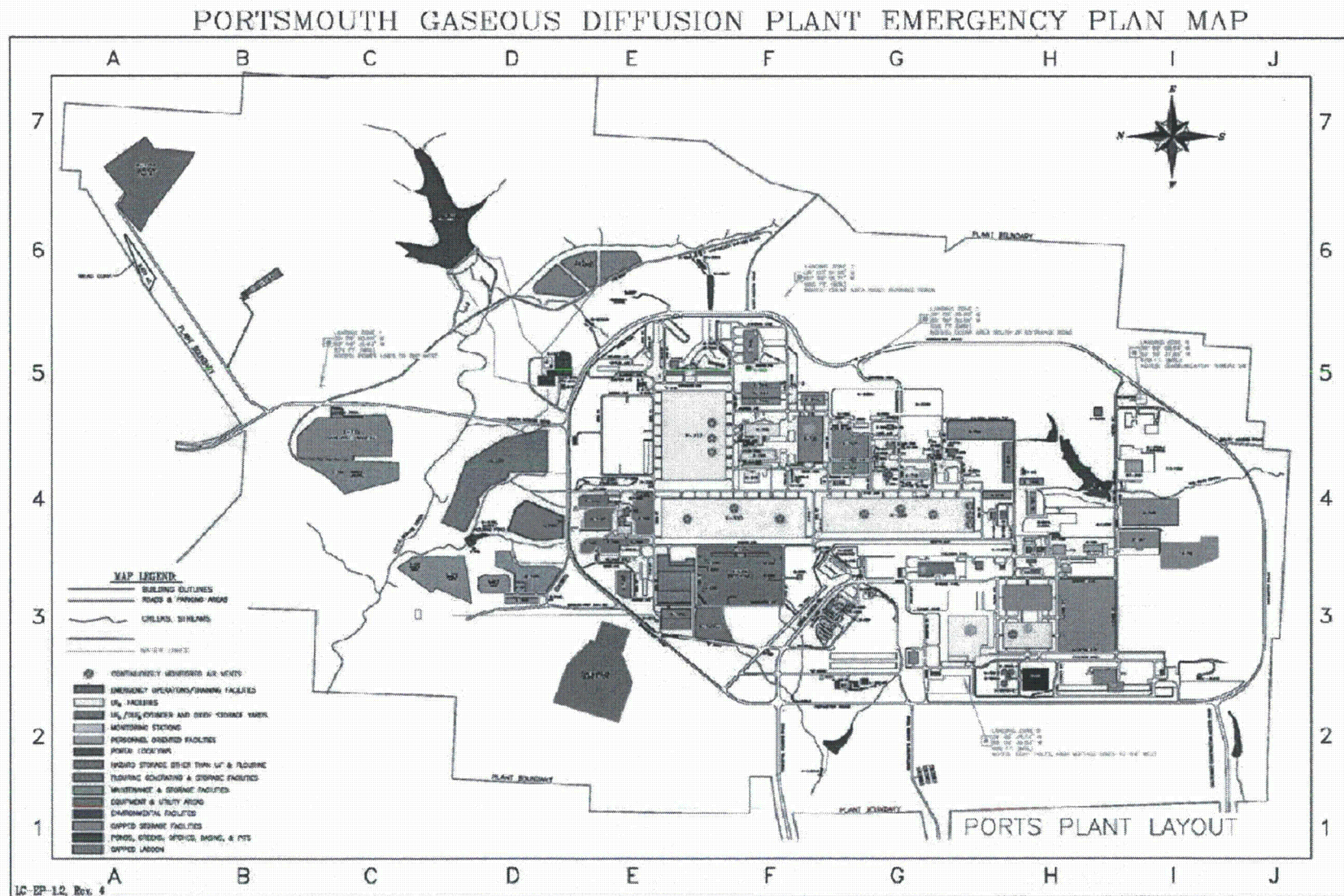


Figure 1-2 PORTS Plant Layout

PORTSMOUTH GASEOUS DIFFUSION PLANT EMERGENCY PLAN MAP INDEX

| FACILITY # | FACILITY NAME | GRID LOCATION | FACILITY # | FACILITY NAME | GRID LOCATION | FACILITY # | FACILITY NAME | GRID LOCATION |
|------------|--|---------------|------------|--|---------------|------------|---|---------------|
| X-104 | GUARD HEADQUARTERS | G5 | X-612 | ELEVATED WATER TANK | E3 | X-745G-1 | CYLINDER STORAGE YARD | E3 |
| X-104A | INDOOR PIPING RANGE | G5 | X-614A | SEWAGE PUMPING STA | F4 | X-745H | CYLINDER STORAGE YARD | D4 |
| XI-104B | PROTECTIVE FORCES OPERATIONS | G4 | X-614B | SEWAGE LIFT STA | E4 | X-747 | SCRAP STORAGE YARD | D3 |
| XI-104C | PROTECTIVE FORCES SHOWER/LOCKER | G4 | X-614D | S SEWAGE LIFT STA | H | X-747A | MATERIAL STORAGE YARD | G4 |
| X-106 | NEW FIRE TRAINING BLDG | G3 | X-614F | NE SEWAGE LIFT STA | E5 | X-747B | MATERIAL STORAGE YARD | G4 |
| X-108A | S PORTAL & SHELTER | G5 | X-614Q | SEWAGE BOOGER PUMP STATION | G4 | X-747C | MATERIAL STORAGE YARD | L5 |
| X-108B | N PORTAL & SHELTER | G5 | X-617 | S HOLDING POND & P1 CONTROL FAC | H | X-747D | MATERIAL STORAGE YARD | L5 |
| X-108E | CONSTRUCTION PORTAL | F4 | X-618 | N HOLDING POND STORAGE BLDG | D4 | X-747E | MATERIAL STORAGE YARD | F5 |
| X-108H | PIKE AVE PORTAL | E4 | X-621 | COAL PILE RUNOFF TREATMENT FAC | H1 | X-747F | MISCELLANEOUS MATERIAL STORAGE YARD | D3 |
| X-108M | SECURITY PORTAL | E3 | X-622 | S GROUNDWATER TREATMENT BLDG | H4 | X-747H | NW CONTAMINATED SCRAP YARD | D3 |
| X-108N | SECURITY PORTAL | E4 | X-623 | N GROUNDWATER TREATMENT BLDG | L5 | X-748 | TRUCK SCALE FAC | C5 |
| X-108P | SECURITY PORTAL | H3 | X-624 | LITTLE BEAVER GROUNDWATER TREATMENT FAC | E6 | X-749 | S CONTAMINATED MATERIAL STORAGE YARD (CAPPED) | H |
| X-109B | PERSONNEL MONITORING STA | F5 | X-624-1 | LITTLE BEAVER GROUNDWATER TREATMENT BLDG | E6 | X-749A | S CLASSIFIED BURIAL YARD (CAPPED) | H5 |
| X-109E | PERSONNEL MONITORING STA | G4 | X-625 | PILOT SCALE TREATMENT FAC | L1 | X-749B | PETER KIEWIT LANDFILL (CAPPED) | H4 |
| X-111A | SNM MONITORING PORTAL (X-328) | D4 | X-626-1 | RECIRCULATING WATER PUMP HOUSE | H4 | X-750 | MOBILE EQUIP MAINTENANCE GARAGE | G4 |
| X-111B | SNM MONITORING PORTAL (NW X-328) | D4 | X-626-2 | COOLING TOWER | H4 | X-750A | GARAGE STORAGE BLDG | C4 |
| X-112 | DATA PROCESSING BLDG | H4 | X-627 | GROUNDWATER TREATMENT FACILITY | F4 | X-751 | SCIP MOBILE EQUIP GARAGE | F3 |
| X-114A | OUTDOOR FIRING RANGE | D8 | X-640-1 | FIRE WATER PUMP HOUSE | F5 | X-752 | WAREHOUSE/WELD SHOP | C3 |
| X-120A | NEW WEATHER STA | I4 | X-640-2 | ELEVATED WATER TANK | E2 | X-1000 | ADMINISTRATION BLDG | H4 |
| X-206A | N MAIN PARKING LOT | G5 | X-640-1A | FIRE WATER PUMP HOUSE SUBSTATION | F4 | X-1007 | PIPE STA | H4 |
| X-206P | S MAIN PARKING LOT | G5 | X-640-2A | ELEVATED WATER TANK AUX. BLDG. | F4 | X-1010 | EMERGENCY OPERATIONS CENTER (LUN) | H4 |
| X-206L | CONSTRUCTION PARKING LOT | E4 | X-670 | COOLING TOWER | G4 | X-1015 | DIAPHRAGM CONVERSION BUILDING | L5 |
| X-209P | PIKE AVE PARKING LOT | I4 | X-675 | PLANT NITROGEN STATION | G3 | X-1015B | HYDROLYN FLUORIDE STORAGE TANK AREA | F3 |
| X-209N | S OFFICE PARKING LOT | E4 | X-680 | BIOLOGICAL SAMPLE & TREATMENT BLDG. | G4 | X-1320 | POTASSIUM HYDROXIDE REGENERATION BUILDING | F3 |
| X-230A-2 | S HOLDING POND EFFLUENT MONITORING STA | F2 | X-690 | STEAM PLANT | G4 | X-1745A | FULL CYLINDER STORAGE AREA | F3 |
| X-230A-3 | W EFFLUENT MONITORING STA | F2 | X-700 | CONDENSER SHOP & CLEANING BLDG | G4 | X-1745C | OXIDE CYLINDER STORAGE AREA | F3 |
| X-230A-5 | W HOLDING POND & ENVP SAMPLING BLDG | F2 | X-700A | AIR CONDITIONING EQUIP BLDG | F5 | X-6613 | SANITARY WATER STORAGE TANK | F3 |
| X-230A-6 | NE HOLDING POND & MONITORING STA | E6 | X-701B | HOLDING POND (DRAIN) | F5 | X-6614C | SEWAGE LIFT STA | C2 |
| X-230A-7 | E HOLDING POND & MONITORING STA | E6 | X-701E | NEUTRALIZATION JUEG | F5 | X-6614H | SEWAGE LIFT STA | H3 |
| X-230B | S HOLDING POND | H4 | X-705 | DECONTAMINATION BLDG | F4 | X-6614J | SEWAGE LIFT STA | H3 |
| X-230C | N HOLDING POND | D4 | X-705P | HEATING BOILER PUMP BLDG | F4 | X-6619 | SEWAGE TREATMENT PLANT | G2 |
| X-230M | CLEAN SITE NE OF XI-801 | H5 | X-705E | OXIDE CONVERSION AREA | E4 | X-6613-1 | FIRE WATER STORAGE TANK #1 | H2 |
| X-231A | SE OIL BIODEGRADATION PLOT | H4 | X-710 | TECHNICAL SERVICES BLDG | G4 | X-6613-2 | FIRE WATER STORAGE TANK #2 | H2 |
| X-231B | SW OIL BIODEGRADATION PLOT | H4 | X-710A | TECHNICAL SERVICES GAS MANHOLE | G4 | X-6614 | FIRE WATER PUMP HOUSE | F3 |
| X-350 | PLANT CONTROL FAC | G4 | X-710E | EXPLOSION TEST FAC | G4 | X-7721 | MAINTENANCE, STORES & TRAINING BLDG | C5 |
| X-350B | PROCESS MONITORING BLDG | G4 | X-720 | MAINTENANCE & STORES BLDG | F4 | XI-847 | WAREHOUSE | H |
| X-350C | PLANT CONTROL FAC CASPORT | G4 | X-720E | RADIO BASE STA BLDG | F4 | | | |
| X-426 | PROCESS BLDG | G4 | X-730C | WATER & OIL STORAGE BLDG | F4 | | | |
| X-426A | L-CASE, L-CASE GUYE BOX & STORAGE AREA | G4 | X-731 | RADIATION INSTRUMENT CALIBRATION FAC | F4 | | | |
| X-530 | PROCESS BLDG | E5 | X-734 | OLD SANITARY LANDFILL | D4 | | | |
| X-533 | PROCESS BLDG | E5 | X-734A | CONSTRUCTION SPOILS DISPOSAL AREA | C3 | | | |
| X-534 | TRANSFORMER CLEANING BLDG | E4 | X-734B | CONSTRUCTION SPOILS DISPOSAL AREA | C3 | | | |
| X-542A | FEED, VAPORIZATION & FLUORINE CONCENTRATION BLDG | E4 | X-735 | SANITARY LANDFILL | C5 | | | |
| X-349B | FLUORINE STORAGE BLDG | E4 | X-735A | LANDFILL UTILITY BLDG | C5 | | | |
| X-343 | FIELD VAPORIZATION & SAMPLING BLDG. | E5 | X-735B | GENERATOR AREA | G4 | | | |
| X-343A | SECURITY PORTAL | G4 | X-735C | W CONSTRUCTION SPOILS LANDFILL | F5 | | | |
| X-344B | W/ SAMPLING FAC | E4 | X-741 | OIL DRUM STORAGE FAC | C4 | | | |
| X-344D | MAINTENANCE STORAGE BLDG | E4 | X-742 | CGI CYLINDER STORAGE FAC | G5 | | | |
| X-345 | SNM STORAGE BLDG | F4 | X-743 | LUMBER STORAGE SHED | G4 | | | |
| X-501 | SUBSTATION | G4 | X-744E | SALT STORAGE SHED | D3 | | | |
| X-501A | SUBSTATION | G4 | X-744G | BULK STORAGE BLDG | F5 | | | |
| X-502 | SUBSTATION | G4 | X-744J | BULK STORAGE BLDG | F5 | | | |
| X-503 | SWITCH YARD | F3 | X-744K | WAREHOUSE | H4 | | | |
| X-503B | SWITCH HOUSE | F3 | X-744L | STORES & MAINTENANCE BLDG | F5 | | | |
| X-503C | TEST & REPAIR BLDG | F4 | X-744M | WAREHOUSE N NON UEA | G2 | | | |
| X-503D | OIL HOUSE | F3 | X-744F | WAREHOUSE F NON UEA | G2 | | | |
| X-503E | VALVE HOUSE | F3 | X-744G | WAREHOUSE G NON UEA | G2 | | | |
| X-503F | VALVE HOUSE | F3 | X-744H | SURPLUS & SALVAGE BLDG | C3 | | | |
| X-503G | CEEP OIL PUMPING STA | F3 | X-744I | WASTE STORAGE YARD | D3 | | | |
| X-503H | ELECTRICAL MAINTENANCE STORAGE BLDG | G5 | X-745 | TOLL ENRICHMENT PROCESS GAS YARD | E4 | | | |
| X-540 | TELEPHONE BLDG | C4 | X-745C | N DUM STORAGE YARD | E3 | | | |
| X-611 | WATER TREATMENT PLANT | D5 | X-745E | CYLINDER STORAGE YARD | E3 | | | |
| X-611A | DRUMS | E6 | X-745F | NW OUF STORAGE YARD | E3 | | | |
| X-611B | SLUDGE LAGOON | D5 | X-745F | N PROCESS GAS STOCKP. YARD | E4 | | | |
| X-611C | LIFER BLDG | D5 | X-745G | CYLINDER STORAGE YARD | D4 | | | |
| X-611D | RECARBONIZATION INSTRUMENT BLDG | D5 | | | | | | |
| X-611E | COLUMBELL & CHLORINE BLDG | D5 | | | | | | |

ABBREVIATION LEGEND

| | |
|-----------------------------|-----------------------------------|
| ADC = AREA OF CONTAMINATION | EQUIP = EQUIPMENT |
| AUX = AUXILIARY | FAC = FACILITY |
| AVE = AVENUE | N = NORTH |
| BLDG = BUILDING | S = SOUTH |
| E = EAST | STA = STATION |
| ENVMT = ENVIRONMENTAL | SNM = SOLID WASTE MANAGEMENT UNIT |
| W = WEST | |

MONITORING STATIONS

| NO. | LOCATION | PHONE |
|-----|--|-------|
| 1. | X-670 DRY AIR PLANT | 2556 |
| 2. | X-109E MINI WHEEL SWATHWEST CORNER OF MAHONING AVE AND 1ST | 5656 |
| 3. | X-109S FRAM. BUILDING EAST OF X-108 | 2556 |
| 4. | X-533H TRAILER - WEST SIDE OF X-640-1 | 4183 |
| 5. | NOT USED | |
| 6. | X-109E PEDESTRIAN PORTAL | +122 |
| 7. | X-1007 PIPE STATION | 5611 |

PASS/REN LOCATIONS

| NO. | LOCATION |
|-----|----------------------|
| 1. | NORTH SIDE OF X-745A |
| 2. | NORTH SIDE OF X-745F |
| 3. | NORTH EAST OF X-6619 |

PORTS PLANT LAYOUT INDEX

Figure 1-2a PORTS Plant Layout Index

4. RESPONSIBILITIES

USEC Inc. is responsible for the control of the Plan. FBP provides emergency management and response services. USEC Inc., FBP and other DOE contractors and subcontractors will each meet the requirements of the Plan.

4.1 NORMAL FACILITY ORGANIZATION

FBP is responsible for the safe operation of the FUEF and is responsible for the day-to-day management and operation of the FUEF, including the program of emergency management and response services. An FBP organizational chart showing the functional levels and reporting responsibilities is provided in the BIO Chapter 17. The administrative and technical support personnel staffing the plant organization are normally onsite daily, Monday through Thursday or Friday, holidays excluded. Plant operational personnel are on duty 24 hours per day. Descriptions of the key managers at the plant and their responsibilities are provided below.

Other senior managers are responsible for the Lead Cascade and the DUF₆ Conversion Facility. Senior managers from these site entities may be designated and qualified as CMs. The CM is authorized to declare an emergency, initiate the appropriate response, and assign a RM when emergency conditions no longer exist. The duties and responsibilities of the RM are addressed in Section 9 of this Plan.

4.1.1 FBP Organization

4.1.1.1 Site Project Director

The Site Project Director has direct responsibility for operation of the FUEF in a safe, reliable, and efficient manner.

The Site Project Director also oversees FUEF industrial safety, nuclear safety, and nuclear criticality safety functions which provide support to the Emergency Plan and emergency plan management function. These areas are managed by directors who report to the Site Project Director.

4.1.1.2 Project Support and Oversight Directors

Project Support and Oversight Directors are responsible for technical functions in direct support of plant activities. These positions oversee engineering; environmental; waste management; records management document control; procedures and training; radiation protection and health physics and industrial hygiene technician functions; fire services; emergency management; emergency medical services; and work control and maintenance of the work control database. These services are managed by functional area managers who report through this Director.

4.1.1.3 Project Execution Directors

Project Execution Directors are responsible for the day-to-day operations of shift operations; power, utilities, chemical services; and related infrastructure support systems. These responsibilities are managed by managers who report through these Directors.

The ERO has the following specific functions and responsibilities, depending on the incident and level of response needed to mitigate the problem: event categorization, determination of emergency class, notification, protective action recommendations, management and decision making, control of onsite emergency activities, consequence assessment, medical support, emergency public information, activation and coordination of onsite response resources, security, communications, administrative support, and coordination and liaison with offsite support and response organizations.

The ERO is divided into functional groups as follows:

1. Field ERO,
2. EOC cadre, and
3. Joint Public Information Center (JPIC).

Members of these groups are assigned to on-scene response locations and emergency response centers such as the EOC. Emergency assignments correspond as closely as possible to daily duties. Primary and alternate personnel are assigned to the ERO positions. Assignments are updated periodically. Management ERO positions in each group provide oversight and final authority in the group's decision-making process.

4.2.1 Direction and Coordination

The initial ERO consists of the appropriate shift personnel with the PSS or designee as IC. Upon classification of the emergency as an Alert or SAE, the PSS becomes the CM and maintains overall control of the plant during the emergency until relieved. Once the EOC is operational, the CM relieves the PSS as CM and the overall control of the emergency shifts from the PSS to the CM.

The PSS conducts transition and turnover of command and control authority and responsibility of the CM function in a formal manner by use of specially developed procedural checklists and, if possible, face-to-face briefings. A primary and alternates are identified for the CM.

The order of succession for the CM position is identified in an EPIP and includes the following:

1. PSS and
2. CM (CMs are designated by the Site Project Director and trained and qualified as CM.)

Because of the importance of some emergency responsibilities, these responsibilities may be performed only by the ERO position assigned to address them. The following responsibilities are transferred when the overall responsibility for emergency response is transferred.

1. Emergency Classification — Initially this is a PSS responsibility as CM. Once the EOC is operational, this responsibility is transferred from the PSS to the CM in the EOC.
2. Protective Action Recommendations — Initially this is a PSS responsibility as CM. Once the EOC is operational, approval of offsite protective action recommendations is transferred to the CM in the EOC.
3. Facility Activation — The PSS or designee is responsible for directing activation of the EOC. The EOC is automatically activated for Alerts and SAEs and may be selectively activated for other emergencies related to non-Plan described activities.