DUN-M-22

OFFSITE SHIPMENT OF RADIOACTIVE MATERIALS

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Radiation Practices Engineering
Manufacturing Engineering
Section

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INTRODUCTION

Offsite shipment is defined as the movement of material from DUN facilities to any receiver other than the Hanford contractors listed below:

- Douglas United Nuclear, Inc.
- Atlantic Richfield Hanford Company
- Battelle Northwest
- ITT/Federal Support Services
- J. A. Jones Company
- Hanford Environmental Health Foundation

The following procedures insure that material prepared by DUN for offsite shipment will comply with all applicable Department of Transportation and AEC Regulations. However, before making international shipments, contact Radiation Practices Engineering on 2-5360. This manual consists of:

1. The "Procedure for Offsite Shipment of Radioactive Materials", which describes proper packaging, labeling and administrative techniques. An appendix of containers normally used by DUN for offsite shipments is included.
2. The procedures needed for proper completion of the "Radioactive Shipment Authorization (RSA) Form" for offsite shipments.

It is the responsibility of the individual who prepares or directs the preparation of a package for offsite shipment to:

1. Insure that offsite shipments of radioactive material prepared be DUN are in compliance with all applicable DOT and AEC regulations by following the procedures in this manual.
2. Call Radiation Practices Engineering (RPE) for procedural or compliance interpretations.

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1.0 SHIPPER

The individual who prepares or directs the preparation of a package for offsite shipment by AEC-RL.

1.1 If the material to be shipped is fissile material (i.e., contains U-233, U-235, Pu-238 or Pu-241), contact the Process Standards Unit on 2-4395. They will specify the container to be used and the transport index of the loaded container.

1.2 Use Appendix B to determine the transport group for the shipment and the quantity category for each container. If a container falls into one of the following three categories, or if the contents are classified, contact RPE on 2-5360.

Categories

- "Large quantity," i.e., exceeds the "Type B" quantity limits
- Small quantity
- Low specific activity quantity

1.3 After determining which quantity category the container falls into (as specified in Appendix B), and if the material being shipped is non-fissile, select a proper container from Appendix A. Insure that all conditions listed for use of the container (such as allowable heat generation rate) are complied with. If a container which is not listed is to be used, contact RPE on 2-5360 before it is used. If the material being shipped is fissile material, contact the Process Standards Unit (see 1.1 above).

NOTE: Type B quantity shipments must be shipped in Type B packages only.

1.4 Advise Nuclear Materials Management on 3211 of the impending shipment.

1.5 Internal bracing or cushioning, where necessary, must be adequate to insure that the distance from the inner container or material to the outside wall of the package remains constant and that the transport index remains constant under conditions normally incident to transportation. If the shipment consists of or contains radioactive liquids, powder or gas, contact RPE on 2-5360 for packaging instructions.

1.6 Have radiation monitoring survey the loaded container. RM will advise the shipper and RPE of any violation of AEC or DOT regulations pertaining to radiation dose rate or radioactive contamination levels.

1.7 Determine the "transport index" for the loaded container. This will be the highest dose rate at three feet from any accessable external surface of the container. However, the dose rate must not exceed 10 mrem/hr. The transport index has no units. (Ex.: If the highest dose rate at 3 feet is 8 mrem/hr., the transport index will be 8).

NOTE: The transport index for all fissile material shipments will be determined by the Process Standards Unit. (See 1.1).

1.8 The transport index for the total shipment (determined by summing the transport index for each package in the shipment) shall not exceed 50 per transport carrier, unless specifically authorized by RPE.

1.9 Select and fill in completely the proper "Radioactive" label for each container, using Appendix C and the information from parts 1.6 and 1.7 above. Each container must be posted with <u>two</u> "Radioactive" labels (placed on <u>opposite</u> sides or faces of the container where they are plainly visible). "Radioactive" labels are available from RPE.

1.10 If the container is to be shipped as an "empty" container, Radiation Monitoring must determine if it meets applicable radiation limits. If the container is released by RM as an

internally contaminated empty, it must be securely closed and a standard "Empty" label available from RPE, must be attached completely covering the old "Radioactive" label. If the interior of the container is found to be uncontaminated, the old "Radioactive" label must be removed. An "Empty" label is not required.

1.11 Request a completed Address label (Form No. RL-451) from Nuclear Materials Management.

NOTE: Address labels are not required on containers shipped in exclusive use, sealed transport vehicles.

1.12 Complete and distribute a Radioactive Shipment Authorization (RSA: Form No. BC-5000-291) in accordance with Procedure II of this manual. Nuclear Materials Management (on 3211) will transmit the Government Bill of Lading (GBL) number, when applicable, to the shipper. This number must be recorded on the RSA and on the container shipping label.

NOTE: If radioactive materials are being shipped in exclusive use, sealed transport vehicles, it is not necessary to mark the GBL number on the containers or on the vehicle.

1.13 Prepare a "Shipping and Receiving Report" (Form No. BD-5000-264) on the day of shipment and distribute copies promptly. Contact Nuclear Materials Management on 3211 for assistance in obtaining and preparing this form.

1.14 Containers must be blocked and braced so that they cannot change positions in the conveyance when submitted to normal conditions of transit.

1.15 Placard the rail or motor freight carrier vehicle placing the proper "Dangerous-Radioactive Materials" placard (different placards are used for motor and rail freight - RPE will supply the proper type) on each of the two sides and the front and rear of the vehicle when:

- A "Radioactive Yellow III" label is used on the container being shipped, or when
- A carload lot of radioactive material is being shipped.

2.0 NUCLEAR MATERIALS MANAGEMENT

2.1 Obtain the GBL number and transmit this number to the shipper. If the shipment will not be made on a Government Bill of Lading, so advise the shipper.

2.2 Prepare an Address label (Form number RL-451) and send it to the shipper.

2.3 Promptly forward copies of the Radioactive Shipment Authorization (RSA) as follows:

2.3.1 The Yellow copy to the receiver

2.3.2 The Goldenrod copy to AEC-RL Traffic Management

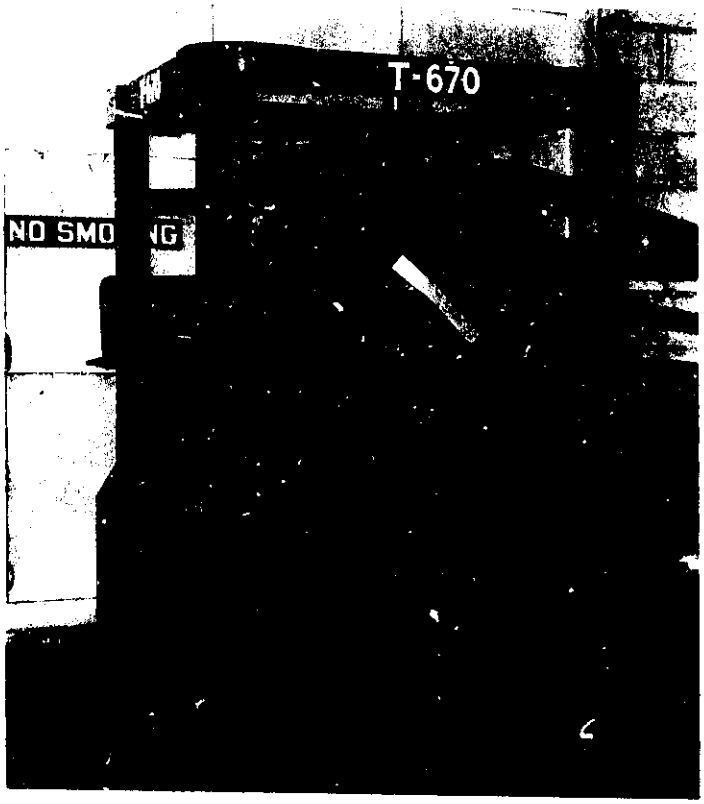
2.4 Comply with all other applicable provisions of DUN-M-4 (Rev 1) "Nuclear Materials Management Procedures Manual".

3.0 RADIATION MONITORING

3.1 Determine the radiation levels and insure that they are within the limits presented in DUN-M-3, 3.2. If they are not within the limits, advise both the shipper and RPE.

3.2 Complete the appropriate sections of the "Radioactive Shipment Authorization" (RSA).

5 TON HOPPER



Type of Package: Exempt - low specific activity fissile material

Shielding: None

Permit: Exempt - low specific activity fissile material

Mode of Transport Authorized: Railcar (closed)

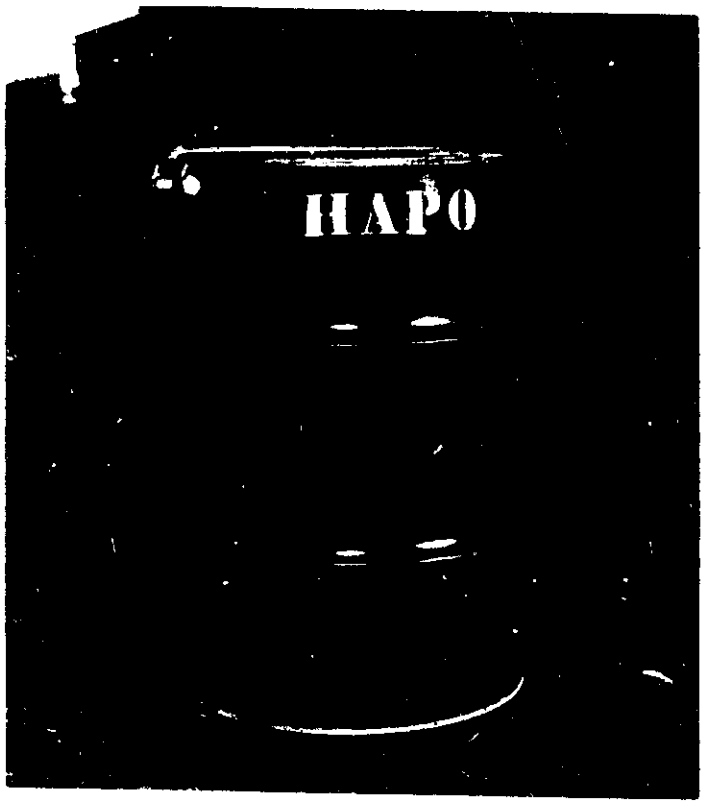
Special Conditions of Transport: Placard the railcar

Note: The 5 ton hopper is filled with UO_3 by Atlantic Richfield Hanford Company. DUN loads the hoppers onto the closed railcars (boxcars) for offsite shipment. This is the only authorized use of the 5 ton hoppers.

NLO WOODEN BOX

Type of Package: Type B - Fissile Material only
Dimensions: Several types are available
Capacity: Determined by Process Standards Unit
Shielding: None
Heat Generation Rate Limit: 0
Permit: DOT Special Permit 5467
Contents Authorized: Determined by Process Standards Unit
Mode of Transport Authorized: Railcar (closed)
Assigned to: National Lead Company of Ohio

MODEL 6B DRUM



Type of Package: Type A
Shielding: None
Capacity: 30 gallons
Permit: DOT 6B Drum Specification Container
Heat Generation Rate Limit: 0
Mode of Transport Authorized: None specified
Special Conditions of Transport: None specified
Maximum Authorized Gross Weight: 480 pounds

APPENDIX A - SHIPPING CONTAINERS

MODEL 44 DRUM

Type of Package: Type B - Fissile Material only

Dimensions: Interior--Cavity - 16" ID x 28" long
Exterior--25 3/4" OD x 34" long

Weight: Varies with loading

Capacity: Determined by Process Standards Unit

Shielding: None

Heat Generation Rate Limit: 0

Permit: DOT Special Permit 5739

Contents Authorized: Determined by Process Standards Unit

Mode of Transport Authorized: Railcar or motor freight

Owner: RL

Home Location: Assigned to DUN, Fuels Section

1.0 Find the Transport Group of the radionuclide being shipped by using Table I of this Appendix. If the radionuclide is not listed in Table I, refer to Section 2.0. When the material being shipped consists of more than one radionuclide, use Section 3.0 of this Appendix to determine the Transport Group.

After the Transport Group has been established, determine which quantity category the proposed shipment falls into by using Table II of this Appendix.

2.0 The Transport Group of any radionuclide not listed in Table I shall be determined by using the following table:

Radionuclide	Radioactive Half Life		
	0-1,000 Days	1,000 days to 10^6 years	Over 10^6 years
Atomic No. 1-81	Group III	Group II	Group III
Atomic No. 82 and over	Group I	Group I	Group III

3.0 Mixtures of Radionuclides

3.1 If the identity and respective activity of each radionuclide in a mixture are known, use the following:

Divide the activity of each radionuclide by the activity allowed in its respective transport group (see Table II). Then add the results obtained for all radionuclides present. The sum must be less than 1.

3.2 If the transport groups of the radionuclides are known but the amount in each group cannot be reasonably determined, the mixture shall be assigned to the most restrictive transport group present in the mixture.

3.3 If the identity of all or some of the radionuclides cannot be reasonably determined, each of those unidentified radionuclides

shall be considered as belonging to the most restrictive transport group which cannot be positively excluded.

3.4 Mixtures consisting of a single radioactive decay chain where the radionuclides are in the naturally occurring proportions shall be considered as consisting of a single radionuclide. The transport group and activity shall be that of the first member present in the decay chain, except that if a radionuclide in the decay chain has a half life longer than that of the first member and an activity greater than that of any other member at any time during transportation, the transport group of the nuclide and the activity of the mixture shall be the maximum activity of that nuclide during transportation.

4.0 Special Form Material

To qualify as Special Form Material, the radioactive material must either be in massive solid form or encapsulated and must meet the criteria outlined in 173.398 of the Code of Federal Regulation (CFR) Title 49. Contact RPE on 2-5360 for assistance in determining if the material meets special form criteria.

5.0 Type A and Type B Quantities

Type A quantity shipments may be packaged in either a Type A or Type B container; however the Type A container should be used whenever possible. Type B quantity shipments must be packaged only in Type B containers. The package type is specified for each container listed in Appendix A.

APPENDIX B

TABLE I

Procedure I

Element [1]	Radionuclide [2]	Transport group I	II	III	IV	V	VI	VII
Actinium (89)	Ac-227	X						
	Ac-228	X						
Americium (95)	Am-241	X						
	Am-243	X						
Antimony (51)	Sb-122				X			
	Sb-124			X				
	Sb-125			X				
Argon (18)	Ar-37						X	
	Ar-41			X				
	Ar-41 (uncompressed) [3]					X		
Arsenic (33)	As-73				X			
	As-74				X			
	As-76				X			
	As-77				X			
Astatine (85)	At-211			X				
Barium (56)	Ba-131				X			
	Ba-133			X				
	Ba-140			X				
Berkelium (97)	Bk-249	X						
Beryllium (4)	Be-7				X			
Bismuth (83)	Bi-206				X			
	Bi-207			X				
	Bi-210			X				
	Bi-212			X				
Bromine (35)	Br-82				X			
Cadmium (48)	Cd-109				X			
	Cd-115m			X				
	Cd-115				X			
Calcium (20)	Ca-45				X			
	Ca-47				X			
Californium (98)	Cf-249	X						
	Cf-250	X						
	Cf-252	X						
Carbon (6)	C-14				X			
Cerium (58)	Ce-141				X			
	Ce-143				X			
	Ce-144			X				
Cesium (55)	Cs-131				X			
	Cs-134m			X				
	Cs-134			X				
	Cs-135				X			
	Cs-136				X			
	Cs-137			X				
Chlorine (17)	Cl-36			X				
	Cl-38				X			
Chromium (24)	Cr-51				X			
Cobalt (27)	Co-56			X				
	Co-57				X			
	Co-58m				X			
	Co-58				X			
	Co-60			X				
Copper (29)	Cu-64				X			
Curium (96)	Cm-242	X						
	Cm-243	X						
	Cm-244	X						
	Cm-245	X						
	Cm-246	X						
Dysprosium (66)	Dy-154			X				
	Dy-165				X			
	Dy-166				X			
Erbium (68)	Er-169				X			
	Er-171				X			
Europium (63)	Eu-150			X				
	Eu-152m				X			
	Eu-152			X				
	Eu-154		X					
	Eu-155				X			
Fluorine (9)	F-18				X			
Gadolinium (64)	Gd-153				X			
	Gd-159				X			
Gallium (31)	Ga-67			X				
	Ga-72				X			
Germanium (32)	Ge-71				X			
Gold (79)	Au-193			X				
	Au-194			X				
	Au-195			X				
	Au-196				X			
	Au-198				X			
	Au-199				X			
Hafnium (72)	Hf-181				X			
Holmium (67)	Ho-160							
Hydrogen (1)	H-3 (see tritium)							
Indium (49)	In-113m					X		
	In-114m			X				
	In-115m					X		
	In-115					X		
Iodine (53)	I-124			X				
	I-125			X				
	I-126			X				
	I-129			X				
	I-131			X				
	I-132					X		
	I-133			X				
	I-134					X		
	I-135					X		
Iridium (77)	Ir-190					X		
	Ir-192			X				
	Ir-194					X		
Iron (26)	Fe-55					X		
	Fe-59					X		
Krypton (36)	Kr-85m			X				
	Kr-85m (uncompressed) [3]						X	
	Kr-85			X				
	Kr-85 (uncompressed) [3]						X	
	Kr-87		X					
	Kr-87 (uncompressed) [3]						X	

See footnotes at end of table.

TABLE I

(Continued)

Radionuclide	Transport group						
	I	II	III	IV	V	VI	VII
140				X			
203				X			
110		X					
112		X					
172			X				
177				X			
38			X				
52				X			
54				X			
56				X			
95m				X			
97				X			
103				X			
P		X					
39				X			
147				X			
149				X			
237	X						
239	X						
6			X				
9				X			
3				X			
5				X			
3m				X			
5				X			
7				X			
3				X			
9m				X			
1				X			
3				X			
2m				X			
8				X			
	X						
	X						
	X						
	X						
	X						
				X			
			X				
				X			
				X			
9				X			
	X						
	X						
		X					
		X					
	X						
	X						
		X					
				X			
				X			
				X			
				X			
				X			
				X			
atural				X			
3m				X			
5				X			
				X			
atural				X			
				X			
				X			
			X				
			X				
				X			

Element [1]	Radionuclide [2]	Transport group						
		I	II	III	IV	V	VI	VII
Scandium (21)	Sc-46			X				
	Sc-47				X			
	Sc-48				X			
Selenium (34)	Se-75				X			
Silicon (14)	Si-31				X			
Silver (47)	Ag-105			X				
	Ag-110m				X			
	Ag-111			X				
Sodium (11)	Na-22				X			
	Na-24				X			
Strontium (38)	Sr-85m				X			
	Sr-85			X				
	Sr-89		X					
	Sr-90			X				
	Sr-91				X			
	Sr-92				X			
Sulphur (16)	S-35			X				
Tantalum (73)	Ta-182				X			
Technetium (43)	Tc-96m				X			
	Tc-96				X			
	Tc-97m				X			
	Tc-97				X			
	Tc-99m				X			
	Tc-99				X			
Tellurium (52)	Te-125m				X			
	Te-127m				X			
	Te-127			X				
	Te-129m				X			
	Te-129			X				
	Te-131m				X			
	Te-132			X				
Terbium (65)	Tb-160				X			
Thallium (81)	Tl-200				X			
	Tl-201				X			
	Tl-202				X			
	Tl-204			X				
Thorium (90)	Th-227		X					
	Th-228	X						
	Th-230	X						
	Th-231	X						
	Th-232			X				
	Th-234		X					
	Th Natural			X				
Thulium (69)	Tm-168			X				
	Tm-170			X				
	Tm-171				X			
Tin (50)	Sn-113				X			
	Sn-117m			X				
	Sn-121			X				
	Sn-125				X			
Tritium (1)	H-3				X			
	H-3 (as a gas, as luminous paint, or adsorbed on solid material).							X
Tungsten (74)	W-181				X			
	W-185				X			
	W-187				X			
Uranium (92)	U-230			X				
	U-232		X					
	U-233 [4]			X				
	U-234			X				
	U-235 [4]				X			
	U-236			X				
	U-238				X			
	U Natural				X			
	U Enriched [4]				X			
	U Depleted				X			
Vanadium (23)	V-48					X		
	V-49				X			
Xenon (54)	Xe-125				X			
	Xe-131m				X			
	Xe-131m (uncompressed) [3]					X		
	Xe-133			X				
	Xe-133 (uncompressed) [3]						X	
	Xe-135		X					
	Xe-135 (uncompressed) [3]					X		
Ytterbium (70)	Yb-175				X			

APPENDIX B

TABLE I

(Continued)

Element[1]	Radionuclide[2]	Transport group						
		I	II	III	IV	V	VI	VII
Yttrium (39)	Y-88			X				
	Y-90				X			
	Y-91m			X				
	Y-91			X				
	Y-92				X			
	Y-93				X			
Zinc (30)	Zn-65				X			
	Zn-69m				X			
	Zn-69				X			
Zirconium (40)	Zr-95				X			
	Zr-95			X				
	Zr-97				X			

[1] Atomic number shown in parentheses.
[2] Uncompressed means at a pressure not exceeding 14.7 p.s.i. (absolute).
[3] Atomic weight shown after the radionuclide symbol.
[4] Fissile radioactive material.

APPENDIX B

TABLE II

DUN-M-22
Procedure I

TRANSPORT GROUP (See 1.0)	LOW SPECIFIC ACTIVITY QUANTITY[1]	SMALL QUANTITY[2]	TYPE A QUANTITY (See 5.0)	TYPE B QUANTITY (See 5.0)
Group I	0[5] to < .0001 mCi/gm[3]	0[5] to < .01 mCi	.01 mCi to < .001 Ci	.001 to < 20 Ci
Group II	0 to < .005 mCi/gm	0 to < .1 mCi	.1 mCi to < .05 Ci	.05 to < 20 Ci
Group III	0 to < .3 mCi/gm	0 to < 1 mCi	1 mCi to < 3 Ci	3 to < 200 Ci
Group IV	0 to < .3 mCi/gm	0 to < 1 mCi	1 mCi to < 20 Ci	20 to < 200 Ci
Group V		0 to < 1 mCi	1 mCi to < 20 Ci	20 to < 5,000
Group VI		0 to < 1 mCi	1 mCi to < 1,000 Ci	1,000 to < 50,000
Group VII		0 to < 25 Ci	25 to < 1,000 Ci	1,000 to < 50,000
Special Form[4]		0 to < 1 mCi	1 mCi to < 20 Ci	20 to < 5,000

[1] To be classified as low specific activity material, the activity must be uniformly distributed in the material and the limits above (given in millicuries per gram of material) must be complied with.

[2] Shipments of manufactured articles containing radioactive components (such as incore fission chambers) may be classified as small quantity shipments even though they exceed the limits above. Contact RPE on 2-5360 for instructions when shipping devices with radioactive components.

[3] mCi = millicures = 10^{-3} curies.

[4] Special Form is defined in Section 4.0 of this Appendix.

[5] Although the lower limit is given as zero, material which does not contain more than 2×10^{-9} Curies per gram of material, and in which the radioactivity is essentially uniformly distributed, is not considered radioactive.

RADIOACTIVE WHITE I LABEL

Use When:

- Dose rate on any external surface of shipping container does not exceed .5 millirem/hr

Do Not Use When:

- Fissile Class II or III material is being shipped

RADIOACTIVE YELLOW II LABEL

Use When:

- The limits for Radioactive White I Label are exceeded
- And dose rate on any external surface of shipping container does not exceed 10 millirem/hr
- And dose rate 3 feet from any external surface of shipping container does not exceed .5 millirem/hr
- And the transport index does not exceed .5

Do Not Use When:

- Fissile Class III materials are being shipped in the container

RADIOACTIVE YELLOW III LABEL

Use When:

- The limits for the two preceding labels are exceeded
- Fissile Class III materials are being shipped in the container
- "Large Quantity" shipment is being made

1.0 APPLICABILITY OF THE RSA FORM

An RSA form (Form No. BC-5000-291) is to be completed in accordance with the following procedure for all offsite shipments. This form is readily available from any Radiation Monitoring office. If the shipment is classified, contact RPE on 2-5360 before filling out the RSA.

2.0 SHIPPER

2.1 Complete the "To, From and Carrier" boxes in the "Shipping Data" Section.

2.2 Fill in "Type of Material and Container" block in the "Shipping Data" Section:

- List each radionuclide in the shipment where practicable. If the contents of the shipment are unknown, the fact should be so stated. If large numbers of different radionuclides are present, so state and identify those present in large relative quantities.
- List the Transport Group classification and the quantity category for the shipment as determined by the "Procedure for Offsite Shipment of Radioactive Material," Appendix B.
- List the total curies of each radionuclide where practicable. If more than one container is used, list the total number of curies of each radionuclide for each container where practicable. Describe the form (normal or special).
- Describe internal packaging (i.e., encapsulation).
- List the number of pieces or the weight of the radioactive material being shipped, whichever is more practical.
- List the type, name and DOT special permit number or a specification continer number for each type of container being used in the shipment.
- List the total shipment weight.
- List the "Radioactive" label type used.

2.3 Check the "Offsite" box.

2.4 Obtain the Government Bill of Lading (GBL) number from Nuclear Materials Management and record it in the GBL box.

2.5 Have Radiation Monitoring survey the loaded container. Insure that RM records the results of the survey on the RSA and completes all other applicable sections of the form.

2.6 Complete the "Special Instruction" Section when fissile material is being shipped or when any other special instructions are needed.

2.7 Obtain a fissile material criticality analysis if:

- The fissile material exceeds 15 grams of contained fissile material (uranium containing U-235 which does not exceed 0.72 w/o is exempted).

2.8 Contact the Process Standards Unit on 2-4395 if the fissile material being shipped falls into the category in 2.7 above.

2.9 The shipper shall insure that the "Special Instructions" Section of the RSA form contains, when applicable, the actual criticality control instructions or that a copy of the instructions is attached to each copy of the RSA.

2.10 Check the "Classified" or "Not Classified" box, whichever is applicable.

2.11 Assure that shipment preparation has been in accord with procedures established in this manual and the RSA form has been completed in full in all sections excluding the "Patrol" Section and that all material recorded in the RSA is accurate and legible.

Then sign in the "Authorized Signature" category and fill in the date in the "Shipping Date" category. If the "Classified" box is checked (2.10 above), the signator must be registered in the patrol specimen signature book. The RSA replaces the C&R Pass.

2.12 Distribute the completed RSA promptly and in accordance with the following:

Send the Yellow and Goldenrod copies to Nuclear Materials Management for distribution and send the White copy to the Radiation Monitoring group which surveyed the shipment. Give the Pink copy to the carrier who will surrender it to Patrol at the last barricade to be passed. Attach the Buff copy to the container being shipped. If there is more than one container in the shipment, the RSA should be attached to the most conspicuous one. If the container is too small to allow the RSA to be attached, fold it, place it in a plainly marked envelope and attach the envelope to the container.

3.0 RADIATION MONITOR

3.1 Perform the following operations in accordance with DUN-M-3, Practice 3.2 and record the results in the "Monitoring Data" Section:

- Determine the maximum surface dose rate in mrem/hr
- Determine the maximum dose rate in mrem/hr at 3 feet from the container
- Determine the surface contamination on the container in d/m/100 cm^2 for alpha, beta, and gamma.
- Insure that each reading is in accordance with the limits presented in DUN-M-3, Practice 3.2. If the limits are exceeded, inform the shipper and RPE.

3.2 Check either the "Patrol Inspection Not Permitted" Box or the "Normal Inspection Permitted" Box based on observed radiation levels.

3.3 Determine if any special instructions concerning handling of the shipment are needed due to radiation levels. If special instructions are needed, record them in the "Special Instruction" Section.

3.4 Print name and date of survey in the "Monitored By" and "Date" spaces respectively.

4.0 PATROL

The "Patrol" Section will be completed by the patrol officer in accordance with ITT/FSS procedures. The RSA will act as a property pass for the shipment after it has been completed by the patrol officer. If the "Classified" Box has been checked (2.10 above), the signator must be registered in the patrol specimen signature book. A C&R pass is not required.