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Safety Analysis Report For Packaging, Y-12 National Security Complex, Model ES-3100 Package with Bulk HEU Contents

Consolidated Nuclear Security, LLC
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CONTENTS

APPROVALS v
FIGURES xiii
TABLES xvii
ABBREVIATIONS xxiii
REVISION LOG xxv
ACKNOWLEDGMENTS xxx
1. GENERAL INFORMATION 1-1
1.1 INTRODUCTION 1-1
1.2 PACKAGE DESCRIPTION 1-2
1.2.1 Packaging 1-2
1.2.2 Contents 1-9
1.2.3 Special Requirements for Plutonium 1-27
1.2.4 Operational Features 1-27
1.3 APPENDIX 1-29
Appendix 1.3.1 Package Certification Drawing 1-31
Appendix 1.3.2 SPC JS-YMN3-801580-A002, *ES-3100 Drum Assembly* 1-39
Appendix 1.3.3 SPC JS-YMN3-801580-A001, ES-3100 Containment Vessel 1-71
Appendix 1.3.4 Equipment Specification JS-YMN3-801580-A003, Manufacturing Process Specification for Casting Kaolite 1600™ into the ES-3100 Shipping Package 1-111
Appendix 1.3.5 Equipment Specification SPC JS-YMN3-801580-A005, *Casting Catalog No. 277-4 Neutron Absorber for the ES-3100 Shipping Package* 1-131
Appendix 1.3.6 Package Category Determination 1-161
Appendix 1.3.7 ES-3100 Design Drawings 1-165
Appendix 1.3.8 Pyrophoricity of Uranium Metal 1-213
Appendix 1.3.9 Equipment Specification SPC M801580-0002, *ES-3100 Ethylene Propylene Diene Monomer (EPDM) Containment Vessel O-rings* 1-233
Appendix 1.3.10 SPC M801580-0004, *ES-3100 Heavy Can Spacer Assemblies* 1-263
Appendix 1.3.11 SPC M801794-0003, *Packcrete Preliminary Lot Qualification* 1-289
Appendix 1.3.12 SPC M801580-0003, *ES-3100 Packcrete Final Lot Qualification and Production Processing* 1-341
Appendix 1.3.13 Chapter 1 References 1-369
2. STRUCTURAL EVALUATION 2-1
2.1 DESCRIPTION OF STRUCTURAL DESIGN 2-2
2.1.1 Discussion 2-2
2.1.2 Design Criteria 2-6
2.1.3 Weights and Centers of Gravity 2-13
2.1.4 Identification of Codes and Standards for Package Design 2-13
2.2 MATERIALS 2-17
2.2.1 Material Properties and Specifications 2-17
2.2.2 Chemical, Galvanic, or Other Reactions 2-17
2.2.3 Effects of Radiation on Materials 2-28

2.3 FABRICATION AND EXAMINATION 2-28
2.3.1 Fabrication 2-28
2.3.2 Examination 2-30
2.4 GENERAL REQUIREMENTS FOR ALL PACKAGES 2-33
2.4.1 Minimum Package Size—10 CFR 71.43(a) 2-33
2.4.2 Tamper-Indicating Feature—10 CFR 71.43(b) 2-33
2.4.3 Positive Closure—10 CFR 71.43(c) 2-34
2.5 LIFTING AND TIE-DOWN STANDARDS FOR ALL PACKAGES 2-34
2.5.1 Lifting Devices 2-34
2.5.2 Tie-Down Devices 2-34
2.6 NORMAL CONDITIONS OF TRANSPORT 2-35
2.6.1 Heat 2-39
2.6.2 Cold 2-42
2.6.3 Reduced External Pressure 2-47
2.6.4 Increased External Pressure 2-47
2.6.5 Vibration 2-48
2.6.6 Water Spray 2-50
2.6.7 Free Drop 2-51
2.6.8 Corner Drop 2-52
2.6.9 Compression 2-52
2.6.10 Penetration 2-54
2.7 HYPOTHETICAL ACCIDENT CONDITIONS 2-55
2.7.1 Free Drop 2-59
2.7.2 Crush 2-69
2.7.3 Puncture 2-76
2.7.4 Thermal 2-81
2.7.5 Immersion—Fissile Material 2-86
2.7.6 Immersion—All Packages 2-86
2.7.7 Deep Water Immersion Test (for Type B Packages Containing More than 10^5 A_2) 2-86
2.7.8 Summary of Damage 2-87
2.8 ACCIDENT CONDITIONS FOR AIR TRANSPORT OF PLUTONIUM 2-101
2.9 ACCIDENT CONDITIONS FOR FISSILE MATERIAL PACKAGES FOR AIR TRANSPORT 2-101
2.10 SPECIAL FORM 2-101
2.11 FUEL RODS 2-101
2.12 APPENDIX 2-102
Appendix 2.12.1 Chapter 2 References 2-104
3. THERMAL EVALUATION 3-1
3.1 DESCRIPTION OF THERMAL DESIGN 3-1
3.1.1 Design Features 3-2
3.1.2 Content's Decay Heat 3-3
3.1.3 Summary Tables of Temperatures 3-4
3.1.4 Summary Tables of Maximum Pressures 3-7
3.2 MATERIAL PROPERTIES AND COMPONENT SPECIFICATIONS 3-10
3.2.1 Material Properties 3-10
3.2.2 Component Specifications 3-10

3.3 THERMAL EVALUATION UNDER NORMAL CONDITIONS OF TRANSPORT 3-16
3.3.1 Heat and Cold 3-17
3.3.2 Maximum Normal Operating Pressure 3-29
3.3.3 Maximum Thermal Stresses.....3-30
3.4 THERMAL EVALUATION UNDER HYPOTHETICAL ACCIDENT CONDITIONS 3-31
3.4.1 Initial Conditions 3-31
3.4.2 Fire Test Conditions.....3-32
3.4.3 Maximum Temperatures and Pressure.....3-35
3.4.4 Maximum Thermal Stresses.....3-52
3.4.5 Accident Conditions for Fissile Material Packages for Air Transport.....3-52
3.5 APPENDIX 3-53
Appendix 3.5.1 Containment Vessel Pressure due to Normal Conditions of Transport for the Proposed Contents.....3-55
Appendix 3.5.2 Containment Vessel Pressure due to Hypothetical Accident Conditions for the Proposed Contents.....3-65
Appendix 3.5.3 Silicone Rubber Thermal Properties from Therm 1.2 Database 3-73
Appendix 3.5.4 Estimates of Hydrogen Buildup in the ES-3100 Package Containing Highly Enriched Uranium 3-75
Appendix 3.5.5 Chapter 3 References 3-89

4. CONTAINMENT 4-1
4.1 DESCRIPTION OF THE CONTAINMENT SYSTEM 4-5
4.1.1 Containment Boundary 4-5
4.1.2 Special Requirements for Plutonium 4-6
4.2 CONTAINMENT UNDER NORMAL CONDITIONS OF TRANSPORT 4-6
4.3 CONTAINMENT UNDER HYPOTHETICAL ACCIDENT CONDITIONS 4-9
4.4 LEAKAGE RATE TESTS FOR TYPE B PACKAGES.....4-11
4.5 APPENDIX 4-13
Appendix 4.5.1 Determination of A_2 for the ES-3100 Package with HEU Contents 4-15
Appendix 4.5.2 Calculation of the ES-3100 CV Regulatory Reference Air Leakage Rates.....4-23
Appendix 4.5.3 Chapter 4 References 4-41

5. SHIELDING EVALUATION 5-1
5.1 DESCRIPTION OF SHIELDING DESIGN 5-1
5.1.1 Design Features.....5-1
5.1.2 Summary Table of Maximum Radiation Levels.....5-2
5.2 SOURCE SPECIFICATION.....5-2
5.2.1 Gamma Source.....5-5
5.2.2 Neutron Source 5-8
5.3 SHIELDING MODEL.....5-9
5.3.1 Configuration of Source and Shielding.....5-10
5.3.2 Material Properties.....5-33
5.4 SHIELDING EVALUATION.....5-35
5.4.1 Methods.....5-35
5.4.2 Input and Output Data.....5-36
5.4.3 Flux-to-Dose-Rate Conversion 5-36
5.4.4 External Radiation Levels.....5-36

5.5 APPENDIX 5-39
Appendix 5.5.1 Origen-S Input Data 5-41
Appendix 5.5.2 MCNP Input Data 5-43
Appendix 5.5.3 Comparative NCT Dose Rates for Kaolite and Packcrete 5-109
Appendix 5.5.4 Chapter 5 References 5-117
6. CRITICALITY EVALUATION 6-1
6.1 DESCRIPTION OF THE CRITICALITY DESIGN 6-1
6.1.1 Design Features 6-1
6.1.2 Codes and Standards 6-2
6.1.3 Summary of the Criticality Evaluation 6-4
6.1.4 Criticality Safety Index 6-41
6.2 PACKAGE CONTENTS 6-42
6.2.1 Fissile Material Contents 6-42
6.2.2 Convenience Cans, Teflon and Polyethylene Bottles, and 277-4 Canned Spacers 6-44
6.2.3 Packing Materials 6-45
6.2.4 Package Content Loading Restrictions 6-45
6.3 GENERAL CONSIDERATIONS 6-47
6.3.1 Model Configuration 6-48
6.3.2 Material Properties 6-65
6.3.3 Computer Codes and Cross-Section Libraries 6-78
6.3.4 Demonstration of Maximum Reactivity 6-81
6.4 SINGLE PACKAGE EVALUATION 6-83
6.4.1 Solid HEU Metal of Specified Geometric Shapes 6-83
6.4.2 HEU Broken Metal; Solid HEU Metal with Unspecified Geometric Shape and Characterized as Broken Metal; or Turnings, Fines, or Powder 6-97
6.4.3 HEU Oxide 6-101
6.4.4 UNH Crystals 6-106
6.5 EVALUATION OF PACKAGE ARRAYS UNDER NORMAL CONDITIONS OF TRANSPORT 6-108
6.5.1 Solid HEU Metal of Specified Geometric Shapes 6-108
6.5.2 HEU Broken Metal; Solid HEU Metal of Unspecified Geometric Shape and Characterized as Broken Metal; or Turnings, Fines, or Powder 6-116
6.5.3 HEU Oxide 6-121
6.5.4 UNH Crystals 6-123
6.6 EVALUATION OF PACKAGE ARRAYS UNDER HYPOTHETICAL ACCIDENT CONDITIONS 6-124
6.6.1 Solid HEU Metal of Specified Geometric Shapes 6-124
6.6.2 HEU Broken Metal; Solid HEU Metal of Unspecified Geometric Shape and Characterized as Broken Metal; or Turnings, Fines, or Powder 6-126
6.6.3 HEU Oxide 6-130
6.6.4 UNH Crystals 6-132
6.7 FISSILE MATERIAL PACKAGES FOR AIR TRANSPORT 6-133
6.7.1 Results for HEU Metal (Excluding TRIGA Fuel Elements) 6-133
6.7.2 Results for TRIGA Fuel Elements, Three Pieces per Convenience Can 6-137
6.7.3 Results for HEU Broken Metal, Turnings, Fines, or Powder 6-143
6.7.4 Results for UF_4 Compounds 6-146
6.7.5 Results for UO_2F_2 Compounds 6-148
6.7.6 Results for UC Compounds 6-150

6.7.7 Results for UN Compounds 6-152
6.7.8 Results for U_3Si_2 Compounds at 40% Enriched 6-154
6.7.9 Results for U_3Si_2 Compounds at 60% Enriched 6-156
6.7.10 Results for U_3Si Compounds at 40% Enriched 6-158
6.7.11 Results for U_3Si Compounds at 60% Enriched 6-160
6.7.12 Conclusions 6-162
6.8 BENCHMARK EXPERIMENTS 6-162
6.8.1 Applicability of Benchmark Experiments 6-162
6.8.2 Details of Benchmark Calculations 6-163
6.8.3 Bias Determination 6-163
6.9 APPENDIX 6-165
Appendix 6.9.1 Fissile Content and Packaging Models 6-167
Appendix 6.9.2 HAC Package Model 6-197
Appendix 6.9.3 Package Material Compositions 6-209
Appendix 6.9.4 Qualification of a Neutron-absorber Material for the ES-3100 6-245
Appendix 6.9.5 Miscellaneous Information and Data 6-257
Appendix 6.9.6 Abridged Summary Tables of Criticality Calculation Results 6-261
Appendix 6.9.7 Input Listings of ES-3100 Calculation Models for Select Cases 6-507
Appendix 6.9.8 Criticality Evaluation of Additional Content 6-795
Appendix 6.9.9 Criticality Evaluation for Increasing the Fissile Loading Limit for HEU Oxide 6-859
Appendix 6.9.10 Criticality Evaluation of HEU Oxide Product Content for Air Transportation 6-915
Appendix 6.9.11 Criticality Evaluation of the Removal of Carbon Limits for Oxides; Removal of Cladding Limits; and Uranium Tetrafluoride at a Criticality Safety Index of 2.0 6-1019
Appendix 6.9.12 Chapter 6 References 6-1041

7. PACKAGE OPERATIONS 7-1
7.1 PACKAGE LOADING 7-4
7.1.1 Preparation for Loading 7-4
7.1.2 Loading of Contents 7-8
7.1.3 Preparation for Transport 7-11
7.2 PACKAGE UNLOADING 7-13
7.2.1 Receipt of Package from Carrier 7-14
7.2.2 Removal of Contents 7-15
7.3 PREPARATION OF EMPTY PACKAGE FOR TRANSPORT 7-16
7.4 OTHER OPERATIONS 7-18
7.5 APPENDIX 7-19
Appendix 7.5.1 Records and Reporting Requirements 7-21
Appendix 7.5.2 Example Leak-Test Procedure, Y-12 Product Specification Procedure Y51-01-B2-R-074, *Shipping Container Leak Test* 7-23
Appendix 7.5.3 Chapter 7 References 7-33

8. ACCEPTANCE TESTS AND MAINTENANCE PROGRAM 8-1
8.1 ACCEPTANCE TESTS 8-3
8.1.1 Visual Inspections and Measurements 8-6
8.1.2 Weld Examinations 8-7
8.1.3 Structural and Pressure Tests 8-7
8.1.4 Leakage Tests 8-8

8.1.5 Component and Material Tests 8-8
8.1.6 Shielding Tests 8-9
8.1.7 Thermal Tests 8-9
8.1.8 Miscellaneous Tests 8-9
8.2 MAINTENANCE PROGRAM 8-9
8.2.1 Structural and Pressure Tests 8-10
8.2.2 Leakage Tests 8-10
8.2.3 Component and Material Tests 8-12
8.2.4 Thermal Tests 8-12
8.2.5 Miscellaneous Tests 8-13
8.3 APPENDIX 8-15
Appendix 8.3.1 Example Leak-test Procedure, Y-12 Product Specification Procedure Y51-01-B2-R-140, *He Leak Testing in B2* 8-17
Appendix 8.3.2 Chapter 8 References 8-39
9. QUALITY ASSURANCE 9-1
9.1 INTRODUCTION 9-1
9.2 SCOPE 9-2
9.3 QUALITY ASSURANCE PLAN 9-3
9.3.1 Quality Assurance Organization 9-3
9.3.2 Quality Assurance Program 9-5
9.3.3 Package Design Control 9-11
9.3.4 Procurement Document Control 9-11
9.3.5 Instructions, Procedures, and Drawings 9-12
9.3.6 Document Control 9-13
9.3.7 Control of Purchased Material, Equipment, and Services 9-13
9.3.8 Identification and Control of Materials, Parts, and Components 9-14
9.3.9 Control of Special Processes 9-15
9.3.10 Internal Inspection 9-15
9.3.11 Test Control 9-15
9.3.12 Control of Measuring and Test Equipment 9-16
9.3.13 Handling, Storage, and Shipping Control 9-16
9.3.14 Inspection, Test, and Operating Status 9-17
9.3.15 Nonconforming Materials, Parts, or Components 9-17
9.3.16 Corrective Action 9-18
9.3.17 Quality Assurance Records 9-18
9.3.18 Audits 9-19
9.3.19 Software Quality Assurance 9-20
9.4 APPENDIX 9-21
Appendix 9.4.1 Chapter 9 References 9-23

FIGURES

Fig. 1.1. Schematic of the ES-3100 shipping package. 1-3
Fig. 1.2. Exploded view of the ES-3100 package with bulk HEU contents. 1-4
Fig. 1.3. Containment boundary of the ES-3100 shipping package. 1-8
Fig. 1.4. Typical shipping configurations inside the ES-3100 containment vessel. 1-12
Fig. 2.1. Containment vessel calculated stress locations. 2-9
Fig. 2.2. ES-3100 shipping package center of gravity locations. 2-14
Fig. 2.3. ES-3100 vibration testing arrangement. 2-49
Fig. 2.4. Water spray test arrangement for TU-4. 2-50
Fig. 2.5. NCT free drop test on TU-4. 2-52
Fig. 2.6. Compression test on TU-4. 2-53
Fig. 2.7. Penetration test damage on TU-4. 2-54
Fig. 2.8. 9-m drop test arrangement for all test units. 2-59
Fig. 2.9. 9-m drop test damage on TU-4. 2-61
Fig. 2.10. Cumulative damage from 9-m drop and crush testing on TU-2. 2-63
Fig. 2.11. TU-3 damage from 1.2- and 9-m drop tests. 2-64
Fig. 2.12. 1.2- and 9-m drop test damage on TU-1. 2-66
Fig. 2.13. 1.2- and 9-m drop test damage to TU-5. 2-68
Fig. 2.14. Cumulative damage following 9-m crush on TU-1. 2-71
Fig. 2.15. Cumulative damage following 9-m crush test on TU-3. 2-73
Fig. 2.16. Cumulative damage from 9-m drop and crush testing on TU-4. 2-74
Fig. 2.17. Cumulative damage from 9-m drop and crush testing on TU-5. 2-76
Fig. 2.18. 28° oblique and horizontal puncture tests on TU-1. 2-77
Fig. 2.19. 40° oblique puncture test on TU-1. 2-78
Fig. 2.20. Horizontal puncture test over TU-1's containment vessel flange. 2-78
Fig. 2.21. Horizontal CG puncture test on TU-2. 2-79
Fig. 2.22. 24.6° oblique puncture test on TU-3. 2-79
Fig. 2.23. Vertical puncture test on TU-4. 2-80
Fig. 2.24. Horizontal puncture test over TU-5's containment vessel flange. 2-80
Fig. 2.25. Visual comparison of the cumulative damage on the crush side surface after the three drop tests (from top to bottom: TU-1, analytical results with BoroBond, analytical results with Cat 277-4). 2-90
Fig. 2.26. Visual comparison of the cumulative damage on the rigid surface side after the four drop tests (from left to right: TU-2, analytical results with BoroBond, analytical results with Cat 277-4). 2-92
Fig. 2.27. Visual comparison of the cumulative damage on the crush plate side after the three drop tests (from left to right: TU-2, analytical results with BoroBond, analytical results with Cat 277-4). 2-93
Fig. 2.28. Visual comparison of the cumulative bottom damage after the three drop tests (from top to bottom: TU-3, analytical results with BoroBond, analytical results with Cat 277-4). 2-95
Fig. 2.29. Visual comparison of the cumulative lid damage after the three drop tests (from top to bottom: TU-3, analytical results with BoroBond, analytical results with Cat 277-4). 2-96
Fig. 2.30. Visual comparison of the cumulative damage after the three drop tests (from left to right: TU-4, analytical results with BoroBond, analytical results with Cat 277-4). 2-98
Fig. 2.31. Containment vessel markings at assembly (swivel hoist ring removed prior to testing). 2-100
Fig. 2.32. Containment vessel marking after compliance testing. 2-100

Fig. 3.1. MSC.Patran axisymmetric finite element model of the ES-3100 shipping container with BoroBond 4—nodal locations of interest (elements representing air not shown for clarity). 3-18
Fig. 3.2. ANSYS axisymmetric finite element model of the ES-3100 shipping container with Cat 277-4. 3-19
Fig. 3.3. ANSYS axisymmetric finite element model of the ES-3100 shipping container with Cat 277-4 (upper portion detail)..... 3-20
Fig. 3.4. ANSYS axisymmetric finite element model of the ES-3100 shipping container with Cat 277-4 (lower portion detail)..... 3-20
Fig. 3.5. ANSYS axisymmetric FEA model of the ES-3100 upper portion. 3-23
Fig. 3.6. ANSYS axisymmetric FEA model of the ES-3100 lower portion. 3-23
Fig. 3.7. ES-3100 nodal temperature locations of interest. 3-24
Fig. 3.8. TU-1 through TU-5 preheat arrangement. 3-34
Fig. 3.9. Test unit insertion into furnace. 3-34
Fig. 3.10. Test unit removal from furnace. 3-36
Fig. 3.11. Test unit cool down and monitoring arrangement. 3-36
Fig. 5.1. Photon spectrum for ^{232}U only and HEU content including ^{232}U. 5-7
Fig. 5.2. Neutron spectrum for HEU source composition..... 5-9
Fig. 5.3. ES-3100 packaging model. 5-11
Fig. 5.4. R/Z section at the bottom of the ES-3100 package model. 5-12
Fig. 5.5. R/Z section near the top of the ES-3100 package model. 5-13
Fig. 5.6. R/Z section at the top of the ES-3100 package model. 5-14
Fig. 5.7. Calculation model of the ES-3100 shipping package (x-z side section) for NCT with cylinder-type source configuration at the top of CV (left) and for HAC with cylinder type source configuration at the bottom of CV (right). 5-15
Fig. 5.8. Calculation model of the ES-3100 shipping package for NCT with UO_2 powder shown in yellow (x-z side section). 5-16
Fig. 5.9. Calculation model of the ES-3100 shipping package for NCT with cylinder type source configuration shown in yellow (x-z side and x-y top sections). 5-18
Fig. 5.10. Calculation model of the ES-3100 shipping package for NCT with cylindrical hemi-shell source configuration shown in yellow (x-z side and x-y top sections). 5-19
Fig. 5.11. Calculation model of the ES-3100 shipping package for NCT with cylindrical shell source configuration shown in yellow (x-z side and x-y top sections)..... 5-20
Fig. 5.12. Calculation model of the ES-3100 shipping package for NCT with plate type source configuration shown in yellow (x-z side and x-y top section). 5-21
Fig. 5.13. Calculation model of the ES-3100 shipping package for NCT with single rod source configuration shown in yellow (x-z side and x-y top sections)..... 5-22
Fig. 5.14. Calculation model of the ES-3100 shipping package for NCT with cylindrical segment source configuration shown in yellow (x-z side and x-y top sections). 5-23
Fig. 5.15. Photon dose rate contours for the cylindrical hemi-shell configuration (x-y plane). 5-25
Fig. 5.16. Photon dose rate contours for the cylindrical hemi-shell configuration (x-z plane). 5-26
Fig. 5.17. Photon dose rate absolute uncertainty contours for the cylindrical hemi-shell configuration (x-z plane). 5-26
Fig. 5.18. Photon dose rate contours for the cylinder at the bottom of CV configuration (x-z plane).... 5-27
Fig. 5.19. Photon dose rate contours for the cylinder at the top of CV configuration (x-z plane). 5-27
Fig. 5.20. Photon dose rate contours for the plate configuration (x-z plane). 5-28
Fig. 5.21. Photon dose rate contours for the plate configuration (y-z plane). 5-28
Fig. 5.22. Neutron dose rate contours for the cylindrical hemi-shell configuration (x-z plane). 5-30

Fig. 5.23. Neutron dose rate absolute uncertainty contours for the cylindrical hemi-shell configuration (x-z plane). 5-30
Fig. 5.24. Photon dose rate contours for the UO_2 cylindrical powder configuration of 75.785 cm height and 6.35 cm radius (x-z plane). 5-31
Fig. 5.25. Calculation model of the ES-3100 shipping package for NCT with cylinder type configuration at the top of CV for dose rate calculations at O-rings (x-z side section). 5-32
Fig. 6.1. R/Z section view of ES-3100 single-unit packaging model. 6-50
Fig. 6.2. R/Z section view at bottom of ES-3100 single-unit packaging showing KENO V.a geometry units 1001–1003, and 1006 (partial). 6-51
Fig. 6.3. R/Z section view at center of the ES-3100 single-unit packaging showing KENO V.a geometry units 1006 (partial), 1007, and 1008 (partial). 6-52
Fig. 6.4. R/Z section view of near top of the ES-3100 single-unit packaging showing KENO V.a geometry units 1008 (partial) and 1010–1016. 6-53
Fig. 6.5. R/Z section view at the top of the ES-3100 single-unit packaging showing KENO V.a geometry units 1016–1019. 6-54
Fig. 6.6. R/Z section view of ES-3100 array packaging model with a 7% reduction in the drum's inner diameter. 6-55
Fig. 6.7. R/Z section view at the bottom of the ES-3100 array packaging showing KENO V.a geometry units 1001–1003, and 1006 (partial). 6-56
Fig. 6.8. R/Z section view at the center of the ES-3100 array packaging showing KENO V.a geometry units 1006 (partial), 1007, and 1008 (partial). 6-57
Fig. 6.9. R/Z section view of near top of the ES-3100 array packaging showing KENO V.a geometry units 1008 (partial) and 1010–1016. 6-58
Fig. 6.10. R/Z section view at the top of the ES-3100 array packaging showing KENO V.a geometry units 1016–1019. 6-59
Fig. 6.11. Model 1. 6-63
Fig. 6.12. Model 2. 6-63
Fig. 6.13. Model 3. 6-63
Fig. 6.14. Model 4. 6-64
Fig. 6.15. Model 5. 6-64
Fig. 6.16. Model 6. 6-64
Fig. 6.17. $k_{eff} + 2\sigma$ versus pitch for triangular arrangement of content in the containment vessel. 6-90
Fig. 6.18. $k_{eff} + 2\sigma$ versus triangular pitch over range of containment vessel moderation. 6-91
Fig. 6.19. $k_{eff} + 2\sigma$ as a function of uranium weight fraction and moderation. 6-91
Fig. 6.20. k_{eff} vs enrichment (wt % ^{235}U) for HEU ranging from 7 to 10 kg. 6-134
Fig. 6.21. k_{eff} vs stainless steel shell radius (cm) for 7 kg HEU with enrichments ranging from 19 to 100 wt % ^{235}U. 6-135
Fig. 6.22. k_{eff} vs wet Kaolite shell radius (cm) for 7 kg HEU with enrichments ranging from 19 to 100 wt % ^{235}U. 6-136
Fig. 6.23. k_{eff} vs shell radius for wet and dry Kaolite for 7 kg HEU at 100% enrichment. 6-137
Fig. 6.24. k_{eff} vs shell radius (cm) for 10.4 kg core of $UZrH_x$ with stainless steel or wet Kaolite shell. 6-138
Fig. 6.25. k_{eff} vs water content (g) for homogenized core of $UZrH_x$, 500 g polyethylene and Kaolite where the Kaolite water content ranges from the dry to the wet condition. 6-140
Fig. 6.26. k_{eff} vs excess water (g) from wet Kaolite for fissile core blanketed with a variable thickness Kaolite shell. 6-141
Fig. 6.27. k_{eff} vs excess water (g) from wet Kaolite for fissile material core blanketed with a variable thickness Kaolite shell. 6-142

Fig. 6.28. k_{eff} vs excess water (g) from wet Kaolite for fissile material core blanketed with a variable thickness Kaolite shell. 6-142
Fig. 6.29. k_{eff} vs water content (g) for homogenized core of HEU with 7 kg ^{235}U, 500 g polyethylene, and Kaolite where the Kaolite water content ranges from the dry to the wet condition. 6-144
Fig. 6.30. k_{eff} vs excess water (g) from wet Kaolite for fissile core blanketed with a variable thickness Kaolite shell. 6-145
Fig. 6.31. k_{eff} vs water (g) in Kaolite for homogenized core of HEU at 100% enrichment, 500-g polyethylene, and wet Kaolite encompassed by shell of ^{235}U. 6-145
Fig. 8.1. Example label for use on the exterior surface of the containment vessel and the drum. 8-12
Fig. 9.1. Y-12 Packaging and Transportation Engineering organizational support. 9-4

TABLES

Table 1.1. Uranium concentration limits 1-9
Table 1.2. Bounding uranium isotopic concentrations in oxide 1-11
Table 1.3. Authorized content and fissile mass loading limits for ground transport 1-20
Table 1.3a. Uranyl nitrate crystal content loading limits for ground transport 1-24
Table 1.3b. Authorized content and fissile mass loading limits for air transport 1-24
Table 2.1. Proposed HEU contents for shipment in the ES-3100 2-2
Table 2.2. Category designations for Type B packages 2-6
Table 2.3. Summary of load combinations for normal and hypothetical accident conditions of transport 2-8
Table 2.4. Containment vessel allowable stress 2-9
Table 2.5. Allowable stress intensity (S_m) for the containment vessel materials of construction 2-10
Table 2.6. ES-3100 containment vessel design evaluation allowable stress comparisons 2-11
Table 2.7. ES-3100 packaging material specifications 2-12
Table 2.8. Packaging weights for various ES-3100 shipping package arrangements 2-15
Table 2.9. Compliance test unit weights 2-17
Table 2.10. Calculated center of gravity for the various ES-3100 shipping arrangements 2-18
Table 2.11. Applicable codes and standards for Category I packaging 2-19
Table 2.12. Mechanical properties of the metallic components of the drum assembly 2-20
Table 2.13. Mechanical properties of the lid fastening components for the drum assembly 2-21
Table 2.14. Mechanical properties of the cast refractory insulation 2-22
Table 2.15. Mechanical properties of containment vessel O-rings 2-22
Table 2.16. Mechanical properties of the metallic components of the containment vessel 2-23
Table 2.17. Mechanical properties of the cast neutron absorber 2-24
Table 2.18. Summary of NCT—10 CFR 71.71 tests for ES-3100 package 2-36
Table 2.19. Summary of HAC—10 CFR 71.73 tests for the ES-3100 package 2-37
Table 2.20. Summary of temperatures and pressures for NCT 2-38
Table 2.20a. Maximum calculated stress in the drum assembly components during NCT hot conditions (100°F, decay heat, solar insolation) 2-41
Table 2.21. ES-3100 containment vessel evaluation for both hot and cold conditions 2-43
Table 2.21a. ES-3100 containment vessel evaluation for internal pressure developed during air transport in accordance with IAEA SSR-6, Paragraph 620 2-44
Table 2.22. NCT ES-3100 containment vessel stress compared to the allowable stress at reduced and increased external pressures 2-45
Table 2.22a. Maximum calculated stress in the drum assembly components during NCT cold conditions (-40°F, no decay heat, no solar insolation) 2-46
Table 2.23. Test and analysis summary for the ES-3100 package [a] 2-58
Table 2.24. Recorded height damage to TU-4 from 1.2- and 9-m drop tests 2-60
Table 2.25. Recorded diametrical damage to TU-4 from 1.2- and 9-m drop tests 2-60
Table 2.26. Recorded diametrical damage to TU-2 from NCT and HAC drop testing 2-62
Table 2.27. Recorded flat contour damage to TU-2 from NCT and HAC drop tests 2-62
Table 2.28. Recorded height damage to TU-2 from NCT and HAC drop tests 2-62
Table 2.29. Recorded height damage to TU-3 from 1.2- and 9-m drop tests 2-64
Table 2.30. Recorded diametrical damage to TU-3 from 1.2- and 9-m drop tests 2-64
Table 2.31. Recorded height damage to TU-1 from 1.2- and 9-m drop tests 2-65
Table 2.32. Recorded diametrical damage to TU-1 from 1.2- and 9-m HAC drop tests 2-65
Table 2.33. Recorded flat contour damage to TU-1 from 1.2- and 9-m drop tests 2-66
Table 2.34. Recorded height damage to TU-5 from 1.2- and 9-m drop tests 2-67

Table 2.35. Recorded diametrical damage to TU-5 from 1.2- and 9-m HAC drop tests 2-67
Table 2.36. Recorded flat contour damage to TU-5 from 1.2- and 9-m drop testing 2-68
Table 2.37. Recorded height damage to TU-1 from the 9-m crush test 2-70
Table 2.38. Recorded diametrical damage to TU-1 from the 9-m crush test 2-70
Table 2.39. Recorded flat contour damage to TU-1 from the 9-m crush test 2-70
Table 2.40. Recorded height damage to TU-3 from the 9-m crush test 2-72
Table 2.41. Recorded flat contour damage to TU-3 from the 9-m crush test 2-72
Table 2.42. Recorded diametrical damage to TU-3 from the 9-m crush test 2-72
Table 2.43. Recorded height damage to TU-4 from the 9-m crush test 2-73
Table 2.44. Recorded diametrical damage to TU-4 from the 9-m crush test 2-74
Table 2.45. Recorded height damage to TU-5 from the 9-m crush test 2-75
Table 2.46. Recorded diametrical damage to TU-5 from the 9-m crush tests 2-75
Table 2.47. Recorded flat contour damage to TU-5 from the 9-m crush test 2-75
Table 2.48. 1-m (40-in.) puncture drop test description and results 2-77
Table 2.49. Thermax temperature-indicating patches for test units 2-82
Table 2.50. Maximum HAC temperatures recorded on the test packages' interior surfaces 2-84
Table 2.51. HAC ES-3100 containment vessel stress compared to the allowable stress 2-87
Table 2.52. Diametrical damage comparison of TU-1 with analytical predictions 2-89
Table 2.53. Flat contour damage comparison of TU-1 with analytical results 2-89
Table 2.54. Cumulative analytical 12° slapdown drop tests maximum effective plastic strain results .. 2-91
Table 2.55. Diametrical damage comparison of TU-2 with analytical predictions 2-91
Table 2.56. Flat contour damage comparison of TU-2 with analytical predictions 2-92
Table 2.57. Cumulative analytical side drop test maximum effective plastic strain results 2-93
Table 2.58. Diametrical damage comparison of TU-3 with analytical predictions 2-94
Table 2.59. Cumulative analytical corner drop test maximum effective plastic strain results 2-97
Table 2.60. Diametrical damage comparison of TU-4 with analytical predictions 2-97
Table 2.61. Cumulative analytical top drop test maximum effective plastic strain results 2-98
Table 2.62. ES-3100 test package weights before and after 10 CFR 71.73(c)(4) HAC testing 2-99
Table 3.1. Isotopic mass and weight percent for the HEU contents [a] 3-3
Table 3.2. Decay heat for 35.2 kg of HEU content 3-5
Table 3.3. Summary of results of evaluation for the ES-3100 under NCT 3-6
Table 3.4. Maximum HAC temperatures recorded on the test packages' interior surfaces 3-6
Table 3.5. Summary of results of evaluation under HAC for the ES-3100 shipping arrangement using bounding case parameters 3-7
Table 3.6. Total pressure inside the containment vessel at 89.60°C (193.28°F) 3-8
Table 3.7. Total pressure inside the containment vessel at 167.39°C (333.31°F) with efflorescence 3-10
Table 3.8. Thermal properties of the materials used in the thermal analysis 3-11
Table 3.9. Mechanical properties of the materials used in the static stress analyses 3-13
Table 3.10. ES-3100 packaging material specifications 3-14
Table 3.11. Component allowable service temperature and pressure 3-15
Table 3.12. Maximum "quasi steady-state" temperatures during NCT for the ES-3100 shipping container with various content heat loads—Kaolite density of 19.4 lb/ft^3 and BoroBond4 3-21
Table 3.13. Maximum "quasi steady-state" temperatures during NCT for the ES-3100 shipping container with various content heat loads—Kaolite density of 30 lb/ft^3 and BoroBond4 .. 3-22
Table 3.14. Steady state temperatures (5 W and 38°C ambient conditions) 3-25
Table 3.15. Steady state temperatures (5 W and 55°C ambient conditions) 3-26
Table 3.16. NCT maximum quasi steady state temperatures 3-27
Table 3.17. ES-3100 test package weights before and after 10 CFR 71.73(c)(4) HAC testing 3-37
Table 3.18. Thermax temperature-indicating patches for test units 3-37
Table 3.19. HAC maximum temperatures using Packcrete (ASH, HTC, HD, 277HD) 3-40

Table 3.20. HAC maximum temperatures using Packcrete (ASH, HTC, HD, 277LD) 3-41
Table 3.21. HAC maximum temperatures using Packcrete (ASH, LTC, LD, 277HD) 3-42
Table 3.22. HAC maximum temperatures using Packcrete (ASH, LTC, LD, 277LD) 3-43
Table 3.23. HAC maximum temperatures using Packcrete (HSH, LTC, LD, 277HD) 3-44
Table 3.24. HAC maximum temperatures using Packcrete (HSH, LTC, LD, 277LD) 3-45
Table 3.25. HAC maximum temperatures using Packcrete (LSH, HTC, HD, 277HD) 3-46
Table 3.26. HAC maximum temperatures using Packcrete (LSH, HTC, HD, 277LD) 3-47
Table 3.27. HAC maximum temperatures using Kaolite (Kaolite LD, 277LD) 3-48
Table 3.28. Predicted temperature adjustments (°F) for containment vessel due to HAC 3-50
Table 3.29. Predicted temperatures of the containment vessel due to HAC 3-51
Table 4.1. Containment requirements of transport for Type B packages 4-1
Table 4.2. Summary of the containment vessel design and fabrication acceptance basis 4-2
Table 4.3. Isotopic mass and weight percent for the HEU contents 4-2
Table 4.4. Activity, A_2 value, and number of A_2 proposed for transport 4-3
Table 4.5. Regulatory leakage criteria for NCT 4-3
Table 4.6. 10 CFR 71.51(a)(1) leakage criteria for air transport in accordance with IAEA environmental conditions 4-3
Table 4.7. Containment vessel verification tests criteria for NCT 4-4
Table 4.8. Regulatory leakage criteria for HAC 4-10
Table 4.9. Containment vessel design verification tests for HAC 4-10
Table 5.1. Calculated external dose rates for the ES-3100 package with 36 kg of HEU metal contents 5-3
Table 5.2. Calculated external dose rates for the ES-3100 package with 24 kg of HEU oxide contents 5-4
Table 5.3. Radioisotope composition for all ES-3100 package analysis source calculations with HEU content and other nuclides per HEU unit weight 5-5
Table 5.4. Photon source for 1 g of HEU for all contents 5-6
Table 5.5. Neutron source for 1 g of HEU for all contents 5-8
Table 5.6. Radiation detector locations 5-17
Table 5.7. Side dose rates for different HEU metal source configurations 5-24
Table 5.8. Shielding model material specifications for the ES-3100 package with HEU content 5-33
Table 5.9. ANSI/ANS-1977 photon flux-to-dose-rate conversion factors 5-37
Table 5.10. ANSI/ANS-1977 neutron flux-to-dose-rate conversion factors 5-38
Table 6.1a. Summary of criticality evaluation for solid HEU metal cylinders and bars 6-5
Table 6.1b. Summary of criticality evaluation for solid HEU metal slugs 6-9
Table 6.1c. Summary of criticality evaluation for HEU broken metal or solid HEU metal of unspecified geometric shape and characterized as broken metal 6-12
Table 6.1d. Summary of criticality evaluation for HEU metal turnings, fines, or powder 6-19
Table 6.1e. Summary of criticality evaluation for HEU product oxide 6-25
Table 6.1e. Summary of criticality evaluation for HEU product and skull oxide 6-28
Table 6.1f. Summary of criticality evaluation for UNX crystals and unirradiated TRIGA reactor fuel elements 6-31
Table 6.2a. HEU fissile material mass loading limits (with case name) for surface-only modes of transportation 6-37
Table 6.2b. HEU fissile material mass loading limits for air mode of transportation [a] 6-40
Table 6.3. Deformation of 18.37-in.-diam ES-3100 drum projected by finite element analysis Case “3100 RUN1HL Lower Bound Kaolite May 2004” 6-61
Table 6.4. Material compositions used in the ES-3100 calculation models 6-68
Table 6.5. Reflected CV model, HEU metal cylinders and bars, with and without 500 g polyethylene, (USL=0.9352) 6-86

Table 6.6. Reflected NCT single package model, HEU metal cylinders and bars, with and without 500 g polyethylene, (USL=0.9352) 6-87
Table 6.7. Reflected HAC single package model, HEU metal cylinders and bars, with and without 500 g polyethylene, (USL=0.9352) 6-88
Table 6.8. Reflected CV model, TRIGA fuel, with and without 500 g polyethylene, (USL=0.9352) ... 6-92
Table 6.9. Reflected NCT single package model, TRIGA fuel, with and without 500 g polyethylene, (USL=0.9352) 6-93
Table 6.10. Reflected HAC single package model, TRIGA fuel, with and without 500 g polyethylene, (USL=0.9352) 6-93
Table 6.11. Reflected CV model, HEU metal slugs, with and without 500 g polyethylene, (USL=0.9352) 6-95
Table 6.12. Reflected NCT single package, HEU metal slugs, with and without 500 g polyethylene, (USL=0.9352) 6-97
Table 6.13. Reflected HAC single package, HEU metal slugs, with and without 500 g polyethylene, (USL=0.9352) 6-97
Table 6.14. Reflected CV model, oxide mixed with 500 g polyethylene, MOCFR of 1.0E-20, (USL=0.935) 6-103
Table 6.15. Reflected CV model, oxide mixed with 500 g polyethylene, MOCFR of 1.0, (USL=0.935) 6-103
Table 6.16. Reflected NCT single package model, oxide mixed with 500 g polyethylene, MOCFR of 1.0, (USL=0.935) 6-103
Table 6.17. Reflected HAC single package model, oxide mixed with 500 g polyethylene, MOCFR of 1.0 (USL=0.935) 6-104
Table 6.18. NCT infinite array model, HEU metal cylinders and bars, with and without 500 g polyethylene, (USL=0.9352) 6-109
Table 6.19. HAC infinite array model, HEU metal cylinders and bars, with and without 500 g polyethylene, (USL=0.9352) 6-110
Table 6.20 NCT array model, TRIGA fuel, with and without 500 g polyethylene, (USL=0.9352) 6-112
Table 6.21. Reflected HAC array model, TRIGA fuel, with and without 500 g polyethylene, (USL=0.9352) 6-112
Table 6.22. NCT infinite array model, HEU metal slugs, with and without 500 g polyethylene, (USL=0.9352) 6-114
Table 6.23. HAC infinite array model, HEU metal slugs, with and without 500 g polyethylene, (USL=0.9352) 6-115
Table 6.24. Array, NCT package model, broken metal mixed with 500 g polyethylene, with canned spacers 6-118
Table 6.25. Array, NCT package model, broken metal (including turnings, fines, or powders) mixed with 500 g polyethylene, with no canned spacers 6-120
Table 6.26. Infinite array, NCT package model, uranium oxide mixed with 500 g polyethylene, (USL=0.935) 6-121
Table 6.27. Infinite array, NCT package model, uranium and thorium oxide mixed with 500 g polyethylene 6-122
Table 6.28. Infinite array, NCT package model, uranium and zirconium oxide mixed with 500 g polyethylene 6-122
Table 6.29. Infinite array, NCT package model, uranium and thorium metal mixed with 500 g polyethylene 6-123
Table 6.30. Infinite array, HAC package model, broken metal mixed with 500 g polyethylene, with canned spacers 6-127
Table 6.31. Infinite array, NCT package model, broken metal (including turnings, fines, or powders) mixed with 500 g polyethylene, with no canned spacers 6-129

Table 6.32. Infinite array, HAC package model, uranium oxide mixed with 500 g polyethylene, (USL=0.935) 6-130
Table 6.33. Infinite array, HAC package model, uranium oxide and thorium oxide mixed with 500 g polyethylene 6-131
Table 6.34. Infinite array, HAC package model, uranium oxide and zirconium oxide mixed with 500 g polyethylene 6-132
Table 6.35. Infinite Array, HAC Package model, uranium oxide and thorium metal mixed with 500 g polyethylene 6-132
Table 7.1. Replacement parts for the ES-3100 packaging 7-3
Table 8.1. Acceptance tests for the drum assembly 8-4
Table 8.2. Acceptance tests for the CV assembly 8-5
Table 8.3. Acceptance tests for packing materials 8-5
Table 9.1. Typical level of quality assurance effort by graded quality category 9-7
Table 9.2. Quality category for ES-3100 packaging components 9-10
Table 9.3. Typical quality assurance records 9-19

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ABBREVIATIONS

ALARA	as low as reasonably achievable
AM	as-manufactured
ANS	American Nuclear Society
ANSI	American National Standards Institute
ASME	American Society of Mechanical Engineers
ASNT	American Society for Nondestructive Testing
ASTM	American Society for Testing and Materials
AWS	American Welding Society
CAS	Chemical Abstract Service
Cat 277-4	Thermo Electron Corporation (corporate name changed to Shieldwerx) Catalog No. 277-4™ (or Cat. No. 277-4)
CFR	Code of Federal Regulations
CG	center of gravity
CMTR	certified material test report
CNS	Consolidated Nuclear Security, LLC
CoC	Certificate of Compliance
CSAS	Criticality Safety Analysis Sequence
CSI	criticality safety index
CV	containment vessel
CVA	containment vessel arrangement
DOE	U.S. Department of Energy
DOT	U.S. Department of Transportation
EPDM	ethylene propylene diene monomer
ESL	Evaluated Suppliers List
ETP	explicit triangular pack
FEA	finite element analysis
FEP	fluorinated ethylene propylene
GMAW	gas metal arc welding
GTAW	gas tungsten arc welding
HAC	Hypothetical Accident Conditions
HEU	highly enriched uranium
HP	Hewlett Packard
H/X ratio	hydrogen-to-fissile isotope ratio
IAEA	International Atomic Energy Agency
IEU	intermediate enriched uranium
k_{eff}	calculated neutron multiplication factor
LANL	Los Alamos National Laboratory
LEU	low enriched uranium
LOD	loss on drying
LTL	lower tolerance limit
MIT	Massachusetts Institute of Technology
MNOP	maximum normal operating pressure
MOCFR	moisture fraction inside the containment vessel
MOIFR	moisture fraction of the package external to the containment vessel
M.S.	margin of safety
M&TE	measuring and test equipment
NCR	nonconformance report
NCT	Normal Conditions of Transport
NITS	not important to safety
NLF	neutron leakage fraction
NNSA	National Nuclear Security Administration

NRC	U.S. Nuclear Regulatory Commission
NTRC	National Transportation Research Center
OECD	Organization for Economic Cooperation and Development
O	Order
ORNL	Oak Ridge National Laboratory
PBR	pebble bed reactor
PGNAA	prompt gamma-ray neutron activation analysis
ppb	parts per billion
ppm	parts per million
PTE	Packaging and Transportation Engineering
QP&A	Quality Performance & Analysis
QA	quality assurance
QAPP	quality assurance program plan
RCSB	Rackable Can Storage Box
RFID	radio-frequency identification
RFWD	request for waiver or deviation
SAE	Y-12 Safety Analysis Engineering
SARP	safety analysis report for packaging
SCALE	Standardized Computer Analysis for Licensing Evaluation
S/CI	suspect/counterfeit item
SGT	Safeguards Transporter
SNAP	Systems for Nuclear Auxiliary Power
SO	skull oxide
SQA	software quality assurance
SRNL	Savannah River National Laboratory
SS304	Type 304 stainless steel
SSCs	structures, systems, and components
TGA	thermogravimetric analysis
TI	transport index
TID	tamper-indicating device
TRISO	tristructural isotopic
TS	test sample
TSD	Transportation Safety Document
TU	test unit
UNH	uranyl nitrate hexahydrate
UNX	uranyl nitrate crystals
USL	upper subcritical limit
VCO	vacuum coupling O-ring
VF	volume fraction
Y-12	Y-12 National Security Complex

REVISION LOG

Date	Revision No.	Description	Affected Pages
9/25/09	A	Draft for DOE EM review. All revisions to the previous ES-3100 SAR approved by the NRC (Y/LF-717/R3) are shown in red text. Since the revisions to Appendix 3.5.4 and Sects. 7 and 9 were extensive, these sections are shown in black text. Appendices 5.5.2 and 6.9.8 are new, but they are shown in black text.	All
8/12/10	0	Incorporated responses to comments received from DOE EM, Packaging Certification Program SARP Review Team.	All
11/10/10	0 Page Change 1	Incorporated minor revisions to make SARP consistent with Rev. 2 of the CoC.	Cover, title page, iii, v, xxiii, 1-2, 1-12, 1-14, 1-16, 1-17, 1-22, 2-1, 3-37, 6-598, 7-13
2/10/11	0 Page Change 2	• Clarified description of U-Zr oxide in "HEU oxide" category (designated as UO_2-ZrO_2 throughout the SARP) • Added a physical form of oxide under "HEU Oxide" in Sect. 1.2.2 for pellets • In Table 1.3, – Modified "CSI" and "277-4 can spacer" entries for U-Zr in "Research reactor fuel elements and components" category – Added a new content group called "Oxides of U-Zr" under the "Research reactor fuel elements and components" category • Changed the maximum enrichment of TRIGA fuel to ≤70% • Revised CSI entries for air transport in Table 1.3b • Clarified appropriate DOE marking on the drum in Sect. 7.1.2.2 • Editorial corrections as necessary	Cover, title page, iii, v, xxiii, 1-10 through 1-12, 1-15 through 1-17, 2-1, 2-2, 4-3, 6-4, 6-30, 6-33, 6-35, 6-598, 7-11

Date	Revision No.	Description	Affected Pages
6/21/12	0 Page Change 3	• Change the U-233 concentration limit in oxide contents to 0.006 g/gU from 200 ppm • Add bulk HEU oxide as an authorized content for air transport • Add uranium silicide as an authorized content for ground transport • Add Viton GLT-S as an optional O-ring material in addition to EPDM and extend the basis for periodic maintenance from 1 to 2 years for packagings with Viton GLT-S O-rings and temperature monitoring • Revise the spacer can drawing (Drawing M2E801580A043) to make the "vibration absorbing silicone can pad" optional • Increase the amount of U-235 in U-Al reactor fuel • Make allowance for convenience cans with diameters >4.25 in. along with a void volume limit for gas expansion and offgassing materials in the CV • Remove the requirement to place empty convenience cans on top of the loaded cans • Revise the wording regarding convenience can use to allow for contents that cannot fit into a convenience can to be bagged only (no convenience can) • Add the option of applying an RFID system to the ES-3100 • Editorial corrections as necessary	All
1/10/13	0 Page Change 4	Incorporate responses to Q1 comments.	Cover, title page, v, viii, ix, xvii, xxi, xxii, xxiv, 1-11, 1-12, 1-18, 1-19, 1-20, 1-24, 2-39, 2-39a, 2-41, 2-43, 2-44a, 2-56, 2-107, 2-109, 2-110, 3-6, 3-24, 3-54a, 3-54b, 3-80, 3-81, 3-82, 4-7, 4-9, 4-33 through 4-42, 6-30, 6-35, 6-36, 6-598, 6-611 through 6-614, 6-616, 6-629 through 6-633, 7-1, 7-16, 7-26, 7-43, 8-1, 8-31, 9-1, 9-19, 9-20
9/30/13	0 Page Change 5	• Incorporate responses to Q1 comments for shipping HEU metal and alloy turnings, fines, or powder • Clarified the "HEU Metal and Alloy" and "HEU Oxide" shipping configurations including the use of aluminum convenience cans and Teflon bottles • Editorial corrections as necessary	Cover, title page, v, x, xi, xiv, xv, xix, xxiv, 1-2, 1-10, 1-18 through 1-22, 1-24, 1-227, 2-1, 2-5, 2-13, 2-24, 2-25, 2-41, 3-16, 6-1 through 6-688, 7-6
2/27/14	0 Page Change 6	Incorporate responses to Q1 comments for Phase III review documented in RP-801940-0011 with additional editorial changes.	Cover, title page, v, xxiv, 1-10, 1-20, 1-22, 2-28, 2-39a, 2-40, 2-109, 4-6, 4-42, 7-20, 8-9, 9-20

Date	Revision No.	Description	Affected Pages
6/30/15	0 Page Change 7	• Incorporated changes to address the Consolidated Nuclear Security, LLC, (CNS) organization/position titles and procedural requirements • Updated references to the current Quality Assurance Program Plan (QAP-Y-91-273860-1, Rev. 15) • Removed provisions in the SARP that supported the extended periodic maintenance interval for the package including the temperature labels requirements • Updated references to reflect current regulatory and DOE directive requirements	Cover, ii, title page, v, vii, ix, xi, xii, xv, xix, xxi, xxii, xxiv through xxviii, 1-1, 1-6, 1-19, 1-27, 1-29, 1-31, 1-33, 1-125, 1-149, 1-167, 1-213 through 1-232, 2-9, 2-10, 2-31 through 2-33, 2-40, 2-41, 2-105, 2-106, 3-79, 4-41, 5-39, 6-173, 6-193, 6-616, 6-685, 7-2, 7-4, 7-7 through 7-12, 7-14, 7-15, 7-17 through 7-36, 8-4, 8-5, 8-9 through 8-12, 8-19 through 8-29, 8-31, 9-1 through 9-22
9/3/15	1	• Incorporated Page Changes 1–7 and minor editorial changes • Added provisions in the SARP to address the requirements for samples and small quantities (≤ 50 g) of HEU metal or alloy turnings, fines, or powder • Added App. 6.9.10 as the basis for the HEU oxide carbon limit requirements and revised appropriate footnotes in Tables 1.3 and 6.9.8.2	All
9/8/16	2	• Incorporated minor editorial changes • Removed the fluorocarbon elastomer (Viton) O-rings from the SARP • Added provisions in the SARP that supported the extended periodic maintenance interval from one to two years for the EPDM O-rings • Revised the bulk density range for uranium oxide from 2.0–6.54 g/cm^3 to 0.5–6.54 g/cm^3 for ground transport. • Removed the carbon limit for uranium oxide. • Evaluated HEU metal or alloy turnings fines or powder for ground transport at enrichments >80% • Added a uranium oxide loading of 12.323 kg ^{235}U with a CSI of 0.4 • Added a uranium tetrafluoride (UF_4) loading of 24.0 kg UF_4 (18.136 kg ^{235}U) with a CSI of 2.0 • Removed the HEU broken metal or alloy cladding restrictions for ground and air transport • Removed the cladding restrictions for research reactor fuel elements and components, which were bounded by HEU bulk oxide • Updated the shielding evaluation presented in Chap. 5 using the MCNP Monte Carlo radiation transport code to perform the photon and neutron transport and dose rate calculations • Added Apps. 6.9.9 and 6.9.11 as the basis for the revised criticality safety evaluations	All

Date	Revision No.	Description	Affected Pages
6/26/17	2 Page Change 1	• Updated the Revision Log for Rev. 2 to clarify that the UF_4 was evaluated with a CSI of 2.0 • Revised Sects. 6.2.4 and 6.7.4 to be consistent with the analyses in App. 6.9.11.	Cover, title page, v, xxv, xxvi, 6-43, 6-118
7/11/19	2 Page Change 2	Incorporated the approved responses to comments documented in RP 801940-0019 000 00.	Cover, title page, v, xxvi, 4-42, 7-6, 7-7, 8-14
2/28/20	2 Page Change 3	• Incorporated minor editorial changes • Added provisions in the SARP to permit Packcrete (in addition to Kaolite) as the thermal insulating and an impact limiting material • Updated SARP and supporting analyses to authorize transport of two right annular cylinders with machined features designated as Cylinders C and D under the solid HEU metal or alloy (specified geometric shapes) category • Updated references to the current Quality Assurance Program Plan (QAP-Y-91-273860-1, Rev. 16) • Updated references to reflect current regulatory and DOE directive requirements • Updated SARP and supporting analyses to include insolation prior to HAC thermal testing • Added HEU oxide mixed with ThO_2 pellets under the research reactor fuel elements and components category for ground and air transport • Clarified that bagging may be polyethylene, nylon, or Teflon throughout the SARP. • Revised SPC JS-YMN3-801580-A005 to solely control casting of the 277-4 material in the ES-3100 packaging and added SPC M801580-0004 to control casting 277-4 material in the can spacers • Added uranium thorium metal alloy material to the HEU metal and alloy category • Evaluated HEU metal and alloy and HEU metal or alloy turnings, fines, or powders categories with 500 g of polyethylene bagging • Clinkers and screenings from metal casting operations were added with a loading restriction (Sect. 1.2.2.8, Item 15) • Revised Sect. 1.2.2.8, Item 6 to clarify the one-third mass loading requirement and use of can spacers consistent with the CoC. • Revised Sect. 1.2.2.8, Item 4 to clarify that the transportation of plutonium by air (due to transuranic concentration allowance) shall be in accordance with 10 CFR 71.88 • Added low density HEU oxide mass loading limits for air transport to Table 1.3b • Revised Tables 1.3 and 1.3b to indicate that carbon coating for research reactor fuel elements and components is not controlled	All

Date	Revision No.	Description	Affected Pages
		• Revised Table 6.8.8.2 for the BR-2 MTR Type 2 fuel enrichment to match the analyses presented in Chap. 6 • Added analyses in Chap. 6 for research reactor fuel elements and components with 500 g of polyethylene • Added product oxides (UO_2, UO_3, U_3O_8) mixed with ThO_2, ZrO_2, or Th metal to Tables 1.3 and 1.3b with supporting analyses • Added uranium compounds (UF_4, UO_2F_2, UC, UN, U_3Si_2, and U_3Si) to Table 1.3b with supporting analyses • Added uranium compounds (U_3Si_2-Al, U_3Si, and U_3Si-Al) to Table 1.3 with supporting analyses	
1/21/21	3	Incorporated the approved responses to comments documented in RP 801940-0025 000 03.	Cover, title page, v, xxix, 1-3, 1-5, 1-16, 1-20, 1-22, 1-23, 1-25, 1-165, 1-175, 1-371, 2-7, 4-28, 6-17, 6-23, 6-38, 6-312 through 6-317, 6-337, 6-816, 6-817, 6-850, 6-851, 6-854, 6-855, 6-857, 7-33, 8-39, 9-10, 9-23

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1. GENERAL INFORMATION

1.1 INTRODUCTION

This safety analysis report for packaging (SARP) presents the results of the safety analysis prepared in support of the Consolidated Nuclear Security, LLC (CNS) request for licensing of the Model ES-3100 package with bulk highly enriched uranium (HEU) contents and issuance of a Type B(U) Fissile Material Certificate of Compliance. This SARP, published in the format specified in the U.S. Nuclear Regulatory Commission (NRC) Regulatory Guide 7.9 and using information provided in UCID-21218 and NRC Regulatory Guide 7.10, demonstrates that the Y-12 National Security Complex (Y-12) ES-3100 package with bulk HEU contents meets the established NRC regulations for packaging, preparation for shipment, and transportation of radioactive materials given in Title 10, Part 71, of the Code of Federal Regulations (CFR) [10 CFR 71] as well as U.S. Department of Transportation (DOT) regulations for packaging and shipment of hazardous materials given in Title 49 CFR.

To protect the health and safety of the public, shipments of radioactive materials are made in packaging that is designed, fabricated, assembled, tested, procured, used, maintained, and repaired in accordance with the provisions cited above. Safety requirements addressed by the regulations that must be met when transporting radioactive materials are containment of radioactive materials, radiation shielding, and assurance of nuclear subcriticality.

A general description and a summary of the evaluation of the packaging are presented in this chapter. Subsequent chapters address structural (Chap. 2) and thermal (Chap. 3) responses to Normal Conditions of Transport (NCT) and Hypothetical Accident Conditions (HAC) and the packaging's ability to contain the radioactive materials (Chap. 4) when subjected to the requirements of 10 CFR 71.71 and 71.73, respectively. A shielding evaluation was prepared to ensure adequate nuclear radiation shielding (Chap. 5). Criticality evaluations that are unique to the contents were prepared to ensure nuclear subcriticality (Chap. 6). Chapters 7 and 8 discuss the operating procedures, the new packaging acceptance tests, and the maintenance program for the planned use and maintenance of the packaging. Chapter 9 describes the packaging quality assurance requirements as demonstrated by the *Packaging and Transportation Quality Assurance Program Plan* (QAP-Y-91-273860-1).

The ES-3100 package was subjected to verification (analysis, similarity comparisons, tests, or a combination of these) for NCT and HAC. Full-scale packages were used for design verification testing (Chaps. 2 and 3). The ES-3100 package with bulk HEU content was verified solely on the ability of the package to meet the requirements of 10 CFR 71. Transport conveyance influence on the package is not required to meet 10 CFR 71 requirements.

The packaging verification activities (Chaps. 2, 3, and 4), using content test masses of between 3.6 and 50.3 kg (8 and 111 lb), show that the packaging meets the containment requirements of 10 CFR 71. The shielding evaluations (Chap. 5) show that the packaging meets the NCT requirements of 10 CFR 71.47, *External Radiation Standards for all Packages*, and the HAC requirements of 10 CFR 71.51, *Additional Requirements for Type B Packages*. Based on the results of the thermal and shielding evaluations, the ES-3100 package with bulk HEU content may be shipped as a nonexclusive use package. The criticality evaluation (Chap. 6) shows that the packaging meets the requirements of 10 CFR 71.55, *General Requirements for Fissile Material Packages*, and 10 CFR 71.59, *Standards for Arrays of Fissile Material Packages*.

1.2 PACKAGE DESCRIPTION

A schematic of the ES-3100 shipping package is shown in Fig. 1.1, and an exploded view of the packaging components is presented in Fig. 1.2. The packaging design drawings (Appendix 1.3.7) provide material lists, dimensions, safety components, welding requirements, and gasket requirements. The maximum nominal gross shipping weight of the ES-3100 package with bulk HEU content is 187.81 kg (414.05 lb). The maximum authorized gross shipping weight of the ES-3100 package is 190.5 kg (420 lb). The certification drawing of the ES-3100 can be found in Appendix 1.3.1. The ES-3100 as specified in this SARP is classified as a Type B(U) fissile material Category I package (see Appendix 1.3.6).

1.2.1 Packaging

The main functions of the packaging are containment, shielding, and nuclear criticality safety. The bulk HEU contents create a maximum decay heat of ~5 W (Sects. 1.2.2.7 and 3.1.2); therefore, the packaging does not require any special design features such as coolant valves or continuous venting to meet the thermal requirements of 10 CFR 71.

1.2.1.1 Drum assembly

The drum assembly consists of a double open-head reinforced stainless-steel 30-gal drum, arched cover that forms the bottom, arched lid, inner liner, and top plug with cast refractory insulation (Kaolite or Packcrete) [Drawing M2E801580A001, Appendix 1.3.7]. The inside diameter of the drum is 46.36 cm (18.25 in.) with an overall height of 110.49 cm (43.5 in.) including the cover and lid (Drawings M2E801580A004 and M2E801580A001, Appendix 1.3.7). The outside diameter of the drum (including the hoops) is 49.2 cm (19.37 in.). The drum and lid are made from 16-gauge [~0.152-cm (0.0598-in.)-thick] Type 304 or 304L stainless steel. A 12-gauge [~0.267-cm (0.105-in.)-thick] stainless-steel arched cover (Drawing M2E801580A005, Appendix 1.3.7) is welded to the double open-head drum to create the bottom of the drum assembly. An inner liner (Drawing M2E801580A003, Appendix 1.3.7) is attached to the drum by an internal flange (angle) that is welded to both the drum and liner. The cavity created by the inner liner for placement of a containment vessel (CV) is a three-tier volume. The uppermost tier accommodates the top plug and has an inside diameter of 37.52 cm (14.77 in.) and is 13.26-cm (5.22-in.) deep (Drawing M2E801580A003, Appendix 1.3.7). The second tier, which accommodates the CV flange, has a 21.84-cm (8.60-in.) inside diameter that is 5.59-cm (2.20-in.) deep (Drawing M2E801580A003, Appendix 1.3.7). The third tier, which accommodates the CV body, has a 15.85-cm (6.24-in.) inside diameter that is 78.31-cm (30.83-in.) deep (Drawing M2E801580A003, Appendix 1.3.7). An additional cavity is created between the second and third tier liners. This cavity runs the full length of the third tier height [78.31 cm (30.83 in.)] and is ~3.00-cm (1.18-in.) thick (Drawing M2E801580A003, Appendix 1.3.7). This cavity is filled with a castable refractory (277-4 special dry mix) for neutron attenuation purposes. Aluminum foil tape is applied over the 277-4 cavity fill and vent holes (four places) located on the drum liner lower shelf (Drawing M2E801580A002, Appendix 1.3.7). The additional cavities between the liner and the drum are filled with an inorganic castable refractory material (Kaolite 1600 or Packcrete), which acts as both an impact-absorbing and thermal-insulating material.

In accordance with NUREG/CR-3854, Part 4.2 for a Category I shipping package, an acceptable specification for drums used in any of the component safety groups is DOT Specification 17C or better. It should be noted that the Specification 17C package is no longer included in the DOT regulations (49 CFR 178). The drum used in the ES-3100 is fabricated in accordance with the dimensional requirements of Military Standard MS27683 and modified as shown on Drawing M2E801580A004 (Appendix 1.3.7). The fabrication requirements for the ES-3100 drum assembly are shown in SPC JS YMN3-801580-A002 (Appendix 1.3.2). Material, fabrication, and quality control criteria are

generally equivalent to those imposed for a DOT Specification 17C drum. Furthermore, the drum of the ES-3100 is part of a performance-based package that has been tested and analyzed to demonstrate its ability to maintain confinement and containment of its contents under both NCT and HAC. By certifying that the outer shell of the drum assembly used in production meets the same specifications as those tested and analyzed, as described in subsequent chapters of this SARP, the outer drum shell used for the ES 3100 is acceptable for a Category 1 shipping package.

As previously discussed, the drum has been modified by the attachment of an inner liner connected to the drum by an internal flange welded to both the drum and the liner. Weld studs are attached to the upper face of the internal flange. The body seams are welded. The following items are conducted in accordance with Sect. IX of the *American Society of Mechanical Engineers (ASME) Boiler and Pressure Vessel Code* (ASME Code, Sect. IX): welding procedures qualification and welders certification to these qualified procedures.

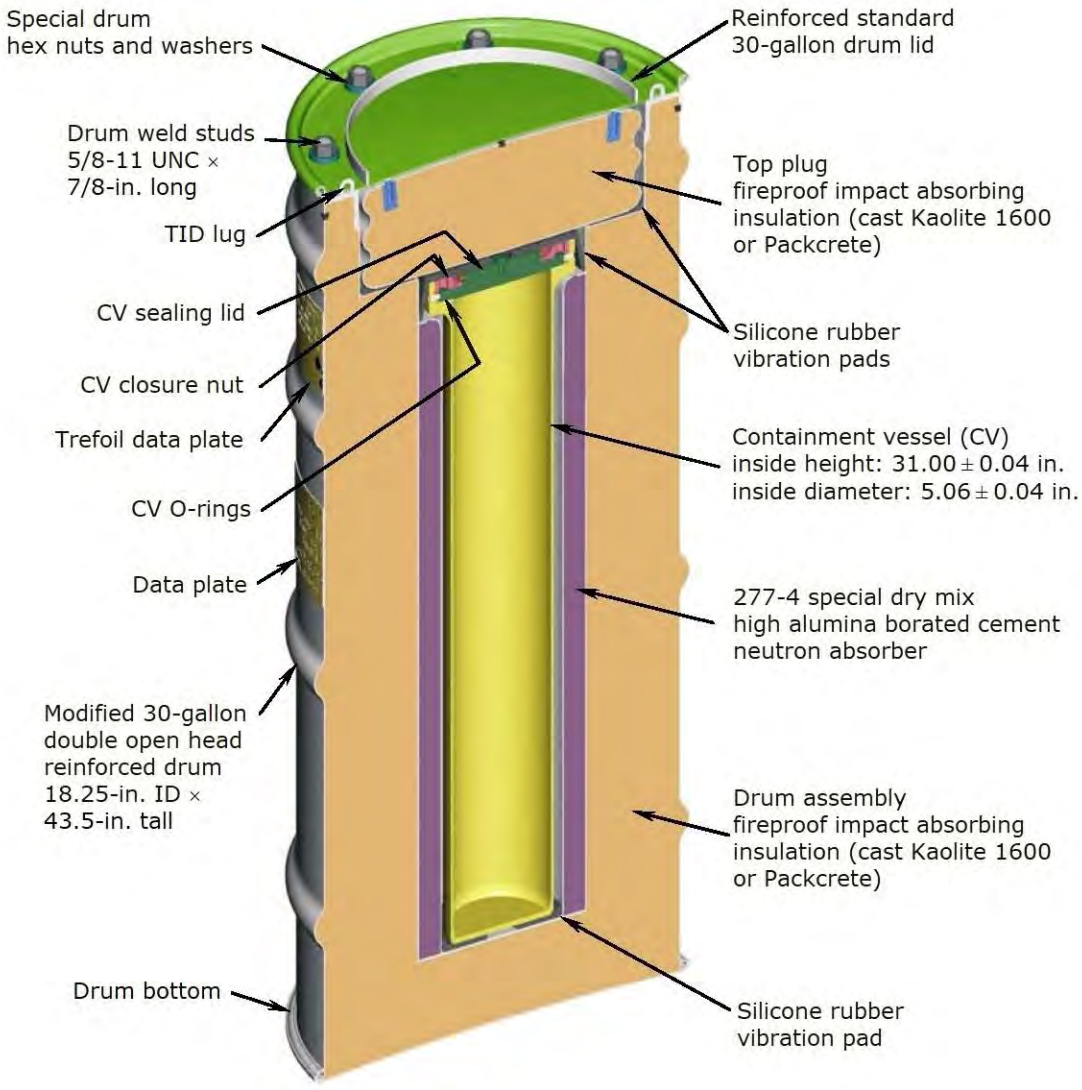


Fig. 1.1. Schematic of the ES-3100 shipping package.

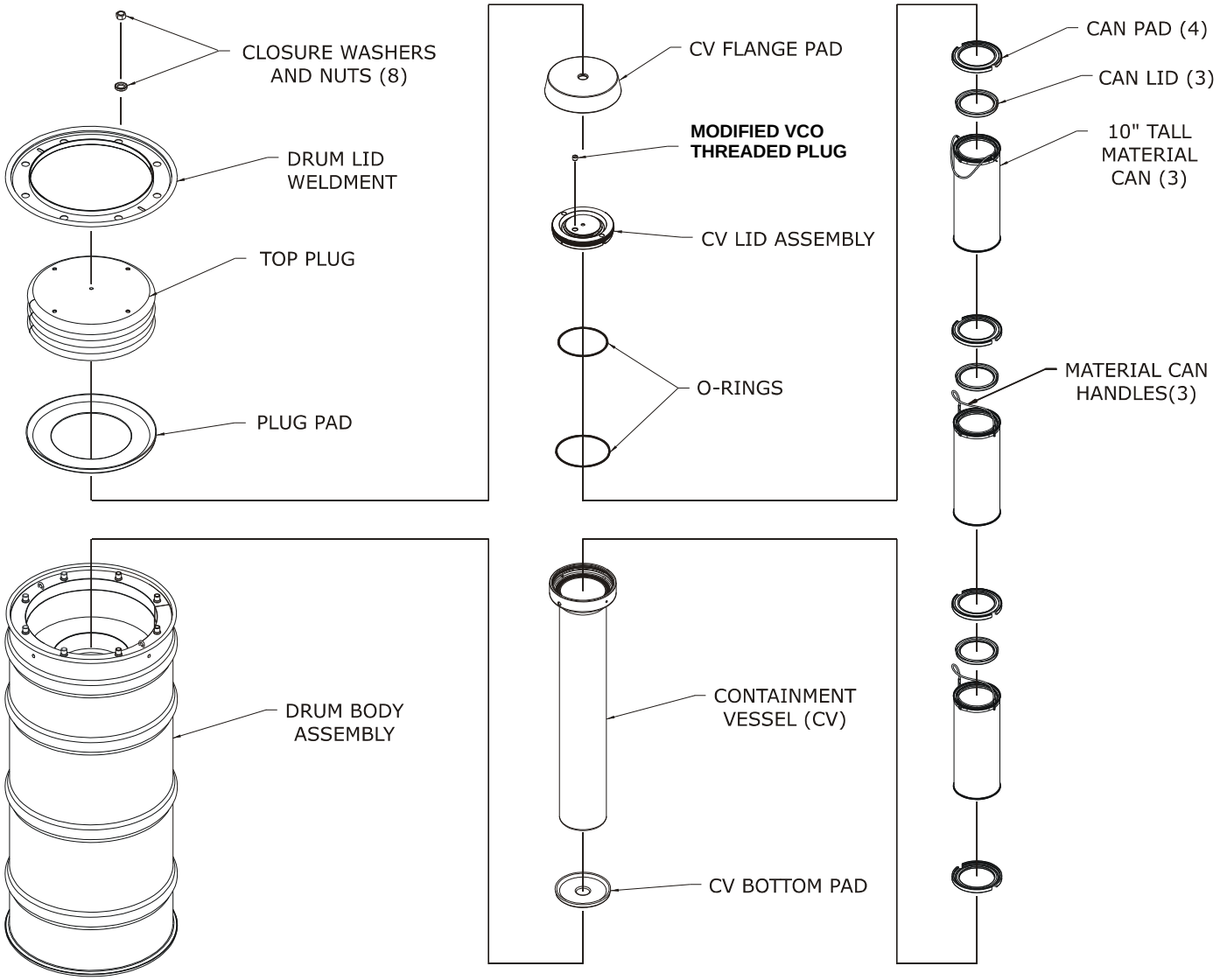


Fig. 1.2. Exploded view of the ES-3100 package with bulk HEU contents.

The drum has four circumferential hoops formed into the body. The drum has four 0.795-cm (0.313-in.)-diam holes equally spaced around the circumference ~3.81 cm (1.50 in.) from the top rim to relieve pressure in the drum in the event of a thermal accident (Drawing M2E801580A002, Appendix 1.3.7). Plastic plugs (Nylon 6/6, Micro Plastic, Inc., Item Number 62MP0312) are placed into these holes from the outside to prevent leakage of water into the drum during NCT and storage. The drum is fabricated with a data plate, trefoil data plate, paint, and two lid TID lugs for use with tamper-indicating devices (TIDs). The two electrochemically etched data plates are affixed to the exterior of the drum body in the locations, and with the methods, indicated on Drawing M2E801580A031 (Appendix 1.3.7). The trefoil data plate (M2E8015803A010-1) provides the owner's return address, container model, container serial number, and the trefoil symbol. The other data plate (M2E801580A010-2) provides the required DOT markings—certificate number, maximum gross weight, and "Type B" designation.

The removable lid is attached to the drum body by a flange with eight silicon bronze, 5/8-11 UNC-2B hex-head nuts [C65100, American Society for Testing and Materials (ASTM) F 467] with stainless-steel washers. These nuts are tightened onto the weld studs (Type 304 or 304L stainless steel, 5/8-11 UNC-2A, ASTM A 493 or F 593) to 40.67 ± 6.78 N·m (30 ± 5 ft-lb) of torque with no sequence specified. A radio-frequency identification (RFID) system may be attached to the ES-3100 package if desired. If an RFID is attached to the package using the drum stud and nut assembly, the normal thread engagement of the external nut shall not be reduced when compared to adjacent stud and nut attachments.

The top plug is 36.5 cm (14.37 in.) in diameter and 13.41 cm (5.28 in.) in height at the center. The skin is made from 16 gauge [~0.152-cm (0.0598-in.)-thick] Type 304 or 304L stainless steel and is filled with Kaolite 1600 or Packcrete.

The drum assembly also contains three silicone rubber pads. The first pad (CV bottom pad) is placed on the bottom of the innermost liner to support the CV bottom during transport. The second pad (CV flange pad) is placed on top of the CV lid during transport. The third pad (plug pad) is placed on the top shelf of the mid-liner to cushion the top plug during transport. The locations of these three pads are shown on Drawing M2E801580A001 (Appendix 1.3.7), and the dimensions of the pads are shown on Drawing M2E801580A009 (Appendix 1.3.7).

The ES-3100 is handled using industry-standard drum handling equipment. When using a forklift, it can be placed on the tines of the forklift from below, or it is designed for a forklift pincher assembly that can be used to grasp the exterior of the drum assembly. Based on analytical results for a similar package (the Model ES-2100), forklift gripping forces of up to 5400 lb can be used with no detrimental effects on the package (DAC-EA-801376-A003).

No tie-down devices are integral to the package, nor can any features be used for these purposes. The ES-3100 package is designed to be shipped using blocking, bracing, and tie-down equipment that meets industry-standard practices to prevent shifting in the conveyance during NCT.

1.2.1.2 Insulation

The void area formed by the drum and the attached inner liner is filled with an inorganic castable refractory material [Kaolite 1600 (made by Thermal Ceramics, Inc.) or Packcrete], which acts as both a thermal insulating and an impact limiting material. The top plug assembly, which is placed between the CV and the drum lid, is also filled with Kaolite 1600 or Packcrete. These materials (Kaolite and Packcrete) are a mixture of cement and vermiculite and have a nominal cured density of ~358.8 kg/m^3 (22.4 lb/ft^3). Additional information regarding the characteristics and properties of Kaolite material is presented in several supporting documents (Kaolite product data sheet, Kaolite material safety data sheet, Y/DW-1661, ORNL-TM-2003/49, Y/DW-1890, Y/DW-1972, Y/LF-565, Moody 2004) and

material properties for Packcrete are specified in RP 802282-0002. Casting takes place while the drum is being vibrated in an inverted orientation to ensure that the castable material penetrates into all areas in the void space formed by the drum and the inner liner and that no considerable voids are formed during this process. The Kaolite or Packcrete material is then baked in a furnace at elevated temperatures [~260°C (500°F)]. The processing of Kaolite 1600 for the ES-3100 is controlled by Equipment Specification JS-YMN3-801580-A003, *Manufacturing Process Specification for Casting Kaolite 1600 into the ES-3100 Shipping Package*, (Appendix 1.3.4), and the processing of Packcrete is controlled by SPC M801794-0003, *Packcrete Preliminary Lot Qualification* (Appendix 1.3.11) and SPC M801580-0003, *ES-3100 Packcrete Final Lot Qualification and Production Processing* (Appendix 1.3.12).

One of the ES-3100 design goals was to build a shipping package entirely of materials that do not char, burn, or thermally decompose when exposed to the temperatures and conditions associated with HAC [800°C (1475°F)]. The Kaolite or Packcrete material is nonflammable and will not undergo chemical decomposition at temperatures below 1260°C (2300°F). When Kaolite or Packcrete is heated to >100°C (212°F), water vapor from free water contained within the casting will form. Pressurization of the drum and top plug is prevented by pressure-relief holes (vent holes) located near the top of the drum and on the top center of the top plug (Sect. 1.2.1.1 and Drawings M2E801580A002 and M2E801580A008, Appendix 1.3.7). The cured Kaolite 1600 or Packcrete material does not decompose, and thus there are no exothermic chemical reactions that could produce superheated offgasses.

Extensive testing of Kaolite 1600 was performed by the Y-12 Development Division to determine the performance of the material for this type of application (Y/DW-1661). Testing showed that Kaolite 1600 has a tremendous ability to absorb shock over a wide range of material densities, curing temperatures and times, and material temperatures. The 10 CFR 71.73 HAC testing documented in Sect. 2.7 demonstrates that Kaolite 1600 is a robust impact limiter and good thermal insulating material for Type B shipping containers. Post HAC drop testing radiographs of a similar package, the ES-2100, showed some minor cracking of the Kaolite structure in some cases. However, subsequent thermal testing of these ES-2100 packages demonstrated that these cracks were inconsequential to the ability of the package to meet regulatory requirements.

Insulation thicknesses within the liner/drum volume adjacent to the side walls of the ES-3100 CV are at least 4.27 cm (1.68 in.), with typical thicknesses of ~12.10 cm (4.77 in.). Below the CV, the minimum thickness of insulation is 10.05 cm (3.96 in.), and the top plug, which is above the CV, includes a 12.55-cm (4.94-in.) thickness of insulation.

1.2.1.3 Shielding

The ES-3100 packaging does not require dedicated shielding materials of specific design to control external radiation levels for the bulk HEU contents. However, the intervening packaging materials of construction (stainless steel of the drum and CV, the Kaolite or Packcrete material, and the 277-4 material) provide some attenuation of the relatively low levels of penetrating radiation emitted by the contents. The amount of shielding modeled for the NCT analysis is represented by the thickness and density of the materials reported in Sects. 1.2.1.1, 1.2.1.2, and 1.2.1.5 and the packaging dimensions (Appendix 1.3.7). HAC physical testing showed that the CV and insulation remain confined within the drum assembly. However, the HAC shielding evaluation conservatively assumes that only the CV remains for shielding purposes (i.e., no shielding credit is taken for the drum and insulation in the HAC analysis).

1.2.1.4 Nuclear criticality safety

The packaging materials of construction in the ES-3100 provide neutron absorption (stainless steel and 277-4) and reflection (stainless steel and insulation). The 277-4 (or Cat 277-4 as it is sometimes referred) material is a noncombustible cast neutron-absorbing material. This material is cast into the innermost liner of the package adjacent to the CV as shown in Fig. 1.1. The material is a high alumina borated concrete composed of aluminum, magnesium, calcium, boron, carbon, silicon, sulfur, sodium, iron, and water. The 277-4 material was manufactured specifically for the ES-3100 package by adding boron carbide to a standard material (Cat No. 277-0) and increasing the boron content from 1.56 wt % to 4.23 wt %. Additional information on the neutron-absorbing characteristics of this material is presented in Appendix 6.9.3. Properties of the 277-4 material are presented in Table 2.17 and several supporting documents (ORNL/TM-2004/290, Y/DW-1987, Y/DZ-2585, COR-NDA-04-93, Y/DV-1914). The cast material has a nominal density of 1681.9 kg/m^3 (105 lb/ft^3). The procedure for mixing this material and casting into the ES-3100 shipping package is documented in SPC JS-YMN3-801580-A005, *Casting Catalog No. 277-4 Neutron Absorber for the ES-3100 Shipping Package* (Appendix 1.3.5). The procedure for mixing and casting 277-4 material into the can spacers is documented in SPC M801580-0004, *ES-3100 Heavy Can Spacer Assemblies* (Appendix 1.3.10).

Although shown by tests up to HAC as not being credible, the criticality analysis considers water leakage into the CV in accordance with 10 CFR 71.55(b). Depending on the content being shipped and the shipping configuration being used, criticality safety index (CSI) values for the ES-3100 package may range from 0 to 3.2 (Sect. 1.2.2).

1.2.1.5 Containment system

A single CV is used in the ES-3100 shipping package for the transport of bulk HEU contents. The ES-3100 containment boundary (consisting of the CV body, lid assembly, and inner O-ring) is shown in Fig. 1.3.

During fabrication, all ES-3100 containment vessels will be inspected and tested to the requirements specified on the design drawings (Appendix 1.3.7) and equipment specification (Appendix 1.3.3). Certification documents received from the vendor with each component acknowledge the use of these drawings and the specification. These certifications are on file with the Y-12 Quality Organization.

The containment boundary of the ES-3100 package is a pressure vessel that is designed, fabricated, examined, and tested in accordance with the ASME Code, Sect. III, Div. 1, Subsection NB. The ES-3100 CV body is constructed of Type 304L stainless steel and may be fabricated by one of two methods. The first method uses a standard 5-in., schedule 40 stainless-steel pipe (ASME SA-312, Type TP304L), a machined flat-head bottom forging (ASME SA-182, Type F304L), and a machined top flange forging (ASME SA-182, Type F304L). Each of these pieces is joined with circumferential welds as shown on Drawing M2E801580A012 (Appendix 1.3.7). The top flange is machined to provide two concentric half-dove-tailed O-ring grooves in the flat face, to provide locations for two 18-8 stainless-steel dowel pins, and to provide the threaded portion for closure using the lid assembly. The second fabrication method for the ES-3100 CV uses flow forming to create the complete body (flat bottom, cylindrical body, and flange) from a single forged billet or bar with final material properties in accordance with ASME SA-182, Type F304L. The top flange area using this fabrication technique is machined identically to that of the welded forging method.

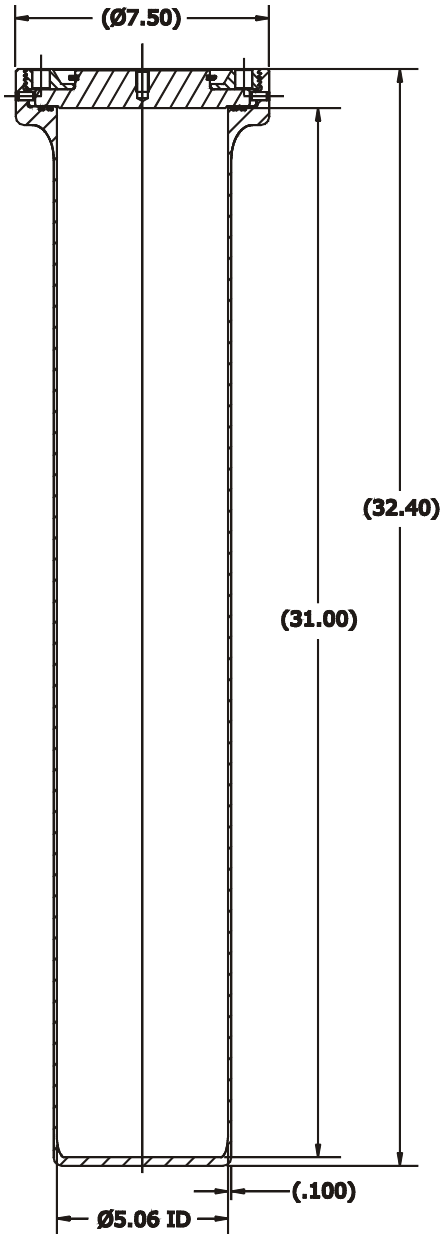


Fig. 1.3. Containment boundary of the ES-3100 shipping package.

The lid assembly, which completes the containment boundary structure, consists of a sealing lid, closure nut, and external retaining ring (Drawing M2E801580A014, Appendix 1.3.7). The CV sealing lid (Drawing M2E801580A015, Appendix 1.3.7) is machined from Type 304 stainless-steel bar with final material properties in accordance with ASME SA-479. The CV closure nut is machined from a Nitronic 60 stainless-steel bar with material properties in accordance with ASME SA-479. These two components are held together using a WSM-400-S02 external retaining ring made from Type 302 stainless steel. The sealing lid is further machined to accept a ⅜-16 swivel hoist ring bolt, to provide a leak-test port between the elastomeric O-rings, and notched along the perimeter to engage two dowel pins. The swivel hoist ring is only intended for use when loading and unloading the CV. The swivel hoist ring will be removed for shipment. The lid assembly and CV body (with O-rings in place) are joined together by torquing the closure nut to 162.70 ± 6.78 N·m (120 ± 5 ft-lb). The sealing lid portion

of the assembly is restrained from rotating during this torquing operation by the two dowel pins installed in the body flange.

The use of a design that includes two O-ring seals permits assembly verification leak testing of the CV by measuring the leak rate from the volume between the inner and outer O-rings. A leak-test port is located between the O-rings in the CV to facilitate a pressure rise or drop leakage test following assembly or 10 CFR 71 compliance testing. This port is sealed during transport using a modified VCO threaded plug. Only the inner O-ring is considered a part of the containment boundary. The O-rings on this CV are ethylene propylene diene monomer (EPDM) fabricated to ASTM D 2000, M3BA712A14B13F17. The equipment specification for the EPDM O-rings is presented in Appendix 1.3.9.

The inner diameter of the CV is 12.852 cm (5.06 in.) and the usable height inside the CV is 78.74 cm (31.0 in.). The wall thickness of the body excluding the flange is 0.254 cm (0.10 in.). The maximum nominal diameter of the CV body is 19.05 cm (7.50 in.). The nominal thickness of the CV flat bottom is 0.635 cm (0.25 in.). The overall height of the CV without the swivel hoist ring is 82.296 cm (32.40 in.). The CV drawing number, drawing revision, and serial number are electroetched onto the side of the CV body, as well as onto the top of the sealing lid and the closure nut (Drawing M2E801580A011, Appendix 1.3.7). No penetrations, connections, or fittings into this sealed container exist.

1.2.2 Contents

The ES-3100 shipping package will be used to ship bulk HEU in the form of oxide [UO_2, UO_3, U_3O_8, U_3O_8-Al, UO_2-Mg, and product oxides (UO_2, UO_3, U_3O_8) mixed with ThO_2, ZrO_2, and Th metal], uranium metal and alloy in the form of solid geometric shapes or broken pieces, uranium compounds, uranyl nitrate crystals (UNX), fuel elements from TRIGA reactors, and research reactor fuel elements or fuel components. Actual loading limits are determined in subsequent chapters of the SARP. The maximum weight of all contents (including convenience cans or bottles, can spacers, bagging and other packing materials) shall not exceed 40.82 kg (90 lb). The maximum concentration of uranium isotopes permitted in the ES-3100 content are listed in Table 1.1. In addition to the uranium isotopes shown in Table 1.1, transuranic isotopes (with the exception of ^{237}Np) may be present in the HEU metal and alloy contents transported by ground at a maximum concentration of 800.0 µg/gU and at a maximum concentration of 40.0 µg/gU in all other contents. Contents to be transported by air are limited to a maximum transuranic concentration of 40.0 µg/gU, and the transportation of plutonium by air (due to the transuranic concentration allowance) shall be in accordance with the requirements in 10 CFR 71.88, which includes restrictions for no more than an A_2 quantity of plutonium in any isotope or form. The concentration of ^{237}Np is limited to 0.0250 g/gU. Unless otherwise specified, the contents described in this section pertain to ground transport only. A discussion of contents of air-transport is included in Sect. 1.2.2.1.

Table 1.1. Uranium concentration limits

Uranium isotope	Limit
^{232}U	0.040 µg/gU
^{233}U	0.006 g/gU
^{234}U	0.02 g/gU
^{235}U	1.00 g/gU
^{236}U	0.40 g/gU
^{238}U	1.00 g/gU

HEU Metal and Alloy

HEU metal and alloy (alloys of uranium with aluminum, molybdenum, thorium, zirconium, stainless steel, titanium, tungsten, niobium, silicon, or vanadium) may be in the form of solid geometric shapes. Solid shapes may include the following:

1. cylinders having a diameter no larger than 4.25 in. (maximum of one cylinder per convenience can);
2. square bars having a cross section no larger than 2.29 in. × 2.29 in. (maximum of one bar per convenience can); and
3. slugs having dimensions of 1.5-in. diam × 2-in. tall (maximum of 10 per convenience can).

HEU bulk metal and alloy contents not covered by the geometric shapes category specified above will be in the broken metal category, and will be so limited.

Alloys of uranium may include aluminum, molybdenum, thorium, zirconium, stainless steel, titanium, tungsten, niobium, silicon, or vanadium. Uranium-aluminum alloys are typically 70 to 95% aluminum. Uranium-molybdenum alloys are typically 1 to 12% molybdenum. Uranium/molybdenum alloys may be plated with, clad with, or contain traces of aluminum, gold, stainless steel, nickel and/or chromium. Other uranium alloys may contain up to 50% of the non-uranium constituents.

HEU bulk metal and alloy contents in the broken metal category may be of unspecified geometric form. HEU bulk metal and alloy in this category may also be of a specific shape where one or more of the characteristic dimensions vary from piece to piece (i.e., the height, width, length, radius).

For pyrophoric considerations, HEU metal and alloy must meet the following restrictions (Appendix 1.3.8):

1. Uranium metal and alloy (broken) pieces must have a surface-area-to-mass ratio of not greater than 1 cm^2/g or must not pass through a 3/8-in. (9.5-mm) mesh sieve (or equivalent size-grading method).
2. Particles and small shapes which do not pass the size restriction tests in #1, and powders, foils, turnings, and wires, are not permitted unless they are in a sealed, inerted container. Material meeting this criteria will be in the HEU metal or alloy turnings, fines, or powder category, and will be so limited.

Note: A "sealed, inerted container" is a container with an inert atmosphere that is leaktight as defined in ANSI N14.5-1997.

HEU in the form of oxide with residual metallic particles is referred to as clinkers and screenings. This material results from metal casting operations where uranium metal is melted in a graphite crucible. After the metal is poured into casting molds, the crucibles are cleaned of residual material. The residual are bits of scrap metal and oxide debris. This residual material is passed through a sieve, where finer oxide passes through the sieve and is considered to be skull oxide. The material that does not pass through the sieve is considered to be clinkers and screenings. This material is predominantly oxide but often will have small particles of metal. Clinkers and screenings from metal casting operations will be loaded in accordance with the HEU metal or alloy turnings, fines, and powders mass loading limits in a sealed container under an inert cover gas. Clinkers and screenings shipments must be completed within 12 months after sealing the CV.

Metal and alloy may be shipped in tin-plated carbon-steel, stainless-steel, aluminum, or nickel-alloy convenience cans; Teflon convenience bottles; or Teflon bottles inside metal convenience cans. Solid form HEU contents (i.e., spheres, cylinders, bars, slugs) that will not fit in a convenience can may be bagged with no convenience can required around the content. The HEU metal and alloy

content may be wrapped or bagged, and the convenience cans may also be wrapped to further reduce the possibility of radioactive contamination of the packaging.

HEU Oxide

The HEU oxide content in the ES-3100 package includes UO_2, UO_3, U_3O_8, U_3O_8-Al, UO_2-Mg, and product oxides (UO_2, UO_3, U_3O_8) mixed with ThO_2, ZrO_2 and Th metal. Maximum overall uranium isotopic concentrations are presented in Table 1.2. The physical form of all contents is dense, loose powder (which may contain clumps) or pellets. Moisture content in oxide is limited to 3 wt % water (Sect. 1.2.2.8, *Loading restrictions*, Item 8 also applies). Theoretical densities of UO_2, U_3O_8, and UO_3 are 10.96, 8.30, and 7.29 g/cm^3, respectively. Allowable oxide bulk densities are 0.5 to 6.54 g/cm^3. Oxide may be shipped in tin-plated carbon-steel, stainless-steel, or nickel-alloy convenience cans; polyethylene or Teflon convenience bottles; or glass (UO_2-Mg oxide only), polyethylene, or Teflon bottles inside metal convenience cans.

Table 1.2. Bounding uranium isotopic concentrations in oxide

Isotope	Bounding limit
^{232}U	40 ppb
^{233}U	0.6 wt %
^{234}U	2.0 wt %
^{235}U	100.0 wt %
^{236}U	40.0 wt %

Uranium oxide shipments must be completed within 12 months after sealing the CV in order to prevent the buildup of hydrogen gas beyond 5 mol %. The time period begins when the CV is sealed. Hydrogen generation calculations are provided in Appendix 3.5.4.

Research Reactor Fuel Elements and Components

Research reactor fuel elements or fuel components composed of clad U-Zr, U-Al, U_3O_8-Al, UO_2, oxides of U-Zr, UO_2-Mg, or U_3Si_2-Al will be shipped in the ES-3100 package. The fuel elements consist of multiple fuel components in the form of plates, rods, and tubes clad in aluminum, stainless steel, or zircalloy and held together as a single unit by other inert structural components. The fuel components are individual plates, rods, or tubes removed from fuel elements. The uranium in these fuel elements and components is enriched to 10 to 93.5 wt % ^{235}U.

The U-Al fuel in the research reactor fuel elements and components is an alloy of uranium and aluminum (U-Al) or in the form of $UA1_x$-Al (alloy in an aluminum matrix). The U-A1 fuel contains ~8 to 30 wt % uranium. The U_3O_8-Al fuel is in the form of a U_3O_8 compound contained in an aluminum metal matrix. The U_3O_8-Al contains ~8 to 40 wt % U_3O_8. The UO_2 fuel is a ceramic compound. The UO_2-Mg fuel is a ceramic UO_2 compound contained in a magnesium metal matrix. The UO_2-Mg fuel contains ~88 wt % UO_2.

The research reactor fuel elements and components will be bundled together and placed inside a modified convenience can [a 17.5-in.–tall can (two 8.75-in.–tall cans brazed together) or a 30-in.–tall can (three 10-in.–tall cans brazed together)] or protected on each end with an open-ended convenience can constructed of stainless steel, tin-plated carbon steel, or nickel alloy (see Fig. 1.4).

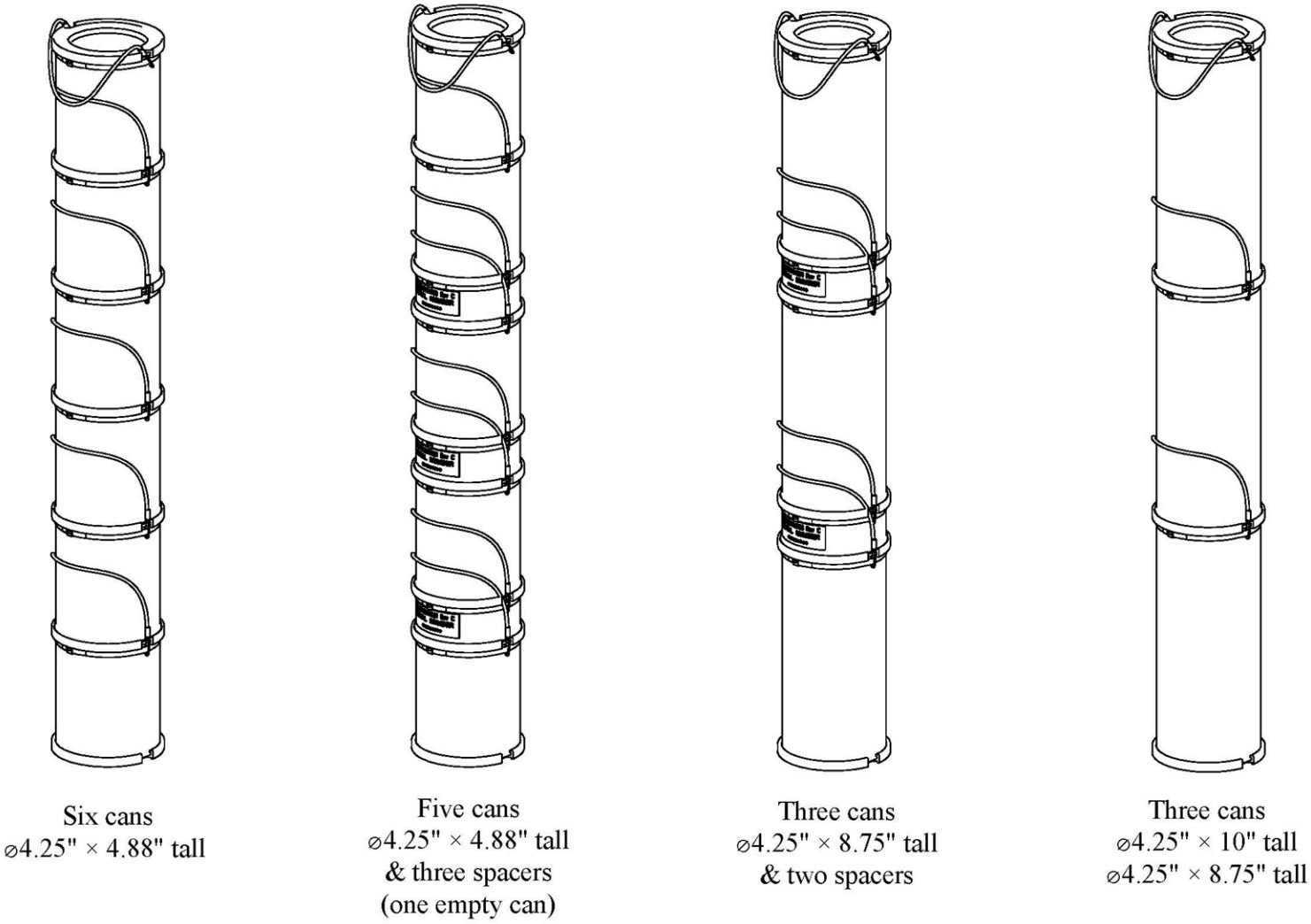


Fig. 1.4. Typical shipping configurations inside the ES-3100 containment vessel.

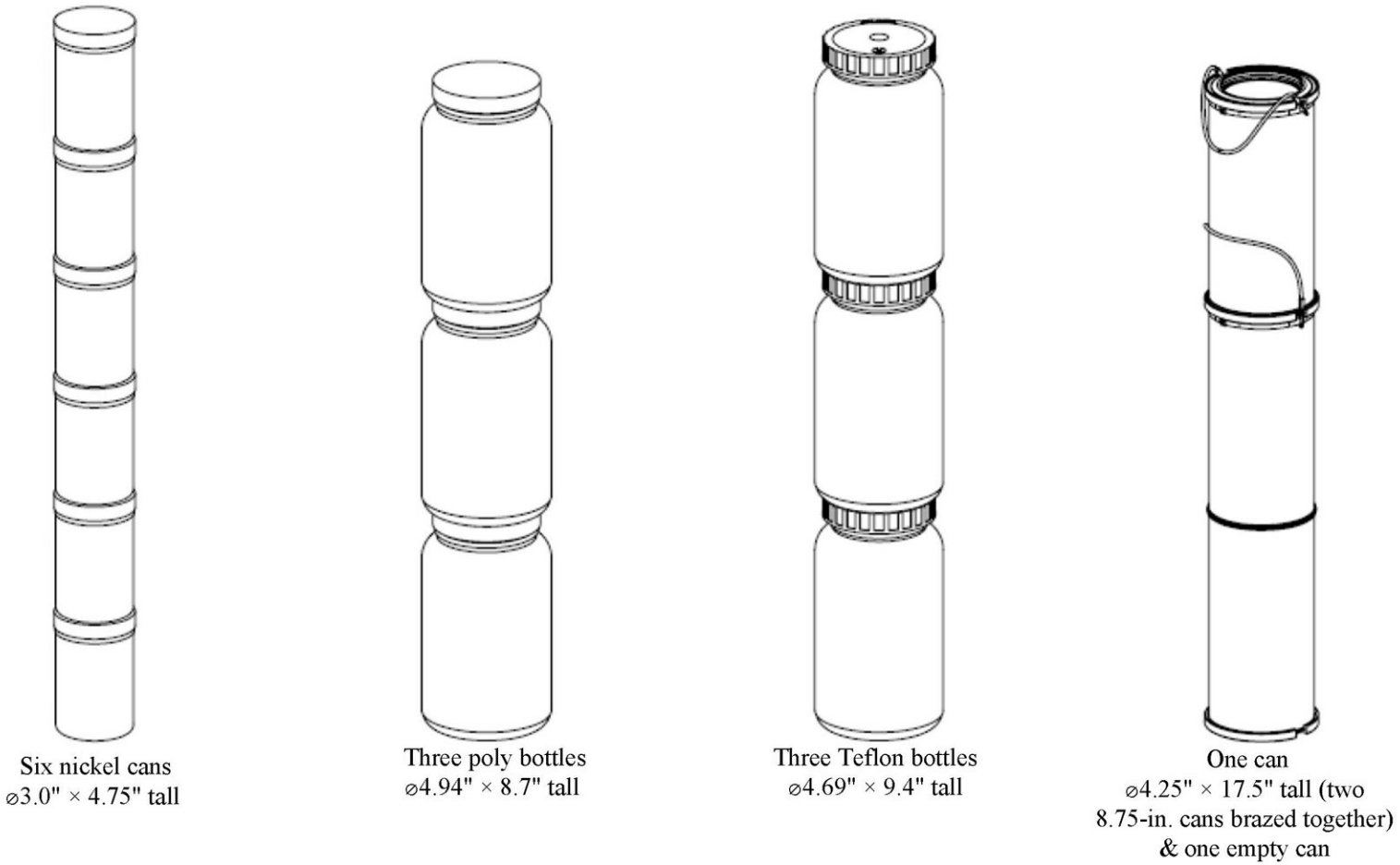
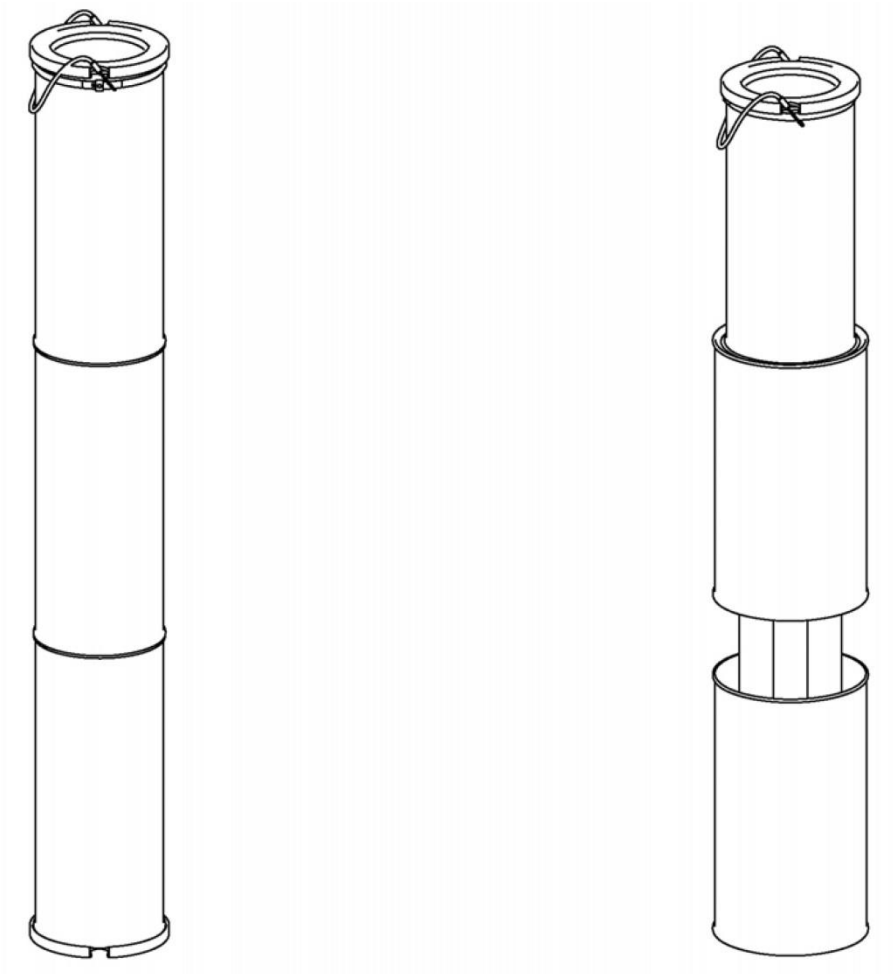


Fig. 1.4. Typical shipping configurations inside the ES-3100 containment vessel (cont.).



One can
⌀4.25" × 30" tall
(three 10-in. cans brazed together)

Two cans open ended
⌀≤5" × ≤10" tall
(one empty can or stainless steel scrubbers on top)

Fig. 1.4. Typical shipping configurations inside the ES-3100 containment vessel (cont.).

Intact TRIGA reactor elements and fuel pellets will also be shipped in the ES-3100. The fuel shall be unirradiated. The TRIGA fuel shall be in the form of uranium zirconium hydride ($UZrH_x$), where $x \leq 1.6$. Fuel from three types of TRIGA fuel elements are allowed: TRIGA Standard Fuel Elements, Instrumented TRIGA Standard Fuel Elements, and TRIGA Fuel Follower Control Rods. These fuel elements have three fuel pellets (or sections) per element. The TRIGA Standard Fuel Elements and Instrumented TRIGA Standard Fuel Elements have fissile loadings of 45.33-g ^{235}U per pellet (136-g ^{235}U per element) and the dimensions are 5 in. in length and 1.44 in. in diameter. The TRIGA Fuel Follower Control Rods have a fissile loading of 37.66-g ^{235}U per pellet (113-g ^{235}U per element) and the dimensions are 5 in. in length and 1.31 in. in diameter.

TRIGA fuel may be shipped as crimped fuel elements or as $UZrH_x$ fuel pellets (if disassembled), both of which shall be packed into convenience cans prior to shipment. Convenience cans of 4.25-in. diam by various lengths shall be used. Fuel pellets loaded into convenience cans shall be up to 5 in. in length (full-length) and no more than three full-length pellets shall be loaded into a convenience can. Crimped fuel rods are clad fuel pellets and can be up to 15 in. in length (full length of the fuel section from one fuel element). Cladding material is stainless steel or aluminum. Only the fuel section of the TRIGA fuel element is allowed to be shipped; however, there may be residual cladding up to ½ in. in length at either end of the crimped fuel rod. Up to three 15-in.-long crimped fuel elements shall be loaded into a single convenience can for shipping. Maximum loading of bare fuel pellets and crimped fuel elements shall be 3 fuel element equivalence per ES-3100 CV. TRIGA fuel with enrichments up to 70% has been evaluated. For TRIGA Standard Fuel Elements and Instrumented TRIGA Standard Fuel Elements, the maximum allowable loading is 408-g ^{235}U per package, and for TRIGA Fuel Follower Control Rods, the maximum allowable loading is 339-g ^{235}U per package. No spacer cans are required.

Fuel elements or pins from the Systems for Nuclear Auxiliary Power (SNAP) reactor will also be shipped in the ES-3100 package. The SNAP reactor fuel pins are composed of $UZrH_x$ ($x \leq 2$) with Hastelloy N cladding. The fuel pins are ~1.25 in. in diameter and ~12.45 in. long. The SNAP reactor fuel pins are enriched to 93 wt % ^{235}U. The SNAP reactor fuel pins will be packed in appropriate length convenience cans or bundled together and protected on each end with an open-ended can. Up to three fuel elements may be packed into any one convenience can or any one bundle. Up to two loaded convenience cans or two bundles may be shipped in the ES-3100.

Uranium Compounds

Several compounds of uranium, including uranium tetrafluoride, uranyl fluoride, uranium carbide, uranium nitride, and uranium silicide, will be shipped in the ES-3100 package. The physical form of these uranium compounds is solid crystalline, granular, or powder. The uranium compounds contain no moisture.

Uranium tetrafluoride (UF_4), often called green-salt because of its characteristic color, is generally an intermediate in the conversion of UF_6 to either uranium oxide (U_3O_8 or UO_2) or uranium metal. UF_4 is a solid composed of agglomerating particles with a texture similar to baking soda. It is non-volatile and non-hygroscopic, but only slightly soluble in water. After exposure to water, UF_4 slowly dissolves and undergoes hydrolysis, forming several possible uranium compounds and hydrogen fluoride (HF). The density of solid UF_4 is 6.7 g/cm^3.

Uranyl fluoride (UO_2F_2) is an intermediate in the conversion of uranium hexafluoride (UF_6) to a uranium oxide or metal form and is a direct product of the reaction of UF_6 with moisture in the air. It is very soluble in water. Uranyl fluoride is hygroscopic and changes in color from brilliant orange to yellow after reacting with water. Uranyl fluoride is reported to be stable in air to 300°C, above which slow decomposition to U_3O_8 occurs. When heated to decomposition, UO_2F_2 emits toxic fluoride fumes. The density of UO_2F_2 is 6.37 g/cm^3.

Uranium carbide is a hard refractive ceramic material. It comes in several stoichiometries such as uranium monocarbide (UC), uranium sesquicarbide (U_2C_3), and uranium dicarbide (UC_2). Like uranium dioxide and some other uranium compounds, uranium carbide can be used as a nuclear fuel for nuclear reactors, usually in the form of pellets or tablets. Uranium carbide is a dull, dark charcoal-gray or flat black colored powder. The densities of UC, U_2C_3, and UC_2 are 13.63, 12.7, and 11.3 g/cm^3, respectively. Loadings for U_2C_3 and UC_2 fall under the general category of UC.

Uranium nitride (UN) and uranium sesquinitride (U_2N_3) are ceramic compounds used as nuclear fuel in nuclear test reactors whose properties are similar to uranium dioxide or uranium carbide. They can be synthesized by the reaction of nitrogen with uranium at 700 K. Uranium nitride is also formed as a product of uranium combustion in air. The densities of solid UN and U_2N_3 are 14.32 and 11.24 g/cm^3, respectively. Loadings for U_2N_3 fall under the general category of UN.

Uranium-silicon compounds (U_3Si_2 and U_3Si) are produced by melting together uranium metal and high purity silicon. The silicon content of U_3Si_2 is ~7.5 wt % and of U_3Si is ~3.9 wt %. Except for minor impurities, the balance of the uranium silicide (U_3Si_2 and U_3Si) is uranium. The composition of the uranium in uranium silicide is as follows: ranging from 19.7 to 60 wt % ^{235}U, 0.5 maximum wt % ^{234}U, 1.0 maximum wt % ^{236}U, and the balance wt % ^{238}U. The bulk density range of uranium silicide powder is 5–7 g/cm^3. Uranium silicide particles may also be dispersed in aluminum (U_3Si_2-Al and U_3Si-Al).

Other uranium compounds consist primarily of finished tristructural-isotropic (TRISO) micro fuel particles; however, also included are pure/impure scrap materials generated during various stages of the manufacturing process. These materials have a ^{235}U assay ≤93.17% and are typically in a solid crystalline or granular form. A finished TRISO fuel particle consists of a kernel composed of UO_X (or sometimes UC or UCO) coated with four exterior layers of three isotropic materials. The four layers are a porous buffer layer made of carbon, followed by a dense inner layer of pyrolytic carbon (PyC), followed by a ceramic layer of SiC to retain fission products at elevated temperatures and to give the TRISO particle more structural integrity, followed by a dense outer layer of PyC.

Uranium compounds may be shipped in tin-plated carbon-steel, stainless-steel, or nickel-alloy convenience cans.

Uranyl Nitrate Crystals

Uranyl nitrate crystals are formed by dissolving uranium metal or any of the uranium oxides in nitric acid and the UNX crystalline precipitates are acquired through a variety of extraction, filtration, and purification processes. The UNX crystals are soluble in water, forming a weak solution of nitric acid. Uranyl nitrate hexahydrate (UNH) has a chemical formula of $UO_2(NO_3)_2 \cdot 6H_2O$. This most reactive form is used as the bounding composition for uranyl nitrate crystals in the criticality evaluation. Therefore, for UNX contents, X must be less than or equal to 6. The theoretical density of UNH crystals is 2.79 g/cm^3; however, the working densities will be less.

The user of the ES-3100 for UNX shipments will be required to use non-metallic containers only (Teflon bottles) as the convenience container.

Shipments of UNX crystals must be completed within the times shown in Table 1.3a in order to prevent the buildup of hydrogen gas beyond 5 mol %. The time period begins when the CV is sealed. Hydrogen generation calculations are provided in Appendix 3.5.4.

1.2.2.1 Radioactive/fissile constituents

For the ES-3100 package with bulk HEU content, the maximum number of A_2s is 4752.8 (at 70 years) and the maximum activity is 0.72554 TBq (at 10 years) [Table 4.4].

Ground Transport

Fissile material loading limits for ground transport of the various contents of the ES-3100, as determined by criticality analyses, structural analyses, or hydrogen gas generation evaluations, are presented in Tables 1.3 and 1.3a.

Air Transport

Contents for air transport of the ES-3100 package are HEU in the form of metal/alloy, research reactor fuel elements and components, and HEU oxide [UO_2, UO_3, U_3O_8, U_3O_8-Al, UO_2-Mg, and product oxides (UO_2, UO_3, U_3O_8) mixed with ThO_2, ZrO_2, and Th metal]. Fissile material mass loading limits for these contents, as determined by the criticality analyses, are presented in Table 1.3b for air transport.

1.2.2.2 Chemical and physical form

The fissile material contents are in solid (HEU metal or alloy, uranium compounds, or research reactor fuel elements and components), crystalline (UNX), or powder (HEU oxide) form. Some moisture (up to 3 wt %) may be present in the HEU oxide material, thereby making the oxide content clump together.

As presented for shipment, the UNX crystals exist as crystalline solids; however, the melting point for uranyl nitrate hexahydrate, trihydrate, and dihydrate is reported as ~60°C, 113°C, and 184°C, respectively (Marshall 1951). Heating of uranyl nitrate hexahydrate crystals up to 200°C results in a stepwise release of water molecules of crystallization (Dash 1999 and Kozlova 2007), which in a closed system results in the partial dissolution of the crystals. During transport of UNH crystals, crystalline solids and a saturated solution of uranyl nitrate will coexist at a temperature above ~60°C (MCW-1424). Given that the NCT maximum CV gas temperature with insolation is ~90°C (194°F) and the HAC maximum predicted gas temperature inside the CV at the location near the Teflon bottles is 167.78°C (334°F), the uranyl nitrate dihydrate and lower hydrates will remain in a solid phase during transportation. However, the trihydrate and higher hydrate crystals will release water molecules of crystallization upon heating above their melting point, thus converting them into a lower hydrate species, which require a successively higher temperature to release additional water molecules. The melting point for hexahydrate (~60°C) will be exceeded during NCT and HAC; and the melting point for trihydrate (~113°C) crystals will be exceeded during HAC. Upon cooling, the uranyl nitrate hydrate melt will recrystallize to a solid form.

1.2.2.3 Reflectors, absorbers, and moderators

The reflectors, absorbers, and moderators present in the ES-3100 package are those associated with the materials of construction. For example, the thermal insulation acts as a neutron reflector to the contents of a single package and as a neutron moderator in an array of packages. The degree of neutron moderation is a function of the hydrogen content in the Kaolite 1600 or Packcrete and 277-4 materials. The stainless-steel materials of the CV and the drum also act as neutron reflectors to the contents of a single package but act as neutron absorbers in an array of packages. The nuclear properties of the materials of construction and of the contents are important and have been taken into account in the criticality safety evaluation (Chap. 6). In addition to the materials of construction in the ES-3100 shipping package mentioned above, the 277-4 material has been specifically added to the ES-3100 package for the purpose of enhancing the neutron absorption characteristics for safety purposes (see Chap. 6 for additional discussion of the neutron-absorbing characteristics of this material).

1.2.2.4 Shipping configurations

Authorized content convenience containers for the ES-3100 are cans constructed of stainless steel, tin-plated carbon steel, aluminum, or nickel-alloy (Series 200, passivated), and polyethylene and Teflon convenience bottles. Modified convenience cans are constructed by brazing two 8.75-in.–tall cans together to create a 17.5-in.–tall can or by brazing three 10-in.–tall cans together to create a 30-in.–tall can. Research reactor fuel elements and fuel components may also be bundled together and protected on each end with open-ended convenience cans having an outer diameter ≤5 in. Solid form HEU contents (i.e., spheres, cylinders, bars, slugs) that will not fit in a convenience can may be bagged only with no convenience can required around the content. Enriched uranium oxide in the form of UO_2-Mg will be packed inside glass bottles, which are placed inside sealed, inerted metal convenience cans. These convenience containers are used to hold the HEU contents for shipment in the ES-3100 package and to assure that the inside of the CV does not become contaminated with HEU under NCT. Convenience containers used in the ES-3100 package must have an outer diameter less than or equal to 12.7 cm (5 in.). The height can vary up to the full internal height of the CV or 78.74 cm (31 in.). Some contents require the use of can spacers (see Table 1.3). These can spacers are thin-walled stainless-steel cans (Drawing M2E801580A043, Appendix 1.3.7) filled with 277-4 material (SPC M801580-0004, Appendix 1.3.10). Each convenience can and spacer may be equipped with a stainless-steel band and nylon-coated wire to facilitate loading and unloading operations. Silicone rubber pads may also be used between convenience cans to dampen vibration and minimize contact between metal components. Any combination of convenience containers will be allowed in a single package, as long as the total height of the stack-up (including spacers, if required) does not exceed the inside working height of the CV [78.74 cm (31 in.)]. If can spacers are required, no more than one-third of the total HEU content mass limit shown in Table 1.3 may be placed between any two spacers.

Typical configurations of authorized ES-3100 convenience containers are shown in Fig. 1.4. The shipping configurations shown in Fig. 1.4 utilize convenience cans having ≤5.0-in. diam and various heights [such as 4.75 in., 4.88 in., 8.75 in., 10 in., 17.5 in. (two 8.75-in. cans brazed together), and 30 in. (three 10-in. cans brazed together)], 4.94-in.-diam by 8.7-in.-tall polyethylene bottles, and 4.69-in.-diam by 9.4-in.-tall Teflon bottles. Although any combination of the convenience cans that will fit inside the internal volume of the CV may be used, content forms shall not be mixed in a single package (i.e., HEU oxides may not be packed with HEU metal). Empty cans and/or stainless-steel scrubbers may be used to fill the void space at the top of the CV. If empty cans are shipped, a minimum 0.32-cm (0.125-in.)-diam hole must be placed through the lid to prevent over-pressurization of the can in the event of a thermal accident. These empty cans may be placed above or below the loaded cans. In configurations not requiring can spacers for criticality control, can spacers may be shipped for convenience if placed on top of loaded cans in the CV. The HEU contents may be bagged or wrapped in polyethylene, nylon or Teflon, and the convenience containers may also be wrapped in polyethylene, nylon, or Teflon to further reduce the possibility of contamination. If metal cans or polyethylene bottles are used as convenience containers, the total amount of offgassing material (including polyethylene bottles; polyethylene, nylon, or Teflon bagging; and lifting slings) is limited to 500 g per package. If Teflon bottles are used as convenience containers, the total amount of offgassing material (including Teflon bottles, polyethylene, nylon, of Teflon bagging, and lifting slings) is limited to 1490 g per package (limit established by assuming three 330-g Teflon bottles and 500-g polyethylene bagging). If closed convenience cans with an outer diameter greater than 4.25 in. are used, at least 43 $in.^3$ of free or void volume must exist inside the CV to allow for gas expansion and offgassing of material at temperatures associated with NCT or HAC. In accordance with Sect. 6.2.4, Item 7, the amount of hydrogenous packing material inside the CV shall not exceed an equivalent mass of 500 g polyethylene. In some shipping configurations, silicone rubber pads will be placed between the convenience cans to reduce vibration.

1.2.2.5 Maximum normal operating pressure

As defined in 10 CFR 71.4, the maximum normal operating pressure is the maximum gauge pressure that would develop in the containment system in one year under an ambient temperature of 38°C (100°F) in still air, with appropriate insolation in the absence of venting, external cooling by an ancillary system, or operational controls during transport. Under these conditions, the maximum normal operating pressure in the ES-3100 CV would be 107.39 kPa (15.576 psig). In comparison, the design internal pressure of the CV is 1378.95 kPa (200 psig). The design internal pressure is a conservatively assumed value that was assigned for the purpose of the ASME Code calculations in DAC-M900000-0002.

1.2.2.6 Maximum and minimum weight

The maximum allowable gross shipping weight for the ES-3100 package is 190.5 kg (420 lb). The largest nominal gross shipping weight of the ES-3100 package with HEU content is 187.81 kg (414.05 lb) [Table 2.8]. The total weight of the tested ES-3100 units ranged from 157.4 to 204.6 kg (347 to 451 lb) [Table 2.9].

The weight of HEU contents in the ES-3100 shipping package is limited to 35.2 kg (77.60 lb). This limit has been established as a bounding case for the maximum structural, thermal, and containment limit for the package. There is no minimum content weight requirement. Actual mass restrictions for the various contents based on the various analyses presented in the SARP are listed in Tables 1.3, 1.3a, and 1.3b. The maximum allowable payload weight of any configuration, including packing components (convenience cans and bottles; polyethylene, nylon, or Teflon bags; silicone pads; can spacers; etc.), is 40.82 kg (90 lb). ES-3100 shipping package weights are discussed in greater detail in Chap. 2 and are broken down into individual component weights in Tables 2.8 and 2.9.

The payload weight (including convenience cans, silicone rubber pads, can spacers, and the HEU mockup) used in the ES-3100 package tests ranged from a minimum of 3.6 kg (8 lb) to a maximum of 50.3 kg (111 lb).

1.2.2.7 Maximum decay heat

As shown in Sect. 3.1.2, the conservatively calculated maximum heat generation rate of the contents is ~5 W. The ES-3100 package was designed for a maximum heat load of 20 W. Thermal analyses with Kaolite have been performed assuming heat sources of 5, 10, 15, 20, 25 and 30 W in the ES-3100 CV (DAC-PKG-801940-A001) and updated thermal analyses of the ES-3100 with Packcrete were performed with content heat loads of 0 and 5 W (DAC M801940-0002).

Table 1.3. Authorized content and fissile mass loading limits for ground transport [a, b, c]

Content description		Enrichment	CSI	No spacers, ^{235}U (kg)	Basis for limit	277-4 can spacers, [d] ^{235}U (kg)	Basis for limit
Solid HEU metal or alloy (specified geometric shapes) [e]	Cylinder A	≤100%	0.0	15.000	Crit.	25.000	Crit.
	Cylinder B	≤100%	0.0	18.000	Crit.	30.000	Crit.
	Cylinder C	≤93.5%	0.0	11.991	Crit.	-	-
	Cylinder D	≤93.5%	0.0	14.656	Crit.	-	-
	Square bars	≤100%	0.0	30.000	Crit.	35.200 [f]	Struct.
	Slugs	≤95%	0.0	17.374	Crit.	-	-
	Slugs	≤80%	0.0	-	-	29.318	Crit.
	Slugs	>80%, ≤95%	0.0	-	-	24.324	Crit.
	Slugs	>80%, ≤95%	0.4	-	-	34.749	Crit.
Broken HEU metal or alloy		>95%, ≤100%	0.0	2.600		3.600	Crit.
			0.4	4.000		5.900	Crit.
			0.8	6.200		10.500	Crit.
			2.0	10.700		17.500	Crit.
			3.2	19.100		22.400	Crit.
		>90%, ≤95%	0.0	2.755		3.800	Crit.
			0.4	4.370		6.395	Crit.
			0.8	7.315		12.825	Crit.
			2.0	13.300		21.280	Crit.
			3.2	23.370		23.370	Crit.
		>80%, ≤90%	0.0	2.880		4.140	Crit.
			0.4	4.860		8.460	Crit.
			0.8	8.550		15.660	Crit.
			2.0	16.110		24.750	Crit.
			3.2	26.100		27.990	Crit.
		>70%, ≤80%	0.0	3.200	Crit.	4.880	Crit.
			0.4	5.840	Crit.	11.040	Crit.
			0.8	11.360	Crit.	20.480	Crit.
			2.0	20.320	Crit.	28.800	Crit.
			3.2	28.800	Crit.	28.800	Crit.
		>60%, ≤70%	0.0	3.570	Crit.	6.580	Crit.
			0.4	7.350	Crit.	15.260	Crit.
			0.8	15.260	Crit.	24.780	Crit.
			2.0	25.200	Crit.	25.200	Crit.
			3.2	25.200	Crit.	25.200	Crit.
		≤60%	0.0	7.200 kg U	Crit.	14.100 kg U	Crit.
			0.4	17.300 kg U	Crit.	32.900 kg U	Crit.
			0.8	34.500 kg U	Crit.	35.20 kg U [f]	Struct.
			2.0	35.20 kg U [f]	Struct.	35.20 kg U [f]	Struct.
			3.2	35.20 kg U [f]	Struct.	35.20 kg U [f]	Struct.

Table 1.3. Authorized content and fissile mass loading limits for ground transport [a, b, c]

Content description	Enrichment	CSI	No spacers, ^{235}U (kg)	Basis for limit	277-4 can spacers, [d] ^{235}U (kg)	Basis for limit
HEU metal or alloy turnings, fines, or powders [g]	>95%, ≤100%	0.0	2.600	Crit.	Spacers not req'd	
		0.4	4.000	Crit.	Spacers not req'd	
		0.8	6.200	Crit.	Spacers not req'd	
		2.0	10.500	Crit.	Spacers not req'd	
		3.2	10.500	Crit.	Spacers not req'd	
	>90%, ≤95%	0.0	2.755	Crit.	Spacers not req'd	
		0.4	4.370	Crit.	Spacers not req'd	
		0.8	7.315	Crit.	Spacers not req'd	
		2.0	13.300	Crit.	Spacers not req'd	
		3.2	15.295	Crit.	Spacers not req'd	
	>80%, ≤90%	0.0	2.880	Crit.	Spacers not req'd	
		0.4	4.860	Crit.	Spacers not req'd	
		0.8	8.550	Crit.	Spacers not req'd	
		2.0	16.110	Crit.	Spacers not req'd	
		3.2	19.800	Crit.	Spacers not req'd	
	>70%, ≤80%	0.0	3.200	Crit.	Spacers not req'd	
		0.4	5.840	Crit.	Spacers not req'd	
		0.8	11.360	Crit.	Spacers not req'd	
		2.0	20.320	Crit.	Spacers not req'd	
		3.2	26.400	Crit.	Spacers not req'd	
	>60%, ≤70%	0.0	3.570	Crit.	Spacers not req'd	
		0.4	7.350	Crit.	Spacers not req'd	
		0.8	15.260	Crit.	Spacers not req'd	
		2.0	25.200	Crit.	Spacers not req'd	
		3.2	25.200	Crit.	Spacers not req'd	
	≤60%	0.0	7.200 kg U	Crit.	Spacers not req'd	
		0.4	17.300 kg U	Crit.	Spacers not req'd	
		0.8	34.500 kg U	Crit.	Spacers not req'd	
		2.0	35.20 kg U [f]	Struct.	Spacers not req'd	
		3.2	35.20 kg U [f]	Struct.	Spacers not req'd	
HEU oxide [h, i]						
UO_2, UO_3, U_3O_8, U_3O_8-Al, UO_2-Mg [j]	≤100%		15.13 kg oxide	H_2 gen.	Spacers not req'd	
2.00 g/cm^3 ≤ bulk density ≤ 6.54 g/cm^3		0.0	9.682 kg ^{235}U	Crit.	Spacers not req'd	
2.00 g/cm^3 ≤ bulk density ≤ 6.54 g/cm^3		0.4	12.323 kg ^{235}U	Crit.	Spacers not req'd	
1.75 g/cm^3 ≤ bulk density < 2.00 g/cm^3		0.0	9.462 kg ^{235}U	Crit.	Spacers not req'd	
1.50 g/cm^3 ≤ bulk density < 1.75 g/cm^3		0.0	8.362 kg ^{235}U	Crit.	Spacers not req'd	
1.25 g/cm^3 ≤ bulk density < 1.50 g/cm^3		0.0	7.042 kg ^{235}U	Crit.	Spacers not req'd	
1.00 g/cm^3 ≤ bulk density < 1.25 g/cm^3		0.0	5.941 kg ^{235}U	Crit.	Spacers not req'd	
0.75 g/cm^3 ≤ bulk density < 1.00 g/cm^3		0.0	4.841 kg ^{235}U	Crit.	Spacers not req'd	
0.50 g/cm^3 ≤ bulk density < 0.75 g/cm^3		0.0	3.521 kg ^{235}U	Crit.	Spacers not req'd	

Table 1.3. Authorized content and fissile mass loading limits for ground transport [a, b, c]

Content description		Enrichment	CSI	No spacers, ^{235}U (kg)	Basis for limit	277-4 can spacers, [d] ^{235}U (kg)	Basis for limit
Product oxides (UO_2, UO_3, U_3O_8) mixed with ThO_2 or mixed with Th metal		≤100%		15.13 kg oxide	H_2 gen.	Spacers not req'd	
2.00 g/cm^3 ≤ bulk density ≤ 6.54 g/cm^3			0.0	9.682 kg ^{235}U	Crit.	Spacers not req'd	
2.00 g/cm^3 ≤ bulk density ≤ 6.54 g/cm^3			0.4	12.323 kg ^{235}U	Crit.	Spacers not req'd	
1.75 g/cm^3 ≤ bulk density < 2.00 g/cm^3			0.0	8.890 kg ^{235}U	Crit.	Spacers not req'd	
1.50 g/cm^3 ≤ bulk density < 1.75 g/cm^3			0.0	6.821 kg ^{235}U	Crit.	Spacers not req'd	
1.25 g/cm^3 ≤ bulk density < 1.50 g/cm^3			0.0	5.765 kg ^{235}U	Crit.	Spacers not req'd	
1.00 g/cm^3 ≤ bulk density < 1.25 g/cm^3			0.0	4.841 kg ^{235}U	Crit.	Spacers not req'd	
0.75 g/cm^3 ≤ bulk density < 1.00 g/cm^3			0.0	4.049 kg ^{235}U	Crit.	Spacers not req'd	
0.50 g/cm^3 ≤ bulk density < 0.75 g/cm^3			0.0	3.301 kg ^{235}U	Crit.	Spacers not req'd	
Product oxides (UO_2, UO_3, U_3O_8) mixed with ZrO_2		≤100%		15.13 kg oxide	H_2 gen.	Spacers not req'd	
2.00 g/cm^3 ≤ bulk density ≤ 6.54 g/cm^3			0.0	9.682 kg ^{235}U	Crit.	Spacers not req'd	
2.00 g/cm^3 ≤ bulk density ≤ 6.54 g/cm^3			0.4	12.323 kg ^{235}U	Crit.	Spacers not req'd	
1.75 g/cm^3 ≤ bulk density < 2.00 g/cm^3			0.0	8.406 kg ^{235}U	Crit.	Spacers not req'd	
1.50 g/cm^3 ≤ bulk density < 1.75 g/cm^3			0.0	6.073 kg ^{235}U	Crit.	Spacers not req'd	
1.25 g/cm^3 ≤ bulk density < 1.50 g/cm^3			0.0	5.105 kg ^{235}U	Crit.	Spacers not req'd	
1.00 g/cm^3 ≤ bulk density < 1.25 g/cm^3			0.0	4.313 kg ^{235}U	Crit.	Spacers not req'd	
0.75 g/cm^3 ≤ bulk density < 1.00 g/cm^3			0.0	3.609 kg ^{235}U	Crit.	Spacers not req'd	
0.50 g/cm^3 ≤ bulk density < 0.75 g/cm^3			0.0	3.081 kg ^{235}U	Crit.	Spacers not req'd	
Research reactor fuel elements and components [k]	$UZrH_x$ (TRIGA)	≤20%	0.0	0.921 [l]	Crit.	Spacers not req'd	
		>20%, ≤70%	0.0	0.408 [l]	Crit.	Spacers not req'd	
	$UZrH_x$ (SNAP)	≥93%	0.0	0.857 [l]	Crit.	Spacers not req'd	
	U-Zr	≤100%	varies	See limit for broken metal or alloy	Crit.	*Spacers as req'd*	
	U-Al	≤100%	0.0	7.333 kg U-Al 1.117 kg U 1.050 kg ^{235}U	Crit.	Spacers not req'd	
	U_3O_8-Al	≤100%	0.0	15.13 kg oxide 9.682 kg ^{235}U	Crit.	Spacers not req'd	
			0.4	15.13 kg oxide 12.323 kg ^{235}U	Crit.	Spacers not req'd	
	UO_2	≤100%	0.0	21.937 kg UO_2 19.308 kg ^{235}U	Crit.	Spacers not req'd	
	UO_2-ThO_2	≤100%	0.0	21.937 kg UO_2 19.308 kg ^{235}U	Crit.	Spacers not req'd	
	Oxides of U-Zr [m]	≤100%	0.0	15.13 kg oxide 9.682 kg ^{235}U	Crit.	Spacers not req'd	
			0.4	15.13 kg oxide 12.323 kg ^{235}U	Crit.	Spacers not req'd	
	UO_2-Mg	≤100%	0.0	15.13 kg oxide 9.682 kg ^{235}U	Crit.	Spacers not req'd	
			0.4	15.13 kg oxide 12.323 kg ^{235}U	Crit.	Spacers not req'd	
	U_3Si_2-Al	≤100%	0.0	5.825 kg U_3Si_2-Al 2.277 kg U 450 g ^{235}U	Crit.	Spacers not req'd	

Table 1.3. Authorized content and fissile mass loading limits for ground transport [a, b, c]

Content description		Enrichment	CSI	No spacers, ^{235}U (kg)	Basis for limit	277-4 can spacers, [d] ^{235}U (kg)	Basis for limit
Uranium compounds	UF_4	≤100%	0.0	3.0 kg UF_4 2.267 kg ^{235}U	Crit.	Spacers not req'd	
			2.0	24.0 kg UF_4 18.136 kg ^{235}U	Crit.	Spacers not req'd	
	UO_2F_2	≤100%	0.0	3.0 kg UO_2F_2 2.067 kg ^{235}U	Crit.	Spacers not req'd	
	UC	≤100%	0.0	2.0 kg UC 1.815 kg ^{235}U	Crit.	Spacers not req'd	
	UN	≤100%	0.0	2.0 kg UN 1.888 kg ^{235}U	Crit.	Spacers not req'd	
	TRISO	≤100%	0.0	2.0 kg TRISO 1.815 kg ^{235}U	Crit.	Spacers not req'd	
	U_3Si_2, U_3Si_2-Al [n]	≥19.7%, <40%	0.0	13.0 kg U_3Si_2 4.819 kg ^{235}U	Crit.	Spacers not req'd	
		≥40%, ≤60%	0.0	7.0 kg U_3Si_2 3.892 kg ^{235}U	Crit.	Spacers not req'd	
	U_3Si, U_3Si-Al [n]	≥19.7%, <40%	0.0	14.0 kg U_3Si 5.387 kg ^{235}U	Crit.	Spacers not req'd	
		≥40%, ≤60%	0.0	8.5 kg U_3Si 4.906 kg ^{235}U	Crit.	Spacers not req'd	

[a] With the exception of the UNX crystals (Sect. 1.2.2.2), which are loaded in crystalline solid form, HEU in solution form is not permitted for shipment in the ES-3100.

[b] All limits are expressed in kg ^{235}U unless otherwise indicated.

[c] Mass loadings cannot be rounded up.

[d] 277-4 can spacers as described on Drawing M2E801580A043 (Appendix 1.3.7).

[e] HEU bulk metal and alloy not covered by these specific geometric shapes must be put into the broken metal category. Geometries of solid shapes are as follows:
- Cylinder A is larger than 3.24-in. diam but no larger than 4.25-in. diam: maximum of 1 cylinder per can.
- Cylinder B is no larger than 3.24-in. diam: maximum of 1 cylinder per can.
- Cylinder C is a uranium-molybdenum alloy with ≤ 95 wt % uranium and ≤ 93.5% ^{235}U enrichment; the cylinder length is ≤ 3.30 in. with an inner diam of ≥ 1.50 in., an outer diam of ≤ 4.35 in., and a maximum mass of 13.5 kg: maximum of 1 cylinder per CV.
- Cylinder D is a uranium-molybdenum alloy with ≤ 95 wt % uranium and ≤ 93.5% ^{235}U enrichment; the cylinder length is ≤ 5.80 in. with an inner diam of ≥ 1.35 in., an outer diam of ≤ 3.86 in., and a maximum mass of 16.5 kg: maximum of 1 cylinder per CV.
- Square bars are no larger than 2.29 in. × 2.29 in. (cross section): maximum of 1 bar per can.
- Slugs are a maximum of 1.5-in. diam × 2.0-in. tall: a maximum of 10 per convenience can where the actual number permitted is restricted by the stated loading limit.

[f] Maximum planned content weight is 35.20 kg. Maximum analyzed for criticality safety is 36.0 kg.

[g] Samples and small quantities (≤ 50 g) of HEU metal or alloy turnings, fines, or powders may be shipped under the parent form mass limits (e.g., broken metal, reactor fuel, etc.).

[h] Seal time must be 12 months or less. Seal time is the length of time after the ES-3100 containment vessel is sealed that the shipment must be complete.

[i] Allowable HEU oxide bulk densities are 0.5–6.54 g/cm^3 and the total mass of oxide in all cases is limited to 15.13 kg. Moisture content in oxide is limited to 3 wt % water.

[j] UO_2-Mg will be shipped in a glass bottle inside a metal convenience can under an inert cover gas.

[k] For SNAP $UZrH_x$, $x \leq 2$. For TRIGA $UZrH_x$, $x \leq 1.6$. Carbon coating for reactor fuel is not controlled (Sect. 6.9.8.3.1).

[l] Evaluation limit based on specific fuel type as opposed to a maximum calculated limit for $UZrH_x$.

[m] Oxides of U-Zr are UO_2-Zr and UO_2-ZrO_2.

[n] No control on the amount of aluminum.

Table 1.3a. Uranyl nitrate crystal content loading limits for ground transport

Product [a, b]	Seal time [c] (months)	CSI	Loading limit [d, e] (kg UNX)	U content [f] (wt %)
UNX, $0 < X \leq 3$	2	0.4	11.90	$52 < U \leq 61$
	4	0.4	6.70	$52 < U \leq 61$
UNX, $X > 3$	2	0.4	9.17	$46 < U \leq 52$
	4	0.0	4.75	$46 < U \leq 52$

[a] UNX is uranyl nitrate hydrate $[UO_2(NO_3)_2 \cdot XH_2O]$ where $0 < X \leq 6$.
[b] Must be shipped in Teflon bottles.
[c] Seal time—length of time after the ES-3100 containment vessel is sealed that the shipment must be complete. Seal times listed in this table are much lower than the calculated values shown in Table 3.5.4.1 in Appendix 3.5.4 and have been reduced for additional conservatism.
[d] Total mass of UNX crystals. Spacers are not required for this content type.
[e] Loading limits for uranyl nitrate crystals are based on hydrogen generation calculations presented in Appendix 3.5.4.
[f] Enrichment up to 100%.

Table 1.3b. Authorized content and fissile mass loading limits for air transport [a, b, c]

Content description	Enrichment	CSI	^{235}U (kg)
HEU metal or alloy	≤100%	— [d]	7.00
HEU metal or alloy turnings, fines, or powder [e]	≤100%	— [d]	7.00
Research reactor fuel elements and components [k] $UZrH_x$, [f] U-Zr, U-Al, U_3O_8-Al, UO_2, UO_2-ThO_2, oxides of U-Zr, [g] UO_2-Mg, U_3Si_2-Al			
	≤20%	— [d]	0.921
	>20%	— [d]	0.408
HEU oxide [h, i]			
UO_2, UO_3, U_3O_8, U_3O_8-Al, UO_2-Mg [j]	≤100%	— [d]	
5.0 g/cm³ ≤ bulk density ≤ 6.54 g/cm³			7.57
4.0 g/cm³ ≤ bulk density < 5.0 g/cm³			6.02
3.0 g/cm³ ≤ bulk density < 4.0 g/cm³			4.75
2.0 g/cm³ ≤ bulk density < 3.0 g/cm³			3.38
1.5 g/cm³ ≤ bulk density < 2.0 g/cm³			2.77
1.0 g/cm³ ≤ bulk density < 1.5 g/cm³			2.15
Product oxides (UO_2, UO_3, U_3O_8) mixed with ThO_2	≤100%	— [d]	
5.0 g/cm³ ≤ bulk density ≤ 6.54 g/cm³			7.57
4.0 g/cm³ ≤ bulk density < 5.0 g/cm³			6.02
3.0 g/cm³ ≤ bulk density < 4.0 g/cm³			4.48
2.0 g/cm³ ≤ bulk density < 3.0 g/cm³			2.46
1.5 g/cm³ ≤ bulk density < 2.0 g/cm³			1.58
1.0 g/cm³ ≤ bulk density < 1.5 g/cm³			1.14
Product oxides (UO_2, UO_3, U_3O_8) mixed with ZrO_2	≤100%	— [d]	
5.0 g/cm³ ≤ bulk density ≤ 6.54 g/cm³			7.57
4.0 g/cm³ ≤ bulk density < 5.0 g/cm³			6.02
3.0 g/cm³ ≤ bulk density < 4.0 g/cm³			3.12
2.0 g/cm³ ≤ bulk density < 3.0 g/cm³			1.49
1.5 g/cm³ ≤ bulk density < 2.0 g/cm³			0.83
1.0 g/cm³ ≤ bulk density < 1.5 g/cm³			0.70

Table 1.3b. Authorized content and fissile mass loading limits for air transport [a, b, c]

Content description	Enrichment	CSI	^{235}U (kg)
Product oxides (UO_2, UO_3, U_3O_8) mixed with Th metal	≤100%	— [d]	
5.0 g/cm^3 ≤ bulk density ≤ 6.54 g/cm^3			7.57
4.0 g/cm^3 ≤ bulk density < 5.0 g/cm^3			6.02
3.0 g/cm^3 ≤ bulk density < 4.0 g/cm^3			4.66
2.0 g/cm^3 ≤ bulk density < 3.0 g/cm^3			2.55
1.5 g/cm^3 ≤ bulk density < 2.0 g/cm^3			1.71
1.0 g/cm^3 ≤ bulk density < 1.5 g/cm^3			1.18
Uranium compounds [l]			
UF_4	≤100%	— [d]	24.0 kg UF_4 18.13 kg ^{235}U
UO_2F_2	≤100%	— [d]	3.0 kg UO_2F_2 2.06 kg ^{235}U
UC	≤100%	— [d]	2.0 kg UC 1.81 kg ^{235}U
UN	≤100%	— [d]	2.0 kg UN 1.88 kg ^{235}U
U_3Si_2	≥19.7%, <40%	— [d]	8.5 kg U_3Si_2 3.15 kg ^{235}U
	≥40%, ≤60%	— [d]	6.5 kg U_3Si_2 3.61 kg ^{235}U
U_3Si	≥19.7%, <40%	— [d]	8.5 kg U_3Si 3.27 kg ^{235}U
	≥40%, ≤60%	— [d]	6.5 kg U_3Si 3.75 kg ^{235}U

[a] All limits are expressed in kg ^{235}U unless otherwise indicated.
[b] Mass loadings cannot be rounded up.
[c] The loading limit for mixed-mode transportation is taken as the most restrictive limit for either ground or air mode of transportation (Table 1.3 or 1.3b).
[d] CSI and spacer use are governed by ground transport mode.
[e] If the mass of metal or alloy turnings, fines, or powders is ≤ 50 g, then it may be shipped as the parent form (e.g., broken metal, reactor fuel, etc.).
[f] For SNAP $UZrH_x$, x ≤ 2. For TRIGA $UZrH_x$, x ≤ 1.6.
[g] Oxides of U-Zr are UO_2-Zr and UO_2-ZrO_2.
[h] Seal time must be 12 months or less. Seal time is the length of time after the ES-3100 containment vessel is sealed that the shipment must be complete.
[i] Allowable uranium oxide bulk densities are 1.0–6.54 g/cm^3. Moisture content in oxide is limited to 3 wt % water.
[j] UO_2-Mg will be shipped in a glass bottle inside a metal convenience can under an inert cover gas.
[k] Carbon coating for reactor fuel is not controlled (Sect. 6.9.8.3.1).
[l] Allowable uranium compound bulk densities are 2.0–6.54 g/cm^3.

1.2.2.8 Loading restrictions

Loading restrictions based upon the results of the criticality safety calculations presented in Sect. 6.2.4 and additional limitations on packing materials outlined in Chap. 3 are as follows:

(1) HEU fissile material to be shipped in the ES-3100 package must be placed in stainless-steel, tin-plated carbon-steel, aluminum, or nickel alloy convenience cans, polyethylene bottles, or Teflon bottles. Solid form HEU contents (i.e., spheres, cylinders, bars, slugs) that will not fit in a convenience can may be bagged only with no convenience can required around the content. For contents that are bagged only, stainless-steel metal scrubbers may be placed on the top and bottom of this assembly inside the CV. For these bagged contents, the void volume requirement stated in Loading Restriction 8 must still be satisfied. Enriched uranium oxide in the form of UO_2-Mg will be shipped in glass bottles inside a metal convenience can. Convenience containers used in the ES-3100 package must have an outer diameter less than or equal to 12.7 cm (5 in.). The height can vary up to the full internal height of the CV or 78.74 cm (31 in.). Any closure on the convenience can is allowed.

(2) Any combination of convenience cans is allowed in a single package, as long as the total height (including silicone rubber pads and can spacers, if required) does not exceed the inside working height of the CV (~31 in.).

(3) In situations where empty convenience cans are shipped in the package, they may be placed either above or below the loaded cans, and a minimum 0.32-cm (0.125-in.)-diam hole must be placed through the lid to prevent over pressurization of the can.

(4) The concentration of uranium isotopes in the content is limited as shown in Table 1.1; concentration limits for uranium oxide are shown in Table 1.2. In addition to the uranium isotopes shown in Table 1.1, transuranic isotopes (with the exception of ^{237}Np) may be present in the HEU metal and alloy contents transported by ground at a maximum concentration of 800.0 μg/gU and at a maximum concentration of 40.0 μg/gU in all other contents. Contents to be transported by air are limited to a maximum transuranic concentration of 40.0 μg/gU, and the transportation of plutonium by air (due to the transuranic concentration allowance) shall be in accordance with the requirements in 10 CFR 71.88, which includes restrictions for no more than an A_2 quantity of plutonium in any isotope or form. The concentration of ^{237}Np is limited to 0.0250 g/gU.

(5) For pyrophoric considerations, HEU metal or alloy pieces must have a specific area not greater than 1 cm^2/g or must not pass through a 3/8-in. (9.5-mm) mesh sieve (or equivalent size-grading method). Incidental small pieces that do not pass the size restriction tests, and powders, foils, turnings, and wires, may only be shipped if they are in a sealed, inerted container. Glass bottles containing enriched uranium oxide in the form of UO_2-Mg must be placed in a sealed, inerted container.

(6) The content shall not exceed "per package" fissile material mass loading limits specified in Tables 1.3, 1.3a, and 1.3b. Where can spacers are required for a "per package" mass loading, the quantity of fissile material located in any vacancy between or adjacent to can spacers shall not exceed one-third of the mass loading limit in Tables 1.3. A spacer must be positioned between each convenience can, or in the case of shipping only one convenience can, the spacer must be positioned on top of the single convenience can.

(7) The package content is defined as the HEU fissile material, the convenience cans and can spacers, and the associated packing materials (plastic bags, pads, tape, etc.) inside the ES-3100 CV.

(8) If metal cans are used as convenience containers, the amount of polyethylene bagging and lifting slings is limited to 500 g per package. If Teflon bottles are used as convenience containers, the total amount of offgassing material (including Teflon bottles; polyethylene, nylon, or Teflon bagging; and lifting slings) is limited to 1490 g per package. If metal cans or polyethylene bottles are used as convenience containers, the total amount of offgassing material (including polyethylene bottles; polyethylene, nylon, or Teflon bagging; and lifting slings) is limited to 500 g per package (see Sect. 6.2.4, Item 7). If closed convenience cans with an outer diameter greater than 4.25 in. are used, at least 43 $in.^3$ of free or void volume must exist inside the CV to allow for gas expansion and offgassing of material at temperatures associated with NCT or HAC. These mass limits do not include moisture in oxide. Moisture is accounted for in criticality safety calculations (Sect. 6.1.2).

(9) The amount of hydrogenous packing material inside the CV shall not exceed an equivalent mass of 500 g polyethylene (Sect. 6.2.4, Item 7).

(10) Shipments of UNX crystals must be completed in the time period noted in Table 1.3a. Shipments of uranium oxide must be completed in 12 months. This time period begins when the CV is sealed.

(11) The mass of any unidentified constituents in content to be shipped in the ES-3100 must be counted against the fissile mass loading limit. Content must not contain unevaluated moderating materials.

(12) Allowable HEU oxide bulk densities are 0.5–6.54 g/cm^3 for ground transport and 1.0–6.54 g/cm^3 for air transport.

(13) As noted in Table 1.3, Note e, ground transport of solid HEU metal or alloy of specified geometric shapes is limited to one item per convenience container, with the exception of slugs, which are limited to a maximum of 10 per convenience container. Cylinders C and D are limited to one cylinder per CV.

(14) For air transport, the total free water permitted in the ES-3100 packaging is limited to 12 lb (5,443 g).

(15) Clinkers and screenings will be loaded in accordance with the HEU metal or alloy turnings, fines, and powders mass loading limits in a sealed container under an inert cover gas. Clinkers and screenings shipments must be completed within 12 months after sealing the CV.

1.2.3 Special Requirements for Plutonium

The contents to be shipped in the ES-3100 have only trace amounts of transuranic isotopes [<0.74 TBq (20 Ci)]. Therefore, the requirements in 10 CFR 71.63 are not applicable.

1.2.4 Operational Features

The ES-3100 package is a Type B(U) fissile material package designed in accordance with DOT and NRC regulations. These regulations require that the package be operated without undue risk to the public, even in the event of a severe accident, and that the dose rate and nonfixed radioactive contamination on the external surface of the package conform with 49 CFR 173.441 and 173.443, respectively. These requirements are translated into the designs for the containment, shielding, and nuclear criticality safety of the contents when subjected to NCT and HAC. Designs for containment, shielding, and nuclear subcriticality safety are supported by operational procedures for loading, unloading, and maintenance to ensure that those design features are used and maintained in a manner commensurate with their intended function. Drop tests, crush tests, puncture tests, thermal tests, and water immersion tests (Sects. 2.6 and 2.7) show that the drum assembly maintains the insulation and the CV in their intended configurations when subjected to NCT and HAC.

Design features that provide shielding, containment, and nuclear criticality control perform these functions in a passive manner. No valves, connections, gauges, active coolants, or operationally pressurized parts are integral to the ES-3100 package.

1.3 APPENDIX

Appendix 1.3.1 Package Certification Drawing 1-31
Appendix 1.3.2 SPC JS-YMN3-801580-A002, *ES-3100 Drum Assembly* 1-39
Appendix 1.3.3 SPC JS-YMN3-801580-A001, ES-3100 Containment Vessel 1-71
Appendix 1.3.4 Equipment Specification JS-YMN3-801580-A003, Manufacturing Process Specification for Casting Kaolite 1600™ into the ES-3100 Shipping Package 1-111
Appendix 1.3.5 Equipment Specification SPC JS-YMN3-801580-A005, *Casting Catalog No. 277-4 Neutron Absorber for the ES-3100 Shipping Package* 1-131
Appendix 1.3.6 Package Category Determination 1-161
Appendix 1.3.7 ES-3100 Design Drawings 1-165
Appendix 1.3.8 Pyrophoricity of Uranium Metal 1-213
Appendix 1.3.9 Equipment Specification SPC M801580-0002, *ES-3100 Ethylene Propylene Diene Monomer (EPDM) Containment Vessel O-rings* 1-233
Appendix 1.3.10 SPC M801580-0004, *ES-3100 Heavy Can Spacer Assemblies* 1-263
Appendix 1.3.11 SPC M801794-0003, *Packcrete Preliminary Lot Qualification* 1-289
Appendix 1.3.12 SPC M801580-0003, *ES-3100 Packcrete Final Lot Qualification and Production Processing* 1-341
Appendix 1.3.13 Chapter 1 References 1-369

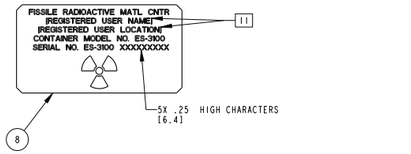
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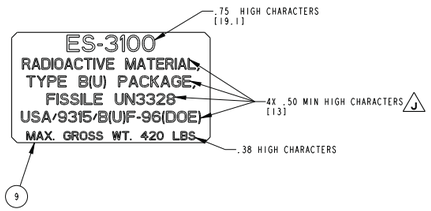
Appendix 1.3.1
Package Certification Drawing

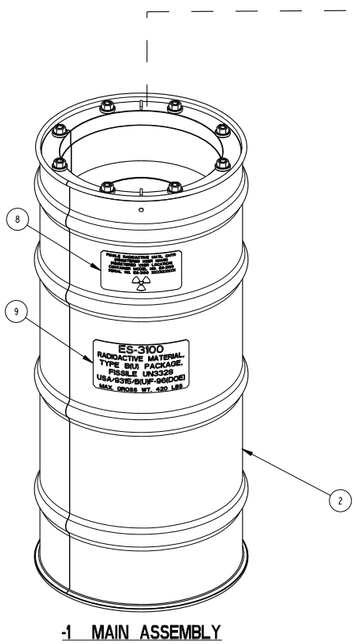
Drawing No.	Rev.	Title
M2E801580A037	J	Consolidated Assembly Drawing (3 sheets)

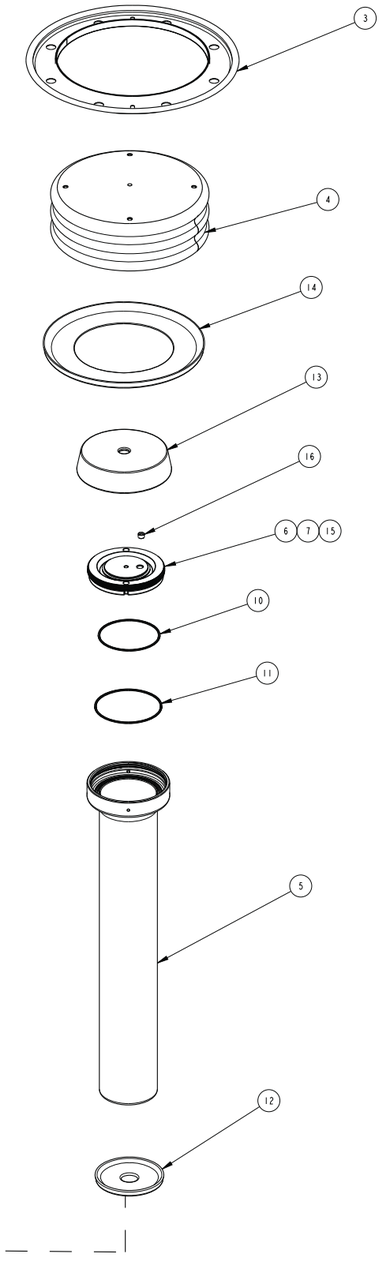
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UNCLASSIFIED

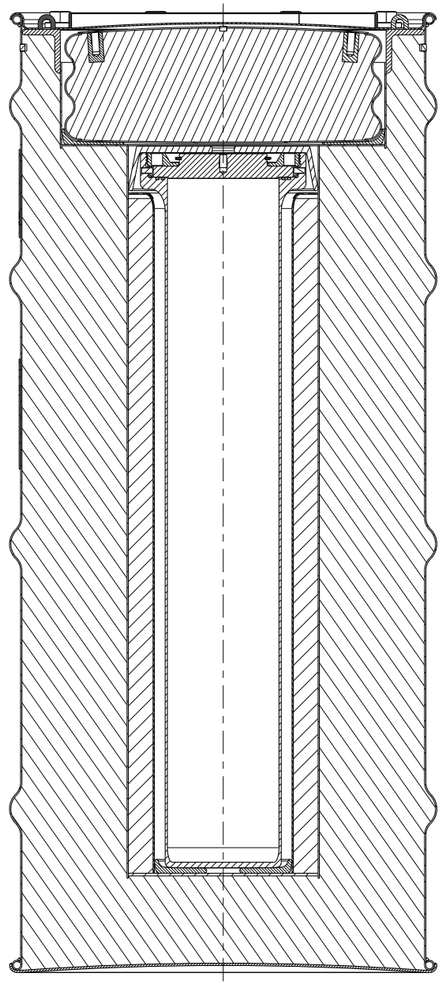








-1 MAIN ASSEMBLY



NOTES

1. DELETED
2. DELETED
3. APPROXIMATE WEIGHT: 325 LBS [147.4 Kg] FOR F/N 1 EMPTY.
4. WELDING SYMBOLS SHALL BE INTERPRETED IN ACCORDANCE WITH AWS A2.4.
5. SEE EQUIPMENT SPECIFICATION JS-YMN3-801580-A002 ES-3100 DRUM ASSEMBLY.
6. SEE EQUIPMENT SPECIFICATION JS-YMN3-801580-A001 ES-3100 CONTAINMENT VESSEL.
7. SEE EQUIPMENT SPECIFICATION SPC-M801580-0003 FOR CASTING PACKCRETE OR JS-YMN3-801580-A003 FOR CASTING KAOLITE 1600™ INTO THE ES-3100 SHIPPING PACKAGE. THE INSULATION CASTING PROCESS IS PROTECTED UNDER U.S. PATENT 6,299,950. UNITED STATES GOVERNMENT HAS RIGHTS IN THE EVENT PURSUANT TO CONTRACT NO. DE-AC05-84 OR 21400 BETWEEN U.S. DEPARTMENT OF ENERGY AND CNS Y-12.
8. SEE EQUIPMENT SPECIFICATION JS-YMN3-801580-A005 CASTING CATALOG # 277-4 NEUTRON ABSORBER FOR THE ES-3100 SHIPPING PACKAGE.
9. DURING INSTALLATION OF O-RINGS APPLY A THIN COAT OF SUPER-O-LUBE
10. DURING INSTALLATION OF CONTAINER VESSEL LID ASSEMBLY, APPLY A LIGHT COAT OF KRYTOX GREASE TO THE THREADS AND UNDER THE NUT.
11. SEE PROCUREMENT DOCUMENTS FOR PROPER REGISTERED USER NAME AND LOCATION.
12. DELETED

	AR	KRYTOX #240AC OR EQUAL THREAD LUBRICANT	FLUORINATED GREASE MILLER-STEPHENSON CHEMICAL CO.	NA	18
J	9 AR	SUPER-O-LUBE OR EQUAL O-RING LUBRICANT	CLEAR DIMETHYL SILOXANE POLYMER PARKER HANNIFIN CORP	NA	17
	1	MODIFIED VCO THREADED PLUG	BRASS	3	16
J	10 1	EXTERNAL RETAINING RING	302 SST	3	15
	1	PLUG PAD	SILICONE RUBBER 72±5 SHORE A COLOR BLACK/GRAY	1	14
	1	CV FLANGE PAD		1	13
	1	CV BOTTOM PAD		1	12
	1	OUTER O-RING Ø5.859±.035 ID X Ø.139 ±.004	ETHYLENE PROPYLENE DIENE MONOMER 70±5 SHORE A COLOR BLACK	1	11
	1	INNER O-RING Ø5.359±.035 ID X Ø.139±.004		1	10
	5 1	ES3100 DATA PLATE	16 GA 304/304L SST ASTM SA240	1	9
	5 1	ES3100 TREFOIL DATA PLATE		1	8
	6 1	CONTAINMENT VESSEL CLOSURE NUT	NITRONIC 60 SST ASME SA-479 UNS-S21800	3	7
	6 1	CONTAINMENT VESSEL SEALING LID	304 SST ASME SA-479	3	6
	6 1	CONTAINMENT VESSEL BODY	304L SST	3	5
	7 5 1	TOP PLUG WELDMENT	16 GA 304/304L SST ASTM SA240	2	4
	5 1	DRUM LID WELDMENT		2	3
	8 7 5 1	DRUM WELDMENT		2	2
		MAIN ASSEMBLY		1	1
		NOMENCLATURE OR DESCRIPTION	MATERIAL / SPECIFICATION	SHEET NO	FIND NO
		QTY REQ'D NEXT ASSEMBLY	PARTS LIST		

UNCLASSIFIED

THIS DOCUMENT HAS BEEN REVIEWED AND CONFIRMED TO BE UNCLASSIFIED.

NUCLEAR CRITICALITY SAFETY

THIS DRAWING INCLUDES FEATURES SUPPORTING NUCLEAR CRITICALITY SAFETY.

ANY REVISION TO THIS DRAWING REQUIRES NUCLEAR CRITICALITY SAFETY DIVISION APPROVAL.

NAME/DATE: Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2020.02.18 10:10:02 -05'00'

TITLE: Y-12 ENGINEER

ORGANIZATION: Y-12 ENGINEERING

APPROVALS

DES	KW JOHNSON: Kevin W (KZH) Johnson, Digitally signed by Kevin W (KZH) Johnson, Date: 2020.02.18 14:58:00 -05'00'	NCS AD WILKINSON: Alan D. (WA9) Wilkinson, Digitally signed by Alan D. (WA9) Wilkinson, Date: 2020.02.19 08:45:46 -05'00'
DE	N LANEY: Noelani A (NL1) Laney, 2020.02.18 10:22:23 -05'00'	WE: John W (FJB) Folk, Digitally signed by John W (FJB) Folk, Date: 2020.02.19 17:24:01 -05'00'
CHKR	GA BYINGTON: G A (GAB) Byington, Digitally signed by G A (GAB) Byington, Date: 2020.02.18 10:13:54 -05'00'	
DVR	LC HOOPER: Lloyd Hooper, Digitally signed by Lloyd Hooper, Date: 2020.02.20 06:16:42 -05'00'	
SE	RD AIGNER: Roger D (R7A) Aigner, Digitally signed by Roger D (R7A) Aigner, Date: 2020.02.18 15:09:58 -05'00'	
DM/PE	JC ANDERSON: James C (J5A) Anderson, Digitally signed by James C (J5A) Anderson, Date: 2020.02.23 14:11:13 -05'00'	

EFFECTIVE DATE: REFER TO DESIGN MANAGER APPROVAL

REVISION DESCRIPTION	NEXT ASSEMBLY/ REFERENCE DOCUMENTS
CHANGED BOX NOTE NUMBERS ON F/N's 15 & 17. SHOW MODIFIED TEXT SIZES ON F/N 9 DATA PLATE.	N/A

TOLERANCES UNLESS OTHERWISE SPECIFIED

FRACTIONS	±.01
XX DECIMALS	±.005
XXX DECIMALS	±0.5°
ANGLES	.01/-.06
BREAK SHARP EDGES	125 RMS MAX
FINISH	
THIRD ANGLE PROJECTION	

I IMPORTANT TO FORM-FIT-FUNCTION INDEPENDENT VERIFICATION REQUIRED

S IMPORTANT TO SAFETY SHALL BE 100% INSPECTED AND NOT DEVIATED WITHOUT APPROVAL

SCALE: NOTED — SHEET SIZE REPRESENTATION: 1 INCH SQUARE AT FULL SIZE — SCALE PROVIDED FOR REFERENCE ONLY DO NOT SCALE

APPROXIMATE WEIGHT: N/A

DIMENSIONING AND TOLERANCING: ASME Y14.5M - 1994

ALL DIMENSIONS ARE IN: INCHES [mm]

SOFTWARE: CREO 2.0

Y-12 NATIONAL SECURITY COMPLEX
CONSOLIDATED NUCLEAR SECURITY, LLC
P.O. BOX 2009 OAK RIDGE, TN 37831

US GOVERNMENT CONTRACT: DE-NA0001942

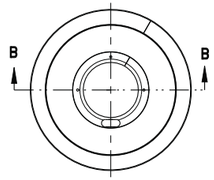
USERS MUST REFER TO THE TRANSMITTAL DOCUMENTS THAT ACCOMPANIED DELIVERY OF THIS DRAWING FOR ANY APPLICABLE DISCLAIMERS GOVERNING THE DRAWING.

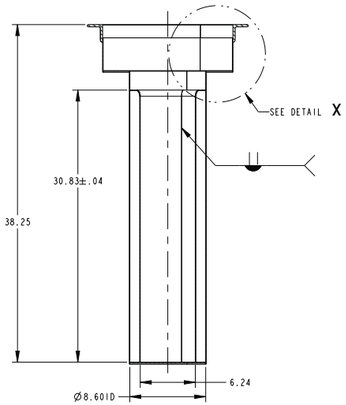
PROJECT	ES-3100 SHIPPING PACKAGE
TITLE	CONSOLIDATED ASSEMBLY DRAWING
DRAWING NUMBER	M2E801580A037
PART	000
REV	J
RECORD NO	N/A
STATE	IF
SHEET	1 OF 3

MATERIAL SOURCE: REV J SHEET 1 OF 3

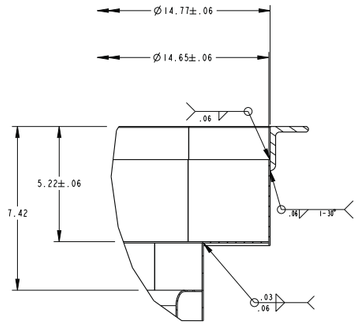
UNCLASSIFIED

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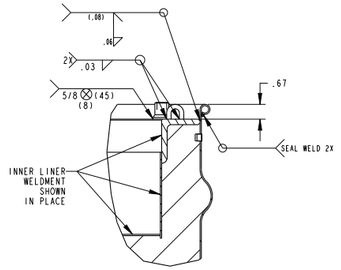


SECTION B-B

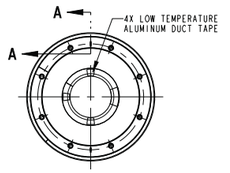


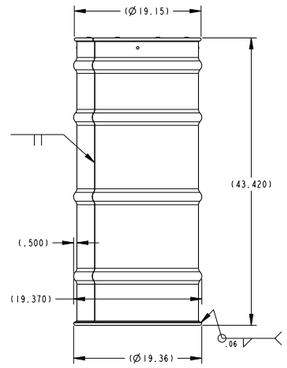
DETAIL X

INNER LINER WELDMENT

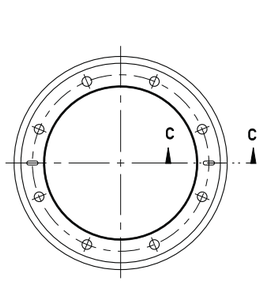


SECTION A-A

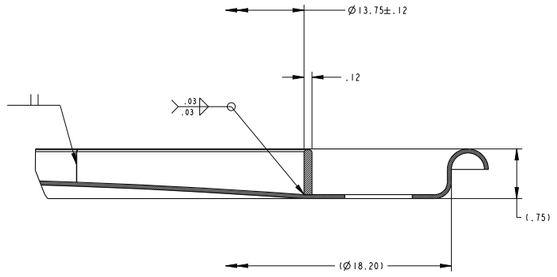




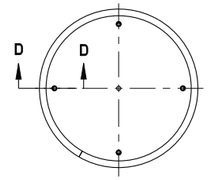
-2 DRUM WELDMENT

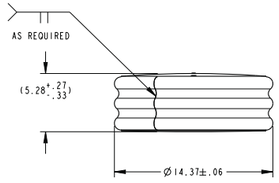


-3 DRUM LID WELDMENT

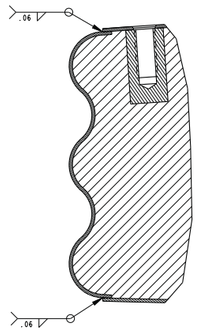


SECTION C-C





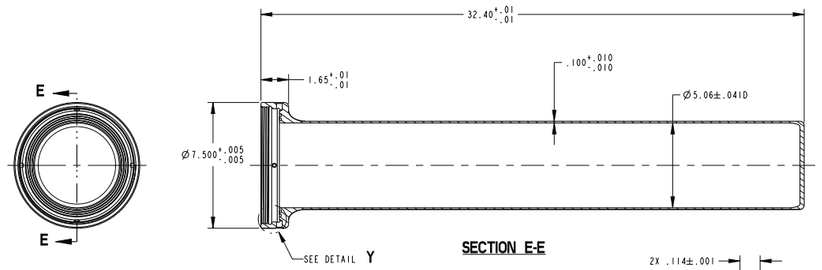
-4 TOP PLUG WELDMENT



SECTION D-D

Y-12 NATIONAL SECURITY COMPLEX CONSOLIDATED NUCLEAR SECURITY, LLC P.O. BOX 2009 OAK RIDGE, TN 37831	PROJECT: ES-3100 SHIPPING PACKAGE		
	TITLE: CONSOLIDATED ASSEMBLY DRAWING		
US GOVERNMENT CONTRACT: DE-NA0001942	DRAWING NUMBER: M2E801580A037	PART: 000	REV: J
USERS MUST REFER TO THE TRANSMITTAL DOCUMENTS THAT ACCOMPANIED DELIVERY OF THIS DRAWING FOR ANY APPLICABLE DISCLAIMERS GOVERNING THE DRAWING.	RECORD NO: N/A	STATE: IF	SHEET: 2 OF 3

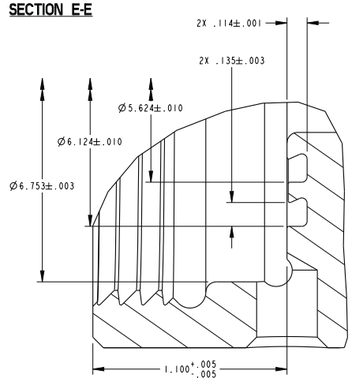
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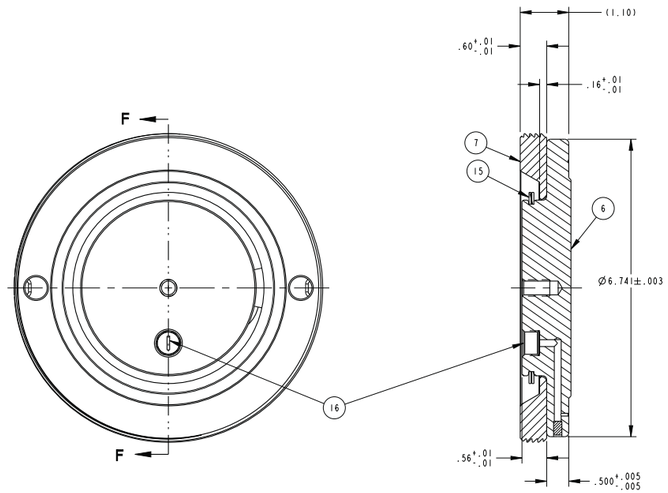
-5 CONTAINMENT VESSEL BODY

OPTIONAL WELDED CONSTRUCTION SHOWN ON SHEET 6

SECTION E-E



DETAIL Y

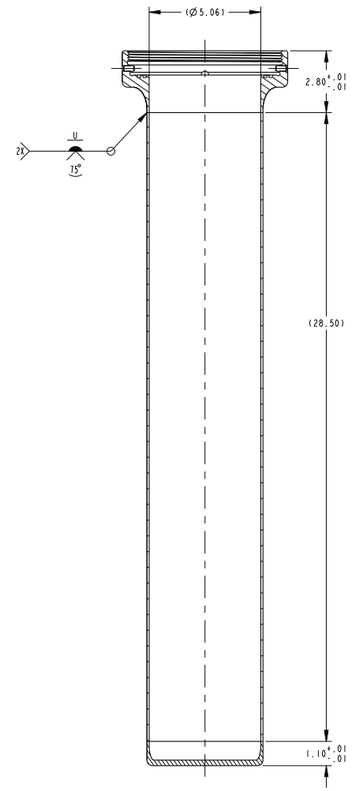


CONTAINMENT VESSEL SEALING LID ASSEMBLY

SECTION F-F

WELD NOTES:

1. ALL WELDS ON THE CONTAINMENT VESSELS SHALL BE DONE EITHER BY THE GTAW OR GMAW PROCESS, MANUAL OR AUTOMATIC, AT THE DISCRETION OF THE SELLER UNLESS SPECIFICALLY CALLED OUT ON THE DRAWINGS. BACKING RINGS, EVEN IF REMOVED AFTER THE WELD HAS BEEN MADE, SHALL NOT BE USED. AS PREVIOUSLY STATED, WELD SYMBOLS ARE PROVIDED ON THE DRAWING INDICATING FOR EACH WELD THE TYPE OF WELD AND DIMENSIONS OF THE WELD.
2. EXCEPT AS LIMITED BY THIS SPECIFICATION, THE APPLICABLE REQUIREMENTS OF NB-4300 AND NB-4400 SHALL APPLY TO THE CONTAINMENT VESSEL.
3. PRIOR TO WELDING, ALL WELD PREPARATION AREAS AND THE SURFACES WITHIN ONE INCH OF THE WELD AREA SHALL BE EXAMINED VISUALLY AND WITH LIQUID PENETRANT. THE ACCEPTANCE CRITERIA FOR THESE EXAMINATIONS ARE THOSE STATED IN NB-5130 (A) THROUGH NB-5130 (D). THE RESULTS OF THESE SURFACE EXAMINATIONS SHALL BE REPORTED TO THE COMPANY TOGETHER WITH THE WELD EXAMINATION REPORTS, SEE SECTION 3.4 OF THIS SPECIFICATION.
4. WELDERS PERFORMING TWO OR MORE WELDS IN ONE DAY THAT ARE REJECTED BASED UPON WELDER TECHNIQUE SHALL BE SUBJECT TO BE RE-QUALIFIED TO THE APPROPRIATE WELDING PROCEDURES, SEE SECTION IX, PARAGRAPH QW-320 OF THE ASME CODE.
5. THE APPLICABLE REQUIREMENTS IN PARAGRAPHS NB-5110, NB-5120, NB-5210, NB-5220, NB-5260, AND NB-5300 SHALL APPLY TO THE CONTAINMENT VESSELS. THE PLUG WELD SHOWN ON DRAWING M2E801580A015 SHALL BE EXAMINED VISUALLY AND WITH PENETRANT. THE APPLICABLE REQUIREMENTS IN PARAGRAPHS NB-5110, AND NB-5350 SHALL APPLY TO THE PLUG WELD. NOTE THAT THE REFERENCE TO THE INSPECTOR IN NB-5112, FOR THE PURPOSES OF THIS SPECIFICATION IS EITHER THE COMPANY'S INSPECTOR OR A SUBCONTRACTOR DESIGNATED BY THE COMPANY.
6. MATERIALS USED IN THE PENETRANT EXAMINATION OF WELDS AND IN THE FINAL SURFACE EXAMINATION OF FINISHED COMPONENTS (SEE SECTION 3.7) SHALL BE SPECIFICALLY RECOMMENDED BY THEIR SUPPLIERS FOR USE WITH AUSTENITIC STAINLESS STEELS, AND COPIES OF THE CERTIFICATION OF CONTAMINANT CONTENT OF MATERIALS USED (SEE SECTION V, ARTICLE 6, T-641) SHALL BE SUPPLIED TO THE COMPANY WITH THE EXAMINATION REPORTS.
7. REPAIR WELDING SHALL MEET THE APPLICABLE REQUIREMENTS OF NB-2500.
8. CERTIFIED WRITTEN WELD EXAMINATION REPORTS TOGETHER WITH THE CORRESPONDING MATERIAL SURFACE EXAMINATION REPORTS, AND WELD MAP SHALL BE SUBMITTED TO THE COMPANY AS STATED IN THE PROCUREMENT SPECIFICATION FOR THE ES-3100 CONTAINMENT VESSEL. WELD EXAMINATION REPORTS FOR ALL WELD AND SURFACE EXAMINATION SHALL INCLUDE: THE CONTAINMENT VESSEL SERIAL NUMBER, A WELD MAP SHOWING THE LOCATION OF THE WELD AND EXAMINATION AREA, THE WELDER'S NAME, THE EXAMINER S NAME, THE TIME AND DATE OF THE WELD EXAMINATION, THE EXAMINATION PROCEDURE(S) NUMBER USED, THE WPS NUMBER, THE HEAT NUMBERS OF THE MATERIALS JOINED, THE HEAT NUMBER OF THE WELD FILLER, AND EXAMINER S REMARKS. THE EXAMINER S REMARKS SHALL INCLUDE THE RESULTS OF THE EXAMINATION AND ACCEPTANCE, OR REJECTION OF THE WELD BASED ON THE STATED CRITERIA. ONE SET OF RADIOGRAPHS SHALL BE PROVIDED TO THE COMPANY WITH RADIOGRAPHIC EXAMINATION REPORTS. IF THE WELD OR SURFACE IS REJECTED, A DESCRIPTION OF THE DEFECT AND SKETCH SHOWING THE LOCATION SHALL BE PROVIDED.
9. IF A WELD IS REJECTED, THE AREA SHALL BE WELD REPAIRED BY THE SELLER AND RE-EXAMINED. AFTER TWO UNSUCCESSFUL REPAIR ATTEMPTS, THE COMPANY SHALL BE NOTIFIED FOR APPROVAL TO PERFORM MORE REPAIR ATTEMPTS. THE COMPANY MAY, AT ITS OPTION, CHOOSE TO REJECT FURTHER REPAIR EFFORTS AND REQUIRE THAT A REPLACEMENT PART BE FABRICATED.



CONTAINMENT VESSEL BODY ASSEMBLY WELDED OPTION

QTY REQ'D NEXT ASSEMBLY	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL/ SPECIFICATION	FIND NO
2	-5	.2501/.2503 OD DOWEL PIN	ANSI B18.8.2 18-8-SST	5
1	-4	VESSEL FLANGE	ASME SA-182 TYPE F304L	4
1	-3	VESSEL END CAP	ASME SA-182 TYPE F304L	3
1	-2	VESSEL BODY SCH40 PIPE	ASME SA-182 TYPE F304L	2
X	-1	CONTAINMENT VESSEL WELDED ASSEMBLY		1

PARTS LIST

Y-12 NATIONAL SECURITY COMPLEX CONSOLIDATED NUCLEAR SECURITY, LLC P.O. BOX 2009 OAK RIDGE, TN 37831	PROJECT: ES-3100 SHIPPING PACKAGE			
	TITLE: CONSOLIDATED ASSEMBLY DRAWING			
US GOVERNMENT CONTRACT: DE-NA0001942	DRAWING NUMBER: M2E801580A037	PART: 000	REV: J	
USERS MUST REFER TO THE TRANSMITTAL DOCUMENTS THAT ACCOMPANIED DELIVERY OF THIS DRAWING FOR ANY APPLICABLE DISCLAIMERS GOVERNING THE DRAWING.	RECORD NO: N/A	STATE: IF	SHEET: 3 OF 3	

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Appendix 1.3.2
SPC JS-YMN3-801580-A002, *ES-3100 Drum Assembly*

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APPROVAL / REVISION PAGE
** For Company Use Only - Do Not Provide To Supplier **

QUALITY LEVEL	PROTECTION LEVEL	BUILDING
Q	C	NA

PROJECT TITLE: ES-3100 Shipping Package
JOB TITLE: ES-3100 Shipping Package
ITEM DESCRIPTION: ES-3100 Drum Assembly
UNID: YAREA-CMH-042

REVISIONS

REV. NO.	DESCRIPTION OF REVISION
D	On Record
E	Added RIC, updated general formatting, added submittal checklist.

REFERENCE DOCUMENTS & OTHER INFORMATION

This Engineering Procurement Document contains Scientific, Technical, or Operational Information (STI) and therefore must go through the Information Release Office prior to release.

Recommended supplier:
TBD

Upon delivery, implement Level C storage requirements.

In-Storage Maintenance Requirements – None

References for Company Use:

Receipt Inspection Checklist (Attached)
Design Verification Record # DV 801580-0018

Other reference documents not needed by the Supplier:
UCN-20064
CK M801580-0016 (QLD)
GWS YAREA-CMH-0001 000 08 (Grading Worksheet)
TIO (approval)

This document has been reviewed by a Y-12 DC/ UCNI RO and has been determined to be UNCLASSIFIED and contains no UCNI. This review does not constitute clearance for Public Release.
Name: Date:
Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2019.08.29 12:57:45 -04'00'

APPROVALS

PRINT	SIGNATURE	DATE	PRINT	SIGNATURE	DATE
PREPARED BY: L.C. Hooper	Lloyd Hooper	Digitally signed by Lloyd Hooper Date: 2019.08.28 06:30:06 -04'00'	PACKAGING ENGINEER: N.A. Laney		Noelani A (NL1) Laney 2019.08.28 13:57:45 -04'00'
DESIGN VERIFICATION: R.D. Aigner	Roger D (R7A) Aigner	Digitally signed by Roger D (R7A) Aigner Date: 2019.08.29 16:09:13 -04'00'	SYSTEM ENGINEER: R.D. Aigner	Roger D (R7A) Aigner	Digitally signed by Roger D (R7A) Aigner Date: 2019.08.29 12:58:06 -04'00'
DISCIPLINE MANAGER: J.C. Anderson	James C (J5A) Anderson	Digitally signed by James C (J5A) Anderson Date: 2019.08.29 16:38:10 -04'00'	OPERATIONS/SYSTEM OWNER: S.K. Thomas	Stan (TSW) Thomas	Digitally signed by Stan (TSW) Thomas Date: 2019.08.29 15:54:48 -04'00'
WELD ENGINEER: J.W. Folk	John W (FJB) Folk	Digitally signed by John W (FJB) Folk Date: 2019.08.28 10:30:25 -04'00'	QUALITY ENGINEER: J.R. Burchfield	Jason (JR6) Burchfield	Digitally signed by Jason (JR6) Burchfield Date: 2019.08.28 10:35:20 -04'00'
NUCLEAR PROD. ENGINEER: J.E. Cook	Jeffrey E (2XK) Cook	Digitally signed by Jeffrey E (2XK) Cook Date: 2019.08.28 10:53:03 -04'00'			

RECEIPT INSPECTION CHECKLIST	DOC TYPE	RIC DOC. #	PART #	REV. #	PAGE
Form instructions – EPD Preparer should complete all spaces pertaining to the specification of the item (shown in red). The individual performing receipt inspection should complete all spaces pertaining to the inspection of the received item (shown in blue). Multiple copies of the RIC may be used for POs with multiple items. Attach comments & other documentation as needed					1 of 3

A. GENERAL INFORMATION

SPECIFIED

ITEM DESCRIPTION	UNID
ES-3100 Drum Assembly	YAREA-CMH-042

QUALITY LEVEL	PROTECTION LEVEL	SAMPLE SIZE: BASED ON NORMAL SAMPLING PLAN IN ACCORDANCE WITH Y17-69-316 CHAPTER 6, ATTACHMENT 6-C	PROCUREMENT QUALITY STRATEGY
Q	C		Evaluated

RECEIVED

ITEM DESCRIPTION	SAT Y or N	INITIALS	DATE

PO#:	ITEM #	QTY ORDERED:	SHIPMENT COMPLETE or PARTIAL	SHIPMENT #: of	QTY REC'D/ LOT SIZE:	QTY INSPECTED/ SAMPLE SIZE:

RELATED APPROVED WAIVERS/DEVIATIONS:

B. SUPPLIER PACKAGING, HANDLING, SHIPPING, & STORAGE (INCL. MAINTENANCE)

SPECIFIED: Per the approved plan for packaging, handling, shipping, and storage as noted in Equipment Specification.

RECEIVED:	SAT Y or N	INITIALS	DATE

C. ITEM SUPPLIER/MANUFACTURER INFORMATION

	IF SPECIFIED AS A REQUIREMENT	RECEIVED
SUPPLIER/MFR	PER THE PURCHASE ORDER	
MANUFACTURER	PER THE PURCHASE ORDER	
MODEL #	N/A	
PART #	N/A	
		SERIAL #:

	SAT Y or N	INITIALS	DATE
Suspect/Counterfeit Item Inspection, Review of S/CI Notifications & Item Markings			

D. MEASUREMENT AND TEST EQUIPMENT (M&TE used for receipt inspection) *(add additional pages if needed)*

M&TE TYPE	M&TE NUMBER	CALIBRATED RANGE	TOLERANCE	CAL. DUE DATE

E. COMPANY PACKAGING, HANDLING, SHIPPING, & STORAGE (INCL. MAINTENANCE)

SPECIFIED: PROTECTION LEVEL C

Communicated requirements to Company Material Management	Y or N	INITIALS	DATE

RECEIPT INSPECTION CHECKLIST	DOC TYPE	RIC DOC. #	PART #	REV. #	PAGE
F. SALIENT FEATURE EVALUATION					2 of 3

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Material properties of Body Weldment Arc Weld Stud	INSPECTION	PQE	PQR	PQE	Y, N, N/A

	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
	CMTR verifying that material is in accordance with ASTM A493 or ASTM F593 for S30400 OR S30403 material per drawing M2E801580A002.		Y or N		

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Material properties of Inner Liner 2x2x1/4 Modified Angle	INSPECTION	PQE	PQR	PQE	Y, N, N/A

	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
	CMTR verifying that material is in accordance with ASME SA479 Tables 1 and 2 for S30400 OR S30403 material per drawing M2E801580A003.		Y or N		

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Material properties of the Inner Liner including the Upper Outer Ring, Upper Floor Plate, Lower Outer Ring, Lower Inner Liner, and Bottom Plate	INSPECTION	PQE	PQR	PQE	Y, N, N/A

	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
	CMTR verifying that material is in accordance with ASME SA240 Tables 1 and 2 for S30400 OR S30403 material per drawing M2E801580A003.		Y or N		

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Material properties of Double Open Head Reinforced Drum	INSPECTION	PQE	PQR	PQE	Y, N, N/A

	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
	CMTR verifying that material is in accordance with ASME SA240 Tables 1 and 2 for S30400 OR S30403 material per drawing M2E801580A004.		Y or N		

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Material properties of Drum Flat Cover	INSPECTION	PQE	PQR	PQE	Y, N, N/A

	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
	CMTR verifying that material is in accordance with ASME SA240 Tables 1 and 2 for S30400 OR S30403 material per drawing M2E801580A005.		Y or N		

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Material properties of 11 GA (.1197) Sheet	INSPECTION	PQE	PQR	PQE	Y, N, N/A

	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
	CMTR verifying that material is in accordance with ASME SA240 Tables 1 and 2 for S30400 OR S30403 material per drawing M2E801580A006.		Y or N		

RECEIPT INSPECTION CHECKLIST	DOC TYPE	RIC DOC. #	PART #	REV. #	PAGE

F. SALIENT FEATURE EVALUATION — 3 of 3

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Material properties of 18.25" Diameter Drum Lid	INSPECTION	PQE	PQR	PQE	Y, N, N/A

	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
	CMTR verifying that material is in accordance with ASME SA240 Tables 1 and 2 for S30400 OR S30403 material per drawing M2E801580A007.		Y or N		

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Material properties of the Top Plug including the Top Sheet, Bottom Sheet and Plug Rim	INSPECTION	PQE	PQR	PQE	Y, N, N/A

	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
	CMTR verifying that material is in accordance with ASME SA240 Tables 1 and 2 for S30400 OR S30403 material per drawing M2E801580A008.		Y or N		

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Material properties of Lifting Insert	INSPECTION	PQE	PQR	PQE	Y, N, N/A

	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
	CMTR verifying that material is in accordance with ASME SA479 Tables 1 and 2 for S30400 OR S30403 material per drawing M2E801580A008.		Y or N		

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Dimensional Requirements of Drum Assembly	INSPECTION	PQE	PQR	PQE	Y, N, N/A

	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	SAT	INITIALS	DATE
	Inspection requirements shown per RIC Attachment.	Y or N		

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Product Identification	INSPECTION	PQE	Visual Inspection	PQE	Y, N, N/A

	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
	Verify Containers Inspected at the Supplier's Facility are the Containers Received at Y-12 by Drawing No. with Rev., Purchase Order No., and Serial No. and that No Visual Damage has Occurred during Shipment.		Y or N		

G. DISPOSITION

APPLICABLE PQR # AND/OR NCR #: ATTACH COMMENTS & OTHER DOCUMENTATION AS NEEDED	QUANTITY APPROVED:	QUANTITY REJECTED:

H. AUTHORIZATION

EVALUATOR SIGNATURE	ORGANIZATION	BADGE	DATE

RIC ATTACHMENT

SERIAL #:	

DRAWING	REQUIREMENTS (ACCEPT. CRITERIA W/TOL./RANGE)	ACTUAL
M2E801580A002 (LOCATION WITHIN DRAWING IS IN PARENTHESIS)	277-4 MAX DEPTH .25± 03 (C4)	
	ARC WELD STUD POSITION OF .04 TO DATUM B (D3)	
	DEPTH OF INNER LINER .67±.03 FROM TOP OF DRUM WALL/DATUM A (B3)	
	INNER LINER MODIFIED ANGLE FLAT TO WITHIN .06 (B3)	
	WELD QUALITY OF MODIFIED ANGLE TO DRUM (B3)	
M2E801580A003 (LOCATION WITHIN DRAWING IS IN PARENTHESIS)	INSIDE DIAMETER OF MODIFIED ANGLE 14.77±.06 (E7)	
	INSIDE DIAMETER OF LOWER OUTER RING 8.60±.06 (E7)	
	LOWER OUTER RING RUNOUT OF .06 TO DATUM B (E7)	
	INNER LINER MODIFIED ANGLE FLAT TO WITHIN .06 (C3-C4) NOTE: PRIOR TO WELD TO BODY	
	INNER LINER TOTAL HEIGHT 38.25± 03 (C8)	
	LOWER INNER RING HEIGHT 30.83±.04 (C8)	
	LOWER INNER RING INSIDE DIAMETER 6.24±.03 (B7)	
	LOWER INNER RING RUNOUT OF .06 TO DATUM B (B7)	
	MODIFIED ANGLE MIN THICKNESS .20±.03 (G2)	
	DEPTH FROM DATUM A TO TOP OF UPPER FLOOR PLATE 5.22±.06 (G5)	
	DEPTH FROM DATUM A TO TOP OF LOWER INNER RING 7.42±.03 (F5)	
	LOWER INNER RING 2:1 ELLIPTICAL RADIUS PRIOR TO WELDING (D4)	
M2E801580A005 (LOCATION WITHIN DRAWING IS IN PARENTHESIS)	DRUM FLAT COVER CENTER HEIGHT .32± 20 (B4)	
M2E801580A006 (LOCATION WITHIN DRAWING IS IN PARENTHESIS)	DRUM LID HOLE (8X) .875 DIAMETER THRU ON 16.00 BOLT CIRCLE, TRUE POSITION OF .02 TO DATUMS A,B (G6)	
	11 GAGE SHEET INSIDE DIAMETER 13.75± 12, TRUE POSITION OF .06 TO DATUMS A,B (C7)	
	18.25 DIAMETER DRUM LID BOTTOM SURFACE FLATNESS OF .06 (D3)	
M2E801580A008 (LOCATION WITHIN DRAWING IS IN PARENTHESIS)	TOP PLUG RIM HEIGHT 4.94± 09 (B3)	
	TOP PLUG RIM OUTSIDE DIAMETER 14.37± 06 (B3)	

TABLE OF CONTENTS

1.0 SCOPE **2**
1.1 General Description of the Item 2
1.2 Background 2

2.0 REFERENCES **2**
2.1 Definitions 2
2.2 Codes/Standards/Orders/Regulations 3
2.3 Applicable Documents 4

3.0 ITEM REQUIREMENTS **4**
3.1 Performance Requirements 5
3.2 Design Requirements 5
3.3 Fabrication and Assembly Requirements 7
3.4 Requirements 8
3.5 Government-Furnished Equipment 13
3.6 Final Examination of Finished Surfaces 13
3.7 Dimensional Inspection 13
3.8 Schedule (Specify to be submitted for approval) 14
3.9 Deliverables (Including Submittals) 15
3.10 Packaging, Handling, Shipping, and Storage Requirements 15
3.11 Marking and Identification Requirements 15
3.12 Requests for Waiver or Deviation 16
3.13 Documentation Retention 16
3.14 Use of Subcontractors 16
3.15 Witness of Documentation and Processes 16
3.16 Nonconformance Control 17
3.17 Approved Procedures 17

4.0 QUALITY ASSURANCE REQUIREMENTS **17**
4.1 Final Acceptance Method 17
4.2 Inspection/Testing Requirements 17
4.3 Quality Requirements 18
4.4 Acceptance Criteria 18
4.5 Personnel Qualifications/Certifications 19

Attachment A: Submittal Checklist 20
Attachment B: Instruction to Supplier for Preparation of Submittals 23
Attachment C: Abbreviations and Acronyms 24

1.0 SCOPE

This specification, the Company's drawings, referenced codes, standards, and the documents referenced herein provide the requirements for the procurement of materials and components, fabrication, inspection, examination, assembly, documentation, and testing of a ES-3100 Drum Body Assembly.

The Drum Assembly will be manufactured in accordance with the applicable requirements stated in the American Society of Mechanical Engineers (ASME) Boiler and Pressure Vessel Code (B&PVC), hereinafter referred to as the ASME Code, Section III, Division 1, Sub-section NB for Class 1 Components as described on the Company's drawings and in this specification. The reference to the Inspector in any of the ASME Codes shall in this particular case be that person designated by the Company.

If conflicting requirements appear in these documents, the Supplier shall immediately notify the Company Subcontract Technical Representative (STR) for resolution.

The Supplier shall not deviate from the requirements of this specification without prior written consent from the Company. Requests for changes or deviations shall be submitted on form UCN-13816B, Request for Waiver or Deviation (RFWD), and the latest RFWD form may be requested from the Subcontract Administrator (SA) or STR.

1.1 General Description of the Item

The Drum Assembly is a confinement barrier capable of aiding in maintaining the content quality during and after designated accident scenarios.

1.2 Background

The ES-3100 Shipping Package is a general-purpose fissile material container accommodates many forms of highly enriched uranium (HEU) and other special nuclear materials in bulk quantities for ground and air transport.

2.0 REFERENCES

2.1 Definitions

Company – The Company, as used in this specification, is the buyer of the Supplier's final product (i.e., Y-12 National Security Complex)

Deviation - A specific written authorization, granted by the Company **prior to the manufacture** of an item, to depart from a subcontract requirement for a specific piece or pieces of equipment or a specified period of time.

First Article - Product that is submitted to the Company for evaluation prior to the Supplier being released to manufacture the remaining quantities in the subcontract. This product must be representative of production items by virtue of having been produced and inspected using the same facilities, testing, processes, and type of personnel planned for use in production.

First Article Evaluation (FAE) – An evaluation by the Company of the first unit(s) manufactured and the facilities, tooling, processes, etc. concerned with the manufacture and inspection.

Hold Point - A hold point is defined as the designated point(s) in the fabrication where the Supplier will stop and hold further production. The Company contact will be provided production data and will decide if it will be necessary to visit the manufacturing facility or if the supplied data will be sufficient.

Manufacturing Plan – A written, step-by-step, process plan for the equipment to be fabricated. The plan includes material control, major fabrication steps, hold points, all in-process inspections, welding, welding inspection/examination, dimensional inspections, testing, and shipping.

Non-conformance - A deficiency in characteristic, documentation, or procedure that renders an item to be in non-compliance with specified requirements.

Offeror - The Organization or person(s) submitting an offer to the Company to provide the product(s) described.

Request for Waiver or Deviation (RFWD) - A formal request by the Supplier for a waiver or deviation to the equipment specification, drawing, or PO using the Company form, which can be provided by the SA or STR. The form must be approved by the Company in writing before the Supplier being granted authorization to proceed.

Supplier - Any individual or organization that furnishes items or services in accordance with a purchase order. Also an all-inclusive term used in place of the following: vendor, seller, subcontractor, dealer, fabricator, consultant, manufacturer, distributor, and their sub-tier levels.

Subcontract Administrator - The person(s) designated in the subcontract as having authority to act officially for the Company.

Subcontract Technical Representative (STR) – The Subcontract Technical Representative, as used in this specification, is the person designated by the Subcontract Administrator as having the authority to represent the Company in technical matters.

Traveler - A written, step-by-step, process document used for the control of components/equipment to be fabricated. The traveler includes material identification, all fabrication steps, hold points, all in-process inspections, welding, welding inspection/examination, dimensional inspections, testing, and preparation for shipping.

Waiver - A specific written authorization, granted by the Company, to accept a configuration item or other designated items which, during production or after having been submitted for inspection, are found to depart from specified requirements, but are considered suitable for use as is or after rework by an approved method.

Witness Point - The Witness point is similar to the hold point except the manufacturing, testing or inspection is halted until the Company representative(s) can visit the manufacturing facility and witness the designated operations.

2.2 Codes/Standards/Orders/Regulations

Drum Assemblies shall be fabricated, inspected, and tested according to the design drawings and the applicable documents referenced herein.

- American Society of Mechanical Engineers, Boiler and Pressure Vessel Code, Section III, Division 1, 2019.

- American Society of Mechanical Engineers, Boiler and Pressure Vessel Code, Section II, Parts A and C, 2019.

- American Society of Mechanical Engineers, Boiler and Pressure Vessel Code, Section V, 2001 2019.

- American Society of Mechanical Engineers, Boiler and Pressure Vessel Code, Section IX, 2019.

- American Society for Nondestructive Testing, No. SNT-TC-1A, Recommended Practice for Nondestructive Testing Personnel Qualification and Certification, 2016.

- American Society for Testing Materials, ASTM A 380-17, Standard Practice for Cleaning, Descaling, and Passivation of Stainless Steel Parts, Equipment and Systems.

- Military Standard, MS27683, Drum, Metal-Shipping and Storage 16 to 80 Gallons.

All references to the ASME Code in this document are to the ASME Boiler and Pressure Vessel Code, 2019 Edition.

2.3 Applicable Documents

Drawings:

M2E801580A001	Drum Assembly
M2E801580A002	Body Weldment
M2E801580A003	Inner Liner Weldment
M2E801580A004	Double Open Head Reinforced Drum
M2E801580A005	Misc. Details
M2E801580A006	Drum Lid Weldment
M2E801580A007	18.25" Diameter Drum Lid
M2E801580A008	Top Plug Weldment
M2E801580A010	Data Plates
M2E801580A031	Main Assembly

Specification(s):

SPC JS-YMN3-801580-A001	Containment Vessel
SPC JS-YMN3-801580-A005	Casting Catalog No. 277-4 Neutron Absorber for the ES-3100 Shipping Package
SPC M801794-0003	Packcrete Preliminary Lot Qualification
SPC M801580-0003	ES-3100 Packcrete Final Lot Qualification and Production Processing
DS 801580-0001	ES-3100 Shipping Container Modified Hex Nut

3.0 ITEM REQUIREMENTS

The Supplier shall be responsible for supplying all materials, services, facilities, and equipment to meet the requirements of this specification and Company drawings unless otherwise noted.

3.1 Performance Requirements

3.1.1 Boiler and Pressure Vessel Code Compliance

3.1.1.1 The drum assembly shall be manufactured in accordance with those paragraphs of the American Society of Mechanical Engineers (ASME) Boiler and Pressure Vessel Code, Section VIII, Division 1 that are specified in this document. A certificate of compliance to the code shall be supplied to the Company.

3.1.1.2 The drum assemblies are not pressure vessels and are not to be hydrostatically tested, nor are they to be stamped.

3.1.1.3 The Supplier shall hold a Certificate of Authorization from the ASME that authorizes it to manufacture and inspect pressure vessels in accordance with Section VIII or Section III of the ASME Code. If the Supplier does not have a certificate of authorization for Section VIII or III, the Supplier shall provide data with its offer that demonstrates its ability to meet the requirements in Subsections NB and NCA as referenced in this specification.

3.2 Design Requirements

3.2.1 Materials and Material Examinations

3.2.1.1 Material requirements are specified on Company drawings, in this specification, and in the documents referenced in this specification.

3.2.2 Certified Material Test Reports (CMTR's)

3.2.2.1 Except for the weld studs, documented Certified Material Test Reports (CMTR's) shall be provided to the Company for all materials used in weldments for the fabrication of the drum assembly, including weld filler metal.

3.2.2.2 CMTR's shall be traceable to heat numbers and shall demonstrate compliance with the applicable SA or SFA material specifications.

3.2.2.3 For materials not used in weldments, Certificates of Conformance (CoC's) shall be provided to the Company certifying that the materials provided comply with the requirements stated on the Company's drawings and specifications as referenced in Section 3.2.5.

3.2.2.4 Materials shall be traceable to each drum assembly's serial number.

3.2.2.5 Supplier shall transfer heat numbers and serial numbers to base materials used in weldments to maintain control of materials to ensure this traceability.

3.2.2.6 Results of these examinations shall be included with the CMTR's provided to the Company.

3.2.2.7 Weld filler metal used in the fabrication and repair of the drum assemblies shall be procured to comply with ASME BPVC Section III, Rules for Construction of Nuclear Facility Components -

Sub-section NCA General Requirements for Division 1 and Division 2- Article NCA-3800 and shall comply with the SFA specifications of Section II; Part C of the ASME Code.

3.2.2.8 Weld filler metal shall be traceable to heat numbers and CMTR's shall be furnished to the Company for each heat of weld filler metal used.

3.2.2.9 Results of the delta ferrite determination shall be included with the CMTR for the weld filler metal (see NB-2433) and shall be a minimum of 5 FN.

3.2.2.10 Weld examiner shall be able to determine the heat number of the weld filler used in each weld on each drum body assembly.

3.2.3 Hold points and Witness points

Hold points and Witness points will be required as noted below.

- For the FAE units, QA Witness Points will be the Dimensional Inspection.
- QA witness points and hold points will be determined based on the submitted manufacturing schedule and in accordance with a normal sampling plan based on the total PO quantity in accordance with Y17-69-316 Chapter 6, attachment 6-C. For the Production Units, QA Witness Points shall include at a minimum the Dimensional Inspection. Other processes may be selected.

3.2.4 First Article Evaluation (FAE)

The Company shall conduct an FAE in two (2) phases in accordance with this specification.

3.2.4.1 In Phase I the Company will conduct a review of the Supplier's process control forms and manufacturing procedures. The Supplier shall furnish an electronic copy of all procedures, travelers, data entry forms, processing records, and related data used by the Supplier to define and/or control those aspects of the manufacturing, testing, and inspection operations that influence the quality of the product being produced prior to fabrication, in accordance with schedule dates described in the subcontract.

3.2.4.2 Phase II of the FAE shall consist of audits and such examinations, inspections and testing oversight as deemed appropriate by the Company at the Supplier's site. The results of these audits and examinations will be evaluated to determine final acceptance of the FAE parts and release to produce production quantities.

3.2.4.3 The Supplier shall not proceed to manufacture parts beyond the initial First Article quantity until a successful FAE has been completed and written notification to proceed has been received from the Company's subcontract administrator.

The criteria established for the performance of the FAE, and subsequent production, shall also apply to the Supplier's subcontractors and sub-tier subcontractors as deemed appropriate by the Company. A listing of any such subcontractors and their involvement shall be submitted to the Company. The Company reserves the right to provide oversight of these proposed Subcontractors if deemed necessary. Signed approval of the proposed Subcontractors shall be received by the Supplier from the Company STR prior to proceeding with fabrication.

3.2.4.4 Once the Company has approved an FAE, any subsequent process changes by the Supplier to manufacturing and acceptance procedures, facilities, type of personnel, testing, etc., which could conceivably impact product quality, shall require the Supplier to notify the STR of the proposed changes. The STR shall then determine if a new First Article Evaluation is warranted.

3.2.5 Certificates of Conformances (CoCs)

CoCs for procured items shall meet the following requirements:

a. The CoC shall identify the purchased item by the purchase order number.

b. The CoC shall identify the specific procurement requirements met by the purchased item, such as codes, standards, and other specifications. This may be accomplished by including a list of the specific requirements or by providing a copy of the purchase order and the procurement specifications or drawings, together with a suitable CoC.

c. The CoC shall identify any approved changes, waivers, or deviations applicable to the item.

d. The CoC shall identify any procurement requirements that have not been met, together with an explanation and the means for resolving the request for waiver or deviation.

e. The CoC shall be signed or otherwise authenticated by a person who is responsible for this quality assurance function and whose function and position are described in the quality assurance program of the Supplier.

f. The Supplier's certification system, including the procedures to be followed in filling out a CoC and the administrative procedures for review and approval of the certificates, shall be described in their quality assurance program.

3.3 Fabrication and Assembly Requirements

The Supplier shall prepare a written, step-by-step, controlled manufacturing plan for all work to be performed. This plan shall include at a minimum:

a. Materials to be procured
b. Suppliers to be used
c. Quality Program used to buy or manufacture each subassembly
d. Major fabrication steps (sequence of operations)
e. Equipment to be utilized
f. All in-process checks
g. All welding
h. All weld inspection/examination including Non-Destructive examination and testing
i. Dimensional inspection.

3.4 Requirements

3.4.1 Welding and Weld Repair (If Required)

3.4.1.1 All welds on the drum assemblies shall be done either by the GTAW, GMAW, or PAW process, manual or automatic, at the discretion of the Supplier unless specified otherwise on the drawings.

3.4.1.2 Weld symbols are provided on the Company's drawings indicating for each weld the type of weld and dimensions of weld.

3.4.1.3 Butt welds in rolled sheet, pipe and angle joints shall be full penetration butt welds.

3.4.1.4 Markings on the weldment materials shall not be removed until after all weld examination is complete.

3.4.1.5 Welding shall be done in accordance with welding procedure specifications that are written and performance qualified in accordance with the ASME Code, Section IX.

3.4.1.6 Welders shall be performance qualified to weld using these procedures, and their qualifications documented in accordance with the ASME Code, Section IX.

3.4.1.7 Welding fabrication requirements stated in the ASME Code, Section VIII, Division 1, paragraphs UW-26 through UW-48 shall be met.

3.4.1.8 Welders performing two or more welds in one day that are rejected based upon welder technique shall be re-qualified to the appropriate welding procedures. Reference Section IX, and paragraph QW-320 of the ASME Code.

3.4.1.9 If a weld is rejected, the area may be reworked by the Supplier and re-examined. After two unsuccessful repair attempts, the Company shall be notified for approval to perform more repair attempts. The Company may, at its option, choose to reject further repair efforts and require that a replacement part be fabricated.

3.4.1.10 Prior written approval of the Company shall be obtained for any weld repair on base materials, and the weld repair areas shall be noted in a Request for Waiver or Deviation (RFWD) Form accompanied by a sketch and the CMTR for the material to be weld repaired. Note that depending on the specific defect in a specific material, the Company may or may not approve the weld repair, even if it is permitted by the material specification.

3.4.1.11 The Supplier shall submit welding information as Appraisal Data in accordance with Attachment A.

a. Job Specific Welding Procedure Specifications (WPS)

b. Job Specific Welding Procedure Qualification Record for each WPS submitted (unless WPS is prequalified (PQR).

c. Job Specific Welder Performance Qualification (WPQ) records, including evidence of process usage updates

d. Job Specific Visual examination and Nondestructive examination procedures

e. Job Specific Certification records of examination personnel

f. Job Specific Post Weld Heat Treatment (PWHT) procedures with appropriate procedure demonstrations (as required) and Supplier's acceptance documentation

g. Provide a list of all welded assemblies not fabricated in accordance with Supplier's welding program. Include any welded assemblies to be purchased as commercial-off-the-shelf

3.4.1.12 The Supplier shall submit welding information as Approval Data in accordance with Attachment A.

a. Welding procedure specifications (WPS)

b. Procedure Qualification Records (PQR) for each WPS submitted (unless WPS is prequalified)

c. Welder Performance Qualification (WPQ) records, including evidence of process usage updates.

d. Roster of all welders to be used to perform work with continuity/expiration dates identified for each process the welder is qualified

e. Updated records (Roster) as required throughout the contract duration, to demonstrate welders submitted have maintained their qualifications

f. NDE-Visual examination and nondestructive examination procedures, VT, MT, PT, RT, UT (as applicable)

g. NDE-Certification records of examination personnel

h. NDE-Procedure for Qualification and Certification of Nondestructive Testing Personnel

i. NDE-Current eye examination record (Annual) for examination personnel

j. Certified Material Test Report (CMTR) for weld filler materials (as required) for each Heat/Lot to be used

k. Weld filler material control procedure

l. Welding fabrication drawings for all welded components

m. Weld examination records, weld maps, radiographs, and PWHT chart recordings

3.4.1.13 Nonconforming Welds

Completed welds that have been inspected and accepted but are later found not to be in compliance shall be documented and submitted to the Company on a nonconformance report in accordance with Supplier's nonconformance procedure. The Supplier's nonconformance procedure shall include language to address welding nonconformances that occur due to both procedural and hardware deficiencies. If a repair by welding is required, the Supplier shall complete a repair procedure that includes the WPS with specific instructions for repair. Additional supporting documents, as required, to make the repairs shall be submitted to the Company. Company approval of the repair procedure shall be obtained before commencing the repairs. Every nonconformance report (NCR) dispositioned "Use-As-Is" or "Repair" requires written concurrence from the Company accepting the disposition and technical justification before continuing work associated with the Nonconformance. A disposition of Rework does not require Company approval. A submittal of the Supplier's nonconformance procedure shall be submitted to the Company in accordance with the Submittal checklist, Attachment A.

3.4.1.14 Weld Filler Material Requirements

a. Weld Filler Material (WFM) shall be selected that matches the base metal as close as possible for mechanical and corrosion resistant properties and be listed on the Welding Procedure Specification (WPS).

b. WFM shall be specified as manufactured in accordance with recognized ASME standards where possible. Use matching WFM or material recommended by the base metal supplier when there is no existing WFM with an assigned AWS classification.

c. Purchase weld electrodes/filler materials with a CMTR as identified in Section 3.6.1.15 below. Submit a Certified Material Test Report (CMTR) for WFM to be used. The reporting requirements are specified in the "Test Requirements for CMTRs" table(s) below for the listed WFM. The CMTR shall provide traceability to the Supplier's purchase order for each heat/lot received. For WFM without an SFA classification, provide the same level of testing, product marking, and packaging, etc. that is required for WFM with a SFA Classification. Use the Supplier's standard designation in lieu of the SFA classification to mark each piece of WFM and the shipping package.

d. All WFM shall meet the requirements of ASME BPVC Section II Part C, *Specification for Welding Rods, Electrodes, and Filler Metals*, except as noted.

3.4.1.15 Weld Filler material Procurement Requirements

a. Weld Filler Material (WFM) and fluxes shall be purchased from manufacturers or suppliers with established Quality System Programs that meet the requirements of ASME BPVC Section III, Rules for Construction of Nuclear Facility Components – Sub-section NCA General Requirements for Division 1 and Division 2- Article NCA-3800 Metallic Material Organization Quality System Program and are active NCA 3800 Quality System Certificate (QSC) holders. The manufacturer or supplier that holds the certificate shall be evaluated by the Supplier and be currently listed on their Quality Approved Suppliers List (QASL).

b. The procurement requirements for WFM apply to all WFM utilized by Supplier organizations that procure their own welding materials. The Supplier at their discretion may elect to procure and use materials to stricter standards. The sections below list the level of Certification for the most commonly used WFM classifications for various applications. Other classification WFM are permitted with the prior approval of the Company. All WFM shall be procured in accordance with material designation (SFA) ASME BPVC Section II SFA 5.01, Procurement Guidelines for Consumables - Welding and Allied Processes - Flux and Gas Shielded Electrical Welding Processes. The level of certification and testing required for these alternate materials shall be the same as required for the similar components described below.

3.4.1.15.1 Weld Filler Material for Stainless Steel Base Materials

Shall comply with ASME BPVC Section II SFA 5.9, Specification for Bare Stainless Steel Welding Electrodes and Rods:

a. Use classification ER308L filler materials for welding 304 or 304L stainless steel base materials. When CMTRs are required, the reports shall also record a minimum delta ferrite of 5 ferrite number and test method.

b. The maximum acceptable carbon content for all "L" grade (low carbon) weld filler material is 0.03%. Heat analysis of weld deposit shall be performed to determine the chemical composition of the material.

3.4.1.15.2 Test Requirements for CMTRs

ASME SPECIFICATION	ASME SFA 5.01 TEST REQUIREMENTS					
	Lot Class	Level of Test	Chemical Analysis	Tensile	Soundness	Impact
5.9 Bare Stainless Steel Welding Electrodes and Rods	S3 or S4	I	Rod/Wire	No	No	No

3.4.2 Weld and Surface Examination (If Required)

Personnel Certification Requirements for Weld Examinations

a. Personnel performing nondestructive examination other than visual shall be currently certified per the employer's written practice in accordance with SNT-TC-1A. Only individuals certified as NDT Level II or III may perform nondestructive examinations in accordance with this specification.

b. Personnel performing visual examination of welds shall be currently certified either as an AWS CWI or as a visual testing Level II or III per the employer's written practice in accordance with SNT-TC-1A. (Note: Eye exams shall be performed on an annual basis and comply with Jaeger 1 visual acuity.)

c. The Level III, in the methods certified, shall conduct the examination of Level II personnel for those same methods.

3.4.2.1 NDE Weld examination procedures shall meet the requirements of the ASME Code, Section V.

3.4.2.2 Certified weld examination reports shall be submitted in accordance with Attachment A for all weld examinations and shall include:

a. Drum assembly serial number
b. A weld map showing the location of the weld
c. Welder's ID
d. Examiner's name
e. The time and date of the weld examination
f. Examination procedure used
g. Welding procedure specification (WPS) number for each weld
h. Heat numbers of the materials joined
i. Heat number of the weld filler
j. Examiner's remarks

3.4.2.3 The examiner's remarks shall include the results of the examination, and acceptance or rejection of the weld based on the stated criteria, and shall include a description and sketch showing the location of any defects.

3.4.2.4 The acceptance criteria for joint fit-up and alignment, and for visual examination of welds are given in the ASME Code, Section VIII, Division 1, paragraphs UW-31 through UW-36. In addition, any visible defects such as lack of fusion, lack of penetration, linear or crack like defects, and visible porosity, are unacceptable.

3.4.3 Cleaning and Passivation

3.4.3.1 After final machining and examination of all welds except the attachment welds for the drum body final closure weld of the drum lid weldment, and prior to filling with Packcrete and Catalog No. 277-4 (see SPC M801580-0003 and SPC JS-YMN3-801580-A005), clean and passivate all stainless steel surfaces of the drum assembly in accordance with ASTM A 380. A certified record of completion of this cleaning step shall be submitted to the Company in accordance with Attachment A.

3.4.3.2 On drawing M2E801580A002 verify that the drum bottom or Packcrete fill hole diameter, where the drum flat cover is assembled and welded to the drum body is round or circular to a tolerance of ±0.03 in. before filling with Packcrete. If not adjust and rework the drum body until it is round or circular to a tolerance of ±0.03 in.

3.4.3.3 After weld examination, cleaning, and passivation for the drum body and drum lid weldment, follow SPC M801580-0003 to fill with Packcrete.

3.4.3.4 After the closure weld on the top plug weldment and the attachment weld on the drum body bottom are examined, clean and locally passivate the weld areas and heat affected zone areas. A certified record of completion of this cleaning step shall be submitted to the Company in accordance with Attachment A.

3.4.3.5 Cleaning procedures for the stainless steel, including weld areas, shall be submitted to the Company for approval, prior to the start of fabrication, in accordance with Attachment A.

3.4.3.6 Finished components awaiting assembly and final drum assemblies shall be free of dirt, debris, foreign objects, cutting fluids, metal chips, grinding residue, and other foreign substances.

3.4.3.7 The Supplier shall clean, cover, and protect parts and subassemblies from becoming dirty while in storage, and to the extent practicable, in the shop environment while performing work.

3.4.3.8 Only non-chloride bearing chemicals shall be used for cleaning (such as trisodium phosphate detergent or acetone).

3.4.3.9 A list of cleaning chemicals to be used shall be submitted for approval in accordance with Attachment A. Safety Data Sheets (SDS) of all cleaning chemicals shall be provided to the Company before use.

3.4.3.10 Water used in cleaning shall have a maximum chlorine content of 4 parts per million tested monthly.

3.4.3.11 Certified cleaning and passivation procedure and report shall be submitted in accordance with Attachment A.

3.5 Government-Furnished Equipment

3.5.1 Modified Hex Nut

Modified Hex Nuts per DS 801580-0001 shall be supplied by the Company

3.6 Final Examination of Finished Surfaces

3.6.1 All accessible welds of the drum assembly (drawing M2E801580A001, M2E801580A002, and M2E801580A004), the drum body liner (drawing M2E801580A003), the drum lid (drawing M2E801580A006), and the top plug (drawing M2E801580A008) shall be examined with liquid penetrant in accordance with NB-2546 (see Section 3.4 for additional requirements for the materials used in liquid the penetrant examination).

3.6.2 The procedure for final surface examination including sample test reports shall be submitted to the Company for approval in accordance with Section 4.1.1 and Attachment A.

3.6.3 The results of the final surface examinations shall be documented in a certified examination report and provided to the Company in accordance with Section 4.1.1 and Attachment A.

3.6.4 If a defect is found, the component shall be tagged and segregated to prevent inadvertent use, and the Company shall be notified in writing using the RFWD in accordance with Section 3.12 and Attachment A, for disposition.

3.6.5 Defective areas may be weld repaired by the Supplier only if specifically permitted by the Company in writing, and the area re-examined. The Company may, at its option, choose to reject repair efforts and require that a replacement part be fabricated.

3.7 Dimensional Inspection

3.7.1 The Supplier shall submit inspection procedures for Company approval in accordance with Attachment A.

3.7.2 Dimensional requirements specified on the Company's drawings require inspection procedure that shall include:

a. A listing of features to be inspected
b. Identification of inspection equipment to be used inspect each dimension or tolerance
c. Sample data sheets with adequate data recording space to record inspection results
d. Adequate information to ensure traceability of inspection data to specific serial numbered drum assemblies

3.7.3 The Supplier shall be responsible for determining stock sizes so that the finished machined components meet the dimensions and tolerances specified on the attached drawings.

3.7.4 Prior to performing final inspection, the Supplier shall perform all deburring and cleaning operations required to ensure that drum assembly is free of all fabrication and handling defects and that no foreign materials are present on the drum assembly surfaces or features.

3.7.5 Inspection, Measuring and Test Equipment shall be calibrated and certified by an organization with ISO 17025 accreditation, or Company approved equal, and traceable to the National Institute of Standards. Documentation shall be submitted in accordance with the attachment A, Submittal Checklist.

3.7.6 Where inspection or test equipment yields quantitative readings, actual measurements and deviation from nominal readings shall be recorded.

3.7.7 The Supplier's inspection shall include, as a minimum, the following:

a. All dimensions and tolerances on Company drawings which are marked with a diamond symbol containing an "I" or "S". These dimensions and tolerances require 100% inspection and documentation. Quantitative documentation of these features shall be provided to the Company for each drum assembly.
b. Edge breaks.
c. Surface finish.
d. Cleanliness as specified in Section 3.4.3.
e. Part identification as specified by the drawings.

3.7.8 Certified inspection report(s) shall be prepared and submitted to the Company in accordance with Attachment A.

3.7.9 Straightening, flattening, and forming of the weldment by mechanical means after welding may be required to ensure proper assembly and fit. The surfaces of areas of the weldment that have been worked shall be examined visually and with liquid penetrant to ensure that no cracks are present and that the weldment has not been degraded. Adjacent welds to these areas shall also be visually and liquid penetrant examined. The acceptance criteria are that no cracks are found in the weldment. The areas worked and the visual inspections performed shall be noted on an inspection report. This metal working and examination shall be performed prior to the installation of Packcrete or Catalog No. 277-4.

3.7.10 All equipment and instruments (Measuring and Testing Equipment (M&TE)) used in the conduct inspections shall bear a calibration sticker that shows the equipment to be within its calibration period. Calibrations must be performed by a laboratory that meets ISO 17025:2005. All calibration sources shall be traceable to the National Institute of Standards and Technology (NIST). All certification documentation shall be submitted to the Company in accordance with Attachment A.

3.8 Schedule (Specify to be submitted for approval)

The Supplier shall prepare a proposed schedule for the fabrication of the ES-3100 Drum Assemblies specified herein. This proposed schedule shall be submitted with the offer in accordance with Attachment A.

The Company will conduct oversight activities. Hold/witness points will be identified by the Company in the Supplier's schedule after it is submitted to the Company for review.

3.9 Deliverables (Including Submittals)

The deliverables for this specification include, but is not limited to:

a. Completed and assembled ES-3100 Drum Assemblies
b. All Requests for Waiver/Deviations shall be closed
c. All submittal documentation in accordance with Attachment A, with applicable documentation in data packages specific to each ES-3100 Drum Assembly identified by its serial number.

The documentation required with the proposal (WP) as indicated in the "Submittal Checklist," Attachment A, shall be submitted to the Company in the quantities listed with the Supplier's offer. Submittals shall be e-mailed to the Company SA and the STR.

The Company will review the submittals that are required prior to fabrication as indicated in the "Submittal Checklist," Attachment A, and respond as shown in the "Instructions to Supplier for Preparation of Submittals," Item h.

The Company shall review the submittals required per Attachment A. Shipping shall not commence without documented permission from the Company.

3.10 Packaging, Handling, Shipping, and Storage Requirements

3.10.1 A packing plan for shipment of Drum Assemblies shall be sent to the Company for approval in accordance with Attachment A.

3.10.2 The packing plan shall include a sketch of the packaging to be used to transport the Drum Assemblies, a list of the documentation that will be included, and a description of the method of transportation.

3.10.3 The drum surfaces must be protected during shipment.

3.10.4 The Supplier shall not ship Drum Assemblies with unapproved RFWD's

3.11 Marking and Identification Requirements

3.11.1 Each drum assembly shall be marked as specified on Company's drawings.

3.11.2 Permanent serial numbers for each drum assembly shall be assigned by the Company and identified in the Purchase Order.

3.12 Requests for Waiver or Deviation

3.12.1 After award, if a waiver or deviation from the specified requirements is desired, then the Supplier shall submit to the Company a Request for Waiver or Deviation form: UCN-13816B. The Company will provide this form upon request.

3.12.2 Use the UCN-13816B form to request permission to change or deviate from the specified requirements; obtain Company approval before proceeding with any changes.

3.12.3 Email the completed form to the Subcontract Technical Representative (STR).

3.12.4 Use the form to report any of the following conditions:

a. A request for deviation from the contract requirements

b. Anytime a requirement contained within the original specification or a contract modification approved by the Company is violated

c. There is nonconformance that cannot be corrected unless an item or process is modified, reworked, or repaired to an equivalent functional condition

d. A request for Company approved substitutions shall be submitted using the RFWD form for Company approval prior to implementation. Adequate information shall be provided with the request so that the Company can determine if the item is equivalent.

3.13 Documentation Retention

3.13.1 Documentation of all inspection and test results shall be maintained by the Supplier for three years after delivery to the Company.

3.13.2 The Company shall be given access to this data upon request.

3.14 Use of Subcontractors

The Supplier shall ensure that all its suppliers and subcontractors comply with the requirements of this specification (including quality assurance requirements). Supplier and subcontractor procedures, approved by the Supplier, shall be included in the procedures submitted to the Company for review and approval.

3.15 Witness of Documentation and Processes

3.15.1 The Company shall be given access to all documentation and shall be allowed to witness any of the processes associated with this specification during the performance of the contract.

3.15.2 The Company shall be informed prior to the start of any testing activities and an agreed upon schedule shall be established. The Company reserves the right to witness any testing activities performed.

3.16 Nonconformance Control

3.16.1 Nonconforming products shall be documented using the Supplier's designated form as required in their QA Plan, and a copy sent to the Company representative.

3.16.2 Deviations or waivers shall be controlled using, Request for Waiver or Deviation, and sent to the Company for approval.

3.17 Approved Procedures

a. Manufacturing, examination, and testing processes shall be controlled by procedure and performed by qualified personnel.

b. Procedures shall incorporate a mechanism to identify process step completion.

c. Procedures shall be submitted to the Company for approval in accordance with Attachment A.

4.0 QUALITY ASSURANCE REQUIREMENTS

4.1 Final Acceptance Method

4.1.1 Final acceptance will be based on the results of the following:

a. Certified Data Package

b. Dimensional inspection reports of each ES-3100 drum assembly in accordance with Section 3.7

c. Any testing witnessed by the Company

d. Submittals listed on Attachment A

e. After all testing, a liquid penetrant report in accordance with NB-2546

4.2 Inspection/Testing Requirements

4.2.1 NDE Examiner Qualifications

4.2.1.1 Qualifications of the personnel performing material or weld examination shall be those provided in NB-5500.

4.2.1.2 Qualification records shall be submitted for approval with the examination procedures in accordance with Attachment A.

4.3 Quality Requirements

The Supplier shall perform all work under a Quality Assurance (QA) Program that complies fully with both 10 CFR 71 Subpart H and NQA-1. If requirements are unclear, or full compliance with both Subpart H and NQA-1 is uncertain, the Supplier shall contact the Company for resolution.

Components (including Packcrete raw materials) are Nuclear Safety Related items. If the Supplier purchases Nuclear Safety Related materials or services from a source that does not have an NQA-1 compliant QA Program, they shall be dedicated in accordance with Commercial Grade Dedication Plans approved by the Company.

For special processes including, but not limited to, flow-forming, heat treating, welding, and NDE, the Supplier shall provide control over activities affecting the quality of the materials and components as necessary to assure conformance to the approved design.

The Supplier shall have implemented and maintain a quality system in accordance with ASME NQA-1 Quality Assurance (QA) Program that meets the requirements of NQA-1 2008, 1a-2009, 1b-2011 Part 1, Section 1-18. A copy of the Supplier's QA Program Manual shall be submitted with the bid in accordance with Attachment A for review and approval. The Supplier shall comply and conduct all work in accordance with their Quality Assurance program and this Equipment Specification.

An uncontrolled copy of the Supplier's controlled QA Program and all applicable subtier suppliers' quality assurance program manuals shall be submitted as Offer Appraisal Data in accordance with Attachment A.

The Supplier shall provide an Excel transmittal or similar file to document the transmission and status of data files. This file shall be updated after each transmission or status change and shall at least identify data by; name, date of transmission, file size, and status (i.e. for review or approval). This file shall be included with the submitted data.

4.3.1 Suspect/Counterfeit Items

The Supplier's QA Program shall implement DOE O 414.1D Attachment 3, with respect to Suspect Counterfeit Items.

Contract terms and conditions that establish the plant's expectations with respect to the Supplier's role in preventing the introduction of Suspect /Counterfeit Items S/CI.

The Supplier's requirements for preventing S/CI from being introduced into the Company's supply chain are referenced in the General Terms and Conditions of the Request for Solicitation and/or Purchase Order.

The Supplier shall use components supplied or assemblies of components from Original Equipment Manufacturer (OEM) or authorized distributors.

4.4 Acceptance Criteria

4.4.1 Approval Data

Approval Data will be reviewed and must be approved by the Company before the Supplier proceeds with the applicable production activity. The Supplier shall schedule at least 4 weeks for Company

review of submittals. A list of the required Approval Data can be found in Attachment A to this specification.

4.4.2 Certified Data

a. A list of the required Certified Data can be found in Attachment A of this specification.
b. An electronic .pdf version of the Certified Data Package shall be provided prior to or with the shipment.
c. The Certificate of Conformance shall be signed by the Supplier and identify the applicable serial number of the containment vessel included in the shipment, one Certificate of Conformance for each Main Assembly (M2E801580A031).
d. The Certificate of Conformance shall attest that the Drum Assembly conforms to the requirements of this specification and Company drawings and approved RFWD's.
e. The assembly drawing number (M2E801580A001) associated with each Drum Assembly shall be recorded on the Certificate of Conformance.
f. The Certified Data package for each Drum Assembly shall be complete, legible, indexed.
g. The Certificate of Conformance shall list the approved RFWD's if applicable.

4.5 Personnel Qualifications/Certifications

4.5.1 Training and Qualification of Personnel

a. The Supplier shall provide for the training and qualification of personnel to ensure their competence in the use of process procedures and specifications.
b. Records of personnel qualifications shall be made available to the Company upon request.

Attachment A: Submittal Checklist

SCHEDULE				FORMAT		PURPOSE	
AA	After Award	PTF	Prior to Fabrication	CD	Compact Disk	FA	For Action
AI	After Issue	PTFA	Prior to Final Acceptance/at Completion	DVD	Digital Video Disk	FI	For Information
AIT	After Inspection Test	PTL	Prior to Lift	EM	E-Mail		
AM	After Mobilization	PTM	Prior to Mobilization	EN	Electronic (Native)		
AP	After Proposal/Bid	PTS	Prior to Shipment	EP	Electronic (PDF)		
ATS	At Time of Shipment (Separately)	PTT	Prior to Test	O	Original		
B	Before Balance of Payment	PTW	Prior to Weld	P	Prints/Photocopies		
NTP	Notice to Proceed	Q	As Required	PH	Photographs		
PTC	Prior to Construction/Commencing Work	R	As Requested	S	Sample		
PTD	Prior to Delivery	WP	With Proposal/Bid	X	X-rays		

#	REFERENCE	REQUIREMENT DESCRIPTION	SCHEDULE	FORMAT	NO. OF COPIES	PURPOSE
1.	3.2.2.1	Certified Material Test Reports (CMTRs)	PTFA	EP	1	FI
2.	3.1.1.1	Certificates of Code Compliance	WP	EP	1	FI
3.	3.12	Request for Waiver or Deviation	Q	EP	1	FA
4.	3.2.5	Certificate of Conformance (when applicable)	PTFA	EP	1	FA
5.	3.8	Proposed contract performance schedule	WP	EP	1	FA
6.	3.7.9	M&TE Calibration Records & Certifications	PTFA	EP	1	FA
7.	3.4.1.13	Nonconformance procedure for welding	WP	EP	1	FA
8.	3.4.1.11.a	Job Specific Welding Procedure Specifications (WPS)	WP	EP	1	FA
9.	3.4.1.11.b	Job Specific Welding Procedure Qualification Record (PQR) for each WPS submitted (unless WPS is prequalified	WP	EP	1	FA
10.	3.4.1.11.c	Job Specific Welder Performance Qualification (WPQ) records, including evidence of process usage updates	WP	EP	1	FA
11.	3.4.1.11.d	Job Specific Visual examination and Nondestructive examination procedures	WP	EP	1	FA
12.	3.4.1.11.e	Job Specific Certification records of examination personnel	WP	EP	1	FA
13.	3.4.1.11.f	Job Specific Post Weld Heat Treatment (PWHT) procedures with appropriate procedure demonstrations (as required) and Supplier's acceptance documentation	WP	EP	1	FA
14.	3.4.1.11.g	Provide a list of all welded assemblies not fabricated in accordance with Supplier's welding program. Include any welded assemblies to be purchased as commercial-off-the-shelf.	WP	EP	1	FA
15.	3.4.1.12.a	Welding Procedure Specifications (WPS)	PTW	EP	1	FA

SCHEDULE				FORMAT		PURPOSE	
AA	After Award	PTF	Prior to Fabrication	CD	Compact Disk	FA	For Action
AI	After Issue	PTFA	Prior to Final Acceptance/at Completion	DVD	Digital Video Disk	FI	For Information
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ATS	At Time of Shipment (Separately)	PTT	Prior to Test	O	Original		
B	Before Balance of Payment	PTW	Prior to Weld	P	Prints/Photocopies		
NTP	Notice to Proceed	Q	As Required	PH	Photographs		
PTC	Prior to Construction/Commencing Work	R	As Requested	S	Sample		
PTD	Prior to Delivery	WP	With Proposal/Bid	X	X-rays		

#	REFERENCE	REQUIREMENT DESCRIPTION	SCHEDULE	FORMAT	NO. OF COPIES	PURPOSE
16.	3.4.1.12.b	Weld Procedure Qualification Records (PQR) for each WPS submitted (unless WPS is prequalified)	PTW	EP	1	FA
17.	3.4.1.12.c	Welder Performance Qualification (WPQ) records, including evidence of process usage updates	PTW	EP	1	FA
18.	3.4.1.12.d	Roster of all welders to be used to perform work with continuity/expiration dates identified for each process the welder is qualified	PTW	EP	1	FA
19.	3.4.1.12.e	Updated records (Roster) as required throughout the contract duration, to demonstrate welders submitted have maintained their qualifications	R	EP	1	FA
20.	3.4.1.12.f	NDE- Visual examination and nondestructive examination procedures, VT, MT, PT, RT, UT (as applicable)	PTW	EP	1	FA
21.	3.4.1.12.g	NDE-Certification records of examination personnel	PTW	EP	1	FA
22.	3.4.1.12.h & 4.2.1	NDE-Procedure for Qualification and Certification of Nondestructive Testing Personnel	PTW	EP	1	FA
23.	3.4.1.12.i	NDE-Current eye examination record (Annual) for examination personnel	PTW	EP	1	FA
24.	3.4.1.12.j	Certified Material Test Report (CMTR) for weld filler materials (as required) for each Heat/Lot to be used	PTW	EP	1	FA
25.	3.4.1.12.k	Weld filler material control procedure	PTW	EP	1	FA
26.	3.4.1.12.l	Welding fabrication drawings for all welded components	PTW	EP	1	FA
27.	3.4.1.12.m & 3.4.2.2	Weld examination records, weld maps, radiographs, and PWHT chart recordings	PTT/PTS	EP/X	1	FA
28.	3.4.1.14	Certified Material Test Report (CMTR) for Weld Filler Material	PTW	EP	1	FI
29.	3.4.3.11	Cleanliness Procedures and Report	PTFA	EP	1	FA
30.	3.4.3.9	Cleaning chemical list	PTF	EP	1	FI
31.	4.1.1	Liquid Penetrant report	PTFA	EP	1	FA

SCHEDULE				FORMAT		PURPOSE	
AA	After Award	PTF	Prior to Fabrication	CD	Compact Disk	FA	For Action
AI	After Issue	PTFA	Prior to Final Acceptance/at Completion	DVD	Digital Video Disk	FI	For Information
AIT	After Inspection Test	PTL	Prior to Lift	EM	E-Mail		
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NTP	Notice to Proceed	Q	As Required	PH	Photographs		
PTC	Prior to Construction/Commencing Work	R	As Requested	S	Sample		
PTD	Prior to Delivery	WP	With Proposal/Bid	X	X-rays		

#	REFERENCE	REQUIREMENT DESCRIPTION	SCHEDULE	FORMAT	NO. OF COPIES	PURPOSE
32.	4.1.1	Dimensional inspection Report	PTF	EP	1	FA
33.	4.3	Quality Plan/Program	WP	EP	1	FA
34.	3.7.1	Dimensional inspection procedure(s)	PTF	EP	1	FA
35.	3.10	Packing/Shipping Plan	PTFA	EP	1	FA
36.	3.6.1.2	Surface Examination Procedure(s)	PTFA	EP	1	FA
37.	3.6.1.3	Surface Examination Report	PTFA	EP	1	FA

Attachment B: Instruction to Supplier for Preparation of Submittals

Note 1 --All correspondence shall be addressed to the Technical Representative identified by the Company. The Supplier shall forward submittals via transmittal letter to the Company at the address specified in the contract.

Note 2 -- The submittal must have adequate detail so that full compliance with the requirements may be determined. For example, a simple off-the-shelf item to be used in an assembly may only need a Supplier's cut-sheet to show compliance, but a factory acceptance test (FAT) developed and submitted by the Supplier must have each test step detailed with acceptance criteria consistent with the requirements.

a. Review submittal before transmitting to the Company to verify conformance with requirements of the contract documents (e.g., field measurements, field construction criteria, or Supplier's catalog numbers).
b. Coordinate submittals with the work requirements and the contract documents.
c. Organize Submittals
   - Do not use highlight marker or color coding on submittals.
   - The minimum resolution used for scanning submittals shall be 300 dpi x 300 dpi.
   - For submittals containing color information important to the record, a 24-bit color setting should be used.
   - Submittals are to be legible and in the format specified on the submittal checklist.
   - Pen and ink changes are to be made in non-erasable ink, legible, dated and initialed.
   - Mark specific options provided for the work, and cross out options not provided.
   - Each submittal shall be sent as a single pdf file unless otherwise specified.
d. Label submittals with the applicable item number, reference, and requirement description as summarized in the Submittal Checklist. Unlabeled submittals will be returned to the Supplier without review.
e. Include with submittals a transmittal letter that identifies individual documents by specification section.
   - Transmittal for submittals shall be numbered using the purchase order number followed by a 4-digit sequential number. (Example: 430001111-0001).
   - Embedded comments or questions that are not included on the transmittal may not be addressed/resolved by the Company.
f. Direction will be given at the time of award to either upload submittals to a company provided URL address or send by email to a company provided email address.
g. If using a company provided URL to upload submittals, notify the Company via email when submittals have been placed.
h. After review of a submittal, the Company will assemble comments and provide a status on the documents. An example of this submittal status stamp is shown below.

DOCUMENT REVIEW STATUS		
1	☐ Work may proceed.	
2	☐ Revise & resubmit. Work may proceed subject to incorporation of changes indicated.	
3	☐ Revise & resubmit. Work may not proceed.	
4	☐ Review not required. Work may proceed.	
Permission to proceed does not constitute acceptance or approval of design details, calculations, analysis, test methods developed or selected by the supplier and does not relieve supplier from full compliance with contractual obligations.		
REVIEWED BY:	Print Name/Signature :	Date:

i. If a submittal is being resubmitted, then reference the applicable item number, reference, and requirement description and identify it as a resubmittal.
j. Company response will only be returned to the Supplier for those submittals with a Submittal Purpose of "For Action, "unless it is determined that a submittal transmitted "For Information" is not acceptable.
k. AFTER written approval is obtained, THEN proceed with work requiring approved submittals.
l. When approval submittals are required, work done before Company approval is at the Supplier's risk.
m. Maintain a copy of the company-approved submittal and status page on file.

Attachment C: Abbreviations and Acronyms

ANSI	American National Standards Institute
ASME	American Society for Mechanical Engineers
ASTM	American Society for Testing Materials
AWS	American Welding Society
BPVC	Boiler and Pressure Vessel Code
CMTR	Certified Material Test Report
COC	Certificate of Conformance
DOE	Department of Energy
FAE	First Article Evaluation
GTAW	Gas Tungsten Arc Welding
GMAW	Gas Metal Arc Welding
HEU	Highly Enriched Uranium
ID	Identification
lb	pounds
MT	Magnetic Test
M&TE	Measurement and Test Equipment
NCR	Non-conformance Report
NDE	Non-destructive examination
NEMA	National Electrical Manufacturer's Association
NFPA	National Fire Protection Association
NIST	National Institute of Standards and Technology
OEM	Original Equipment Manufacturer
PAW	Plasma Arc Welding
PQR	Procurement Quality Report
psig	Pounds per Square Inch, gage
PWHT	Post-weld Heat Treatment
PT	Penetrant Test
QA	Quality Assurance
QASL	Quality Approved Supplier List
QSC	Quality System Certificate
RFWD	Request for Waiver/Deviation
RT	Radiographic Testing
SA	Subcontract Administrator
SDS	Safety Data Sheet
STR	Subcontract Technical Representative
S/CI	Suspect / Counterfeit Items
UL	Underwriter's Laboratory
UT	Ultrasonic nondestructive testing
VT	Visual Testing
WFM	Weld Filler Material
WPQ	Welder Performance Qualification
WPS	Welding Procedure Specification

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Appendix 1.3.3
SPC JS-YMN3-801580-A001, ES-3100 Containment Vessel

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APPROVAL / REVISION PAGE
** For Company Use Only - Do Not Provide To Supplier **

QUALITY LEVEL	PROTECTION LEVEL	BUILDING
Q	C	NA

PROJECT TITLE	JOB TITLE
ES-3100 Shipping Package	ES-3100 Shipping Package

ITEM DESCRIPTION	UNID
ES-3100 CONTAINMENT VESSEL	YAREA-CMH-042

REVISIONS

REV. NO.	DESCRIPTION OF REVISION
F	On Record
G	Added Viton 0-ring drawing as an optional O-ring. Changed Procurement Specification OO-PP-986 to Equipment Specifications SPC-M801580-0001 (for Viton 0-ring) and SPC-M801580-0002 (for EPDM 0-ring).
H	Removed Viton 0-ring as an optional 0-ring.
I	Added RIC, updated general formatting, added submittal checklist.

REFERENCE DOCUMENTS & OTHER INFORMATION

This Engineering Procurement Document contains Scientific, Technical, or Operational Information (STI) and therefore must go through the Information Release Office prior to release.

Recommended supplier:
TBD

Upon delivery, implement Level C storage requirements.
In-Storage Maintenance Requirements – None

References for Company Use:

Receipt Inspection Checklist (Attached)
Design Verification Record # DV 801580-0018

Other reference documents not needed by the Supplier:
UCN-20064
CK M801580-0016 (QLD)
GWS YAREA-CMH-0001 000 08 (Grading Worksheet)
TIO (Approval)

This document has been reviewed by a Y-12 DC/ UCNI RO and has been determined to be UNCLASSIFIED and contains no UCNI. This review does not constitute clearance for Public Release.
Name: Date:
Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2019.08.29 14:45:23 -04'00'

APPROVALS

PRINT	SIGNATURE	DATE	PRINT	SIGNATURE	DATE
PREPARED BY L.C. Hooper	Lloyd Hooper	Digitally signed by Lloyd Hooper Date: 2019.08.28 08:19:21 -04'00'	PACKAGING ENGINEER N.A. Laney		Noelani A (NL1) Laney 2019.08.28 13:56:41 -04'00'
DESIGN VERIFICATION R.D. Aigner	Roger D (R7A) Aigner	Digitally signed by Roger D (R7A) Aigner Date: 2019.08.29 16:08:21 -04'00'	SYSTEM ENGINEER R.D. Aigner	Roger D (R7A) Aigner	Digitally signed by Roger D (R7A) Aigner Date: 2019.08.28 14:45:47 -04'00'
DISCIPLINE MANAGER J.C. Anderson	James C (J5A) Anderson	Digitally signed by James C (J5A) Anderson Date: 2019.08.29 16:27:31 -04'00'	OPERATION/SYSTEM OWNER S.K. Thomas	Stan (TSW) Thomas	Digitally signed by Stan (TSW) Thomas Date: 2019.08.29 15:50:22 -04'00'
WELD ENGINEER J.W. Folk	John W (FJB) Folk	Digitally signed by John W (FJB) Folk Date: 2019.08.28 13:46:35 -04'00'	QUALITY OWNER J.R. Burchfield	Jason (JR6) Burchfield	Digitally signed by Jason (JR6) Burchfield Date: 2019.08.28 09:33:13 -04'00'
NUCLEAR PROC. ENGINEER J.E. Cook	Jeffrey E (2XK) Cook	Digitally signed by Jeffrey E (2XK) Cook Date: [illegible]			

RECEIPT INSPECTION CHECKLIST	DOC TYPE	RIC DOC. #	PART #	REV. #	PAGE
Form instructions – EPD Preparer should complete all spaces pertaining to the specification of the item (shown in red). The individual performing receipt inspection should complete all spaces pertaining to the inspection of the received item (shown in blue). Multiple copies of the RIC may be used for POs with multiple items. Attach comments & other documentation as needed					1 of 2

A. GENERAL INFORMATION

SPECIFIED

ITEM DESCRIPTION	UNID
ES-3100 Containment Vessel (CV)	YAREA-CMH-042

QUALITY LEVEL	PROTECTION LEVEL	SAMPLE SIZE: BASED ON NORMAL SAMPLING PLAN IN ACCORDANCE WITH Y17-69-316 CHAPTER 6, ATTACHMENT 6-C	PROCUREMENT QUALITY STRATEGY
Q	C		Evaluated

RECEIVED

ITEM DESCRIPTION	SAT Y or N	INITIALS	DATE

PO#:	ITEM	QTY ORDERED:	SHIPMENT	SHIPMENT #:	QTY REC'D/ LOT SIZE:	QTY INSPECTED/ SAMPLE SIZE:
			COMPLETE or PARTIAL	of		

RELATED APPROVED WAIVERS/DEVIATIONS:

B. SUPPLIER PACKAGING, HANDLING, SHIPPING, & STORAGE (INCL. MAINTENANCE)

SPECIFIED: Per the approved plan for packaging, handling, shipping, and storage as noted in Equipment Specification.

RECEIVED:	SAT Y or N	INITIALS	DATE

C. ITEM SUPPLIER/MANUFACTURER INFORMATION

	IF SPECIFIED AS A REQUIREMENT	RECEIVED
SUPPLIER/MFR	PER THE PURCHASE ORDER	
MANUFACTURER	PER THE PURCHASE ORDER	
MODEL #	N/A	
PART #	N/A	
		SERIAL #:

	SAT Y or N	INITIALS	DATE
Suspect/Counterfeit Item Inspection, Review of S/CI Notifications & Item Markings			

D. MEASUREMENT AND TEST EQUIPMENT (M&TE used for receipt inspection) *(add additional pages if needed)*

M&TE TYPE	M&TE NUMBER	CALIBRATED RANGE	TOLERANCE	CAL. DUE DATE

E. COMPANY PACKAGING, HANDLING, SHIPPING, & STORAGE (INCL. MAINTENANCE)

SPECIFIED:
PROTECTION LEVEL C

Communicated requirements to Company Material Management	Y or N	INITIALS	DATE

RECEIPT INSPECTION CHECKLIST	DOC TYPE	RIC DOC. #	PART #	REV. #	PAGE
					2 of 2

F. SALIENT FEATURE EVALUATION

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Material Properties of CV Body Assembly (flow formed or machined)	INSPECTION	PQE	PQR	PQE	Y, N, N/A

QLD #	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
CK M801580-0016	CMTR verifying that material is in accordance with ASME SA-182 for F304L (S30403) material per drawing M2E801580A012.		Y or N		

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Material Properties of CV Body Assembly (welded)	INSPECTION	PQE	PQR	PQE	Y, N, N/A

	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
	1. CV Vessel Flange and End Cap: CMTR verifying that material is in accordance with ASME SA-182 for F304L (S30403) material per drawing M2E801580A012. 2. CV Pipe Body: CMTR verifying that material is in accordance with ASME SA-312 for F304L (S30403) material per drawing M2E801580A012.		Y or N		

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Material properties of CV Sealing Lid	INSPECTION	PQE	PQR	PQE	Y, N, N/A

	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
	CMTR verifying that material is in accordance with ASME SA-479 for S30400 material per drawing M2E801580A015.		Y or N		

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Material properties of CV Closure Nut	INSPECTION	PQE	PQR	PQE	Y, N, N/A

	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
	CMTR verifying that material is in accordance with ASME SA-479 for S21800 material per drawing M2E801580A016.		Y or N		

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Dimensional Requirements of CV	INSPECTION	PQE	PQR	PQE	Y, N, N/A

	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	SAT	INITIALS	DATE
	Inspection requirements shown per RIC Attachment.	Y or N		

G. DISPOSITION

APPLICABLE PQR # AND/OR NCR #: ATTACH COMMENTS & OTHER DOCUMENTATION AS NEEDED	QUANTITY APPROVED:	QUANTITY REJECTED:

H. AUTHORIZATION

EVALUATOR SIGNATURE	ORGANIZATION	BADGE	DATE

RIC ATTACHMENT

SERIAL #:	

DRAWING	REQUIREMENTS (ACCEPT. CRITERIA W/TOL./RANGE)	ACTUAL
M2E801580A012 (LOCATION WITHIN DRAWING IS IN PARENTHESIS)	CV TOP OUTSIDE DIAMETER 7.500±.005 (D4)	
	CV HEIGHT 32.40±.01 (B4)	
	CV BOTTOM THICKNESS .25±.01 (A4)	
	CV THREADS 7.0-8 PUSH-BUTT-2B PER ANSI B1.9-1973 (C4)	
	CV THREAD RUNOUT OF .005 TO DATUMS B,A (C4)	
	CV WRENCH HOLE LOCATION .550±.005, 2X (D3)	
	CV TOP INSIDE DIAMETER 6.753±.003 (D2-D3)	
	CV DATUM B PERPENDICULARITY OF .003 TO DATUM A (D3)	
	CV THREAD UNDERCUT ANGLE 45°±.5° BEFORE THREADING, RADIUS .09±.01, LOCATION .55, AND DIAMETER 6.85±.01 (C3)	
	CV DATUM A FLATNESS TO WITHIN .003 (C3)	
	DATUM A TO O-RING SURFACE HEIGHT 1.100±.005 (C3)	
	CV O-RING SURFACE PARALLEL TO DATUM A TO WITHIN .005 (C3)	
	CV DOWEL PIN LOCATION 3.200±.005, 2X FROM CENTERLINE (B3)	
	CV DOWEL PIN CENTER LINE .80±.01, 2X FROM DATUM A (C2)	
	CV BOTTOM INSIDE DIAMETER 5.06±.04 (B3)	
	CV BOTTOM SIDE WALL THICKNESS .100±.010 (B2)	
	CV OUTER O-RING OUTSIDE DIAMETER 6.124±.010 (C2)	
	CV OUTER O-RING RUNOUT OF .010 TO DATUMS A,B (C2)	
	CV O-RINGS SINGLE DOVETAIL OPENING WIDTH .151±.003, 2X TO INSPECTION POINT (C2)	
	CV O-RINGS OPENING HEIGHT .114±.001, 2X (C2)	
	CV INNER O-RING OUTSIDE DIAMETER 5.624±.010 (B2)	
	CV INNER O-RING RUNOUT OF .010 TO DATUMS A,B (B2)	
	CV O-RINGS OPENING SURFACE FINISH 32, MATERIAL REMOVAL REQUIRED (B1)	
	CV O-RINGS OPENING TOP SURFACE DEPTH .007±.003 (C1)	

RIC ATTACHMENT (continued)

SERIAL #:	

DRAWING	REQUIREMENTS (ACCEPT. CRITERIA W/TOL./RANGE)	ACTUAL
M2E801580A015 (LOCATION WITHIN DRAWING IS IN PARENTHESIS)	CV LID OUTSIDE DIAMETER 6.741±.003 (H5-H6)	
	CV LID CENTER TO SLOT DISTANCE 3.17±.01, 2X (F6)	
	CV LID SLOT LOCATION FROM CENTERLINE .15±.01 (F5)	
	CV LID SLOT LENGTH .30±.01 (F5)	
	CV LID TOP OUTSIDE DIAMETER 3.98±.01 (D7)	
	CV LID BOTTOM THICKNESS .500±.005 (D6)	
	CV LID RETAINING RING POCKET INSIDE DIAMETER 3.792±.005 (E4)	
	CV LID RETAINING RING POCKET HEIGHT .120±.005 (D3)	
	CV LID BOTTOM OUTSIDE FLANGE FLATNESS TO WITHIN .005 (D2)	
	CV LID BOTTOM OUTSIDE FLANGE SURFACE FINISH 32, MATERIAL REMOVAL REQUIRED (C3)	
	CV LID LEAK CHECK PORT SURFACE FINISH 32, MATERIAL REMOVAL REQUIRED (F2)	
M2E801580A016 (LOCATION WITHIN DRAWING IS IN PARENTHESIS)	CV CLOSURE NUT DISTANCE BETWEEN TORQUE HOLES 6.000±.002 (D6)	
	CV CLOSURE NUT DATUM A FLATNESS TO WITHIN .003 (E3)	
	CV CLOSURE NUT THREAD 7.0-8 PUSH BUTT-2A PER ANSI B1.9-1973 (D3)	
	CV CLOSURE NUT THREAD PERPENDICULAR TO DATUM A TO WITHIN .003 (D3)	
	CV CLOSURE NUT TORQUE HOLE DIAMETER .507±.002 THRU (D3)	

TABLE OF CONTENTS

1.0 SCOPE **2**
1.1 General Description of the Item 2

2.0 REFERENCES **2**
2.1 Definitions 2
2.2 Codes/Standards/Orders/Regulations 3
2.3 Applicable Documents 4

3.0 ITEM REQUIREMENTS **4**
3.1 Performance Requirements 4
3.2 Design Requirements 5
3.3 Fabrication and Assembly Requirements 9
3.4 Requirements 9
3.5 Government-Furnished Equipment 15
3.6 Hydrostatic Testing 15
3.7 Leak Testing 16
3.8 Final Examination of Finished Surfaces 17
3.9 Dimensional Inspection 17
3.10 Schedule (Specify to be submitted for approval) 19
3.11 Deliverables (Including Submittals) 19
3.12 Packaging, Handling, Shipping, and Storage Requirements 20
3.13 Marking and Identification Requirements 20
3.14 Requests for Waiver or Deviation 20
3.15 Documentation Retention 21
3.16 Use of Subcontractors 21
3.17 Witness of Documentation and Processes 21
3.18 Nonconformance Control 21
3.19 Approved Procedures 21

4.0 QUALITY ASSURANCE REQUIREMENTS **22**
4.1 Final Acceptance Method 22
4.2 Inspection/Testing Requirements 22
4.3 Quality Requirements 23
4.4 Acceptance Criteria 23
4.5 Personnel Qualifications/Certifications 24

Attachment A: Submittal Checklist 25
Attachment B: Instruction to Supplier for Preparation of Submittals 29
Attachment C: Abbreviations and Acronyms 30
Attachment D: Requirements for Authorized Nuclear Inspector (ANI) 31

1.0 SCOPE

This specification, equipment specification SPC-M801580-0002, *ES-3100 Ethylene Propylene Diene Monomer {EPDM) Containment Vessel 0-rings,* the Company's drawing, and the referenced codes and standards in Sect. 2.2 of this specification state the requirements for the procurement of materials and components, fabrication, inspection, examination, assembly, and testing of the containment vessel (CV) for the ES-3100 shipping package.

The CV will be manufactured in accordance with the applicable requirements stated in the American Society of Mechanical Engineers (ASME) Boiler and Pressure Vessel Code (B&PVC), hereinafter referred to as the ASME Code, Section III, Division 1, Sub-section NB for Class 1 Components as described on the Company's drawings and in this specification. The CV will not require an N stamp. However, if the Supplier does not have a certificate of authorization from the ASME to apply the N stamp, the Supplier shall be familiar with, and capable of meeting those requirements in Section III, Division 1, Subsections NB and NCA of the ASME Code that are referenced in this specification. The reference to the Inspector in any of the ASME Codes shall in this particular case be that person designated by the Company.

If conflicting requirements appear in these documents, the Supplier shall immediately notify the Company for resolution.

Any deviation from the requirements specified is not allowed without the Company's written approval of a written request for waiver or deviation.

1.1 General Description of the Item

The CV is a leak tight metal vessel capable of maintaining content quality during and after designated accident scenarios.

2.0 REFERENCES

2.1 Definitions

Company – The Company, as used in this specification, is the buyer of the Supplier's final product (i.e., Y-12 National Security Complex)

Deviation - A specific written authorization, granted by the Company **prior to the manufacture** of an item, to depart from a subcontract requirement for a specific piece or pieces of equipment or a specified period of time.

First Article - Product that is submitted to Y-12 for evaluation prior to the Supplier being released to manufacture the remaining quantities in the subcontract. This product must be representative of production items by virtue of having been produced and inspected using the same facilities, testing, processes, and type of personnel planned for use in production.

First Article Evaluation (FAE) – An evaluation by Y-12 of the first unit(s) manufactured and the facilities, tooling, processes, etc. concerned with the manufacture and inspection.

Hold Point - A hold point is defined as the designated point(s) in the fabrication where the Supplier will stop and hold further production. The Y-12 contact will be provided production data and will decide if it will be necessary to visit the manufacturing facility or if the supplied data will be sufficient.

Manufacturing Plan – A written, step-by-step, process plan for the equipment to be fabricated. The plan includes material control, major fabrication steps, hold points, all in-process inspections, welding, welding inspection/examination, dimensional inspections, testing, and shipping.

Non-conformance - A deficiency in characteristic, documentation, or procedure that renders an item to be in non-compliance with specified requirements.

Offeror - The Organization or person(s) submitting an offer to the Company to provide the product(s) described.

Request for Waiver or Deviation (RFWD) - A formal request by the Supplier for a waiver or deviation to the equipment specification, drawing, or PO using the Company form, which can be provided by the SA or STR. The form must be approved by the Company in writing before the Supplier being granted authorization to proceed.

Supplier - Any individual or organization that furnishes items or services in accordance with a purchase order. Also an all-inclusive term used in place of the following: vendor, seller, subcontractor, dealer, fabricator, consultant, manufacturer, distributor, and their sub-tier levels.

Subcontract Administrator - The person(s) designated in the subcontract as having authority to act officially for the Company.

Subcontract Technical Representative (STR) – The Subcontract Technical Representative, as used in this specification, is the person designated by the Subcontract Administrator as having the authority to represent the Company in technical matters.

Traveler - A written, step-by-step, process document used for the control of components/equipment to be fabricated. The traveler includes material identification, all fabrication steps, hold points, all in-process inspections, welding, welding inspection/examination, dimensional inspections, testing, and preparation for shipping.

Waiver - A specific written authorization, granted by the Company, to accept a configuration item or other designated items which, during production or after having been submitted for inspection, are found to depart from specified requirements, but are considered suitable for use as is or after rework by an approved method.

Witness Point - The Witness point is similar to the hold point except the manufacturing, testing or inspection is halted until the Y-12 representative(s) can visit the manufacturing facility and witness the designated operations.

2.2 Codes/Standards/Orders/Regulations

CVs shall be fabricated, inspected, and tested according to the design drawings and the applicable documents referenced herein.

- American National Standards Institute, ANSI N14.5-1997, American National Standard for Radioactive Materials – Leakage Tests on Packages for Shipment.

- American Society of Mechanical Engineers, Boiler and Pressure Vessel Code, Section III, Division 1 - Subsections NB and NCA, Class 1 Components, 2019.

- American Society of Mechanical Engineers, Boiler and Pressure Vessel Code, Section II, Parts A and C, 2019.

- American Society of Mechanical Engineers, Boiler and Pressure Vessel Code, Section V, 2019.

- American Society of Mechanical Engineers, Boiler and Pressure Vessel Code, Section IX, 2019.

- American Society for Nondestructive Testing, No. SNT-TC-1A, Recommended Practice for Nondestructive Testing Personnel Qualification and Certification, 2016.

- American Society for Testing Materials, ASTM A 380-17, Standard Practice for Cleaning, Descaling, and Passivation of Stainless Steel Parts, Equipment and Systems.

- Society for Protective Coatings, SSPC SP 5/NACE No. 1, White Metal Blast Cleaning, 2006.

- Title 10, Code of Federal Regulations, Section 71, Subpart H, Latest date.

All references to the ASME Code in this document are to the ASME Boiler and Pressure Vessel Code, 2019 Edition.

2.3 Applicable Documents

Drawings:	
M2E801580A011	Containment Vessel Assembly
M2E801580A012	Containment Vessel Body Assembly
M2E801580A013	Containment Vessel O-Ring Details
M2E801580A014	Containment Vessel Lid Assembly
M2E801580A015	Containment Vessel Sealing Lid
M2E801580A016	Containment Vessel Closure Nut
Specification(s):	
SPC M801580-0002	ES-3100 Ethylene Propylene Diene Monomer (EPDM) Containment Vessel O-rings
Datasheet(s):	
DS 801580-0002	Procurement Specification for ES-3100 Silicone Rubber Parts

3.0 ITEM REQUIREMENTS

The Supplier shall be responsible for supplying all materials, services, facilities, and equipment to meet the requirements of this specification and Company drawings unless otherwise noted.

3.1 Performance Requirements

3.1.1 Boiler and Pressure Vessel Code Compliance

3.1.1.1 The term ASME Code in this specification refers to the ASME B&PVC. A paragraph referenced as NB-XXXX or NCA-XXXX, where XXXX is a specific paragraph number, is that paragraph in Section III, Subsection NB or Subsection NCA, respectively, of the ASME Code. If a given paragraph is referenced as a requirement, all subparagraphs under the stated paragraph shall also be requirements. For example, if NB-2430 is referenced as a requirement, not only do the applicable

requirements of NB-2430 apply, but also those of NB-2431, NB-2431.1, NB-2431.1(a), NB-2432, etc.

3.1.1.2 The CV shall be manufactured in accordance with the applicable requirements stated in the ASME B&PVC, Section III, Division 1, Sub-section NB for Class 1 Components as specified on the Company's drawings and in this specification. A certificate of compliance to the code shall be supplied to the Company.

3.1.1.3 The Supplier shall hold a Certificate of Authorization from the ASME that authorizes it to manufacture and inspect pressure vessels in accordance with Section VIII or Section III of the ASME Code. If the Supplier does not have a certificate of authorization for Section III, the Supplier shall provide data with its offer that demonstrates its ability to meet the requirements in Subsections NB and NCA as referenced in this specification.

3.1.1.4 The Supplier is not required to Code stamp the CV. However, the Supplier and an Authorized Nuclear Inspector (ANI) shall fulfill their duties per the Code as though the CV will be Code stamped and both shall sign the Certificate Holder's Data Report, Attachment D.

3.1.1.5 The ANI is not required to verify the design calculations.

3.2 Design Requirements

3.2.1 Materials and Material Examinations

3.2.1.1 Material requirements are specified on Company drawings, in this specification, and in the documents referenced in this specification.

3.2.1.2 The *Containment Vessel Body Assembly* (drawing M2E801580A012), *Containment Vessel Sealing Lid* (drawing M2E801580A015), and the Closure Nut (drawing M2E801580A016) shall be considered pressure retaining materials as defined in paragraph NB-2110 and therefore shall meet the applicable requirements of NB-2120.

3.2.1.3 There are two CV assemblies shown on Drawing M2E801580A012, Parts M2E801580A012-1 and M2E801580A012-4. The CV assembly(s) to be fabricated will be specified in the Company's purchase order. Note that Part M2E801580A012-4 is fabricated by welding a forged bottom, and forged top flange to a cylindrical shell machined from seamless pipe as shown on the drawing.

The flow formed or machined CV body option, Part M2E801580A012-1, shall be flow formed or machined from a single forged billet or bar. Special requirements for the flow formed option are given as follows:

a. The flow formed, heat treated, and finished machined CV body, Part M2E801580A012-1, shall meet the chemical composition requirements of ASME SA-182 for Grade F304L for a forged component as well as the requirements listed below. After final forming, parts shall be solution annealed and quenched per the requirements of ASME SA-182 for Grade F304L. In addition, the requirements of NB-2180 shall also apply. A certified heat treatment Procedure shall be submitted to the Company for approval. A certified heat treatment report shall be provided to the Company for approval stating for each furnace charge the following information: the serial numbers of the CV bodies heat treated in the furnace charge, the time and date of the heat

treating, the person responsible for the heat treating, the time-temperature profile of the furnace and representative parts of the furnace charge, the quench medium, and all other pertinent details of the heat treating. Such a heat treating report is required for all heat treating, both in process annealing and final heat treatment.

b. It shall be demonstrated that the flow formed, heat-treated CV bodies, Part M2E801580A012-1, meet the mechanical property requirements of ASME SA-182 for Grade F304L by mechanical testing of coupons. The test coupons are to be machined from the same heats of materials used to form the CV bodies, and shall have the same or greater amount of cold work (plastic strain) as the CVs will have as a result of the forming process. The mechanical tensile testing of coupons shall be done in accordance with ASME SA-370: A minimum of six test coupons shall be tested for each final heat treatment furnace charge. The first set of three test coupons, chosen at random, shall be tested without being heat treated. The second set of three of more test coupons shall be heat treated together with the CV bodies, and then tested. The heating rates and maximum temperatures of the test coupons shall be representative of the entire furnace charge. Test coupons are not required to be heat treated with intermediate processing annealing steps, but are required in the final heat treatment furnace charge.

c. The results of all the testing of the sample coupons shall be documented, certified and reported to the Company. The mechanical properties test report shall contain the following information: a description of the furnace charge in which the test coupons are to represent; the times and dates of the heat treating and the testing; the person responsible for the testing; a statement that these coupons are prior to or after heat treatment; a description of the testing including a sketch of the tensile test specimen; the make, model, serial number, and current calibration data of the testing machine(s) used in the testing; reference to the written testing procedure used; the resulting measure yield strength, ultimate strength, % elongation and % reduction in area; and any pertinent remarks.

d. It is permissible to deviate from the liquid quench requirements stated in SA-182 provided that the cooling rates of the alternate quench are such that the heat treated material is not susceptible to intergranular corrosion due to chromium carbide precipitation. This is to be demonstrated by testing according to Practice E of ASTM A262, and meeting the stated acceptance criteria. This shall be accomplished by obtaining test coupons from each furnace batch that represent the slowest cooling rates of the batch, or by following a heat treating procedure that has been qualified to ensure that the heat treated batch will not be sensitive to intergranular corrosion. In any case, the requirements of NB-2180 shall apply.

e. The heat treating procedure must be qualified by measuring the annealing temperatures, soak times and cooling rates of the furnace batch, and then testing heat treated specimens that represent the lowest annealing temperatures, soak times and cooling rates for that furnace batch for sensitivity to intergranular corrosion using Practice E of ASTM A262. For subsequent annealing operations, the temperatures, soak times, and cooling rates of subsequent furnace batches must be measured and compared to the qualified procedure. Other factors, such as variations of the size and arrangement of the furnace batch that can affect part temperatures and part cooling rates, and the calibration of the furnace temperature sensors must be assessed in the procedure qualification to ensure that minimum temperatures and cooling rates of production heat treating batches can be properly compared to those of the qualified procedure. Such a procedure should be requalified for each individual furnace used, and for significantly different furnace batch sizes. The procedure shall be requalified annually, or if it has not been used for a period of at least three months.

3.2.2 Certified Material Test Reports (CMTR's)

3.2.2.1 CMTR's shall be provided to the Company for the materials used to fabricate these components in accordance with ASME Section III, Subsection NCA, NCA-3860. The Supplier shall provide the Company with certified material test reports, certified material examination reports and certificates of compliance for the materials stated above as required by this specification.

3.2.2.2 Material suppliers shall meet the requirements of NCA-3800.

3.2.2.3 Materials must be identified by material type, applicable specification, and revision number and be traceable to their lot or batch numbers. Traceability records shall be available for review by the Company's representative.

3.2.2.4 Materials shall be traceable to each CV's serial number.

3.2.2.5 Supplier shall maintain control of materials to ensure this traceability.

3.2.2.6 Materials shall be supplied with Certificates of Compliance in accordance with NCA-3862(g) and (h).

3.2.2.7 Materials shall be examined in accordance with the applicable paragraphs of NB-2500, and shall meet the stated acceptance criteria.

3.2.2.8 Results of these examinations shall be included with the CMTR's provided to the Company.

3.2.2.9 Weld filler metal used in the fabrication and repair of the CVs shall meet the applicable requirements of ASME BPVC Section III, Rules for Construction of Nuclear Facility Components - Subsection NCA General Requirements for Division 1 and Division 2- Article NCA-3800 and shall comply with the SFA specifications of Section II; Part C of the ASME Code.

3.2.2.10 Weld filler metal shall be traceable to heat numbers and CMTR's shall be furnished to the Company for each heat of weld filler metal used.

3.2.2.11 Results of the delta ferrite determination shall be included with the CMTR for the weld filler metal (see NB-2433) and shall be a minimum of 5 FN.

3.2.2.12 Weld examiner shall be able to determine the heat number of the weld filler used in each weld on each CV.

3.2.3 Hold points and Witness points

Hold points and Witness points will be required as noted below.

- For ALL units, QA Witness Points will be the Load Test, Sealing Test, Hydrostatic Test, Helium Leak Test, Air Leak Test and Dimensional Inspection including surface finishes.

3.2.4 First Article Evaluation (FAE)

The Company shall conduct an FAE in two (2) phases in accordance with this specification.

3.2.4.1 In Phase I the Company will conduct a review of the Supplier's process control forms and manufacturing procedures. The Supplier shall furnish an electronic copy of all procedures, travelers, data entry forms, processing records, and related data used by the Supplier to define and/or control those aspects of the manufacturing, testing, and inspection operations that influence the quality of the product being produced prior to fabrication, in accordance with schedule dates described in the subcontract.

3.2.4.2 Phase II of the FAE shall consist of audits and such examinations, inspections and testing oversight as deemed appropriate by the Company at the Supplier's site. The results of these audits and examinations will be evaluated to determine final acceptance of the FAE parts and release to produce production quantities.

3.2.4.3 The Supplier shall not proceed to manufacture parts beyond the initial First Article quantity until a successful FAE has been completed and written notification to proceed has been received from the Company's subcontract administrator.

The criteria established for the performance of the FAE, and subsequent production, shall also apply to the Supplier's subcontractors and sub-tier subcontractors as deemed appropriate by the Company. A listing of any such subcontractors and their involvement shall be submitted to the Company. The Company reserves the right to provide oversight of these proposed Subcontractors if deemed necessary. Signed approval of the proposed Subcontractors shall be received by the Supplier from the Y-12 STR prior to proceeding with fabrication.

3.2.4.4 Once Y-12 has approved an FAE, any subsequent process changes by the Supplier to manufacturing and acceptance procedures, facilities, type of personnel, testing, etc., which could conceivably impact product quality, shall require the Supplier to notify Y-12 of the proposed changes. Y-12 shall then determine if a new First Article Evaluation is warranted.

3.2.5 Certificates of Conformances (CoCs)

CoCs for procured items shall meet the following requirements:

a. The CoC shall identify the purchased item by the purchase order number.

b. The CoC shall identify the specific procurement requirements met by the purchased item, such as codes, standards, and other specifications. This may be accomplished by including a list of the specific requirements or by providing a copy of the purchase order and the procurement specifications or drawings, together with a suitable CoC.

c. The CoC shall identify any approved changes, waivers, or deviations applicable to the item.

d. The CoC shall identify any procurement requirements that have not been met, together with an explanation and the means for resolving the request for waiver or deviation.

e. The CoC shall be signed or otherwise authenticated by a person who is responsible for this quality assurance function and whose function and position are described in the quality assurance program of the Supplier.

f. The Supplier's certification system, including the procedures to be followed in filling out a CoC and the administrative procedures for review and approval of the certificates, shall be described in their quality assurance program.

3.3 Fabrication and Assembly Requirements

The Supplier shall prepare a written, step-by-step, controlled manufacturing plan for all work to be performed. This plan shall include at a minimum:

a. Materials to be procured
b. Suppliers to be used
c. Quality Program used to buy or manufacture each subassembly
d. Major fabrication steps (sequence of operations)
e. Equipment to be utilized
f. All in-process checks
g. All welding
h. All weld inspection/examination including Non-Destructive examination and testing.
i. Dimensional inspection.

3.4 Requirements

3.4.1 Welding and Weld Repair (If Required)

3.4.1.1 All welds on the CVs shall be done either by the GTAW or GMAW process, manual or automatic, at the discretion of the Supplier unless specified otherwise on the drawings.

3.4.1.2 Backing rings, even if removed after the weld has been made, shall not be used. Except as limited by this specification, the applicable requirements of NB-4300 and NB-4400 shall apply to the CV.

3.4.1.3 Prior to welding, all weld preparation areas and the accessible surfaces within one inch of the weld area shall be examined visually and with liquid penetrant. The acceptance criteria for these examinations are provided in NB-5130 (a) through NB-5130 (d). Note: All open, rounded or elongated indications to the surface of the weld metal or adjacent base metal detected by NDE (VT PT) are unacceptable.

3.4.1.4 The results of these surface examinations shall be reported to the Company together with the weld examination reports in accordance with Attachment A.

3.4.1.5 Prior written approval of the Company shall be obtained for any weld repair of base materials. Base material weld repair is only acceptable with Company approval.

3.4.1.6 Repair welding shall meet the applicable requirements of NB-2500. Based on the specific defect, the Company may or may not approve the weld repair, even if it is permitted by the material specification or by paragraph NB-2500.

3.4.1.7 Base material weld repair areas shall be both surface and volumetrically examined. Volumetric examination may be performed by radiography or other method specified by a welding examination procedure approved by the Company prior to welding repair.

3.4.1.8 Repair areas shall be noted in a sketch supplied with the CMTR for the material that was weld repaired and the documented results of the weld examination shall be provided to the Company as Certified Data.

3.4.1.9 Welders performing two or more welds in one day that are rejected based upon welder technique shall be re-qualified to the appropriate welding procedures (see Section IX paragraph QW-320 of the ASME Code).

3.4.1.10 The Supplier shall submit welding information as Appraisal Data in accordance with Attachment A.

a. Job Specific Welding Procedure Specifications (WPS).
b. Job Specific Welding Procedure Qualification Records (PQR).
c. Job Specific Welder Performance Qualification (WPQ) records including evidence of process usage updates.
d. Job Specific Visual examination and Nondestructive examination procedures.
e. Job Specific Certification records of examination personnel.
f. Job Specific Post Weld Heat Treatment (PWHT) procedures with appropriate procedure demonstrations (as required) and Supplier's acceptance documentation. Components that have received PWHT and are to be welded shall be qualified with PWHT WPSs.
g. Provide a list of all welded assemblies not fabricated in accordance with Supplier's welding program. Include any welded assemblies to be purchased commercial-off-the-shelf.

3.4.1.11 The Supplier shall submit welding information as Approval Data in accordance with Attachment A.

a. WPS for all commodities to be welded. Provide drawing, sketch, list of components, etc., where WPS is to be applied.
b. Weld Procedure Qualification Records (PQR) for each WPS submitted (unless WPS is prequalified.
c. Welder Performance Qualification (WPQ) records, including evidence of continuous process usage updates.
d. Roster of all welders to be used to perform work with continuity/expiration dates identified for each process the welder qualified.
e. Updated records (Roster) as required throughout the contract duration, to demonstrate welders submitted have maintained their qualifications.
f. NDE- Visual examination and Nondestructive Examination Procedures, VT, MT, PT, RT, UT (as applicable).

g. NDE- Certification Records of examination personnel.

h. NDE-Procedure for Qualification and Certification of Nondestructive Testing Personnel.

i. NDE-Current eye examination record (Annual) for examination personnel.

j. Certified Material Test Report (CMTR) for weld filler materials (as required) for each Heat/Lot to be used.

k. Weld filler material control procedure.

l. Welding fabrication drawings for all welded components.

m. Weld examination records, weld maps, radiographs, and PWHT chart recordings.

3.4.1.12 Nonconforming Welds

Completed welds that have been inspected and accepted but are later found not to be in compliance shall be documented and submitted to the Company on a nonconformance report in accordance with Supplier's nonconformance procedure. The Supplier's nonconformance procedure shall include language to address welding nonconformances that occur due to both procedural and hardware deficiencies. If a repair by welding is required, the Supplier shall complete a repair procedure that includes the WPS with specific instructions for repair. Additional supporting documents, as required, to make the repairs shall be submitted to the Company. Company approval of the repair procedure shall be obtained before commencing the repairs. Every nonconformance report (NCR) dispositioned "Use-As-Is" or "Repair" requires written concurrence from the Company accepting the disposition and technical justification before continuing work associated with the Nonconformance. A disposition of Rework does not require Company approval. A submittal of the Supplier's nonconformance procedure shall be submitted to the Company in accordance with the Submittal checklist, Attachment A.

3.4.1.13 Weld Filler Material Requirements

a. Weld Filler Material (WFM) shall be selected that matches the base metal as close as possible for mechanical and corrosion resistant properties and be listed on the Welding Procedure Specification (WPS).

b. WFM shall be specified as manufactured in accordance with recognized ASME standards where possible. Use matching WFM or material recommended by the base metal manufacturer when there is no existing WFM with an assigned AWS classification.

c. Purchase weld electrodes/filler materials with a Certified Material Test Report (CMTR) as identified in Section 3.6.1.14 below. Submit a Certified Material Test Report (CMTR) for WFM to be used. The reporting requirements are specified in the "Test Requirements for CMTRs" table(s) below for the listed WFM. The CMTR shall provide traceability to the Supplier's purchase order for each heat/lot received. For WFM without an SFA classification, provide the same level of testing, product marking, and packaging, etc. that is required for WFM with a SFA Classification. Use the Supplier's standard designation in lieu of the SFA classification to mark each piece of WFM and the shipping package.

d. All WFM shall meet the requirements of ASME BPVC Section II Part C, *Specification for Welding Rods, Electrodes, and Filler Metals*, except as noted.

3.4.1.14 Weld Filler material Procurement Requirements

a. Weld Filler Material (WFM) and fluxes shall be purchased from manufacturers or suppliers with established Quality System Programs that meet the requirements of ASME BPVC Section III, Rules for Construction of Nuclear Facility Components - Subsection NCA General Requirements for Division 1 and Division 2- Article NCA-3800 Metallic Material Organization Quality System Program and are active NCA 3800 Quality System Certificate (QSC) holders. The manufacturer or supplier that holds the certificate shall be evaluated by the Supplier and be currently listed on their Quality Approved Suppliers List (QASL).

b. The procurement requirements for WFM apply to all WFM utilized by Supplier organizations that procure their own welding materials. The Supplier at their discretion may elect to procure and use materials to stricter standards. The sections below list the level of Certification for the most commonly used WFM classifications for various applications. Other classification WFM are permitted with the prior approval of the Company. All WFM shall be procured in accordance with material designation (SFA) ASME BPVC Section II SFA 5.01, Procurement Guidelines for Consumables - Welding and Allied Processes - Flux and Gas Shielded Electrical Welding Processes. The level of certification and testing required for these alternate materials shall be the same as required for the similar components described below.

3.4.1.14.1 Weld Filler Material for Stainless Steel Base Materials

Shall comply with ASME BPVC Section II SFA 5.9, *Specification for Bare Stainless Steel Welding Electrodes and Rods*:

a. Use classification ER308L filler materials for welding 304 or 304L stainless steel base materials. When CMTRs are required, the reports shall also record a minimum delta ferrite of 5 ferrite number and test method.

b. The maximum acceptable carbon content for all "L" grade (low carbon) weld filler material is 0.03%. Heat analysis of weld deposit shall be performed to determine the chemical composition of the material.

3.4.1.14.2 Test Requirements for CMTRs

ASME SPECIFICATION	ASME SFA 5.01 TEST REQUIREMENTS					
	Lot Class	Level of Test	Chemical Analysis	Tensile	Soundness	Impact
5.9 Bare Stainless Steel Welding Electrodes and Rods	S3 or S4	I	Rod/Wire	No	No	No

3.4.2 Weld and Surface Examination (If Required)

Personnel Certification Requirements for Weld Examinations

a. Personnel performing nondestructive examination other than visual shall be currently certified per the employer's written practice in accordance with SNT-TC-1A. Only individuals certified as NDT Level II or III may perform nondestructive examinations in accordance with this specification.

b. Personnel performing visual examination of welds shall be currently certified either as an AWS CWI or as a visual testing Level II or III per the employer's written practice in accordance with

SNT-TC-1A. (Note: Eye exams shall be performed on an annual basis and comply with Jaeger 1 visual acuity.)

c. The Level III, in the methods certified, shall conduct the examination of Level II personnel for those same methods.

3.4.2.1 Weld examination procedures shall meet the requirements of the ASME Code, Section V.

3.4.2.2 The applicable requirements in paragraphs NB-5110, NB-5120, NB-5210, NB-5220, NB-5260, and NB-5300 shall apply to the CVs. Note: All open, rounded or elongated indications to the surface of the weld metal or adjacent base metal detected by NDE (VT PT) are unacceptable.

3.4.2.3 The V-groove welds on part M2E801580A012 shall be liquid penetrant and radiographically examined if the welded option is used. Note: All open, rounded or elongated indications to the surface of the weld metal or adjacent base metal detected by NDE (VT PT) are unacceptable.

3.4.2.4 The applicable requirements in paragraphs NB-5110, and NB-5350 shall apply to the plug weld and V-groove welds. Note: All open, rounded or elongated indications to the surface of the weld metal or adjacent base metal detected by NDE (VT PT) are unacceptable.

3.4.2.5 Materials used in the liquid penetrant examination of welds and in the final surface examination of finished components shall be specifically recommended by the manufacturer for use with austenitic stainless steels.

3.4.2.6 Copies of the certification of contaminant content of materials used for liquid penetrant examination (see Section V, Article 6, T-641) shall be supplied to the Company with the examination reports.

3.4.2.7 Certified weld examination reports, together with the corresponding material surface examination reports shall be submitted to the Company in accordance with Attachment A. Examination reports shall include lot number and expiration date of liquid penetrant, developer, and cleaner used.

3.4.2.8 Certified weld examination reports shall be submitted in accordance with Attachment A for all weld and surface examination shall include:

a. The CV serial number
b. A weld map showing the location of the weld and examination area
c. The welder's ID
d. The examiner's name
e. The time and date of the weld examination
f. Identification of the examination procedure(s) used
g. WPS number for each weld
h. Heat numbers of the materials joined
i. The heat number of the weld filler
j. Examiner's remarks

3.4.2.9 Examiner's remarks on weld examination reports and surface examination reports shall include the results of the examination and acceptance or rejection based on the stated criteria and shall include a description and sketch showing the location of defect(s).

3.4.2.10 One set of radiographs shall be provided to the Company with radiographic examination reports.

3.4.2.11 If a weld is rejected, the area may be weld repaired by the Supplier and re-examined. After two unsuccessful repair attempts, the Company shall be notified for approval prior to performing more repair attempts. The Company may, at its option, choose to reject further repair efforts and require that a replacement part be fabricated.

3.4.2.12 Implement, at any and all sub-tier levels during production, the workmanship provisions of ASME Section III, Division 1 as appropriate for the applicable material and not modified by the acceptance criteria presented in this document.

3.4.2.13 Notify the Company through the bid or proposal if a sub-tier will perform welding or non-destructive examination (NDE) services. The sub-tier(s) must be identified with the bid or proposal and submit the applicable documentation specified by the governing code(s) for welding and/or NDE for the sub-tier supplier(s) with the bid and for approval.

3.4.2.14 Notify the Company if, after the award of a subcontract, the Supplier determines the need for welding and/or NDE services from a sub-tier(s). The sub-tier(s) must be identified and submit the applicable documentation specified by the governing code(s) for welding and/or NDE for the sub-tier supplier(s) with the proposed change and for approval.

3.4.2.15 The Company may conduct welding inspection and oversight activities. Hold/witness points will be identified by the Company in the Supplier's manufacturing schedule after it is submitted to the Company for review.

3.4.3 Cleaning, Passivation, and Bead Blasting

3.4.3.1 Cleaning, passivation, and bead blasting procedures for the stainless steel, including weld areas, shall be submitted to the Company for approval in accordance with Attachment A.

3.4.3.2 After final machining and all examination of welds and surfaces, the Supplier shall clean and passivate all stainless steel surfaces of the CV in accordance with ASTM A380.

3.4.3.3 After passivating is complete, the Supplier shall bead blast all exterior surfaces in accordance with SSPC-SP 5/NACE No. 1, White Metal Blast Cleaning, with the exception of sealing or threaded surfaces.

3.4.3.4 Finished components awaiting assembly and final assemblies shall be free of dirt, debris, foreign objects, cutting fluids, metal chips, grinding residue, liquid penetrant and developer, and other foreign substances. The Company shall perform a final inspection of the CV vessel prior to installation with the drum. The Company shall apply an Empty label to the CV assembly prior to installation in the drum.

3.4.3.5 The Supplier shall clean, cover, and protect parts and subassemblies from becoming dirty while in storage, and to the extent practicable, in the shop environment while in work.

3.4.3.6 Only non-chloride bearing chemicals shall be used for cleaning (such as trisodium phosphate detergent or acetone).

3.4.3.7 A list of cleaning chemicals to be used shall be submitted for approval in accordance with Attachment A. Safety Data Sheets (SDS) of all cleaning chemicals shall be provided to the Company before use.

3.4.3.8 Water used in cleaning shall have a maximum chlorine content of 4 parts per million tested monthly.

3.4.3.9 Certified cleaning, passivation, and bead blasting procedures and reports shall be documented per ASTM A380 and submitted in accordance with Attachment A.

3.5 Government-Furnished Equipment

3.5.1 Silicone Rubber Parts

Silicone Rubber Parts per DS 801580-0002 and drawing M2E801580A024 shall be supplied by the Company.

3.5.2 O-ring(s) (Inner & Outer)

O-ring(s) per SPC M801580-0002 and drawing M2E801580A013 shall be supplied by the Company.

3.6 Hydrostatic Testing

3.6.1 A hydrostatic test procedure including sample test report forms shall be prepared by the Supplier and submitted to the Company for approval prior to testing in accordance with Attachment A.

3.6.2 After all machining is complete, assembled CVs shall be hydrostatically tested by the Supplier in accordance with the applicable sections of NB-6000.

3.6.3 The test shall be conducted with a test pressure of 158 psig +/- 5 psig at ambient temperature (60°F to 90°F).

3.6.4 The test medium shall be water with a maximum chlorine content of 4 parts per million tested monthly.

3.6.5 The Supplier shall provide suitable fittings to perform the hydrostatic testing.

3.6.6 Measuring devices used in performance of hydrostatic testing shall be certified and certified calibration reports shall be made available upon request to the Company. Applicable test equipment calibration shall be traceable to NIST.

3.7 Leak Testing

3.7.1 Leak test procedure(s) (written by a leak testing ASNT NDT Level III) including sample test report forms shall be prepared to perform this testing and shall be submitted to the Company for approval in accordance with Section 4.1 and Attachment A.

3.7.2 Leak test equipment shall be calibrated and certified calibration reports shall be made available upon request to the Company. Applicable test equipment calibration shall be traceable to NIST.

3.7.3 Two leak tests shall be performed on the CV after hydrostatic testing.

3.7.4 Prior to conducting any leak test, the CV and O-ring cavities must be thoroughly dried.

3.7.5 The leak testing shall be performed in accordance with the applicable sections of ANSI N14.5-1997.

3.7.6 The leak test procedure(s) and leak testing report shall comply with the applicable requirements of Section V of the ASME Code.

3.7.7 The leak testing for the first leak test shall have the sensitivity to detect a leak less than or equal to 5×10^{-8} ref-cm^3/sec of air, or 1×10^{-7} cm^3/sec helium and shall use the leak test fixture shown on the Company's drawing T2E801827A009.

3.7.8 The first leak test of the CV body and lid shall be performed with the CV assembled as shown on drawing T2E801827A009, (Part T2E801827A009-1, *Containment Vessel Body Leak Test Assembly*). Note that the outer O-ring in the CV body is not to be installed for this test. The leak testing acceptance criteria is as follows: the assembly shall not have an integrated leak rate greater than 1×10^{-7} ref-cm^3/sec of air or 2×10^{-7} cm^3/sec helium.

3.7.9 The second leak test is to be performed with the CV assembled as shown on Drawing M2E801580A011. The leak testing acceptance criteria is that the assembly shall not have an air leak rate greater than 1×10^{-4} ref-cm^3 /sec and the sensitivity of the leak testing procedure shall be less than or equal to 5×10^{-5} ref-cm^3 /sec.

3.7.10 If a leak is found the Company shall be notified in writing using the RFWD form, see Section 3.14.

3.7.11 A leak may be weld repaired by Supplier only if specifically permitted by the Company in writing, and the leak test repeated. The Company may, at its option, choose to reject repair efforts, and require that a replacement part be fabricated.

3.7.12 Certified leak test reports that describe the leak testing process and results shall be provided to the Company in accordance with Section 4.1 and Attachment A.

3.7.13 The leak test reports shall include the following data:

a. CV serial number
b. identification of all standard leaks, gauges, transducers and electronic readouts
c. CV serial number
d. date on which these instruments were certified
e. identification of the leak detector
f. date on which the leak detector was last certified
g. date of the leak test
h. time of the start and end of the test
i. recorded pressures and leak rates at the start and end of the test
j. name of the person conducting the test
k. qualifications of the person conducting the test
l. location of areas where the CV was repaired, if applicable
m. any pertinent remarks

3.8 Final Examination of Finished Surfaces

3.8.1 After all finish machining, load testing, leak testing, and hydrostatic testing, all accessible surfaces of the CV body assembly (drawing M2E801580A012), the CV sealing lid (drawing M2E801580A015), and the CV closure nut (drawing M2E801580A016) shall be examined with liquid penetrant in accordance with NB-2546 (see Section 3.4 for additional requirements for the materials used in the liquid penetrant examination).

3.8.2 The procedure for final surface examination including sample test reports shall be submitted to the Company for approval in accordance with Section 4.1 and Attachment A.

3.8.3 The results of the final surface examinations shall be documented in a certified examination report and provided to the Company in accordance with Section 4.1 and Attachment A.

3.8.4 If a defect is found, the component shall be tagged and segregated to prevent inadvertent use, and the Company shall be notified in writing using the RFWD in accordance with Section 3.14 and Attachment A, for disposition.

3.8.5 Defective areas may be weld repaired by the Supplier only if specifically permitted by the Company in writing, and the area re-examined. The Company may, at its option, choose to reject repair efforts and require that a replacement part be fabricated.

3.9 Dimensional Inspection

3.9.1 Dimensional requirements specified on the Company's drawings require inspection procedure that shall include:

a. A listing of features to be inspected
b. Identification of inspection equipment to be used inspect each dimension or tolerance
c. Sample data sheets with adequate data recording space to record inspection results
d. Adequate information to ensure traceability of inspection data to specific serial numbered CVs.

3.9.2 The Supplier shall submit inspection procedures for Company approval in accordance with Attachment A.

3.9.3 The Supplier shall be responsible for determining stock sizes so that the finished machined components meet the dimensions and tolerances specified on the attached drawings.

3.9.4 Prior to performing final inspection, the Supplier shall perform all deburring and cleaning operations required to ensure that CVs are free of all fabrication and handling defects and that no foreign materials are present on the vessel surfaces or features (i.e., scratches, dents, nicks, gouges, tool marks, etc.), that are greater than good workmanship standards.

3.9.5 The forming, fitting, and alignment requirements stated in paragraph NB-4200 shall be met in the fabrication of each CV unless more stringent requirements are specified on the Company's drawings.

3.9.6 The roundness of cylinders, profile of formed head surfaces, and misalignment or offsets in weld joints shall be included in the dimensional inspection reports for each Containment Vessel and shall satisfy the requirements paragraph NB-4200 unless more stringent requirements are specified on the Company's drawings.

3.9.7 The Supplier shall not perform a final inspection of the vessel until all machining and process operations have been completed. Sufficient re-inspection after testing operations are complete may be required to ensure the containers meet the applicable specifications.

3.9.8 Inspection, Measuring and Test Equipment shall be calibrated and certified by an organization with ISO 17025 accreditation, or Y-12 approved equal, and traceable to the National Institute of Standards. Documentation shall be submitted in accordance with the attachment A, Submittal Checklist.

3.9.9 Where inspection or test equipment yields quantitative readings, actual measurements and deviation from nominal readings shall be recorded.

3.9.10 The Supplier's inspection shall include, as a minimum, the following:

a. All dimensions and tolerances on Company drawings including a diamond <I> or <S> shall require 100% inspection, documentation, and shall be submitted per Attachment A.

b. Edge breaks.

c. Surface finish.

d. Cleanliness as specified in Section 3.4.3.

e. Part identification as specified by the drawings.

f. Diameter dimensions that show compliance with the requirements of paragraph NB-4200.

3.9.11 Certified inspection report(s) shall be prepared and submitted to the Company in accordance with Attachment A.

3.9.12 Straightening, flattening, and forming of the weldment by mechanical means after welding may be required to ensure proper assembly and fit. The surfaces of areas of the weldment that have been worked shall be visually examined to ensure that no cracks are present and that the weldment has not been degraded. Adjacent welds to these areas shall also be visually examined. The acceptance criteria are that no cracks are found in the weldment. The areas worked and the visual inspections performed shall be noted on an inspection report.

3.9.13 The Company shall require verification of Diamond <I> or Diamond <S> dimensions in accordance with a normal sampling plan based on the total PO quantity in accordance with Y17-69-316 Chapter 6, attachment 6-C.

3.9.14 All equipment and instruments (Measuring and Testing Equipment (M&TE)) used in the conduct inspections shall bear a calibration sticker that shows the equipment to be within its calibration period. Calibrations must be performed by a laboratory that meets ISO 17025:2005. All calibration sources shall be traceable to the National Institute of Standards and Technology (NIST). All certification documentation shall be submitted to the Company in accordance with Attachment A.

3.10 Schedule (Specify to be submitted for approval)

The Supplier shall prepare a proposed schedule for the fabrication of the ES-3100 CV assembly specified herein. This proposed schedule shall be submitted with the offer in accordance with Attachment A.

The Company will conduct oversight activities. Hold/witness points will be identified by the Company in the Supplier's schedule after it is submitted to the Company for review.

3.11 Deliverables (Including Submittals)

The deliverables for this specification includes, but is not limited to:

a. Completed and assembled ES-3100 CV assembly

b. All Requests for Waiver/Deviations shall be closed.

c. All submittal documentation in accordance with Attachment A, with applicable documentation in data packages specific to each ES-3100 CV assembly identified by its serial number.

The documentation required with the proposal (WP) as indicated in the "Submittal Checklist," Attachment A, shall be submitted to the Company in the quantities listed with the Supplier's offer. Submittals shall be e-mailed to the Company SA and the STR.

The Company will review the submittals that are required prior to fabrication as indicated in the "Submittal Checklist," Attachment A, and respond as shown in the "Instructions to Supplier for Preparation of Submittals," Item h.

The Company shall review the submittals required per Attachment A. Shipping shall not commence without documented permission from the Company.

3.11.1 Material certifications and/or any supporting test data as specified above cannot be waived. Failure to supply the required data shall be cause for rejection of the entire shipment lot.

3.11.2 Certification data shall be provided to the Company as soon as possible after completion of the vessels.

3.12 Packaging, Handling, Shipping, and Storage Requirements

The CVs are part of the ES-3100 Shipping Container and will be shipped with the ES-3100 Drum Assembly package. See specification JS-YMN3-801580-A001 for requirements. A packing plan for shipment of the ES-3100 Drum Assembly package shall be sent to the Company for approval in accordance with Attachment A.

3.12.1 The CV sealing surfaces must be protected during shipment.

3.12.2 The Supplier shall not ship CVs with unapproved RFWD's

3.13 Marking and Identification Requirements

3.13.1 The assembled CVs shall be marked as specified on Company's drawings.

3.13.2 Permanent serial numbers for each CV shall be assigned by the Company and identified in the Purchase Order.

3.14 Requests for Waiver or Deviation

3.14.1 After award, if a waiver or deviation from the specified requirements is desired, then the Supplier shall submit to the Company a Request for Waiver or Deviation form: UCN-13816B. The Company will provide this form upon request.

3.14.2 Use the UCN-13816B form to request permission to change or deviate from the specified requirements; obtain Company approval before proceeding with any changes.

3.14.3 Email the completed form to the STR.

3.14.4 Use the form to report any of the following conditions:

a. A request for deviation from the contract requirements.

b. Anytime a requirement contained within the original specification or a contract modification approved by the Company is violated.

c. There is nonconformance that cannot be corrected unless an item or process is modified, reworked, or repaired to an equivalent functional condition.

d. A request for Company approved substitutions shall be submitted using the RFWD form for Company approval prior to implementation. Adequate information shall be provided with the request so that the Company can determine if the item is equivalent.

3.15 Documentation Retention

3.15.1 Documentation of all inspection and test results shall be maintained by the Supplier for three years after delivery to the Company.

3.15.2 The Company shall be given access to this data upon request.

3.16 Use of Subcontractors

The Supplier shall ensure that all its suppliers and subcontractors comply with the requirements of this specification (including quality assurance requirements). Supplier and subcontractor procedures, approved by the Supplier, shall be included in the procedures submitted to the Company for review and approval.

3.17 Witness of Documentation and Processes

3.17.1 The Company shall be given access to all documentation and shall be allowed to witness any of the processes associated with this specification during the performance of the contract.

3.17.2 The Company shall be informed prior to the start of any testing activities and an agreed upon schedule shall be established. The Company reserves the right to witness any testing activities performed.

3.18 Nonconformance Control

3.18.1 Nonconforming products shall be documented using the Supplier's designated form as required in their QA Plan, and a copy sent to the Company representative.

3.18.2 Deviations or waivers shall be controlled using, Request for Waiver or Deviation, and sent to the Company for approval.

3.19 Approved Procedures

a. Manufacturing, examination, and testing processes shall be controlled by procedure and performed by qualified personnel.
b. Procedures shall incorporate a mechanism to identify process step completion.
c. Procedures shall be submitted to the Company for approval in accordance with Attachment A.

4.0 QUALITY ASSURANCE REQUIREMENTS

4.1 Final Acceptance Method

4.1.1 Final Acceptance will be based on the results of the following:

a. Certified Data Package
b. Hydrostatic test of each ES-3100 CV in accordance with Section 3.6
c. Load test of each ES-3100 CV per drawing M2E801580A011 and in accordance with an approved load test report
d. Sealing test of each ES-3100 CV per drawing M2EM801580A014 and in accordance with an approved sealing test report
e. Helium leak test of each ES-3100 CV in accordance with Section 3.7
f. Air leak test of each ES-3100 CV in accordance with Section 3.4.10
g. Dimensional inspection reports of each ES-3100 CV in accordance with Section 3.9
h. Submittals listed on Attachment A
i. After all testing, a liquid penetrant report in accordance with NB-2564

4.2 Inspection/Testing Requirements

4.2.1 NDE Examiner Qualifications

4.2.1.1 Qualifications of the personnel performing material or weld examination shall be those provided in NB-5500.

4.2.1.2 Qualification records shall be submitted for approval with the examination procedures in accordance with Attachment A.

4.2.1.3 Certified hydrostatic test reports for each CV shall contain the following data:

a. Serial number of the CV
b. Time and date of the test
c. Name of person who performed the hydrostatic testing
d. Hydrostatic test procedure number
e. Name, serial number and calibration date of all gages and transducers
f. Sketch areas showing any leakage or any areas where surface defects where observed after hydrostatic testing.

Certified hydrostatic test reports shall be submitted to the Company in accordance with Section 4.1 and Attachment A.

4.3 Quality Requirements

The Supplier shall perform all work under a QA Program that complies fully with both 10 CFR 71 Subpart H and NQA-1. If requirements are unclear, or full compliance with both Subpart H and NQA-1 is uncertain, the Supplier shall contact the Company for resolution.

If the Supplier purchases Nuclear Safety Related materials or services from a source that does not have an NQA-1 compliant QA Program, they shall be dedicated in accordance with Commercial Grade Dedication Plans approved by the Company. Otherwise, use suppliers already approved on the Company Quality Assurance Suppliers List. Contact the STR for approved suppliers.

For special processes including, but not limited to, flow-forming, heat treating, welding, and NDE, the Supplier shall provide control over activities affecting the quality of the materials and components as necessary to assure conformance to the approved design.

The Supplier shall have implemented and maintain a quality system in accordance with ASME NQA-1 Quality Assurance (QA) Program that meets the requirements of NQA-1 2008, 1a-2009, 1b-2011 Part 1, Section 1-18. A copy of the Supplier's QA Program Manual shall be submitted with the bid in accordance with Attachment A for review and approval. The Supplier shall comply and conduct all work in accordance with their Quality Assurance program and this Equipment Specification.

An uncontrolled copy of the Supplier's controlled QA Program and all applicable subtier suppliers' quality assurance program manuals shall be submitted as Offer Appraisal Data in accordance with Attachment A.

The Supplier shall provide an Excel transmittal or similar file to document the transmission and status of data files. This file shall be updated after each transmission or status change and shall at least identify data by; name, date of transmission, file size, and status (i.e. for review or approval). This file shall be included with the submitted data.

4.3.1 Suspect/Counterfeit Items

The Supplier's QA Program shall implement DOE O 414.1D Attachment 3, with respect to Suspect Counterfeit Items.

Contract terms and conditions that establish the plant's expectations with respect to the Supplier's role in preventing the introduction of S/CI.

The Supplier's requirements for preventing Suspect /Counterfeit Items (S/CI) from being introduced into the Company's supply chain are referenced in the General Terms and Conditions of the Request for Solicitation and/or Purchase Order.

The Supplier shall use components supplied or assemblies of components from OEM or authorized distributors.

4.4 Acceptance Criteria

4.4.1 Approval Data

Approval Data will be reviewed and must be approved by the Company before the Supplier proceeds with the applicable production activity. The Supplier shall schedule at least 4 weeks for Company

review of submittals. A list of the required Approval Data can be found in Attachment A to this specification.

4.4.2 Certified Data

a. A list of the required Certified Data can be found in Attachment A of this specification.
b. An electronic .pdf version of the Certified Data Package shall be provided prior to or with the shipment.
c. The Certificate of Conformance shall be signed by the Supplier and identify the applicable serial number of the CV included in the shipment, one Certificate of Conformance for each Drum Assembly (M2E801580A001).
d. The Certificate of Conformance shall attest that the CV assembly conforms to the requirements of this specification and Company drawings and approved RFWD's.
e. The CV assembly drawing number (M2E801580A011) associated with each Drum Sub-Assembly shall be recorded on the Certificate of Conformance.
f. The Certified Data package for each CV assembly shall be complete, legible, indexed and added to the final drum assembly (M2E801580A001).
g. The Certificate of Conformance shall list the approved RFWD's if applicable.

4.5 Personnel Qualifications/Certifications

The Supplier shall provide for the training and qualification of personnel to ensure their competence in the use of process procedures and specifications.

4.5.1 Records of personnel qualifications shall be made available to the Company upon request.

Attachment A: Submittal Checklist

SCHEDULE				FORMAT		PURPOSE	
AA	After Award	PTF	Prior to Fabrication	CD	Compact Disk	FA	For Action
AI	After Issue	PTFA	Prior to Final Acceptance/at Completion	DVD	Digital Video Disk	FI	For Information
AIT	After Inspection Test	PTL	Prior to Lift	EM	E-Mail		
AM	After Mobilization	PTM	Prior to Mobilization	EN	Electronic (Native)		
AP	After Proposal/Bid	PTS	Prior to Shipment	EP	Electronic (PDF)		
ATS	At Time of Shipment (Separately)	PTT	Prior to Test	O	Original		
B	Before Balance of Payment	PTW	Prior to Weld	P	Prints/Photocopies		
NTP	Notice to Proceed	Q	As Required	PH	Photographs		
PTC	Prior to Construction/Commencing Work	R	As Requested	S	Sample		
PTD	Prior to Delivery	WP	With Proposal/Bid	X	X-rays		

#	REFERENCE	REQUIREMENT DESCRIPTION	SCHEDULE	FORMAT	NO. OF COPIES	PURPOSE
1.	3.2.2.1	Certified Material Test Reports (CMTRs)	PTFA	EP	1	FI
2.	3.1.1.2	Certificates of Code Compliance	WP	EP	1	FI
3.	3.14	Request for Waiver or Deviation	Q	EP	1	FA
4.	3.1.1.4 & 3.2.5	Certificate of Conformance (when applicable)	PTFA	EP	1	FA
5.	3.10	Proposed contract performance schedule	WP	EP	1	FA
6.	3.9.14	M&TE Calibration Records & Certifications	PTFA	EP	1	FI
7.	3.2.1.3.a	Heat Treatment Procedure(s) (flow formed option)	PTC	EP	1	FA
8.	3.2.1.3.a	Heat Treatment Report (flow formed option)	PTFA	EP	1	FA
9.	3.2.1.3.c	Mechanical Properties Test Report (flow formed option)	PTFA	EP	1	FA
10.	3.4.1.12	Nonconformance procedure for welding	WP	EP	1	FA
11.	3.4.1.10.a	Job Specific Welding Procedure Specifications (WPS)	WP	EP	1	FA
12.	3.4.1.10.b	Job Specific Welding Procedure Qualification Record (PQR) for each WPS submitted (unless WPS is prequalified	WP	EP	1	FA
13.	3.4.1.10.c	Job Specific Welder Performance Qualification (WPQ) records, including evidence of process usage updates	WP	EP	1	FA
14.	3.4.1.10.d	Job Specific Visual examination and Nondestructive examination procedures	WP	EP	1	FA
15.	3.4.1.10.e	Job Specific Certification records of examination personnel	WP	EP	1	FA
16.	3.4.1.10.f	Job Specific Post Weld Heat Treatment (PWHT) procedures with appropriate procedure demonstrations (as required) and Supplier's acceptance documentation	WP	EP	1	FA

SCHEDULE				FORMAT		PURPOSE	
AA	After Award	PTF	Prior to Fabrication	CD	Compact Disk	FA	For Action
AI	After Issue	PTFA	Prior to Final Acceptance/at Completion	DVD	Digital Video Disk	FI	For Information
AIT	After Inspection Test	PTL	Prior to Lift	EM	E-Mail		
AM	After Mobilization	PTM	Prior to Mobilization	EN	Electronic (Native)		
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B	Before Balance of Payment	PTW	Prior to Weld	P	Prints/Photocopies		
NTP	Notice to Proceed	Q	As Required	PH	Photographs		
PTC	Prior to Construction/Commencing Work	R	As Requested	S	Sample		
PTD	Prior to Delivery	WP	With Proposal/Bid	X	X-rays		

#	REFERENCE	REQUIREMENT DESCRIPTION	SCHEDULE	FORMAT	NO. OF COPIES	PURPOSE
17.	3.4.1.10.g	Provide a list of all welded assemblies not fabricated in accordance with Supplier's welding program. Include any welded assemblies to be purchased as commercial-off-the-shelf.	WP	EP	1	FI
18.	3.4.1.11.a	WPS for all commodities to be welded. Provide drawing, sketch, list of components etc., where WPS is to be applied	PTW	EP	1	FA
19.	3.4.1.11.b	Weld Procedure Qualification Records (PQR) for each WPS submitted (unless WPS is prequalified)	PTW	EP	1	FA
20.	3.4.1.11.c	Welder Performance Qualification (WPQ) records, including evidence of process usage updates	PTW	EP	1	FA
21.	3.4.1.11.d	Roster of all welders to be used to perform work with continuity/expiration dates identified for each process the welder is qualified	PTW	EP	1	FA
22.	3.4.1.11.e	Updated records (Roster) as required throughout the contract duration, to demonstrate welders submitted have maintained their qualifications	R	EP	1	FA
23.	3.4.1.11.f	NDE-Visual examination and nondestructive examination procedures, VT, MT, PT, RT, UT (as applicable)	PTW	EP	1	FA
24.	3.4.1.11.g	NDE-Certification records of examination personnel	PTW	EP	1	FA
25.	3.4.1.11.h & 4.2.1	NDE-Procedure for Qualification and Certification of Nondestructive Testing Personnel	PTW	EP	1	FA
26.	3.4.1.11.i	NDE-Current eye examination record (Annual) for examination personnel	PTW	EP	1	FA
27.	3.4.1.11.j	Certified Material Test Report (CMTR) for weld filler materials (as required) for each Heat/Lot to be used	PTW	EP	1	FA
28.	3.4.1.11.k	Submit a written procedure specifying requirements for the control of filler materials and electrodes	PTW	EP	1	FA

SCHEDULE				FORMAT		PURPOSE	
AA	After Award	PTF	Prior to Fabrication	CD	Compact Disk	FA	For Action
AI	After Issue	PTFA	Prior to Final Acceptance/at Completion	DVD	Digital Video Disk	FI	For Information
AIT	After Inspection Test	PTL	Prior to Lift	EM	E-Mail		
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ATS	At Time of Shipment (Separately)	PTT	Prior to Test	O	Original		
B	Before Balance of Payment	PTW	Prior to Weld	P	Prints/Photocopies		
NTP	Notice to Proceed	Q	As Required	PH	Photographs		
PTC	Prior to Construction/Commencing Work	R	As Requested	S	Sample		
PTD	Prior to Delivery	WP	With Proposal/Bid	X	X-rays		

#	REFERENCE	REQUIREMENT DESCRIPTION	SCHEDULE	FORMAT	NO. OF COPIES	PURPOSE
29.	3.4.1.11.l	Submit welding fabrication drawings for all welded components	PTW	EP	1	FA
30.	3.4.2.7, 3.4.2.8, 3.4.1.4 & 3.4.1.11.m	Weld examination records, weld maps, radiographs, and PWHT chart recordings	PTT/PTS	EP/X	1	FA
31.	3.4.1.13	Certified Material Test Report (CMTR) for Weld Filler Material	PTW	EP	1	FI
32.	3.4.2.13	The sub-tier(s) must be identified with the bid or proposal and submit the applicable documentation specified by the governing code(s) for welding and/or NDE for the sub-tier supplier(s) with the bid and for approval.	WP	EP	1	FA
33.	3.4.2.14	If, after the award of a subcontract, the Supplier determines the need for welding and/or NDE services from a sub-tier(s). The sub-tier(s) must be identified and submit the applicable documentation specified by the governing code(s) for welding and/or NDE for the sub-tier supplier(s) with the proposed change and for approval.	PTW	EP	1	FA
34.	3.4.3.9	Cleanliness Procedures and Report	PTFA	EP	1	FI
35.	3.4.3.7	Cleaning chemical list	PTF	EP	1	FI
36.	3.7.1	Leak Test Procedure(s)	WP	EP	1	FA
37.	3.7.13	Helium Leak Test Report & Pressure Rise Report	PTFA	EP	1	FA
38.	3.9.2	Dimensional inspection Procedure(s)	PTF	EP	1	FA
39.	3.9.11	Dimensional inspection Report	PTFA	EP	1	FA
40.	4.3	Quality Plan/Program	WP	EP	1	FA
41.	4.1.1	Liquid Penetrant Report	PTFA	EP	1	FA
42.	4.1.1	Load Test Report	PTFA	EP	1	FA
43.	4.1.1	Sealing Test Report	PTFA	EP	1	FA
44.	3.12	Packing/Shipping Plan	PTFA	EP	1	FA

SCHEDULE				FORMAT		PURPOSE	
AA	After Award	PTF	Prior to Fabrication	CD	Compact Disk	FA	For Action
AI	After Issue	PTFA	Prior to Final Acceptance/at Completion	DVD	Digital Video Disk	FI	For Information
AIT	After Inspection Test	PTL	Prior to Lift	EM	E-Mail		
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PTC	Prior to Construction/Commencing Work	R	As Requested	S	Sample		
PTD	Prior to Delivery	WP	With Proposal/Bid	X	X-rays		

#	REFERENCE	REQUIREMENT DESCRIPTION	SCHEDULE	FORMAT	NO. OF COPIES	PURPOSE
45.	3.6.1	Hydrostatic Test Procedure(s)	PTFA	EP	1	FA
46.	4.2.1.3	Hydrostatic Test Report	PTFA	EP	1	FA
47.	3.8.2	Surface Examination Procedure(s)	PTFA	EP	1	FA
48.	3.4.2.7 & 3.8.3	Surface Examination Report	PTFA	EP	1	FA

Attachment B: Instruction to Supplier for Preparation of Submittals

Note 1 -- All correspondence shall be addressed to the Technical Representative identified by the Company. The Supplier shall forward submittals via transmittal letter to the Company at the address specified in the contract.

Note 2 -- The submittal must have adequate detail so that full compliance with the requirements may be determined. For example, a simple off the-shelf item to be used in an assembly may only need a supplier's cut-sheet to show compliance, but a factory acceptance test (FAT) developed and submitted by the Supplier must have each test step detailed with acceptance criteria consistent with the requirements.

a. Review submittal before transmitting to the Company to verify conformance with requirements of the contract documents (e.g., field measurements, field construction criteria, or Supplier's catalog numbers).
b. Coordinate submittals with the work requirements and the contract documents.
c. Organize Submittals
   - Do not use highlight marker or color coding on submittals.
   - The minimum resolution used for scanning submittals shall be 300 dpi x 300 dpi.
   - For submittals containing color information important to the record, a 24-bit color setting should be used.
   - Submittals are to be legible and in the format specified on the submittal checklist.
   - Pen and ink changes are to be made in non-erasable ink, legible, dated and initialed.
   - Mark specific options provided for the work, and cross out options not provided.
   - Each submittal shall be sent as a single pdf file unless otherwise specified.
d. Label submittals with the applicable item number, reference, and requirement description as summarized in the Submittal Checklist. Unlabeled submittals will be returned to the Supplier without review.
e. Include with submittals a transmittal letter that identifies individual documents by specification section.
   - Transmittal for submittals shall be numbered using the purchase order number followed by a 4-digit sequential number. (Example: 430001111-0001).
   - Embedded comments or questions that are not included on the transmittal may not be addressed/resolved by the Company.
f. Direction will be given at the time of award to either upload submittals to a company provided URL address or send by email to a company provided email address.
g. If using a company provided URL to upload submittals, notify the Company via email when submittals have been placed.
h. After review of a submittal, the Company will assemble comments and provide a status on the documents. An example of this submittal status stamp is shown below.

DOCUMENT REVIEW STATUS		
1	☐ Work may proceed.	
2	☐ Revise & resubmit. Work may proceed subject to incorporation of changes indicated.	
3	☐ Revise & resubmit. Work may not proceed.	
4	☐ Review not required. Work may proceed.	
Permission to proceed does not constitute acceptance or approval of design details, calculations, analysis, test methods developed or selected by the supplier and does not relieve supplier from full compliance with contractual obligations.		
REVIEWED BY:	Print Name/Signature :	Date:

i. If a submittal is being resubmitted, then reference the applicable item number, reference, and requirement description and identify it as a resubmittal.
j. Company response will only be returned to the Supplier for those submittals with a Submittal Purpose of "For Action, "unless it is determined that a submittal transmitted "For Information" is not acceptable.
k. AFTER written approval is obtained, THEN proceed with work requiring approved submittals.
l. When approval submittals are required, work done before Company approval is at the Supplier's risk.
m. Maintain a copy of the company-approved submittal and status page on file.

Attachment C: Abbreviations and Acronyms

ANI	Authorized Nuclear Inspector
ANSI	American National Standards Institute
ASME	American Society for Mechanical Engineers
ASNT	American Society Nondestructive Testing
ASTM	American Society for Testing Materials
AWS	American Welding Society
BPVC	Boiler and Pressure Vessel Code
CMTR	Certified Material Test Report
COC	Certificate of Conformance
CV	Containment Vessel
DOE	Department of Energy
EPDM	Ethylene Propylene Diene Monomer
FAE	First Article Evaluation
GTAW	Gas Tungsten Arc Welding
GMAW	Gas Metal Arc Welding
lb	pounds
MT	Magnetic Test
NCR	Non-conformance Report
NDE	Non-destructive examination
NDT	Non-Destructive Testing
NFPA	National Fire Protection Association
NEMA	National Electrical Manufacturer's Association
psig	Pounds per Square Inch, gage
PQR	Procurement Quality Report
PWHT	Post-weld Heat Treatment
PT	Penetrant Test
QASL	Quality Approved Supplier List
QSC	Quality System Certificate
RT	Radiographic Testing
S/CI	Suspect / Counterfeit Items
UL	Underwriter's Laboratory
UT	Ultrasonic nondestructive testing
VT	Visual Testing
WFM	Weld Filler Material
WPQ	Welder Performance Qualification
WPS	Welding Procedure Specification
Y-12	Y-12 National Security Complex

Attachment D: Requirements for Authorized Nuclear Inspector (ANI)

1.0 REQUIREMENTS

If requirements are unclear, or conflicts exist between applicable documents on this work, the Supplier shall contact the Company STR for resolution. If multiple interpretations are possible, the Supplier shall contact the STR for clarification based on the Company's intent. All work associated with this attachment is important to nuclear safety.

1.1 The Supplier shall subcontract for and oversee this work in accordance with its Nuclear QA Manual approved by the Company for this subcontract, for a nuclear safety related item.

1.2 Both the Supplier and the ANI shall perform their duties per the ASME Code as though the CVs will be Code stamped and both shall sign the Certificate Holder's Report of Inspection provided at the end of this attachment.

1.3 Each inspection by the ANI shall be documented and included with the Supplier's certification records for the item being inspected.

1.4 Supplier approval Data Documents and Certification Data Documents like procedures, inspection reports, test reports, etc. associated with ASME Code work shall be stamped and/or signed and dated by the ANI, indicating his review and approval.

1.5 ANI inspection results, reports, and other quality records associated with the ANI's work shall be submitted to the Company along with other quality records required in this specification.

1.6 The ANI shall not inspect 100% of the CVs but shall inspect based on EPRI recommendations for a NORMAL sampling plan (EPRI Guideline for Sampling, document number TR-017218-R1, dated January 1999). The ANI's sampling plan or approach shall be approved by the Company in advance of the work, to ensure. As a minimum, each manufacturing batch of items being worked shall be sampled. A manufacturing batch is defined as a segment of the overall quality to be manufactured that is being worked as a batch with no breaks or interruptions that would affect the quality of the work. Manufacturing batches must be identified by the Supplier and approved by the Company in advance so Company resources can make plans to oversee and participate with the work the Company deems appropriate.

2.0 DOCUMENTATION REQUIREMENTS

2.1 Submittals for Company approval prior to initiating work

2.1.1 Copy of a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors for the ANI (Approval Data)

2.1.2 Approval Data Documents for ASME Code work with stamp or signature showing ANI review and approval (Approval Data)

2.1.3 Sampling Plan for ANI inspections (Approval Data)

2.2 Submittals following the work for Company acceptance

2.3 ANI inspection results, reports, and other quality records associated with the ANI's work (Certification Data)

2.4 Certification Data Documents for ASME Code work with stamp or signature showing ANI review and approval (Certification Data)

3.0 ACCEPTANCE OF WORK

Final acceptance of this work will be based on the Company's acceptance of the applicable Advance Data documents and Certification Data documents submitted to the Company for approval as required in this attachment.

Certificate Holder's Report of Inspection
Subcontract Number TBD

Item name: _____ Item drawing number: _____
Item serial number: _____

Certificate Holder – Supplier
The Supplier certifies that the subject item was manufactured in accordance with the ASME Boiler and Pressure Vessel Code requirements specified in Equipment Specification _____, Revision _____, and all Owner approved Deviations and Waivers.

Certificate of Authorization Number: _____Expiration date: _____
Authorized Representative name and title (printed):
_____
Authorized Representative signature and date:
_____

Authorized Nuclear Inspector
Holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors, the following ANI has inspected the subject item during the manufacturing process and certifies that it has been manufactured in accordance with the ASME Boiler and Pressure Vessel Code requirements specified in Equipment Specification _____, Revision _____, and all Owner approved Deviations and Waivers.
ANI Commission number and expiration date: _____
ANI Name (printed): _____
ANI signature and date: _____
By signing this certificate, the Inspector makes any warranty, expressed or implied, concerning the subject item. Furthermore, neither shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.

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Appendix 1.3.4
Equipment Specification JS-YMN3-801580-A003,
Manufacturing Process Specification for Casting Kaolite 1600™
into the ES-3100 Shipping Package

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EQUIPMENT SPECIFICATION APPROVAL/REVISION PAGE

SPECIFICATION NO.	REV.	ISSUE DATE
JS-YMN3-801580-A003	C	11/24/03
PAGE	REVISION DATE	
i OF ii	6/1/06	
PROCURED BY	INSTALLED BY	
BWXT L.L.C.	BWXT L.L.C.	
PROJECT TITLE	PLANT	BUILDING
ES-3100 SHIPPING PACKAGE	Y-12	YAREA-00
JOB TITLE	W.O. OR E.S.O.	RECORD NUMBER
Production Design Definition	7RCPCA08	2003-0328
SPECIFICATION FOR		SSC IDENTIFICATION NUMBER
MANUFACTURING PROCESS SPECIFICATON FOR CASTING KAOLITE 1600™ INTO THE ES-3100 SHIPPING PACKAGE		

ENGINEERING AND PLANT APPROVALS

SIGNATURE	DATE	SIGNATURE	DATE
PREPARED BY		PROJECT ENGINEER:	
R. D. Aigner	11-25-03	G. A. Byington	11-25-03
DISCIPLINE MANAGER		OPERATIONS MANAGER/SYSTEM OWNER:	
J. C. Walls	11-25-03		
DESIGN VERIFICATION			
R. D. Aigner	11-25-03		

REVISIONS/ENGINEERING AND PLANT APPROVALS

REV. NO.	DESCRIPTION OF REVISION
A	Issue for procurement
B	Removed the reference to the Prototype Procurement Specification document number OO-PP-1210. Change the equipment reference in Section 3.1.3(c) from a "large mortar mixer or plaster mixer with moving vanes or a smooth wall cement mixer with the fixed vanes removed" to "Whiteman Multiquip's WM700S-H8 plaster/mortar mixer, refereed to as WM700". In Section 3.2 changed the method and time that the water and dry mix were added into the mixer based upon the mixer qualification in Section 3.5. Added Section 3.5, added attachments E and F to determine the proper mixing time and the Mixer Qualification Castings. In section 3.3.1 and 3.3.3 added misting procedure. Section 3.3.2(b) added a circular concave of .32±.10 to the Kaolite before it is baked to match drawing M2E801580A002. Section 3.3.4(b) add a circular convex scrape of .09±.06 to the Kaolite before it is baked to match drawing M2E801580A008. Updated the attachments with general revisions. Section 3.4 has been subdivided into 3.4.1 Baking Instruction and 3.4.2 Baking Documentation and added attachment F to this section.
C	Revised patent information in scope. Added recommended "Before Baking" weights for the Body Weldment and Top Plug Weldment based upon a more refined Kaolite 1600™ product code GI80ACCUMD0027 that is produced to the lower side and a smaller range of the manufactures normal tolerance band. This Kaolite 1600™ product code requires using 1.65 times the dry weight for the water weight (instead of 1.5) and generates an acceptable wet mix density of 56.2+/− 5.8 lb/ft^3. This additional water requires between 36 to 46 hours of bake time at 500°F.

SIGNATURE	DATE	SIGNATURE	DATE
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This document has been has been reviewed by a Y-12 ADC and UNCI RO and has been determined to be UNCLASSIFIED and not UNCI. This review does not constitute clearance for public release.

Name: R. D. Aigner Date: 06/01/06

EXEMPT FROM IO-155

TABLE OF CONTENTS

		Page
1	**Scope**	3
2	**Applicable Documents**	3
3	**Kaolite 1600™ Processing Requirements**	3
3.1	**General**	3
3.1.1	Kaolite 1600™ Receiving and Storage Instructions	3
3.1.2	Cleaning Instructions	4
3.1.3	Mixing Water and Mixing Equipment Requirements	4
3.2	**Mixing of Kaolite 1600™**	4
3.3	**Vibration Casting and Curing of Kaolite 1600™ Into Assemblies**	5
3.3.1	Body Weldment Casting Instructions	5
3.3.2	Body Weldment Curing Instructions	6
3.3.3	Top Plug Assembly Casting Instructions	6
3.3.4	Top Plug Assembly Curing Instructions	7
3.4	**Baking of Assemblies Cast and Cured with Kaolite 1600™ mixture**	7
3.4.1	Baking Instructions	7
3.4.2	Baking Documentation	8
3.5	**Mixer Qualification for Kaolite 1600™ Casting Placement**	9
3.5.1	Wet Density Mixing Test	9
3.5.2	Mixer Baked Density Qualification Castings	10
4	**Quality Assurance Requirements**	10
4.1	**General**	10
4.2	**Material and Equipment Certification**	11
4.3	**Nonconformance Control**	11
4.4	**Operator and Witness Qualifications**	11
4.4.1	Kaolite 1600™ Mixing Process Qualifications	12
4.4.2	Kaolite 1600™ Vibration Casting Process Qualifications	12
4.4.3	Kaolite 1600™ Baking Process Qualifications	12

ATTACHMENTS

A	**Kaolite Mixing Control**
B	**Body Weldment**
C	**Top Plug Assembly Vibration Casting Control**
D	**Furnace and Baking Control**
E	**Wet Density Mixer Time Vibration Casting**
F	**Baked Qualification Density Sample Vibration Casting**

1 Scope

This manufacturing process specification describes the quality assurance and technical requirements that shall be met when weighing, mixing, pouring, vibrating, curing, and baking the Kaolite 1600™ for the ES-3100 shipping container Body Weldment and Top Plug Assemblies. The product produced by following this manufacturing process is protected under U.S. Patent 6,299,950. The United States Government has rights in this invention pursuant to Contract No. DE-AC05-84OR21400, between the U.S. Department of Energy and BWXT Y-12 L.L.C.

This specification describes the instructions that shall be followed for these activities. The components (Body Weldment and Top Plug Assembly) will be fabricated to the design requirements specified on the engineering drawings for the components.

Reference to the Company in this specification shall mean the package certificate holder and reference to the Seller shall mean the supplier of the fabricated Body Weldment and Top Plug Assemblies.

2 Applicable Documents

The following documents apply when Casting Kaolite 1600™ Into ES-3100 Shipping Containers.

ES-3100 Drawing Numbers
M2E801580A002, Body Weldment
M2E801580A008, Top Plug Weldment,

Procurement Specification for ES-3100 Confinement Boundary Assembly
JS-YMN3-801580-A002 Equipment Specification for the ES-3100 Drum Assembly

3 Kaolite 1600™ Processing Requirements

3.1 General

The Kaolite 1600™ material referenced with in this specification shall be provided by Thermal Ceramics, Incorporated or an authorized distributor. The material certification documentation (Certificate of Conformance) for the Kaolite 1600™ must be provided by the supplier for each manufacturer's lot of material to a product code of GI80ACCUMD0027.

3.1.1 Kaolite 1600™ Receiving and Storage Instructions

a. Damaged packages of Kaolite 1600™ shall be rejected by the Seller upon receipt. Damaged packages are those that are wet, those that are visually determined to have been wet, and packages that have been torn.

b. Packages of Kaolite 1600™ must be stored unopened in a dry location and protected from damage. Opened unused and partial used Kaolite 1600™ packages are to be discarded at the end of the work shift. The term work shift shall be defined by the Seller and approved by the Company before commencing operations.

3.1.2 Cleaning Instructions

a. Use **NO CHLORINE BLEACH** for cleaning. Potable water shall be used and if required some mild soap (tri-sodium phosphate) may be added to the water to clean all processing equipment and manufactured components before casting. Before the start of any mixing/blending operation, the mixer shall be clean from all foreign materials or previous mixing residues from the inner surface of the mixer. The mixer shall be flushed thoroughly with potable water at the completion of the final mixing operation of the work shift to remove residues. Mixing, and casting shall be performed within a temperature range of 70 (± 25) °F.

b. Fabricated assemblies must be cleaned and protected prior to the casting operation to prevent the introduction of foreign materials into the assemblies. The assemblies shall be inspected and wiped clean prior to casting to ensure no visible contaminants are present inside the casting cavity. This inspection shall be documented in the checklist.

3.1.3 Mixing Water and Mixing Equipment Requirements

a. Potable water, that has been filtered through a 20-micron filter and has a chlorine content less than 4 mg/L (4 ppm, 0.0004 percent by mass) for chlorine shall be used for the mixing of Kaolite 1600™. If the potable water is higher then 4 ppm, then use an activated charcoal filter or some other means to reduce the amount of chlorine to at or below 4 ppm. Test the water quality for chlorine weekly during casting operations. Unfiltered potable water may be used for the cleaning of equipment used to process Kaolite 1600™.

b. All weighing operations of assemblies and materials shall be conducted on certified scales with a minimum accuracy of ½ lb.

c. This specification has been developed around the Whiteman Multiquip's WM700S-H8 plaster/mortar mixer, refereed to as WM700. This steel-drum machine mixes 7-cubic feet (193 liters) of material with an 8-horsepower Honda engine running at a slow speed. Other models of plaster/mortar mixers may be used if the speeds and mix times are qualified per section 3.5 and approved by the company.

d. A Heavy Duty Drum Vibrator/Packer(like McMaster-Carr, No. 5809K11, or Company approved equal) shall be used to clamp the Body Weldment, M2E-801580-A002 or Top Plug Weldment, M2E-801580-A008 upside down for vibration casting the Kaolite 1600™ into the welded stainless steel forms.

3.2 Mixing of Kaolite 1600™

Mixing shall be performed by operators qualified in accordance with requirements in Section 4.4.

The term batch is defined as a mixture of one bag of Kaolite 1600™ with the appropriate amount of water. The required mix ratio is 1.65 pounds of filtered water per pound of Kaolite 1600™.

The mixing activity shall be recorded on Attachment A, *Kaolite Mixing Control*. Each batch shall be given a mixture control number (MCN) and recorded upon its data Attachment. (A 10-digit control number is recommended consisting of the date and the time format using a 24-hour clock. Example: 1021041515 for October 21, 2004 at 3:15 pm.)

The Kaolite 1600™ mixing shall be performed as follows:

a. Record the weight of the bag of Kaolite 1600™ on the mixing Attachment.

b. The required mix ratio is 1.65 pounds of filtered water per pound of Kaolite 1600™. For a 50 pound bag of Kaolite 1600™, weigh and record 82.5 (± ½) lbs. of filtered water generating an acceptable wet mix density of 56.2±5.8 lb/ft^3.

c. Start the mortar mixer motor and when ready to engage the moving vanes, pour the weighed filtered water, pour all of the 50-pound bag of Kaolite 1600™ over the water. Immediately start the WM700 moving vanes for 3.0 (±0.2) minutes.

3.3 Vibration Casting and Curing of Kaolite 1600™ into Assemblies

3.3.1 Body Weldment Casting Instructions

Casting operations shall be performed by operators and witnesses qualified in accordance with requirements listed in Section 4.4.

Use Attachment B, *Body Weldment Vibration Casting Control,* to record information gathered during this operation.

Complete the casting of the mixture in less than 70 minutes. This timed procedure starts when the first batch is poured into the vibrating component. The casting and vibrating procedure must be completed within 77 minutes from initial pour for each assembly.

Casting operations shall be performed as follows:

a. Weigh the Body Weldment clean and empty. Record the weight.

b. Fill the Body Weldment with potable water that has been filtered through a 20 micron filter and has a chlorine content of ≤ 4 ppm and weigh it. Record the weight.

c. Remove the water from the assembly as much as is practical.

d. Secure the assembly on the vibration table. Set the vibration table dial indicators to approximately 800 lb-force at 450 vibrations per minute (VPM). Assure that the Body Weldment is properly secured to the table and start the vibration table. The Body Weldment must be vibrated continuously throughout the casting operation.

e. The mixture shall then be poured directly into the assembly after mixing through the fill hole provided.

f. Repeat the mixing operation in Section 3.2 and continue pouring until the mixture overflows the fill hole by ½ to ¾ inch.

g. Mist the top surface of the mixture with a bottle water sprayer if necessary to get the mixture into a solution after the pouring is completed. Do not add more than 8 ounces of water.

h. Vibrate the filled assembly for 5 to 7 minutes after the casting is completed.

3.3.2 Body Weldment Curing Instructions

A designated area shall be set aside for curing the assemblies. The temperature of the curing area shall be controlled to 70°F (±25°F) and shall prevent the introduction of foreign materials into the mixture.

Curing operations shall be performed as follows:

a. Remove the Body Weldment from the vibration table and place it in the curing area. Let it rest uncovered for 2½ (±½) hours.

b. Weigh and record the Before Baking weight of the cast assembly. If the weight is outside of 330 to 386 lbs range it is recommended not to cure the casting but to clean out and recast the Kaolite. This Before Baking weight is a recommended process control for the finished baked density. The manufacture may continue with a part outside of this weight range but it has a high chance being rejected for not meeting the finished baked density.

c. After resting, scrape the excess mixture from the fill opening until the Kaolite surface has a circular concave of .32±.10 to match drawing M2E801580A002.

d. Weigh the cast assembly, and photograph the fill opening. Record the weight.

e. Cover the fill opening with plastic sheeting and let the assembly set undisturbed in the curing area for at least 24 hours.

3.3.3 Top Plug Assembly Casting Instructions

Use Attachment C, Top Plug Assembly Vibration Casting Control, to record information gathered during this operation.

Complete the casting of the mixture in less than 70 minutes. This timed procedure starts when the first batch is poured into the vibrating component. The casting and vibrating procedure must be completed within 77 minutes from initial pour for each assembly.

Casting operations shall be performed as follows:

a. Weigh the top plug assembly clean and empty. Record the weight.

b. Fill the top plug assembly with potable water that has been filtered through a 20-micron filter and has a chlorine content of ≤ 4 ppm and weigh it. Record the weight.

c. Remove the water from the assembly as much as practical.

d. Place the assembly on the vibration table. Assure that the assembly is properly secured to the table. Set the vibration table dial indicator to approximately 120 lb-force at 450 vibrations per minute and start the vibration table. The top plug assembly must be vibrated continuously throughout the casting operation.

e. The mixture shall then be poured directly into the assembly after mixing through the fill hole provided.

f. Repeat the mixing operation in Section 3.2 and continue pouring until the mixture overflows the fill hole by ½ to ¾ inch.

g. Mist the top surface of the mixture with a bottle water sprayer if necessary to get the mixture into a solution after the pouring is completed. Do not add more than 4 ounces of water.

h. Vibrate the filled assembly for 5 to 10 minutes after the casting is completed.

3.3.4 Top Plug Assembly Curing Instructions

Curing operations shall be performed as follows:

a. Remove the top plug assembly from the vibration table and place it in the curing area. Let it rest uncovered for 2½ (± ½) hours.

b. Weigh and record the Before Baking weight of the cast assembly. If the weight is outside of 29.2 to 34.2 lbs range it is recommended not to cure the casting but to clean out and recast the Kaolite. This Before Baking weight is a recommended process control for the finished baked density. The manufacture may continue with a part outside of this weight range but it has a high chance being rejected for not meeting the finished baked density.

c. After resting, scrape the excess Kaolite mixture from the fill opening until surfaces are a circular convex shape of .09±.06 before it is baked to match drawing M2E801580A008.

d. Weigh the cast assembly, and photograph the fill opening. Record the weight.

e. Cover the fill opening with plastic sheeting and let the assembly set undisturbed in the curing area for at least 24 hours.

3.4 Baking of Assemblies Cast and Cured with Kaolite 1600™ mixture

3.4.1 Baking Instructions

Several assemblies may be baked together during each furnace heating cycle. Once the furnace heating cycle has started, no additional assemblies may be inserted into the furnace. The furnace and temperature control requirements to perform the baking operation are as follows:

a. The furnace shall be a gas-fired or a forced convection fresh air circulating electric furnace.

b. The furnace heat zone shall be certified to +25°F from the furnace set point temperature at each baking temperature process point.

c. Furnace time and temperature strip charts for each furnace heating cycle shall be provided with each completed Attachment D. Alternatively, an ASCII furnace time and temperature data file may be provided for each completed Attachment D.

3.4.2 Baking Documentation

Use Attachment D, *Furnace and Baking Control*, to record information gathered during this operation. An Attachment D identified by the Baking Control Number (BCN) shall be generated for each set of assemblies subjected to the furnace baking operations. Record the BCN from Attachment D for each assembly baked during this furnace heating cycle utilizing the proper assembly Casting Attachments B, C, and F. Qualified operators as indicated in Section 4.4 shall perform the baking of the cured assemblies. Movement of the cured assemblies before baking shall be minimized. The time and actual furnace exhaust air temperature shall be recorded at least every 15 minutes for baking control during a furnace heating cycle.

The baking furnace heating cycle shall be completed as follows:

a. Place the assemblies into the furnace.

b. Set the initial set point temperature to 200 (±10) °F.

c. Hold the temperature for 4 hours at a 200 (±10) °F steady state.

d. Increase the furnace set point temperature to 275 (±10) °F.

e. Hold the temperature for 1 hour at a 275 (±10) °F steady state.

f. Increase the furnace set point temperature to 350 (±10) °F.

g. Hold the temperature for 1 hour at a 350 (±10) °F steady state.

h. Increase the furnace set point temperature to 425 (±10) °F.

i. Hold the temperature for 1 hour at a 425 (±10) °F steady state.

j. Increase the furnace set point temperature to 500 (±10) °F.

k. Hold the temperature for 41 (±5) hours at a 500 (±10) °F steady state.

l. Remove assemblies and allow cooling in still air until they reach ambient temperature.

m. Weigh the assemblies after the baking process and record the weights upon the appropriate Attachment (Attachment B or C). Calculate the baked density of the cured mixture using the equation at the bottom of Attachment B or C and record.

EXEMPT FROM 10-155

Acceptance criteria:

An acceptable baking process is defined as the process in which the density of the baked mixture in an assembly is within the acceptance range of 22.4 ±3 lb/ft^3 as defined on Attachments B or C. If the density is less than the allowable value, contact the Company for disposition. If the density is greater than the allowable level, then re-bake the assembly using Section 3.4.5.a through k, with the exception of the final hold time which shall be 5 (±0.5) hours. Remove assemblies and allow cooling in still air until they reach ambient temperature. Recalculate and record the density on the appropriate Attachment. If the density still is greater than the allowable level, contact the Company for disposition.

n. Photograph the surface of the baked mixture (digital images are preferred).

o. Following the acceptable baking process, weld the cover plate onto the assemblies in accordance with the appropriate engineering drawing within 24 hours.

p. Weigh the final assembly and record on the appropriate Attachment (Attachment B or C).

3.5 Mixer Qualification for Kaolite 1600™ Casting Placement

The mixer qualification process shall verify that the mixer speed and mix time are properly set to mix the Kaolite 1600™. The end result of the mixer qualification is the as-baked density of 22.4±1 lb/ft^3 in the Baked Mixer Qualification Samples. This baked density can be estimated by monitoring the wet density. The baked density is approximately 41% of the wet density; therefore, the Target Wet Density is 56.2 lb/ft^3 for an average baked density of 22.4±1 lb/ft^3. The longer the Kaolite 1600™ is mixed the denser it becomes. The mixer qualification process shall verify the mix time required at a fixed and repeatable speed. The operators shall use the mixer to determine a repeatable speed to operate the mixer for all of the tests. Record the speed setting and assure that the speed setting is repeatable. The mixer qualification tests are a two step process: first is a Wet Density Mixer Time Vibration Casting test used to determine the range of mix time versus wet density; second is the mixer Baked Density Qualification Sample Vibration Casting. It is recommended that a 4-gallon or larger metal pail be used for the testing like the 4-1/2 gallon Tin-Plated Steel Pail (McMaster-Carr 4243T16 or equivalent), 9" Top Dia, 19-3/8" Height.

3.5.1 Wet Density Mixing Test

Use Attachment E, *Wet Density Mixer Time Vibration Casting*, to record information gathered during this operation.

Prepare the Kaolite 1600™ and water for mixing per section 3.2 except for the mix time. A digital stop watch shall be used to monitor the running mix time. The mix time shall vary per Form F from 1 to 15 minutes in 1 minute intervals. Use a quick release attachment to affix the two metal pails (at least 4 gallon) to the vibration table. Start the mixer and run it for one minute, start the vibration table and pour the Kaolite 1600™ into the two pails after filling let them vibrate for 2 minutes, stop the vibration table, scrape them flush, and remove the pails and weigh them. Record the weight, dump the Kaolite 1600™ back into the mixer and start the mixer for another minute and repeat the process.

Plot the wet mix density of the two pails versus the mix time in an Excel file. An Excel file generated by the Company can be provided for this task upon request. Curve fit the data

using a third order polynomial curve and show the equation. Plot the target density of 56.2 lb/ft^3 on a chart in Excel along with the wet mix density. Where the curves intersect the target density line is the mixer's target mix time. Consult the Company for verification of this data. Use the Company verified mix time for the Mixer Baked Density Qualification Castings in Section 3.5.2.

3.5.2 Mixer Baked Density Qualification Castings

Use Attachment F, *Baked Qualification Density Sample Vibration Casting*, to record information gathered during this operation.

Prepare the Kaolite 1600™ and water for mixing per section 3.2.1 except for the mix time. A digital stop watch shall be used to obtain the Company verified mix time. Start mixer and run it for the Company verified mix time. Start the vibration table and pour the Kaolite 1600™ into the two pails. After filling, let them vibrate for 5 to 7 minutes then stop the vibration table.

Remove the two pails from the vibration table. Place the filled two pails in the curing area, and let them sit uncovered for 2½ (±½) hours. After sitting 2½ (±½) hours, scrape the excess mixture from the fill opening until surfaces are flush. Cover the fill opening with plastic sheeting or a metal lid and let the assembly sit undisturbed in the curing area for at least 24 hours before weighing. Remove the two pails and weigh the cured qualification samples to an accuracy ±1 pounds. Record the as-cured and after-baking weights and follow the baking instructions in section 3.4.

4. Quality Assurance Requirements

4.1 General

4.1.1 The Seller shall have a quality assurance program that meets the applicable requirements of Title 10 CFR Part 71, Subpart H for packaging and transportation of radioactive material. The quality assurance plan shall be in accordance with the requirements identified in the ES-3100 procurement specification. The Seller shall submit an approved quality assurance program plan that describes the quality assurance policies and practices to be implemented in identifying, controlling and verifying quality of the Kaolite 1600™ processes (weighing, mixing, pouring, vibrating, curing, and baking).

4.1.2 The Seller shall submit a Manufacturing Plan as defined in procurement specification, and shall describe how the Seller will comply with the instructions in this specification. If subcontractors are utilized for any of the processing of the Kaolite 1600™, the Seller shall ensure that the requirements of this specification (including quality assurance requirements) are met by all suppliers and subcontractors. The subcontractor's procedures, approved by the Seller, shall be included in the procedures submitted to the Company for review and approval.

4.1.3 The Seller's quality assurance program plan shall include the requirements for the process controls for the operations, operator and witness' qualifications, and verification records. Operator qualification requirements are identified in Section 4.4.

4.1.4 The Seller shall generate the documentation necessary to show compliance with the approved quality assurance program plan. All records shall be identified based on the assembly serial numbers. The Seller shall maintain quality-related documentation in accordance with requirements in the procurement specification. The Company reserves the right to request any

such documentation and to witness all aspects of the fabrication process in accordance with this specification. The Seller shall ensure that the specified manufacturing and inspection records are generated and supplied to the Company as part of the certification package.

4.1.5 The Seller must ensure all operators are aware of and comply with the quality assurance requirements identified in this specification. The Seller must ensure all operators use and follow written procedures for the respective processes. The Seller shall ensure operators and witnesses are aware of the operational requirements for the common industrial equipment (material handling equipment, mixers, vibration tables, ovens/furnace) used for the processes.

4.2 Material and Equipment Certification

4.2.1 Material certification for the Kaolite 1600™ must be provided by the supplier as defined in Section 8.0 of the procurement specification. Bags of Kaolite 1600™ must be identified with the product name and unique lot number. The material certification will be incorporated into the quality assurance records of the certification package.

4.2.3 All weighting, mixing, casting, curing, and baking processes shall be controlled and performed by qualified personnel (see Section 4.4). Written procedures shall be utilized by the operator at each operation and shall identify process hold points where required by the Company.

4.2.4 All process equipment used for mixing, casting, and baking of the Kaolite 1600™ and water mixture must be the model type identified in this specification, and must be in good working condition. Equipment used for measurements must be certified to traceable NIST standards or similar agency. Variation from specified equipment (vibration table, mixer, and furnace) is not allowed without the written approval of the Company before implementation.

4.3 Nonconformance Control

4.3.1 The Seller shall have an approved procedure for the control of nonconformances, waivers, and deviation requests during the execution of this manufacturing specification.

4.3.2 Nonconforming components shall not be used unless it has been determined by analysis or assessment by the Company that the nonconformance does not impact the physical properties of the material.

4.2.3 The disposition of nonconforming components shall be documented. Any nonconforming component shall be clearly identified and all nonconformance reports shall be traceable to the actual component affected. Copies of all approved nonconformance reports, except for scrapped components shall be supplied by the Seller to the Company as part of the certification package.

4.4 Operator and Witness Qualifications

The Kaolite™ 1600 mixing and vibration casting qualification evaluations shall be sequential. Each operator must mix and cast at least one simulated drum. Mixing and casting operations shall be repeated as necessary to achieve fully cast mock drums. The simulated ES-3100 drums cast during qualification activities shall be baked according to procedure.

4.4.1 Kaolite 1600™ Mixing Process Qualifications

Each operator and witness performing Kaolite 1600™ mixing activities must be qualified to perform this activity. This qualification shall be documented. This qualification shall consist of the following:

a. Location and time.

b. Properly identifying a bag of Kaolite 1600™ the bag of material and associated certification data (such as lot numbers)

c. Inspection of the bag for observable damage (such as water damage)

d. Successfully weighing the bag of Kaolite 1600™ on an industrial scale

e. Successfully calculating the required amount of water to be mixed with the Kaolite 1600™ (1.65 pounds of water per pound of Kaolite 1600™)

f. Properly inspecting the mixing equipment for foreign materials (such as oil, grease, free liquids, trash, or evidence of non-Kaolite 1600™ material affixed to the inner surfaces.)

g. Successfully operating the mixing equipment while mixing a complete bag of Kaolite 1600™.

h. Successfully preparing a uniformly mixed batch of Kaolite 1600™. (Uniformly shall be defined as a thoroughly mixed material with no dry material and no free liquids remaining in the mixer.)

4.4.2 Kaolite 1600™ Vibration Casting Process Qualifications

Each operator and witness performing Kaolite 1600™ casting activities must be qualified by successfully performing a casting activity. This qualification shall consist of the following.

a. Properly inspecting the inner surfaces of an empty simulated ES-3100 drum body for residues (oil, grease, free liquids) and waste material. (A simulated ES-3100 drum body shall consist of a 55-gallon carbon steel open-head drum which has a 16-gallon carbon steel drum secured to the bottom center. The 16-gallon drum may be secured by tack welding or suitable fasteners. The lid of the 55-gallon drum must have an opening 15" in diameter through which the Kaolite 1600™ can be poured into the drum.)

b. Properly securing an empty simulated ES-3100 drum body to the vibration table.

c. Properly adjusting the vibration table controls to the specified values for drum assemblies.

d. Successfully transferring the Kaolite 1600™ from the mixer into the drum while the drum is vibrating.

4.4.3 Kaolite 1600™ Baking Process Qualifications

Each operator and witness performing Kaolite 1600™ baking operations shall review the procedure steps for calculating the as-baked density of the Kaolite 1600™ in the assemblies and perform a sample calculation.

Attachment A **EQUIPMENT SPECIFICATION** **ES-3100 Shipping Package** **Kaolite Mixing Control**	Specification Number JS-YMN3-801580-A003-1		Revision C
	Issue Date 11/24/03	Revision Date 6/1/06	
	Plant Y-12	Page 1	of 1

Caster's Company Name			Supplier's Company Name		
Mixing Start Date	Time	Air Temp. °F	Thermal Ceramics Kaolite 1600™ Certificate of Conformance		
Kaolite 1600™ Mixing and Vibration Casting Information			Comments	Operator	Witness
50 lb. Bag ID Number					
Bag Wt.					
1.65 × Bag Wt.					
Mixing Control Number (MCN) [a]					
Water Wt. ±0.5 lbs. (1.65 times Kaolite Bag Wt.)					
Mix Finish Time					

[a] A 10-digit control number is recommended for the Mixing Control Number (MCN) consisting of the date and the time format using a 24-hour clock (i.e. 1021041515 is used for October 21, 2004 at 3:15 pm.)

EXEMPT FROM ICPSR

Attachment B	Specification Number JS-YMN3-801580-A003-2		Revision C
EQUIPMENT SPECIFICATION **ES-3100 Shipping Package** **Body Weldment**	Issue Date 11/24/03	Revision Date 6/1/06	
	Plant Y-12	Page 1	of 1

Caster's Company Name			Seller's Company Name			
Part Serial Number			Body Weldment Drawing Number M2E801580A002			
Measured Weights ±0.5 lb	Casting Information		Comments		Operator	Witness
	Weight	Date				
Clean and Empty						
Filled with Water [a]						
Before Baking [f]						
After Baking Cycle 5						
After Baking Cycle 5A [d]						
After Welding						
Water Information	Water Weight ±0.5 lb	Water Temp.	Comments		Operator	Witness
Water Conditions [a]	lb	°F				
Casting Start Date	Air Temp. °F	Vibration Settings [b] lbf / VPM				
Operation	MCN [c]	Time	Comments		Operator	Witness
Pour Start						
Pour Start						
Pour Start						
Vibration Start						
Vibration Stop						
Baking Cycle 5	Baking Control Num. [c]	Date	Time	Density [d]	Operator	Witness
Baking Cycle 5A [d]	Baking Control Num. [c]	Date	Time	Density [d]	Operator	Witness

[a] Record the water weight and water temperature within 10 minutes from completion of the weighing process.

[b] Recommended Vibration settings are at 450 VPM and twice the total vibrated weight. The total vibrated weight is the finish cast part and fixtures weight, for a setting of approximately 800 pound-force.

[c] A 10-digit Baking Control Number shall be used to define the date and the time of baking using the format with a 24-hour clock (i.e. 1021041515 is used for October 21, 2004 at 3:15 pm.)

[d] Use the above weights to calculate the Density as shown below. If the density is greater, then 25.4 lb/ft^3 then proceed with the next Baking Cycle. If the density is less then 19.4 lb/ft^3 then contact the Company for disposition.

$$\text{Density} = \frac{(AfterBaking - CleanAndEmpty)}{(WithWater - CleanAndEmpty)} \times 62.3 \text{ lb/ft}^3 \quad @\ 70°\text{F}$$

[f] Recommend Before Baking weight is to be 330 to 386 lb range.

EXEMPT FROM ID-155

Attachment C **EQUIPMENT SPECIFICATION** **ES-3100 Shipping Package** **Top Plug Assembly Vibration Casting Control**	Specification Number JS-YMN3-801580-A003-3		Revision C
	Issue Date 11/24/03	Revision Date 6/1/06	
	Plant Y-12	Page 1	of 1

Caster's Company Name			Seller's Company Name			
Part Serial Number			Top Plug Assembly Drawing Number M2E801580A008			
Measured Weights ±0.5 lb	Casting Information		Comments		Operator	Witness
	Weight	Date				
Clean and Empty						
Filled with Water [a]						
Before Baking [f]						
After Baking Cycle 5						
After Baking Cycle 5A [d]						
After Welding						
Water Information	Water Weight ±0.5 lb	Water Temp.	Comments		Operator	Witness
Water Conditions [a]	lb	°F				
Casting Start Date	Air Temp. °F	Vibration Settings [b] lbf / VPM				
Operation	MCN	Time	Comments		Operator	Witness
Pour Start						
Pour Start						
Vibration Start						
Vibration Stop						
Baking Cycle 5	Baking Control Num. [c]	Date	Time	Density [d]	Operator	Witness
Baking Cycle 5A [d]	Baking Control Num. [c]	Date	Time	Density [d]	Operator	Witness

[a] Record the water weight and water temperature within 10 minutes from completion of the weighing process.

[b] Recommended Vibration settings are at 450 VPM and twice the total vibrated weight. The total vibrated weight is the finish cast part and fixtures weight, for a setting of approximately 120 pound-force.

[c] A 10-digit Baking Control Number shall be used to define the date and the time of baking using the format with a 24-hour clock (i.e. 1021041515 is used for October 21, 2004 at 3:15 pm.)

[d] Use the above weights to calculate the Density as shown below. If the density is greater than 25.4 lb/ft^3 then proceed with Baking Cycle 1A. If the density is, less then 19.4 lb/ft^3 then contact the Company for disposition.

$$\text{Density} = \frac{(AfterBaking - CleanAndEmpty)}{(WithWater - CleanAndEmpty)} \times 62.3 \text{ lb/ft}^3 \text{ @ } 70°\text{F}$$

[f] Recommend Before Baking weight is to be 29.2 to 34.2 lb range.

EXEMPT FROM IO-155

Attachment D **EQUIPMENT SPECIFICATION** **ES-3100 Shipping Package** **Furnace and Baking Control**	Specification Number JS-YMN3-801580-A003-4		Revision C
	Issue Date 11/24/03	Revision Date 6/1/06	
	Plant Y-12	Page 1	of 1

Baking Company Name				Seller's Company Name			
Baking Control Number [a]				Furnace Serial Number			
Bake Start Date		Air Temp. °F		Computer Data File Name [b]			
Baking Process Control	Furnace Check or NA	Start Time	Start Date	Stop Time	Stop Date	Operator	Witness
Baking Cycle (1) 200°F for 4 hrs.							
Baking Cycle (2) 275°F for 1 hrs.							
Baking Cycle (3) 350°F for 1 hrs.							
Baking Cycle (4) 425°F for 1 hrs.							
Baking Cycle (5) 500°F for 36 to 46 hrs. [c]							
Baking Cycle (1A) 200°F for 4 hrs.							
Baking Cycle (2A) 275°F for 1 hrs.							
Baking Cycle (3A) 350°F for 1 hrs.							
Baking Cycle (4A) 425°F for 1 hrs.							
Baking Cycle (5A) 500°F for 4.5 to 5.5 hrs. [c]							

[a] Record the Baking Control Number in MMDDYYTIME (with time the 24 hour format i.e. 1021041515 is used for October 21, 2004 at 3:15 pm.) on Casting Forms B, C, and F for each part baked under this furnace heating cycle.

[b] The sample baking cycle time and temperature data could be presented both in a digital and graphical form. For example, an Excel file showing the original data and time verses temperature plots shall be acceptable.

[c] Calculate the density as shown on Forms B or C following this furnace heating cycle phase. If the part density is greater than 25.4 lb/ft^3, then proceed with the remaining furnace phases.

EXEMPT FROM ID-155

Attachment E	Specification Number JS-YMN3-801580-A003-5		Revision C
EQUIPMENT SPECIFICATION **ES-3100 Shipping Package** **Wet Density Mixer Time Vibration Casting**	Issue Date 11/24/03	Revision Date 6/1/06	
	Plant Y-12	Page 1	of 1

Caster's Company Name			Seller's Company Name		
Mixer Make and Model					
Wet Mix Density Qualification Number [a]			Mix Control Number [a]		
Measured Weights ±0.5 lb	Casting Information		Comments	Operator	Witness
	Weight [c, b] (lb)	Date			
Clean and Empty					
Filled with Water [b]					
Water Information	Water Weight [c, b] ±0.5 lb	Water Temp.	Comments	Operator	Witness
Water Conditions		°F			
Casting Start Date	Air Temp. °F	Vibration Settings [c] lbf / VPM	Mixer Speed Setting		
Operation	Weight [c, b] (lb)	Time (min)	Wet Density [d] (lb/ft³)	Operator	Witness
Wet Cast [c]		1.0			
Wet Cast [c]		2.0			
Wet Cast [c]		3.0			
Wet Cast [c]		4.0			
Wet Cast [c]		5.0			
Wet Cast [c]		6.0			
Wet Cast [c]		7.0			
Wet Cast [c]		8.0			
Wet Cast [c]		9.0			
Wet Cast [c]		10.0			
Wet Cast [c]		11.0			
Wet Cast [c]		12.0			
Wet Cast [c]		13.0			
Wet Cast [c]		14.0			
Wet Cast [c]		15.0			
Curve fit the Time required to generate the target density and contact the Company for confirmation.			Target Density 56.2 lb/ft³		

[a] Record the Wet Mix Density Qualification Number **and the** Mix Control Number in MMDDYYTIME (with time the 24 hour format i.e. 1021041515 is used for October 21, 2004 at 3:15 pm.).

[b] Record water weight and water temperature within 10 minutes from completion of the weighing process.

[c] Use both steel pails to calculate the weights and density.

[d] Recommended Vibration settings are at 450 VPM and twice the total vibrated weight. The total vibrated weight is the finish cast part and fixtures weight, for a setting of approximately 120 pound-force.

[e] Use the above weights to calculate the Wet Density as shown below.

$$\text{Wet Density} = \frac{(WetCast - CleanAndEmpty)}{(WithWater - CleanAndEmpty)} \times 62.3 \text{ lb/ft}^3 \text{ @ } 70°\text{F}$$

EXEMPT FROM IO-155

Attachment F **EQUIPMENT SPECIFICATION** **ES-3100 Shipping Package** **Baked Qualification Density Sample Vibration Casting**	Specification Number JS-YMN3-801580-A003-6		Revision C
	Issue Date 11/24/03	Revision Date 6/1/06	
	Plant Y-12	Page 1	of 1

Caster's Company Name				Seller's Company Name			
Mixer Make and Model							
Baked Qualification Density Number [a]				Mix Control Number [a]			
Measured Weights ±0.5 lb	Casting Information			Comments		Operator	Witness
	Weight ±0.5 lb		Date				
Clean and Empty							
Filled with Water [c]							
Before Baking							
After Baking Cycle 5							
Water Information	Water Weight ±0.5 lb		Water Temp.	Comments		Operator	Witness
Water Conditions [c]			°F				
Casting Start Date	Air Temp. °F	Vibration Settings [b] lbf	VPM				
Operation	MCN		Time	Comments		Operator	Witness
Pour Start							
Vibration Start							
Vibration Stop							
Baking Cycle 5	Baking Control Num.		Date	Time	Density [d]	Operator	Witness

[a] Record the Baked Qualification Density Number **and the** Mix Control Number in MMDDYYTIME (with time the 24 hour format i.e. 1021041515 is used for October 21, 2004 at 3:15 pm.).

[b] Recommended Vibration settings are at 450 VPM and twice the total vibrated weight. The total vibrated weight is the finish cast part and fixtures weight, for a setting of approximately 120 pound-force.

[c] Record water weight and water temperature within 10 minutes from completion of the weighing process

[d] Use the above weights to calculate the Qualification Sample Density as shown below. If the density is greater then 23.4 lb/ft^3 or less then 21.4 lb/ft^3 contact the Company for disposition.

$$\text{Qualification Density} = \frac{(AfterBaking - CleanAndEmpty)}{(WithWater - CleanAndEmpty)} \times 62.3 \text{ lb/ft}^3 \quad @\ 70°\text{F}$$

EXEMPT FROM IO-155

Appendix 1.3.5
Equipment Specification SPC JS-YMN3-801580-A005,
Casting Catalog No. 277-4 Neutron Absorber for the ES-3100 Shipping Package

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APPROVAL / REVISION PAGE

** For Company Use Only - Do Not Provide To Supplier **

QUALITY LEVEL	PROTECTION LEVEL	BUILDING
Q	C	N/A

PROJECT TITLE	JOB TITLE
ES-3100 Shipping Package	Production Design Definition

ITEM DESCRIPTION	UNID
Casting Catalog No. 277-4 Neutron Absorber For The ES-3100 Shipping Package	YAREA-CMH-042

REVISIONS

REV. NO.	DESCRIPTION OF REVISION
F	On Record
G	Shieldwerx, supplier of 277-0 was Thermo Electron Corporation. Added Figures 9, 10, & 11 to represent design and procurement changes made to the ES-3100 Heavy Spacer Can Assembly, see drawing M2E801580A043 Rev. O for supplementary details. Added additional reference to M2E801580A043.
H	Updated format and removed B&W reference. Removed Heavy Can Spacer sections and figures for placement in new spec SPC M801580-0004 000 00. Removed the PGNAA Verification for placement in new statement of work SOW 801580-0007 000 00.

REFERENCE DOCUMENTS & OTHER INFORMATION

Recommended Suppliers:
TBD

In-Storage Maintenance Requirements – N/A

References for Company Use:

Reference Receipt Inspection: N/A

Design Verification Record: DV-801580-0018

Other reference documents needed by the Seller: None

This specification is used by the Supplier as part of a contract to fabricate ES-3100 shipping packages. Receipt Inspection Checklist on the ES-3100 Drum Assembly specification will be used for receipt into the Y-12 National Security Complex.

This document has been reviewed by a Y-12 DC/ UCNI RO and has been determined to be UNCLASSIFIED and contains no UCNI. This review does not constitute clearance for Public Release.
Name: Date:
Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2019.08.28 14:48:49 -04'00'

APPROVALS

PRINT	SIGNATURE/DATE	PRINT	SIGNATURE/DATE
PREPARED BY L. C. Hooper	Lloyd Hooper Digitally signed by Lloyd Hooper Date: 2019.08.28 11:52:33 -04'00'	DISCIPLINE MANAGER J. C. Anderson	James C (J5A) Anderson Digitally signed by James C (J5A) Anderson Date: 2019.08.29 16:39:39 -04'00'
DESIGN VERIFICATION R. D. Aigner	Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2019.08.29 16:11:01 -04'00'	SYSTEM ENGINEER R. D. Aigner	Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2019.08.28 14:49:01 -04'00'
PACKAGING ENGINEER N. A. Laney	Noelani A (NL1) Laney 2019.08.29 11:52:31 -04'00'	OPERATIONS/SYSTEMS OWNER S. K. Thomas	Stan (TSW) Thomas Digitally signed by Stan (TSW) Thomas Date: 2019.08.29 16:04:59 -04'00'
NUCLEAR PROC. ENGINEER J. E. Cook	Jeffrey E (2XK) Cook Digitally signed by Jeffrey E (2XK) Cook Date: 2019.08.29 13:12:56 -04'00'	QUALITY ENGINEER J. R. Burchfield	Jason (JR6) Burchfield Digitally signed by Jason (JR6) Burchfield Date: 2019.08.28 12:49:01 -04'00'

CONTENTS

1.0 Scope 2

2.0 Applicable Documents 7

3.0 Requirements 8

4.0 Quality Assurance 14

5.0 Preparation For Delivery 15

6.0 Manufacturer's Data 16

ATTACHMENTS

FORM A 277-4 Dry Blend Batch Control 18
FORM B 277-4 Wet Mix Control (Overcast or Special Batch) 19
FORM C ES-3100 Body Weldment Casting Control 20
FORM D ES-3100 Neutron Absorber Form Casting Control 21
FORM E PGNAA Acceptance Standard Lot Casting Control 22
FORM F ES-3100 Companion Sample Casting Control and Tests 23

Attachment A: Instructions to Supplier for Preparation of Submittals 24
Attachment B: Submittal Checklist 25
Attachment C: Abbreviations and Acronyms 26

1.0 Scope

1.1 This specification describes the requirements for the procurement, preparation, casting, and verification of a neutron absorber material into the ES−3100 shipping package. The neutron absorber material shall be cast into ES−3100 Body Weldment (Figure 1), Neutron Absorber Form (Figures 4 and 5), and 10 oz. double friction style cans (Figures 6 and 7) with tooling, i.e., Neutron Absorber Casting Funnel Assembly (Figure 2), and Body Weldment and Casting Funnel Assembly (Figure 3).

The Company (Y-12 National Security Complex) will provide training and direct oversight for the casting of the 277-4 Neutron Absorber when the Subcontractor does not have prior 277-4 casting experience.

1.2 Definitions

277-0 - Shieldwerx Catalog No. SWX-277-0 or equivalent, Heat Resistant Shielding "Non-Borated" high alumina cement.

277-4 - A mixture of 277-0 and boron carbide (B_4C) powder to form a neutron absorber material.

Companion Sample Cans - The 10 oz. double friction style cans in Figures 6 and 7 used for sampling.

Company – The Company, as used in this specification, is the buyer of the Supplier's final product (i.e., Y-12 National Security Complex)

Dry Batch - A dry mix of batch size of 277-4.

Dry Blend Batch - A thoroughly mixed Dry Batch.

Overcast – Additional cast material required to achieve the fill requirements.

PGNAA Subcontractor – Independent testing firm that performs the Prompt Gamma-ray Neutron Analysis on the companion sample cans for the Company.

Process Procedures - Dry mixing, wet mixing, casting, sampling, and inspection procedures.

Subcontractor - The manufacturer of the ES-3100 Drum Assembly per SPC JS-YMN3-801580-A002.

Vibration Casting – Vibration during casting to remove the air bubbles.

Wet Mix Batch - A wet mix of Dry Blend Batch and water.

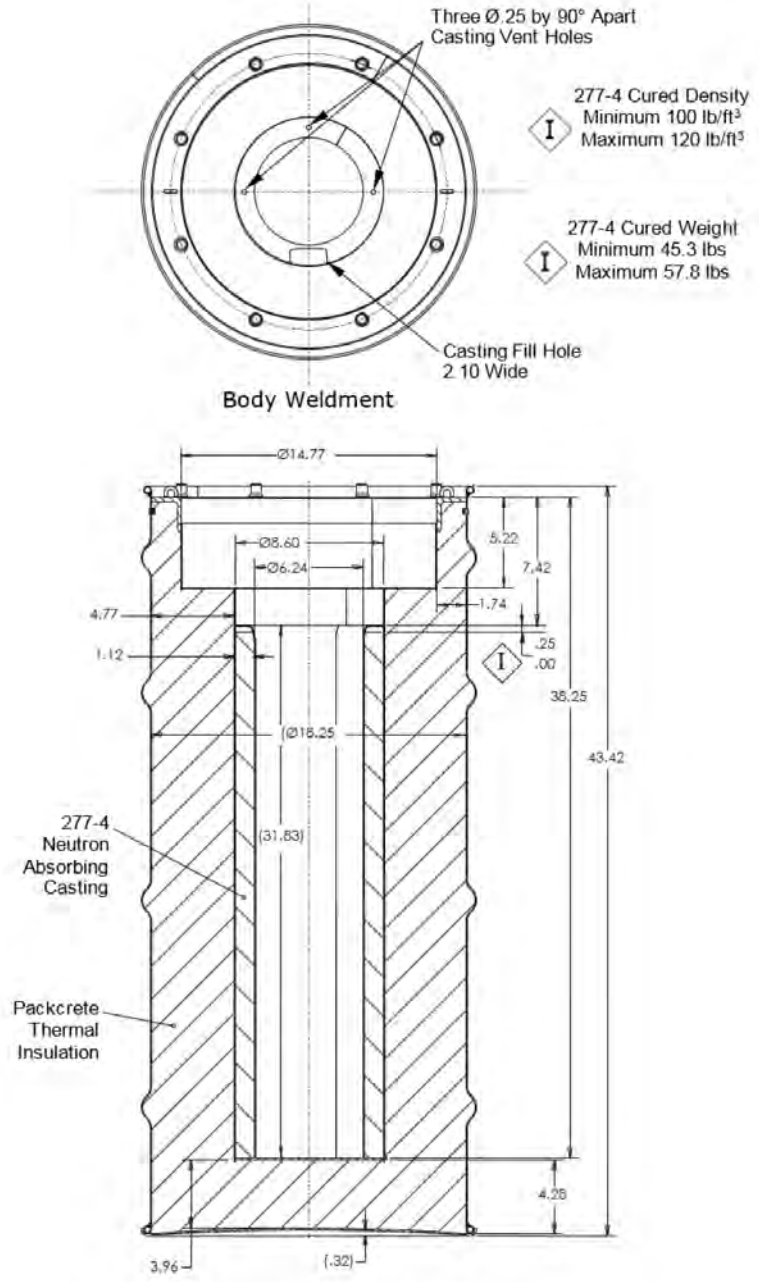
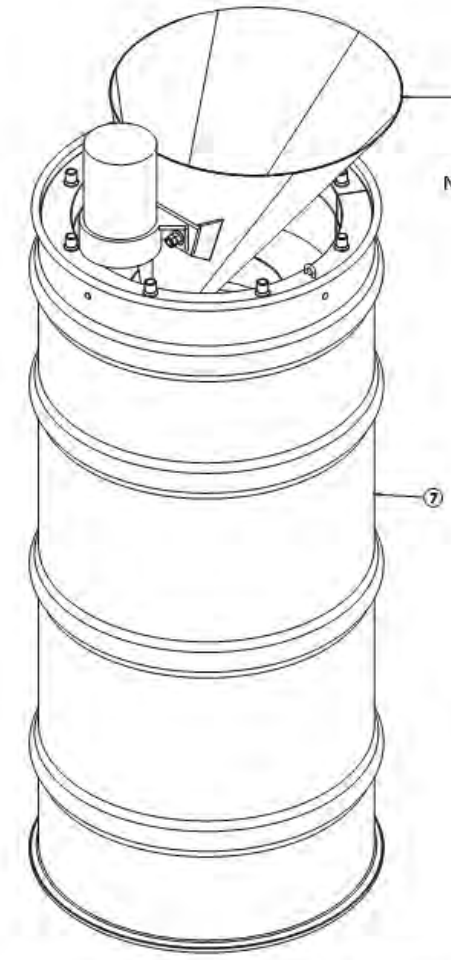


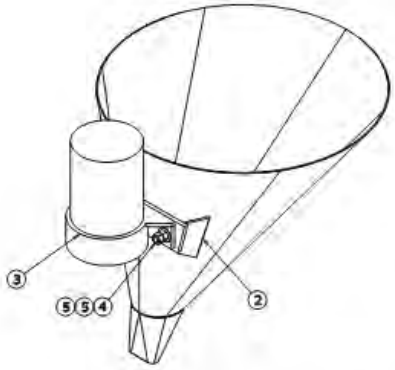
Figure 1 ES-3100 Neutron Absorbing Casting



-6 BODY WELDMENT AND CASTING FUNNEL ASSEMBLY

Figure 3

Neutron Absorber Casting Funnel Assembly



-1 NEUTRON ABSORBER CASTING FUNNEL ASSEMBLY

VIBRATOR POWERED CASTING FUNNEL

Figure 2

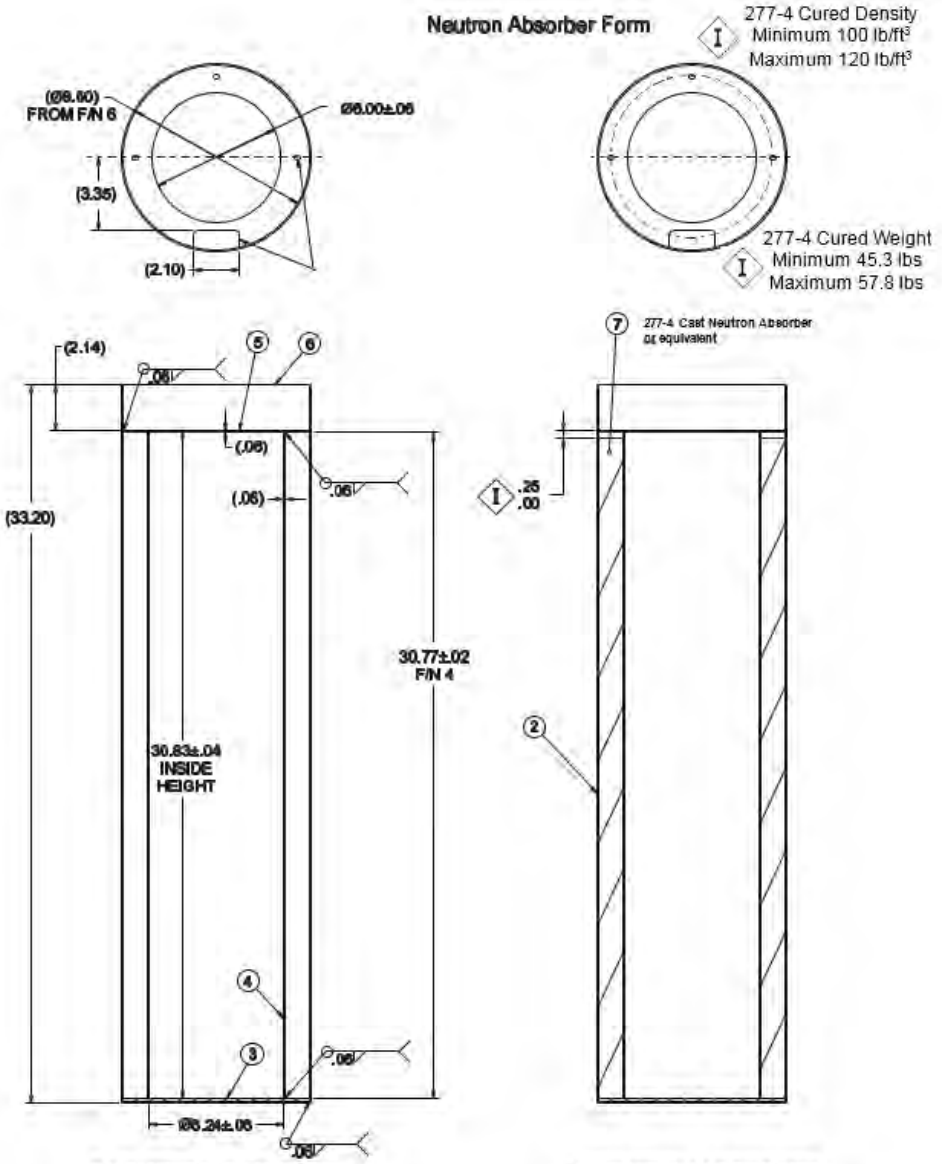


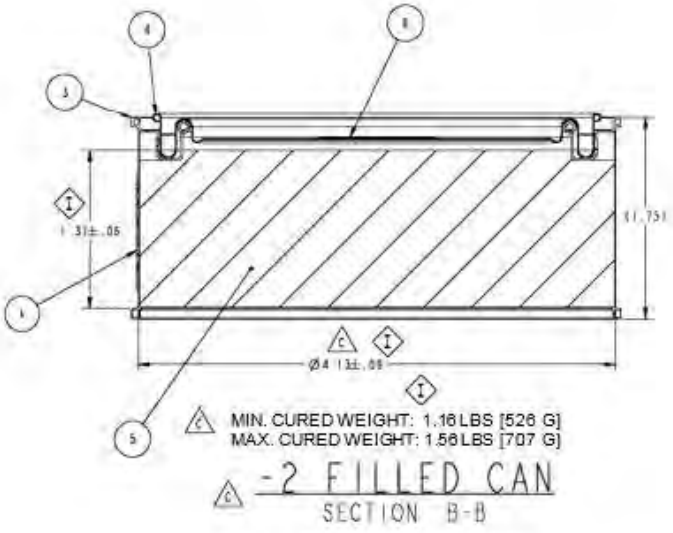
Figure 4

Figure 5



10oz DOUBLE FRICTION CAN
FILLED WITH 277-4

Figure 6



10oz DOUBLE FRICTION CAN
FILLED WITH 277-4

Figure 7

2.0 Applicable Documents

2.1 The following documents are a part of this specification. When there is a conflict between the specification and the applicable documents, the Subcontractor shall bring it to the attention of the Company for resolution.

2.2 Standards

ASTM A 380-2017	*Standard Practice for Cleaning, Descaling, and Passivation of Stainless Steel Parts, Equipment and Systems*
ASTM C 750-2018	*Specification for Nuclear-Grade Boron Carbide Powder*
ASTM C 791-2019	*Standard Test Methods for Chemical, Mass Spectrometric, and Spectrochemical Analysis of Nuclear-Grade Boron Carbide*
ASTM C371-2009 (R 2018)	*Standard Test Method for Wire-Cloth Sieve Analysis of Nonplastic Ceramic Powders*
ASTM E105-2016	*Standard Practice for Probability Sampling of Materials*
ASTM E 11-2017	*Standard Specification for Woven Wire Test Sieve Cloth and Test Sieves*
10 CFR 71 Subpart H	*Code of Federal Regulations - Energy - Packaging and Transportation of Radioactive Material - Quality Assurance*

2.3 Company Documents

SPC JS-YMN3-801580-A002	*ES-3100 Drum Assembly*
SPC M801580-0003	*ES-3100 Packcrete Final Lot Qualification and Production Processing*
M2E801580A002	*Body Weldment*
M2E801580A032	*Neutron Absorber Casting Funnel Assembly*
M2E801580A033	*Neutron Absorber Casting Funnel Weldment*
M2E801580A034	*Neutron Absorber Form Assembly*

2.4 Referenced Documents (Not Provided with Request for Proposal)

DAC-PKG-801624-A001	*Mixing Weights And Elemental Composition of 277-4 Neutron Poison used in the ES-3100*

3.0 Requirements

3.1 General Requirements

The Subcontractor shall be responsible for supplying all materials, services, facilities, and equipment to meet the requirements of this specification unless otherwise noted. Items needed to meet the requirements of this specification that are not identified in this specification shall be specified by the Subcontractor and submitted to the Company in accordance with Attachment A.

3.2 Equipment Requirements

3.2.1 Certified Scales

All equipment and instruments (Measuring and Testing Equipment (M&TE)) used in the conduct inspections shall bear a calibration sticker that shows the equipment to be within its calibration period. Calibrations must be performed by a laboratory that meets ISO 17025. All calibration sources shall be traceable to the National Institute of Standards and Technology (NIST). All certification documentation shall be submitted to the Company in accordance with Attachment A.

3.2.2 Dry Blending the 277-0 and B_4C

A small parts tumbler shall be used to dry blend the ingredients. The small parts tumbler shall be a Multi-Barrel Small Parts Tumbler Benchtop Base (McMaster-Carr No. 44235A11) with Multi-Barrel Small Parts Tumbler 8 Gallon Barrel, 15-3/4" Dia X 14-3/4" W (McMaster-Carr No. 44235A24).

3.2.3 Mortar or Plaster Mixer

A mortar or plaster type mixer with moving vanes to shear the wet mix shall be used. The batch volume is approximately 0.5 ft^3 (15 quarts or 3.8 gallons). Therefore, it is recommended that the mixer volume should be 1.5 to 2 times the mix volume or around 0.75 to 1.0 ft^3 (22.5 to 30 quarts, ~6 to 8 gallons). The 277-4 wet mix is thixotropic when mixed and it is recommended that a heavy duty adjustable vibrator mounted to the mixer for both mixing and pouring is used.

3.2.4 Small Plaster Mixer

A drill-powered mortar or plaster mixer and a 5-gallon plastic bucket may be used on small batches of 277-4 instead of the mortar or plaster type mixer. The 5-gallon plastic bucket shall be placed upon the Heavy Duty Drum Vibrator (see Section 3.2.6).

3.2.5 Vibration Powered Funnel Assembly

The Neutron Absorber Casting Funnel Assembly with a vibration- powered funnel (Figures 2 and 3) shall fill both the Body Weldment (Figure 1) and the Neutron Absorber Form (Figure 4). The Casting Funnel Assembly may be modified as required by the Subcontractor to get the wet mix to flow.

3.2.6 Heavy Duty Drum Vibrator

A Heavy Duty Drum Vibrator/Packer shall be used to hold the Body Weldment (Figure 1) or Neutron Absorber Form (Figure 4) for vibration casting the 277-4 into the stainless steel forms.

3.2.7 Bench Vibrator

A bench vibrator shall be used during the mixing of the companion sample cans. The bench vibrator shall be Tabletop Vibration/Mixing Table 10-in. by 7-in. Platform, 10-lb Capacity Continuous Use (McMaster-Carr No. 5714K61.

3.3 277-4 Neutron Absorber

3.3.1 Raw Casting Material Requirements and Inspection

3.3.1.1 277-0

Shieldwerx Catalog No. SWX-277-0 Heat Resistant Shielding "Non-Borated" shall be procured. The manufacturer model or catalog number and expiration date shall be clearly indicated on the container. A Certificate of Conformance shall be provided with each lot or batch. The Certificate of Conformance shall include the lot or batch number and the expiration date. The 277-0 shall be sealed and stored in a dry place.

3.3.1.2 Type 1 Nuclear-Grade Boron Carbide Powder

The $^{nat}B_4C$ Manufacturer shall supply the Supplier with a CoC stating that the $^{nat}B_4C$ is Type 1 Nuclear Grade $^{nat}B_4C$ and 99.90% of the material has passed through a No. 140 sieve per ASTM E 11. The Supplier shall submit Sampling Plans per ASTM E105 for Company approval in accordance with the submittal checklist. The Company will supply test results to the Supplier from samples obtained from the $^{nat}B_4C$ Manufacturer. A test report will be submitted to the Supplier for inclusion into the final data package. The $^{nat}B_4C$ **shall not be shipped** from the $^{nat}B_4C$ Manufacturer **prior to Company approval.** A copy of the CoC shall be submitted with the final data package **in accordance with the submittal checklist.**

3.3.1.3 ^{10}B Content

B_4C powder shall be procured as Type 1 Nuclear-Grade Boron Carbide Powder per ASTM C 750. The ^{10}B content shall be verified to meet the amount as stated in ASTM C 750 by a testing subcontractor, determined by gravimetric analysis of batch samples per ASTM C791.

3.3.1.4 Water

The water shall be potable, filtered through a 20-micron filter and an activated charcoal filter, have a chlorine content of less than 4 ppm, and have a temperature of 65±15°F. Unfiltered potable water may be used for the cleaning of equipment used to cast the neutron absorber system.

3.3.2 Dry Blending Process

3.3.2.1 Dry Batch

A dry batch of 277-4 shall be a mixture of 93.6 wt% 277-0 and 6.4 wt% B_4C. It shall be of sufficient quantity to fill one ES-3100 Body Weldment or Neutron Absorber Form, i.e., approximately 0.55 ft^3 poured volume and 50 lbs. of dry 277-4 weight. The batch size may be adjusted as necessary based on experience for the ES-3100 Body Weldment or Neutron Absorber Form. The tolerance for 277-0 and B_4C weighting shall be the following:

277-4 Dry Batch Size	277-0	B_4C
Equal to or greater than 30 lbs.	±0.2 lbs.	±.01 lbs.
Less than 30 lbs	±.01 lbs.	±.01 lbs.

The data shall be recorded on Form A.

3.3.2.2 Blended Dry Batch

The dry batch of 277-4 shall be thoroughly blended. The data shall be recorded on Form A.

If the blended dry batch is not used immediately, the blended dry batch shall be sealed and stored in a dry place with a Blended Dry Batch control number attached to the container.

The Blended Dry Batch shall not be used if the 277-0 expiration date has expired.

3.3.3 Wet Mixing

The weight of the dry mix and water shall be to the following weight proportions of 100% dry mix and 27±1% water. The 277-4 is thixotropic when mixed. It is recommended to have a heavy duty adjustable vibrator mounted to the mixer for both mixing and pouring. Place the water in the mixer and add the dry mix into the water. Before casting, mix the dry powder and water for at least 3 minutes and less than 60 minutes. Any material in the mixer after 60 minutes shall be discarded. Mix only in a room with a temperature range of 70±25°F.

The data shall be recorded on the appropriate form, i.e., Form B for overcast, Form C for Body Weldment, Form D for Neutron Absorber Form, and Form E for PGNAA Acceptance Standards.

3.3.4 Body Weldment and Neutron Absorber Form Vibration Casting

3.3.4.1 Vibration Casting Requirements for Body Weldment and Neutron Absorber Form

During the vibration casting of the 277-4, record the Body Weldment (Figure 1) casting data on Form C and the Neutron Absorber Form (Figure 5) casting data on Form D. A stainless steel vibration powered funnel (i.e., Neutron Absorber Funnel Assembly shown in Figure 3) fits inside the 2.10-in. wide slotted fill hole shown in Body Weldment and in Neutron Absorber Form.

a. Weigh and record the data on Form C or on Form D.
b. Weigh and record the water weight and temperature data when filled with water to within 0.25 in. of the top metal surface.
c. Remove the water.
d. Secure the part on the drum vibrator.
e. Plug the 6.24 in. diameter cavity to keep the wet mix from falling into the liner bottom.

f. Place the Neutron Absorber Funnel Assembly in the slot and secure in place. If required, additional vibrators may be added.
g. Prepare the Wet Mix per Section 3.3.3.
h. Start the drum vibrator.
i. Scoop the wet mix into the Neutron Absorber Funnel Assembly.
j. Turn on the vibrating funnel and adjust the vibration force until the wet mix flows.
k. About half way through filling the wet mix in either the Body Weldment or Neutron Absorber Form, cast two companion samples for Section 3.3.7. Record the companion sample data on Form F and either Form C or Form D.
l. Continue filling the wet mix until the part will take no more.
m. After filling is complete, vibrate the container for 45±15 seconds to remove air bubbles.

3.3.4.2 Overcast Requirements for Body Weldment and Neutron Absorber Form

A few hours after casting, the 277-4 will settle in the vertical direction and leave a layer of watery fluid on the top of the casting. Remove this fluid and overcast the top between 4 and 24 hours from the first casting. After the overcast has cured for between 4 and 24 hours inspect the depth of casting to the top metal surface and verify that it is within 0.25 in. If not within the 0.25 in., cast additional 277-4 material and perform the following:

a. Remove the water.
b. Secure the Body Weldment or Neutron Absorber Form on the drum vibrator.
c. Plug the 6.24 in. diameter cavity to keep the wet mix from falling into the liner bottom.
d. Record the Overcast Wet Mix Control Number (WMCN) on the appropriate casting data form.
e. Prepare the Wet Mix per Section 3.3.3.
f. Start the drum vibrator.
g. Scoop the wet mix into the Body Weldment or Neutron Absorber Form Assembly until the vent hole is filled.

The final shrinkage of the 277-4 shall be within 0.25 in. of the metal surface as shown in Figures 1 and 5.

3.3.4.3 Curing Requirements Body Weldment and Neutron Absorber Form

Cover the newly cast wet component with plastic or metal for 7 days. Do not store the cast 277-4 castings in temperatures below 35°F for the first 30 days after casting.

After 7 days, remove the plastic or metal cover and dehydrated using either or both vacuum and heat to create an acceptable density and weight. If heat is used, the maximum temperature of the inner liner shall not exceed 250°F.

Record the diamond I measurements shown on Figures 1 and 5 on the appropriate casting data forms. The acceptable cured height measurement shall be less than 0.25 inches. The acceptable cured casting weight shall be between 45.3 and 57.8 lbs. Cured casting weights shall be used to calculate the cured density. If the cured casting density is greater than 120 lb/ft^3, continue the dehydration process. If the cured casting density is less than 100 lb/ft^3, the casting shall be unacceptable, the appropriate form shall be completed, and a copy of the form shall be sent to the Company.

3.3.5 PGNAA Acceptance Standards

The PGNAA Acceptance Standards shall be made with a Company representative witnessing the manufacturing processes of weighing, blending, wet mixing, and casting. The PGNAA Acceptance Standards shall be the 10-oz. double friction style metal cans as shown in Figures 6 and 7. The cured

casting weight for each can shall be measured and the cured casting density recorded on Form E. A cured casting density of 100 to 120 lb/ft^3 and a cured casting weight of 1.16 to 1.56 lbs shall be acceptable. If the cured casting density is outside the acceptable range, a copy of the form shall be sent to the Company.

One can from the middle of the lot on Form E, i.e., a maximum lot of 22 cans, shall be selected and identified as a companion sample can for Loss On Drying (LOD) testing. The remainder of the lot shall be sent to the PGNAA Subcontractor.

3.3.6 Companion Sample Cans

In addition to the companion sample cans selected in Section 3.3.5, two companion sample cans shall be made half way through the casting process for the Body Weldment and the Neutron Absorber Form per Section 3.3.4.1. Companion sample can data shall be recorded on Test Form F.

a. The cured casting density of all companion sample cans shall be calculated per Section 3.3.8.2 and recorded on Form F. If the cured casting density is outside the acceptable range, a copy of the form shall be sent to the Company. A low cured casting density of a companion sample can shall not be a reason to reject the Body Weldment, Neutron Absorber Form, or PGNAA Acceptance Standards casting lot.
b. The odd serial number companion sample cans for the Body Weldment, Neutron Absorber Form, or PGNAA Acceptance Standards casting lot shall be LOD tested to verify the hydrogen content per Section 3.3.8.3.
c. The even serial number companion sample cans for the Body Weldment and the Neutron Absorber Form casting lot shall be PGNAA tested to verify the ^{10}B content per Section 3.3.8.4.

3.3.7 Casting the 10 oz. Double Friction Style Cans

a. Weigh the empty labeled can and lid and record the casting can data on Forms C, D, or E. It is acceptable to weigh ten cans with ten lids for each purchase order of cans and to use the average can and lid weight on each form.
b. Weigh the water and measure the water temperature. Record this data on Form C, D, or E. Fill with water only up to the bottom of the inside rim. The can lid shall be on the scale. It is acceptable to weigh the water weight of the first ten cans with ten lids of the same lot of cans and to use the average water weight for each of the following cans if the measurements are consistent.
c. Remove the water from the cans.
d. Prepare the Wet Mix Batch following Section 3.3.3.
e. Hold the can on the bench vibrator during filling with the 277-4 wet mix. Quickly vibrate and continue to add wet mix to the can lip.
f. Once all of the cans are full of wet mix, return the first can back to the vibrator for at least 3 minute at a high frequency setting. During the 3 minutes of vibration, continue to add 277-4 wet mix until the can stays full. Repeat this process for all the cans in the casting lot.
g. Between 1 to 24 hours after casting, scrape the top of the casting to meet 1.37±0.06 dimension from bottom of can noted on Figure 7.
h. Clean the can rim around the edge per Section 3.4.2.
i. Perform an in-process measurement of the scraped casting height to ensure that the casting height parameters are met shown in Figure 7.
j. Cover the casting by placing the properly labeled can lid on the can for 7 days.
k. Remove the can lid and let the can air dry or use either or both vacuum and heat to create an acceptable density and weight. If heat is used, the maximum temperature of the can shall not exceed 250°F.
l. Measure casting height and weigh the can with lid. Record this data on Forms C, D, or E.

m. Record the final Companion Sample Can casting density, weight, or casting height measurements data on Form F.
n. Plug lid onto double friction style can, as applicable.

3.3.8 Verification

All verification shall be completed after the casting is cured.

3.3.8.1 Cured Casting Density Verification

The density of cured casting in the Body Weldment, Neutron Absorber Form, and PGNAA Acceptance Standards shall be determined by weighing the casting container before casting, while filled with water, after casting, and when cured.

Since the density of water is known, a simple relationship between the weight differences shall determine the cured casting density.

$$Density = \left(\frac{Cured - Empty}{WithWater - Empty} \right) \times 62.3 \text{ lb/ft}^3$$

3.3.8.2 Companion Sample Can Cured Casting Density Verification

The density of cured casting in each companion sample can shall be determined by weighing the can before casting, while filled with water, after casting, and when cured.

Since the density of water is known, a simple relationship between the weight differences shall determine the cured casting density.

$$Density = \left(\frac{Cured - Empty}{WithWater - Empty} \right) \times 62.3 \text{ lb/ft}^3$$

3.3.8.3 Companion Sample LOD Verification

The companion sample cans identified in Section 3.3.6.b shall be LOD tested. The acceptable LOD percent range shall be based upon the companion sample can cured casting density in Section 3.3.8.2. The Acceptable Maximum and Minimum LOD% at Density is in this table developed from data in DAC-PKG-801624-A001 Table 7, 277-4 Composition @ Extreme Densities and LOD% and compared to the average values as manufactured.

Acceptable Maximum and Minimum LOD% at Density		
Density (lb/ft^3)	Maximum LOD%	Minimum LOD%
100	31.80%	28.61%
101	32.47%	28.33%
102	33.12%	28.06%
103	33.77%	27.79%
104	34.40%	27.52%
105	35.03%	27.26%
106	35.64%	27.00%
107	36.25%	26.75%
108	36.84%	26.50%
109	37.42%	26.25%
110	37.99%	26.01%
111	38.56%	25.78%
112	39.11%	25.55%
113	39.65%	25.32%
114	40.18%	25.10%
115	40.70%	24.88%
116	41.21%	24.66%
117	41.71%	24.45%
118	42.20%	24.25%
119	42.68%	24.05%
120	43.15%	23.85%

a. The lid shall have the serial number permanently transferred by vibro etch or other method.
b. The lid shall have a small vent hole in it. It is recommended that a nail be used to punch a hole 0.12±0.06 in. diameter in the metal lid from the inside surface of the lid.
c. Match the can serial numbers and place the lid on the can.
d. The weight of the can shall be recorded on Form F.
e. The cans shall be placed in an oven at 1500±150°F (800°C) for 4 hours.
f. The weight of the can shall be recorded on Form F with the can temperature not below 100°F.
g. Calculate the LOD% using the equation below and record it on Form F. Due to can oxidizing and gaining weight during the heating cycle, a 0.024 lb correction factor is included in the following LOD% calculation.

$$\text{LOD\%} = \left[1 - \frac{(LODWeight - Empty - 0.024lb)}{(Cured\ \&\ Clean - Empty)}\right] \times 100\%$$

h. Verify that the LOD% is within the acceptable range. If water content is outside the acceptable range, a copy of the form shall be sent to the Company.

3.3.8.4 PGNAA Verification

The PGNAA Acceptance Standards in Section 3.3.5 and Companion Sample Cans identified testing in Section 3.3.6.c shall be sent to the PGNAA Subcontractor.

3.4 Cleaning Requirements

3.4.1 Contact with Chlorides or Fluorides

The stainless steel material shall be protected from contact with chlorides in accordance with ASTM A380, paragraph 8.5, during all operations including packaging. The Safety Data Sheet (SDS) for all cleaning solutions or products used on the ES-3100 shall be submitted to the Company in accordance with Attachment A.

3.4.2 Satisfactory Cleanliness

Cleaning procedures for the stainless steel per Section 3.4.3 of equipment specification SPC JS-YMN3-801580-A002 shall be submitted to the Company in accordance with Attachment A. Only non-chloride-bearing chemicals shall be used for cleaning (e.g., trisodium phosphate detergent or acetone). Water used in cleaning shall have a maximum chlorine content of 4 parts per million.

After casting but prior to packaging, stainless steel components of the forms and cans shall be cleaned per the approved cleaning procedures. Satisfactory cleanliness shall be determined by visual inspection as can be observed by a person with normal visual acuity (natural or corrected) and without magnification. Light intensity of at least 100 ft-candles shall be provided on the surface to be inspected.

3.5 Government-Furnished Equipment

None

4.0 Quality Assurance

4.1 Quality Assurance Program

The Seller shall have implemented and maintain a quality system in accordance with ASME NQA-1 2008, 1a-2009, Part 1, Sections 1-18 and/or 10 CFR 71 Subpart H and DOE O 414.1D Attachment 3, with respect to Suspect Counterfeit Items. A copy of the Seller's QA Program Manual shall be submitted with the bid in accordance with Attachment A for review and approval. The Seller shall comply and conduct all work in accordance with their Quality Assurance program and this Equipment Specification. Company will provide the critical characteristics for any items or services to be dedicated.

4.2 ES−3100 Casting Quality Assurance Requirements

4.2.1 ES−3100 Documentation Package

All records shall be identified based on the ES−3100 serial numbers. The ES-3100 Documentation Package shall be provided as Certified Data with each ES-3100 casting. The ES-3100 Documentation Package shall be complete, legible, indexed, and traceable to the material supplied and include the following:

a. Material measuring, dry blending, wet mixing, casting, sampling, and inspection forms, i.e, Forms A through F.
b. A Certificate of Compliance for each lot of the 277-0 Heat Resistant Shielding "Non-Borated" dry mix documentation with the expiration date identified on each container.
c. A Certificate of Compliances for B_4C powder to Type 1 Nuclear-Grade Boron Carbide Powder per ASTM C 750, chemical and elemental analysis per ASTM C 791, and 99.90% of the powder passes through a No. 140 Sieve per ASTM E 11.

d. A Certificate of Compliance signed by an officer of the Subcontractor confirming that the cast neutron absorber in ES−3100 shipping package meets the subcontract requirements.

4.2.2 Batch Processes

Batch processes such as mixing, pouring, curing, sampling, inspection, etc., shall be performed in accordance with detailed written procedures. These procedures shall specifically describe the exact manner in which these processes are to be performed. All records shall be traceable to the ES−3100 Shipping Package, Neutron Absorber Form, PGNAA Acceptance Standards or Companion can serial numbers.

4.2.3 Materials Traceability

A manufacturing lot or batch number shall identify material furnished to make up the neutron absorber system. Materials shall be identified by material type; applicable specification and revision number, and be traceable to their lot numbers. Traceability records shall be available for review by the Company's representative.

4.2.4 Procedures

Preparation, installation, sample collection, and inspection processes shall be controlled and performed by qualified personnel. The procedures must incorporate a mechanism to identify process step completion. Procedures shall be submitted as Approval Data. The approved procedures shall be provided as Certified Data prior to the start of casting.

4.2.5 Training and Qualification of Personnel

The Subcontractor shall provide for the training and qualification of personnel to ensure their competence in the use of process procedures and specifications. Records of personnel qualifications shall be made available to the Company upon request. Note: If the Subcontractor does not have prior experience in casting 277-4 Neutron Absorber, the Company will provide training and direct oversight on the processes.

4.2.6 The Company reserves the right to request any documentation and to witness any of the processes performed in accordance with this specification.

5.0 Preparation for Delivery

After cleaning of stainless steel surfaces per Section 3.4, aluminum foil duct tape shall be applied over the fill and vent holes in the Body Weldment (Figure 1) and the Neutron Absorber Form (Figure 5).

6.0 Manufacturer's Data

6.1 Offer Appraisal Data shall be submitted with the offer. This data shall become part of the subcontract requirements.

6.2 Approval Data will be reviewed and approved by the Company. Subcontractor shall not proceed with the casting activity until Company approval is given for all the Approval Data. The Approval Data shall be transmitted to the Company by the dates agreed to by the Subcontractor and the Company Subcontractor Administrator.

6.3 Certified Data will be used by the Company as the record for the ES-3100 shipping packages. The Certified Data shall be transmitted as noted.

6.4 Requests for Waiver or Deviation

6.4.1 After award, if a waiver or deviation from the specified requirements is desired, then the Supplier shall submit to the Company a Request for Waiver or Deviation form: UCN-13816B. The Company will provide this form upon request.

6.4.2 Use the UCN-13816B form to request permission to change or deviate from the specified requirements; obtain Company approval before proceeding with any changes.

6.4.3 Email the completed form to the STR.

6.4.4 Use the form to report any of the following conditions:

a. A request for deviation from the contract requirements.
b. Anytime a requirement contained within the original specification or a contract modification approved by the Company is violated.
c. There is nonconformance that cannot be corrected unless an item or process is modified, reworked, or repaired to an equivalent functional condition.
d. A request for Company approved substitutions shall be submitted using the RFWD form for Company approval prior to implementation. Adequate information shall be provided with the request so that the Company can determine if the item is equivalent.

FORM A 277-4 Dry Blend Batch Control Rev G Page 1 of 1

Casting Company Name	Certificate of Conformance of the 277-0 dry mix		
Blended Dry Batch Control Number [a]	Record the expiration date of the 277-0 dry mix [b]		
Certificate of Conformance of the B_4C dry mix	277-0 Heat Resistant Shielding Drum ID Number		
Planning	277-4 Weight	Units	Operator
Batch Size		lb	
Operation	Measurement	Units	Operator
277-0 Weight (Target = 277-4 Weight x 93.6 wt%)		lb	
B_4C Weight (Target = 277-4 Weight x 6.4 wt%)		lb	
Dry Blending Time		min.	
Comments			

[a] A 10-digit Blended Dry Batch Control Number shall be used to define the date and the time of mixing the casting batch using the format with a 24-hour clock (i.e. 1021041515 is used for October 21, 2004 at 3:15 pm.)

[b] Record the expiration date of the Blended Dry Batch and confirm that it is still acceptable to be cast following this specification.

EXEMPT FROM IO-155 (8-02)

FORM B 277-4 Wet Mix Control (Overcast or Special Batch) Rev G Page 1 of 1

Casting Company Name		Blended Dry Batch Control Number		
Wet Mix Control Number (WMCN) [a]		Record the expiration date of the Dry Blend Batch		
Water Temperature °F	Air Temperature °F	Measurement	Units	Operator
277-4 Weight			lb	
Water Weight (Target = 277-4 Weight × 27±1 wt%)			lb	
Mix Time			min.	
Mix Finish Time			min.	
Comments				

[a] A 10-digit Wet Mix Control Number (WMCN) shall be used to define the date and the time of mixing the casting batch using the format with a 24-hour clock (i.e. 1021041515 is used for October 21, 2004 at 3:15 pm.)

FORM C ES-3100 Body Weldment Casting Control **Rev G Page 1 of 1**

Casting Company Name					Body Weldment Casting Control # [a]		
Part Serial Number					Drawing Number M2E801580A002		
Measured Weights ±0.5 lb	Casting Information Weight	Date			Comments		Operator
Clean and Empty							
Filled with Water [b]							
Water Information	Water Weight ±0.5 lb	Water Temp. [b]			Comments		Operator
Water Conditions [b]	lb	°F					
Vibration Settings [c]	lbf	VPM					
Wet Mix Control	Blended Dry Batch Control No.				Dry Blend Batch Expiration Date		
(Target Water = 277-4 Weight × 27±1 wt%)	277-4 Weight	lb			Water Weight	lb	
	Air Temperature	°F			Water Temperature	°F	
	Mix Time				Mix Finish Time		
Companion Samples [d]	−1				−2		
	Time	Date			Comments		Operator
Vibration Start							
Vibration Stop							
Overcast WMCN							
After Casting	lb	Date					
After Cured and Clean	lb	Date					
Measurements ◇I	Height [e] (in)	Pass or Fail Height	Cured Weight (lb)		Pass or Fail Cured Weight [e]	Cured Density [f] (lb/ft³)	Pass or Fail 100−120 (lb/ft³)
Body Weldment							

[a] A 10-digit Body Weldment Casting Control Number shall be used to define the date and the time of mixing the casting batch using the format with a 24-hour clock (i.e., 1021041515 is used for October 21, 2004 at 3:15 pm).

[b] Record the water weight and water temperature within 10 minutes from completion of the weighing process.

[c] Recommended vibration settings are at 450 VPM and three times the total vibrated weight. The total vibrated weight is the finish cast part and fixtures weight, for a setting of approximately 800 pound-force.

[d] Use Form F, for ES-3100 Companion Sample Casting Control and Tests to control the companion sample castings.

[e] The acceptable cured height measurement is less than 0.25 inches. The Body Weldment cured casting weight shall be between 45.3 and 57.8 lbs.

[f] Use the above weights to calculate the density as shown below. $Density = \left(\frac{Cured - Empty}{With Water - Empty} \right) \times 62.3 \text{ lb/ft}^3$

FORM D ES-3100 Neutron Absorber Form Casting Control Rev G Page 1 of 1

Casting Company Name			Body Weldment Casting Control # [a]		
Part Serial Number			Drawing Number M2E801580A034		
Measured Weights ±0.5 lb	Casting Information Weight	Date	Comments		Operator
Clean and Empty					
Filled with Water [b]					
Water Information	Water Weight ±0.5 lb	Water Temp. [b]	Comments		Operator
Water Conditions [b]	lb	°F			
Vibration Settings [c]	lbf	VPM			
Wet Mix Control	Blended Dry Batch Control No.		Dry Blend Batch Expiration Date		
(Target Water = 277-4 Weight × 27±1 wt%)	277-4 Weight	lb	Water Weight	lb	
	Air Temperature	°F	Water Temperature	°F	
	Mix Time		Mix Finish Time		
Companion Samples [d]	−1		−2		
	Time	Date	Comments		Operator
Vibration Start					
Vibration Stop					
Overcast WMCN					
After Casting	lb	Date			
After Cured and Clean	lb	Date			

Measurements ◇I	Height [e] (in)	Pass or Fail Height	Cured Weight (lb)	Pass or Fail Cured Weight [e]	Cured Density [f] (lb/ft^3)	Pass or Fail 100−120 (lb/ft^3)
Neutron Absorber Form						

[a] A 10-digit Body Weldment Casting Control Number shall be used to define the date and the time of mixing the casting batch using the format with a 24-hour clock (i.e., 1021041515 is used for October 21, 2004 at 3:15 pm).

[b] Record the water weight and water temperature within 10 minutes from completion of the weighing process.

[c] Recommended vibration settings are at 450 VPM and three times the total vibrated weight. The total vibrated weight is the finish cast part and fixtures weight, for a setting of approximately 800 pound-force.

[d] Use Form F, for ES-3100 Companion Sample Casting Control and Tests to control the companion sample castings.

[e] The acceptable cured height measurement is less than 0.25 inches. The Neutron Absorber Form cured casting weight shall be between 45.3 and 57.8 lbs.

[f] Use the above weights to calculate the density as shown below. $Density = \left(\frac{Cured - Empty}{With Water - Empty} \right) \times 62.3$ lb/ft^3

FORM E PGNAA Acceptance Standard Lot Casting Control Rev G Page 1 of 1

Casting Company Name	Can Lot Serial Number [a]	
Average 10 Can and Lid **Empty** Weight	Temperature of Water Weight (°F)	Average 10 Can and Lid **Water** Weight

Wet Mix Control	Blended Dry Batch Control No.		Dry Blend Batch Expiration Date	
(Target Water = 277-4 Weight × 27±1 wt%)	277-4 Weight	lb	Water Weight	lb
	Air Temperature	°F	Water Temperature	°F
	Mix Time		Mix Finish Time	

Wet Mix Control Number (Overcast), if required

Can Serial #	After Casting Weight (lb)	Cured Weight (lb)	Pass or Fail Cured Weight [b]	Cured Height (in)	Pass or Fail Cured Height [b]	Cured Density (lb/ft³)	Pass or Fail Cured Density [c]
Companion Samples [d]		−1			−2		

Operator	Comments

[a] A 10-digit Can Lot Serial Number shall be used to define the date and the time of setup using the format with a 24-hour clock (i.e., 1021041515 is used for October 21, 2004 at 3:15 pm).

[b] Acceptable weight is 1.16 to 1.56 lbs and height 1.37±0.06 as shown in Figure 7.

[c] Use this equation for the; $Density = \left(\frac{Cured - Empty}{WithWater - Empty} \right) \times 62.3$ lb/ft³. Acceptable 100 to 120(lb/ft³).

[d] Use Form F, for ES-3100 Companion Sample Casting Control samples.

FORM F ES-3100 Companion Sample Casting Control **Rev G Page 1 of 1**

Casting Company Name		Ave. 10 Can and Lid Empty Weight [a]		Ave. 10 Can and Lid Water Wgt. [a]		Temp. of Water Weight (°F)	
Serial Numbers		Can Measurement Weights ±0.01 (lb)			For Record Only	Loss On Drying (Odd Serial Numbered Cans)	
Part # or Can Lot#	Companion Sample Can [a]	After Casting Weight	Cured Weight	LOD Weight	Cured Density (lb/ft^3)	Calculated LOD%	Pass Or Fail per Sec. 3.3.8.3
Complied by					Comments		

[a] For the same lot of sample cans, it is acceptable to use an average weight of ten can bodies and ten can lids.

[b] Recommended vibration settings are at 450 VPM and three times the total vibrated weight. The total vibrated weight is the finish cast part and fixtures weight, for a setting of approximately 5 pound-force.

$$Density = \left(\frac{Cured - Empty}{WithWater - Empty} \right) \times 62.3 \text{ lb/ft}^3$$

$$\text{LOD\%} = \left[1 - \frac{(LODWeight - Empty - 0.024)}{(Cured \ \& \ Clean - Empty)} \right] \times 100\%$$

Attachment A: Instructions to Supplier for Preparation of Submittals

Note 1 –All correspondence shall be addressed to the Technical Representative identified by the company. The Supplier shall forward submittals via transmittal letter to the Company at the address specified in the contract.

Note 2 – The submittal must have adequate detail so that full compliance with the requirements may be determined. For example, a simple off-the-shelf item to be used in an assembly may only need a manufacturer's cut-sheet to show compliance, but a factory acceptance test (FAT) developed and submitted by the Seller must have each test step detailed with acceptance criteria consistent with the requirements.

a. Review submittal before transmitting to the Company to verify conformance with requirements of the contract documents (e.g., field measurements, field construction criteria, or manufacturer's catalog numbers).
b. Coordinate submittals with the work requirements and the contract documents.
c. Organize Submittals
   - Do not use highlight marker or color coding on submittals.
   - The minimum resolution used for scanning submittals shall be 300 dpi x 300 dpi.
   - For submittals containing color information important to the record, a 24-bit color setting should be used.
   - Submittals are to be legible and in the format specified on the submittal checklist.
   - Pen and ink changes are to be made in non-erasable ink, legible, dated and initialed.
   - Mark specific options provided for the work, and cross out options not provided.
   - Each submittal shall be sent as a single pdf file unless otherwise specified.
d. Label submittals with the applicable item number, reference, and requirement description as summarized in the Submittal Checklist. Unlabeled submittals will be returned to the Seller without review.
e. Include with submittals a transmittal letter that identifies individual documents by specification section.
   - Transmittal for submittals shall be numbered using the purchase order number followed by a 4-digit sequential number (Example: 430001111-0001).
   - Embedded comments or questions that are not included on the transmittal may not be addressed/resolved by the Company.
f. Direction will be given at the time of award to either upload submittals to a company provided URL address or send by email to a company provided email address.
g. If using a company provided URL to upload submittals, notify the Company via email when submittals have been placed.
h. After review of a submittal, the Company will assemble comments and provide a status on the documents. An example of this submittal status stamp is shown below.

DOCUMENT REVIEW STATUS		
1	☐ Work may proceed.	
2	☐ Revise & resubmit. Work may proceed subject to incorporation of changes indicated.	
3	☐ Revise & resubmit. Work may not proceed.	
4	☐ Review not required. Work may proceed.	
Permission to proceed does not constitute acceptance or approval of design details, calculations, analysis, test methods developed or selected by the supplier and does not relieve supplier from full compliance with contractual obligations.		
REVIEWED BY:	Print Name/Signature :	Date:

i. If a submittal is being resubmitted, then reference the applicable item number, reference, and requirement description and identify it as a resubmittal.
j. Company response will only be returned to the Supplier for those submittals with a Submittal Purpose of "For Action, "unless it is determined that a submittal transmitted "For Information" is not acceptable.
k. AFTER written approval is obtained, THEN proceed with work requiring approved submittals.
l. When approval submittals are required, work done before Company approval is at the Seller's risk.
m. Maintain a copy of the company-approved submittal and status page on file.

Attachment B: Submittal Checklist

SCHEDULE				FORMAT		PURPOSE	
AA	After Award	PTF	Prior to Fabrication	CD	Compact Disk	FA	For Action
AI	After Issue	PTFA	Prior to Final Acceptance/at Completion	DVD	Digital Video Disk	FI	For Information
AIT	After Inspection Test	PTL	Prior to Lift	EM	E-Mail		
AM	After Mobilization	PTM	Prior to Mobilization	EN	Electronic (Native)		
AP	After Proposal/Bid	PTS	Prior to Shipment	EP	Electronic (PDF)		
ATS	At Time of Shipment (Separately)	PTT	Prior to Test	O	Original		
B	Before Balance of Payment	PTW	Prior to Weld	P	Prints/Photocopies		
NTP	Notice to Proceed	Q	As Required	PH	Photographs		
PTC	Prior to Construction/Commencing Work	R	As Requested	S	Sample		
PTD	Prior to Delivery	WP	With Proposal/Bid	X	X-rays		

#	REFERENCE	REQUIREMENT DESCRIPTION	SCHEDULE	FORMAT	NO. OF COPIES	PURPOSE
1.	4.1	SUBCONTRACTOR'S QUALITY ASSURANCE PLAN/PROGRAM MANUAL	WP	EP	1	FA
2.	3.1	MATERIAL SUBSTATION LISTING (IF APPLICABLE)	AA	EP	1	FA
3.	3.2.1	M & TE CALIBRATION RECORDS	PFTA	EP	1	FI
4.	6.4	REQUEST FOR WAIVER OR DEVIATION	Q	EP	1	FA
5.	3.4.1	SDS FOR CLEANING PRODUCTS	PTF	EP	1	FI
6.	3.4.2	CLEANING PROCEDURES	PTF	EP	1	FI
7.	4.2.1	ES-3100 DOCUMENTATION PACKAGE WITH EACH ES-3100 UNIT.	PTFA	EP	1	FA
8.	4.2.4	PROCESS PROCEDURES	PTF	EP	1	FA
9.	3.3.1.2	TYPE 1 NUCLEAR-GRADE BORON CARBIDE POWDER CoC	PTF	EP	1	FA
10.	3.3.1.2	SAMPLING PLAN	PTF	EP	1	FA
11.	3.3.1.3	B10 CONTENT REPORT	PTF	EP	1	FA

Attachment C: Abbreviations and Acronyms

ANSI	American National Standards Institute
ASME	American Society for Mechanical Engineers
ASTM	American Society for Testing Materials
AWS	American Welding Society
COC	Certificate of Conformance
DOE	Department of Energy
lb	pounds

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Appendix 1.3.6
Package Category Determination

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Appendix 1.3.6

Package Category Determination

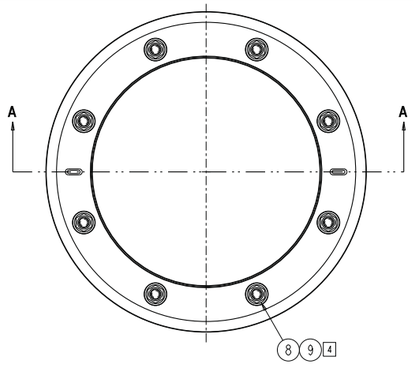
The ES-3100 with HEU content package has a maximum activity of 0.72554 TBq (19.6092 Ci) at 10 y after initial fabrication; the maximum number of A2s carried is 4752.8 at 70 y after initial fabrication (Table 4.4). Based on the guidance from Nuclear Regulatory Commission Regulatory Guide 7.11, *Fracture Toughness Criteria of Base Material for Ferritic Steel Shipping Cask Containment Vessels with a Maximum Wall Thickness of 4 Inches (0.1 m)*, this package is classified in Table 1.1 of NUREG-1609 as a Category I package.

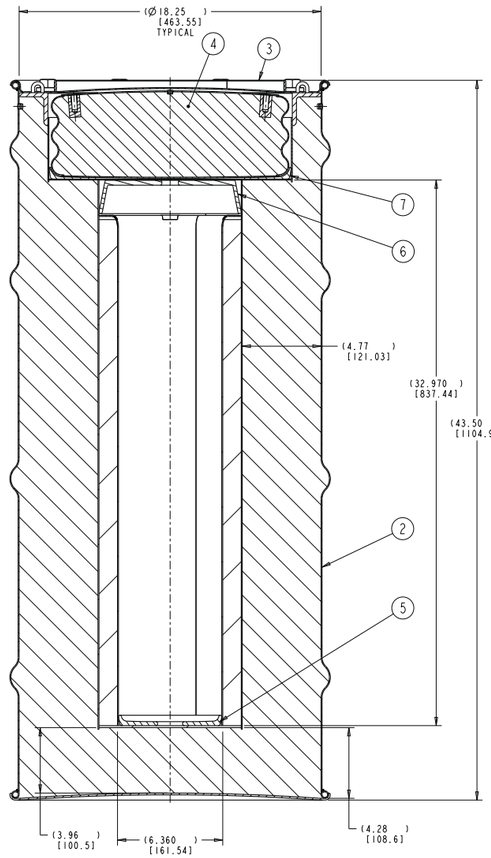
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Appendix 1.3.7
ES-3100 Design Drawings

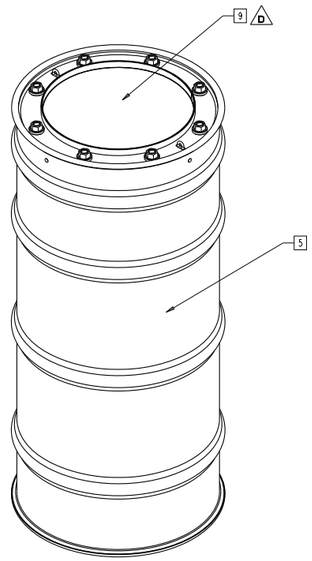
Drawing No.	Rev.	Title
M2E801580A001	D	Drum Assembly
M2E801580A002	C	Body Weldment
M2E801580A003	B	Inner Liner Weldment (2 sheets)
M2E801580A004	C	Double Open Head Reinforced Drum
M2E801580A005	E	Misc. Details
M2E801580A006	B	Drum Lid Weldment
M2E801580A007	B	18.25" Diameter Drum Lid
M2E801580A008	D	Top Plug Weldment
M2E801580A009	D	Pad Details
M2E801580A010	G	Data Plate Details
M2E801580A011	H	Containment Vessel Assembly
M2E801580A012	D	Containment Vessel Body Assembly (2 sheets)
M2E801580A013	D	Containment Vessel O-ring Details
M2E801580A014	C	Containment Vessel Lid Assembly
M2E801580A015	C	Containment Vessel Sealing Lid
M2E801580A016	B	Containment Vessel Closure Nut
M2E801580A023	E	Containment Vessel Leak Test Assemblies
M2E801580A024	D	Containment Vessel Vibration Absorbing Silicone 4.25” Can Pads
M2E801580A031	G	Main Assembly
M2E801580A043	C	Heavy Can Spacer Assembly (SST)
T2E801827A008	A	Leak Check Flange Assembly

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SECTION A-A
SCALE 3/8



ISOMETRIC VIEW
SCALE 1/4

NOTES

1 DELETED

2 DELETED

3 DIMENSIONS ARE IN INCHES [mm]. THE [mm] ARE ONLY FOR REFERENCE.

4 TORQUE HEX NUTS TO 30±5 ft-lb AT ASSEMBLY.

5 ON THE SIDE OF THE DRUM IN APPROXIMATE LOCATION SHOWN, USING BLACK ENAMEL PAINT (F/N 10), PAINT DRAWING NUMBER, REVISION LETTER AND FIVE DIGIT SERIAL NUMBER IN 1.00" HIGH CHARACTERS.

6. FOR ADDITIONAL REQUIREMENTS SEE EQUIPMENT SPECIFICATION JS-YMN3-801580-A002.

7 FOR REF ONLY. APPROXIMATE WEIGHT: 289.2 LBS [131.2 Kg].

8 REFERENCE CONFIGURATION CONTROL EQUIPMENT DATA SHEET DS-PKG-801580-A001.

9 ON THE LID IN APPROXIMATE LOCATION SHOWN, USING BLACK ENAMEL PAINT (F/N 10), PAINT OR ETCH AND FILL THE FIVE DIGIT SERIAL NUMBER IN 1.00" HIGH CHARACTERS. OPTIONALLY, USING F/N 10, PAINT THE DRAWING NUMBER AND REVISION IN 1.00" HIGH CHARACTERS.

-1 DRUM ASSEMBLY

5 9	AR		PAINT, BLACK ENAMEL	FED SPEC 595B-17038	10
4	8	M2E801580A005-3	DRUM HEX NUT		9
	8	M2E801580A005-4	DRUM WASHER		8
	1	M2E801580A009-3	PLUG PAD		7
	1	M2E801580A009-2	CV FLANGE PAD		6
	1	M2E801580A009-1	CV BOTTOM PAD		5
	1	M2E801580A008-1	TOP PLUG WELDMENT		4
	1	M2E801580A006-1	DRUM LID WELDMENT		3
	1	M2E801580A002-1	BODY WELDMENT		2
8	AR	-1	DRUM ASSEMBLY		1
M2E801580A001	-1	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPECIFICATION	FIND NO
		QTY REQ'D NEXT ASSEMBLY	PARTS LIST		

M2E801580A001 REV D SHEET 1 OF 1

REVISION DESCRIPTION	NEXT ASSEMBLY/ REFERENCE DOCUMENTS
UPDATED FORMAT, CHANGED MARKINGS, MODIFIED NOTE 5 & ADDED NOTE 9.	SEE NOTES 6 & 8 SEE PARTS LIST

TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS
XX DECIMALS
XXX DECIMALS
ANGLES
BREAK SHARP EDGES .01-.06
FINISH
THIRD ANGLE PROJECTION

I IMPORTANT TO FORM-FIT-FUNCTION
INDEPENDENT VERIFICATION REQUIRED

S IMPORTANT TO SAFETY
SHALL BE 100% INSPECTED AND NOT DEVIATED WITHOUT APPROVAL

SCALE NOTED
SHEET SIZE REPRESENTATION 1 INCH SQUARE AT FULL SIZE
SCALE PROVIDED FOR REFERENCE ONLY DO NOT SCALE

NUCLEAR CRITICALITY SAFETY
THIS DRAWING INCLUDES FEATURES SUPPORTING NUCLEAR CRITICALITY SAFETY.
ANY REVISION TO THIS DRAWING REQUIRES NUCLEAR CRITICALITY SAFETY DIVISION APPROVAL.

APPROXIMATE WEIGHT
DIMENSIONING AND TOLERANCING ASME Y14.5 - 2009
ALL DIMENSIONS ARE IN
SOFTWARE CREO 2.0

UNCLASSIFIED
THIS DOCUMENT HAS BEEN REVIEWED AND CONFIRMED TO BE UNCLASSIFIED.
NAME/DATE Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2020.02.18 10:03:56 -05'00'
TITLE: Y-12 ENGINEER
ORGANIZATION: Y-12 ENGINEERING

Y-12 NATIONAL SECURITY COMPLEX
CONSOLIDATED NUCLEAR SECURITY, LLC
P.O. BOX 2009 OAK RIDGE, TN 37831
US GOVERNMENT CONTRACT DE-NA0001942
USERS MUST REFER TO THE TRANSMITTAL DOCUMENTS THAT ACCOMPANIED DELIVERY OF THIS DRAWING FOR ANY APPLICABLE DISCLAIMERS GOVERNING THE DRAWING.

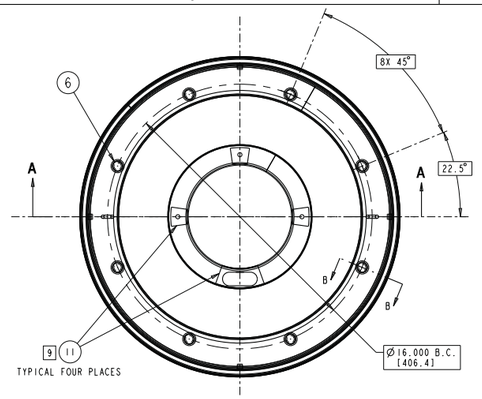
APPROVALS

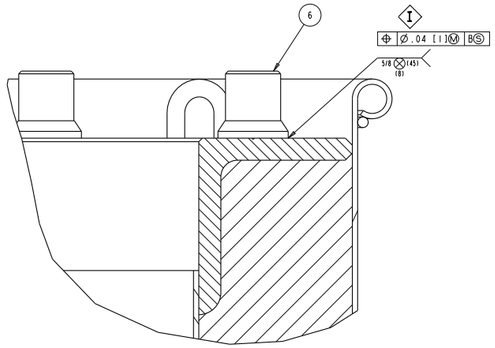
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	Kevin W (KZH) Johnson Digitally signed by Kevin W (KZH) Johnson Date: 2020.02.18 14:59:54 -05'00'		Alan D. (WA9) Wilkinson Digitally signed by Alan D. (WA9) Wilkinson Date: 2020.02.19 08:40:26 -05'00'
DE	N LANEY		
	Noelani A (NLT) Laney 2020.02.18 10:20:40 -05'00'		
CHKR	GA BYINGTON		
	G A (GAB) Byington Digitally signed by G A (GAB) Byington Date: 2020.02.18 10:12:41 -05'00'		
DVR	LC HOOPER		
	Lloyd Hooper Digitally signed by Lloyd Hooper Date: 2020.02.20 06:10:36 -05'00'		
SE	RD AIGNER		
	Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2020.02.18 10:04:20 -05'00'		
DM/PE	JC ANDERSON		
	James C (J5A) Anderson Digitally signed by James C (J5A) Anderson Date: 2020.02.23 16:07:31 -05'00'		

APPROVAL DATE REFER TO DESIGN MANAGER APPROVAL

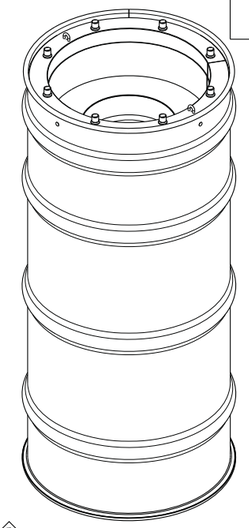
PROJECT	ES-3100 SHIPPING PACKAGE		
TITLE	DRUM ASSEMBLY		
DRAWING NUMBER	M2E801580A001	PART 000	REV D
ALTERNATE DRAWING NUMBER	N/A	RECORD NO N/A	STATE IF
			SHEET 1 OF 1

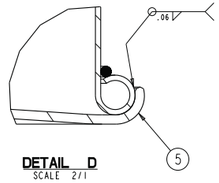
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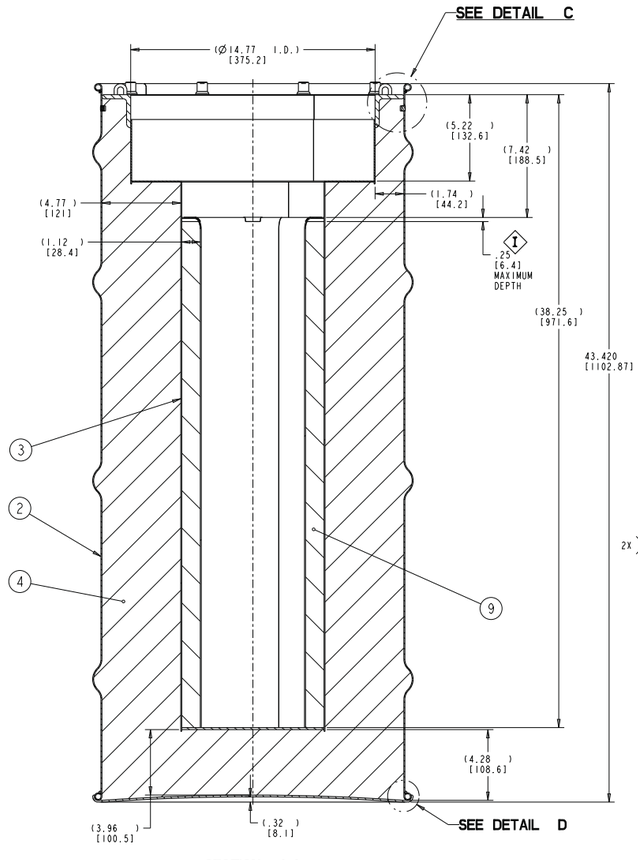


SECTION B-B
SCALE 2/1

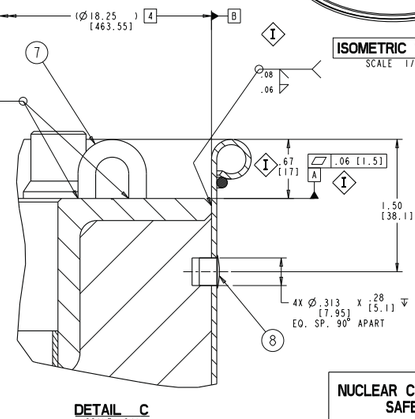




DETAIL D
SCALE 2/1



SECTION A-A
SCALE 3/8



ISOMETRIC VIEW
SCALE 1/4

DETAIL C
SCALE 2/1

-1 BODY WELDMENT

NOTES

1 DELETED

2 DELETED

3 DELETED

4 OD OF ANGLE TURNED TO ID OF DRUM AT ASSEMBLY.

5 WELDING SYMBOLS SHALL BE INTERPRETED IN ACCORDANCE WITH AWS A2.4.

6 FOR ADDITIONAL REQUIREMENTS SEE EQUIPMENT SPECIFICATION JS-YMN3-801580-A002.

7 DELETED

8 SEE EQUIPMENT SPECIFICATION SPC-M801580-0003 FOR CASTING PACKCRETE OR JS-YMN3-801580-A003 FOR CASTING KAOLITE 1600 TM INTO THE ES-3100 SHIPPING PACKAGE. THE INSULATION CASTING PROCESS IS PROTECTED UNDER U.S. PATENT 6,299,950. UNITED STATES GOVERNMENT HAS RIGHTS IN THE EVENT PURSUANT TO CONTRACT NO. DE-AC05-84 OR 21400 BETWEEN U.S. DEPARTMENT OF ENERGY AND CNS Y-12.

9 SEE EQUIPMENT SPECIFICATION JS-YMN3-801580-A005 FOR REQUIREMENTS OF CATALOG 277-4 PROCESSING AND APPLYING THE F/N 11 OVER FILL/VENT HOLES.

10 FOR REFERENCE ONLY APPROXIMATE WEIGHT: 259.7 LBS [117.8 Kg]

PACKCRETE OR KAOLITE:
VOLUME: 4.82 CU. FT.
DENSITY: 22.4 LBS/CU. FT.
WEIGHT: 108.0 LBS [49.0 Kg]

CATALOG 277-4:
VOLUME: 0.466 CU. FT.
DENSITY: 105.0 LBS/CU. FT.
WEIGHT: 48.89 LBS [22.18 Kg]

9	AR	7616A21 OR EQUAL	LOW TEMPERATURE (-40° to +250°F)	ALUMINUM FOIL DUCT TAPE 2" WIDE	McMASTER- CARR ATLANTA, GA	11
	AR		WELD FILLER METAL	PER WELD PROCEDURES		10
9	AR	-9	CATALOG NO. 277-4	THERMO ELECTRON CORP., THERMOREAX, 504 AIRPORT ROAD, SANTA FE, NM 87507 PHONE 505-428-3508, FAX 505-428-3535		9
	4	62MP0312 OR EQUAL	PLUG, NYLON 6/6	MICRO PLASTIC INC. FLIPPIN, AR 72634		8
	2	M2E801580A005-2	TID LUG			7
	8	ARC FT 5/8-11 X 7/8 LG	ARC WELD STUD	304 / 304L SST	ASTM A493 OR ASTM F593	6
	1	M2E801580A005-1	DRUM FLAT COVER			5
C 8	AR	-4	THERMAL IMPACT LIMITER	PACKCRETE OR KAOLITE	SPC-M801794-0003 SPC-M801580-0003 JS-YMN3-801580-A003	4
	1	M2E801580A003-1	INNER LINER WELDMENT			3
	1	M2E801580A004-1	DOUBLE OPEN HEAD REINFORCED DRUM			2
AR		-1	BODY WELDMENT			1
M01580 A001	–	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
		QTY REQ'D NEXT ASSEMBLY	PARTS LIST			

M2E801580A001 REV C SHEET 1 OF 1

UNCLASSIFIED

THIS DOCUMENT HAS BEEN REVIEWED AND CONFIRMED TO BE UNCLASSIFIED.

NUCLEAR CRITICALITY SAFETY

THIS DRAWING INCLUDES FEATURES SUPPORTING NUCLEAR CRITICALITY SAFETY.

ANY REVISION TO THIS DRAWING REQUIRES NUCLEAR CRITICALITY SAFETY DIVISION APPROVAL.

NAME/DATE
Roger D (R7A) Aigner — Digitally signed by Roger D (R7A) Aigner Date: 2019.08.27 14:39:29 -04'00'
TITLE: Y-12 ENGINEER
ORGANIZATION: Y-12 ENGINEERING

APPROVALS

DES KW JOHNSON	Kevin W (KZH) Johnson — Digitally signed by Kevin W (KZH) Johnson Date: 2019.08.27 07:29:27 -04'00'	WE JW FOLK	John W (FJB) Folk — Digitally signed by John W (FJB) Folk Date: 2019.08.28 15:48:53 -04'00'
DE LC HOOPER	Lloyd Hooper — Digitally signed by Lloyd Hooper Date: 2019.08.26 16:04:03 -04'00'	NCS AD WILKINSON	Alan D. (WA9) Wilkinson — Digitally signed by Alan D. (WA9) Wilkinson Date: 2019.08.29 06:37:11 -04'00'
CHKR N LANEY	Noelani A (NL1) Laney 2019.08.27 13:52:28 -04'00'		
DVR RD AIGNER	Roger D (R7A) Aigner — Digitally signed by Roger D (R7A) Aigner Date: 2019.08.29 10:28:21 -04'00'		
SE RD AIGNER	Roger D (R7A) Aigner — Digitally signed by Roger D (R7A) Aigner Date: 2019.08.27 14:39:50 -04'00'		
QM/PE JC ANDERSON	James C (J5A) Anderson — Digitally signed by James C (J5A) Anderson Date: 2019.08.29 16:11:25 -04'00'		

APPROVAL DATE: REFER TO DESIGN MANAGER APPROVAL

REVISION DESCRIPTION	NEXT ASSEMBLY/ REFERENCE DOCUMENTS
UPDATED FORMAT; REVISION PER EC-801580-0018.	JS-YMN3-801580-A002 JS-YMN3-801580-A005 SPC-M801580-0003 SPC-M801794-0003 JS-YMN3-801580-A003 SEE PARTS LIST

TOLERANCES UNLESS OTHERWISE SPECIFIED

FRACTIONS	
XX DECIMALS	±.03
XXX DECIMALS	±.005
ANGLES	±0.5°
BREAK SHARP EDGES	.01-.06
FINISH	125 RMS MAX
THIRD ANGLE PROJECTION	

I IMPORTANT TO FORM-FIT-FUNCTION INDEPENDENT VERIFICATION REQUIRED

S IMPORTANT TO SAFETY SHALL BE 100% INSPECTED AND NOT DEVIATED WITHOUT APPROVAL

SCALE: NOTED
SHEET SIZE REPRESENTATION: 1 INCH SQUARE AT FULL SIZE
SCALE PROVIDED FOR REFERENCE ONLY DO NOT SCALE

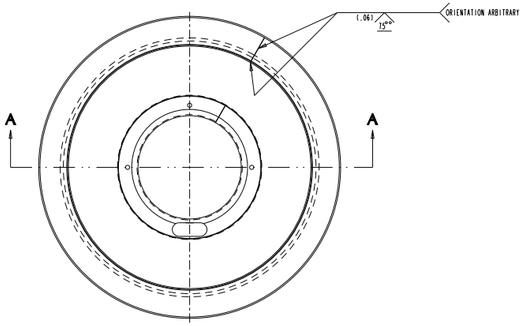
APPROXIMATE WEIGHT: N/A
DIMENSIONING AND TOLERANCING: ASME Y14.5 - 2009
ALL DIMENSIONS ARE IN: INCHES
SOFTWARE: CREO 2.0

Y-12 NATIONAL SECURITY COMPLEX
CONSOLIDATED NUCLEAR SECURITY, LLC
P.O. BOX 2009 OAK RIDGE, TN 37831
US GOVERNMENT CONTRACT: DE-NA0001942

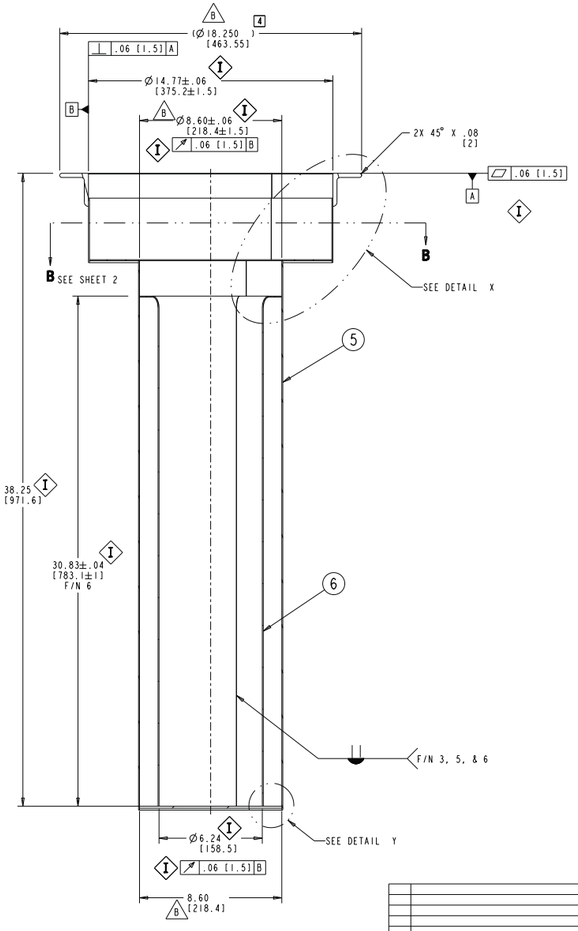
USERS MUST REFER TO THE TRANSMITTAL DOCUMENTS THAT ACCOMPANIED DELIVERY OF THIS DRAWING FOR ANY APPLICABLE DISCLAIMERS GOVERNING THE DRAWING.

PROJECT: ES-3100 SHIPPING PACKAGE
TITLE: BODY WELDMENT
DRAWING NUMBER: M2E801580A002 — PART 000 — REV C
ALTERNATE DRAWING NUMBER: N/A — RECORD NO: N/A — STATE: IF — SHEET: 1 OF 1

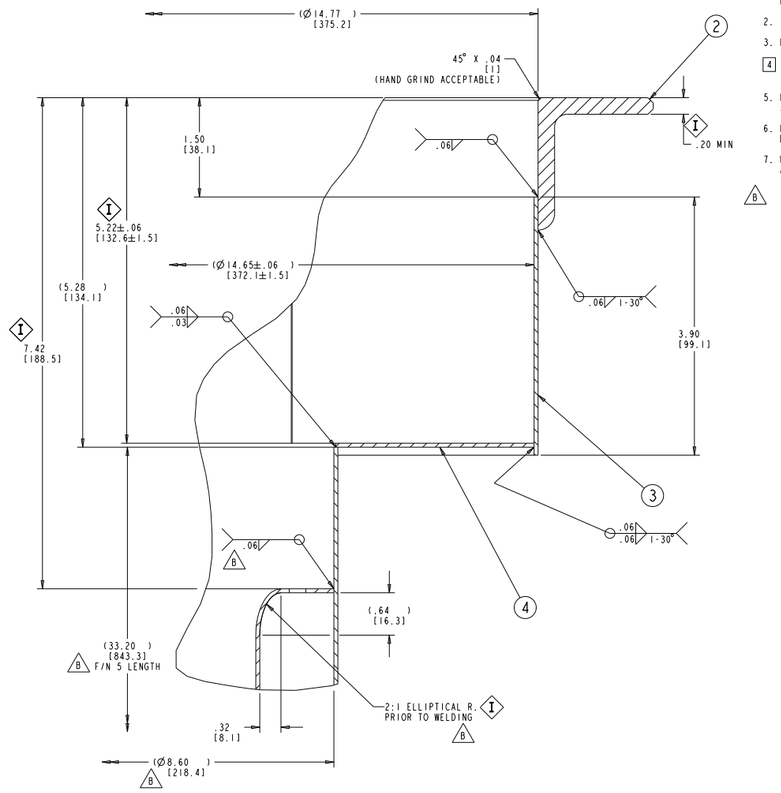
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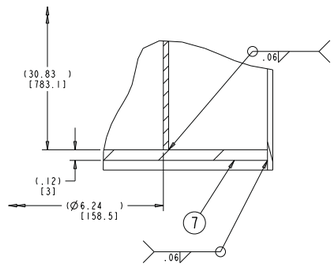
-1 INNER LINER WELDMENT
SCALE 3/8



SECTION A-A



DETAIL X
SCALE 3/2



DETAIL Y
SCALE 2/1

NOTES

1. INTERPRET DRAWING PER MECHANICAL DRAFTING STANDARD ES-3.1.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M-1994.
3. DIMENSIONS ARE IN INCHES [mm].
4. FINAL DIAMETER SET BY DRUM INSIDE DIAMETER, -.01 TO -.06 TOLERANCE.
5. FOR ADDITIONAL REQUIREMENTS SEE EQUIPMENT SPECIFICATION JS-YMN3-801580-A002.
6. DIMENSIONS AND FEATURES FLAGGED BY A (I) SYMBOL SHALL BE INSPECTED AND DOCUMENTED.
7. WELDING SYMBOLS SHALL BE INTERPRETED IN ACCORDANCE WITH AWS A2.4.

	AR		WELD FILLER METAL			8
	1	-7	BOTTOM PLATE	11 GAGE SHEET 304/304L SST	ASME SA240	7
	1	-6	LOWER INNER RING	16 GAGE SHEET 304/304L SST		6
	1	-5	LOWER OUTER RING			5
	1	-4	UPPER FLOOR PLATE			4
	1	-3	UPPER OUTER RING			3
4	1	-2	2 X 2 X 1/4 ANGLE MODIFIED	304/304L SST	ASME SA479	2
	AR	-1	INNER LINER WELDMENT			1
MATERIAL CODE	QTY REQ'D NEXT ASSEMBLY	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO

PARTS LIST

THIS DRAWING INCLUDES FEATURES SUPPORTING NUCLEAR CRITICALITY SAFETY. ANY REVISION TO THIS DIAGRAM REQUIRES NUCLEAR CRITICALITY SAFETY DIVISION APPROVAL.

REVISION	DATE	NCSD APPROVAL
B	2/10/05	JF DECLUE

This document has been reviewed by a Y-12 ADC and UCNI RO and has been determined to be UNCLASSIFIED and not UCNI. This review does not constitute clearance for public release.

Name: ROGER D. AIGNER Date: 2/10/05

REV	DESCRIPTION	DRW	CHKR	DE	DVR	DM	DATE	PE	DATE	PM	DATE	NC	DATE	AR	CV	ST	HV	EM	FP	PD	EC	IE	M	NP
A	ISSUED FOR PROTOTYPE PROCUREMENT	JRJ	JSL	GAB	JLH	JCW	10/29/03	MRF	10/29/03	DBM	10/29/03													
B	DELETED F/N 7, RENUMBERED F/N 8 TO 7 AND F/N 9 TO 8. CHANGED F/N 5 Ø8.80 TO Ø8.60. LENGTH 2.14 TO 33.20. F/N 6 OD WAS Ø9.13 NOW Ø8.60. REMOVED NOTE #8	JRP	SMM	GAB	RDA	DPS	11/1/05	GAB	2/10/05	JGA	2/10/05	DJE	2/11/05											

REVISION OR ISSUE PURPOSE — REVISION APPROVALS — SQUAD CHECK — DRAWING APPROVALS

SCALE:	NOTED
TOLERANCES UNLESS OTHERWISE SPECIFIED	
FRACTIONS	
XX DECIMALS ±.03	
XXX DECIMALS ±.005	
ANGLES ±0.5°	
BREAK SHARP EDGES .06 MAX	
FINISH 125 RMS	

DRW	J.R. JACKSON	10/29/03
CHKR	J.S. LOWERY	10/29/03
DE	G.A. BYINGTON	10/29/03
DVR	J.L. HECK	10/29/03
DM	J.C. WALLS	10/29/03
PE	M.R. FELDMAN	10/29/03
PM	D.B. MILLER	10/29/03

BWXT Y-12 National Security Complex managed by BWXT Y-12, L.L.C. for the Department of Energy under U.S. Government contract DE-AC05-00OR22800 at Oak Ridge, Tennessee

PROJECT NAME: ES-3100 SHIPPING PACKAGE

INNER LINER WELDMENT

1	48	49	50	PLANT	BLDG	FL	SH.	OF	TYPE	CLASS
6	M	L	F	Y-12	NA	NA	1	2	S	U

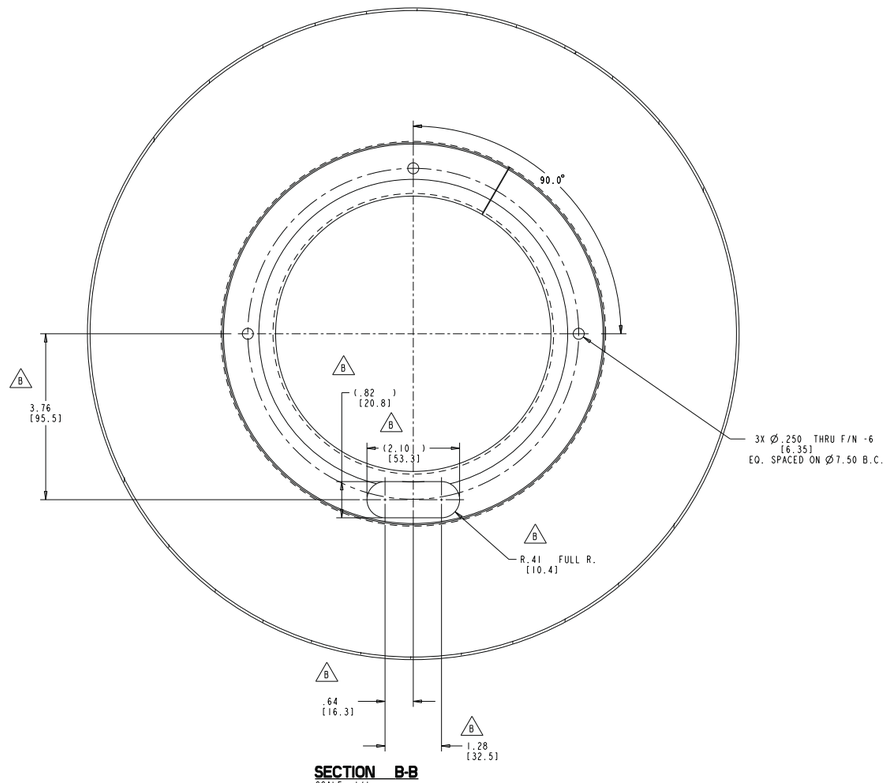
51	52	53	REV
CM	PKG	IN	M2E801580A003 B

M2E801580A003

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P THIS DRAWING PRODUCED ON PRO/ENGINEER

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SECTION B-B
SCALE 1/1

NEXT ASS'Y: | FINAL ASS'Y:

NO REPRESENTATION OR WARRANTY, EXPRESSED OR IMPLIED, IS MADE AS TO THE ACCURACY, COMPLETENESS OR USEFULNESS OF THE INFORMATION OR STATEMENTS CONTAINED IN THESE DRAWINGS, OR THAT THE USE OR DISCLOSURE OF SUCH INFORMATION, APPARATUS, METHOD, OR PROCESS DISCLOSED IN THESE DRAWINGS MAY NOT INFRINGE PRIVATE RIGHTS OF OTHERS. NO LIABILITY IS ASSUMED WITH RESPECT TO THE USE OF, OR FOR DAMAGES RESULTING FROM THE USE OF ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS. DRAWINGS MADE AVAILABLE FOR INFORMATION TO BIDDER ARE NOT TO BE USED FOR OTHER PURPOSES AND ARE TO BE RETURNED UPON REQUEST OF THE FORWARDING CONTRACTOR.

PTHIS DRAWING PRODUCED ON PRO/ENGINEER

BWXT Y-12 National Security Complex managed by BWXT Y-12, L.L.C. for the Department of Energy under U.S. Government contract DE-AC05-00OR22800 at Oak Ridge, Tennessee

PROJECT NAME
ES-3100 SHIPPING PACKAGE

INNER LINER WELDMENT

I	48	49	50	PLANT	BLDG	FL	SH.	OF	TYPE	CLASS
6	M	L	F	Y-12	NA	NA	2	2	S	U

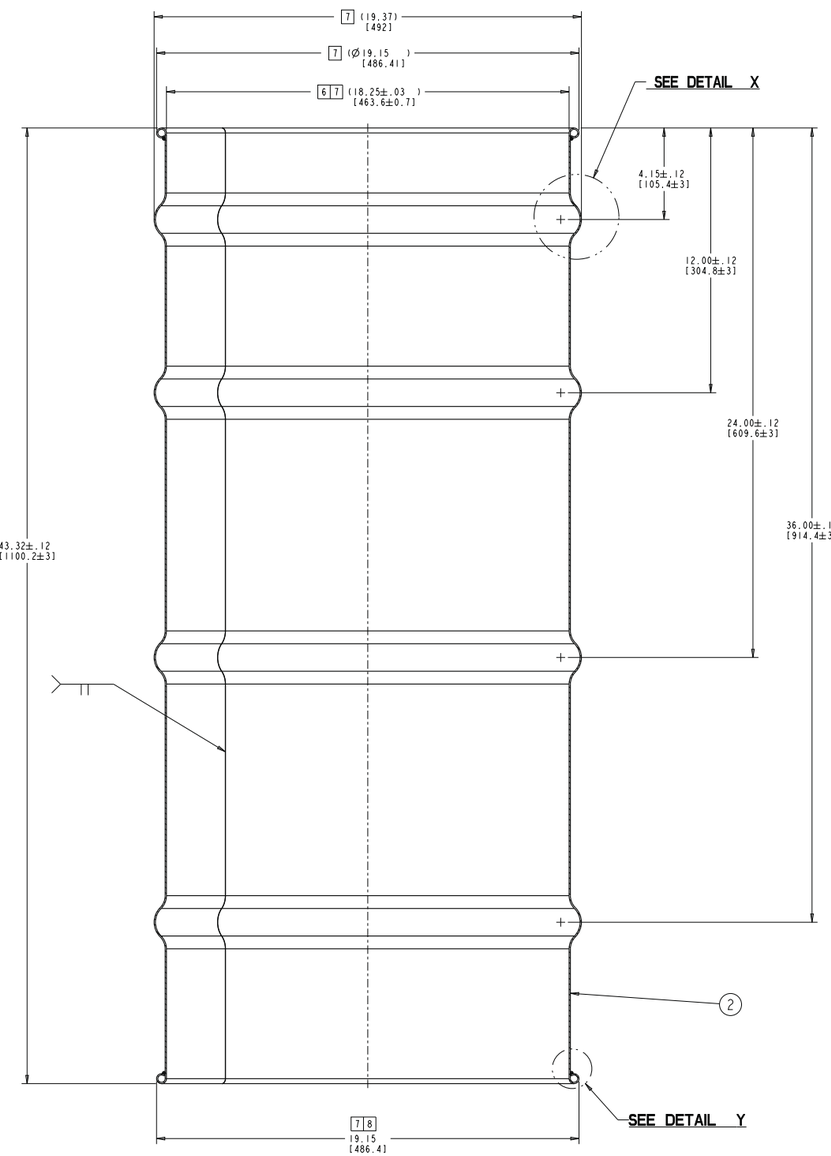
51	52	53		REV
CM	PKG	IN	M2E801580A003	B

M2E801580A003

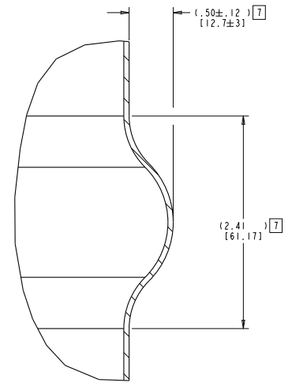
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NOTES

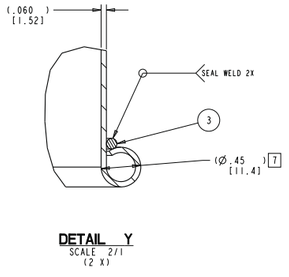
1. DELETED
2. DELETED
3. DIMENSIONS ARE IN INCHES.[mm].
4. WELDING SYMBOLS SHALL BE INTERPRETED IN ACCORDANCE WITH AWS A2.4.
5. FOR ADDITIONAL REQUIREMENTS SEE EQUIPMENT SPECIFICATION JS-YMN3-801580-A002.
6. INSPECT THE I.D. OF THE DRUM TO DETERMINE THE ACTUAL DIAMETER DIMENSION FOR FABRICATION INTERFACE WITH M2E801580A003. REFERENCE NOTE 4 ON DWG. M2E801580A002.
7. DRUM DIAMETERS, CORRUGATIONS, AND MANUFACTURING SHALL MEET THE REQUIREMENTS OF MILITARY STANDARD, MS27683-7 (DRUM, METAL SHIPPING AND STORAGE 16 TO 80 GALLS). THE SEAM WELD OF THE DOUBLE OPEN-HEAD DRUM SHALL BE TESTED BY APPLYING AN INTERNAL AIR PRESSURE TO 10 PSIG (MIL-D-6054F, PARAGRAPH 4.6.1 PROCEDURE B).
8. INSPECT THE O.D. OF THE DRUM FOR INTERFACE DIMENSION WITH M2E801580A005-1, DRUM FLAT COVER. REFERENCE NOTE 5 ON DRAWING M2E801580A005.



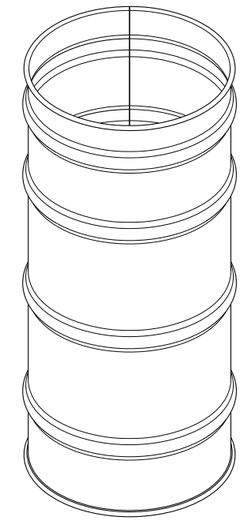
SECTION A-A
SCALE 1/2



DETAIL X
SCALE 2/1
(4X)



DETAIL Y
SCALE 2/1
(2 X)



ISOMETRIC VIEW
SCALE 1/4

	AR		WELD FILLER METAL	PER WELD PROCEDURES		4
	AR	Ø1/8	WELD WIRE	ER308L	ASME SFA 5.9	3
7	1	-2	DRUM 16 GA (.0595)	304/304L SST	ASME SA240	2
AR	X	-1	DOUBLE OPEN HEAD REINFORCED DRUM			1
M2E801580A004 REV C		PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
		QTY REQ'D NEXT ASSEMBLY	PARTS LIST			

M2E801580A004-1
DOUBLE OPEN HEAD REINFORCED DRUM

NUCLEAR CRITICALITY SAFETY

THIS DRAWING INCLUDES FEATURES SUPPORTING NUCLEAR CRITICALITY SAFETY.

ANY REVISION TO THIS DRAWING REQUIRES NUCLEAR CRITICALITY SAFETY DIVISION APPROVAL.

UNCLASSIFIED

THIS DOCUMENT HAS BEEN REVIEWED AND CONFIRMED TO BE UNCLASSIFIED.

NAME/DATE
Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2020.03.14 12:59:56 -04'00'
TITLE: Y-12 ENGINEER
ORGANIZATION: Y-12 ENGINEERING

APPROVALS

DES KW JOHNSON	Kevin W (KZH) Johnson Digitally signed by Kevin W (KZH) Johnson Date: 2020.03.12 09:48:46 -04'00'	WE JW FOLK	John W (FJB) Folk Digitally signed by John W (FJB) Folk Date: 2020.03.12 11:43:56 -04'00'
DE GA BYINGTON	G A (GAB) Byington Digitally signed by G A (GAB) Byington Date: 2020.03.16 07:53:18 -04'00'	NCS AD WILKINSON	Alan D. (WA9) Wilkinson Digitally signed by Alan D. (WA9) Wilkinson Date: 2020.03.12 11:46:12 -04'00'
CHKR LC HOOPER	Lloyd Hooper Digitally signed by Lloyd Hooper Date: 2020.03.12 10:58:42 -04'00'		
DVR RD AIGNER	Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2020.03.14 13:01:27 -04'00'		
SE RD AIGNER	Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2020.03.14 13:00:37 -04'00'		
DM/PE JC ANDERSON	James C (J5A) Anderson Digitally signed by James C (J5A) Anderson Date: 2020.03.16 13:39:56 -04'00'		
APPROVAL DATE	REFER TO DESIGN MANAGER APPROVAL		

REVISION DESCRIPTION	NEXT ASSEMBLY/ REFERENCE DOCUMENTS
UPDATED FORMAT. REVISION PER EC-801580-0022.	SEE PARTS LIST SEE NOTE 5

TOLERANCES UNLESS OTHERWISE SPECIFIED

FRACTIONS	
XX DECIMALS	±.03
XXX DECIMALS	±.010
ANGLES	±0.5°
BREAK SHARP EDGES	.01-.06
FINISH	125 RMS MAX

THIRD ANGLE PROJECTION

I IMPORTANT TO FORM-FIT-FUNCTION
INDEPENDENT VERIFICATION REQUIRED

S IMPORTANT TO SAFETY
SHALL BE 100% INSPECTED AND NOT DEVIATED WITHOUT APPROVAL

SCALE: NOTED
SHEET SIZE REPRESENTATION: 1 INCH SQUARE AT FULL SIZE
SCALE PROVIDED FOR REFERENCE ONLY DO NOT SCALE

APPROXIMATE WEIGHT

DIMENSIONING AND TOLERANCING: ASME Y14.5 - 2009
ALL DIMENSIONS ARE IN

SOFTWARE: CREO 2.0

Y-12 NATIONAL SECURITY COMPLEX
CONSOLIDATED NUCLEAR SECURITY, LLC
P.O. BOX 2009 OAK RIDGE, TN 37831
US GOVERNMENT CONTRACT: DE-NA0001942
USERS MUST REFER TO THE TRANSMITTAL DOCUMENTS THAT ACCOMPANIED DELIVERY OF THIS DRAWING FOR ANY APPLICABLE DISCLAIMERS GOVERNING THE DRAWING.

PROJECT: ES-3100 SHIPPING PACKAGE
TITLE: DOUBLE OPEN HEAD REINFORCED DRUM
DRAWING NUMBER: M2E801580A004 PART 000 REV C
ALTERNATE DRAWING NUMBER: N/A RECORD NO: N/A STATE: IF SHEET: 1 OF 1

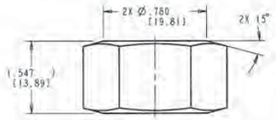
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NOTES

1. DELETED
2. DELETED
3. DELETED
4. DELETED
5. DRUM FLAT COVER SHALL BE FABRICATED TO INTERFACE WITH DOUBLE OPEN HEAD REINFORCED DRUM DIMENSION. TOLERANCE SHALL BE +.01 TO -.04. REFERENCE NOTE 9 ON DRAWING M2E801580A004.
6. FOR ADDITIONAL REQUIREMENTS SEE EQUIPMENT SPECIFICATION JS-YMN3-801580-A002.
7. THE MODIFIED DRUM NUT SHALL MEET THE REQUIREMENTS IN EQUIPMENT DATA SHEET DS 801580-0001.
8. THE DRUM NUT MECHANICAL PROPERTY MARKING, F467K, SHALL BE FULLY VISIBLE AFTER MODIFICATION.

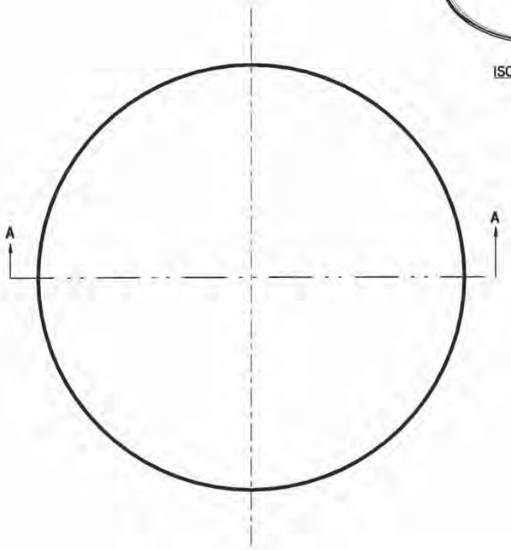


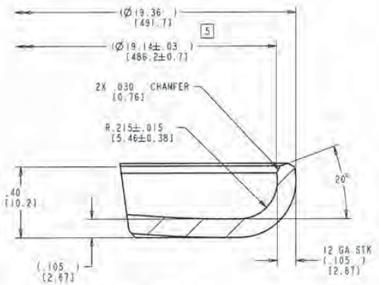
ISOMETRIC VIEW
SCALE 1/4



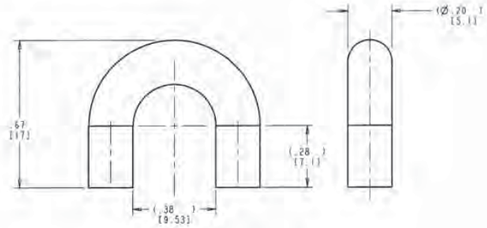


-3 MODIFIED DRUM NUT 7 8
SCALE 3/1

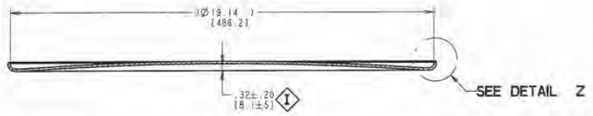




DETAIL Z
SCALE 4/1

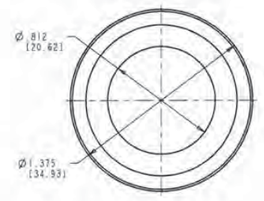


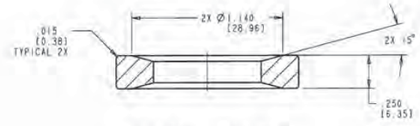
-2 TID LUG
SCALE 4/1



SECTION A-A

-1 DRUM FLAT COVER
SCALE 1/2





-4 DRUM WASHER
SCALE 3/1

QTY REQ'D NEXT ASSEMBLY	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
B	-4	DRUM WASHER	300 SERIES SST	ASTM A240 OR A276	4
B	-3	MODIFIED DRUM NUT	C65100 SILICON BRONZE	ASTM F-467 ANSI B18.2.2	3
2	MODIFIED 3392751 OR EQUAL	TID LUG	304L SST CHAIN 3/16" TRADE SIZE, 20 DIA. MATERIAL, INSIDE LINK SIZE .38 WD, .95L	McMASTER-CARR SUPPLY CO. ATLANTA, GA 30374	2
1	-1	DRUM FLAT COVER	12 GA 304/304L SST	ASME SA240	1

M2E801580 A001-1
M2E801580 A002-1

PARTS LIST

REV	DATE	REVISION DESCRIPTION
E	3/31/2016	UPDATED FORMAT; REVISED NOTE 7 & DELETED NOTES 1-4
D	3/17/10	ADDED NOTE 8, REVISED FORMAT
C	9/10/09	ADDED REFERENCE NOTE 7.
B	2/11/05	REVISED F/N 2; ADDED F/N 3 & 4 REMOVED TOL FROM DETAIL Z DIM.
A	10/29/03	ISSUED FOR PROTOTYPE PROCUREMENT

NEXT ASSEMBLY/ REFERENCE DOCUMENTS: N/A

SCALE: NOTED
SHEET SIZE REPRESENTATION: 1 INCH SQUARE AT FULL SIZE
SCALE PROVIDED FOR REFERENCE ONLY DO NOT SCALE

TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS ±.01
XX DECIMALS ±.005
XXX DECIMALS ±0.5°
ANGLES
BREAK SHARP EDGES .01-.06
FINISH 125 RMS
THIRD ANGLE PROJECTION

I IMPORTANT TO FORM-FIT-FUNCTION INDEPENDENT VERIFICATION REQUIRED.
S IMPORTANT TO SAFETY SHALL BE 100% INSPECTED AND NOT DEVIATED WITHOUT APPROVAL

APPROXIMATE WEIGHT: N/A
DIMENSIONING AND TOLERANCING: ASME Y14.5M - 1994
ALL DIMENSIONS ARE IN: INCHES
SOFTWARE: CREO 2.0

UNCLASSIFIED

THIS DOCUMENT HAS BEEN REVIEWED BY A Y-12 DC/UCNI-RO AND HAS BEEN DETERMINED TO BE UNCLASSIFIED AND CONTAINS NO UCNI. THIS REVIEW DOES NOT CONSTITUTE CLEARANCE FOR PUBLIC RELEASE.

NAME: STAN THOMAS
DATE: 03/01/16
TITLE: PKG. ENGR
ORGANIZATION: PACKAGING

NUCLEAR CRITICALITY SAFETY

THIS DRAWING INCLUDES FEATURES SUPPORTING NUCLEAR CRITICALITY SAFETY. ANY REVISION TO THIS DRAWING REQUIRES NUCLEAR CRITICALITY SAFETY DIVISION APPROVAL.

CURRENT ISSUE APPROVALS

DES	HW JOHNSON	NCS	AD WILKINSON
PM	GA BYINGTON		
CNSE	J ROBERSON		
DVR	WL GOINS		
SE	N/A		
PE	L ROBERSON		
DN	C ANDERSON		

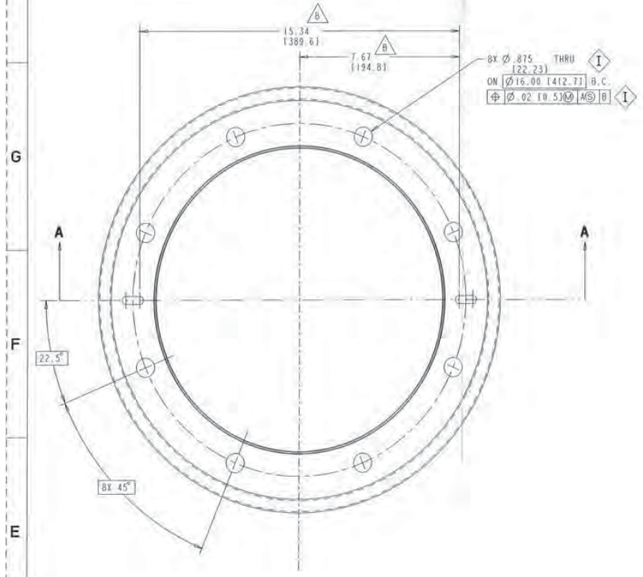
Y-12 NATIONAL SECURITY COMPLEX
CONSOLIDATED NUCLEAR SECURITY, LLC
P.O. BOX 2009 OAK RIDGE, TN 37829

US GOVERNMENT CONTRACT: DE-NA0001942

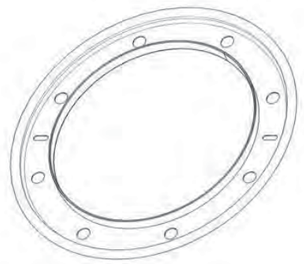
USERS MUST REFER TO THE TRANSMITTAL DOCUMENTS THAT ACCOMPANIED DELIVERY OF THIS DRAWING FOR ANY APPLICABLE DISCLAIMERS GOVERNING THE DRAWING.

PROJECT: ES-3100 SHIPPING PACKAGE
TITLE: MISC. DETAILS
DRAWING NUMBER: M2E801580A005 PART 000 REV E
RECORD NO: N/A TBIS: N/A STATE: AR SHEET 1 OF 1

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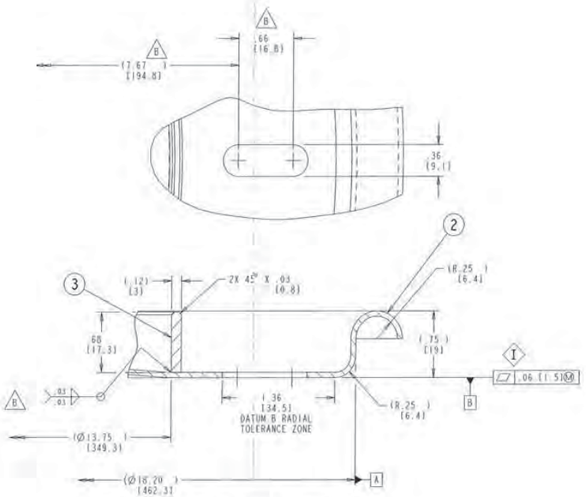
-1 DRUM LID WELDMENT
SCALE 1/2



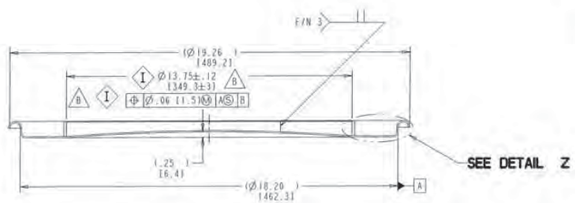
ISOMETRIC VIEW
SCALE 3/8

NOTES:

1. INTERPRET DRAWING PER MECHANICAL DRAFTING STANDARD ES-3.1.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M-1994.
3. DIMENSIONS ARE IN INCHES [mm].
4. WELDING SYMBOLS SHALL BE INTERPRETED IN ACCORDANCE WITH AWS A2.4.
5. FOR ADDITIONAL REQUIREMENTS SEE EQUIPMENT SPECIFICATION JS-YWN3-801580-A002.
6. DIMENSIONS AND FEATURES FLAGGED BY A I SYMBOL SHALL BE INSPECTED AND DOCUMENTED.
7. FOR REFERENCE ONLY APPROXIMATE WEIGHT: 9.1 LBS [4.1 Kg]



DETAIL Z
SCALE 2/1



SECTION A-A

AR		WELD FILLER METAL	PER WELD PROCEDURES		4
1	-3	11 GA 1.1971 SHEET	304/304L SST	ASME SA240	3
1	M2E801580A007-1	18.25" DIA. DRUM LID			2
AR	-1	DRUM LID WELDMENT			1
MATERIAL CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
	QTY REQ'D NEXT ASSEMBLY	PARTS LIST			

THIS DRAWING INCLUDES FEATURES SUPPORTING NUCLEAR CRITICALITY SAFETY. ANY REVISION TO THIS DIAGRAM REQUIRES NUCLEAR CRITICALITY SAFETY DIVISION APPROVAL.

REVISION	DATE	NCSD APPROVAL
B	02/10/05	

This document has been reviewed by a Y-12 ADC and UCNI RO and has been determined to be UNCLASSIFIED and not UCNI. This review does not constitute clearance for public release.

Name: Date: 2/10/05

REV	DESCRIPTION	DRW	CHKR	PE	DVR	DM	DATE	FE	DATE	IM	DATE	MI	DATE
B	REPLACED HOLE WITH SLOT; ADDED TOL TO 13.75 DIM; ADDED I ; MOD WELD; GEN REV. NOTE 4 WAS 5	RD	SMM	GAB	JLH	DBS	2/10/05	MRT	2/10/05	DBM	2/10/05		
A	ISSUED FOR PROTOTYPE PROCUREMENT	JRJ	JSL	GAB	JLH	JCW	10/29/03	MRT	10/29/03	DBM	10/29/03		

REVISION OR ISSUE PURPOSE	REVISION APPROVALS												SQUAD CHECK										DRAWING APPROVALS
	DRW	CHKR	PE	DVR	DM	DATE	FE	DATE	IM	DATE	MI	DATE	AR	CV	ST	WF	EM	FP	PD	EE	IE	M	MP

SCALE: NOTED
TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS
XX DECIMALS ±.03
XXX DECIMALS ±.010
ANGLES ±0.5°
BREAK SHARP EDGES .06 MAX
FINISH 125 RMS

DRW	J. R. JACKAON	10/29/03
CHKR	J. S. LOWERY	10/29/03
EE	G. A. BYINGTON	10/29/03
DVR	J. L. HECK	10/29/03
DM	J. C. WALLS	10/29/03
PE	M. R. FELDMAN	10/29/03
PM	D. B. MILLER	10/29/03

BWXT Y-12 National Security Complex managed by BWXT Y-12, L.L.C. for the Department of Energy under U.S. Government contract DE-AC05-00OR22800. a Oak Ridge, Tennessee co

PROJECT NAME: ES-3100 SHIPPING PACKAGE

DRUM LID WELDMENT

J	AS	AR	SU	PLANT	BLDG	FL	DN	OF	TYPE	CLASS
6	M	L	F	Y-12	NA	NA	1	1	S	U

S1	S2	S3	DRAWING NUMBER	REV
CM	PKG	IN	M2E801580A006	B

M2E801580A006

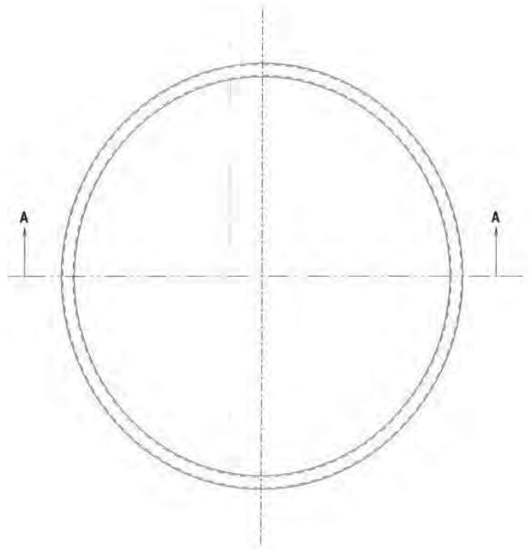
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THIS DRAWING PRODUCED ON PRO/ENGINEER

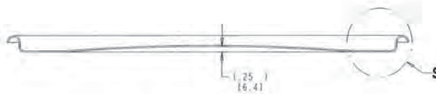
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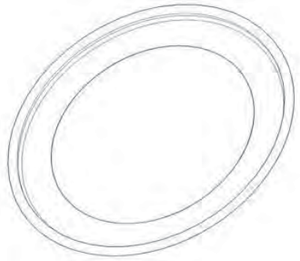
NOTES:

1. INTERPRET DRAWING PER MECHANICAL DRAFTING STANDARD ES-3.1.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M-1994.
3. DIMENSIONS ARE IN INCHES [mm].
4. FOR ADDITIONAL INFORMATION SEE EQUIPMENT SPECIFICATION DS-YMN3-801580A002.
5. LID SHALL BE FABRICATED IN ACCORDANCE WITH MILITARY SPECIFICATION MS27683-61, COVER STYLE 1.

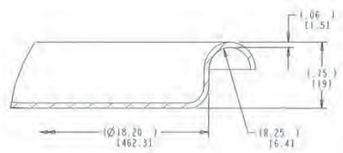


SECTION A-A





ISOMETRIC VIEW
SCALE 3/8



DETAIL Z
SCALE 2/1

-1 18.25" DIAMETER DRUM LID
SCALE 1/2

AR	-1	18.25" DIA. DRUM LID	16 GA 304/304L SST	ASME SA240	1
	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
	QTY REQ'D NEXT ASSEMBLY	PARTS LIST			

THIS DRAWING INCLUDES FEATURES SUPPORTING NUCLEAR CRITICALITY SAFETY. ANY REVISION TO THIS DIAGRAM REQUIRES NUCLEAR CRITICALITY SAFETY DIVISION APPROVAL.

REVISION	DATE	NCSD APPROVAL
B	02/10/05	

This document has been reviewed by a Y-12 ADC and UCNI RO and has been determined to be UNCLASSIFIED and not UCNI. This review does not constitute clearance for public release.

Name: Date: 2/10/05

REV	DESCRIPTION	DRW	CHKR	DE	DVR	DM	DATE	PE	DATE	PM	DATE
B	GENERAL REVISION	JRJ	JSL	GAB	JLH	JCW	10/29/03	MRF	10/29/03	DBM	10/29/03
A	ISSUED FOR PROTOTYPE PROCUREMENT	JRJ	JSL	GAB	JLH	JCW	10/29/03	MRF	10/29/03	DBM	10/29/03

REVISION OR ISSUE PURPOSE | REVISION APPROVALS | SQUAD CHECK | DRAWING APPROVALS | DATE

SCALE: NOTED
TOLERANCES UNLESS OTHERWISE SPECIFIED:
FRACTIONS
XX DECIMALS
XXX DECIMALS
ANGLES
BREAK SHARP EDGES MAX
FINISH

DRW	J.R. JACKSON	10/29/03
CHKR	J.S. LOWERY	10/29/03
DE	G.A. BYINGTON	10/29/03
DVR	J.L. HECK	10/29/03
DM	J.C. WALLS	10/29/03
PE	M.R. FELDMAN	10/29/03
PM	D.B. MILLER	10/29/03

BWXT Y-12 National Security Complex managed by BWXT Y-12 LLC for the Department of Energy under U.S. Government contract DE-AC05-00OR22800 at Oak Ridge, Tennessee

PROJECT NAME
ES-3100 SHIPPING PACKAGE

18.25" DIAMETER DRUM LID

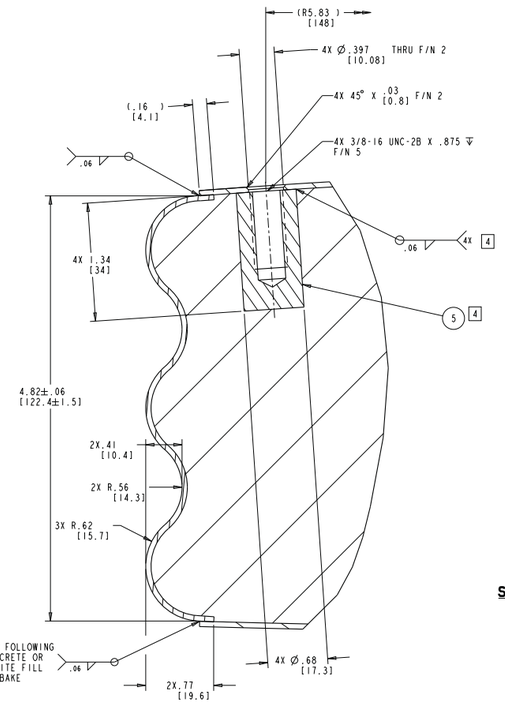
J	AR	AP	SO	PLANT	BLDG	FY	SH	OF	TYPE	CLASS
6	M	L	F	Y-12	NA	NA	1	1	S	U
SY		SZ		ST						REV
CM		PKG		IN	M2E801580A007					B

M2E801580A007

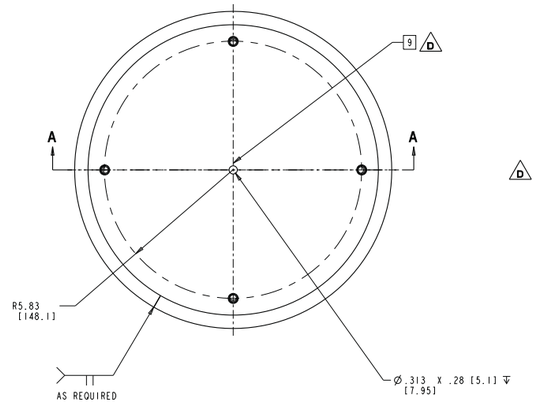
NO REPRESENTATION OR WARRANTY, EXPRESSED OR IMPLIED, IS MADE AS TO THE ACCURACY, COMPLETENESS OR USEFULNESS OF THE INFORMATION OR STATEMENTS CONTAINED IN THESE DRAWINGS, OR THAT THE USE OR DISCLOSURE OF ANY INFORMATION, APPARATUS, METHOD, OR PROCESS DISCLOSED IN THESE DRAWINGS MAY NOT INFRINGE PRIVATE RIGHTS OF OTHERS. NO LIABILITY IS ASSUMED WITH RESPECT TO THE USE OF, OR FOR DAMAGES RESULTING FROM THE USE OF, ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS. DRAWINGS MADE AVAILABLE FOR INFORMATION TO BIDDERS ARE NOT TO BE USED FOR OTHER PURPOSES AND ARE TO BE RETURNED UPON REQUEST OF THE FORWARDING CONTRACTOR

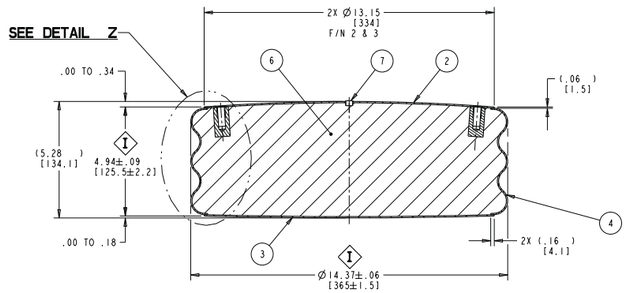
THIS DRAWING PRODUCED ON PRO/ENGINEER

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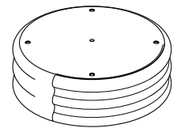
DETAIL Z
SCALE 2/1





SECTION A-A

-1 TOP PLUG WELDMENT
SCALE 1/2



ISOMETRIC VIEW
SCALE 1/4

NOTES

1. DELETED
2. DELETED
3. DELETED
4. WELD LIFTING INSERTS (F/N 5) IN PLACE BEFORE FILLING WITH PACKCRETE OR KAOLITE (F/N 6).
5. WELDING SYMBOLS SHALL BE INTERPRETED IN ACCORDANCE WITH AWS A2.4.
6. SEE EQUIPMENT SPECIFICATION SPC-801580-0003 FOR CASTING PACKCRETE OR JS-YMN3-801580-A003 FOR CASTING KAOLITE 1600 TM INTO THE ES-3100 SHIPPING PACKAGE. THE INSULATION CASTING PROCESS IS PROTECTED UNDER U.S. PATENT 6,299,950. UNITED STATES GOVERNMENT HAS RIGHTS IN THE EVENT PURSUANT TO CONTRACT NO. DE-AC05-84 OR 2400 BETWEEN U.S. DEPARTMENT OF ENERGY AND CNS Y-12.
7. DELETED
8. FOR REFERENCE ONLY APPROXIMATE WEIGHT 19.6 LBS [8.8 Kg]
   PACKCRETE OR KAOLITE:
   VOLUME 0.43 CU.FT.
   DENSITY 22.4 LBS/CU. FT.
   WEIGHT: 9.6 LBS [4.7 Kg]
9. IN APPROXIMATE LOCATION SHOWN, USING BLACK ENAMEL PAINT (F/N 9), PAINT M2E801580A001, REVISION LETTER AND FIVE DIGIT SERIAL NUMBER IN 1.00" HIGH CHARACTERS.

D 9	AR		PAINT, BLACK ENAMEL		FED SPEC 595B-17038	9
	AR		WELD FILLER METAL	PER WELD PROCEDURES		8
	1	62MP0312 OR EQUAL	PLUG, NYLON 6/6	MICRO PLASTIC INC. FLIPPIN, AR 72634		7
	1	-6	THERMAL IMPACT LIMITER	PACKCRETE OR KAOLITE	SPC-M801794-0003 SPC-M801580-0003 JS-YMN3-801580-A003	6
	4	-5	LIFTING INSERT	1 1/16 ROUND 304/304L SST	ASME SA479	5
	1	-4	PLUG RIM	16 GA SHT 304/304L SST	ASME SA240	4
	1	-3	BOTTOM SHEET			3
	1	-2	TOP SHEET			2
AR	X	-1	TOP PLUG WELDMENT			1
M2E801580 A001	-	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
		QTY REQ'D NEXT ASSEMBLY	PARTS LIST			

M2E801580A008 REV D SHEET 1 OF 1

REVISION DESCRIPTION	NEXT ASSEMBLY/ REFERENCE DOCUMENTS
ADDED NOTE 9 AND F/N 9.	JS-YMN3-801580-A002 SPC-M801580-0003 SPC-M801794-0003 JS-YMN3-801580-A003 SEE PARTS LIST

TOLERANCES UNLESS OTHERWISE SPECIFIED

FRACTIONS	±.03
XX DECIMALS	±.005
XXX DECIMALS	±0.5°
ANGLES	.01-.06
BREAK SHARP EDGES	125 RMS MAX
FINISH	

THIRD ANGLE PROJECTION

I IMPORTANT TO FORM-FIT-FUNCTION
INDEPENDENT VERIFICATION REQUIRED

S IMPORTANT TO SAFETY
SHALL BE 100% INSPECTED AND NOT DEVIATED WITHOUT APPROVAL

SCALE: NOTED
SHEET SIZE REPRESENTATION: 1 INCH SQUARE AT FULL SIZE
SCALE PROVIDED FOR REFERENCE ONLY DO NOT SCALE

APPROXIMATE WEIGHT: N/A
DIMENSIONING AND TOLERANCING: ASME Y14.5 - 2009
ALL DIMENSIONS ARE IN
SOFTWARE: CREO 2.0

NUCLEAR CRITICALITY SAFETY
THIS DRAWING INCLUDES FEATURES SUPPORTING NUCLEAR CRITICALITY SAFETY.
ANY REVISION TO THIS DRAWING REQUIRES NUCLEAR CRITICALITY SAFETY DIVISION APPROVAL.

UNCLASSIFIED
THIS DOCUMENT HAS BEEN REVIEWED AND CONFIRMED TO BE UNCLASSIFIED.

NAME/DATE: Roger D (R7A) Aigner — Digitally signed by Roger D (R7A) Aigner Date: 2020.02.18 10:13:55 -05'00'
TITLE: Y-12 ENGINEER
ORGANIZATION: Y-12 ENGINEERING

USERS MUST REFER TO THE TRANSMITTAL DOCUMENTS THAT ACCOMPANIED DELIVERY OF THIS DRAWING FOR ANY APPLICABLE DISCLAIMERS GOVERNING THE DRAWING.

APPROVALS

DES KW JOHNSON	Kevin W (KZH) Johnson — Digitally signed by Kevin W (KZH) Johnson Date: 2020.02.18 14:56:11 -05'00'	WE JW FOLK	John W (FJB) Folk — Digitally signed by John W (FJB) Folk Date: 2020.02.19 17:27:01 -05'00'
DE N LANEY	Noelani A (NL1) Laney 2020.02.18 10:24:03 -05'00'	WCS IAD WILKINSON	Alan D. (WA9) Wilkinson — Digitally signed by Alan D. (WA9) Wilkinson Date: 2020.02.19 08:46:33 -05'00'
CHKR IGA BYINGTON	G A (GAB) Byington — Digitally signed by G A (GAB) Byington Date: 2020.02.18 10:15:58 -05'00'		
DVR LC HOOPER	Lloyd Hooper — Digitally signed by Lloyd Hooper Date: 2020.02.20 06:11:51 -05'00'		
SE RD AIGNER	Roger D (R7A) Aigner — Digitally signed by Roger D (R7A) Aigner Date: 2020.02.18 10:14:18 -05'00'		
DM/PE JC ANDERSON	James C (J5A) Anderson — Digitally signed by James C (J5A) Anderson Date: 2020.02.23 16:12:13 -05'00'		
APPROVAL DATE	REFER TO DESIGN MANAGER APPROVAL		

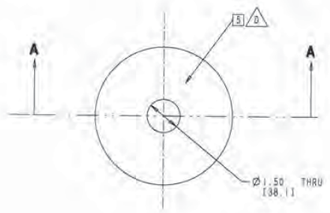
Y-12 NATIONAL SECURITY COMPLEX
CONSOLIDATED NUCLEAR SECURITY, LLC
P.O. BOX 2009 OAK RIDGE, TN 37831
US GOVERNMENT CONTRACT: DE-NA0001942

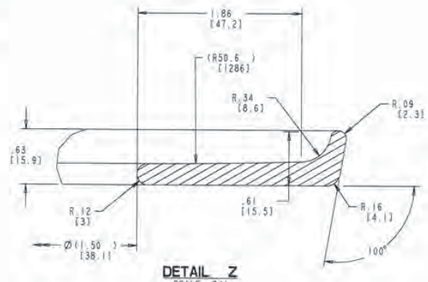
PROJECT: ES-3100 SHIPPING PACKAGE
TITLE: TOP PLUG WELDMENT
DRAWING NUMBER: M2E801580A008 — PART 000 — REV D
ALTERNATE DRAWING NUMBER: N/A — RECORD NO: N/A — STATE: IF — SHEET: 1 OF 1

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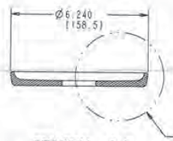
NOTES

1. INTERPRET DRAWING PER MECHANICAL DRAFTING STANDARD ES-3.1.
2. INTERPRET DIMENSIONS AND TOLERANCES PER "RMA" RUBBER HANDBOOK (RMA-392) CLASS "A2 PRECISION."
3. DIMENSIONS ARE IN INCHES. [mm]
4. MANUFACTURER/SUPPLIER TO PROVIDE CERTIFICATE OF COMPLIANCE FOR ALL FEATURES OF THESE ITEMS.
5. IN APPROXIMATE LOCATION SHOWN, ENGRAVE DRAWING NUMBER AND REVISION LETTER IN 1/4" HIGH CHARACTERS IN THE MOLD TO MAKE A LEGIBLE RAISED MARKINGS IN THE PART.
6. FOR ADDITIONAL INFORMATION SEE EQUIPMENT DATA SHEET DS-801580-0002.



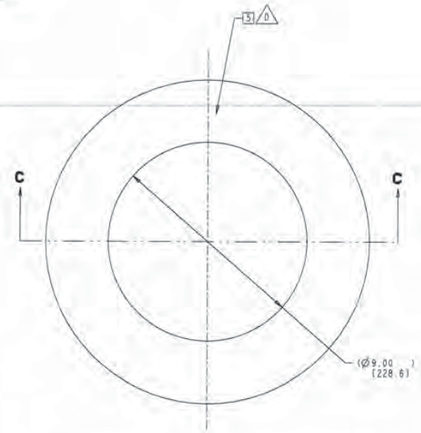


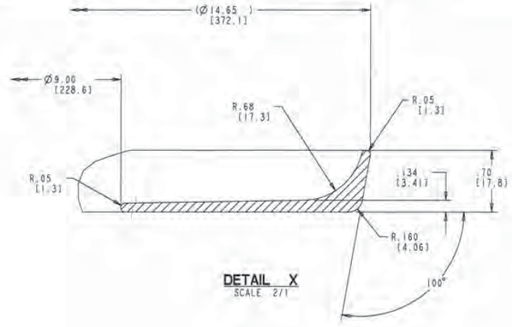
DETAIL Z
SCALE 2/1



SECTION A-A

-1 CV BOTTOM PAD
SCALE 1/2
APPROXIMATE WEIGHT- 0.37 LB



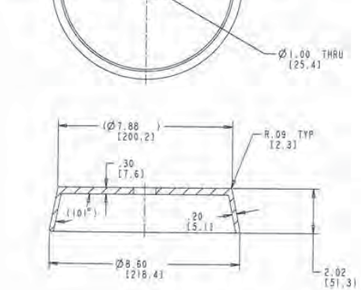


DETAIL X
SCALE 2/1



SECTION C-C

SEE DETAIL X



SECTION B-B

-2 CV FLANGE PAD
SCALE 1/2
APPROXIMATE WEIGHT - 1.15 LB

-3 PLUG PAD
SCALE 1/2
APPROXIMATE WEIGHT 0.77 LB

ITEM NO	QTY REQ'D NEXT ASSEMBLY	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
	←	PARTS LIST				
3	AR	-3	PLUG PAD	SILICONE RUBBER 22±5 SHORE A COLOR BLACK/GRAY	SEE NOTE 6	
2	AR	-2	CV FLANGE PAD			
1	AR	-1	CV BOTTOM PAD			

M2E801580A009

THIS DRAWING INCLUDES FEATURES SUPPORTING NUCLEAR CRITICALITY SAFETY. ANY REVISION TO THIS DIAGRAM REQUIRES NUCLEAR CRITICALITY SAFETY ANALYSIS ENGINEERING APPROVAL.

REVISION	DATE	SAE APPROVAL
D	6/5/2012	J.T. DeClue

This document has been reviewed by a Y-12 DC and UCNI RO and has been determined to be UNCLASSIFIED and not UCNI. This review does not constitute clearance for public release.

Name: Date: 6/6/12

THIS DRAWING PRODUCED ON PRO/ENGINEER

THIS DRAWING IS LOANED FOR SOLE USE OF THE INTENDED RECIPIENT AND ONLY FOR THE LIMITED PURPOSES FOR WHICH IT WAS PROVIDED. USE BY OTHER ENTITIES OR FOR OTHER PURPOSES IS PROHIBITED AND AT THE USER'S OWN RISK. DRAWINGS ARE TO BE RETURNED UPON REQUEST OF THE FORWARDING RECIPIENT.

PART	REV	DESCRIPTION	REVISION OR ISSUE PURPOSE	DRW	CHKR	DE	SVR	DM	DATE	FE	DATE	SE	DATE	ME	DATE	NCS	DATE	ON/SO	DATE
000	D	DELETED FIND NO 4. ADDED NOTE 6, CHANGED NOTE 5, REMOVED VENDOR FROM PARTS LIST		JRP	SMM	GAB	RDA	DPS	11/18/03	GAB	11/18/03	JGA	11/20/03						
000	C	GEN REV: REDESIGNED F/N 1; ADDED APPROXIMATE WEIGHT TO F/N 1, 2 AND 3		GAB	RA	GAB	JLH	JCW	11/27/04	GAB	11/27/04	JGA	11/27/04						
000	B	MODIFIED DIMENSIONING ON -3		JRJ	JSL	GAB	JLH	JCW	10/29/08	MRF	10/29/08	DBM	10/29/08						
000	A	ISSUED FOR PROTOTYPE PROCUREMENT		DRW	CHKR	DE	SVR	DM	DATE	FE	DATE	SE	DATE	ME	DATE	NCS	DATE	ON/SO	DATE

AR	CV	ST	HV	EM	FP	PD	EE	IE	M	MP

SQUAD CHECK

DRAWING APPROVALS

SCALE:	NOTED	
TOLERANCES UNLESS OTHERWISE SPECIFIED		
FRACTIONS		
XX DECIMALS		
XXX DECIMALS		
ANGLES		
BREAK SHARP EDGES	MAX	WE N/R
FINISH		

DRW	J.R. JACKSON	10/29/03
CHKR	J.S. LOWERY	10/29/03
DE	G.A. BYINGTON	10/29/03
SVR	J.L. HECK	10/29/03
DM	J.C. WALLS	10/29/03
FE	M.R. FELDMAN	10/29/03
SE		
ON/SO	D.B. MILLER	10/29/03

Y-12 National Security Complex managed by B & W Technical Services Y-12, L.L.C. for the Department of Energy under U.S. Government contract DE-AC-05-00OR22800 • Oak Ridge, Tennessee •

PROJECT NAME
ES-3100 SHIPPING PACKAGE

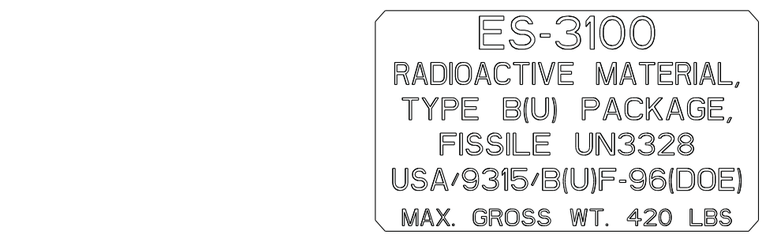
PAD DETAILS

USE	DISC	DT	DC	CM	SYSTEM	SUBSYSTEM	BLDG	FL	CLASS
6	M	L	F	CM	PKG	INE	NA	NA	U

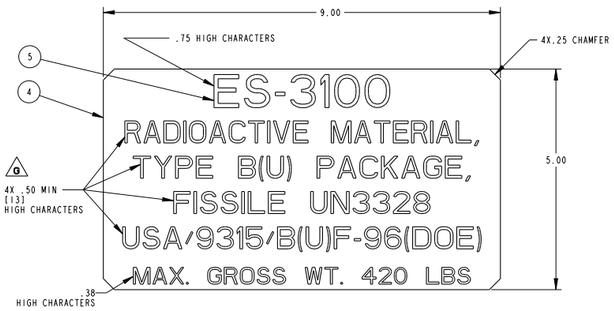
SH.	OF	TYPE			PART	REV
1	1	DD	M2E801580A009		000	D

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-2 ES-3100 DATA PLATE
(FORMED)



-2 ES-3100 DATA PLATE
(FLAT PATTERN)
SCALE 1/1

NOTES

1 DELETED

2 DELETED

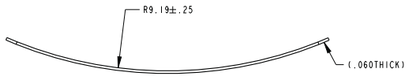
3 DIMENSIONS ARE IN INCHES [mm].

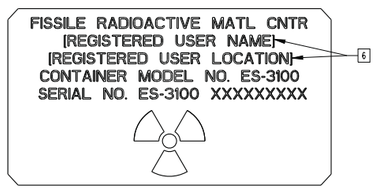
4 CONTAINER SERIAL NUMBER SHOWN "XXXXXXXXX" IS A GENERIC REPRESENTATION. ACTUAL SERIAL NUMBERS SHALL BE SPECIFIED IN PURCHASE ORDER, OR PROCUREMENT CONTRACT.

G 5 ALL CHARACTERS AND SYMBOLS SHALL BE ETCHED, ENGRAVED, OR STAMPED .003-.02 DEEP AND FILLED WITH BLACK ENAMEL PAINT (F/N 5).

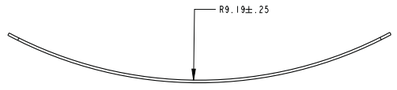
6 SEE PROCUREMENT DOCUMENTS FOR PROPER REGISTERED USER NAME AND LOCATION.

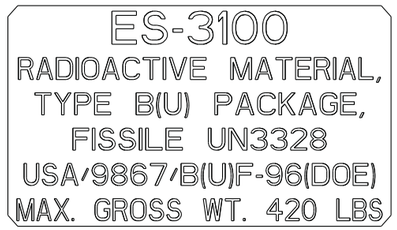
G 7 IDENTIFICATION NUMBERS PRECEDED BY "UN" THAT ARE LESS THAN .47" HIGH AND PERMANENTLY MARKED PRIOR TO JANUARY 1, 2017 MAY REMAIN AT THE CURRENT HEIGHT (49 CFR 172.301).



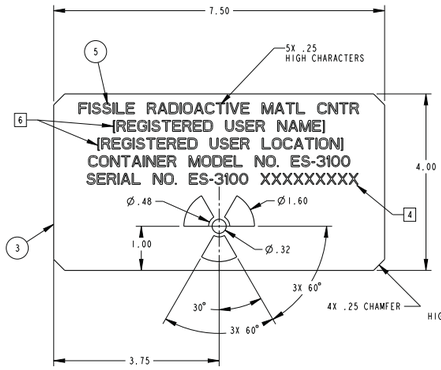


ES-3100 TREFOIL DATA PLATE
(FORMED)

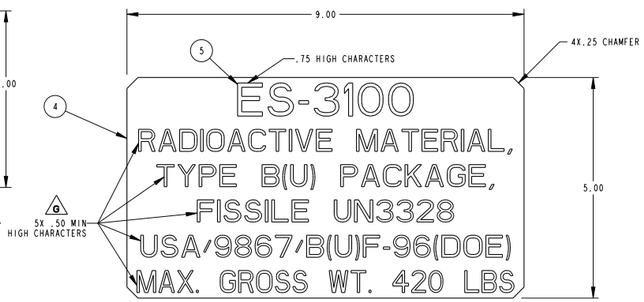




-6 ES-3100 DATA PLATE
(FORMED)



-1 ES-3100 TREFOIL DATA PLATE
(FLAT PATTERN)
SCALE 1/1



-6 ES-3100 DATA PLATE
(FLAT PATTERN)
SCALE 1/1

AR					-6	ES-3100 DATA PLATE			6
		AR	AR	AR	-5	PAINT, BLACK ENAMEL		FED SPEC 595b-17038	5
					-4	16 GA. SHEET	304/304L SST	ASME SA240	4
					-3				3
		AR			-2	ES-3100 DATA PLATE			2
		AR			-1	ES-3100 TREFOIL DATA PLATE			1
2801580-A031	M2E801580	-6	-1	-2	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
					QTY REQ'D NEXT ASSEMBLY	PARTS LIST			

THIS DRAWING IS CONFIGURATION CONTROLLED BY A SAFETY ANALYSIS REPORT FOR PACKAGING (SARP). DRAWING REVISIONS MUST BE APPROVED BY THE PACKAGING ENGINEERING MANAGER.

DATE APPROVAL
James C (J5A) Anderson Digitally signed by James C (J5A) Anderson Date: 2020.02.23 16:09:38 -05'00'

NUCLEAR CRITICALITY SAFETY

THIS DRAWING INCLUDES FEATURES SUPPORTING NUCLEAR CRITICALITY SAFETY.

ANY REVISION TO THIS DRAWING REQUIRES NUCLEAR CRITICALITY SAFETY DIVISION APPROVAL.

UNCLASSIFIED

THIS DOCUMENT HAS BEEN REVIEWED AND CONFIRMED TO BE UNCLASSIFIED.

NAME/DATE
Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2020.02.18 10:06:13 -05'00'
TITLE: Y-12 ENGINEER
ORGANIZATION: Y-12 ENGINEERING

APPROVALS

DES	KW JOHNSON		NCS	AD WILKINSON	
Kevin W (KZH) Johnson	Digitally signed by Kevin W (KZH) Johnson Date: 2020.02.18 14:08:53 -05'00'		Alan D. (WA9) Wilkinson	Digitally signed by Alan D. (WA9) Wilkinson Date: 2020.02.19 08:42:33 -05'00'	
DE	N LANEY				
	Noelani A (NL1) Laney 2020.02.18 10:21:28 -05'00'				
CHKR	GA BYINGTON				
G A (GAB) Byington	Digitally signed by G A (GAB) Byington Date: 2020.02.18 10:13:17 -05'00'				
DVR	LC HOOPER				
Lloyd Hooper	Digitally signed by Lloyd Hooper Date: 2020.02.20 06:14:28 -05'00'				
SE	RD AIGNER				
Roger D (R7A) Aigner	Digitally signed by Roger D (R7A) Aigner Date: 2020.02.18 10:05:58 -05'00'				
DM/PE	JC ANDERSON				
James C (J5A) Anderson	Digitally signed by James C (J5A) Anderson Date: 2020.02.23 16:09:02 -05'00'				

APPROVAL DATE REFER TO DESIGN MANAGER APPROVAL

REVISION DESCRIPTION	NEXT ASSEMBLY/ REFERENCE DOCUMENTS
UPDATED FORMAT. MODIFIED -2 ES-3100 DATA PLATE, -6 ES-3100 DATA PLATE CHARACTER HEIGHT, NOTE 5 AND ADDED NOTE 7.	SEE PARTS LIST

TOLERANCES UNLESS OTHERWISE SPECIFIED

FRACTIONS	±1/16
XX DECIMALS	±.01
XXX DECIMALS	±.005
ANGLES	±0.5°
BREAK SHARP EDGES	.01-.06
FINISH	125 RMS MAX

THIRD ANGLE PROJECTION

I IMPORTANT TO FORM-FIT-FUNCTION
INDEPENDENT VERIFICATION REQUIRED

S IMPORTANT TO SAFETY
SHALL BE 100% INSPECTED AND NOT DEVIATED WITHOUT APPROVAL

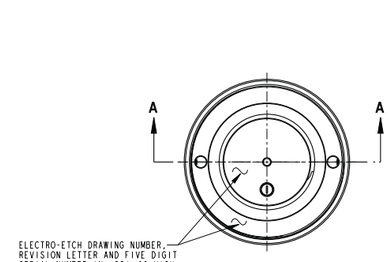
SCALE NOTED
SHEET SIZE REPRESENTATION 1 INCH SQUARE AT FULL SIZE
SCALE PROVIDED FOR REFERENCE ONLY DO NOT SCALE

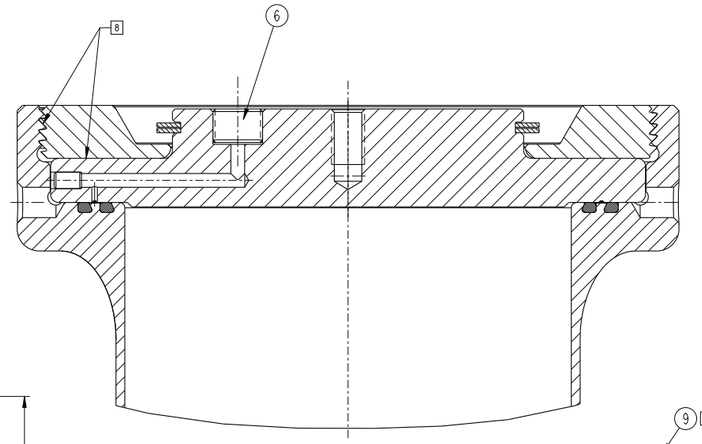
APPROXIMATE WEIGHT N/A
DIMENSIONING AND TOLERANCING ASME Y14.5 - 2009
ALL DIMENSIONS ARE IN INCHES
SOFTWARE CREO 2.0

Y-12 NATIONAL SECURITY COMPLEX
CONSOLIDATED NUCLEAR SECURITY, LLC
P.O. BOX 2009 OAK RIDGE, TN 37831
US GOVERNMENT CONTRACT DE-NA0001942
USERS MUST REFER TO THE TRANSMITTAL DOCUMENTS THAT ACCOMPANIED DELIVERY OF THIS DRAWING FOR ANY APPLICABLE DISCLAIMERS GOVERNING THE DRAWING.

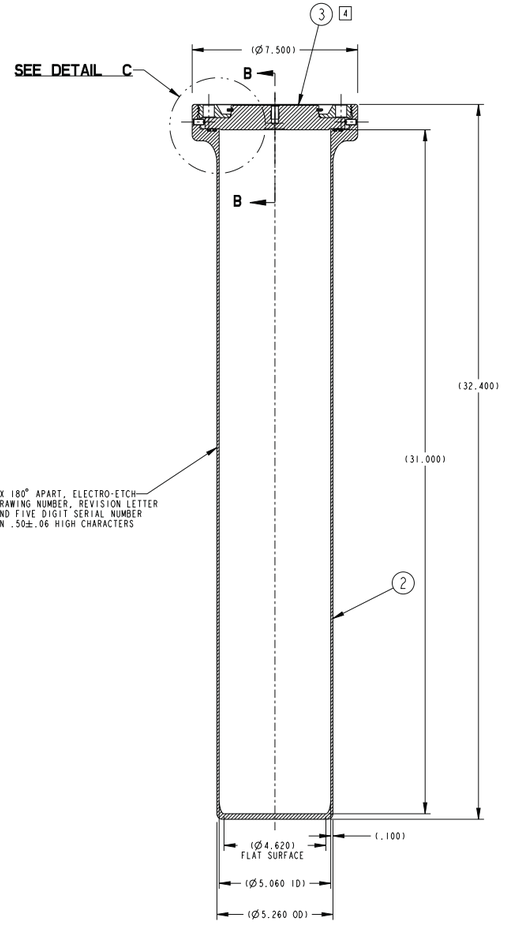
PROJECT ES-3100 SHIPPING PACKAGE
TITLE DATA PLATE DETAILS
DRAWING NUMBER M2E801580A010 PART 000 REV G
ALTERNATE DRAWING NUMBER N/A RECORD NO N/A STATE IF SHEET 1 OF 1

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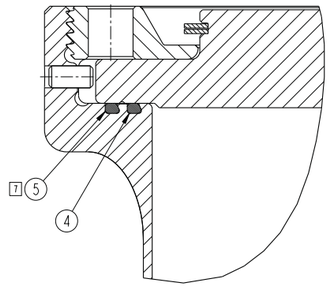




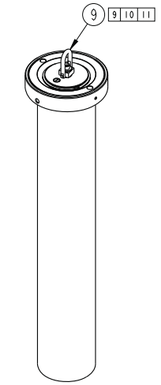
SECTION B-B
SCALE 2/1



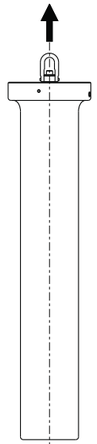
SECTION A-A
SCALE 1/2



DETAIL C
SCALE 2/1



ISOMETRIC VIEW
SCALE 1/4



H 13 LOAD TEST DIAGRAM
SCALE 1/4

-1 CONTAINMENT VESSEL ASSEMBLY

NOTES

1 DELETED

2 DELETED

3 DELETED

4 INSTALL THE LID NUT AND TORQUE TO 120 ±5 FT-LBS AS SHOWN ON M2E801580A020-3 AND A020-4.

5. APPROXIMATE WEIGHT: 32.98 LBS. [14.96 KG].

6. FOR ADDITIONAL REQUIREMENTS SEE EQUIPMENT SPEC. DS-YMN3-801580-A001.

7 DURING INSTALLATION OF O-RINGS APPLY A THIN COAT OF SUPER-O-LUBE.

8 DURING INSTALLATION OF CONTAINER VESSEL LID ASSEMBLY, APPLY A LIGHT COAT OF KRYTOX GREASE TO THE THREADS AND UNDER THE NUT.

9 SWIVEL HOIST RING FOR USE WHEN LOADING AND UNLOADING CONTAINMENT VESSEL ONLY. NOT FOR SHIPMENT.

10 TORQUE SWIVEL HOIST RING TO 12 ±1 FT.LBS. PER MFGR'S SPEC.

11 THE SWIVEL HOIST RING, THREAD LUBRICANT AND O-RING LUBRICANTS ARE REQUIRED AT EACH LOADING AND MAINTENANCE STATION.

12 DELETED

H 13 F/N 1 SHALL BE LOAD TESTED USING F/N 9 SWIVEL HOIST RING AS THE ATTACHMENT POINT. LOAD TEST TO 172±8 LBS.

	AR	3052T56 OR COMPANY APPROVED EQUAL	SWIVEL HOIST RING	ALLOY STEEL	McMASTER- CARR ATLANTA, GA	9
9 10 11	AR	KRYTOX #240AC OR COMPANY APPROVED EQUAL	THREAD LUBRICANT	FLUORINATED GREASE	MILLER-STEPHENSON CHEMICAL CO. DANBURY, CT 06810	8
8 11	AR	SUPER-O-LUBE OR COMPANY APPROVED EQUAL	O-RING LUBRICANT	CLEAR DIMETHYL SILOXANE POLYMER	PARKER HANNIFIN CORP, O-RING DIV,PO BOX 11751 LEXINGTON, KY 40512	7
H 7 11	1	PART # 04-2126 OR COMPANY APPROVED EQUAL	MODIFIED VCO THREADED PLUG	BRASS	VOLUNTEER INDUSTRIAL P. O. BOX 30371 KNOXVILLE, TN 37930 PHONE 865-643-2617	6
	1	M2E801580A013-2	O-RING, OUTER			5
	1	M2E801580A013-1	O-RING, INNER			4
	1	M2E801580A014-1	CONTAINMENT VESSEL LID ASSEMBLY			3
H	1	M2E801580A012-1 OR A012-4 OR COMPANY APPROVED EQUAL	CONTAINMENT VESSEL BODY ASSEMBLY			2
AR	X	-1	CONTAINMENT VESSEL ASSEMBLY			1
M2E801580A011 REV H		PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
		QTY REQ'D NEXT ASSEMBLY	PARTS LIST			

UNCLASSIFIED

THIS DOCUMENT HAS BEEN REVIEWED AND CONFIRMED TO BE UNCLASSIFIED.

NAME/DATE: Roger D (R7A) Aigner — Digitally signed by Roger D (R7A) Aigner Date: 2019.08.28 14:33:57 -04'00'

TITLE: Y-12 ENGINEER

ORGANIZATION: Y-12 ENGINEERING

NUCLEAR CRITICALITY SAFETY

THIS DRAWING INCLUDES FEATURES SUPPORTING NUCLEAR CRITICALITY SAFETY.

ANY REVISION TO THIS DRAWING REQUIRES NUCLEAR CRITICALITY SAFETY DIVISION APPROVAL.

APPROVALS

DES	KW JOHNSON — Kevin W (KZH) Johnson, Digitally signed by Kevin W (KZH) Johnson, Date: 2019.08.28 09:58:13 -04'00'	NCS	AD WILKINSON — Alan D. (WA9) Wilkinson, Digitally signed by Alan D. (WA9) Wilkinson, Date: 2019.08.29 06:59:37 -04'00'
DE	LC HOOPER — Lloyd Hooper, Digitally signed by Lloyd Hooper, Date: 2019.08.27 17:00:54 -04'00'		
CHKR	N LANEY — Noelani A (NL1) Laney, 2019.08.28 10:08:24 -04'00'		
DVR	RD AIGNER — Roger D (R7A) Aigner, Digitally signed by Roger D (R7A) Aigner, Date: 2019.08.29 10:29:29 -04'00'		
SE	RD AIGNER — Roger D (R7A) Aigner, Digitally signed by Roger D (R7A) Aigner, Date: 2019.08.28 14:33:44 -04'00'		
DM/PE	JC ANDERSON — James C (J5A) Anderson, Digitally signed by James C (J5A) Anderson, Date: 2019.08.29 16:12:21 -04'00'		

EFFECTIVE DATE: REFER TO DESIGN MANAGER APPROVAL

REVISION DESCRIPTION	NEXT ASSEMBLY/ REFERENCE DOCUMENTS
REVISED PER EC-801580-0018. ADDED LOAD TEST DIAGRAM AND NOTE 13.	SEE PARTS LIST DS-YMN3-801580-A001

TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS ±.01
XX DECIMALS ±.005
XXX DECIMALS ±0.5°
ANGLES .01-.06
BREAK SHARP EDGES 125 RMS MAX
FINISH
THIRD ANGLE PROJECTION

I IMPORTANT TO FORM-FIT-FUNCTION INDEPENDENT VERIFICATION REQUIRED

S IMPORTANT TO SAFETY SHALL BE 100% INSPECTED AND NOT DEVIATED WITHOUT APPROVAL

SCALE NOTED
SHEET SIZE REPRESENTATION: 1 INCH SQUARE AT FULL SIZE
SCALE PROVIDED FOR REFERENCE ONLY DO NOT SCALE

APPROXIMATE WEIGHT N/A
DIMENSIONING AND TOLERANCING ASME Y14.5M - 1994
ALL DIMENSIONS ARE IN INCHES [mm]
SOFTWARE CREO 2.0

Y-12 NATIONAL SECURITY COMPLEX
CONSOLIDATED NUCLEAR SECURITY, LLC
P.O. BOX 2009 OAK RIDGE, TN 37831
US GOVERNMENT CONTRACT DE-NA0001942

USERS MUST REFER TO THE TRANSMITTAL DOCUMENTS THAT ACCOMPANIED DELIVERY OF THIS DRAWING FOR ANY APPLICABLE DISCLAIMERS GOVERNING THE DRAWING.

PROJECT: ES-3100 SHIPPING PACKAGE
TITLE: CONTAINMENT VESSEL ASSEMBLY
DRAWING NUMBER: M2E801580A011 — PART 000 — REV H
RECORD NO: N/A — STATE IF — SHEET 1 OF 1

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NOTES

1 DELETED

2 DELETED

3 DELETED

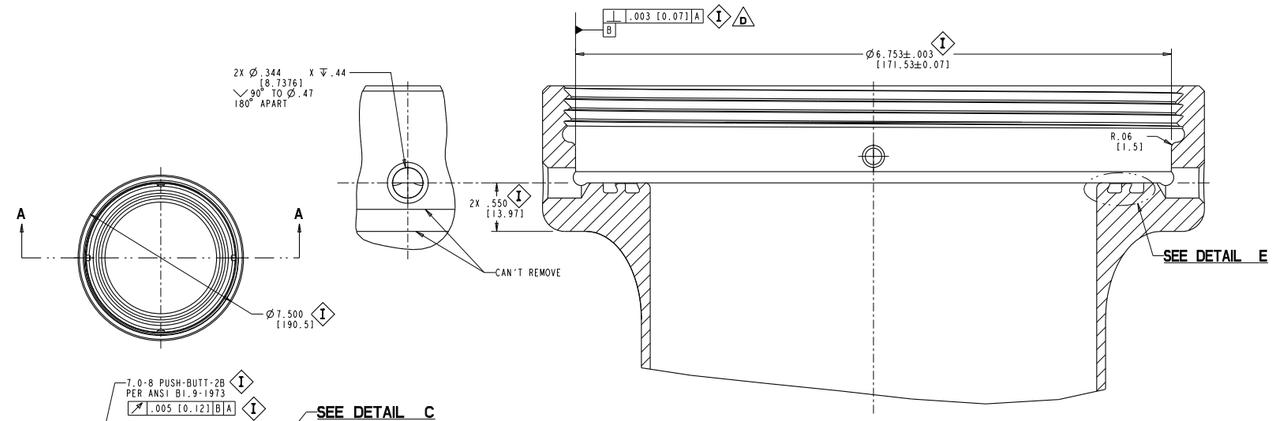
4 APPROXIMATE WEIGHT: 22.44 LBS [10.18 Kg].

5 FOR ADDITIONAL REQUIREMENTS SEE JS-YMN3-801580-A001.

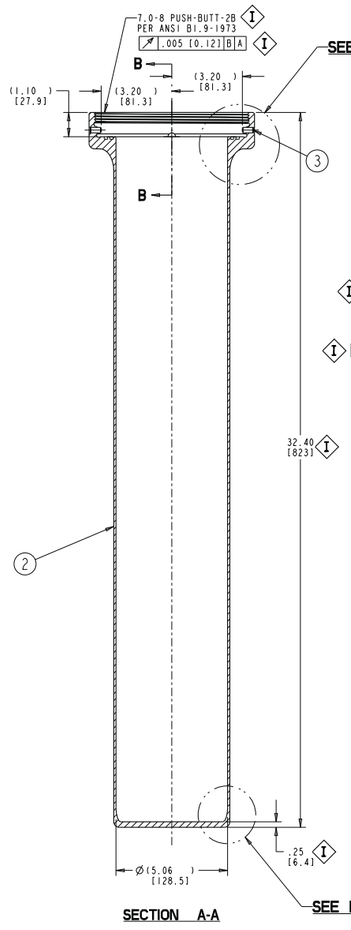
6 DELETED

7 VERIFY THE CONTAINMENT VESSEL INTERNAL DIAMETER BY USING THE MINIMUM CVID GAGE. THE CVID GAGE SHALL BE 10.30±.03 LONG BY 5.020±.001 EXTERNAL DIAMETER WITH A 20° CHAMFER FROM THE CYLINDER TO A 4.52±.03 DIAMETER ON THE BOTTOM. THE BOTTOM SHALL BE FINISHED WITH A .25 THICK YELLOW BRASS PLATE.

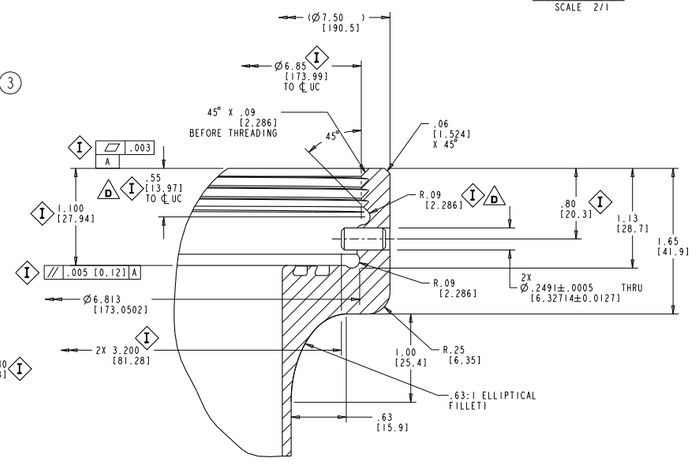
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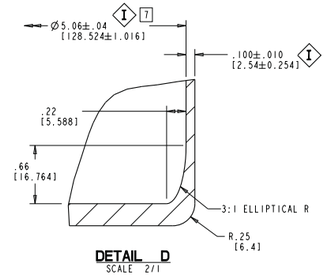
SECTION B-B
SCALE 2/1



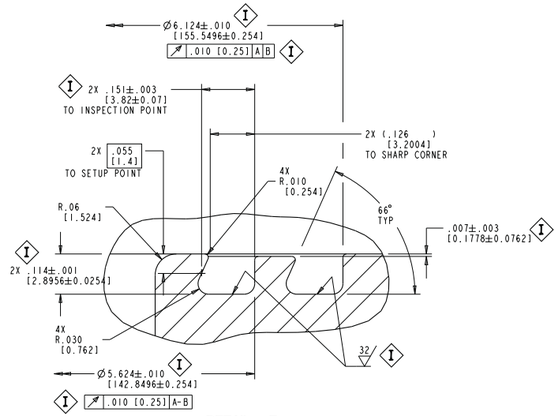
SECTION A-A



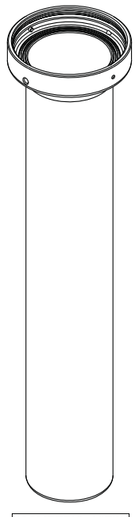
DETAIL C
SCALE 2/1



DETAIL D
SCALE 2/1



DETAIL E
SCALE 8/1



ISOMETRIC VIEW
SCALE 3/8

		1		-7	CONTAINMENT VESSEL END CAP	SST	ASME SA-182 TYPE F304L	7
		1		-6	CV PIPE BODY 5IPS SCH40		ASME SA-312 TYPE TP304L	6
		1		-5	CONTAINMENT VESSEL FLANGE		ASME SA-182 TYPE F304L	5
7	AR	AR	X	-4	CONTAINMENT VESSEL BODY ASSEMBLY WELDED OPTION			4
		2	2	-3	DOWEL PIN, .50 LONG Ø0.2501/0.2503 OD	18-8-SST	ANSI B18.8.2	3
D		1		-2	CONTAINMENT VESSEL FORMED OR MACHINED BODY	304L SST	SEE NOTE 5	2
7	AR	AR	X	-1	CONTAINMENT VESSEL BODY ASSEMBLY			1
M2E801580 A001 / M2E801580	-4	-1	←	PART OR IDENTIFYING NO / QTY REQD / NEXT ASSY	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO

PARTS LIST

-1 CONTAINMENT VESSEL BODY ASSEMBLY

REVISION DESCRIPTION	NEXT ASSEMBLY/ REFERENCE DOCUMENTS
UPDATED FORMAT AND DELETED NOTES 1-3, 6 & 8. REVISED PER EC-801580-0018.	JS-YMN3-801580-A001 SEE PARTS LIST

TOLERANCES UNLESS OTHERWISE SPECIFIED

FRACTIONS	±1/16
XX DECIMALS	±.01
XXX DECIMALS	±.005
ANGLES	±0.5°
BREAK SHARP EDGES	.01/.06
FINISH	125 RMS MAX
THIRD ANGLE PROJECTION	

I IMPORTANT TO FORM-FIT-FUNCTION INDEPENDENT VERIFICATION REQUIRED

S IMPORTANT TO SAFETY SHALL BE 100% INSPECTED AND NOT DEVIATED WITHOUT APPROVAL

SCALE: NOTED
SHEET SIZE REPRESENTATION: I INCH SQUARE AT FULL SIZE
SCALE PROVIDED FOR REFERENCE ONLY DO NOT SCALE

APPROXIMATE WEIGHT: N/A
DIMENSIONING AND TOLERANCING: ASME Y14.5 - 2009
ALL DIMENSIONS ARE IN: INCHES
SOFTWARE: CREO 2.0

NUCLEAR CRITICALITY SAFETY

THIS DRAWING INCLUDES FEATURES SUPPORTING NUCLEAR CRITICALITY SAFETY.

ANY REVISION TO THIS DRAWING REQUIRES NUCLEAR CRITICALITY SAFETY DIVISION APPROVAL.

UNCLASSIFIED

THIS DOCUMENT HAS BEEN REVIEWED AND CONFIRMED TO BE UNCLASSIFIED.

NAME/DATE
Roger D (R7A) Aigner — Digitally signed by Roger D (R7A) Aigner Date: 2019.08.28 14:37:01 -04'00'
TITLE: Y-12 ENGINEER
ORGANIZATION: Y-12 ENGINEERING

Y-12 NATIONAL SECURITY COMPLEX
CONSOLIDATED NUCLEAR SECURITY, LLC
P.O. BOX 2009 OAK RIDGE, TN 37831
US GOVERNMENT CONTRACT: DE-NA0001942
USERS MUST REFER TO THE TRANSMITTAL DOCUMENTS THAT ACCOMPANIED DELIVERY OF THIS DRAWING FOR ANY APPLICABLE DISCLAIMERS GOVERNING THE DRAWING.

APPROVALS

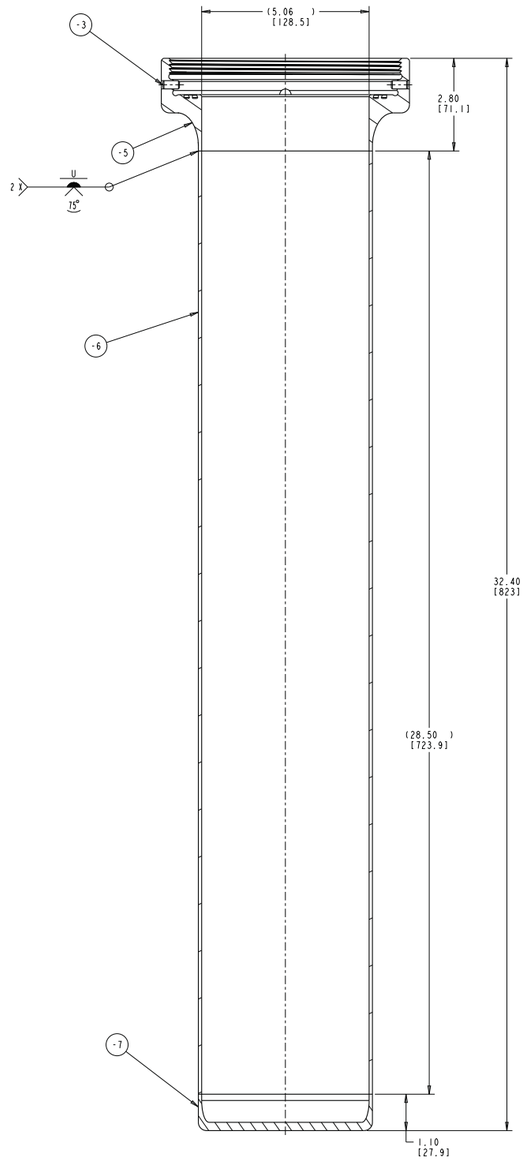
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	Kevin W (KZH) Johnson — Digitally signed by Kevin W (KZH) Johnson Date: 2019.08.28 09:07:23 -04'00'		John W (FJB) Folk — Digitally signed by John W (FJB) Folk Date: 2019.08.28 10:41:26 -04'00'
DE	LC HOOPER	NCS	AD WILKINSON
	Lloyd Hooper — Digitally signed by Lloyd Hooper Date: 2019.08.27 17:07:47 -04'00'		Alan D. (WA9) Wilkinson — Digitally signed by Alan D. (WA9) Wilkinson Date: 2019.08.29 07:02:01 -04'00'
CHKR	N LANEY		
	Noelani A (NL1) Laney 2019.08.28 10:09:43 -04'00'		
DVR	RD AIGNER		
	Roger D (R7A) Aigner — Digitally signed by Roger D (R7A) Aigner Date: 2019.08.29 10:30:13 -04'00'		
SE	RD AIGNER		
	Roger D (R7A) Aigner — Digitally signed by Roger D (R7A) Aigner Date: 2019.08.28 14:36:46 -04'00'		
DM/PE	JC ANDERSON		
	James C (J5A) Anderson — Digitally signed by James C (J5A) Anderson Date: 2019.08.29 16:13:17 -04'00'		

APPROVAL DATE: REFER TO DESIGN MANAGER APPROVAL

PROJECT: ES-3100 SHIPPING PACKAGE
TITLE: CONTAINMENT VESSEL BODY ASSEMBLY
DRAWING NUMBER: M2E801580A012 — PART 000 — REV D
ALTERNATE DRAWING NUMBER: N/A — RECORD NO: N/A — STATE: IF — SHEET: 1 OF 2

M2E801580A012 REV D SHEET 1 OF 2

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-4 CONTAINMENT VESSEL BODY ASSEMBLY WELDED OPTION

SCALE 3/4

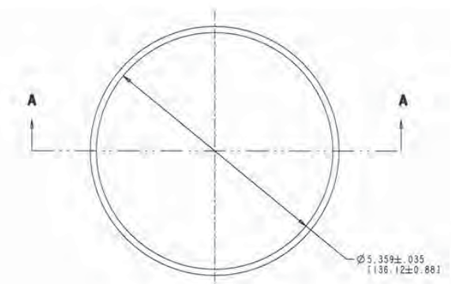
M2E801580A012 REV D
SHEET 2 OF 2

Y-12 NATIONAL SECURITY COMPLEX CONSOLIDATED NUCLEAR SECURITY, LLC P.O. BOX 2009 OAK RIDGE, TN 37831		PROJECT	ES-3100 SHIPPING PACKAGE		
		TITLE	CONTAINMENT VESSEL BODY ASSEMBLY		
US GOVERNMENT CONTRACT		DRAWING NUMBER	M2E801580A012	PART 000	REV D
DE-NA0001942		ALTERNATE DRAWING NUMBER	RECORD NO	STATE	SHEET
USERS MUST REFER TO THE TRANSMITTAL DOCUMENTS THAT ACCOMPANIED DELIVERY OF THIS DRAWING FOR ANY APPLICABLE DISCLAIMERS GOVERNING THE DRAWING.		N/A	N/A	IF	2 OF 2

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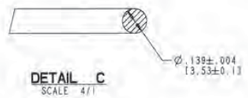
NOTES

1. INTERPRET DRAWING PER MECHANICAL DRAFTING STANDARD ES-3.1.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M-1994.
3. DIMENSIONS ARE IN INCHES.[mm].
4. (D) O-RING SHALL MEET THE REQUIREMENTS SPECIFIED IN EQUIPMENT SPECIFICATION SPC-M801580-0002.

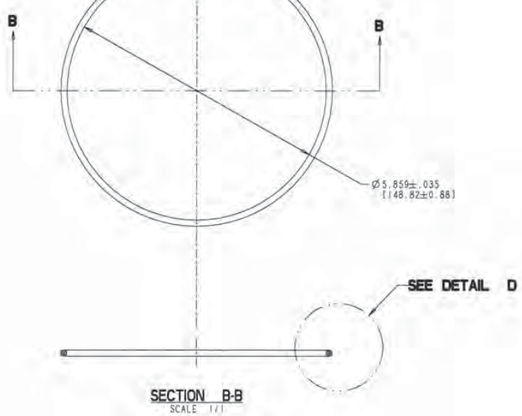


SECTION A-A
SCALE 1/1

-1 INNER O-RING

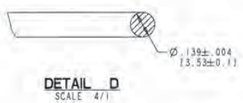


DETAIL C
SCALE 4/1



SECTION B-B
SCALE 1/1

-2 OUTER O-RING



DETAIL D
SCALE 4/1

AR	-2	OUTER O-RING	SEE NOTE 4	2
AR	-1	INNER O-RING		1
PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
← QTY REQ'D NEXT ASSEMBLY	PARTS LIST			

M2E801580A013

THIS DRAWING INCLUDES FEATURES SUPPORTING NUCLEAR CRITICALITY SAFETY. ANY REVISION TO THIS DIAGRAM REQUIRES NUCLEAR CRITICALITY SAFETY ANALYSIS ENGINEERING APPROVAL.

REVISION	DATE	SAE APPROVAL
D	6/5/2012	J.T. DeClue

This document has been reviewed by a Y-12 DC and UCNI RO and has been determined to be UNCLASSIFIED and not UCNI. This review does not constitute clearance for public release.

Name: Drew Date: 6/6/12

THIS DRAWING PRODUCED ON PRO/ENGINEER

THIS DRAWING IS LOANED FOR SOLE USE OF THE INTENDED RECIPIENT AND ONLY FOR THE LIMITED PURPOSES FOR WHICH IT WAS PROVIDED. USE BY OTHER ENTITIES OR FOR OTHER PURPOSES IS PROHIBITED AND AT THE USER'S OWN RISK. DRAWINGS ARE TO BE RETURNED UPON REQUEST OF THE FORWARDING RECIPIENT.

PART	REV	DESCRIPTION / REVISION OR ISSUE PURPOSE	DRW	CHKR	DE	DVR	DM	PE	SE	WE	NCS	OM/SO	AR	CV	ST	NV	EM	FP	PD	EC	IE	M	NP
000	D	RESPECIFIED MATERIAL COMPOSITION AND SPECIFICATION FOR O-RINGS	CDD	JRP	MLG	JRP	JRP	MLE	JRP	MLE	JRP	JRP											
000	C	ADDED REFERENCE NOTE 5.	MLE	JRJ	MLE	JRJ	CMA	8/15/11	LR	8/15/11	CMA	8/15/11											
000	B	GEN REV; -1 WAS 2-253; -2 WAS 2-257;302°F WAS 300°F	JRP	SMM	GAB	RDA	DPS	1/11/05	GAB	2/10/03	JGA	2/10/03											
000	A	ISSUED FOR PROTOTYPE PROCUREMENT	DWS	JSL	GAB	JLH	JCW	10/29/02	MRF	10/29/02	DBM	10/29/02											

SCALE: NOTED	DRW	JRJ/D.W. SPARKS	10/29/03
TOLERANCES UNLESS OTHERWISE SPECIFIED	CHKR	J.S. LOWERY	10/29/03
	DE	GAB	10/29/03
FRACTIONS	DVR	J.L. HICKS	10/29/03
XX DECIMALS ±.01	DN	J.C. WALLS	10/29/03
XXX DECIMALS ±.005	PE	M.R. FELDMAN	10/29/03
ANGLES ±0.5°	SE		
BREAK SHARP EDGES ,06 MAX	OM/SO	D.B. MILLER	10/29/03
FINISH: 125 RMS	WE	N/R	

Y-12 National Security Complex managed by B & W Technical Services Y-12, LLC for the Department of Energy under U.S. Government contract DE-AC-05-00OR22800 • Oak Ridge, Tennessee •

PROJECT NAME: ES-3100 SHIPPING PACKAGE

CONTAINMENT VESSEL O-RING DETAILS

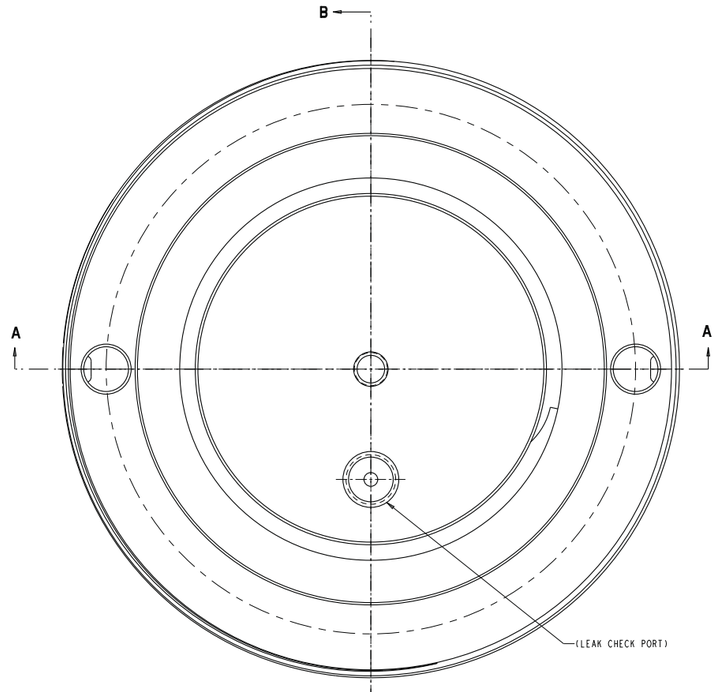
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G	M	L	F	CM	PKG	IN/E	NA	NA	U

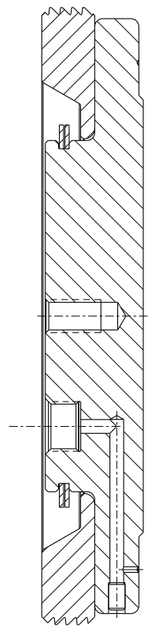
SH	OF	TYPE	PART	REV
1	1	DD	M2E801580A013	000	D

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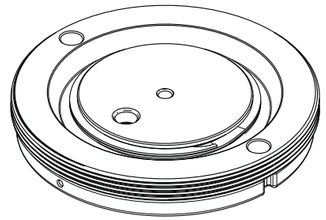
NOTES

1. DELETED
2. DELETED
3. DIMENSIONS ARE IN INCHES [mm].
4. APPROXIMATE WEIGHT: 10.54 LBS [4.78 Kg].
5. FOR ADDITIONAL REQUIREMENTS SEE JS-YMN3-801580-A001.
6. CHECK FOR PROPER CV SEALING BY THREADING EACH CLOSURE NUT (M2E801580A016-1) INTO CV BODY ASSEMBLY (M2E801580A012-1 OR A012-4) WITH RING GAGE (DD-M801580-0015-1) IN PLACE OF SEALING LID (M2E801580A015-1). THE RING GAGE SHALL BE VERIFIED TO NOT BE FREE TO MOVE, AND GAPS BETWEEN THE RING GAGE AND THE CLOSURE NUT AND BETWEEN THE RING GAGE AND THE CV BODY ARE LESS THAN .005 USING A FEELER GAGE.

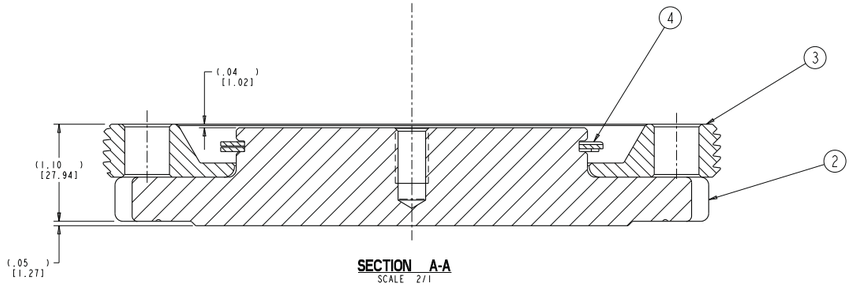




SECTION B-B



ISOMETRIC VIEW
SCALE 1/1



SECTION A-A
SCALE 2/1

-1 CONTAINMENT VESSEL LID ASSEMBLY

		1	WSM-400-S02	EXTERNAL RETAINING RING	SMALLEY STEEL RING CO. 385 GILMAN AVE. WHEELING, IL 60090	4
		1	M2E801580A016-1	CONTAINMENT VESSEL CLOSURE NUT		3
		1	M2E801580A015-1	CONTAINMENT VESSEL SEALING LID		2
AR	AR	X	-1	CONTAINMENT VESSEL LID ASSEMBLY		1
M2E801580 A023-2	M2E801580 -1		PART OR IDENTIFYING NO QTY REQD NEXT ASSY	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPECIFICATION	FIND NO

PARTS LIST

M2E801580A014 REV C SHEET 1 OF 1

UNCLASSIFIED
THIS DOCUMENT HAS BEEN REVIEWED AND CONFIRMED TO BE UNCLASSIFIED.

NAME/DATE
Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2019.08.28 14:40:46 -04'00'
TITLE: Y-12 ENGINEER
ORGANIZATION: Y-12 ENGINEERING

NUCLEAR CRITICALITY SAFETY
THIS DRAWING INCLUDES FEATURES SUPPORTING NUCLEAR CRITICALITY SAFETY.
ANY REVISION TO THIS DRAWING REQUIRES NUCLEAR CRITICALITY SAFETY DIVISION APPROVAL.

APPROVALS

DES	KW JOHNSON	NCS	AD WILKINSON
	Kevin W (KZH) Johnson Digitally signed by Kevin W (KZH) Johnson Date: 2019.08.28 09:06:10 -04'00'		Alan D. (WA9) Wilkinson Digitally signed by Alan D. (WA9) Wilkinson Date: 2019.08.29 07:03:06 -04'00'
DE	LC HOOPER		
	Lloyd Hooper Digitally signed by Lloyd Hooper Date: 2019.08.27 17:02:22 -04'00'		
CHKR	IN LANEY		
	Noelani A (NL1) Laney 2019.08.28 10:11:06 -04'00'		
DVR	RD AIGNER		
	Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2019.08.29 10:30:59 -04'00'		
SE	RD AIGNER		
	Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2019.08.28 14:40:25 -04'00'		
DM/PE	JC ANDERSON		
	James C (J5A) Anderson Digitally signed by James C (J5A) Anderson Date: 2019.08.29 16:36:49 -04'00'		

APPROVAL DATE: REFER TO DESIGN MANAGER APPROVAL

REVISION DESCRIPTION	NEXT ASSEMBLY/ REFERENCE DOCUMENTS
UPDATED FORMAT, DELETED NOTES 1 & 2 AND ADDED NOTE 6. REVISED PER EC-801580-0018.	JS-YMN3-801580-A001 SEE PARTS LIST

TOLERANCES UNLESS OTHERWISE SPECIFIED

FRACTIONS	N/A
XX DECIMALS	N/A
XXX DECIMALS	N/A
ANGLES	N/A
BREAK SHARP EDGES	N/A
FINISH	N/A

THIRD ANGLE PROJECTION

(I) IMPORTANT TO FORM-FIT-FUNCTION INDEPENDENT VERIFICATION REQUIRED

(S) IMPORTANT TO SAFETY SHALL BE 100% INSPECTED AND NOT DEVIATED WITHOUT APPROVAL

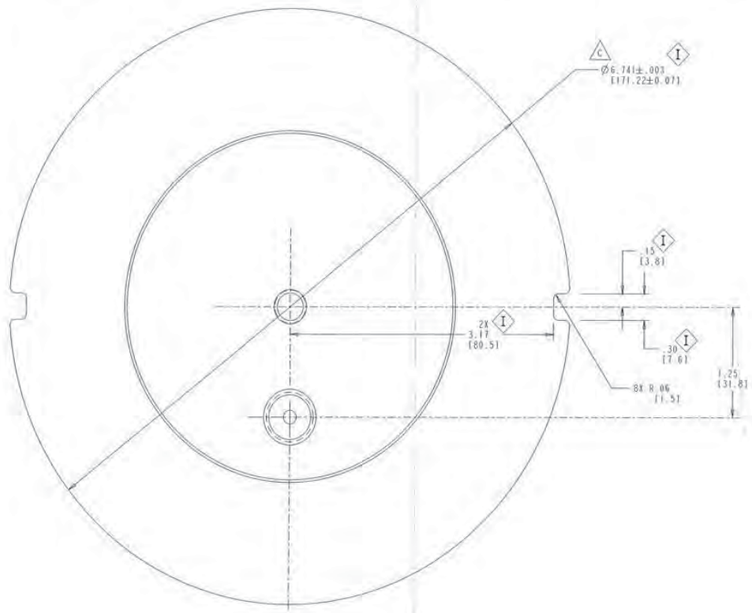
SCALE: NOTED
SHEET SIZE REPRESENTATION: 1 INCH SQUARE AT FULL SIZE
SCALE PROVIDED FOR REFERENCE ONLY DO NOT SCALE

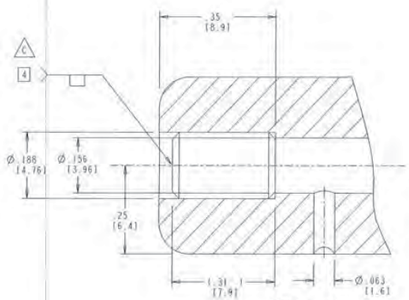
APPROXIMATE WEIGHT: N/A
DIMENSIONING AND TOLERANCING: ASME Y14.5 - 2009
ALL DIMENSIONS ARE IN: INCHES
SOFTWARE: CREO 2.0

Y-12 NATIONAL SECURITY COMPLEX
CONSOLIDATED NUCLEAR SECURITY, LLC
P.O. BOX 2009 OAK RIDGE, TN 37831
US GOVERNMENT CONTRACT: DE-NA0001942
USERS MUST REFER TO THE TRANSMITTAL DOCUMENTS THAT ACCOMPANIED DELIVERY OF THIS DRAWING FOR ANY APPLICABLE DISCLAIMERS GOVERNING THE DRAWING.

PROJECT: ES-3100 SHIPPING PACKAGE
TITLE: CONTAINMENT VESSEL LID ASSEMBLY
DRAWING NUMBER: M2E801580A014 | PART: 000 | REV: C
ALTERNATE DRAWING NUMBER: N/A | RECORD NO: N/A | STATE: IF | SHEET: 1 OF 1

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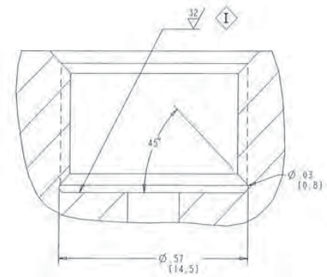




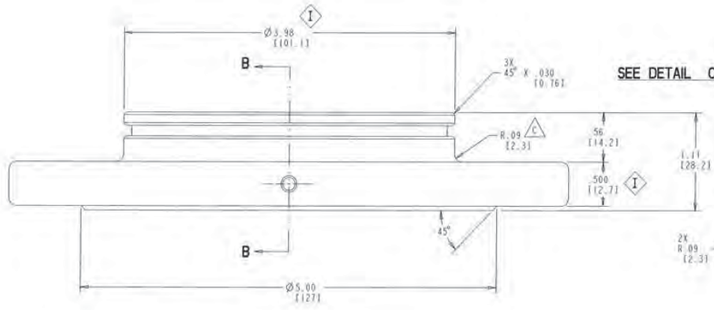
DETAIL C
SCALE 8/1

NOTES

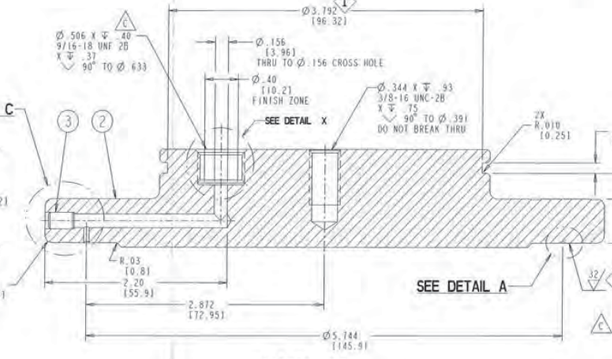
1. INTERPRET DRAWING PER ENGINEERING DRAFTING STANDARD ES-3.1.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M-1994. PERFECT ORIENTATION AT MMC FOR INTERRELATED FEATURES REQUIRED
3. DIMENSIONS ARE IN INCHES [mm].
4. WELD BAR (F/N 3) TO CONTAINER LID (F/N 2) BEFORE FINAL MACHINING.
5. FOR ADDITIONAL REQUIREMENTS SEE IS-YMN3-80(580-A001.
6. DIMENSIONS OR FEATURES FLAGGED BY A Ⓘ SYMBOL SHALL BE INSPECTED AND DOCUMENTED.



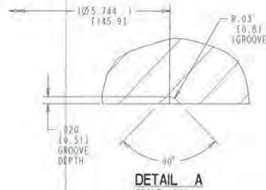
DETAIL X
SCALE 8/1



-1 CONTAINMENT VESSEL SEALING LID
SCALE 2/1



SECTION B-B



DETAIL A
SCALE 8/1

AR	-4	WELD FILLER METAL	PER WELD PROCEDURES		4
1	-3	BAR - Ø3/16 X .31 LONG	SST 304	ASME SA-479	3
1	-2	CONTAINMENT LID			2
AR	-1	CONTAINMENT VESSEL SEALING LID			1
WORK ORDER QUALITY	PART OR IDENTIFYING NO ← QTY REQD NEXT ASSY	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO

PARTS LIST

THIS DRAWING INCLUDES FEATURES SUPPORTING NUCLEAR CRITICALITY SAFETY. ANY REVISION TO THIS DIAGRAM REQUIRES NUCLEAR CRITICALITY SAFETY DIVISION APPROVAL

REVISION	DATE	NCSD APPROVAL
C	02/10/05	

This document has been reviewed by a Y-12 ADC and UCNI RO and has been determined to be UNCLASSIFIED and not UCNI. This review does not constitute clearance for public release.

Name: Date: 2/10/05

REV	DESCRIPTION	DRW	CHKR	DE	DVR	DM	DATE	PE	DATE	PM	DATE	ME	DATE
C	MOVED Ø6.741 DIM TO ZONE H6; ZONE D6. ADDED DIM R.09, ZONE D5 CHANGED DIM .38 TO .37, ADDED DET X MOVED 32 FINISH SYM X Ⓒ Ⓘ FROM SEC B-B	GAB	RA	GAB	JLH	JCW	02/04/05	GAB	02/04/05	GAB	02/04/05	GAB	02/04/05
B	REDUCED ORING FINISH ANN LEAKCHECK DEPTH	DWS	JSL	GAB	JLH	JCW	02/01/05	MRF	02/03/05	DBM	02/03/05		
A	ISSUED FOR PROTOTYPE PROCUREMENT												

REVISION OR ISSUE PURPOSE | REVISION APPROVALS | SQUAD CHECK

	AR	CV	ST	MV	EM	FP	PD	EE	IE	M	NP
DATE											

DRAWING APPROVALS

SCALE:	NOTED
TOLERANCES: UNLESS OTHERWISE SPECIFIED	
FRACTIONS	
XX DECIMALS ±.01	
XXX DECIMALS ±.005	
ANGLES ±0.5°	
BREAK SHARP EDGES .06 MAX	
FINISH 125 RMS	

DRW	RJ for B.W. SPARKS	10/29/03
CHKR	J.S. LOWERY	10/29/03
DE	G.A. BYINGTON	10/29/03
DVR	J.L. HECK	10/29/03
DM	J.C. WALLS	10/29/03
PE	M.R. FELDMAN	10/29/03
PM	D.B. MILLER	10/29/03

BWXT Y-12

Y-12 National Security Complex managed by BWXT Y-12, L.L.C. for the Department of Energy under U.S. Government contract DE-AC05-00OR22800 in Oak Ridge, Tennessee

PROJECT NAME
ES-3100 SHIPPING PACKAGE

CONTAINMENT VESSEL SEALING LID

I	AG	AR	SS	PLANT	BLDG	FL	SM	OP	TYPE	CLASS
6	M	L	F	Y-12	NA	NA	I	I	S	U

SI	SZ	SS		REV
CM	PKG	IN	M2E801580A015	C

THIS DRAWING PRODUCED ON PRO/ENGINEER

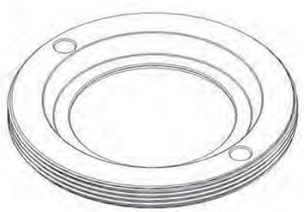
M2E801580A015

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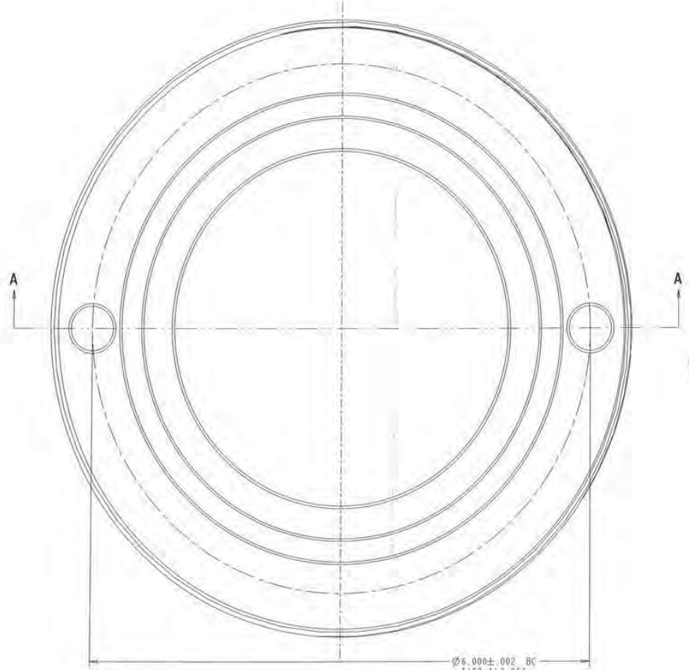
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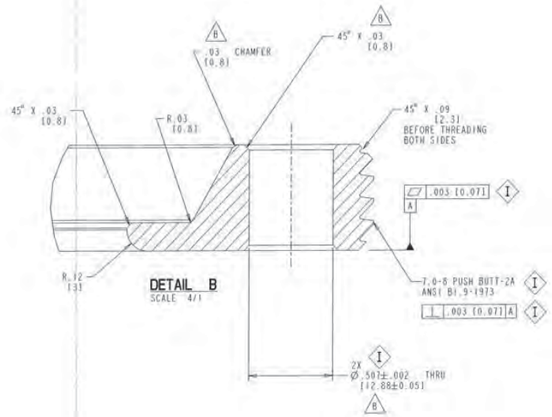
NOTES

1. INTERPRET DRAWING PER ENGINEERING DRAFTING STANDARD ES-3.1.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M-1994. PERFECT ORIENTATION AT MMC FOR INTERRELATED FEATURES REQUIRED.
3. DIMENSIONS ARE IN INCHES [mm].
4. FOR ADDITIONAL REQUIREMENTS SEE JS-YMN3-801580-A001. (C)
5. DIMENSIONS AND FEATURES FLAGGED BY A (I) SYMBOL SHALL BE INSPECTED AND DOCUMENTED.1

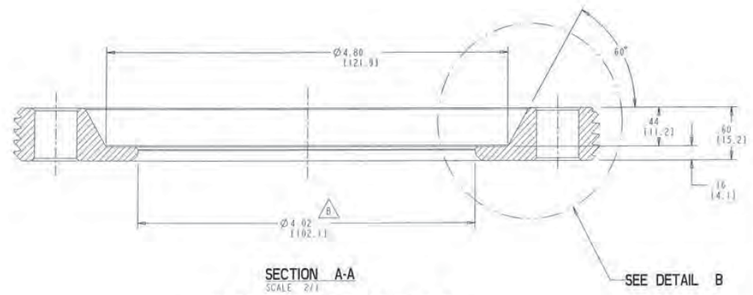


ISOMETRIC VIEW
SCALE 1/1





DETAIL B
SCALE 4/1



SECTION A-A
SCALE 2/1

SEE DETAIL B

-1 CONTAINMENT VESSEL CLOSURE NUT

AR	AB	( )	CONTAINMENT VESSEL CLOSURE NUT	NITRONIC 60 SST	ASME SA-479 UNS-S21800	1
		PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
		← QTY REQD NEXT ASSY	PARTS LIST			

THIS DRAWING INCLUDES FEATURES SUPPORTING NUCLEAR CRITICALITY SAFETY. ANY REVISION TO THIS DIAGRAM REQUIRES NUCLEAR CRITICALITY SAFETY DIVISION APPROVAL.

REVISION	DATE	NCSD APPROVAL
B	02/10/05	J.T. DeVine

This document has been reviewed by a Y-12 ADC and UCNI RO and has been determined to be UNCLASSIFIED and not UCNI. This review does not constitute clearance for public release.

Name: Date: 2/10/05

BWXT Y-12 National Security Complex, managed by BWXT Y-12, L.L.C. for the Department of Energy under U.S. Government contract DE-AC05-00OR22800 at Oak Ridge, Tennessee

REV	DESCRIPTION	DWN	CHKR	DE	DVR	DM	DATE	PE	DATE	PM	DATE	AR	CV	ST	HV	EM	FP	PD	EE	IE	M	NP
B	ADDED CHAMFER IN DETAIL B; MOD. HOLE TOL REMOVED NOTE 4; RENUMBERED NOTES IN GEN NOTES	RP	SPARKS	2310	DES	Mar	2/10/05	DWS	2/10/05	JSL	2/10/05											
A	ISSUED FOR PROTOTYPE PROCUREMENT	GAB	JLH	JCW	BJN	MRF	10/29/03	DWS	10/29/03	JSL	10/29/03											

REVISION OR ISSUE PURPOSE — REVISION APPROVALS — SQUAD CHECK — DRAWING APPROVALS

SCALE	NOTED
TOLERANCES UNLESS OTHERWISE SPECIFIED	
FRACTIONS	
XX DECIMALS	± .01
XXX DECIMALS	± .005
ANGLES	±0.5°
BREAK SHARP EDGES	.06 MAX
FINISH	125 RMS

DWN	JBJ for B.R. SPARKS	10/29/03	
CHKR	J.S. LOWERY	10/29/03	
DE	G.A. BYINGTON	10/29/03	
DVR	J.L. HECK	10/29/03	
DM	J.C. WALLS	10/29/03	
PE	M.R. FELDMAN	10/29/03	
PM	D.B. MILLER	10/29/03	

PROJECT NAME
ES-3100 SHIPPING PACKAGE

CONTAINMENT VESSEL CLOSURE NUT

1	40	49	50	PLANT	BLDG	FL	SH. OF	TYPE	CLASS
6	M	L	F	Y-12	NA	NA	1	I	S	U

51	52	53		REV
CM	PKG	IN	M2E801580A016	B

M2E801580A016

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P THIS DRAWING PRODUCED ON PRO/ENGINEER

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NOTES

1 DELETED

2 DELETED

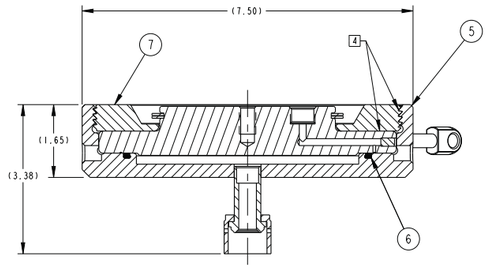
3 DELETED

4 APPLY A LIGHT COAT OF THREAD LUBRICANT, F/N 8, TO THREADS OF CLOSURE NUT, F/N 7; AND ON SURFACES BETWEEN CLOSURE NUT, F/N 3 AND TEST FLANGE, F/N 2.

5 APPLY A LIGHT COAT OF THREAD LUBRICANT, F/N 8, TO THREADS OF CONTAINMENT VESSEL LID ASSEMBLY, F/N 7; AND ON SURFACES BETWEEN CONTAINMENT VESSEL LID TEST FLANGE, F/N 5 AND CONTAINMENT VESSEL LID ASSEMBLY, F/N 7.

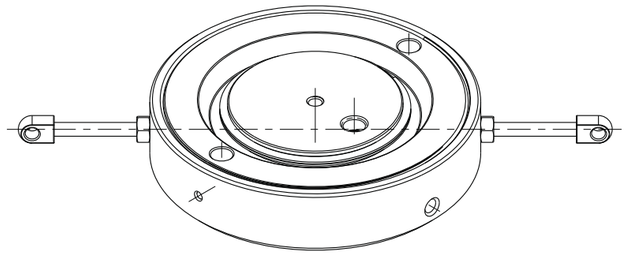
6 APPLY A LIGHT COAT OF SUPER O-LUBE, F/N 9, TO SURFACE OF INNER O-RING, F/N 6.

7 FOR ADDITIONAL REQUIREMENTS SEE EQUIPMENT SPECIFICATION JS-YMN3-801580-A001



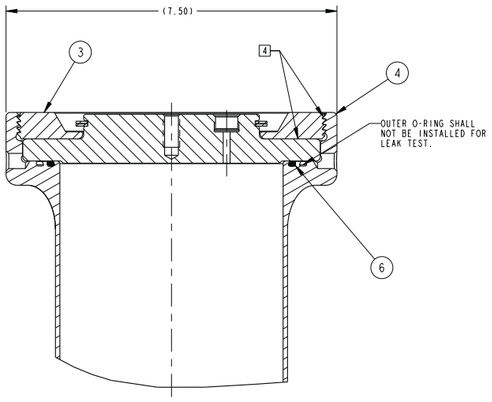
-2 CONTAINMENT VESSEL LID LEAK TEST ASSEMBLY

SCALE: 1/1



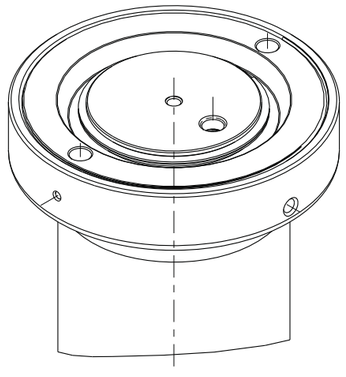
ISO VIEW

SCALE 1/1



-1 CONTAINMENT VESSEL BODY LEAK TEST ASSEMBLY

SCALE: 1/1



ISO VIEW

SCALE 1/1

	AR	AR	-9	SUPER O-LUBE	CLEAR DIMETHYL SILOXANE POLYMER	PARKER HANNIFIN O-RING DIVISION 2360 PALUMBO DR. LEXINGTON, KY	9
6	AR	AR	KRYTOX ® 240 AC	THREAD LUBRICANT	FLUORINATED GREASE	MILLER-STEPHENSON CHEMICAL CO. DANBURY, CT 068101	8
4 5	1		M2E801580A014-1	CONTAINMENT VESSEL LID ASSEMBLY			7
E 6	1		M2E801580A013-1	INNER O-RING			6
	1		M2E801580A022-1	CONTAINMENT VESSEL LID TEST FLANGE			5
		1	M2E801580A012-1 OR A012-4	CONTAINMENT VESSEL BODY ASSEMBLY			4
		1	M2E801580A021-1	CONTAINMENT VESSEL BODY TEST FLANGE ASSEMBLY			3
			-2	CONTAINMENT VESSEL LID LEAK TEST ASSEMBLY			2
			-1	CONTAINMENT VESSEL BODY LEAK TEST ASSEMBLY			1
-2	-1		PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
		←	QTY REQ'D NEXT ASSEMBLY	PARTS LIST			

UNCLASSIFIED

THIS DOCUMENT HAS BEEN REVIEWED AND CONFIRMED TO BE UNCLASSIFIED.

NAME/DATE: This document has been reviewed and confirmed to be UNCLASSIFIED. Digitally signed by Stan (TSW) Thomas DN: c=US, o=U.S. Government, ou=Department of Energy, ou=Y-12 National Security Complex, ou=Classification Management, cn=Stan (TSW) Thomas Date: 2016.07.18 15:46:01 -04'00'

Stan (TSW) Thomas

TITLE: Y-12 ENGINEER

ORGANIZATION: Y-12 ENGINEERING

APPROVALS

DES	KW JOHNSON Kevin W (KZH) Johnson	
DE	GA BYINGTON G A (GAB) Byington	
CHKR	L ROBERSON Larry (LRN) Roberson	
DVR	ML GOINS Monty L (MLG) Goins	
DM/PE	JC ANDERSON James C (JSA) Anderson	
PM	JG ARBITAL Jeffrey G (AJJ) Arbital	

EFFECTIVE DATE: REFER TO DESIGN MANAGER APPROVAL

REVISION DESCRIPTION	NEXT ASSEMBLY/ REFERENCE DOCUMENTS
UPDATED FORMAT, DELETED VITON OPTION IN F/N 6 AND DELETED NOTES 1-3.	N/A

TOLERANCES UNLESS OTHERWISE SPECIFIED

FRACTIONS ±.01
XX DECIMALS ±.005
XXX DECIMALS ±.005
ANGLES ±0.5°
BREAK SHARP EDGES .01-.06
FINISH 125 RMS MAX
THIRD ANGLE PROJECTION

I IMPORTANT TO FORM-FIT-FUNCTION INDEPENDENT VERIFICATION REQUIRED

S IMPORTANT TO SAFETY SHALL BE 100% INSPECTED AND NOT DEVIATED WITHOUT APPROVAL

SCALE: NOTED

SHEET SIZE REPRESENTATION: 1 INCH SQUARE AT FULL SIZE

SCALE PROVIDED FOR REFERENCE ONLY DO NOT SCALE

APPROXIMATE WEIGHT: N/A

DIMENSIONING AND TOLERANCING: ASME Y14.5M - 1994

ALL DIMENSIONS ARE IN: INCHES

SOFTWARE: CREO 2.0

Y-12 NATIONAL SECURITY COMPLEX
CONSOLIDATED NUCLEAR SECURITY, LLC
P.O. BOX 2009 OAK RIDGE, TN 37831

US GOVERNMENT CONTRACT: DE-NA0001942

USERS MUST REFER TO THE TRANSMITTAL DOCUMENTS THAT ACCOMPANIED DELIVERY OF THIS DRAWING FOR ANY APPLICABLE DISCLAIMERS GOVERNING THE DRAWING.

PROJECT: ES-3100 SHIPPING CONTAINER

TITLE: CONTAINMENT VESSEL LEAK TEST ASSEMBLIES

DRAWING NUMBER: M2E801580A023 PART 000 REV E

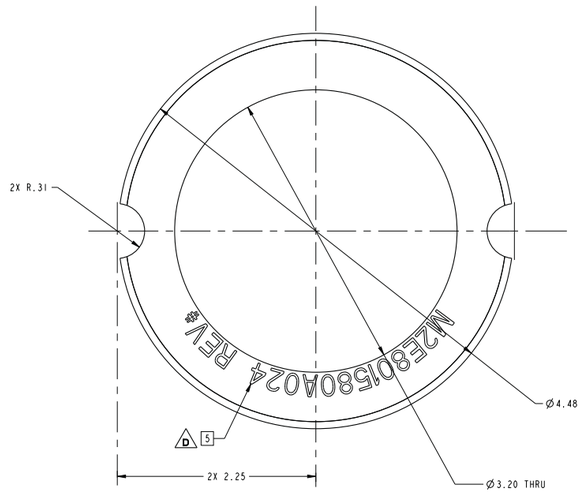
RECORD NO: N/A STATE IF SHEET 1 OF 1

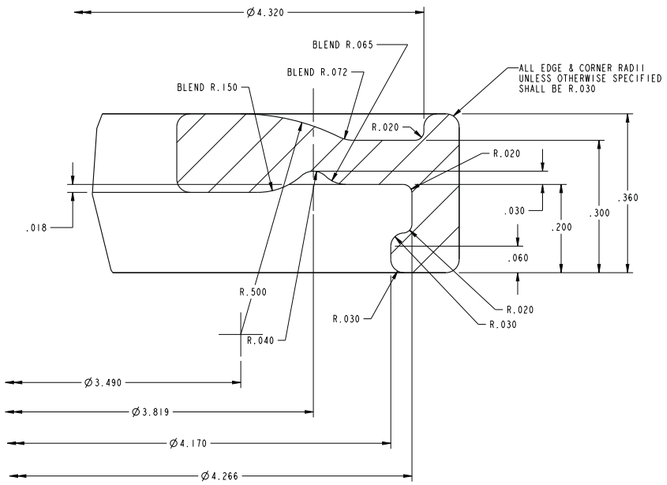
M2E801580A023 REV E SHEET 1 OF 1

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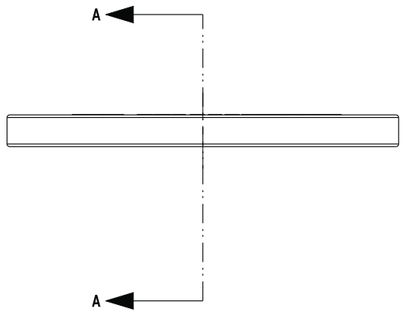
NOTES

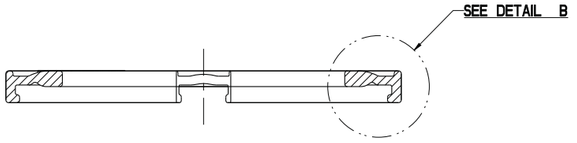
1. DELETED
2. DELETED
3. DELETED
4. MANUFACTURER/SUPPLIER TO PROVIDE CERTIFICATE OF COMPLIANCE FOR ALL FEATURES OF THESE ITEMS.
5. IN APPROXIMATE LOCATION SHOWN, ENGRAVE DRAWING NUMBER AND REVISION LETTER IN 1/4" HIGH CHARACTERS IN THE MOLD TO MAKE A LEGIBLE RAISED MARKING IN THE PART.
6. FOR ADDITIONAL INFORMATION SEE EQUIPMENT DATA SHEET DS-801580-0002.
7. FOR REFERENCE ONLY: WEIGHT: 0.0535 LBS [24.3 g]





DETAIL B
SCALE 10/1





SECTION A-A

4 6	AR	AR	AR	AR		CONTAINMENT VESSEL VIBRATION ABSORBING SILICONE 4.25" CAN PAD	CONTAINMENT VESSEL VIBRATION ABSORBING SILICONE 4.25" CAN PAD	SILICONE RUBBER A50-83B, SILICA FILLED, LOW HYDROGEN AND LOW VOLATILE VAPORS, POST CURED HARDNESS 75+/- 5 SHORE A	SEE NOTE 6	1
	PART OR IDENTIFYING NO					NOMENCLATURE OR DESCRIPTION		MATERIAL	SPECIFICATION	FIND NO
M2E801580 A024	M2E801580 A023	M2E801580 A026	M2E801580 A025	-1	← QTY REQ'D NEXT ASSEMBLY	PARTS LIST				

M2E801580A024-1
CONTAINMENT VESSEL VIBRATION ABSORBING SILICONE 4.25 CAN PAD
SCALE 2/1

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NAME/DATE
Roger D (R7A) Aigner — Digitally signed by Roger D (R7A) Aigner Date: 2019.06.13 07:31:44 -04'00'
TITLE: Y-12 ENGINEER
ORGANIZATION: Y-12 ENGINEERING

APPROVALS

DES	KW JOHNSON	NCS	AD WILKINSON
Kevin W (KZH) Johnson	Digitally signed by Kevin W (KZH) Johnson Date: 2019.06.12 13:29:41 -04'00'	Alan D. (WA9) Wilkinson	Digitally signed by Alan D. (WA9) Wilkinson Date: 2019.06.13 13:19:00 -04'00'
DE	GA BYINGTON		
G A (GAB) Byington	Digitally signed by G A (GAB) Byington Date: 2019.06.13 08:34:16 -04'00'		
CHKR	LC HOOPER		
Lloyd Hooper	Digitally signed by Lloyd Hooper Date: 2019.07.10 08:06:11 -04'00'		
DVR	ML ENSLEY		
Michael L (MER) Ensley	Digitally signed by Michael L (MER) Ensley Date: 2019.07.11 13:41:03 -04'00'		
SE	RD AIGNER		
Roger D (R7A) Aigner	Digitally signed by Roger D (R7A) Aigner Date: 2019.06.13 07:32:17 -04'00'		
DM/PE	JC ANDERSON		
James C (J5A) Anderson	Digitally signed by James C (J5A) Anderson Date: 2019.07.17 10:45:58 -04'00'		

APPROVAL DATE: REFER TO DESIGN MANAGER APPROVAL

REVISION DESCRIPTION	NEXT ASSEMBLY/ REFERENCE DOCUMENTS
UPDATED FORMAT, REVISION PER EC-801580-0017	SEE PARTS LIST SEE NOTE 6

UNLESS OTHERWISE SPECIFIED

FRACTIONS	±1/16
XX DECIMALS	±.01
XXX DECIMALS	±.005
ANGLES	±0.5°
BREAK SHARP EDGES	.01-.06
FINISH	125 RMS MAX
THIRD ANGLE PROJECTION	

I — IMPORTANT TO FORM-FIT-FUNCTION INDEPENDENT VERIFICATION REQUIRED

S — IMPORTANT TO SAFETY SHALL BE 100% INSPECTED AND NOT DEVIATED WITHOUT APPROVAL

SCALE: NOTED
SHEET SIZE REPRESENTATION: 1 INCH SQUARE AT FULL SIZE
SCALE PROVIDED FOR REFERENCE ONLY DO NOT SCALE

APPROXIMATE WEIGHT: N/A
DIMENSIONING AND TOLERANCING: ASME Y14.5 - 2009
ALL DIMENSIONS ARE IN: INCHES
SOFTWARE: CREO 2.0

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P.O. BOX 2009 OAK RIDGE, TN 37831
US GOVERNMENT CONTRACT: DE-NA0001942
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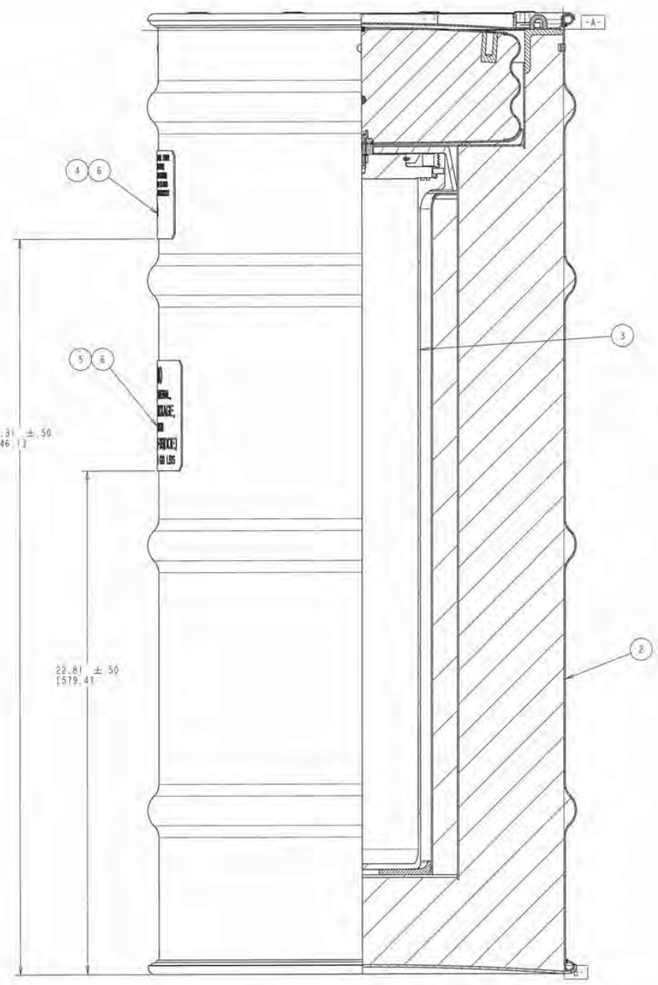
PROJECT: ES-3100 SHIPPING PACKAGE
TITLE: CONTAINMENT VESSEL VIBRATION ABSORBING SILICONE 4.25 CAN PAD
DRAWING NUMBER: M2E801580A024 — PART: 000 — REV: D
ALTERNATE DRAWING NUMBER: N/A — RECORD NO: N/A — STATE: IF — SHEET: 1 OF 1

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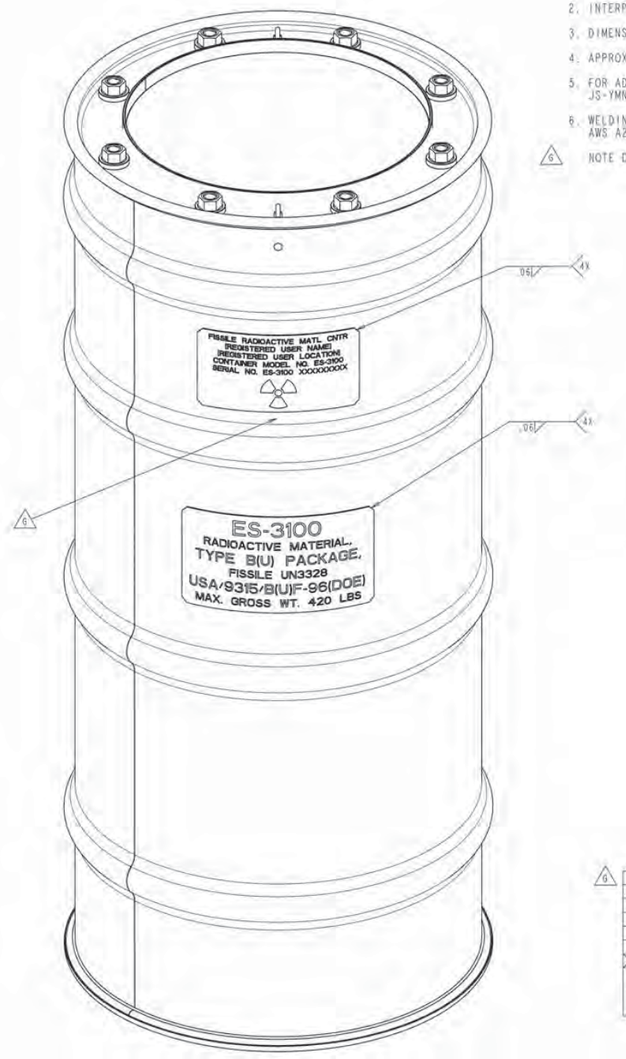
NOTES

1. INTERPRET DRAWING PER MECHANICAL DRAFTING STANDARD ES-3.1.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M-1994.
3. DIMENSIONS ARE IN INCHES [mm].
4. APPROXIMATE WEIGHT: 323.8 LBS [146.9 Kg]
5. FOR ADDITIONAL REQUIREMENTS SEE EQUIPMENT SPECIFICATION JS-YMN3-801580-A002.
6. WELDING SYMBOLS SHALL BE INTERPRETED IN ACCORDANCE WITH AWS A2.4.

G NOTE DELETED



-1 MAIN ASSEMBLY
SCALE 1/2



ISOMETRIC VIEW
SCALE 1/2

AR	-6	WELD FILLER METAL			6
1	M2E801580A010-2	ES-3100 DATA PLATE			5
1	M2E801580A010-1	ES-3100 TREFOIL DATA PLATE			4
1	M2E801580A011-1	CONTAINMENT VESSEL ASSEMBLY			3
1	M2E801580A001-1	DRUM ASSEMBLY			2
	-1	MAIN ASSEMBLY			1
QTY. REQ'D NEXT ASSEMBLY	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO

PARTS LIST

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REVISION	DATE	SAE APPROVAL
G	6/11/15	

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Name: John Thomas Date: 06/11/15

C THIS DRAWING PRODUCED ON CREO PARAMETRIC

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PART	REV	DESCRIPTION	DRW	CHKR	QE	DVR	DM	DATE
000	G	REMOVED TEMPERATURE LABEL F/N 7 AND DELETED NOTE 7; UPDATED FORMAT	KJS	MG	GAB	MG	SCA	6/11/15
000	F	ADDED NOTE 7. ALONG WITH F/N 7 TO PARTS LIST AND DRAWING FIELD	CDB	DEW	MLG	DEW	TNN	6/11/15
000	E	REVISED ES-3100 DATA PLATE.	MLE	JRJ	MLE	DEW	TNN	6/11/15
000	D	REVISED TREFOIL DATA PLATE	JRJ	RDA	LLR	GAB	TNN	6/11/15
000	C	REVISED TREFOIL DATA PLATE	JRJ	RDA	JLR	GAB	TNN	6/11/15
000	B	GEN REV;CHG. NOTE 4;ADDED NOTES 5 & 6; CHG. F/N 6 WAS BLIND RIVIT;WEIGHTS & VOLS IN NOTE 10 UPDATED TO REFLECT NEW MAT'L.	JRJ	PSM	GAB	RDA	DPS	6/11/15
000	A		JRJ	JSL	GAB	JLH	JCW	6/11/15

REVISION OR ISSUE PURPOSE | REVISION APPROVALS | SQUAD CHECK

SCALE:	NOTED
TOLERANCES UNLESS OTHERWISE SPECIFIED:	
FRACTIONS	
XX DECIMALS	±.01
XXX DECIMALS	±.005
ANGLES	±0.5°
FINISH	125 RMS
BREAK SHARP EDGES	.06 MAX

DRAWING APPROVALS		
DRW	J.R. JACKSON	10/29/03
CHKR	J.S. LOWERY	10/29/03
DC	G.A. BYINGTON	10/29/03
DVR	J.L. HECK	10/29/03
DM	J.C. WALLS	10/29/03
PE	M.R. FELDMAN	10/29/03
SE		
QM/SD	D.B. MILLER	10/29/03
MC	N/R	

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PROJECT NAME: ES-3100 SHIPPING PACKAGE

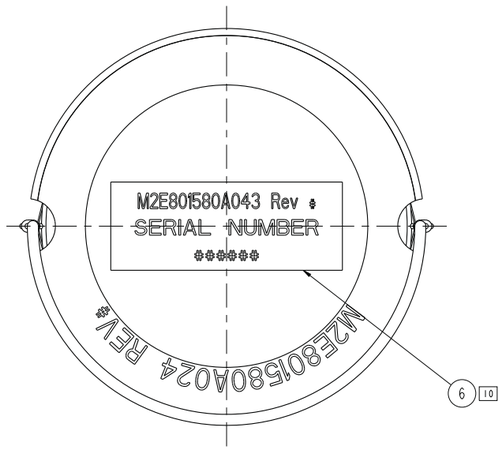
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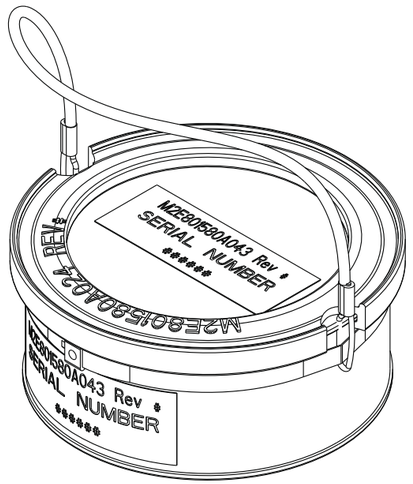
DRE	RISK	DT	DC	COM	SYSTEM	STABILITY	ALOG	YL	CLASS
6	M	L	F	CM	PKG	I N	E	NA	U

SH.	OF	TYPE	PART	REV
1	1	DD	M2E801580A031	000 G

M2E801580A031

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ISOMETRIC VIEW
SCALE 2/1

NOTES

1 DELETED

2 DELETED

3 DELETED

C 4 FOR FURTHER INFORMATION, SEE EQUIPMENT SPECIFICATION SPC-M801580-0004.

5 FOR PURCHASE OF F/N 8, SEE DOCUMENT #DS-YMN3-801580-A001.

6 USE THE BAND-IT TIE-LOCK II HAND TOOL "A920" TO ATTACH THE STAINLESS STEEL BANDS AND CABLE ASSEMBLIES TO THE MATERIAL CANS. THE TOOL'S TENSION SETTING SHALL BE SET BETWEEN 4 AND 8.

7 REFERENCE DOCUMENT #DAC-YMN3-801580-A001.

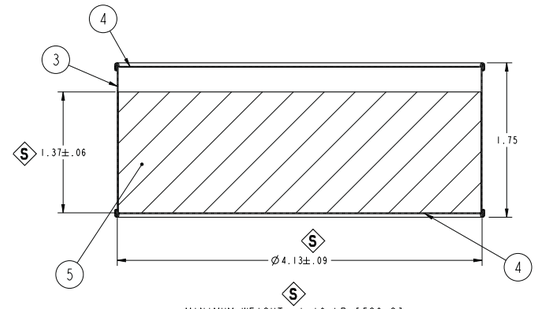
8 FOR REFERENCE ONLY FIND NO 1; NOMINAL WEIGHT: 1.38 LBS [0.626 KG]

9 DELETED

10 MARK WITH PERMANENT LABELS F/N 6 DRAWING NUMBER, REVISION LETTER AND SIX DIGIT SERIAL NUMBER IN .18±.03 HIGH CHARACTERS.

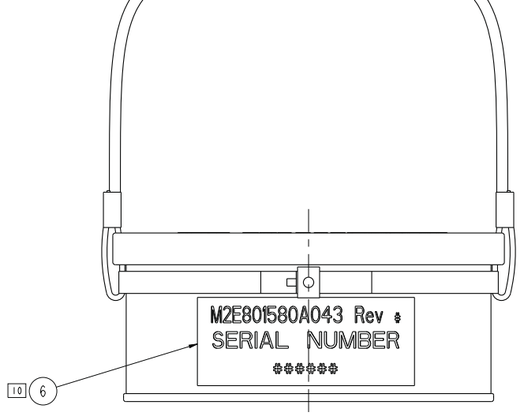
11 SUPPLIED BY COMPANY.

12 FOR SHIPMENTS, THE USE OF VIBRATION PAD, FIND NO.9 WITH HEAVY CAN SPACER, IS OPTIONAL.

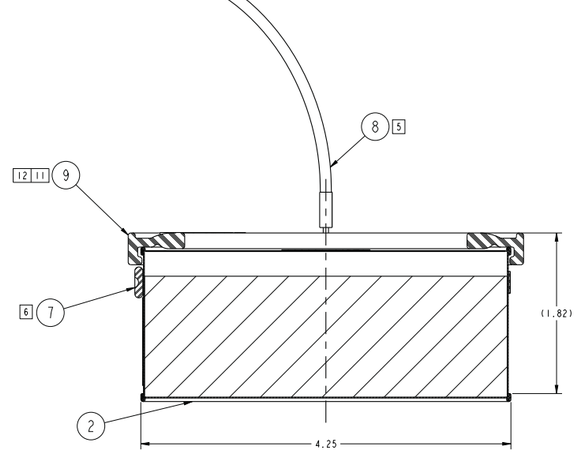


MINIMUM WEIGHT: 1.16 LB [526 G]
MAXIMUM WEIGHT: 1.56 LB [707 G]

-2 FILLED CAN
SCALE 2/1



-1 HEAVY CAN SPACER ASSEMBLY (SST)
SCALE 2/1



12 | 11		AR	M2E801580A024-1	VIBRATION ABSORBING SILICONE 4.25" CAN PAD			9
5		1	-8	CABLE LANYARD	REFERENCE NOTE 5		8
6		1	AS213	BAND CLAMP	304 SST	BAND-IT-IDEX, INC. DENVER, CO 80216	7
10		2	WL-OL875WJ OR EQUAL	2.625" BY 1" VINYL COATED WEATHERPROOF WHITE PRINTER LABELS		WORLDLABEL.COM 336 CONVENT AVE,STE 2A NEW YORK NY 10031 SALES (866) 226-8869	6
C 4	AR		-5	277-4 FILLER		SPC-M801580-0004	5
	2		-4	CAN END COVER	304/304L STAINLESS STEEL 30 GA. (0.012)	ASTM A240	4
	1		-3	CAN BODY			3
		1	-2	FILLED CAN			2
			-1	HEAVY CAN SPACER ASSEMBLY (SST)			1
-2	-1		PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
← QTY REQ'D NEXT ASSEMBLY			PARTS LIST				

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NAME/DATE Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2020.01.22 15:44:23 -05'00'
TITLE: PKG ENGR
ORGANIZATION: PACKAGING

APPROVALS

DES	KW JOHNSON	WCS	AD WILKINSON
	Kevin W (KZH) Johnson Digitally signed by Kevin W (KZH) Johnson Date: 2019.10.24 13:48:33 -04'00'		Alan D. (WA9) Wilkinson Digitally signed by Alan D. (WA9) Wilkinson Date: 2019.10.25 08:13:45 -04'00'
DE	GA BYINGTON		
	G A (GAB) Byington Digitally signed by G A (GAB) Byington Date: 2019.10.24 13:36:20 -04'00'		
CHKR	N LANEY		
	Noelani A (NL1) Laney 2019.10.24 16:04:02 -04'00'		
DVR	RD AIGNER		
	Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2020.01.22 15:44:42 -05'00'		
SE	N/A		
DM/PE	JC ANDERSON		
	James C (J5A) Anderson Digitally signed by James C (J5A) Anderson Date: 2020.01.22 16:59:34 -05'00'		

APPROVAL DATE REFER TO DESIGN MANAGER APPROVAL

REVISION DESCRIPTION	NEXT ASSEMBLY/ REFERENCE DOCUMENTS
UPDATED FORMAT. REVISED PER EC-801580-0020.	N/A

TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS ±.01
XX DECIMALS ±.005
XXX DECIMALS ±0.5"
ANGLES 01-06
BREAK SHARP EDGES 125 RMS MAX
FINISH
THIRD ANGLE PROJECTION

I IMPORTANT TO FORM-FIT-FUNCTION INDEPENDENT VERIFICATION REQUIRED

S IMPORTANT TO SAFETY SHALL BE 100% INSPECTED AND NOT DEVIATED WITHOUT APPROVAL

SCALE NOTED
SHEET SIZE REPRESENTATION 1 INCH SQUARE AT FULL SIZE
SCALE PROVIDED FOR REFERENCE ONLY DO NOT SCALE

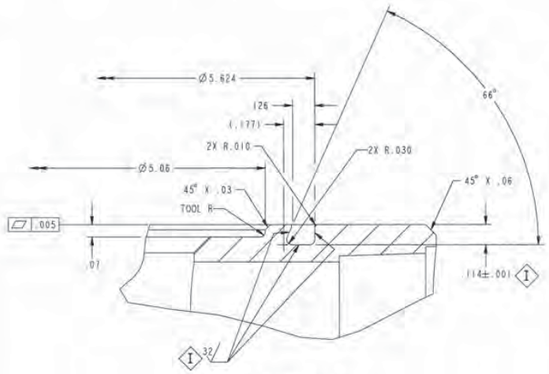
APPROXIMATE WEIGHT N/A
DIMENSIONING AND TOLERANCING ASME Y14.5M - 1994
ALL DIMENSIONS ARE IN INCHES
SOFTWARE CREO 2.0

Y-12 NATIONAL SECURITY COMPLEX
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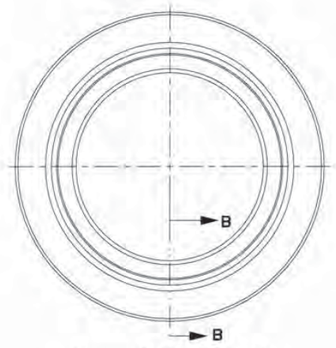
PROJECT ES-3100 SHIPPING PACKAGE
TITLE HEAVY CAN SPACER ASSEMBLY (SST)
DRAWING NUMBER M2E801580A043 PART 000 REV C
ALTERNATE DRAWING NUMBER N/A RECORD NO N/A STATE IF SHEET 1 OF 1

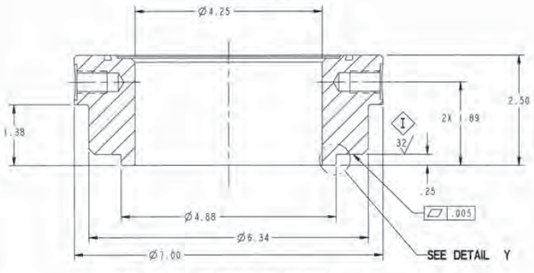
M2E801580A043 REV C SHEET 1 OF 1

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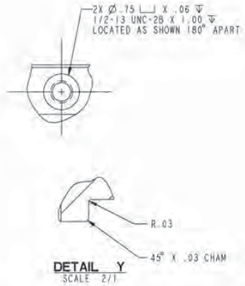


DETAIL X
SCALE 4/1

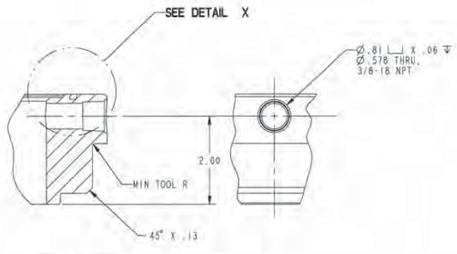




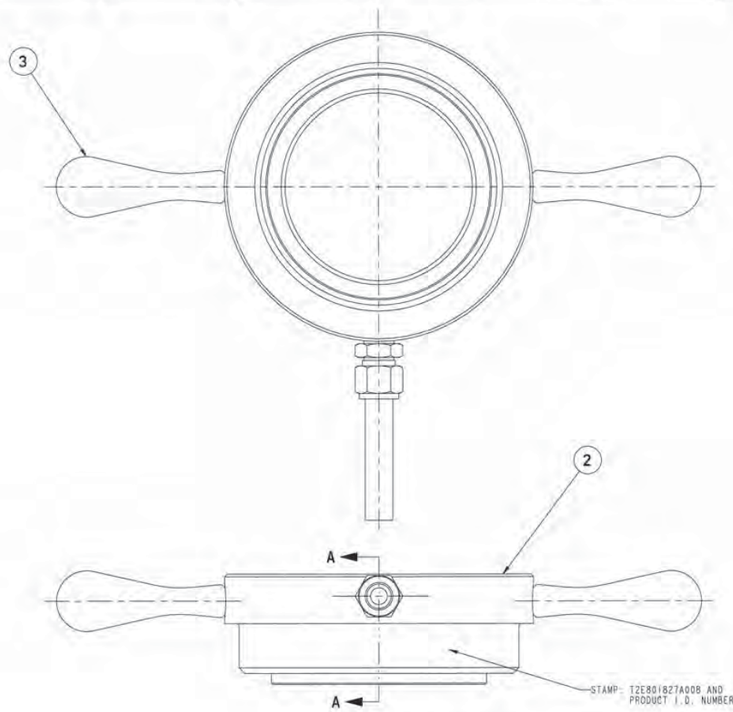
-2 LEAK CHECK FLANGE
SCALE 1/1



DETAIL Y
SCALE 2/1

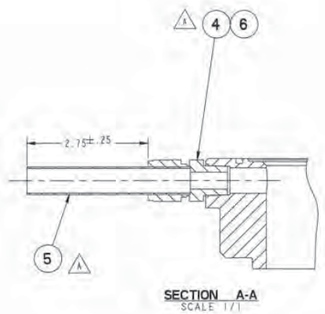


SECTION B-B
SCALE 1/1



-1 LEAK CHECK FLANGE ASSEMBLY
SCALE 1/1

NOTES
1. INTERPRET DRAWING PER MECHANICAL DRAFTING STANDARD ES-3.1.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M - 1994.
3. DIMENSIONS ARE IN INCHES.
4. DIMENSIONS OR FEATURES FLAGGED BY ① SHALL BE INDEPENDENTLY VERIFIED.



SECTION A-A
SCALE 1/1

A		AR	-6	TEFLON PIPE TAPE		6
A		1	-5	5/8 OD X .035 WALL OR 5/8 OD X .060 WALL TUBE	304 S.S. OR 316 S.S.	ASTM A269	5
A		1	SS-1010-1-6	MALE CONNECTOR	316 S.S.	SWAGELOK COMPANY	4
		2	TH-7	MACHINE HANDLE	STEEL	REID TOOL SUPPLY CO MUSKEGON, MI 49444	3
		1	-2	LEAK CHECK FLANGE	304 S.S.		2
AR	AR	X	-1	LEAK CHECK FLANGE ASSEMBLY			1
M2E801893 M2E801827 A008-1		1	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
A			← NEXT ASSEMBLY	PARTS LIST			

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Name: Date: 6/28/07

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P THIS DRAWING PRODUCED ON PRO/ENGINEER

REV	DESCRIPTION	DRW	CHKR	DE	OVR	DN	DATE	PE	DATE	SE	DATE	MC	DATE	OM/SD	DATE
A	ADDED M2E801893A028-1, ADDED F/N 4, F/N 5 AND F/N 6 TO PARTS LIST	MG	LR												
0	ORIGINAL ISSUE, RN Y2003-0328	GAB	EL	RDA	LEG			JL		MDW					

REVISION OR ISSUE PURPOSE | REVISION APPROVALS

AR	CV	ST	HV	EN	FP	PD	EE	IE	M	NP

SQUAD CHECK

SCALE: NOTED	DRW	McTEER/JOHNSON 4/12/06
TOLERANCES UNLESS OTHERWISE SPECIFIED	CHKR	GA BYINGTON 4-18-06
	DE	E LOZYNIAK 4-18-06
FRACTIONS	OVR	RD AIGNER 4-18-06
XX DECIMALS ±.01	DM	LE GALYON 4-18-06
XXX DECIMALS ±.005	PE	JACK LAFFERTY 4-18-06
ANGLES ±0.5°	SE	MD WALDROP 4-18-06
BREAK SHARP EDGES .06 MAX	QM/SD	NR
FINISH 125 RMS		

DRAWING APPROVALS | DATE

PROJECT NAME: TOOLING

LEAK CHECK FLANGE ASSEMBLY

1	48	49	50	PLANT	BLDG	FL	SH	OF	TYPE	CLASS
2	M	U	D	Y-12			1	1	S	U

51	52	53
NC	TOOL	IN

T2E801827A008 REV A

T2E801827A008

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Appendix 1.3.8
Pyrophoricity of Uranium Metal

Prepared by: Russell W. Schmidt
BWXT Y-12
November 2006
Revised June 2007

Reviewed by: Sanford G. Bloom
BWXT Y-12
November 2006
Re-reviewed June 2007

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Appendix 1.3.8
Pyrophoricity of Uranium Metal

I. Introduction

The ES-3100 is a new shipping container designed for safe and efficient transportation of highly enriched uranium in a wide range of material forms. The ES-3100 has been certified for use with a variety of contents, including enriched uranium metal and alloy. However, the current size limitations on uranium contents in the form of broken metal are unnecessarily restrictive. The size limits exist because under certain conditions uranium metal and some uranium alloys are pyrophoric – they have the potential to spontaneously ignite. The size restrictions are intended to eliminate the possibility of spontaneous ignition during transport.

The purpose of this analysis is to evaluate the potential for uranium metal pieces to spontaneously ignite under the conditions expected for shipment in the ES-3100 shipping container, and to identify limits on the uranium metal content that will prevent spontaneous ignition during transport, while still allowing a high degree of flexibility and utility.

It is important to remember that the content limits developed for the ES-3100 must be implemented in the field. Therefore the criteria derived from this evaluation must be simple, robust, and readily applied in all of the facilities using this package.

This evaluation does not include new laboratory tests of uranium metal ignition parameters. Such tests have been performed and well documented in the past. This evaluation draws on the extensive body of existing data and proven storage and transport practice to identify the bounds within which uranium metal and alloys can be safely transported in the ES-3100 shipping container.

II. Proposed Definition of Pyrophoricity

The Certificate of Compliance (CoC), gives the definition of broken metal in Paragraph 5(b)(1)(ii), as follows:

> *For metal or alloy defined as broken metal, mass limits are specified in Table 2. Uranium metal and alloy pieces must have a surface-area-to-mass ratio of not greater than 1 cm²/g or must have a mass not less than 50 g, whichever is most restrictive. Powders, foils, turnings, wires, and incidental small particles are not permitted, unless they are restricted to not more than 1 percent by weight of the content per convenience can, and they are either in a sealed, inerted container or are stabilized to an oxide prior to shipment.*

It is suggested that the definition of broken metal in Paragraph 5(b)(1)(ii) be revised to the following:

> *For metal and alloy defined as broken metal, mass limits are specified in Table 2. Uranium metal and alloy pieces must have a surface-area-to-mass ratio of not greater than 1 cm²/g or must not pass freely through a 3/8-inch (0.0095 m) mesh sieve. Particles and small shapes that do not pass this size restriction, as well as powders, foils, turnings, and wires, are not permitted, unless they are either in a sealed container under an inert cover gas.*

III. Rational for Proposed Changes

The proposed text makes the following changes:

- The 50 g minimum piece size is eliminated.
- A 3/8-in. mesh limit is added.
- The phrase "whichever is most restrictive" is deleted.
- Remove oxidation as a treatment for pyrophoric uranium, in this context.
- The 1% limit on inerted material is eliminated.

The 1-cm^2/g maximum specific surface area limit is the most significant limit in the original text, and that limit is retained unchanged. Specific surface area is the most significant parameter in determining if a given piece of uranium is at risk of spontaneous ignition under a given set of conditions, and therefore it is appropriate that this restriction should control any other restrictions to the package contents. The discussion section below will demonstrate that the 1 cm^2/g maximum allowable specific surface area is adequate to prevent spontaneous ignition in the ES-3100.

The 50-g minimum piece size is overly restrictive and is inconsistent with the 1-cm^2/g upper limit on specific surface area. Smooth uranium metal pieces can have a mass of less than 0.5 g and still have a specific surface area less than 1 cm^2/g (see Example 1). This makes the 50-g limit two orders of magnitude too large. The 50-g limit is nearly an order of magnitude too large even considering metal pieces with the rough surface of broken metal instead of a smooth cast or polished surface.

Example 1.
Consider a smooth uranium metal sphere with a diameter of 0.32 cm (0.126 in.).
The radius of the sphere is 0.16 cm. The density of uranium metal is 19 g/cm^3.

The volume is	$V = (4 / 3) \times Pi \times r^3 = (4 / 3) \times Pi \times (0.16)^3 = 0.01716\ cm^3$
The mass is	$M = Density \times V = 19\ g/cm^3 \times 0.01716\ cm^3 = 0.3260\ g$
The surface area is	$A = 4 \times Pi \times r^2 = 4 \times Pi \times (0.16)^2 = 0.3217\ cm^2$
The specific surface area is	$SA = A / M = 0.3217\ cm^2 / 0.3260\ g = 0.9868\ cm^2/g$

This specific surface area is just within the 1 cm^2/g upper limit.

If instead of a smooth surface the sphere has a rough surface characteristic of broken uranium metal, a larger size is needed to ensure that the 1 cm^2/g limit is maintained. For a roughness factor of three (meaning that the rough surface has an actual surface area that is three times the surface area calculated from the radius), the radius would need to be three times the above example to give the same specific area. In this case:
$r = 3 \times 0.16\ cm = 0.48\ cm$; $V = (4 / 3) \times Pi \times (0.48)^3 = 0.463\ cm^3$;
$M = 19\ g/cm^3 \times 0.463\ cm^3 = 8.802\ g$; $A = 4 \times Pi \times (0.48)^2 \times 3$ (roughness factor) $= 8.686\ cm^2$
And so the specific surface area is $8.686\ cm^2 / 8.802\ g = 0.9868\ cm^2/g$ as above.

Depending on the surface roughness, a sphere with a mass between 0.33 and 8.8 g will meet the 1 cm^2/g specific surface area limit

The 1 cm^2/g specific surface area limit controls the parameter that is most important in terms of preventing spontaneous ignition, but it is not easy to measure or to use in the field. A mass limit (similar to the 50-g limit in the existing certificate, but more consistent with the 1-cm^2/g specific area limit) could be used, but it is very time-consuming to weigh every piece of metal in a package. An approach that is both effective at enforcing the 1-cm^2/g specific surface area limit and quick and easy to use in the field is to separate large pieces from small ones in a sieve. The recommended text stipulates a 3/8-in. mesh sieve to quickly remove small particles (with a large specific surface area) from large particles which have a small specific surface area.

As demonstrated in Example 1, rough-surfaced spheres 3/8 in. (0.95 cm) in diameter meet the 1 cm^2/g specific surface area limit (a smooth-surfaced sphere of this size has a specific surface area of 0.33 cm^2/g). Therefore, a sphere which does not pass freely through the 3/8-in. mesh sieve will meet the 1 cm^2/g specific surface area limit. Other simple shapes such as cubes and rods are also effectively controlled by the 3/8-in. sieve. Foils, turnings, and wires are explicitly forbidden in both the current and proposed text, unless they are packed in an inert atmosphere.

The phrase "whichever is most restrictive" has been deleted from the proposed text since the sieve test has been sized to effectively enforce the 1-cm^2/g specific surface area limit.

The option of converting pyrophoric uranium to an oxide is removed, since metals need to be shipped as metals for maximum usefulness at the receiver site. In addition, if oxides are produced, packing limits for oxides have been explicitly given in the CoC.

The final change in the proposed text is to eliminate the 1% of content weight limit on inerted material. This limit is unnecessary for uranium metal sealed in a container containing an inert atmosphere. If the metal has been sealed in a container containing an inert atmosphere, there is no oxygen available to the metal and therefore no chance of combustion.

Uranium metal packaged for transport in the ES-3100 is first placed inside a convenience can or other container. These cans are then placed into the ES-3100 containment vessel (CV). The convenience cans will displace most of the oxygen from the CV, leaving only enough to react with a few grams of metal. If a sealed container containing an inert atmosphere somehow came open in transport (an unlikely scenario given the very limited amount of movement possible inside a properly loaded CV), this small amount of oxygen is not enough to support spontaneous ignition. The CV has been shown to retain its structural integrity and remain leak tight under hypothetical accident conditions (HAC), so no additional oxygen can enter.

IV. Discussion

In his 1995 review,[1] Terry Totemeier explains pyrophoricity this way: "Pyrophoricity refers to the tendency of certain metals to ignite and burn in a self-sustaining oxidation reaction. The pyrophoric nature of metals is usually defined in terms of an ignition temperature, which is the temperature at which a metal will ignite and burn in a self-sustained fashion for a given set of conditions." ASTM C-1454[2] defines pyrophoric as "capable of igniting spontaneously under temperature, chemical, or physical/mechanical conditions specific to the storage, handling, or transportation environment."

This evaluation will demonstrate that uranium metal with a specific surface area of 1 cm^2/g will not spontaneously ignite under the conditions existing in the ES-3100 during packaging and transport.

The primary factors determining if the conditions for spontaneous ignition exist are specific surface area and temperature. Totemeier explains, "Because oxidation is a surface reaction, the amount of area available for reaction is a critical factor in the determination of the heat generated in oxidation. Specific area is the best parameter to describe the effect of area, as it also accounts for the amount of material not reacting which can serve as a heat sink." Temperature is critical because the amount of heat generated by the reaction is a function of the reaction rate, which is in turn a function of the temperature. Higher temperatures give higher reaction rates.

An additional safety factor in the case of the ES-3100 is the small amount of oxygen available in the sealed inner CV. This serves to limit the total amount of uranium that can oxidize, and therefore prevents any potential heat build-up from reaching the ignition point of uranium metal.

Ignition Temperature and Transport Conditions

In Figs. 4 and 5 of his review, Totemeier plots two separate tests of uranium ignition temperatures as a function of specific surface area. For a specific surface area of 1 cm^2/g these two plots give values of 390°C (663 K)[1] and 340°C (613 K), respectively. Using the lower value and rounding down gives a conservative value of 600 K for the ignition temperature of uranium metal in the ES-3100.

The ES-3100 thermal analysis determined that the temperature at the CV wall would not exceed 190°F (361 K) for normal conditions of transport (NCT) and 255°F (397 K) for HAC. These values, particularly the HAC temperature, are very conservative. The actual results from six separate package tests showed that the CV wall temperature was typically around 210°F (372 K), with the highest recorded value of 241°F (389 K). Note that all of these temperatures are well below the 600 K ignition temperature of the uranium metal contents.

Maximum Temperature from Oxidation – Basic Equations

Uranium metal readily reacts with oxygen to form uranium dioxide (UO_2). This reaction is exothermic. The heat released by the reaction warms the uranium metal, increasing the reaction rate. Under normal conditions for storage and transport, the reaction rate is slow enough that the small amount of heat generated by the reaction is lost to the environment, and a stable steady-state is achieved. If the reaction rate is fast enough, and the metal is relatively well insulated, the temperature of the uranium metal can build, slowly at first but at an increasing rate, until the ignition temperature is reached and the metal ignites and burns.

The task at hand is to evaluate the balance between heat generation and heat loss in the ES-3100 under HAC to verify that a stable steady state is reached, and that the steady-state condition is safely below the ignition point of uranium metal. A recent paper by Epstein, Malinovic, and Plys[3] lays out a useful approach, which will be followed here without the approximations used in their paper.

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[1] The curve in Totemeier Fig. 4 is discontinuous, with a transition from a lower curve to an upper curve shown at a specific surface area of 6 cm^2/g. At a specific surface area of 1 cm^2/g, the upper curve would give an ignition temperature of 550ºC, while extrapolation of the lower curve gives 390ºC. The original reference from which Totemeier drew Fig. 4 explains that the transition from the lower curve to the upper curve is influenced by many factors, including the metallurgy of the uranium, any alloying metals or impurities, and the oxygen content of the gas involved. Therefore, this analysis uses the lower curve value of 390ºC.

For uranium metal packed in cylindrical cans, the generation of heat throughout the can and the associated transfer of heat to the can wall is mathematically identical to the generation of heat within a wire due to electrical resistance. In their text "Transport Phenomena"[4] Bird, Stewart & Lightfoot develop the desired relation (Equation 9.2-14):

$$Tcenter - Twall = (S \times R^2) / (4 \times Kth) \quad \text{(Equation 1)}$$

where

Tcenter is the temperature at the center of the can (K)
Twall is the temperature at the can wall (K)
S is the heat production per unit volume (W/cm^3)
R is the radius of the can (cm)
Kth is the thermal conductivity of the uranium contents (W/cm K)

The heat production per unit volume is a function of the reaction rate and the heat of reaction. Since the oxidation reaction occurs at the surface of the uranium, the reaction rate is typically stated as a mass reacted per second per unit area. The specific surface area, the uranium metal density, and the packing density are applied to convert the rate per unit uranium surface area to a rate per unit can volume. The result is:

$$S = Rho \times Phi \times SArea \times dHrxn \times RxnRate \quad \text{(Equation 2)}$$

where

Rho is the density of the uranium metal (g/cm^3)
Phi is the packing density of the uranium in the can (cm^3 U/cm^3 can volume)
SArea is the specific surface area of the uranium (cm^2/g)
dHrxn is the heat of reaction (J/g uranium)
RxnRate is the reaction rate [g uranium / ($s \cdot cm^2$)]

The reaction rate of uranium metal with oxygen has been evaluated by many researchers over the years. The general form of the rate equation used is:

$$RxnRate = K0 \times P^n \times e^{(-Te/T)} \quad \text{(Equation 3)}$$

where

K0 is the reaction rate coefficient [g uranium / ($s \cdot cm^2$)]
P is the partial pressure of water vapor (kPa)
n is the exponential coefficient on the partial pressure of water vapor
Te is the activation energy (K)
T is the temperature of the reactants (K)

For the case at hand, the temperature of the reactants is the highest at the can center (Tcenter) and the lowest at the can wall (Twall). The average temperature of the reactants is midway between these two values. For conservatism the reaction rate of the entire contents is evaluated at the maximum temperature, which occurs at the center of the can (Tcenter). This analysis considers heat transfer only through the can walls, and ignores heat transfer through the top and bottom of the can. This is also a conservative assumption.

Equations 1, 2, and 3 are combined to yield:

$$Tcenter - Twall = (R^2 \times Rho \times Phi \times SArea \times dHrxn \times K0 \times P^n \times e^{(-Te/Tcenter)}) / (4 \times Kth) \quad \text{(Equation 4)}$$

Note that Kth is a property of the can contents (that is, for the bed of uranium metal particles with air in between), and not a property of solid uranium metal. The thermal conductivity of uranium metal is much higher than the thermal conductivity of a bed of uranium metal pieces.

P is the partial pressure of H_2O present in the CV at the center-line temperature. This value is calculated by assuming that the ES-3100 was loaded at ambient conditions of T0 and 100% relative humidity, which yields a water vapor pressure of P0. When the temperature in the CV increases the partial pressure of water vapor increases according to the ideal gas law, which in this case reduces to:

$$P = P0 \times (Tcenter/T0) \quad \text{(Equation 5)}$$

In this evaluation, the maximum possible rate of heat generation due to the oxidation of the uranium metal is also of interest since this heat must be carried away by the package, even at HAC. The maximum rate of heat generation is the heat generated by the oxidation of uranium metal at the highest temperature reached during HAC, assuming the maximum allowable load of uranium metal. This is:

$$Qmax = Mmax \times SArea \times dHrxn \times K0 \times P^n \times e^{(-Te/Tcenter)} \quad \text{(Equation 6)}$$

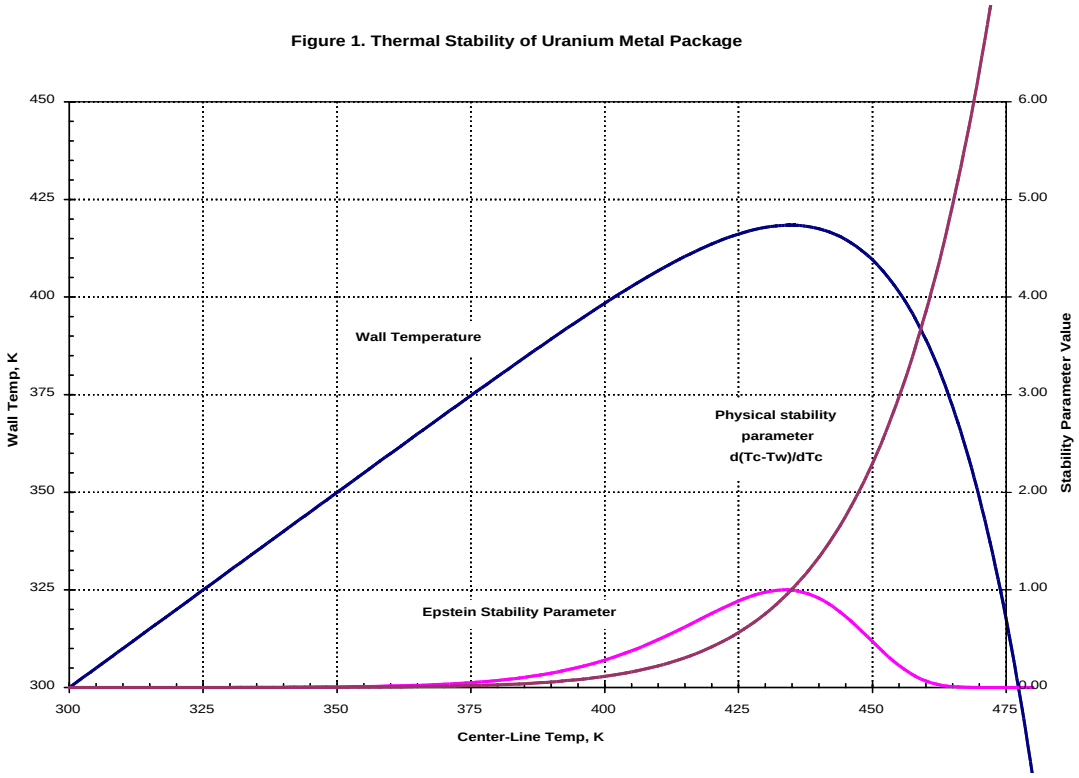
where

Qmax = the maximum rate of heat generation (W)
Mmax = the maximum uranium metal loading (g)

Evaluation of Thermal Stability

Equation 4 provides the means to evaluate the maximum temperature reached in the uranium metal. It does not by itself validate the stability of the system. This system does present a simple means to evaluate stability – both numerical stability and more importantly physical stability (meaning that the temperature cannot build to spontaneous ignition).

Solving Equation 4 for Twall over a range of Tcenter values and plotting the results produces Fig. 1:



The wall temperature calculated from Equation 4 and plotted here is the temperature needed in order to provide enough heat transfer to maintain the given center-line temperature. The wall temperature initially tracks the center-line temperature – the rate of heat generation is low, so a very small temperature difference is sufficient to remove that heat. As the center-line temperature (and therefore the amount of heat generated) increases, the temperature difference needed to keep the center-line temperature steady at the given value increases exponentially. At some point (~435 K in Fig. 1) the required temperature difference gets so large that the wall temperature would have to decrease in order to maintain a stable center-line temperature. In an actual package there is no cooling mechanism to do this, and once the center-line temperature exceeds this point the amount of heat generated will exceed the ability to carry off that heat, and the center-line temperature will increase until either the reaction runs out of oxygen or the ignition point is reached. The point at which the required wall temperature stops increasing, marks the maximum stable center-line temperature for the package. The required wall temperature stops increasing at the point where the rate of increase in the needed temperature difference [d(Tcenter−Twall)] equals the rate of increase of the center-line temperature (dTcenter). Stated mathematically, when d(Tcenter−Twall)/dTcenter is less than 1 the required Twall increases along with Tcenter, and stability is maintained. When d(Tcenter−Twall)/dTcenter is greater than 1 Twall would have to drop to maintain stability as Tcenter increases. Since this is not possible in a real package, the temperature in the package would steadily increase to either ignition or consumption of all available oxygen. The value of d(Tcenter−Twall)/dTcenter = 1 marks the maximum stable point for a given package.

Equation 4 is

$$Tcenter - Twall = (R^2 \times Rho \times Phi \times SArea \times dHrxn \times K0 \times P^n \times e^{(-Te/Tcenter)}) / (4 \times Kth)$$

Taking the first derivative of this equation with respect to Tcenter yields an equation for the stability parameter derived above:

$$d(Tcenter-Twall)/dTcenter = (Tcenter-Twall) \times Te/Tcenter^2 \quad \text{(Equation 7)}$$

The thermal stability of the system is maintained as long as $(Tcenter-Twall) \times Te/Tcenter^2 \leq 1$. This parameter is equivalent to the stability parameter "B" developed in Epstein et al., without the simplifying assumptions made in that paper. The value of d(Tcenter−Twall)/dTcenter is plotted in Fig. 1, along with the Epstein "B" parameter.

Input Parameters

The key values used to evaluate Equations 4, 5, 6, and 7 are shown in Table 1.

Table 1. Key input parameters

Parameter	Value	Units
R	5.27	cm
Rho	19	g/cm³
Phi	0.26	cm³/cm³
SArea	1	cm²/g
dHrxn	4559	J/g Uranium
K0	76086	gU/(s·cm²)
P0	3.53	kPa
T0	300	K
n	0.3	
Te	11490	K
Kth	0	W/(cm·K)

The sources of these parameters are:

R is the inside radius of a convenience can. The typical can used has an outside diameter of 4.25 in., and an inside diameter of 4.15 in. (10.54 cm).

Rho is the density of uranium metal.

Phi is the packing density of uranium metal when packed into the convenience cans. Operator experience at Y-12 is that a maximum of 5 kg U of broken metal will fit into a 4.25-in. OD by 4.875-in. high can, which has an internal volume of 1000 cm³. This yields a packing density of 0.26 cm³/cm³. The effects of variations on this value are discussed below.

SArea is the specific surface area, which is limited by the package certification to 1 cm²/g.

dHrxn is the heat of reaction, on a uranium basis. This value came from Totemeier, page 17 (1089 cal/gU = 4559 J/gU).

K0, n, and Te are parameters for the reaction rate equation. As noted above, a number of researchers have analyzed the reaction rate of uranium metal with various combinations of oxygen and water vapor. Numerous models have been developed from this data. This analysis used the published model that best fit the conditions present. Many of the published rate models are only valid up to 100 to 130°C. This evaluation requires evaluation beyond 140°C. Many of the models are for either pure oxygen or pure water vapor. McGillivray[5] notes that the reaction rate at a given temperature varies with both the oxygen concentration and the partial pressure of water vapor. The published model that best matches the conditions of this evaluation (reaction in air at temperatures exceeding 140°C, with a small water vapor partial pressure) is the Pearce model (Pearce, <100% RH, in Air, T <192°C) as reported in the Epstein paper.

P0 and T0 are used to calculate P, the partial pressure of H_2O vapor present in the CV at the center-line temperature. This value is calculated by assuming that the ES-3100 was loaded at ambient conditions of T0 = 300 K (80°F) and 100% relative humidity. P0 is therefore the vapor pressure of water at 300 K, which is P0 = 3.53 kPa. When the temperature in the CV increases, the partial pressure of water vapor increases according to equation 5.

Kth is the thermal conductivity of the uranium particle bed. The value here was taken from Epstein et al., page 6. Because of the air-filled void spaces, the bed thermal conductivity is much lower than the uranium metal value of 0.3 W/(cm·K).

Results

The set of equations (4, 5, 6, and 7) was evaluated using a commercial software package named Tk!Solver, which has the advantage of being able to automatically iterate to solutions as needed. This is necessary when solving equation 4 for a fixed wall temperature to determine Tcenter. Attachment 1 shows the rules, input and output for the TK!Solver model for the HAC and NCT cases.

The HAC evaluation gave a maximum CV temperature (Twall) of 255°F (397 K). Evaluating Equations 4–7 for these conditions yields a Tcenter of 398.4 K (257.5°F), with a maximum heat output (assuming a full load of 36 kgU) of 5.9 Watts, and a stability parameter d(Tcenter−Twall)/dTcenter of 0.102, well below the critical value of 1.0.

The 255°F HAC temperature was based on a uranium heat generation of 0.4 W. The 5.9-W maximum heat generated from the oxidation reaction under those conditions would heat the CV wall above that temperature. The thermal analysis evaluated the HAC for heat generation rates of 20 W and 30 W as well as the 0.4-W standard value. Table 3.7 in the thermal analysis shows that for an assumed 20 W heat generation in the uranium metal contents, the peak CV wall temperature is 277°F (409.3 K). Using this value ensures that the heat transfer from the uranium contents to the CV wall and to the rest of the package is conservatively addressed.

For the revised HAC wall temperature of 277°F (409.3 K), Equations 4–7 yield the following results:

Tcenter = 413.3 K (284.4°F) [well below the ignition temperature of 600 K]
MaxQ = 17.0 Watts (below the 20 W assumption)
d(Tcenter−Twall)/dTcenter = 0.272 (well below the critical value of 1.0)

At the NCT wall temperature of 190°F (360.9 K) the results are:

Tcenter = 361.0 K (190.1°F) [well below the ignition temperature of 600 K]
MaxQ = 0.289 Watts (below the 0.4 W assumption)
d(Tcenter−Twall)/dTcenter = 0.006 (well below the critical value of 1.0)

These values clearly show that uranium metal with a specific surface area of no more than 1 cm^2/g will not spontaneously ignite under any anticipated transport conditions.

Variation in Input Packing Density

The density with which uranium metal is packed into the convenience cans limits the surface area available to oxidize. Operator experience at Y-12 is that a maximum of 5 kg U of broken metal will fit into a 4.25-in.-OD by 4.875-in.-high can, which has an internal volume of 1000 cm^3. This yields a packing density of 0.26 cm^3/cm^3.

A search of the literature on packing densities reveals a lot of work on smooth spheres, and very little on anything else. Scott and Kilgour[6] experimented with packing smooth steel spheres in cylinders, and reported a maximum packing density of 0.6366 after extensive vibration to compact the steel spheres as much as possible. The steel balls used in this experiment had a coefficient of friction of 0.2, well below the value for smooth uranium metal of 1.0. Subsequent analysis by Kong and Lannutti[7] considering the effects of friction between particles gives packing fractions in the range of 0.41 to 0.46, with higher friction coefficients producing lower packing fractions.

The broken metal routinely packed at Y-12 consists of large, rough, irregular pieces. The reported packing density of 0.26 for this material is consistent with the literature reviewed, particularly Kong and Lannutti. Therefore, the value of 0.26 was used as the base value in the analyses reported above.

To bound the metal contents of the ES-3100 two additional cases have been analyzed under HAC: rough broken metal at a packing density of 0.46 (the upper end of the range reported by Kong & Lannutti); and smooth cast spheres at a packing density of 0.64 (consistent with Scott & Kilgour).

For rough broken metal at a packing density of 0.46 the maximum center temperature at HAC was 422 K, well below the ignition temperature of 600 K. For smooth cast 3/8” spheres at a packing density of 0.64 the maximum center temperature at HAC was 412 K, well below the ignition temperature of 600 K.

Oxygen Limitation in the Containment Vessel

The analysis above placed no restriction on the amount of oxygen available to react with the uranium metal contents. In reality, the ES-3100 CV has a finite volume, which restricts the amount of oxygen available for reaction.

The CV is a cylinder with inside dimensions of 31.00-in. (78.74-cm) tall and 5.06 in. (12.85 cm) in diameter. This produces a volume of 10,215 cm^3, or 10.215 liters. At ambient conditions of 300 K (80.3°F) and 100% relative humidity, 10.215 liters of humid air contains 2.78 g of oxygen from the air, and another 0.23 grams of oxygen in the H_2O. These 3.01 grams of oxygen can react with 22.40 g of uranium metal. This is 0.06% of the ES-3100’s capacity.

A mass of 22.4 g of U metal when reacted with 3.01 g of oxygen will produce a maximum total heat output of 102 kJ (96.8 BTU), spread out over the time required for the reaction to take place. This total amount of oxygen could sustain the NCT maximum heat output of 0.289 W for 4.1 days, or the HAC peak heat output for 1.7 hours. If somehow released all at once, the 102 kJ would only raise the temperature of 36 kg of uranium by 24.5 K. More realistically, as shown by the calculations above, any reaction will be slow, with enough time for the heat generated to flow to the CV and the rest of the package.

The ES-3100 CV is 15.1 kg of stainless steel, with a heat capacity of 0.515 J/(g·K). The 102 kJ maximum produced by the oxidation reaction could only raise the temperature of the CV (ignoring contents) by 13.1 K. This heat sink, plus the heat sinks offered by the CV contents, ensures that the oxidation reaction will not be able to build to the 600 K ignition temperature required for spontaneous ignition.

In practice there will less than 3 g of oxygen available to react with the uranium metal inside the closed CV. A full load of uranium will, by itself, displace nearly 20% of the air in the CV. The convenience cans, spacer cans, and other packing materials will displace even more air, further reducing the amount of uranium that could possibly react. Also, the uranium metal is packed inside closed convenience cans. These cans limit the oxygen available to react with the contents to the oxygen in the convenience can itself. Finally, part of the available oxygen will react with the uranium before the peak HAC conditions are reached. Figure 22b in Sect. 3 shows that it will take ~4 hours for the CV wall to reach the maximum temperature in the HAC fire. During this four-hour temperature ramp-up 0.9 grams of oxygen would be consumed by reaction with the uranium, leaving only 2.1 grams available to react once the HAC temperature was reached. Even if the uranium surface area was uncontrolled, lack of oxygen would snuff out any increase in the uranium reaction rate before it could reach the ignition point.

Specific Surface Area Implementation via Sieve

As noted above, the 1 cm^2/g specific surface area limit is not easy to measure or to use in the field. A screening method that is simple and easy to use in the field will reduce the potential for packaging mistakes. The recommended approach is to separate large pieces from small ones in a sieve. The recommended text stipulates a 3/8-in. mesh sieve to quickly remove small particles (with a large specific surface area) from large particles which have a small specific surface area.

Example 1 above showed that the minimum size of a metal sphere meeting the 1 cm^2/g specific surface area limit varies with the degree of surface roughness. In Example 1 a smooth sphere 1/8 in. in diameter and a rough sphere 3/8 in. in diameter both had specific surface areas just below the 1 cm^2/g limit. The 3/8-in. mesh is stipulated in the recommended text in order to accommodate both smooth and rough metal.

The actual metal contents of the ES-3100 will include both smooth-surfaced and rough-surfaced metal. The smooth-surfaced items include a variety of cast and machined shapes. The rough-surfaced items are “broken metal” – large castings that have been fractured into smaller pieces. These broken metal pieces will typically have two or three cast surfaces with the remaining 3 or 4 surfaces of fractured metal.

The 3/8-in. mesh recommendation is based on a surface roughness factor of three, meaning that the rough surface has an actual surface area available to react with oxygen that is three times that of a smooth-surface of the same gross dimensions. This roughness factor of three was derived from an evaluation of fracture surfaces for cast uranium metal. Roughness factors ranged from 1.1 to 2.7, with a mean value of 2.0. A roughness factor of three was selected to bound the highest value observed. The

3/8-in. mesh screening is therefore suitable for metal that is fractured on all surfaces. Since as noted above even broken metal will have several smooth faces the 3/8-in. mesh screening should be quite conservative.

As demonstrated above, a rough-surfaced sphere which does not pass freely through the 3/8-in. mesh sieve will meet the 1 cm^2/g specific surface area limit. Other simple shapes such as cubes and rods are also effectively controlled by the 3/8-in. sieve. Foils, turnings, and wires are explicitly forbidden in both the current and proposed text, unless they are packaged in an inert atmosphere. Attachment 2 shows the dimensions of a variety of shapes that have a specific surface area of 1 cm^2/g. All of these items will fall through a 3/8-in. sieve, demonstrating that the sieve will effectively enforce the 1 cm^2/g specific surface area limit.

Most foils and wires will not fall through a sieve of any reasonable size. The current 50 g test would likewise not reliably exclude these materials, which is why foils, turnings, and wires are explicitly forbidden in both the current and proposed text, unless they are packed in an inert atmosphere. Operator training will be required under either the current or the proposed text to ensure that these items are properly packaged.

Operator Training

As part of the transition to using the new shipping container, training materials are being prepared to instruct the field operations personnel on the proper way to use the ES-3100. As noted above, the training for the operators packing uranium metal into the convenience cans for shipment in the ES-3100 will be important in ensuring that potentially pyrophoric materials are properly categorized and inerted as necessary. This training will cover the following points:

- All metal pieces must be evaluated to ensure that their smallest dimension is larger than the 3/8-in. mesh size.
  - Single solid-metal pieces that are clearly larger than the 3/8-in. mesh in every dimension do not require sieving.
  - Items which are obviously unacceptable, such as foils, wires, and turnings, may be removed before the sieving
  - Any item that is not obviously larger than the 3/8-in. mesh in every dimension and which has not been rejected must be sieved.
  - Any item that falls through the sieve must be rejected.
- Operators need to be alert to items which may not fall through the sieve but which are too small:
  - Long, thin shapes such as wires and turnings may not fall through the sieve when shaken. If the wire or turning could be picked up and poked through the mesh it must be rejected, even if it did not fall through unassisted.
  - Wires or turnings may form a tangled ball which will not fall through. The above criterion applies: if the wire or turning could be separated and poked through the mesh it must be rejected.

- No distinction is made between wires and rods – if the item could be picked up and poked through the mesh it must be rejected.
- Foils, thin chips or shards - any item less than 1/8-in. thick – must be rejected.
- Metal showing visible moisture or signs of having been stored in water must be rejected.

- Rejected items must be separated for proper handling:
  - Rejected items can be shipped if packed under an inert cover gas.
  - An acceptable cover gas must be an inert gas or mixture of inert gases with a high-purity (≥99%) and low moisture (≤5 ppm moisture).

V. Conclusion

The evaluations performed show that uranium metal conforming to the 1-cm^2/g limit on specific surface area will not spontaneously ignite under any anticipated transport conditions. Spontaneous ignition is independently prevented by both the 1-cm^2/g limit on the uranium metal and by the limited amount of oxygen available in the sealed ES-3100 CV.

The 3/8-in. sieve specified in the revised text effectively applies the 1-cm^2/g specific surface area limit to broken uranium metal in a manner that is quick and easy to use in the field.

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Attachment 1. TK!Solver Model and Results

Rules

Tcenter-Twall=((R^2*rho*phi*SArea*dHrxn*K0*P^n)/(4*Kth))*exp(-Te/Tcenter)
P=P0*(Tcenter/T0)
Deriv=(Tcenter-Twall)*Te/Tcenter^2
HRate=SArea*dHrxn*K0*P^n*exp(-Te/Tcenter)
MaxQ=HRate*MaxM
RRate=SArea*MaxM*K0*P^n*exp(-Te/Tcenter)
ORate=RRate*32/238
OTime=MaxO/ORate

HAC—277°F Wall Temperature

Input	Name	Output	Unit	Comment
	Tcenter	413.348	K	Temperature at the center of the can
409.3	Twall		K	Temp at the can wall
	HRate	.000472	W/gU	Rate of heat production (w/unlimited O2)
	MaxQ	16.9945	W	Maximum heat production (from max KgU)
36000	MaxM		gU	Maximum ES-3100 contents
3.01	MaxO		gO	Maximum ES-3100 Oxygen Content
	RRate	.003728	gU/s	Reaction Rate at given Conditions
	ORate	.000501	gO/s	Oxygen Use rate at given conditions
	OTime	1.66822	hr	Oxygen time to run-out
5.27	R		cm	Can radius
1	SArea		cm^2/gU	Specific Surface Area of U particles
	Deriv	.272221		d(Tcenter-Twall)/dTcenter
19	rho		gU/cm^3	Density of uranium
.26	phi			Packing density, U cm^3 / Can cm^3
4559	dHrxn		J/gU	Heat of Reaction
76086	K0		gU/(s*cm^2)	Reaction rate coefficient - Pearce <100%
11490	Te		K	Reaction rate coefficient - Pearce <100%
.3	n			Reaction rate coefficient - Pearce <100%
3.53	P0		kPa	Vapor pressure of water at T0
300	T0		K	Temperature for P0
	P	4.86373	kPa	Vapor Pressure of Water at Tcenter
.004	Kth		W/cm*K	Thermal Conductivity of U particle bed

NCT - 190℉ Wall Temperature

Input	Name	Output	Unit	Comment
	Tcenter	360.969	K	Temperature at the center of the can
360.9	Twall		K	Temp at the can wall
	HRate	8.03E-6	W/gU	Rate of heat production (w/unlimited O2)
	MaxQ	.288991	W	Maximum heat production (from max KgU)
36000	MaxM		gU	Maximum ES-3100 contents
3.01	MaxO		gO	Maximum ES-3100 Oxygen Content
	RRate	6.34E-5	gU/s	Reaction Rate at given Conditions
	ORate	8.52E-6	gO/s	Oxygen Use rate at given conditions
	OTime	98.1015	hr	Oxygen time to run-out
5.27	R		cm	Can radius
1	SArea		cm^2/gU	Specific Surface Area of U particles
	Deriv	.00607		d(Tcenter-Twall)/dTcenter
19	rho		gU/cm^3	Density of uranium
.26	phi			Packing density, U cm^3 / Can cm^3
4559	dHrxn		J/gU	Heat of Reaction
76086	K0		gU/(s*cm^2)	Reaction rate coefficient - Pearce <100%
11490	Te		K	Reaction rate coefficient - Pearce <100%
.3	n			Reaction rate coefficient - Pearce <100%
3.53	P0		kPa	Vapor pressure of water at T0
300	T0		K	Temperature for P0
	P	4.2474	kPa	Vapor Pressure of Water at Tcenter
.004	Kth		W/cm*K	Thermal Conductivity of U particle bed

Attachment 2. Pyrophoric Size Limits on Small Uranium Metal Pieces

Specific Surface Area:	1.0	cm^2/g
Uranium Metal Density:	19.0	g/cm^3
Surface Area Multiplier:	3.0	

The surface area multiplier is the ratio of the actual surface area divided by the simple geometeric surface area.

Spheres - Minimum Safe Diameter

Limiting diameter	0.9474	cm	or	0.3730	in	8.459	grams

Rods - Minimum Safe Diameter

Length	Diameter						
0.9 cm	0.9474	cm	or	0.3730	in	12.688	grams
1.0 cm	0.9231	cm	or	0.3634	in	12.715	grams
1.5 cm	0.8000	cm	or	0.3150	in	14.326	grams
2.0 cm	0.7500	cm	or	0.2953	in	16.788	grams
2.5 cm	0.7229	cm	or	0.2846	in	19.495	grams
Infinite	0.6316	cm	or	0.2487	in		

Cubes - Minimum Safe Side Length

Limiting side length	0.9474	cm	or	0.3730	in	16.155	grams

Square Cross-Section Rods - Minimum Safe Side Length

Length	Side						
0.9 cm	0.9474	cm	or	0.3730	in	16.155	grams
1.0 cm	0.9231	cm	or	0.3634	in	16.189	grams
1.5 cm	0.8000	cm	or	0.3150	in	18.240	grams
2.0 cm	0.7500	cm	or	0.2953	in	21.375	grams
2.5 cm	0.7229	cm	or	0.2846	in	24.822	grams
Infinite	0.6316	cm	or	0.2487	in		

Chips & Shards - Minimum Safe Thickness

Length	Width	Thickness					
1.0 cm	0.5 cm	6.0000	cm	or	2.3622	in	57.000 grams
1.5 cm	0.5 cm	2.0000	cm	or	0.7874	in	28.500 grams
2.0 cm	0.5 cm	1.5000	cm	or	0.5906	in	28.500 grams
2.5 cm	0.5 cm	1.3043	cm	or	0.5135	in	30.978 grams
3.0 cm	0.5 cm	1.2000	cm	or	0.4724	in	34.200 grams
Infinite	0.5 cm	0.8571	cm	or	0.3375	in	
1.0 cm	0.6 cm	2.0000	cm	or	0.7874	in	22.800 grams
1.5 cm	0.6 cm	1.2000	cm	or	0.4724	in	20.520 grams
2.0 cm	0.6 cm	1.0000	cm	or	0.3937	in	22.800 grams
2.5 cm	0.6 cm	0.9091	cm	or	0.3579	in	25.909 grams
3.0 cm	0.6 cm	0.8571	cm	or	0.3375	in	29.314 grams
Infinite	0.6 cm	0.6667	cm	or	0.2625	in	
Infinite	Infinite	0.3158	cm	or	0.1243	in	

VI. References

1. Totemeier, Terry C. ANL/ED/95-2 "A Review of the Corrosion and Pyrophoricity Behavior of Uranium and Plutonium", June 1995, Argonne National Lab-West.

2. ASTM C-1454-00, "Standard Guide for Pyrophoricity/Combustibility Testing in Support of Pyrophoricity Analyses of Metallic Uranium Spent Nuclear Fuel", January 10, 2000, ASTM International.

3. M. Epstein, B. Malinovic, M. G. Plys, SNF-6192-FP, "Uranium Pyrophoricity Phenomena and Prediction", April 2000, Fluor Hanford, Richland Washington.

4. R. Byron Bird, Warren E. Stewart, Edwin N. Lightfoot, "Transport Phenomena", 1960, John Wiley & Sons.

5. G. W. McGillivray, D. A. Geeson, R. C. Greenwood, "Studies of the Kinetics and Mechanism of the Oxidation of Uranium by Dry and Moist Air – A Model for Determining the Oxidation Rate Over a Wide Range of Temperatures and Water Vapor Pressures", June 1993, Journal of Nuclear Materials # 208 (1994) pg 81-97.

6. G. D. Scott, D. M. Kilgour, "The Density of Random Close Packing of Spheres", February 1969, British Journal of Applied Physics, Series 2, Volume 2, pp 863 - 866.

7. C. M. Kong, J. J. Lannutti, "Effect of Agglomerate Size Distributions on Loose Packing Fraction", March 2000, Journal of the American Ceramic Society, Volume 83, pp 2183 – 2188.

Appendix 1.3.9
Equipment Specification SPC M801580-0002,
ES-3100 Ethylene Propylene Diene Monomer (EPDM) Containment Vessel O-rings

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EQUIPMENT SPECIFICATION

DOC TYPE	DOC #	PART #	REV. #	PAGE
SPC	M801580-0002	000	03	i of vi

APPROVAL / REVISION PAGE

** For Company Use Only - Do Not Provide To Supplier **

QUALITY LEVEL	PROTECTION LEVEL	BUILDING
Q	B	

PROJECT TITLE	JOB TITLE
ES-3100	O-rings

ITEM DESCRIPTION	UNID
ES-3100 Ethylene Propylene Diene Monomer (EPDM) Containment Vessel O-rings	YAREA-CMH-042

REVISIONS

REV. NO.	DESCRIPTION OF REVISION
00	Original issue
01	Made corrections and added procurement-related attachments and O-ring drawing
02	Changed inspection standard and updated requirements and format using SPC-M801794-0005 000 01 as template
03	Updated to incorporate procurement-related waivers and questions. Added inspection lab temperature and humidity report to Sect. 4.1.2.2, Sect. 4.6.1, and submittal checklist (item # 23), added calibration report prior to inspection to Sect. 4.1.2.4, Sect. 4.6.1, and submittal checklist (item # 24), and added serialized tamper-indicating devices (TIDs) to Sect. 3.6.1.1, Sect. 4.6.1 certified data package and submittal checklist (item #25); added control documents and revisions to the Certificate of Conformance (Sect. 4.6) - all per Commercial Grade Survey CGS-225151-17-02.

REFERENCE DOCUMENTS & OTHER INFORMATION

This specification is for procurement of domestic, commercially available items; does not contain scientific, technical, or operational information (STI); and therefore does not require a review by the Information Release Office (IRO).

Recommended Suppliers:

JDS Technologies, Inc.	OR	Rainier Rubber Co.	OR	Other Company Approved Supplier
1299 Airport Road		15660 Nelson Pl		
Oneida, TN 37841		Tukwila, WA 98188		
(423) 286-6190		(425) 227-4500		

Upon delivery, maintain Supplier's level of packaging
In-Storage Maintenance Requirements – [None], for long term storage maintain Protection Level B per Y60-015, *Integrated Quality Manual*

References for Company Use

1. Receipt Inspection Checklist: Attached
2. CGD Plan: TEA 801794-0001
3. QCPI: QCPI-1335
4. QLD: CK-M801580-0010 (inner O-ring) and CK-M801580-0011 (outer O-ring)
5. This specification includes applicable requirements from OO-PP-986, OO-A-017, and OO-A-018
6. Commercial Grade Survey of JDS Technology: RP 801794-0019

Quality Notes:

1. ASTM D1329 Low Temperature TR-10 test results are not to be used for acceptance criteria, but for information only
2. Procurement of O-rings must satisfy 10 CFR Part 71, Subpart H

Procurement Notes:

Purchasing shall include this specification and O-ring Drawing M2E801580A013 (latest revision)

DC REVIEW
This document has been reviewed by a Y-12 DC / UCNIRO and has been determined to be UNCLASSIFIED and contains no UCNI.
This review does not constitute clearance for Public Release.
Name: Stan (TSW) Thomas

APPROVALS

PRINT	SIGNATURE/DATE	PRINT	SIGNATURE/DATE
PREPARED BY / PACKAGING ENGINEER N. A. Laney	Noelani A (NL1) Laney	**CGD ENGINEER (Q)** J. Cook	Jeffrey E (2XK) Cook
DESIGN VERIFICATION M. L. Goins	Monty L (MLG) Goins	**DESIGN AUTHORITY REP. (DAR)** R.D. Turner	Richard D (B19) Turner
DESIGN ENGINEER G. A. Byington	GERALD BYINGTON (Affiliate)	**QA ENGINEER (Q & RS)** D. R. Cardwell	Sheila Lynn (SLX) Roddy
DISCIPLINE MANAGER J. C. Anderson	James C (JSA) Anderson		

08/24/2011

RECEIPT INSPECTION CHECKLIST	DOC TYPE RP	DOC. #	PART #	REV. #	PAGE of

Form instructions – EPD Preparer should complete all spaces pertaining to the specification of the item (shown in red). The individual performing receipt inspection should complete all spaces pertaining to the inspection of the received item (shown in blue). Multiple copies of the RIC may be used for POs with multiple items. Attach comments and other documentation, as needed.

A. GENERAL INFORMATION

SPECIFIED

ITEM DESCRIPTION	UNID
Ethylene Propylene Diene Monomer (EPDM) Containment Vessel Inner O-rings	

QUALITY LEVEL	PROTECTION LEVEL	QTY TO INSPECT OR SAMPLE SIZE: IF SAMPLE IS <100%, ATTACH SAMPLING PLAN AND JUSTIFICATION	PROCUREMENT QUALITY STRATEGY
Q	B	See Sampling Plan below	Evaluated or Commercial

RECEIVED

ITEM DESCRIPTION	SAT Y or N	INITIALS	DATE

PO#:	ITEM #	QTY ORDERED:	SHIPMENT	SHIPMENT #:	QTY REC'D/ LOT SIZE:	QTY INSPECTED/ SAMPLE SIZE:
			COMPLETE OR PARTIAL	of		

RELATED APPROVED WAIVERS/DEVIATIONS:

B. SUPPLIER PACKAGING, HANDLING, SHIPPING, & STORAGE (INCL. MAINTENANCE)

SPECIFIED:

Supplier's normal packaging, handling, shipping and storage are adequate.

RECEIVED:	SAT Y or N	INITIALS	DATE

C. ITEM SUPPLIER/MANUFACTURER INFORMATION

	IF SPECIFIED AS A REQUIREMENT	RECEIVED
SUPPLIER		
MANUFACTURER		
MODEL #		
PART #		
		SERIAL #:

	SAT Y or N	INITIALS	DATE
Suspect/Counterfeit Item (S/CI) Inspection, Review of S/CI Notifications and Item Markings			

D. MEASUREMENT AND TEST EQUIPMENT (M&TE used for receipt inspection)

(add additional pages if needed)

M&TE TYPE	M&TE NUMBER	CALIBRATED RANGE	TOLERANCE	CAL. DUE DATE

E. COMPANY PACKAGING, HANDLING, SHIPPING, & STORAGE (INCL. MAINTENANCE)

SPECIFIED:

Upon delivery, maintain Supplier's level of packaging, handling, and shipping. Protection Level B required. No specific maintenance requirements are applicable to these items.

	Y or N	INITIALS	DATE
Communicated requirements to Company Material Management			

08/24/2017

RECEIPT INSPECTION CHECKLIST	DOC TYPE RP	DOC. #	PART #	REV. #	PAGE of

F. SALIENT FEATURE EVALUATION

CRITICAL CHARACTERISTIC	NUC PROC OR CGD METH #	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Product Identification – Product identification information and/or markings on each O-ring package (Receipt inspector – see sampling note below.)	CGD Method 1 or CGD Method 3	Inspection	SQE	Documentation of Inspection Results (CGD Method 1) or PQR(s) (CGD Method 3)	PQE	Y, N, N/A

TE&AP # IF CGD	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
TEA-801794-0001	Y-12 PO number, markings that properly identify material such as part name, batch ID, lot ID (as applicable). Additional markings are required for sampling in the important features section.		Y or N		

CRITICAL CHARACTERISTIC	NUC PROC OR CGD METH #	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Physical Property Testing – Material Composition	CGD Method 2 or CGD Method 3	Inspection	SQE	CoC (CGD Method 2) or PQR (CGD Method 3)	PQE	Y, N, N/A

TE&AP # IF CGD	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
TEA-801794-0001	CoC or PQR are in accordance with EPD referenced in the PO; test results are in accordance with the applicable criteria in the EPD. Additional Fourier transform infrared (FTIR) test (Method 1) to be verified downstream per QCPI. 1. Chemical composition FTIR per ASTM D3677, EPDM (two specimens from each batch) 2. Hardness test per ASTM D2240, 70 ± 5 Shore A 3. Low temp. resistance test per ASTM D2137 Method C, non-brittle after 3 ± 0.5 min at −40°C • None of the specimens shall fail per Sect. 9.3.3 4. Heat resistance test per ASTM D573 after 70 h at 100°C • Increase in hardness ≤10 Shore A points per ASTM D2240 • Maximum of 25% reduction in tensile strength per ASTM D412 • Maximum of 25% reduction in ultimate elongation per ASTM D412 5. Compression set test per ASTM D395 after 22 h at 70°C, Method B • Maximum compression set ≤25%		Y or N		

RECEIPT INSPECTION CHECKLIST

DOC TYPE	DOC. #	PART #	REV. #	PAGE
RP				of

CRITICAL CHARACTERISTIC	NUC PROC OR CGD METH #	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Configuration – Dimensions, Cross-sectional diameter & Inside diameter	CGD Method 2 or CGD Method 3	Inspection	SQE	CoC (CGD Method 2) or PQR(s) (CGD Method 3)	PQE	Y, N, N/A

TE&AP # IF CGD	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
TEA-801794-0001	CoC or PQR are in accordance with EPD referenced in the PO. Supplier must certify via report of 100% dimensional inspection. 1. Record inner O-ring dim's from drawing for verification: • Cross-section diameter is 0.135" to 0.143" • Inside diameter and tolerance is 5.324" to 5.394" 2. Record outer O-ring dim's from drawing (for information only): • Cross-section diameter and tolerance • Inside diameter and tolerance		Y or N		

RISK ATTRIBUTES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
None	N/A	N/A	N/A	N/A	Y, N, N/A

QLD #	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
CK-M801580-0010 CK-M801580-0011	N/A		Y or N		

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Product Identification – Information and/or markings on each O-ring package (Receipt inspector – see sampling note below.)	Inspection	SQE	Documentation of Inspection Results	PQE	Y, N, N/A

	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
	As specified in the EPD, identification for size, material compound, cure date, and expiration date.		Y or N		

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Configuration – Visual Inspection	Inspection	SQE	CoC, test reports, or PQR(s)	PQE	Y, N, N/A

	ACCEPT. CRITERIA W/ TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
	Supplier must certify to 100% visual inspection. 1. O-ring shall be molded in one piece. O-ring shall be smooth, non-porous, and free of skin defects per ISO-3601-3, Grade CS. Imperfection limits per Table 3 of ISO 3601-3.		Y or N		

08/24/2017

RECEIPT INSPECTION CHECKLIST	DOCTYPE RP	DOC. #	PART #	REV. #	PAGE of

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Mechanical Property Testing	Inspection	SQE	CoC, test reports, or PQR(s)	PQE	Y, N, N/A

	ACCEPT. CRITERIA W / TOLERANCE/ RANGE	ACTUAL	SAT	INITIALS	DATE
	Test results are in accordance with the applicable criteria in the EPD. 1. Tensile strength test in accordance with ASTM D412, 12 MPa (1740 psi) minimum 2. Elongation test in accordance with ASTM D412, 100% minimum 3. Density (specific gravity) test in accordance with ASTM D297 on representative cured specimens from the batch of material, 1.13–1.19 g/cm^3 (two specimens from each batch) 4. Low temperature TR-10 test in accordance with ASTM D1329, performed on a representative cured test specimen from each batch of material. (See Quality Note #1 on page i.)		Y or N		

G. DISPOSITION

APPLICABLE PQR # AND/OR NCR #; ATTACH COMMENTS & OTHER DOCUMENTATION AS NEEDED	QUANTITY APPROVED:	QUANTITY REJECTED:

H. AUTHORIZATION

EVALUATOR SIGNATURE	ORGANIZATION	BADGE:	DATE:

Sampling Plan:

Critical characteristics for product identification/marking will be verified in accordance with a normal sampling plan as defined for non-destructive testing in Y17-69-316, *Engineering Procurement Document Manual*, Chapter 6, Attachment 6-C, "Sampling Plan Guidance and Justification," based on the total quantity procured per the purchase order (PO). Based upon Supplier performance and compliance data accumulated from receiving, the sampling plan may be relaxed or tightened accordingly per Table 6.C.1 in Attachment 6-C. This sampling plan is acceptable based on the leak-testing performed on each O-ring after its installation in the containment vessel. As noted in the safety function, these O-rings are used to provide a containment function verified after the O-ring installation by the performance of a pre-shipment leak-test between the inner and outer O-rings. Any issues with a specific O-ring would be identified during this leak testing.

Per the requirements of this specification, the Supplier places a label on each O-ring package, performs dimensional verification and visual configuration inspections on 100% of the O-rings prior to shipment to Y-12. Y-12 personnel will witness these verification activities at the Supplier's facility during the First Article Evaluation (FAE) process if warranted per the EPD. Depending upon Supplier's quality program quality, oversight sampling could be enforced on every order.

For material of composition, one FTIR test will be performed in accordance with Option 1 (destructive testing with production traceability) on a sample size of one for each batch of O-rings as defined in Y17-69-316, Chapter 6, and Attachment 6-C. O-rings and a 6 x 6 in. minimum piece of material are supplied directly to Y-12 from the Supplier with material identified by PO number, batch number, and lot number (if applicable). Based on this lot identification, material composition is verified either on a 6 x 6 in. minimum piece of material from the same batch, which has been cured with the lot or on a specific O-ring. Option 1, according to Attachment 6C, is an acceptable approach based on the rationale provided in the previous paragraphs.

NOTE:

Receipt Inspector will confirm receipt of Supplier Certificate of Conformance (CoC) and Certified Data Package or verify with the Procurement Quality Report (PQR) that O-rings are in accordance with the specification requirements to address

critical characteristics specified in the Commercial Grade Dedication (CGD) Plan **and** for important features specified in the Receiving Inspection Checklist (RIC).

If Method 2 Commercial Grade Survey (CGS) is used for acceptance, critical characteristics 2-3 and the important features will be verified by confirming the CoC meets the requirements of Sect. 4.6 and the Certified Data Package meets the requirements found in Sect. 4.6.1 of this document. Critical characteristic 1 for product identification should be verified per the sampling plan requirements listed above and the results of these inspections documented in the RIC and include the results in the receipt inspection package.

If Method 3 Source Surveillance is used for acceptance, critical characteristics and important features will be verified at the Supplier's facility and documented in the PQR. The Receipt Inspector will verify that the items inspected and documentation of this inspection are traceable to the items shipped and received at Y-12.

After this acceptance, Supplier Quality Engineer (SQE) will green tag (i.e., UCN-4804) the O-rings. O-rings will then be transferred to the user organization for implementation of the Quality Certification and Procurement Instructions (QCPI) requirements and final acceptance as certified O-rings (i.e., UCN-14850). An identification label with product number, MC number, expiration date, and lot number will be added to each O-ring package.

EQUIPMENT SPECIFICATION FOR ETHYLENE PROPYLENE DIENE MONOMER (EPDM) CONTAINMENT VESSEL O-RINGS

TABLE OF CONTENTS

1. SCOPE 2
1.1 General Description of the Item 2
1.2 Background 2
2. REFERENCES 2
2.1 Definitions 2
2.2 Codes/Standards/Orders/Regulations 3
2.3 Applicable Documents 4
3. ITEM REQUIREMENTS 4
3.1 Performance Requirements 4
3.2 Design Requirements 4
3.3 Service Conditions 6
3.4 Fabrication and Assembly Requirements 6
3.5 Installation Requirements 6
3.6 Requirements 6
3.7 Government-Furnished Material, Equipment, Services 8
3.8 Schedule 8
3.9 Deliverables (Including Submittals) 8
3.10 Packaging, Handling, Shipping, and Storage Requirements 8
3.11 Marking and Identification Requirements 10
3.12 Request for Waiver or Deviation (RFWD) 10
4. QUALITY ASSURANCE REQUIREMENTS 10
4.1 Final Acceptance Method 10
4.2 Inspection/Testing Requirements 12
4.3 Surveillance and Audits 12
4.4 Quality Requirements 12
4.5 Acceptance Criteria 15
4.6 Certificate of Conformance (CoC) 16
4.7 Factory Acceptance Testing or Inspection 18
4.8 Personnel Qualifications/Certification 18
ATTACHMENT A: SUBMITTAL CHECKLIST 19

1. SCOPE

This specification and design drawing specify the requirements for O-rings used in Type B shipping packages. Drawing M2E801580A013 (latest revision) specifies the dimensional requirements and refers to this specification for the nondimensional requirements.

If conflicting requirements appear in these documents, the Supplier shall immediately notify the Company for resolution. The Supplier shall not make any assumptions regarding requirements within this specification and shall always contact the Company for clarification.

The Supplier shall not deviate from the requirements of this specification without prior written consent from the Company. Requests for changes or deviations shall be submitted on form UCN-13816B, *Request for Waiver or Deviation (RFWD)*, and the latest RFWD form may be requested from the Subcontract Administrator (SA) or Subcontract Technical Representative (STR).

1.1 General Description of the Item

This specification is applicable to inner and outer containment vessel (CV) O-rings used in fissile hazardous material shipping containers. The O-rings will be used for a static face seal application. The O-ring material shall be ethylene propylene diene monomer (EPDM). The O-ring service temperature range is −40 to 150°C (−40 to 302°F). The O-ring material must properly seal at these extreme temperatures. CV O-rings must comply with strict manufacturing, testing, and quality standards.

1.2 Background

Failure or malfunction of these O-rings will directly result in an unacceptable condition of containment. Proper O-ring sealing is crucial for package containment during storage, shipping, and testing for normal conditions of transport and hypothetical accident conditions. Shipping containers are regulated and certified by the U.S. Nuclear Regulatory Commission, the U.S. Department of Energy, the U.S. Department of Transportation, and the National Nuclear Security Administration.

2. REFERENCES

2.1 Definitions

Batch – A batch of material is defined as a homogeneous mixture of material compound mixed at one time.

Company – The Company (i.e., Y-12 National Security Complex), as referenced in this specification, is the buyer of the Supplier's final product.

First Article – Product that is submitted to the Company for evaluation prior to the Seller being released to manufacture the remaining quantities in the purchase order (PO). This product must be representative of production items by virtue of having been produced and inspected using the same facilities, testing, processes, and type of personnel planned for use in production.

First Article Evaluation (FAE) – An evaluation by the Company of the first article manufactured and the facilities, tooling, and processes, concerned with manufacture, test, and inspection.

Lot – A lot shall be a quantity of product of the same identity, cured in the same production run, and from the same batch.

Manufacturing Plan/Manufacturing Traveler – A written, step-by-step, process plan for the equipment to be fabricated. The plan or traveler includes material control, major fabrication steps, hold points, all in-process inspections, welding, welding inspection/examination, dimensional inspections, testing, and shipping.

Non-conformance - A deficiency in characteristic, documentation, or procedure that renders an item to be in non-compliance with specified requirements.

Offeror - The Organization or person(s) submitting an offer to the Company to provide the product(s) described.

Request for Waiver or Deviation (RFWD) – A formal request by the Supplier for a waiver or deviation to the equipment specification, drawing, or PO using the Company form, which can be provided by the SA or STR. The form must be approved by the Company in writing before the Supplier being granted authorization to proceed.

- **Deviation** – A specific written authorization, granted by the Company prior to the manufacture of an item, to depart from a subcontract requirement for a specific piece or pieces of product, or a specified period of time.
- **Waiver** – A specific written authorization, granted by the Company, to accept a configuration item or other designated items that, during production or after having been submitted for inspection, are rework by an approved method.

Subcontract Administrator (SA) – An individual, generally called the Buyer, who is responsible for the overall subcontract administration and has authority to act officially for the Company. This person may also assign a Subcontract Technical Representative to have authority to represent the Company in technical matters.

Subcontract Technical Representative (STR) – The Subcontract Technical Representative, as used in this specification, is the person designated by the Subcontract Administrator as having the authority to represent the Company in technical matters.

Supplier – The Organization or person(s) entering into a subcontract with the Company to provide the product(s) described in this specification.

Testing Agency (TA) – Supplier may use an approved testing lab with ISO 17025 accreditation for property & chemical testing

2.2 Codes/Standards/Orders/Regulations

The EPDM O-rings shall be fabricated, tested, and inspected according to the design drawing, this specification, and the applicable referenced documents.

- ASME Y14.5, *Dimensioning and Tolerancing*
- ASTM D297, *Standard Test Methods for Rubber Products—Chemical Analysis*
- ASTM D395, *Standard Test Methods for Rubber Property—Compression Set*
- ASTM D412, *Standard Test Methods for Vulcanized Rubber and Thermoplastic Elastomers—Tension*
- ASTM D573, *Standard Test Methods for Rubber—Deterioration in an Air Oven* (high temperature test)
- ASTM D1329, *Standard Test Method for Evaluating Rubber Property—Retraction at Lower Temperatures (TR Test)*
- ASTM D1349, *Standard Practice for Rubber—Standard Conditions for Testing*
- ASTM D2000, *Standard Classification System for Rubber Products in Automotive Applications*

- ASTM D2084, *Standard Test Methods for Rubber Property—Vulcanization Using Oscillating Disc Cure Meter* or equivalent such as ISO 3417, *Rubber—Measurement of Vulcanization Characteristics with the Oscillating Disk Curemeter*
- ASTM D2137, *Standard Test Methods for Rubber Property—Brittleness Point of Flexible Polymers and Coated Fabrics* (low temperature test)
- ASTM D2240, *Standard Test Method for Rubber Property—Durometer Hardness*
- ASTM D3182, *Standard Practice for Rubber—Materials, Equipment, and Procedures for Mixing Standard Compounds and Preparing Standard Vulcanized Sheets*
- ASTM D3677, *Standard Test Methods for Rubber—Identification by Infrared Spectrophotometry*
- ISO 3601-3, *Fluid Power Systems — O-rings — Part 3: Quality Acceptance Criteria*
- MIL-DTL-117H, *Bags, Heat-Sealable*
- MIL-PRF-121G, *Barrier Materials, Greaseproof, Waterproof, Flexible, Heat-Sealable*

2.3 Applicable Documents

A Company-provided O-ring drawing will be supplied with the PO.

3. ITEM REQUIREMENTS

3.1 Performance Requirements

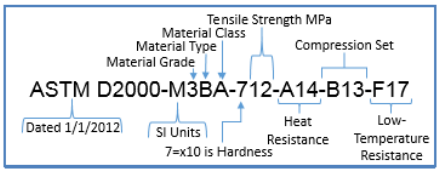
See Sect. 3.2

3.2 Design Requirements

O-rings shall meet the requirements specified in ASTM D2000. The "line call-out" or specification for these O-rings shall be as follows: ASTM-D2000-M3BA-712-A14-B13-F17.

NOTE: O-ring application is for a static face seal.

1. Below is a summary of the requirements in this line call-out.



- ASTM D2000 is the required consensus standard.
- M3BA
  - M – prefix letter meaning requirements are in SI units (International System of Units) [Sect. 4.1 in ASTM D2000]
  - 3 – grade number (Sect. 5 in ASTM D2000)
  - B – material type (Sect. 4.3 and Table 1 in ASTM D2000), testing temperature 100°C
  - A – material class based on volume swell in oil (Sect. 4.4 and Table 2 in ASTM D2000), no requirement for these O-rings
- 712
  - 7 – 70 Shore A hardness (Sect. 9.1 in ASTM D2000)
    - Test per ASTM D2240 (Table 5 in ASTM D2000)
  - 12 – 12 MPa tensile strength minimum (Sect. 9.1 in ASTM D2000)

    - Test per ASTM D412 (Table 5 in ASTM D2000)

- A14 (Table 6, BA materials, Grade 3 in ASTM D2000)
  - A – heat resistance (Table 3 in ASTM D2000)
  - 1 – test per ASTM D573 for 70 h (Table 5 in ASTM D2000)
  - 4 – test at 100°C (Table 4 in ASTM D2000)
  - Change in hardness +10 maximum
  - Change in tensile strength −25% maximum
  - Change in ultimate elongation −25% maximum
- B13 (Table 6, BA materials, Grade 3 in ASTM D2000)
  - B – compression set (Table 3 in ASTM D2000)
  - 1 – test per ASTM D395 Method B for 22 h (Table 5 in ASTM D2000)
  - 3 – test at 70°C (Table 4 in ASTM D2000)
  - 25% maximum compression set
- F17 (Table 6, BA materials, Grade 3 in ASTM D2000)
  - F – low temperature resistance (Table 3 in ASTM D2000)
  - 1 – test per ASTM D2137 Method C, Sect. 9.3.3, 3 min (Table 5 in ASTM D2000)
  - 7 – test at −40°C (Table 4 in ASTM D2000)

2. Material shall be EPDM.
3. Color shall be black.
4. Specific gravity/density shall be 1.13–1.19 g/cm^3.
5. Minimum elongation shall be 100%.
6. Normal service temperature range shall be −40 to 150°C (−40 to 302°F).
7. Each O-ring shall be molded as a single piece.
8. O-ring surface imperfection limits shall be in accordance with ISO 3601-3, Sect. 5 and Table 3, “Quality Acceptance Criteria for Grade CS – Critical Service”. A visual inspection report shall be submitted in the Certified Data Package (Sect. 4.6.1) and a visual inspection procedure per the “Submittal Checklist,” Attachment A.
9. O-ring dimensions shall comply with the requirements on the Company drawing (M2E801580A013). A dimensional inspection report shall be submitted in the Certified Data Package (Sect. 4.6.1) and a dimensional inspection procedure per the “Submittal Checklist,” Attachment A.
10. Each lot of O-rings associated with this procurement shall be molded from the same batch of material unless prior Company approval is obtained. A batch of material is defined as a homogeneous mixture of material compound mixed at one time.
11. Each production run (lot) of O-rings shall be cured according to the temperature and time schedule specified in the Supplier’s Company-approved manufacturing plan (Sect. 3.6.2). The Supplier shall provide a copy of the curing time-temperature charts to the Company in the Certified Data Package (Sect. 4.6.1).
12. For each batch of material used to mold O-rings, Supplier shall supply to the Company one molded slab or sheet that is at least 6 x 6 in. and meets the mixing, preparation, and size requirements of ASTM D3182. The sheet shall be identified with the PO, the batch number of the material compound used, and the lot number

(as applicable) that it represents. The sheet shall be provided to the Company with the first shipment of O-rings.

3.3 Service Conditions

See Sect. 3.2.

3.4 Fabrication and Assembly Requirements

N/A

3.5 Installation Requirements

N/A

3.6 Requirements

3.6.1 Property testing

1. Raw material containers shall be secured with four serialized tamper indicating devices (TIDs). Required a) once material is received, b) while specimens are being tested at a third party lab, c) until material is released for production, and d) for excess material between production runs. Time stamped photos that document the security of the raw material shall be submitted in accordance with the submittal checklist, Attachment A.
2. Specimens shall be hardness tested in accordance with ASTM D2240. The acceptance criteria is 70 ± 5 Shore A points. Median values shall be recorded from five determinations taken a minimum of 6.0 mm apart and a minimum of 12.0 mm from any edge. The specimen shall be ≥6.0 mm in thickness and may be composed of plied pieces.
3. Tensile strength test a minimum of three dumbbell specimens and, if needed, up to two spare specimens in accordance with ASTM D412. Specimen size shall be per Die C dimensions with thickness requirement of 2.0 ± 0.2 mm. The length of the specimens shall be die cut parallel with the sheet grain direction. The acceptance criteria is 12 MPa (1740 psi) minimum. The median of three thickness measurements on each specimen shall be used to calculate cross-sectional area. The test speed shall be 500 ± 50 mm/min. Median tensile values shall be recorded from the test specimens.
4. High temperature test a minimum of three specimens and, if needed, up to two spare specimens in accordance with ASTM D573 for 70 h at 100°C. The acceptance criteria are ≤10 max Shore A hardness points, 25% maximum reduction in tensile strength, and 25% maximum reduction in elongation. Final testing shall be performed following ≥16 h cooling period (conditioning time) after removal from the oven. Hardness, tensile, and elongation tests shall be performed as described in Sects. 3.6.1.1, 3.6.1.2, and 3.6.1.7. Median values shall be recorded from the test specimens.
5. Compression set test three specimens in accordance with ASTM D395 Method B for 22 h at 70°C. The acceptance criteria is ≤25% maximum compression set. Final measurements shall be performed following ≥30 min cooling period after removal from the oven and fixture. Button diameter and thickness shall be per ASTM D395, Sect. 5.2.1, Type 1 specimen. Median values expressed as a percentage shall be recorded from the test specimens.
6. Low temperature test five specimens in accordance with ASTM D2137 Method C for 3.0 ± 0.5 min at −40°C. Acceptance criteria is non-brittle after 3 min. Failure is

defined as any crack, fissure, or hole in the test specimens visible to the naked eye, or complete separation into two or more pieces. None of the specimens shall fail this test per Sect. 9.3.3 of ASTM D2137. Die cut specimens with a thickness requirement of 2.0 ± 0.2 mm per Fig. 2 of ASTM D2137. Prior to testing, condition the specimens for ≥16 h. The striker speed shall be ≥1.8 m/s and be maintained for ≥6.0 mm of travel following impact.

7. Low temperature TR-10 test three specimens in accordance with ASTM D1329 performed on representative cured test specimens from the batch of material. Die cut specimens with a thickness requirement of 2.0 ± 0.2 mm per Fig. 2 of ASTM D1329. Following ASTM procedure, stretch specimens 250% or half the ultimate elongation if 250% is unobtainable. While stretched in the specimen rack, soak specimens for a minimum of 10 min at −70 to −73°C. Release stretched specimen with a controlled temperature rise of 1°C per min. First retraction reading shall be recorded at −70°C. Specimen length shall be measured every 2 min until 75% retraction is completed. Median values shall be recorded from the test specimens. A 10% specimen retraction is desired prior to the temperature rising above −40°C. The results of this test are for information only and shall not be used for rejection purposes but are expected to be met.
8. Elongation test a minimum of three dumbbell specimens and up to two spare specimens in accordance with ASTM D412. Specimen size shall be per Die C dimensions with a thickness requirement of 2.0 ± 0.2 mm. The length of the specimens shall be die cut parallel with the sheet grain direction. The acceptance criteria is 100% minimum elongation. The median of three measurements on each specimen shall be used to calculate thickness for cross-sectional area. The test speed shall be 500 ± 50 mm/min. Median values shall be recorded from the test specimens.
9. Composition test in accordance with ASTM D3677 using Fourier transform infrared (FTIR) spectroscopy on two representative cured specimens from each batch. The purpose of this test is to verify that the material is EPDM. The result shall be consistent with that of "known" infrared spectra of EPDM recorded over the 4000 to 666 cm^{-1} region. The results shall be compared to standard reference spectra and by reference to tables of diagnostic absorptions (significant absorption frequencies). Compare and identify the pyrolysis method to the significant absorption frequency graph shown in ASTM D3677, Fig. 16, "EPM Pyrolyzate from a Vulcanizate," and the film method to the significant absorption frequency graph shown in ASTM D3677, Fig. 32, "EPM Film from a Vulcanizate."
10. Density (specific gravity) test in accordance with ASTM D297 on two representative cured specimens from each batch. The acceptance criteria is 1.13–1.19 g/cm^3 using the hydrostatic method. To eliminate air bubbles, dip specimens in alcohol and blot prior to suspending in water.
11. Supplier's procedures for conducting all of these tests shall be provided to the Company in accordance with Sect. 3.9 requirements.
12. Rubber sheets for test specimens shall conform to the mixing, preparation, and size requirements of ASTM D3182. Sheets may be used for all property testing except for the compression set test.
13. Test specimen conditioning and testing shall be conducted at 23 ± 2°C (73.4 ± 3.6°F) and 50 ± 10% relative humidity (RH) per ASTM D1349, Sect. 2.1.2, *standard laboratory atmosphere* requirements. Materials shall be conditioned for no less than 12 h at this controlled atmosphere prior to testing unless specified otherwise.

3.6.2 Manufacturing Requirements

1. The Manufacturer shall be responsible for supplying all materials, services, facilities, and equipment to meet the requirements of this specification and Company drawing unless otherwise noted.
2. The Supplier shall submit manufacturing plans (i.e., routings, written procedures, follow sheets, data forms, and processing records) for FAE and production orders as required to document and control the manufacturing processes to ensure consistency of all operations for Company approval. At a minimum, the plan should include materials to be procured, Suppliers to be used, quality assurance (QA) program used to buy or manufacture product, sequence of operations, equipment to be utilized, and hold point(s) TBD with Company approval. These submittals shall be provided in accordance with the "Submittal Checklist," Attachment A.
3. The Supplier shall prepare and submit to the Company inspection procedures as specified in Sect. 4.1 for review and approval. These procedures shall be submitted in accordance with the "Submittal Checklist," Attachment A.

3.7 Government-Furnished Material, Equipment, Services

N/A

3.8 Schedule

Proposed contract performance schedule (i.e., raw material procurement, fabrication, testing, inspection, delivery) shall be submitted with the proposal. This proposal shall be approved by the company prior to start of fabrication. Hold/witness points shall be included as applicable.

3.9 Deliverables (Including Submittals)

The documentation required with the proposal as indicated in the "Submittal Checklist," Attachment A, shall be submitted to the Company in the quantities listed with the Supplier's offer. Submittals shall be e-mailed to the Company SA and the STR.

Additional documentation listed in "Submittal Checklist," Attachment A, shall be submitted at the times requested.

The Company will review the submittals that are required prior to fabrication as indicated in the "Submittal Checklist," Attachment A, and respond as shown in the "Instructions to Supplier for Preparation of Submittals," Item h.

The Company shall review the submittals required per Attachment A. Shipping shall not commence without documented permission from the Company. Submittals apply to both FAE work and production work.

3.10 Packaging, Handling, Shipping, and Storage Requirements

3.10.1 Packaging Requirements

1. Each O-ring will be thoroughly cleaned after the completion of all processing and prior to inspection and individual packaging. The Supplier will clean the O-rings in accordance with industry standard cleaning procedures for O-rings to ensure that they are free of foreign materials (including dirt, grease, curing compound, etc.) on the surface. After cleaning, O-rings will be handled with clean nitrile gloves. Supplier shall submit a cleaning procedure for Company approval per "Submittal Checklist," Attachment A.

2. O-ring packaging will be accomplished under conditions that will ensure no contamination by dust, oil, grease, and other extraneous matter. Packaging will be carried out in an atmosphere in which RH <65%.
3. Each O-ring shall be packaged in an individual sealed package that provides adequate protection against ultra violet rays.
4. Packaging material shall be a heat-sealable, greaseproof, waterproof, flexible barrier made of laminated paper or film in accordance with MIL-PRF-121G, Type I (medium duty) and identified on each bag. Supplier shall submit Certificate of Conformance (CoC) for packaging material per "Submittal Checklist," Attachment A.
5. Packaging method shall be in accordance with MIL-DTL-117H, Type II (medium duty), Class C (waterproof, greaseproof), Style 1 (opaque) and identified on each bag. Supplier shall submit CoC for packaging material per "Submittal Checklist," Attachment A.
6. Bag sizes shall be 8 × 8 in. unless Company approves otherwise. One source for the Poly Kraft bag sizes shown is Edco Supply.
7. Tape or any other material shall not be used inside the heat-sealed bag. O-rings <10-in. diameter shall not be folded over and shall be packaged per Fig. 1. O-rings >10-in. diameter shall be folded over one time and packaged per Fig. 2. Adequate spacing is required around each O-ring for proper heat-seal closure of bag. O-rings are required to lay flat after storage.

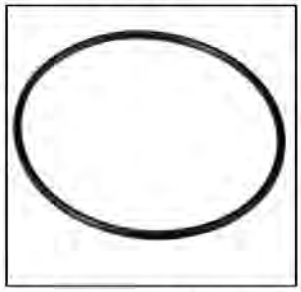


Fig. 1. O-rings <10-in. diameter.



Fig. 2. O-rings >10-in. diameter.

3.10.2 Shipping Requirements

O-rings shall be shipped in containers that will protect the O-rings during shipment and storage. The O-rings shall be protected against exposure to weather or any other normal conditions of transportation and storage. Unless otherwise specified in the Company PO, as a minimum, the box shall be marked with the following information:

- Supplier company name and return ship-to address
- Supplier part number
- Supplier part name
- Company ship-to address
- Company PO
- Date of shipment
- Number of O-rings inside

3.11 Marking and Identification Requirements

Each individual O-ring package shall be marked with the following information:

- MIL-DTL-117H, Type II, Class C, Style 1
- MIL-PRF-121G, Type I
- O-ring Supplier company name
- O-ring PO
- O-ring batch number
- O-ring lot number (if applicable)
- O-ring part number shown on Drawing M2E801580A013 (i.e., M2E801580A013-1 or M2E801580A013-2)
- O-ring compound number
- O-ring size (inside diameter and cross section as stated per Drawing M2E801580A013)
- O-ring cure date, quarter and year (i.e., 4Q15)
- O-ring expiration date, 4 years from cure date (i.e., 4Q19)

3.12 Request for Waiver or Deviation (RFWD)

1. The Supplier must comply with all requirements specified in this specification, the design drawing, and the applicable documents referenced herein unless approved otherwise in writing by the Company.
2. Any requested exceptions, deviations, or proposed changes to the requirements of a procurement specification by the Supplier after award or before acceptance shall be submitted using UCN-13816B, *Request for Waiver or Deviation (RFWD)*.
3. The Supplier shall contact the STR or SA to obtain the latest UCN-13816B, *Request for Waiver or Deviation (RFWD)*, form and submit the RFWD to the STR or SA when a nonconforming condition is identified that includes:
   - requirements in Supplier documents approved by the Company are violated,
   - non-conformances cannot be corrected by continuing the original manufacturing process except by reworking or repairing the item, or
   - the item does not meet original requirements, even though it can be restored to a fully functional condition.
4. The Supplier shall not ship nonconforming O-rings to the Company without a Company-approved RFWD to justify such action.
5. Any nonconforming O-ring approved for shipment shall be documented on the CoC with a reference to the approved RFWD number.
6. Certified Data Packages (Sect. 4.6.1) for the applicable O-rings being shipped shall include all applicable Company-approved RFWDs per Sect. 4.6.

4. QUALITY ASSURANCE REQUIREMENTS

4.1 Final Acceptance Method

1. Final acceptance of a shipment of O-rings will be based on receipt inspection performed by the Company at the Supplier's facility or upon receipt.
2. Any O-ring not meeting the requirements set forth in this document will be cause for rejection of the entire lot.
3. No O-rings shall be shipped with unapproved RFWDs.

4.1.1 General Requirements

The Supplier shall ensure the quality of the O-rings by fully complying with all drawings, requirements, testing, inspections, reports, documentation, and approvals required by this specification.

1. Prior to the start of production, the Supplier shall submit an uncontrolled copy of the QA program that meets 10 CFR 71, Subpart H requirements. This shall include a copy of the cover page with signatures, date, and revision number of their current Quality Manual with the Proposal. The Company reserves the right to evaluate and approve the QA plan of the Supplier. The Company reserves the right to perform oversight activities if there are deficiencies in the Supplier's quality program.
2. The Supplier shall notify the Company a minimum of 14 calendar days prior to the fabrication start date. The Company reserves the right to inspect the fabrication prior to, during, and after completion. Hold/witness points will be identified by the Company in the Supplier's manufacturing schedule after it is submitted to the Company for review.
3. The Supplier shall document the results of each inspection and/or test on quality record forms.
4. Where inspection or test equipment yields quantitative readings, actual measurements or deviation from nominal readings shall be submitted. Test results from the chemical analysis and physical properties test results from the batch shall be provided to the Company per the Certified Data Package (Sect. 4.6.1) requirements and the submittal schedule (Attachment A).
5. The quality requirements shall be applicable and implemented by the Supplier and flowed down to all sub-tier supplier and subcontractors.
6. The Company shall be notified in advance of any subcontracting work and provided a copy of the sub-tier supplier or subcontractor project specific QA plan(s) addressing the quality requirements.
7. The Supplier shall provide an assessment/oversight plan for ensuring implementation of sub-tier supplier QA requirements.
8. For requirements governing suspect/counterfeit items (S/CI), reference the section regarding S/CI in the General Terms and Conditions. The General Terms and Conditions can be found in the request for solicitation.
9. The Supplier shall ensure the packaged O-rings are traceable from the marking on the individual packaging (Sect. 3.11) to the raw material Supplier quality records accepted by the Supplier. The Supplier shall ensure that the Company has full access to all records that validate this traceability, including all lower-tier raw material certifications. The Supplier shall ensure that only raw material meeting the applicable specifications are used in the fabrication of the O-rings.
10. Documentation of all final inspection, traceability, and testing results shall be maintained by the Supplier for a minimum of five (5) years after acceptance by the Company. The Company shall have the option to retrieve and review this data during this period, if and when deemed necessary to ensure compliance with all product requirements.

4.1.2 Dimensional Inspections

1. Cross-sectional width/diameter shall be measured and documented on all of the O-rings. This width/diameter shall be measured with an optical/vision system,

micrometer or other method via a Company-approved procedure. This diameter shall be measured at a minimum of eight locations equally spaced around the O-rings. All eight locations shall meet the width/diameter tolerance specified on the Company drawing.

2. Per ASME Y14.5, all O-ring dimensions are applicable at 20 ± 1.1°C (68 ± 2°F). **Submittal of inspection lab temperature and humidity report are required in accordance with Attachment A.** Recommended recording frequency for the report is every 5 minutes. Affected parts must be re-measured and dimensions updated on the dimensional inspection report if the temperature and humidity report identifies any non-conforming lab conditions. The relative humidity (RH) shall be less than 50%. The Temperature and Humidity gage shall be calibrated and certified by an ISO-17025 accredited organization. **Caution:** If O-rings are verified at the Company, and the Supplier's dimensional lab is not controlled at this level, the Company's measurements may be used to determine dimensional acceptance or rejection.
3. Inside diameter shall be measured and recorded on all of the O-rings. This diameter shall be measured with an optical/vision system, Pi tape or other method via a Company-approved procedure. Diameter shall meet the specified tolerance on the Company drawing.
4. Supplier procedures for dimensional inspection shall be provided to the Company in accordance with Sect. 3.9 requirements. **Submittal of daily dimensional inspection equipment calibration report is required in accordance with Attachment A.** Calibration accuracy of the daily calibration to be 1/5th of the tolerance band (+/-.001") at a minimum. Measuring equipment shall be calibrated and certified by an ISO-17025 accredited organization.
5. Dimensional inspection reports shall be prepared and submitted to the Company for approval in the Certified Data Package according to Sect. 4.6.1.

4.1.3 Visual Inspections

1. All of the O-rings shall be visually inspected per ISO 3601-3, Sect. 5, Grade CS. O-ring surfaces shall be free from foreign material (including dirt, grease, curing compound, etc.) and cracks, ruptures, blisters, or other imperfections that are greater than the limits given in Table 3 of ISO 3601-3 when the unstretched O-ring is viewed under a 2X magnifier with adequate illumination.
2. Supplier's procedure for visual inspection shall be provided to the Company in accordance with Sect. 3.9 requirements.
3. Visual inspection reports shall be prepared and submitted to the Company for approval in the Certified Data Package per Sect. 4.6.1.

4.2 Inspection/Testing Requirements

See Sect. 4.4, "Quality Requirements"

4.3 Surveillance and Audits

See Sect. 4.5 (FAE)

4.4 Quality Requirements

Program/Plan Quality Assurance Requirements

The Supplier's specific QA plan shall, as a minimum, address the requirements listed in this section. The specific QA plan shall be submitted for approval.

4.4.1 Quality Assurance Organization

Responsibilities for the establishment and implementation of the QA program shall be defined. The organizational structure, functional responsibilities, levels of authority, and lines of communications for activities affecting quality shall be documented.

4.4.2 Quality Assurance Program

The QA program shall be based upon requirements of 10 CFR 71, Subpart H. The program shall provide control over activities affecting quality to an extent consistent with their importance. The program shall include monitoring activities against acceptance criteria in a manner sufficient to provide assurance that the activities affecting quality are performed satisfactory and shall be established at the earliest time consistent with the schedule for accomplishing the activities.

The program shall provide for planning and accomplishment of activities affecting quality under suitable controlled conditions. The controlled conditions shall include the use of appropriate equipment, suitable environmental conditions for accomplishing the activity, and assurance that prerequisites for the given activity have been satisfied.

The program shall provide for any special controls, processes, test equipment, tools, and skills to attain the required quality of activities and items and for verification of that quality. The organization shall establish and implement processes to detect and correct quality problems.

The program shall provide for indoctrination and training, and qualification as necessary of personnel performing or managing activities affecting quality to assure that suitable proficiency is achieved and maintained.

Management shall regularly assess the adequacy and effective implementation of the QA program.

4.4.3 Design Control

N/A

4.4.4 Procurement Document Control

Applicable design bases and other requirements necessary to assure adequate quality requirements shall be included or referenced in documents for procurement of items and services.

4.4.5 Instructions, Procedures and Drawings

Activities affecting quality and services shall be prescribed by and performed in accordance with documented instructions, procedures, or drawings that include or reference appropriate quantitative or qualitative acceptance criteria for determining prescribed results have been satisfactorily attained.

4.4.6 Document Control

The preparation, issue, and change of documents that specify quality requirements or prescribe activities affecting quality (i.e., instructions, procedures, and drawings) shall be controlled to assure correct documents are being employed.

Such documents, including changes thereto, shall be reviewed for adequacy and approved for release by authorized personnel.

4.4.7 Control of Purchased Items and Services

The procurement of items and services shall be controlled to ensure conformance with specified requirements.

4.4.8 Identification and Control of Items

Controls shall be established to assure that only correct and accepted items are used or installed. Identification shall be maintained on the items or in documents traceable to the items or in a manner assuring that identification is established and maintained.

4.4.9 Special Processes

N/A

4.4.10 Inspection

Inspections requiring verifying conformance of an item or activity to specified requirements or continued acceptability of items in service shall be planned and executed. Characteristics subject to inspection and inspection methods shall be specified, and inspection results shall be documented.

Inspection for acceptance shall be performed by qualified persons other than those who performed or directly supervised the work being inspected.

4.4.11 Test Control

Tests requiring collecting data for design input to verify conformance of an item or computer program to specified requirements or to demonstrate satisfactory performance for service shall be planned and executed. Characteristics to be tested and test methods to be employed shall be specified. Test results shall be documented, and their conformance with test requirements and acceptance criteria shall be evaluated.

4.4.12 Control of Measuring and Test Equipment

Tools, gages, instruments, and other measuring and test equipment used for activities affecting quality shall be controlled, adjusted, and maintained to required accuracy limits. Measuring and test equipment shall be calibrated and certified by an organization with ISO 17025 accreditation or Company-approved equal and traceable to the National Institute of Standards. Documentation shall be submitted in accordance with the "Submittal Checklist," Attachment A.

4.4.13 Handling, Storage, and Shipping

Handling, storage, cleaning, packaging, shipping, and preservation of items shall be controlled to prevent damage or loss and to minimize deterioration. These activities shall be conducted in accordance with established work and inspection instructions, drawings, specifications, shipment instructions, or other pertinent documents or procedures specified for use in conducting the activity.

4.4.14 Inspection, Test, and Operating Status

The status of inspection and test activities shall be identified either on the item or in documents traceable to the items where it is necessary to assure required inspections and tests are performed and to assure items that have not passed the required inspections and tests are not inadvertently installed, used, or operated.

Status shall be maintained through indicators (i.e., physical location and tags, markings, shop travelers, stamps, inspection records) or other suitable means.

The authority for application and removal of tags, markings, labels, and stamps shall be specified.

4.4.15 Control of Nonconforming Items

Items that do not conform to specified requirements shall be controlled to prevent inadvertent installation or use. Controls shall provide for identification, documentation, evaluation, segregation when practical, and disposition of nonconforming items, and for notification to affected organizations.

4.4.16 Corrective Action

Conditions adverse to quality shall be identified promptly and corrected as soon as practicable. In the case of a significant condition adverse to quality, the cause of the condition shall be determined, and corrective action shall be taken to preclude recurrence. The identification, cause, and corrective action for significant conditions adverse to quality shall be documented and reported to appropriate levels of management. Completion of corrective actions shall be verified.

4.4.17 Quality Assurance Records

QA records shall furnish documentary evidence that items or activities meet specified quality requirements. QA records shall be identified, generated, authenticated, and maintained, and their final disposition specified. Requirements and responsibilities for these activities shall be documented.

4.4.18 Audits

N/A

4.4.19 Software Quality Assurance (SQA)

If applicable, the SQA process shall be established to provide assurance that software will satisfy customer requirements. The process shall apply to acquisition, development, operation, maintenance, and retirement.

4.4.20 Suspect/Counterfeit Items (S/CIs)

For requirements governing Suspect / Counterfeit Items (S/CIs), reference the section regarding Suspect/Counterfeit Items in the General Terms and Conditions. The General Terms and Conditions can be found in the Request for Solicitation. Use components supplied or assemblies of components from OEM or authorized distributors. These items should be treated as nonconforming items.

4.5 Acceptance Criteria

First Article Evaluation (FAE)/Surveillance and Audits

NOTE: Follow-on orders will not require additional FAEs unless warranted by changes at the Supplier.

The primary objective of a FAE is to verify that the O-ring conforms to its requirements and the facilities, tooling, processes, controls, personnel, and acceptance methods, can consistently furnish O-rings of the required quality and quantity. The FAE is conducted in two phases. The first phase is an evaluation at the Supplier's site of all critical manufacturing, inspection, and testing operations and equipment. The second phase is an independent evaluation by the Company of the FAE O-rings received by the Company.

FAE O-rings must be submitted to the Company for evaluation prior to releasing the Supplier to manufacture the remaining quantities in the PO. The O-rings must be representative of production items by virtue of having been produced and inspected using the same facilities, testing, processes, compounds, and type of personnel planned for use in production.

The total number of O-rings to be manufactured for the FAE and production shall be specified in the Company's PO.

1. Supplier shall notify the Company approximately 14 calendar days in advance of initiating fabrication of FAE O-rings.
2. Supplier shall provide the Company a Certified Data Package (Sect. 4.6.1) for the FAE O-rings, same as required for production O-rings.
3. The Supplier shall not proceed to manufacture O-rings beyond the initial FAE quantities until a successful FAE has been completed and notification to proceed has been received from the Company. The Company will notify the Supplier in writing with the results of the FAE. The FAE results will be reported in one of the following three categories:
   - Acceptable: Supplier is released to initiate manufacture of production quantities.
   - Conditionally Acceptable: The Company will specify actions that the Supplier must complete before being released for production quantities.
   - Not Acceptable: The first article units have serious deficiencies, or the ability of the Supplier to consistently furnish product of the required quality and quantity is subject to major uncertainty. The Company will specify the required action.

After the Company has approved an FAE, the Supplier shall notify the Company of <u>any</u> proposed changes to manufacturing and acceptance procedures, facilities, personnel, testing, tooling, and compounds, which could conceivably impact product quality. The Company will determine if a new FAE is warranted.

The Company may periodically perform quality surveys of the Supplier's operations for assurance that the evaluated facilities, procedures, personnel, processes, testing, and tooling, are being used in fulfilling the subcontract.

4.6 Certificate of Conformance (CoC)

A CoC shall be submitted to the Company with each shipment of O-rings.

- The CoC shall identify the purchased material or equipment by the PO number.
- The CoC shall identify the specific procurement requirements met by the purchased material or equipment (i.e., codes, standards, other specifications). This may be accomplished by including a list of the specific requirements or by providing to the Company a copy of the PO and the procurement specifications or drawings, together with a suitable CoC.
- The CoC shall identify any approved changes, waivers, or deviations applicable to the subject material or equipment.
- The CoC shall identify any procurement requirements that have not been met, together with an explanation and the means for resolving the RFWD.
- The CoC shall be signed or otherwise authenticated by a person who is responsible for this QA function and whose function and position are described in the QA program of the Supplier.
- The Supplier's certification system, including the procedures to be followed in filling out a CoC and the administrative procedures for review and approval of the CoCs, shall be described in their QA program.

- The CoC shall state the Commercial Grade Survey (CGS) Survey number: CGS-225151-17-02 and list the following procedures and forms that were evaluated during the CGS and used to produce the O-rings.

Procedure or Form	Revision
QM-101 Cover Sheet for JDS Quality Manual	Rev 02, 12/10/2018
QM-102 JDS Quality Cover Sheet Crosswalk for CNS	Rev 0, 11/20/2017
MP-PRP-QOP-8.4-03 Verification of Purchased Product	Rev 02, 11/28/2018
SP-QIN-QOP-8.5-02 Identification and Traceability	Rev 01, 04/24/2018
SP-QIN-QOP-8.6-01 Quality Inspection Process	Rev 02, 02/02/2018
WI 106 Molding, Cleaning, Visual Insp. and Dimensional Insp. of O-Rings	Rev 02, 10/22/2018
WI 123 Method for Obtaining Samples of Incoming Samples of Incoming Material for 3rd Party Testing	Rev 01, 06/11/2018
WI 125 Micro Vu Verification of Calibration	Rev 01, 06/14/2018
WI 126 Obtaining Data from the Temperature, Humidity, and Pressure Data Logger	Rev 01, 06/14/2018
JDS form SP-CAL-QF-7.1-05 Dimensional Calibration Verification	Rev A, 10/22/2018
JDS form 8.3-12 Final Audit-Record of Inspection	Rev 02, 05/07/2018
ENG-16-01 Manufacturing Plan	09/28/2016

4.6.1 Certified Data Package Requirements

The following Certified Data Package shall be forwarded to the Company with each shipment of O-rings. One copy shall be forwarded to the SA and STR **before** shipment via PDF files. E-mail is preferred. One copy shall be included with the shipment of O-rings. Failure to supply the required data may be cause for rejection.

- CoC (Sect. 4.6)
- Raw material Supplier CoC that raw material is EPDM and meets specification requirements
- Oscillating disc rheometer (ODR) curve for vulcanization characteristics in accordance with ASTM D2084, ISO 3417, or approved equal for each batch of material, to be supplied for information purposes only
- If used, testing agency CoC that physical and/or chemical testing meets specification requirements
- Curing time-temperature charts, the Supplier shall certify each lot was cured according to the temperature and time parameters specified in the Seller's approved manufacturing plan.
- ASTM D2000 physical properties
  - ASTM D573 high temperature test report (A14)
  - ASTM D395 compression set test report (B13)
  - ASTM D2137 low temperature test report (F17)
  - ASTM D2240 hardness test report (7)
  - ASTM D412 tensile strength test report (12)
- ASTM D412 elongation test report
- ASTM D1329 low temperature TR-10 test report
- ISO 3601-3 Grade CS visual inspection report
- ASTM D3677 FTIR spectroscopy report (**two specimens from each batch**)

- ASTM D297 density test report (**two specimens from each batch**)
- Dimensional inspection report
- 6 x 6 in. batch test slab/sheet (in box with shipment of O-rings only)
- Applicable RFWDs
- Temperature and humidity data recorded in the lab during the dimensional inspection of products manufactured for CNS
- Daily Calibration Report for measuring equipment prior to CNS O-ring dimensional inspection
- Time stamped photos of serialized TIDs that verify each container is securely controlled in accordance with Sect. 3.6.1.

4.7 Factory Acceptance Testing or Inspection

N/A

4.8 Personnel Qualifications/Certification

The Supplier shall provide for the training and qualification of personnel, as necessary, to ensure their competence in the use of process, test and inspection procedures, and specifications.

ATTACHMENT A: SUBMITTAL CHECKLIST

Instructions to Supplier for Preparation of Submittals

Note 1 --All correspondence shall be addressed to the Technical Representative identified by the company. The Supplier shall forward submittals via transmittal letter to the Company at the address specified in the contract.

Note 2 -- The submittal must have adequate detail so that full compliance with the requirements may be determined. For example, a simple off-the-shelf item to be used in an assembly may only need a manufacturer's cut-sheet to show compliance, but a factory acceptance test (FAT) developed and submitted by the Seller must have each test step detailed with acceptance criteria consistent with the requirements.

a. Review submittal before transmitting to the Company to verify conformance with requirements of the contract documents (e.g., field measurements, field construction criteria, or manufacturer's catalog numbers).
b. Coordinate submittals with the work requirements and the contract documents.
c. Organize Submittals
   - Do not use highlight marker or color coding on submittals.
   - The minimum resolution used for scanning submittals shall be 300 dpi x 300 dpi.
   - For submittals containing color information important to the record, a 24-bit color setting should be used.
   - Submittals are to be legible and in the format specified on the submittal checklist.
   - Pen and ink changes are to be made in non-erasable ink, legible, dated and initialed.
   - Mark specific options provided for the work, and cross out options not provided.
   - Each submittal shall be sent as a single pdf file unless otherwise specified.
d. Label submittals with the applicable item number, reference, and requirement description as summarized in the Submittal Checklist. Unlabeled submittals will be returned to the Seller without review.
e. Include with submittals a transmittal letter that identifies individual documents by specification section.
   - Transmittal for submittals shall be numbered using the purchase order number followed by a 4-digit sequential number. (Example: 430001111-0001).
   - Embedded comments or questions that are not included on the transmittal may not be addressed/resolved by the Company.
f. Direction will be given at the time of award to either upload submittals to a company provided URL address or send by email to a company provided email address.
g. If using a company provided URL to upload submittals, notify the Company via email when submittals have been placed.
h. After review of a submittal, the Company will assemble comments and provide a status on the documents. An example of this submittal status stamp is shown below.

DOCUMENT REVIEW STATUS		
1	☐ Work may proceed.	
2	☐ Revise & resubmit. Work may proceed subject to incorporation of changes indicated.	
3	☐ Revise & resubmit. Work may not proceed.	
4	☐ Review not required. Work may proceed.	
Permission to proceed does not constitute acceptance or approval of design details, calculations, analysis, test methods developed or selected by the supplier and does not relieve supplier from full compliance with contractual obligations.		
REVIEWED BY:	Print Name/Signature :	Date:

i. If a submittal is being resubmitted, then reference the applicable item number, reference, and requirement description and identify it as a resubmittal.
j. Company response will only be returned to the Supplier for those submittals with a Submittal Purpose of "For Action," unless it is determined that a submittal transmitted "For Information" is not acceptable.
k. AFTER written approval is obtained, THEN proceed with work requiring approved submittals.
l. When approval submittals are required, work done before Company approval is at the Seller's risk.
m. Maintain a copy of the company-approved submittal and status page on file.

JCN-22212V (01-17)

ATTACHMENT A
SUBMITTAL CHECKLIST

SCHEDULE				FORMAT		PURPOSE	
AA	After Award	PTF	Prior to Fabrication	CD	Compact Disk	FA	For Action
AI	After Issue	PTFA	Prior to Final Acceptance/at Completion	DVD	Digital Video Disk	FI	For Information
AIT	After Inspection Test	PTL	Prior to Lift	EM	E-Mail		
AM	After Mobilization	PTM	Prior to Mobilization	EN	Electronic (Native)		
AP	After Proposal/Bid	PTS	Prior to Shipment	EP	Electronic (PDF)		
ATS	At Time of Shipment (Separately)	PTT	Prior to Test	O	Original		
B	Before Balance of Payment	PTW	Prior to Weld	P	Prints/Photocopies		
NTP	Notice to Proceed	Q	As Required	PH	Photographs		
PTC	Prior to Construction/Commencing Work	R	As Requested	S	Sample		
PTD	Prior to Delivery	WP	With Proposal/Bid	X	X-rays		

EPDM O-ring Submittal Checklist

Item No.	Reference	Requirement Description	Schedule	Format	No. of Copies	Purpose
1	4.1.1.1, 4.4, 4.6	An uncontrolled copy of the quality assurance program under which the Supplier will perform the work. Shall include document number, revision, approval signatures, and issuance date	WP	EP	1	FA, FI
2	3.12	UCN-13816B, *Request for Waiver or Deviation (RFWDs)*, if necessary	Q	EP	1	FA
3	3.6.2.2	Manufacturing Plan	PTF	EP	1	FA, FI
4	3.6.2.2, 3.8, 4.1.1.2, 4.4, 4.5	Proposed schedule for manufacturing, inspection, and test activities that will be used for determining hold/witness point for Company oversight	WP	EP	1	FA, FI
5	3.6.1	Procedure for hardness test in accordance with ASTM D2240 [1]	PTF	EP	1	FI
6	3.6.1	Procedure for tensile test in accordance with ASTM D412 [1]	PTF	EP	1	FI
7	3.6.1	Procedure for high temperature test in accordance with ASTM D573 [1]	PTF	EP	1	FI
8	3.6.1	Procedure for compression set test in accordance with ASTM D395 [1]	PTF	EP	1	FI
9	3.6.1	Procedure for low temperature test in accordance with ASTM D2137 [1]	PTF	EP	1	FI
10	3.6.1	Procedure for TR-10 test in accordance with ASTM D1329 [1]	PTF	EP	1	FI
11	3.6.1	Procedure for elongation test in accordance with ASTM D412 [1]	PTF	EP	1	FI
12	3.6.1	Procedure for Fourier transform infrared (FTIR) test in accordance with ASTM D3677 [1, 2]	PTF	EP	1	FI
13	3.6.1	Procedure for density test in accordance with ASTM D297 [1]	PTF	EP	1	FI
14	4.1.2.1	Procedure for dimensional inspection of O-ring cross section	PTF	EP	1	FA
15	4.1.2.3	Procedure for dimensional inspection of O-ring inside diameter	PTF	EP	1	FA
16	4.1.3.1	Procedure for visual inspection in accordance with ISO 3601-3, Grade CS	PTF	EP	1	FA

EPDM O-ring Submittal Checklist

Item No.	Reference	Requirement Description	Schedule	Format	No. of Copies	Purpose
17	4.5	Approval data documents for First Article Evaluation (FAE)	PTF	EP	1	FA
18	4.6	Certificate of Conformance including CGS requirements	PTS, ATS	EP, P	2	FA
19	4.6.1	Certified Data Package	PTS, ATS	EP, P	2	FA
20	4.4.12	Measuring and test equipment (M&TE) calibration reports per ISO 17025	PTF	EP	1	FA
21	3.10.1.1	Cleaning procedure	PTF	EP	1	FI
22	3.10.1.4, 3.10.1.5	Certificate of Conformance for packaging material	PTF	EP	1	FA
23	4.1.2.2, 4.6.1	Dimensional Lab temperature and humidity report that monitors O-ring dimensional inspection	PTFA	EP	1	FA
24	4.1.2.4, 4.6.1	Daily Calibration Report for measuring equipment prior to O-ring dimensional inspection	PTFA	EP	1	FA
25	3.6.1.1, 4.6.1	Time stamped photos of raw material secure storage of raw material with serialized TIDs	PTFA	EP	1	FA

Notes:

[1] Items 5 through 13: Procedures for property testing are not required if testing agency (testing laboratory with ISO 17025 accreditation for property and chemical testing) follows ASTM guidance.

[2] Item 12: FTIR in accordance with ASTM D3677, Sect 10.1.8, "Concentrate the centrifuged or filtered solution to a small volume under vacuum in a stream of nitrogen." Alternate drying methods such as drying on a hot plate followed by low temperature oven are acceptable, FTIR identification / signature is proven not to be affected by alternate drying methods.

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Appendix 1.3.10
SPC M801580-0004, *ES-3100 Heavy Can Spacer Assemblies*

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APPROVAL / REVISION PAGE

** For Company Use Only - Do Not Provide To Supplier **

QUALITY LEVEL	PROTECTION LEVEL	BUILDING
Q	C	N/A

PROJECT TITLE	JOB TITLE
ES-3100 Shipping Package	Heavy Can Spacers

ITEM DESCRIPTION	UNID
ES-3100 Heavy Can Spacer Assemblies	YAREA-CMH-042

REVISIONS

REV. NO:	DESCRIPTION OF REVISION
00	Initial Issue

REFERENCE DOCUMENTS & OTHER INFORMATION

This Engineering Procurement Document contains Scientific, Technical, or Operational Information (STI) and therefore must go through the Information Release Office prior to release.

Recommended supplier:
TBD

Upon delivery, implement Level C storage requirements.
In-Storage Maintenance Requirements – None

References for Company Use:

Receipt Inspection Checklist (Attached)
Design Verification Record: DV-801580-0020
TE&AP #: TEA 801580-0001

Other reference documents needed by the Supplier: None

This document has been reviewed by a Y-12 DC/ UCNI RO and has been determined to be UNCLASSIFIED and contains no UCNI. This review does not constitute clearance for Public Release.
Name: Date:
Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2020.01.22 15:41:39 -05'00'

APPROVALS

PRINT	SIGNATURE/DATE	PRINT	SIGNATURE/DATE
PREPARED BY L. C. Hooper	Lloyd Hooper Digitally signed by Lloyd Hooper Date: 2020.01.09 14:19:36 -05'00'	DISCIPLINE MANAGER J. C. Anderson	James C (J5A) Anderson Digitally signed by James C (J5A) Anderson Date: 2020.02.07 09:42:49 -05'00'
DESIGN VERIFICATION R. D. Aigner	Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2020.02.06 13:45:02 -05'00'	SYSTEM ENGINEER R. D. Aigner	Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2020.02.06 13:45:17 -05'00'
PACKAGING ENGINEER N. A. Laney	Noelani A (NLI) Laney 2020.01.27 08:52:30 -05'00'	OPERATIONS/SYSTEMS OWNER S. K. Thomas	Stan (TSW) Thomas Digitally signed by Stan (TSW) Thomas Date: 2020.02.06 13:15:23 -05'00'
NUCLEAR PROD. ENGINEER J. E. Cook	Jeffrey E (2XK) Cook Digitally signed by Jeffrey E (2XK) Cook Date: 2020.01.27 15:32:02 -05'00'	QUALITY ENGINEER J. R. Burchfield	Jason (JR6) Burchfield Digitally signed by Jason (JR6) Burchfield Date: 2020.01.23 05:39:15 -05'00'

RECEIPT INSPECTION CHECKLIST	DOC TYPE	RIC DOC. #	PART #	REV. #	PAGE
Form instructions – EPD Preparer should complete all spaces pertaining to the specification of the item (shown in red). The individual performing receipt inspection should complete all spaces pertaining to the inspection of the received item (shown in blue). Multiple copies of the RIC may be used for POs with multiple items. Attach comments & other documentation as needed					1 of 2

A. GENERAL INFORMATION

SPECIFIED

ITEM DESCRIPTION	UNID
ES-3100 Heavy Can Spacer Assemblies	YAREA-CMH-042

QUALITY LEVEL	PROTECTION LEVEL	SAMPLE SIZE: BASED ON NORMAL SAMPLING PLAN IN ACCORDANCE WITH Y17-69-316 CHAPTER 6, ATTACHMENT 6-C	PROCUREMENT QUALITY STRATEGY
Q	C		Evaluated

RECEIVED

ITEM DESCRIPTION	SAT Y or N	INITIALS	DATE

PO#:	ITEM #	QTY ORDERED:	SHIPMENT COMPLETE or PARTIAL	SHIPMENT #: of	QTY REC'D/ LOT SIZE:	QTY INSPECTED/ SAMPLE SIZE:

RELATED APPROVED WAIVERS/DEVIATIONS:

B. SUPPLIER PACKAGING, HANDLING, SHIPPING, & STORAGE (INCL. MAINTENANCE)

SPECIFIED: Per the approved plan for packaging, handling, shipping, and storage as noted in Equipment Specification.

RECEIVED:	SAT Y or N	INITIALS	DATE

C. ITEM SUPPLIER/MANUFACTURER INFORMATION

	IF SPECIFIED AS A REQUIREMENT	RECEIVED
SUPPLIER/MFR	N/A	
MANUFACTURER	N/A	
MODEL #	N/A	
PART #	N/A	
		SERIAL #:

	SAT Y or N	INITIALS	DATE
Suspect/Counterfeit Item Inspection, Review of S/CI Notifications & Item Markings			

D. MEASUREMENT AND TEST EQUIPMENT (M&TE used for receipt inspection) *(add additional pages if needed)*

M&TE TYPE	M&TE NUMBER	CALIBRATED RANGE	TOLERANCE	CAL. DUE DATE

E. COMPANY PACKAGING, HANDLING, SHIPPING, & STORAGE (INCL. MAINTENANCE)

SPECIFIED: PROTECTION LEVEL C

	Y or N	INITIALS	DATE
Communicated requirements to Company Material Management			

RECEIPT INSPECTION CHECKLIST	DOC TYPE	RIC DOC. #	PART #	REV. #	PAGE
					2 of 2

F. SALIENT FEATURE EVALUATION

CRITICAL CHARACTERISTICS	NUC PROC OR CGD METH #	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Fill Height	CGD Method 3	INSPECTION	PQE	PQR	PQE	Y, N, N/A
TE&AP # IF CGD	**ACCEPT. CRITERIA W/ TOLERANCE/ RANGE**		**ACTUAL**	**SAT**	**INITIALS**	**DATE**
TEA 801580-0001	1.37 ± 0.06 inches			Y or N		

CRITICAL CHARACTERISTICS	NUC PROC OR CGD METH #	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Outside diameter of filled can excluding seams	CGD Method 3	INSPECTION	PQE	PQR	PQE	Y, N, N/A
TE&AP # IF CGD	**ACCEPT. CRITERIA W/ TOLERANCE/ RANGE**		**ACTUAL**	**SAT**	**INITIALS**	**DATE**
TEA 801580-0001	4.13 ± 0.09 inches			Y or N		

CRITICAL CHARACTERISTICS	NUC PROC OR CGD METH #	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Filled Can Weight	CGD Method 3	INSPECTION	PQE	PQR	PQE	Y, N, N/A
TE&AP # IF CGD	**ACCEPT. CRITERIA W/ TOLERANCE/ RANGE**		**ACTUAL**	**SAT**	**INITIALS**	**DATE**
TEA 801580-0001	Minimum Weight: 1.16 lb Maximum Weight: 1.56 lb			Y or N		

CRITICAL CHARACTERISTICS	NUC PROC OR CGD METH #	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Neutron absorption	CGD Method 3	INSPECTION	PQE	PQR	PQE	Y, N, N/A
TE&AP # IF CGD	**ACCEPT. CRITERIA W/ TOLERANCE/ RANGE**		**ACTUAL**	**SAT**	**INITIALS**	**DATE**
TEA 801580-0001	Net count rate acceptance measurements as specified in Form AD of SOW M801580-0009			Y or N		

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Assembly rigidity	INSPECTION	PQE	Visual Inspection	PQE	Y, N, N/A
ACCEPT. CRITERIA W/ TOLERANCE/ RANGE		**ACTUAL**	**SAT**	**INITIALS**	**DATE**
Assembly is metal and filler material is installed and solid.			Y or N		

IMPORTANT FEATURES	INSPECTION AND/OR TEST	TO BE WITNESSED BY	REQ'D OBJ EVIDENCE	TO BE REVIEWED BY	REC'D ?
Product Identification	INSPECTION	PQE	Visual Inspection	PQE	Y, N, N/A
ACCEPT. CRITERIA W/ TOLERANCE/ RANGE		**ACTUAL**	**SAT**	**INITIALS**	**DATE**
Verify Cans Inspected at the Supplier's Facility are the Cans Received at Y-12 by Drawing No. with Rev., Purchase Order No., and Serial No. and that No Visual Damage has Occurred during Shipment.			Y or N		

G. DISPOSITION

APPLICABLE PQR # AND/OR NCR #: ATTACH COMMENTS & OTHER DOCUMENTATION AS NEEDED	QUANTITY APPROVED:	QUANTITY REJECTED:

H. AUTHORIZATION

EVALUATOR SIGNATURE	ORGANIZATION	BADGE	DATE

CONTENTS

1 SCOPE 2
1.1 DEFINITIONS 2
2 APPLICABLE DOCUMENTS 5
2.1 STANDARDS 5
2.2 COMPANY DOCUMENTS 5
2.3 REFERENCED DOCUMENTS (NOT PROVIDED WITH REQUEST FOR PROPOSAL) 5
3 REQUIREMENTS 6
3.1 GENERAL REQUIREMENTS 6
3.2 EQUIPMENT REQUIREMENTS 6
3.3 277-4 NEUTRON ABSORBER 7
3.4 CLEANING REQUIREMENTS 11
3.5 SCHEDULE 11
3.6 DELIVERABLES 12
3.7 PACKAGING, HANDLING, SHIPPING, AND STORAGE REQUIREMENTS 12
3.8 MARKING AND IDENTIFICATION REQUIREMENTS 12
3.9 REQUESTS FOR WAIVER OR DEVIATION 13
4 QUALITY ASSURANCE 13
4.1 QUALITY ASSURANCE PROGRAM 13
4.2 ES−3100 CASTING QUALITY ASSURANCE REQUIREMENTS 13
FORM A 277-4 DRY BLEND BATCH CONTROL 15
FORM B 277-4 WET MIX CONTROL (OVERCAST OR SPECIAL BATCH) 16
FORM C ES-3100 HEAVY CAN SPACER ASSEMBLY LOT CASTING CONTROL 17
FORM D ES-3100 COMPANION SAMPLE CASTING CONTROL 18
ATTACHMENT A: SUBMITTAL CHECKLIST 19
ATTACHMENT B: INSTRUCTIONS TO SUPPLIER FOR PREPARATION OF SUBMITTALS 20
ATTACHMENT C: ABBREVIATIONS AND ACRONYMS 21

1 Scope

This specification describes the requirements for the procurement, preparation, casting, and verification of a neutron absorber material into the ES-3100 Heavy Can Spacer Assemblies. The neutron absorber material shall be cast into the ES-3100 Heavy Can Spacer Assembly (Figure 1), and 10 oz. double friction can (Figure 4).

The Company (Y-12 National Security Complex) will provide training and direct oversight for the casting of the 277-4 Neutron Absorber when the Supplier does not have prior 277-4 casting experience.

1.1 Definitions

277-0 - Shieldwerx Catalog No. SWX-277-0 or equivalent, Heat Resistant Shielding "Non-Borated" high alumina cement.

277-4 - A mixture of 277-0 and boron carbide (B4C) powder to form a neutron absorber material.

Companion Sample Cans - The 10 oz. double friction style cans in Figure 4 used for sampling.

Company – The Company, as used in this specification, is the buyer of the Supplier's final product (i.e., Y-12 National Security Complex)

Dry Batch - A dry mix of batch size of 277-4.

Dry Blend Batch - A thoroughly mixed Dry Batch.

Heavy Can Spacer Assembly - The 10 oz. crimp style can in Figure 1.

Overcast – Additional cast material required to achieve the fill requirements.

PGNAA Subcontractor – Independent testing firm that performs the Prompt Gamma Neutron Activation Analysis on the companion sample cans for the Company.

Process Procedures - Dry mixing, wet mixing, casting, sampling, and inspection procedures.

Supplier - The manufacturer of the ES-3100 Heavy Can Spacer Assemblies.

Wet Mix Batch - A wet mix of Dry Blend Batch and water.



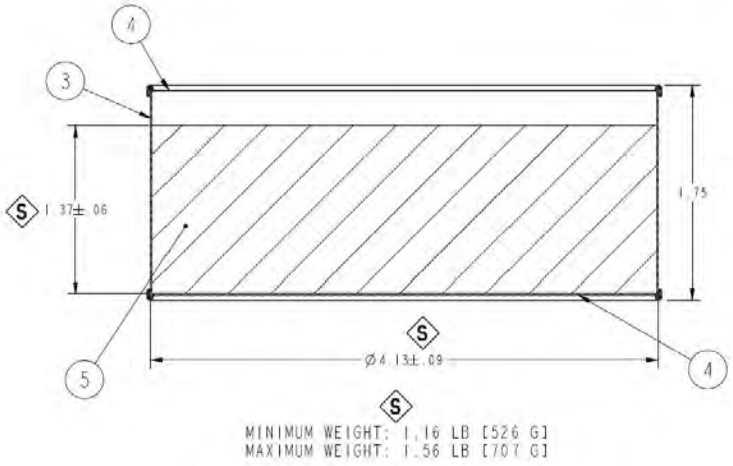
HEAVY CAN SPACER ASSEMBLY
(Rev 0 depicted, latest revision may differ)

Figure 1



10oz CRIMP STYLE CAN
FILLED WITH 277-4
(Rev 0 depicted, latest revision may differ)

Figure 2



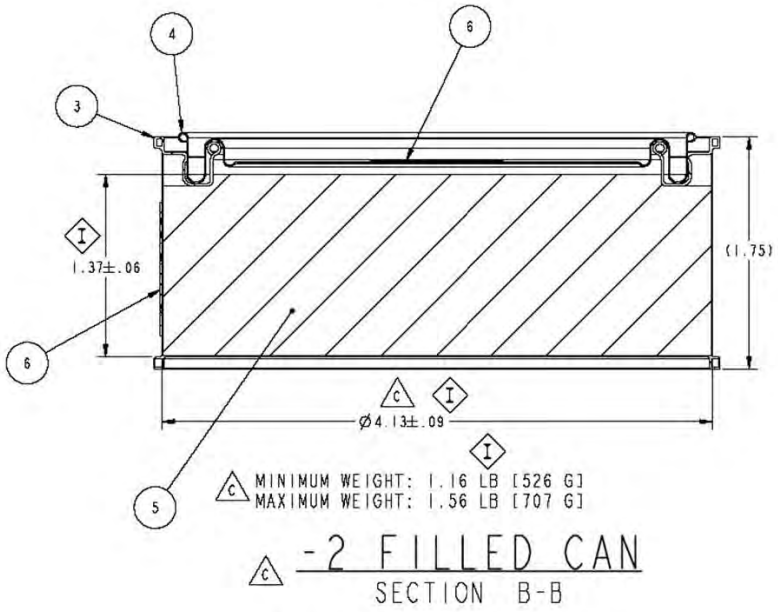
10oz CRIMP STYLE CAN
FILLED WITH 277-4

Figure 3



10oz DOUBLE FRICTION CAN
FILLED WITH 277-4

Figure 4



10oz DOUBLE FRICTION CAN
FILLED WITH 277-4

Figure 5

2 Applicable Documents

The following documents are a part of this specification. When there is a conflict between the specification and the applicable documents, the Supplier shall bring it to the attention of the Company for resolution.

2.1 Standards

ASME NQA-1 2008	*Quality Assurance Requirements for Nuclear Facility Applications*
ASME NQA-1A-2009	*NQA-1 Addendum*
ASTM A 380-2017	*Standard Practice for Cleaning, Descaling, and Passivation of Stainless Steel Parts, Equipment and Systems*
ASTM C 750-2018	*Specification for Nuclear-Grade Boron Carbide Powder*
ASTM C 791-2019	*Standard Test Methods for Chemical, Mass Spectrometric, and Spectrochemical Analysis of Nuclear-Grade Boron Carbide*
ASTM C371-2009 (R 2018)	*Standard Test Method for Wire-Cloth Sieve Analysis of Nonplastic Ceramic Powders*
ASTM E105-2016	*Standard Practice for Probability Sampling of Materials*
ASTM E 11-2017	*Standard Specification for Woven Wire Test Sieve Cloth and Test Sieves*
10 CFR 71 Subpart H	*Code of Federal Regulations - Energy - Packaging and Transportation of Radioactive Material - Quality Assurance*
DOE O 414.1D	*Quality Assurance - DOE Directives*
ISO/IEC 17025	*General Requirements for the Competence of Testing and Calibration Laboratories*

2.2 Company Documents

M2E801580A043	*Heavy Can Spacer Assembly (SST)*
M2E801580A026	*Heavy Can Spacer Assembly*

2.3 Referenced Documents (Not Provided with Request for Proposal)

DAC-PKG-801624-A001	*Mixing Weights And Elemental Composition of 277-4 Neutron Poison used in the ES-3100*

3 Requirements

3.1 General Requirements

The Supplier shall be responsible for supplying all materials, services, facilities, and equipment to meet the requirements of this specification unless otherwise noted. Items needed to meet the requirements of this specification that are not identified in this specification shall be specified by the Supplier and submitted to the Company in accordance with Attachment A.

3.2 Equipment Requirements

3.2.1 Certified Scales

All equipment and instruments (Measuring and Testing Equipment (M&TE)) used in the conduct inspections shall bear a calibration sticker that shows the equipment to be within its calibration period. Calibrations must be performed by a laboratory that meets ISO 17025. All calibration sources shall be traceable to the National Institute of Standards and Technology (NIST). All certification documentation shall be submitted to the Company in accordance with Attachment A.

3.2.2 Dry Blending the 277-0 and B_4C

A small parts tumbler shall be used to dry blend the ingredients. The small parts tumbler shall be a Multi-Barrel Small Parts Tumbler Benchtop Base (McMaster-Carr No. 44235A11) with Multi-Barrel Small Parts Tumbler 8 Gallon Barrel, 15-3/4" Dia X 14-3/4" W (McMaster-Carr No. 44235A24).

3.2.3 Mortar or Plaster Mixer

A mortar or plaster type mixer with moving vanes to shear the wet mix shall be used. The batch volume is approximately 0.5 ft^3 (15 quarts or 3.8 gallons). Therefore, it is recommended that the mixer volume should be 1.5 to 2 times the mix volume or around 0.75 to 1.0 ft^3 (22.5 to 30 quarts, ~6 to 8 gallons). The 277-4 wet mix is thixotropic when mixed and it is recommended that a heavy duty adjustable vibrator mounted to the mixer for both mixing and pouring is used.

3.2.4 Small Plaster Mixer

A drill-powered mortar or plaster mixer and a 5-gallon plastic bucket may be used on small batches of 277-4 instead of the mortar or plaster type mixer.

3.2.5 Bench Vibrator

A bench vibrator shall be used during the mixing of the companion sample cans and Heavy Spacer Can Assemblies. The bench vibrator shall be Tabletop Vibration/Mixing Table 10-in. by 7-in. Platform, 10-lb Capacity Continuous Use (McMaster-Carr No. 5714K61).

3.3 277-4 Neutron Absorber

3.3.1 Raw Casting Material Requirements and Inspection

3.3.1.1 277-0

Shieldwerx Catalog No. SWX-277-0 Heat Resistant Shielding "Non-Borated" shall be procured. The manufacturer model or catalog number and expiration date shall be clearly indicated on the container. A Certificate of Conformance shall be provided with each lot or batch. The Certificate of Conformance shall include the lot or batch number and the expiration date package **in accordance with the submittal checklist, Attachment A**. The 277-0 shall be sealed and stored in a dry place.

3.3.1.2 Type 1 Nuclear-Grade Boron Carbide Powder

The $^{nat}B_4C$ Manufacturer shall supply the Supplier with a CoC stating that the $^{nat}B_4C$ is Type 1 Nuclear Grade $^{nat}B_4C$ and 99.90% of the material has passed through a No. 140 sieve per ASTM E 11. The Supplier shall submit Sampling Plans per ASTM E105 for Company approval in accordance with the submittal checklist, Attachment A. The Company will supply test results to the Supplier from samples obtained from the $^{nat}B_4C$ Manufacturer. A test report will be submitted to the Supplier for inclusion into the final data package. The $^{nat}B_4C$ **shall not be shipped** from the $^{nat}B_4C$ Manufacturer **prior to Company approval.** A copy of the CoC shall be submitted with the final data package **in accordance with the submittal checklist, Attachment A.**

3.3.1.3 ^{10}B Content

B_4C powder shall be procured as Type 1 Nuclear-Grade Boron Carbide Powder per ASTM C 750. The ^{10}B content shall be verified to meet the amount as stated in ASTM C 750 by a testing subcontractor, determined by testing of batch samples per ASTM C791.

3.3.1.4 Water

The water shall be potable, filtered through a 20-micron filter and an activated charcoal filter, have a chlorine content of less than 4 ppm, and have a temperature of 65 ± 15°F. Unfiltered potable water may be used for the cleaning of equipment used to cast the neutron absorber system.

3.3.2 Dry Blending Process

3.3.2.1 Dry Batch

A dry batch of 277-4 shall be a mixture of 93.6 wt% 277-0 and 6.4 wt% B_4C. The tolerance for 277-0 and B_4C weighting shall be the following:

277-4 Dry Batch Size	277-0	B_4C
Equal to or greater than 30 lbs.	±0.2 lbs.	±.01 lbs.
Less than 30 lbs	±.01 lbs.	±.01 lbs.

The data shall be recorded on Form A.

3.3.2.2 Blended Dry Batch

The dry batch of 277-4 shall be thoroughly blended. The data shall be recorded on Form A.

If the blended dry batch is not used immediately, the blended dry batch shall be sealed and stored in a dry place with a Blended Dry Batch control number attached to the container.

The Blended Dry Batch shall not be used if the 277-0 expiration date has expired.

3.3.3 Wet Mixing

The weight of the dry mix and water shall be to the following weight proportions of 100% dry mix and 27 ± 1% water. The 277-4 is thixotropic when mixed. It is recommended to have a heavy duty adjustable vibrator mounted to the mixer for both mixing and pouring. Place the water in the mixer and add the dry mix into the water. Before casting, mix the dry powder and water for at least 3 minutes and less than 60 minutes. Any material in the mixer after 60 minutes shall be discarded. Mix only in a room with a temperature range of 70 ± 25°F.

The data shall be recorded on the appropriate form, i.e., Form C for ES-3100 Heavy Can Spacer Assembly/PGNAA Acceptance Standards.

3.3.4 Heavy Can Spacer Assembly

The Heavy Can Spacer Assembly shown in Figure 1 shall be the 10-oz. crimp style stainless steel can as shown in Figures 2 and 3. The cured casting weight for each can shall be measured and the cured casting density recorded on Form C. A cured cast density of 100 to 120 lb/ft^3 and a cured weight range of 1.16 to 1.56 lbs shall be acceptable. If the cured casting density is outside the acceptable range, a copy of the form shall be sent to the Company in accordance with Attachment A.

Two cans from the middle of the lot on Form C, i.e., a maximum lot of 22 cans, shall be selected and identified as companion sample cans. Cans that are not from the middle of the lot on Form C may be selected with Company approval.

3.3.5 PGNAA Acceptance Standards

The PGNAA Acceptance Standards shall be made with a Company representative witnessing the manufacturing processes of weighing, blending, wet mixing, and casting. The PGNAA Acceptance Standards shall be the 10-oz. double friction style metal cans as shown in Figures 4 and 5. The cured casting weight for each can shall be measured and the cured casting density recorded on Form C. A cured casting density of 100 to 120 lb/ft^3 and a cured casting weight of 1.16 to 1.56 lbs shall be acceptable. If the cured casting density is outside the acceptable range, a copy of the form shall be sent to the Company in accordance with Attachment A.

One can from the middle of the lot on Form C, i.e., a maximum lot of 22 cans, shall be selected and identified as a companion sample can for Loss On Drying (LOD) testing. The remainder of the lot shall be sent to the PGNAA Subcontractor.

3.3.6 Companion Sample Cans

Companion sample can data shall be recorded on Form D.

a. The cured casting density of all companion sample cans shall be calculated per Section 3.3.8.2 and recorded on Form D. If the cured casting density is outside the acceptable range, a copy of the form shall be sent to the Company in accordance with Attachment A. The cured casting density of a companion sample outside the acceptable range can shall not be a reason to reject the Heavy Can Spacer Assembly casting lot or PGNAA Acceptance Standards casting lot.

b. The odd serial number companion sample cans for the Heavy Can Spacer Assembly casting lot or PGNAA Acceptance Standards casting lot shall be LOD tested to verify the hydrogen content per Section 3.3.8.3.
c. The even serial number companion sample cans for the Heavy Can Spacer Assembly casting lot shall be PGNAA tested to verify the ^{10}B content per Section 3.3.8.4.

3.3.7 Casting the 10 oz. Double Friction Metal Cans or 10 oz. Crimp Style Cans

a. Weigh the empty labeled can and lid and record the casting can data on Form C. It is acceptable to weigh ten cans with ten lids for each purchase order of cans and to use the average can and lid weight on each form.
b. Weigh the water and measure the water temperature. Record this data on Form C. Fill with water only up to the bottom of the inside rim. The can lid shall be on the scale. It is acceptable to weigh the water weight of the first ten cans with ten lids of the same lot of cans and to use the average water weight for each of the following cans if the measurements are consistent.
c. Remove the water from the cans.
d. Prepare the Wet Mix Batch following Section 3.3.3.
e. Hold the can on the bench vibrator during filling with the 277-4 wet mix. Quickly vibrate and continue to add wet mix to the can lip.
f. Once all of the cans are full of wet mix, return the first can back to the vibrator for at least 3 minutes at a high frequency setting. During the 3 minutes of vibration, continue to add 277-4 wet mix until the can stays full. Repeat this process for all the cans in the casting lot.
g. Between 1 to 24 hours after casting, scrape the top of the casting to meet 1.37 ± 0.06 dimension from bottom of can noted on Figures 3 or 5.
h. Clean the can rim around the edge per Section 3.4.2.
i. Perform an in-process measurement of the scraped casting height to ensure that the casting height parameters are met shown in Figures 3 or 5.
j. Cover the casting by placing the properly labeled can lid on the can for 7 days.
k. Remove the can lid and let the can air dry or use either or both vacuum and heat to create an acceptable density and weight. If heat is used, the maximum temperature of the can shall not exceed 250°F.
l. Measure casting height and weigh the can with lid. Record this data on Form C.
m. Record the final Companion Sample Can casting density, weight, or casting height measurements data on Form D.
n. Crimp lid onto crimp style can or plug lid onto double friction style can, as applicable.

3.3.8 Verification

All verification shall be completed after the casting is cured.

3.3.8.1 Cured Casting Density Verification

The density of cured casting in the Heavy Can Spacer Assembly and PGNAA Acceptance Standards shall be determined by weighing the casting container before casting, while filled with water, after casting, and when cured. Since the density of water is known, a simple relationship between the weight differences shall determine the cured casting density.

$$Density = \left(\frac{Cured - Empty}{WithWater - Empty} \right) \times 62.3 \quad lb/ft^3$$

3.3.8.2 Companion Sample Can Cured Casting Density Verification

The density of cured casting in each companion sample can shall be determined by weighing the can before casting, while filled with water, after casting, and when cured.

Since the density of water is known, a simple relationship between the weight differences shall determine the cured casting density.

$$Density = \left(\frac{Cured - Empty}{WithWater - Empty} \right) \times 62.3 \quad lb/ft^3$$

3.3.8.3 Companion Sample LOD Verification

The companion sample cans identified in Section 3.3.6.b shall be LOD tested. The acceptable LOD percent range shall be based upon the companion sample can cured casting density in Section 3.3.8.2. The Acceptable Maximum and Minimum LOD% at Density is in this table developed from data in DAC-PKG-801624-A001 Table 7, 277-4 Composition @ Extreme Densities and LOD% and compared to the average values as manufactured.

Acceptable Maximum and Minimum LOD% at Density		
Density (lb/ft^3)	Maximum LOD%	Minimum LOD%
100	31.80%	28.61%
101	32.47%	28.33%
102	33.12%	28.06%
103	33.77%	27.79%
104	34.40%	27.52%
105	35.03%	27.26%
106	35.64%	27.00%
107	36.25%	26.75%
108	36.84%	26.50%
109	37.42%	26.25%
110	37.99%	26.01%
111	38.56%	25.78%
112	39.11%	25.55%
113	39.65%	25.32%
114	40.18%	25.10%
115	40.70%	24.88%
116	41.21%	24.66%
117	41.71%	24.45%
118	42.20%	24.25%
119	42.68%	24.05%
120	43.15%	23.85%

a. The lid shall have the serial number permanently transferred by vibro etch or other method.

b. The lid shall have a small vent hole in it. It is recommended that a nail be used to punch a hole 0.12 ± 0.06 in. diameter in the metal lid from the inside surface of the lid.

c. Match the can serial numbers and place the lid on the can.

d. The weight of the can shall be recorded on Form D.

e. The cans shall be placed in an oven at 1500 ± 150°F (800°C) for 4 hours.

f. The weight of the can shall be recorded on Form D with the can temperature not below 100°F.

g. Calculate the LOD% using the equation below and record it on Form D. Due to can oxidizing and gaining weight during the heating cycle, a 0.024 lb correction factor is included in the following LOD% calculation.

$$\text{LOD\%} = \left[1 - \frac{(LOD Weight - Empty - 0.024 lb)}{(Cured \,\&\, Clean - Empty)}\right] \times 100\%$$

h. Verify that the LOD% is within the acceptable range. If water content is outside the acceptable range, a copy of the form shall be submitted to the Company in accordance with Attachment A.

3.3.8.4 PGNAA Verification

The PGNAA Acceptance Standards in Section 3.3.5 and Companion Sample Cans identified in Section 3.3.6.c shall be sent to the PGNAA Subcontractor.

3.4 Cleaning Requirements

3.4.1 Contact with Chlorides or Fluorides

The stainless steel material shall be protected from contact with chlorides in accordance with ASTM A380, paragraph 8.5, during all operations including packaging. The Safety Data Sheet (SDS) for all cleaning solutions or products used on the ES-3100 Heavy Can Spacer Assemblies shall be submitted to the Company in accordance with Attachment A.

3.4.2 Satisfactory Cleanliness

Cleaning procedures for the stainless steel shall be submitted to the Company in accordance with Attachment A. Only non-chloride-bearing chemicals shall be used for cleaning (e.g., trisodium phosphate detergent or acetone). Water used in cleaning shall have a maximum chlorine content of 4 parts per million.

After casting but prior to packaging, stainless steel cans shall be cleaned per the approved cleaning procedures. Satisfactory cleanliness shall be determined by visual inspection as can be observed by a person with normal visual acuity (natural or corrected) and without magnification. Light intensity of at least 100 ft-candles shall be provided on the surface to be inspected.

3.5 Schedule

The Supplier shall prepare a proposed schedule for the fabrication of the ES-3100 Heavy Can Spacer Assemblies specified herein. This proposed schedule shall be submitted with the offer in accordance with Attachment A.

The Company will conduct oversight activities. Hold/witness points will be identified by the Company in the Supplier's schedule after it is submitted to the Company for review.

3.6 Deliverables

The deliverables for this specification includes, but is not limited to:

a. Completed and assembled ES-3100 Heavy Can Spacer Assemblies.

b. All Requests for Waiver/Deviations (RFWDs) shall be closed.

c. All submittal documentation in accordance with Attachment A, with applicable documentation in data packages specific to each ES-3100 Heavy Can Spacer Assembly serial numbers.

The documentation required with the proposal (WP) as indicated in the "Submittal Checklist," Attachment A, shall be submitted to the Company in the quantities listed with the Supplier's offer. Submittals shall be e-mailed to the Company Subcontract Administrator (SA) and the Subcontract Technical Representative (STR).

The Company will review the submittals that are required prior to fabrication as indicated in the "Submittal Checklist," Attachment A, and respond as shown in the "Instructions to Supplier for Preparation of Submittals," Attachment B, Item h.

The Company shall review the submittals required per Attachment A. Shipping shall not commence without documented permission from the Company.

3.7 Packaging, Handling, Shipping, and Storage Requirements

3.7.1 A packing plan for shipment of ES-3100 Heavy Can Spacer Assemblies shall be sent to the Company for approval in accordance with Attachment A.

3.7.2 The ES-3100 Heavy Can Spacer Assembly surfaces must be protected during shipment.

3.7.3 The Supplier shall not ship ES-3100 Heavy Can Spacer Assemblies with unapproved RFWD's.

3.8 Marking and Identification Requirements

3.8.1 The ES-3100 Heavy Can Spacer Assemblies shall be marked as specified on the Company's drawing M2E801580A043.

3.8.2 Permanent serial numbers for each ES-3100 Heavy Can Spacer Assembly shall be assigned by the Company and identified in the Purchase Order.

3.9 Requests for Waiver or Deviation

3.9.1 After award, if a waiver or deviation from the specified requirements is desired, then the Supplier shall submit to the Company a Request for Waiver or Deviation form: UCN-13816B. The Company will provide this form upon request.

3.9.2 Use the UCN-13816B form to request permission to change or deviate from the specified requirements; obtain Company approval before proceeding with any changes.

3.9.3 Email the completed form to the STR.

3.9.4 Use the form to report any of the following conditions:

a. A request for deviation from the contract requirements.

b. Anytime a requirement contained within the original specification or a contract modification approved by the Company is violated.

c. There is nonconformance that cannot be corrected unless an item or process is modified, reworked, or repaired to an equivalent functional condition.

d. A request for Company approved substitutions shall be submitted using the RFWD form for Company approval prior to implementation. Adequate information shall be provided with the request so that the Company can determine if the item is equivalent.

4 Quality Assurance

4.1 Quality Assurance Program

The Supplier shall have implemented and maintain a quality system in accordance with ASME NQA-1 2008, 1a-2009, Part 1, Sections 1-18 (excluding requirement 3), and 10 CFR 71 Subpart H and DOE O 414.1D Attachment 3, with respect to Suspect Counterfeit Items. A copy of the Supplier's QA Program Manual shall be submitted with the bid in accordance with Attachment A for review and approval. The Supplier shall comply and conduct all work in accordance with their Quality Assurance program and this Equipment Specification. Company will provide the critical characteristics for any items or services to be dedicated.

4.2 ES−3100 Casting Quality Assurance Requirements

4.2.1 ES−3100 Heavy Can Spacer Assembly Documentation Package

All records shall be identified based on the ES−3100 Heavy Can Spacer Assembly serial numbers. The Documentation Package shall be provided in accordance with Attachment A with each ES-3100 Heavy Can Spacer Assembly casting lot. The Documentation Package shall be complete, legible, indexed, and traceable to the material supplied and include the following:

a. Material measuring, dry blending, wet mixing, casting, sampling, and inspection forms, i.e, Forms A through D.

b. A Certificate of Compliance for each lot of the 277-0 Heat Resistant Shielding "Non-Borated" dry mix documentation with the expiration date identified on each container.

c. Certificate of Compliances for B_4C powder to Type 1 Nuclear-Grade Boron Carbide Powder per ASTM C 750, chemical and elemental analysis per ASTM C 791, and 99.90% of the powder passes through a No. 140 Sieve per ASTM E 11.

d. A Certificate of Compliance signed by an officer of the Supplier confirming that the cast neutron absorber in the ES−3100 Heavy Can Spacer Assemblies meets the subcontract requirements.

4.2.2 Batch Processes

Batch processes such as mixing, pouring, curing, sampling, inspection, etc., shall be performed in accordance with detailed written procedures. These procedures shall specifically describe the exact manner in which these processes are to be performed. All records shall be traceable to the PGNAA Acceptance Standards or Companion can serial numbers.

4.2.3 Materials Traceability

A manufacturing lot or batch number shall identify material furnished to make up the neutron absorber system. Materials shall be identified by material type; applicable specification and revision number, and be traceable to their lot numbers. Traceability records shall be available for review by the Company's SA or STR.

4.2.4 Procedures

Preparation, installation, sample collection, and inspection processes shall be controlled and performed by qualified personnel. The procedures must incorporate a mechanism to identify process step completion. Procedures shall be submitted prior to fabrication in accordance with Attachment A.

4.2.5 Training and Qualification of Personnel

The Supplier shall provide for the training and qualification of personnel to ensure their competence in the use of process procedures and specifications. Records of personnel qualifications shall be made available to the Company upon request in accordance with Attachment A. Note: If the Supplier does not have prior experience in casting 277-4 Neutron Absorber, the Company will provide training and direct oversight on the processes.

4.2.6 The Company reserves the right to request any documentation and to witness any of the processes performed in accordance with this specification.

FORM A 277-4 Dry Blend Batch Control

Casting Company Name	Certificate of Conformance of the 277-0 dry mix		
Blended Dry Batch Control Number [a]	Record the expiration date of the 277-0 dry mix [b]		
Certificate of Conformance of the B_4C dry mix	277-0 Heat Resistant Shielding Drum ID Number		
Planning	277-4 Weight	Units	Operator
Batch Size		lb	
Operation	Measurement	Units	Operator
277-0 Weight (Target = 277-4 Weight x 93.6 wt%)		lb	
B_4C Weight (Target = 277-4 Weight x 6.4 wt%)		lb	
Dry Blending Time		min.	
Comments			

[a] A 10-digit Blended Dry Batch Control Number shall be used to define the date and the time of mixing the casting batch using the format with a 24-hour clock (i.e. 1021041515 is used for October 21, 2004 at 3:15 pm.)

[b] Record the expiration date of the Blended Dry Batch and confirm that it is still acceptable to be cast following this specification.

EXEMPT FROM IO-155 (8-02)

FORM B 277-4 Wet Mix Control (Overcast or Special Batch)

Casting Company Name		Blended Dry Batch Control Number		
Wet Mix Control Number (WMCN) [a]		Record the expiration date of the Dry Blend Batch		
Water Temperature °F	Air Temperature °F	Measurement	Units	Operator
277-4 Weight			lb	
Water Weight (Target = 277-4 Weight × 27±1 wt%)			lb	
Mix Time			min.	
Mix Finish Time			min.	
Comments				

[a] A 10-digit Wet Mix Control Number (WMCN) shall be used to define the date and the time of mixing the casting batch using the format with a 24-hour clock (i.e. 1021041515 is used for October 21, 2004 at 3:15 pm.)

FORM C ES-3100 Heavy Can Spacer Assembly Lot Casting Control

Casting Company Name			Can Lot Serial Number [a]				
Average 10 Can and Lid **Empty** Weight		Temperature of Water Weight (°F)		Average 10 Can and Lid **Water** Weight			
Wet Mix Control		Blended Dry Batch Control No.		Dry Blend Batch Expiration Date			
(Target Water = 277-4 Weight × 27±1 wt%)		277-4 Weight	lb	Water Weight	lb		
		Air Temperature	°F	Water Temperature	°F		
		Mix Time		Mix Finish Time			
Wet Mix Control Number (Overcast), if required							
Can Serial #	After Casting Weight (lb)	Cured Weight (lb)	Pass or Fail Cured Weight [b]	Cured Height (in)	Pass or Fail Cured Height [b]	Cured Density (lb/ft³)	Pass or Fail Cured Density [c]
Companion Samples [d]		−1			−2		
Operator		Comments					

[a] A 10-digit Can Lot Serial Number shall be used to define the date and the time of setup using the format with a 24-hour clock (i.e., 1021041515 is used for October 21, 2004 at 3:15 pm).

[b] Acceptable weight is 1.16 to 1.56 lbs and height 1.37 ± 0.06 as shown in Figure 3.

[c] Use this equation for the; $Density = \left(\frac{Cured - Empty}{WithWater - Empty} \right) \times 62.3$ lb/ft³. Acceptable 100 to 120(lb/ft³).

[d] Use Form D for Companion Samples.

FORM D ES-3100 Companion Sample Casting Control

Casting Company Name		Ave. 10 Can and Lid Empty Weight [a]			Ave. 10 Can and Lid Water Wgt. [a]		Temp. of Water Weight (°F)
Serial Numbers		Can Measurement Weights ±0.01 (lb)			For Record Only	Loss On Drying (Odd Serial Numbered Cans)	
Can Lot#	Companion Sample Can [a]	After Casting Weight	Cured Weight	LOD Weight	Cured Density (lb/ft³)	Calculated LOD%	Pass Or Fail per Sec. 3.3.8.3
Complied by					Comments		

[a] For the same lot of sample cans, it is acceptable to use an average weight of ten can bodies and ten can lids.
[b] Recommended vibration settings are at 450 VPM and three times the total vibrated weight. The total vibrated weight is the finish cast part and fixtures weight, for a setting of approximately 5 pound-force.

$$Density = \left(\frac{Cured - Empty}{WithWater - Empty} \right) \times 62.3 \text{ lb/ft}^3$$

$$\text{LOD\%} = \left[1 - \frac{(LODWeight - Empty - 0.024)}{(Cured\ \&\ Clean - Empty)} \right] \times 100\%$$

Attachment A: Submittal Checklist

SCHEDULE				FORMAT		PURPOSE	
AA	After Award	PTF	Prior to Fabrication	CD	Compact Disk	FA	For Action
AI	After Issue	PTFA	Prior to Final Acceptance/at Completion	DVD	Digital Video Disk	FI	For Information
AIT	After Inspection Test	PTL	Prior to Lift	EM	E-Mail		
AM	After Mobilization	PTM	Prior to Mobilization	EN	Electronic (Native)		
AP	After Proposal/Bid	PTS	Prior to Shipment	EP	Electronic (PDF)		
ATS	At Time of Shipment (Separately)	PTT	Prior to Test	O	Original		
B	Before Balance of Payment	PTW	Prior to Weld	P	Prints/Photocopies		
NTP	Notice to Proceed	Q	As Required	PH	Photographs		
PTC	Prior to Construction/Commencing Work	R	As Requested	S	Sample		
PTD	Prior to Delivery	WP	With Proposal/Bid	X	X-rays		

#	REFERENCE	REQUIREMENT DESCRIPTION	SCHEDULE	FORMAT	NO. OF COPIES	PURPOSE
1.	4.1	SUPPLIER'S QUALITY ASSURANCE PLAN/PROGRAM MANUAL	WP	EP	1	FA
2.	3.1	ITEMS REQUIRED THAT ARE NOT LISTED IN THIS SPEC (IF APPLICABLE)	AA	EP	1	FA
3.	3.2.1	M & TE CALIBRATION RECORDS	PFTA	EP	1	FI
4.	3.9	REQUEST FOR WAIVER OR DEVIATION	Q	EP	1	FA
5.	3.4.1	SDS FOR CLEANING PRODUCTS	PTF	EP	1	FI
6.	3.4.2	CLEANING PROCEDURES	PTF	EP	1	FI
7.	4.2.1	DOCUMENTATION PACKAGE WITH EACH ES-3100 HEAVY CAN SPACER ASSEMBLY CASTING LOT.	PTFA	EP	1	FA
8.	4.2.4	PROCESS PROCEDURES	PTF	EP	1	FA
9.	4.2.5	PERSONNEL QUALIFICATIONS	R	EP	1	FI
10.	3.3.1.1	SHIELDWERX CATALOG NO. SWX-277-0 CoC FOR EACH LOT	PTF	EP	1	FA
11.	3.3.1.2	TYPE 1 NUCLEAR-GRADE BORON CARBIDE POWDER CoC	PTF	EP	1	FA
12.	3.3.1.2	SAMPLING PLAN	PTF	EP	1	FA
13.	3.3.1.3	B10 CONTENT REPORT	PTF	EP	1	FA
14.	3.3.4, 3.3.5	FORM C – OUTSIDE ACCEPTABLE RANGE	Q	EP	1	FA
15.	3.3.6, 3.3.8.3	FORM D – OUTSIDE ACCEPTABLE RANGE	Q	EP	1	FA
16.	3.5	SCHEDULE	WP	EP	1	FA
17.	3.7.1	PACKING PLAN	PTFA	EP	1	FA

Attachment B: Instructions to Supplier for Preparation of Submittals

Note 1 --All correspondence shall be addressed to the Technical Representative identified by the company. The Supplier shall forward submittals via transmittal letter to the Company at the address specified in the contract.

Note 2 -- The submittal must have adequate detail so that full compliance with the requirements may be determined. For example, a simple off-the-shelf item to be used in an assembly may only need a manufacturer's cut-sheet to show compliance, but a factory acceptance test (FAT) developed and submitted by the Supplier must have each test step detailed with acceptance criteria consistent with the requirements.

a. Review submittal before transmitting to the Company to verify conformance with requirements of the contract documents (e.g., field measurements, field construction criteria, or manufacturer's catalog numbers).
b. Coordinate submittals with the work requirements and the contract documents.
c. Organize Submittals
   - Do not use highlight marker or color coding on submittals.
   - The minimum resolution used for scanning submittals shall be 300 dpi x 300 dpi.
   - For submittals containing color information important to the record, a 24-bit color setting should be used.
   - Submittals are to be legible and in the format specified on the submittal checklist.
   - Pen and ink changes are to be made in non-erasable ink, legible, dated and initialed.
   - Mark specific options provided for the work, and cross out options not provided.
   - Each submittal shall be sent as a single pdf file unless otherwise specified.
d. Label submittals with the applicable item number, reference, and requirement description as summarized in the Submittal Checklist. Unlabeled submittals will be returned to the Supplier without review.
e. Include with submittals a transmittal letter that identifies individual documents by specification section.
   - Transmittal for submittals shall be numbered using the purchase order number followed by a 4-digit sequential number. (Example: 430001111-0001).
   - Embedded comments or questions that are not included on the transmittal may not be addressed/resolved by the Company.
f. Direction will be given at the time of award to either upload submittals to a company provided URL address or send by email to a company provided email address.
g. If using a company provided URL to upload submittals, notify the Company via email when submittals have been placed.
h. After review of a submittal, the Company will assemble comments and provide a status on the documents. An example of this submittal status stamp is shown below.

DOCUMENT REVIEW STATUS		
1	☐ Work may proceed.	
2	☐ Revise & resubmit. Work may proceed subject to incorporation of changes indicated.	
3	☐ Revise & resubmit. Work may not proceed.	
4	☐ Review not required. Work may proceed.	
Permission to proceed does not constitute acceptance or approval of design details, calculations, analysis, test methods developed or selected by the supplier and does not relieve supplier from full compliance with contractual obligations.		
REVIEWED BY:	Print Name/Signature:	Date:

i. If a submittal is being resubmitted, then reference the applicable item number, reference, and requirement description and identify it as a resubmittal.
j. Company response will only be returned to the Supplier for those submittals with a Submittal Purpose of "For Action, "unless it is determined that a submittal transmitted "For Information" is not acceptable.
k. AFTER written approval is obtained, THEN proceed with work requiring approved submittals.
l. When approval submittals are required, work done before Company approval is at the Supplier's risk.
m. Maintain a copy of the company-approved submittal and status page on file.

Attachment C: Abbreviations and Acronyms

ANSI	American National Standards Institute
ASME	American Society for Mechanical Engineers
ASTM	American Society for Testing Materials
AWS	American Welding Society
CFR	Code of Federal Regulations
COC	Certificate of Conformance
DOE	Department of Energy
FAT	Factory Acceptance Test
IEC	International Electrotechnical Commission
in.	inches
ISO	International Organization for Standardization
lb	pounds
LOD	Loss on Drying
M&TE	Measuring and Testing Equipment
NIST	National Institute of Standards and Technology
PGNAA	Prompt Gamma Neutron Activation Analysis
RFWD	Request for Waiver/ Deviations
SA	Subcontract Administrator
SDS	Safety Data Sheet
SST	Stainless Steel
STI	Scientific, Technical, or Operational Information
STR	Subcontract Technical Representative
WP	With Proposal

Appendix 1.3.11
SPC M801794-0003, *Packcrete Preliminary Lot Qualification*

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EQUIPMENT SPECIFICATION

APPROVAL / REVISION PAGE
** For Company Use Only - Do Not Provide To Supplier **

DOC TYPE	DOC #	PART #	REV #	PAGE
SPC	M801794-0003	000	00	i of i

QUALITY LEVEL	PROTECTION LEVEL	BUILDING
Q	C	N/A

PROJECT TITLE: SHIPPING CONTAINERS

JOB TITLE:

ITEM DESCRIPTION: PACKCRETE PRELIMINARY LOT QUALIFICATION

UNID:

REVISIONS

REV. NO.	DESCRIPTION OF REVISION
00	Initial issue.

REFERENCE DOCUMENTS & OTHER INFORMATION

Required Supplier (not defined):

In-Storage Maintenance Requirements – None (Material will not be shipped to Y-12.)

References for Company Use:

Reference Receipt Inspection: NA (Material will not be shipped to Y-12.)

Design Verification Record: DV-801794-0003

Installation Drawings: None

Other reference documents needed by the Seller: None

This shipping package was designed for an offsite use and will not be received or used in the Y-12 National Security Complex. Acceptance occurs at the Seller's location.

This document has been reviewed by a Y-12 DC/UCNI-RO and has been determined to be UNCLASSIFIED and contains no UCNI. This review does not constitute clearance for Public Release.

Name, Date: Stan (TSW) Thomas

APPROVALS

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TABLE OF CONTENTS

1. Scope **4**
1.1 General Description of the Item 4
1.2 Background 5
2. References **5**
2.1 Definitions 5
2.2 Acronym List 8
2.3 Codes/Standards/Orders/Regulations 8
2.4 Applicable Documents for CNS Y-12's use only 8
3. Item Requirements **9**
3.1 Performance Requirements 9
3.2 Design Requirements 9
3.3 Service Conditions 9
3.4 Fabrication and Assembly Requirements 9
3.5 Installation Requirements 9
3.6 Requirements 9
3.7 Government-Furnished Material, Equipment, Services 9
3.8 Schedule 9
3.9 Deliverables and Submittals Documents 9
3.9.1 Approval Data Documents 10
3.9.2 Certification Data Documents 10
3.10 Packaging, Handling, Shipping, and Storage Requirements 10
3.11 Marking and Identification Requirements 10
3.12 Requests for Waiver or Deviation 10
4. Quality Assurance Requirements **10**
4.1 Final Acceptance Test Method 11
4.2 Inspection/Testing Requirements 11
4.3 Surveillance and Audits 11
4.3.1 Quality Hold Points 11
4.3.2 Quality Observations 11
4.4 Quality Requirements 11
4.5 Acceptance Criteria 12
4.6 Personnel Qualifications/Certifications 12
4.7 Training and Qualification of Personnel 12
4.7.1 Operator and Witness Training and Qualifications 12
4.8 Documentation Retention 12
4.9 Nonconformance Control 12
5. Packcrete Raw Material Requirements **12**
5.1 Procuring Packcrete Raw Materials 12
5.2 Receiving and Material Storage Instructions 13
5.2.1 Damaged Packages 13
5.2.2 Storage of Raw Materials 13
5.3 Sample Plan for Third Party Testing 13
5.4 Material Procurement and Acceptance Criteria 13
5.4.1 Vermiculite Acceptance Criteria 13
5.4.2 Portland cement Acceptance Criteria 14
5.4.3 Airalon 3000 Acceptance Criteria 14
5.5 Mixing Water 15
6. Facility and Process Equipment Requirements **15**
6.1 Cleaning Instructions 15
6.2 Equipment Requirements 15
6.2.1 Scales Requirements 16
6.2.2 Plaster or Mortar Mixers 16
6.2.3 Low Profile Platform Vibrator 16

6.2.4 Table Vibrator ... 16
6.2.5 Time Clocks ... 16
6.2.6 Furnace with Temperature Recorded and Controller ... 16
6.3 Work Environments ... 16
6.3.1 Mixing and Casting ... 16
6.3.2 Mixing and Casting Water ... 16
6.3.3 Curing Storage ... 17
6.3.4 Portland Cement and Vermiculite Storage ... 17

7. Packcrete Preliminary Lot Qualification ... 17
7.1 Processing Setup Requirements ... 17
7.1.1 Setup Verification ... 18
7.1.2 Preliminary Lot Qualifications (PLQs) ... 18
7.1.3 Final Lot Qualifications ... 18
7.1.4 Change Control—Hardware or Process Settings for Mixing, Vibrating, Curing, and Baking ... 18
7.1.5 Mixing Recipe Amounts and Adjustments ... 19
7.2 Setup Approval Control Number (Form A) for Process Qualification ... 21
7.3 Processing Preparation for Samples and Parts ... 22
7.3.1 Setup—Mixing, Vibration Casting, and Curing Samples and Parts ... 22
7.4 Process—Mixing and Vibration Casting, Curing, and Baking for Samples and Parts ... 24
7.4.1 Process—Mixing and Vibration Casting for Samples and Parts ... 24
7.4.2 Process—Curing for Samples and Parts ... 25
7.4.3 Process—Baking for Samples and Parts ... 26
7.5 Setup Approval Process Verification—4.5-gal Pail or 30-gal Drum ... 27
7.6 Packcrete Pipe Samples for Preliminary and Final Lot Qualification ... 27

8. Packcrete PLQ and Production Test Samples ... 27
8.1 Packcrete 4.5-gal Pails ... 28
8.2 Packcrete Production Sampling Set ... 28
8.3 Packcrete 30-gal Sample Drum ... 28
8.4 Packcrete Brick Samples per ASTM C862 ... 28
8.5 Packcrete Sample Pipes ... 28

9. Packcrete Final Lot Qualification Properties Limits ... 28
9.1 Wet and Baked Densities ... 28
9.2 Dynamic Impact Crush Strength ... 28
9.3 Chemical Compositions of the Constituents ... 28
9.4 Thermal Conductivity ... 29
9.5 Specific Heat Capacity ... 29
9.6 Linear Thermal Coefficient of Expansion ... 29
9.7 Elastic Modulus ... 29
9.8 Poisson's Ratio ... 29

Attachments ... 30
Attachment A: Submittal Check List ... 30
Attachment B: Request for Waiver/Deviation Sample Forms ... 34
Attachment C: Airalon 3000 Infrared Analysis ... 40
Attachment D: VIBCO Vibration Force Settings ... 41
Attachment E: Packcrete Processing Forms ... 42
Form A Packcrete Setup Approval ... 43
Form B Packcrete Mixing For Samples and Parts ... 44
Form C Packcrete Sample 4.5-Gal Pail Vibration Casting Control ... 45
Form D Packcrete Sample 30-Gal Drum Vibration Casting Control ... 46
Form E Packcrete Sample Pipes Vibration Casting Control ... 47
Form F Packcrete Furnace and Baking ... 48

FIGURES

Fig. 1. Packcrete sample section without magnification. 4
Fig. 2. Packcrete preliminary lot qualification. 18
Fig. 3. Mixing Packcrete. 19
Fig. 4. Mixing Packcrete, continued. 20
Fig. 5. VIBCO SCR-1000 default eccentric counter weight set at 3 (675 lb). 24

TABLES

Table 1. Particle size distribution acceptance criteria 14
Table 2. Airalon 3000 55-gal drum acceptance criteria 15
Table 3. Nominal recipe for a large batch and a small batch at wet density of 53.9 lb/ft3. 21
Table 4. Extreme recipes for a large Packcrete batch at wet densities of 52.9 and 55.0 lb/ft3 21
Table 5. Vibration settings. 23

1. SCOPE

This specification describes the quality assurance and technical requirements for Packcrete raw materials and preliminary lot qualification (PLQ). It includes procuring, inspection and accepting raw materials; weighing, mixing, casting, vibrating, curing, and baking Packcrete in a 30-gallon and other sizes of containers. For successful completion of the PLQ, samples shall pass verification tests. Once verification tests are complete and affirmed by the Company [Y-12 National Security Complex, Consolidated Nuclear Security, LLC (CNS)], the Seller is approved (but not yet qualified) to start the Packcrete casting process into a specific shipping package (SSP). Separate equipment specifications will specify the qualification requirements for each SSP.

If conflicting requirements appear in this specification and an SSP equipment specification (SSPES), the SSPES shall supersede this equipment specification. If additional conflicting requirements appear in this document, the Seller shall immediately notify the Company for resolution. Waivers and deviations from these requirements are not allowed without the Company's written approval on UCN-13816B, *Request for Waiver or Deviation (RFWD)*, [Attachment B]. The subcontract technical representative (STR) will provide an electronic copy of the RFWD form upon request.

The product produced from this specification is protected under U.S. Patent 6,299,950 B1. The U.S. Government has rights in this product pursuant to Contract No. DE-NA0001942 between the U.S. Department of Energy and CNS.

1.1 GENERAL DESCRIPTION OF THE ITEM

Packcrete is a fireproof, lightweight cast refractory. It is comprised of water, Airalon 3000 (air entraining agent), Portland cement, and vermiculite. Fig. 1 shows a sample section without magnification of Packcrete with a centimeter scale.

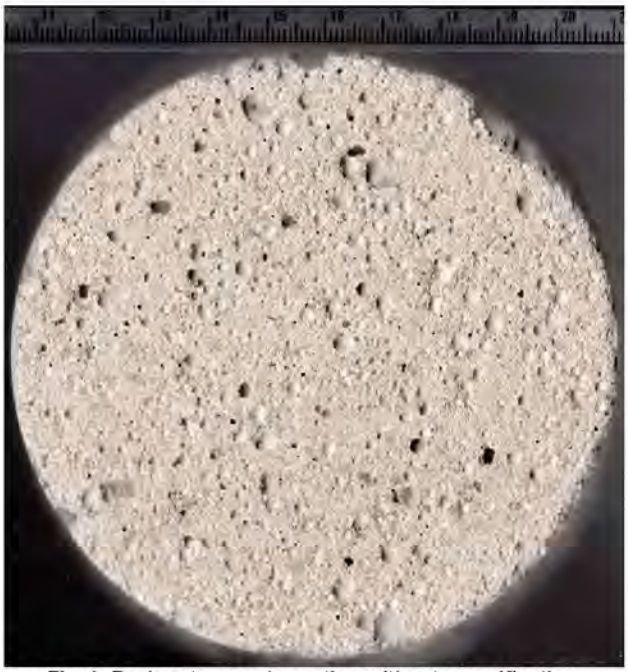


Fig. 1. Packcrete sample section without magnification.

1.2 BACKGROUND

Packcrete is a non-commercially available mixture that was developed as an insulation material for Type-B radioactive material shipping packages. Mixtures of Packcrete must comply with strict manufacturing standards, outlined in this specification.

2. REFERENCES

2.1 DEFINITIONS

4.5-gal pail – A metal container that is at least 4.5 gal and is >18-in. deep. The McMaster-Carr tin-plated steel pail and lid (Part 4243T16) with 4¾-gal capacity and 9-in. top outer diameter is acceptable.

Acceptable Raw Materials – Upon the purchase of new lots of raw materials they must pass Sect 5.4 testing before use in preliminary lot qualification. (Before production use, the raw materials must also pass final lot qualification testing for each simulated specific shipping package and unique casting volume and weight before production approval.)

Baking Control Number (BCN) – B alpha prefix control number that defines the date and the time when baking is started and recorded on Forms C through F (Attachment E).

Baked density – The calculated density of the Packcrete after baking using the following equation.

$$\text{Baked density} = \frac{(AfterBaking - CleanAndEmpty)}{\text{Volume}} \text{ lb/ft}^3 \quad \text{[see equation names below]}$$

Baking Qualification Control Number-Vol (BQCN-Vol) – BQ alpha prefix control number with a volume in cubic feet suffix used to document the date and time the baking process qualification is started and the volume of Packcrete casting used. The BQCN-Vol shall be recorded on each production baking form if used (Form F, Attachment E) to define the appropriate baking process qualification settings.

Certificate of Conformance (COC) – A declaration from a Seller/Supplier stating that the referenced product/material meets all requirements, standards, and/or specifications, but it is not a summary of test results. At minimum, the COC should include the following information:

Certification on Seller/Supplier's letterhead
Manufacturer's name
Purchase order number
Lot number (if available)
Quantity
Purchased material or equipment
Certification system followed
Appropriate Seller/Supplier signature
Seller/Supplier name
Manufacturing location
Part/item number
Date codes
Seller/Supplier contact information
Procurement requirements met/not met
Means of verification

Certified material test report (CMTR) – A document attesting that the materials are in accordance with specified requirements, including the actual results of all required chemical analyses, tests, and examinations from a third party testing facility.

Company – The Company, as used in this specification, is the Y-12 National Security Complex.

Control Number (CN) – 10-digit control number is used with an alpha prefix to document the date and time that process was started using a 24-h format (i.e., B1021081515 is used for starting baking on October 21, 2008, at 3:15 p.m.).

Deviation – A specific written authorization initiated by the supplier and granted by the Company prior to the manufacture of an item to depart from a subcontract requirement.

Equation names – Equation names are used to calculate the wet and baked densities on the casting forms. The following definition of terms clearly states how this data is to be used.

Name	Equation Name	Definitions
After baking cycle	AfterBaking	The baked Packcrete and metal container's weight after it has finished the baking cycles.
Before baking	BeforeBaking	The weight of the metal container with cured Packcrete scraped to the finished casting level before baking.
Clean and empty	CleanAndEmpty	The weight of the metal container that is dry, clean, and empty.
Wet after casting	WetCast	The weight of the scraped and cleaned actual wet cast Packcrete in the container after the vibration process has stopped.
Filled with water	WithWater	The weight of the metal container filled with water to the level of the finished casting.

Final lot qualification (FLQ) – Is required for new lots of raw materials before production castings may start. FLQ shall generate acceptable material property testing results using sample pipes and samples cut from a simulated specific shipping package lid and body casting following written procedures approved by the Company as described in Sect. 9.

Material test report (MTR) – A document attesting that the materials are in accordance with specified requirements, including the actual results of all required chemical analyses, tests, and examinations from the Seller.

Mix Control Number (MCN) – M alpha prefix control number for starting the mixing process.

Nonconformance – A deficiency in characteristic, documentation, or procedure that renders an item to be in noncompliance with specified requirements.

Operator (on casting forms) – A qualified individual, other than the witness, who is responsible for recording the casting measurement, or an individual other than the witness who made a density calculation using the recorded measurements. Multiple operators are acceptable on the forms.

Preliminary lot qualification (PLQ) – Is required before production castings and after raw materials passes the Sect 5.4 testing. It is accomplished using a 30-gallon drum to gain experience in casting and testing process control. The same 30-gallon drum tests may be acceptable to use during production to obtain verification material properties if there is a correlation made between the 30-gallon drum test results of the simulated specific shipping package PQ casting material properties test results.

Process qualification (PQ) – An individual process procedure following this or a SSPES used to verify that the mixing, vibration casting, curing, baking for a unique container size and weight that generates acceptable material properties. Qualified processes may vary process equipment, vibration force, and baking time. For a PQ of a SSP a SSSP lid and body casting must pass FLQ. The vibration force and baking time of each process may vary the most. For PQ of the sample pipes Forms A, B, E, and F are needed and a different vibration table. For PQ of the SSSP lid or body requires Forms A, B, and F and form(s) in the SSPES.

Sample Pipes – Successful dynamic testing results is required following Sect. 9.2 for LQ. A 4NPS Schedule 40 carbon steel pipe, 6.5 ± 0.02-in. long with no sharp edges, used for compression testing Packcrete samples. The inside of the pipe must be smoothed to a maximum surface roughness of 125 microfinish. The Packcrete casting in the pipe is finished to a depth of 0.3 ± 0.09-in. and 4.5 ± 0.09 in. from the fill hole, for a cast height of 4.2 in. Each finished end shall be finished flat to within 0.02. A large flat bottom drill bit and a small drill press works well to finish the cured casting flat.

Setup Approval Control Number (SACN) – SA alpha prefix control number to document the date and the time that the setup approval is started. The SACN shall be recorded on each mixing form (Form B, Attachment E) to define the appropriate Packcrete mixing process and casting materials amounts. A particular setup of hardware, settings, mixing times, and vibration speeds for mixing and casting Packcrete defined on Form A with casting records and submitted to the Company for approval. The sample pipes and SSSP may each have a unique SACN

to follow the PQ testing for approval. The Company approval SACN date gives the Seller authorization to cast record parts following the SACN. Due to changes in the mixing or vibration hardware, the Seller may have more than one SACN for the same lot of materials.

Seller – The organization or person(s) entering into a subcontract with the Company to provide the product(s) described.

Specific shipping package (SSP) – The final placement of Packcrete will be following the SSPES. This PLQ specification must be completed before and as part of the SSPES. Since the references, drawings, size, and weight of the shipping package or container are defined by the SSPES. Final acceptance of the Packcrete material properties shall be when the SSSP is cut and tested following Sect. 9 of this specification.

Simulated specific shipping package (SSSP) – Is defined in the SSPES and will have a body and lid that reasonably match the volume and weight of the SSP body and lid. The SSSP is used to verify the Seller's operating procedures produce parts that are acceptable to the SSPES.

Subcontract administrator – A Company person, called the buyer, who is responsible for overall subcontract administration.

Subcontract technical representative (STR) – A Company person responsible for managing, monitoring, and ensuring compliance with technical requirements of a subcontract.

Supplier – The organization or person(s) entering into a subcontract with the Seller to provide the product(s) described.

Technical representative (TR) – A Company person who identifies technical and quality requirements necessary to support development of a procurement specification.

Third party – An independent test organization, person, or company that tests products and materials in accordance with the contract requirements. The organization cannot be affiliated with the producer or the user of the item being tested. These independent testing facilities are sometimes called third party testing facilities. The third party test agency shall be certified to ANSI/ISO/IEC 17025 or be evaluated and accepted to meet the Seller's Company-approved quality assurance program, as applicable.

Volume – The calculated casting volume in cubic feet using the equations below.

For a metal container filled to Packcrete casting level.

$$\text{Volume} = \frac{(WithWater - CleanAndEmpty)}{62.3}\ \text{ft}^3 \text{ @ } 70^\circ\text{F}$$

For pipes or cylinders the internal diameter (ID) and the baked internal height (BIH) in inches.

$$\text{Volume} = \frac{ID^2 \times BIH}{2200.16}\ \text{ft}^3$$

Waiver – A specific written authorization initiated by the supplier and granted by the Company to accept a configuration item or other designated items that, during production or inspection, are found to depart from specified requirements but are considered suitable for use as is or after rework by an approved method.

Wet density – The calculated density of Packcrete after the container is filled and scraped, but not cured, using the equation below.

$$\text{Wet density} = \frac{(WetCast - CleanAndEmpty)}{\text{Volume}}\ \text{lb/ft}^3$$

Witness (on mixing and casting forms) – A qualified individual other than the operator trained in mixing and casting Packcrete who has verified that the data is accurately recorded. If a density is to be calculated, then the witness is an individual other than the operator who independently checked and verified the density calculation. Multiple witnesses are acceptable on the forms.

2.2 ACRONYM LIST

BCN	Baking Control Number
BCT	bottom center thermocouple
BIH	baked internal height
BQCN	Baking Qualification Control Number
CMTR	Certified Material Test Report
CN	Control Number
CNS	Consolidated Nuclear Security, LLC
COC	Certificate of Conformance
DOE	U.S. Department of Energy
EWCW	estimated wet cast weight
FLQ	final lot qualification
MCN	Mix Control Number
MTR	material test report
PLQ	preliminary lot qualification
PQ	process qualification
QAP	quality assurance plan
RFWD	Request for Waiver or Deviation
RMLQ	Raw Material Lot Qualification
SACN	Setup Approval Control Number
SSP	specific shipping package
SSPES	SSP equipment specification
SSSP	simulated specific shipping package
STR	subcontract technical representative
TR	technical representative
VOL	volume

2.3 CODES/STANDARDS/ORDERS/REGULATIONS

10 CFR Part 71	*Packaging and Transportation of Radioactive Material*
ASTM C114	*Standard Test Methods for Chemical Analysis of Hydraulic Cement*
ASTM C136	*Standard Test Method for Sieve Analysis of Fine and Coarse Aggregates*
ASTM C150/C150M	*Standard Specification for Portland Cement*
ASTM C233/C233M	*Standard Test Method for Air-Entraining Admixtures for Concrete*
ASTM C260/C260M	*Standard Specification for Air-Entraining Admixtures for Concrete*
ASTM C494/C494M	*Standard Specification for Chemical Admixtures for Concrete*
ASTM C516	*Standard Specification for Vermiculite Loose Fill Thermal Insulation*
ASTM C520	*Standard Test Methods for Density of Granular Loose Fill Insulations*
ASTM C860	*Standard Test Method for Determining the Consistency of Refractory Castable Using the Ball-In-Hand Test*
ASTM C862	*Standard Practice for Preparing Refractory Concrete Specimens by Casting*
ASTM C1113	*Standard Test Method for Thermal Conductivity of Refractories by Hot Wire (Platinum Resistance Thermometer Technique)*
ASTM E70	*Standard Test Method for pH of Aqueous Solutions With the Glass Electrode*
ASTM E228	*Standard Test Method for Linear Thermal Expansion of Solid Materials with a Push-Rod Dilatometer*
ASTM E1269	*Heat Capacity by Differential Scanning Calorimetry*
ANSI/ISO/IEC 17025	*General requirements for the competence of testing and calibration laboratories*

2.4 APPLICABLE DOCUMENTS FOR CNS Y-12'S USE ONLY

The following documents apply when casting Packcrete.

RP-802282-0002	*Packcrete Material Properties*
Y/DW-2345	*Impact Properties of Packcrete Material at −40°F and 100°F*

3. ITEM REQUIREMENTS

Packcrete must be cast into a steel container specified in this equipment specification. The manufacturing controls are based on a finished baked density of 22.4 ± 3 lb/ft^3 that controls the proper thermal and impact properties. The serial numbers for the casting shall be on the casting and recorded on proper casting forms.

3.1 PERFORMANCE REQUIREMENTS

The Seller has no responsibilities for performance of Packcrete beyond the measured density of 22.4 ± 3 lb/ft^3 when the requirements of this specification are satisfied.

3.2 DESIGN REQUIREMENTS

NA

3.3 SERVICE CONDITIONS

NA

3.4 FABRICATION AND ASSEMBLY REQUIREMENTS

See production processing in Sect. 7.7

3.5 INSTALLATION REQUIREMENTS

NA

3.6 REQUIREMENTS

NA

3.7 GOVERNMENT-FURNISHED MATERIAL, EQUIPMENT, SERVICES

NA

3.8 SCHEDULE

A manufacturing plan with written, step-by-step process plans shall be submitted to the Company for approval and used by the Seller to comply with requirements in this specification. At a minimum, the plan shall include:

- material control and materials to be procured,
- subtiers to be used, and control thereof,
- quality plan used to procure materials and manufacture Packcrete,
- major fabrication steps and sequence of operations,
- hold points to be determined for Company involvement,
- all in-process inspection/examination, and
- dimensional inspections and testing.

3.9 DELIVERABLES AND SUBMITTALS DOCUMENTS

There are two types of submittals associated with this specification: (1) Approval Data documents and (2) certification data documents. The submittal schedule, submittal format, number of copies, and submittal purpose are shown in Attachment A. All records shall be traceable to the casting and identified by serial numbers. The Seller shall maintain quality-related documentation in accordance with requirements in the purchase order and this specification. The Company reserves the right to request any such documentation and to witness all aspects of the manufacturing process in accordance with this specification.

3.9.1 Approval Data Documents

Approval Data documents are identified in Attachment A. Approval Data documents include written procedures and personnel qualifications which must be approved by the Company prior to conducting the work defined in Sect. 7.

With each submittal transmitted to the Company, the Seller will include an updated submittal checklist using an Excel spreadsheet. The checklist shall identify all of the documents to be submitted and the status of each. All submitted documents shall be identified with document title, document number, revision level, computer filename, and submission date. The reply date of and disposition by the Company shall be included in the Excel spreadsheet for documents already submitted and dispositioned by the Company.

The Seller shall generate documentation in compliance with the Company-approved quality assurance plan (QAP). All records shall be identified based on the component serial numbers traceable to the casting serial number. The Company reserves the right to request any additional documentation used in fabrication or raw material qualification.

Procedures shall be submitted to the Company for approval prior to use in accordance with Attachment A and shall identify all mixing and vibrating equipment models and settings required to complete the casting process. Approvals of submittals must be received from the Company prior to implementing any activities involving these procedures. Submittal version control must be exercised to ensure correct and approved versions are used. All fabrication activities used to make Packcrete must be described in approved written procedures.

3.9.2 Certification Data Documents

Certification data documents are identified in Attachment A, and document measurements, testing, and calculations created during the performance of the work described in Sect. 7 as documented in Attachment E forms.

Certification data documents include raw material test reports (MTRs) in accordance with the requirements of Sect. 5.4.

The Seller shall provide a certification data package that connects all specified processing data collected to the particular casting.

3.10 Packaging, Handling, Shipping, and Storage Requirements

See Sect. 5.2 for storage requirements for raw materials.

3.11 Marking and Identification Requirements

Packcrete as a material is not marked in any way. For production the procurement and processing records (forms) for Packcrete raw materials and procedures used shall be tracked by the manufacturing SSP serial numbers for the drum lid and body.

3.12 Requests for Waiver or Deviation

Any requested exceptions, deviations, or proposed changes to the requirements of this specification by the Seller after award and before acceptance shall be submitted using UCN-13816B. This form is included as Attachment B. The Seller shall request an electronic copy of the form with instructions from the STR or subcontract administrator.

4. Quality Assurance Requirements

The Seller shall perform this work under a Company-approved quality assurance program that meets the applicable requirements of 10 CFR Part 71, Subpart H, for packaging and transportation of radioactive materials.

The Seller shall submit a QAP for the scope of this work that describes the quality assurance policies and practices to be implemented in identifying, controlling, and verifying the quality of Packcrete processes (weighing, mixing, pouring, vibrating, curing, and baking). The Seller's QAP shall ensure full compliance with

all requirements, tests, inspections, reports, documentation, and approvals contained within this specification. The Seller's QAP shall include the requirements for the process controls for the operations, the qualifications of the operator(s) and witness(es), and verification records.

4.1 FINAL ACCEPTANCE TEST METHOD

The final acceptance test method includes verification that 100% of the castings contain Packcrete with a finished baked density of 22.4 ± 3 lb/ft^3 and the process used to achieve that density followed the prescribed steps included in Sect. 7.

Final acceptance will be based on compliance with the Approval Data documents as verified through surveillance activities by the Company, compliance with the technical requirements in this specification as verified through surveillance activities by the Company, and final review and acceptance of the certification data package documents that apply to Packcrete.

4.2 INSPECTION/TESTING REQUIREMENTS

See Sect. 7 for additional information.

4.3 SURVEILLANCE AND AUDITS

The Company shall reserve the right to evaluate the Seller's QAP and subtiers to ensure compliance with this specification at the Company's discretion. The Company shall be allowed to witness any of the processes associated with this specification during the performance of the contract.

4.3.1 Quality Hold Points

4.3.1.1 Raw Material Lots Must Be Qualified

Before any materials are used in LQ castings, the MTRs shall show that the materials meet the testing requirements and acceptance criteria specified in Sect. 5.4. The MTR number and the water weight shall be documented on Forms A and B (Attachment E).

Raw materials shall not be used until the Company has reviewed the MTRs and provided documented approval to use the materials.

4.3.1.2 Components Must Pass Geometric Inspection Requirements

NA

4.3.1.3 Company Approval Setup for Lot Qualified Raw Materials

Each change to the approved setup on Form A must be documented on a new Form A and reapproved by the Company. These changes may include hardware, mixing amounts, mixing rotation speed, mixing times, vibration speed setting (Sect. 7.3.1.5), and vibration time.

Modifications to the vermiculite dry weight percent shall require LQ testing and written Company approval. Changing from one lot of raw materials to another shall require LQ testing and written Company approval. Approval requires positive testing results of LQ testing defined in Sect. 9. Several months of lead time will be needed to perform these tests and for the results to be evaluated by the Company.

Changes to a Form A shall not be implemented for production castings until the Company has approved the changes. This approval process requires PLQ testing results. The Company may witness implementation of the changes through PQ and review third-party qualification testing results/reports, and then provide its documented approval to proceed via second signatures on the Form As.

4.3.2 Quality Observations

The Company reserves the right to perform quality observations of the Packcrete casting process at any time. Observations will include, but not be limited to, LQs, first article evaluation casting, and initial production casting.

4.4 QUALITY REQUIREMENTS

NA

4.5 ACCEPTANCE CRITERIA

The acceptance criteria for fabrication and assembly requirements are based on the baked density of 22.4 ± 3 lb/ft^3, and evidence that Packcrete was cast in compliance with this specification.

4.6 PERSONNEL QUALIFICATIONS/CERTIFICATIONS

Personnel qualified and trained as operators and witnesses shall be able to follow and perform written instructions and procedures and accurately record operations involving weighing, mixing, casting, vibrating, curing, and baking processes.

4.7 TRAINING AND QUALIFICATION OF PERSONNEL

The Seller shall provide the Company (1) a plan for qualifying and training personnel and (2) documented evidence that personnel have been qualified and trained in accordance with the Seller's procedures approved by the Company to ensure their competence in the use of process procedures and specifications. The Seller must ensure all operators use and follow written procedures for the respective processes. Submit the training plans for Company approval.

4.7.1 Operator and Witness Training and Qualifications

Each operator and witness who performs Packcrete processing activities shall be trained and qualified. This requires the operator and witness to (1) have read the operating procedures and (2) have experience making the measurements, filling out the forms, and successfully performing the activity. Operator and witness qualifications shall be documented and submitted to the Company for approval with the casting forms as evidence that personnel have been qualified and trained.

4.7.1.1 Packcrete mixing and vibration casting training shall consist of successfully completing mixing and casting activities described in Sects. 7.2 and 7.3.

4.7.1.2 Packcrete curing and baking process training shall consist of successfully completing curing and baking activities described in Sect. 7.4.

4.8 DOCUMENTATION RETENTION

Documentation of all inspection and test results shall be maintained by the Seller for 3 years after acceptance by the Company. The Company shall have access to this documentation to ensure compliance with all requirements.

The Seller shall not destroy quality records without notifying the Company in advance to confirm that the Company does not have a need for the records.

4.9 NONCONFORMANCE CONTROL

The Seller shall have an approved procedure for the control of non-conformances, waivers, and deviation requests during the execution of this specification. A nonconforming component shall not be used unless it has been specifically approved by the Company (see Sect. 3.12). The disposition of a nonconforming component shall be documented. Any nonconforming component shall be clearly identified, and each nonconformance report shall be traceable to the actual component affected. A copy of each approved nonconformance report for a component shall be provided to the Company as a part of the certification data package.

5. PACKCRETE RAW MATERIAL REQUIREMENTS

This section defines the requirements for Packcrete raw material procurement, receiving, storage, sampling, testing, and acceptance.

5.1 PROCURING PACKCRETE RAW MATERIALS

The Seller shall procure the Packcrete raw materials (i.e., vermiculite, Portland cement, and Airalon 3000) in accordance with the requirements in Sect. 5.4.

5.2 Receiving and Material Storage Instructions

Packcrete raw materials procured per this specification shall be marked and received with a traceable Certificate of Conformance (COC).

5.2.1 Damaged Packages

The Seller shall not accept and/or use damaged packages of Packcrete raw materials. Damaged packages are those that are visually determined to be wet, have been wet, have been torn open, or are leaking.

5.2.2 Storage of Raw Materials

Packcrete raw materials shall be stored in a dry location and protected from damage and moisture with an air temperature range of 70 ± 20°F and compliant with the manufacturers recommended practices.

5.3 Sample Plan for Third Party Testing

Packcrete raw materials must be purchased in accordance with Sect. 5.4. The plan will require each lot of sampled material to be tested by an independent third party. A sample plan must be created by the Seller to determine the definition of appropriate lot and sample size(s) in order to achieve reasonable assurance that the sample size chosen provides an adequate representation of the purchased item(s) quality. The sample plan shall comply with guidelines as directed by the Company. The lot size is defined in Sect. 5.4.

5.4 Material Procurement and Acceptance Criteria

Packcrete raw MTRs shall be provided with the COCs. The Seller shall also provide a CMTR from a qualified third party testing laboratory in accordance with the requirements in this section.

Note 1: One lot of Airalon 3000 is comprised of a single 55-gal drum that is (1) marked with a manufacturer's lot number and (2) noted in the manufacturer's COC.

Note 2: One lot of Portland cement is comprised of bags received against the same purchase order that have a date code (1) noted in the COC and (2) within the time period noted on the MTR provided with the manufacturer's COC.

Note 3: One lot of vermiculite is comprised of bags received against the same purchase order that have the same manufacturer's lot number noted in the manufacturer's COC.

5.4.1 Vermiculite Acceptance Criteria

The raw material manufacturer shall provide a COC package that includes the following, as a minimum: (1) the Buyer's purchase order number; (2) the date(s) of manufacture; (3) a statement that the material complies with ASTM C516; (4) a signature by the supplier's official or quality manager; and (5) a Certificate of Analysis in accordance with ASTM C516 for bulk density and grading. The COC shall also include the lot numbers in the order and the number of bags for each lot number.

All bags in the order shall come from a single manufacturing run in order to ensure consistency from bag to bag in terms of chemical composition, bulk density, and particle size distribution.

The manufacturer shall mark each bag as being vermiculite, Type 1, Grade 3, per ASTM C516 requirements. The manufacturer shall also mark each bag with (1) the lot number, (2) the manufacturing line identifier, and (3) a date code showing when the material was manufactured and bagged.

The manufacturer shall maintain quality records that connect the lot number, manufacturing line identifier, or date codes to the raw materials, manufacturing processes, operating procedures, and other manufacturing specifics associated with the manufacturing run.

Bagged vermiculite shall be stored in an area where vibrations from adjacent equipment and handling or movement are minimized, and be stored and transported in a manner that protects the bags and materials from exposure to water.

Bulk density and grading shall be independently tested by a third party testing laboratory in accordance with ASTM C516 (Type 1, Grade 3 Fine).

When tested in accordance with Sect. 9.1.1 of ASTM C516 and ASTM C520, third party testing must show each sample has a bulk density between 6.4 and 8 lb/ft3. When tested in accordance with Sect. 9.1.2 of ASTM C516 and ASTM C136, all samples must have a particle size distribution that complies with Table 1

Table 1. Particle size distribution acceptance criteria

U.S. Sieve No.	Weight % passing through the sieve
8	90 to 100
16	40 to 82
30	0 to 35
50	0 to 20
100	0 to 10
200	0 to 2

If all samples do not pass the bulk density and particle size distribution acceptance criteria, the lot shall be rejected by the Seller and the Company should be notified.

5.4.2 Portland cement Acceptance Criteria

The manufacturer shall provide a COC package for each purchase order that includes the following, as a minimum: (1) the Buyer's purchase order number; (2) the date(s) of manufacture; (3) a statement that the material complies with ASTM C150; (4) a signature by the supplier's official or quality manager; (5) an MTR in accordance with ASTM C150; and (6) a statement that all bags in the order were bagged during the time period stated in the MTR. The COC package shall also include the lot number in the order and the numbers of bags in each lot number.

The manufacturer shall mark each bag as being Portland cement, Type III, per ASTM C150 requirements. The manufacturer shall also mark each bag with a date code showing the week and year the material was bagged. All bags in the order/lot shall have a date code that is within the valid time period stated in the MTR.

The manufacturer shall maintain quality records that connect the lot number or date codes to the raw materials, manufacturing processes, operating procedures, and other manufacturing specifics associated with the manufacturing run.

The packaging practices of the manufacturer are acceptable unless stated otherwise in the Buyer's purchase order. Material shall be stored and transported in a manner that protects the bags and materials from exposure to water.

A CMTR shall be provided from a third party independent testing laboratory showing that all samples comply with ASTM C150, Table 1, Type III standard chemistry requirements when tested in accordance with the test methods specified in ASTM C114, Table 1.

If all samples do not pass the acceptance criteria, the lot shall be rejected by the Seller, and the Company should be notified.

5.4.3 Airalon 3000 Acceptance Criteria

The manufacturer shall provide a COC package with each purchase order that must include the following as a minimum: (1) the Buyer's purchase order number; (2) the date(s) of manufacture; (3) a statement attesting to the fact that the material complies in concentration, composition, and performance to ASTM C260 requirements; (4) a statement providing the chloride content of the material; and (5) a signature by the supplier's official or quality manager. The COC package shall also include the lot number, the date codes, and the number of containers in the order for each date code.

The manufacturer shall mark each container as being Airalon 3000 per ASTM C260 requirements. The manufacturer shall also mark each container with (1) the lot number and (2) a date code showing when the material was manufactured and containerized.

The manufacturer shall maintain quality records that connect the lot number or date codes to the raw materials, manufacturing processes, operating procedures, and other manufacturing specifics associated with the manufacturing run.

A CMTR shall be provided from a third party independent testing laboratory that shows that each 55-gal drum of Airalon 3000 complies with the acceptance criteria in Table 2.

Table 2. Airalon 3000 55-gal drum acceptance criteria

Reference	Test	Original lot	Acceptance criteria*
ASTM C494, C260, or C233	Infrared analysis**	Attachment C	Essentially similar to Attachment C
ASTM C494, C260, or C233	Specific gravity	1.01 S.G	0.91 to 1.13 S.G.
ASTM C260 or C233	pH	10.25 pH	9.15 to 11.48 pH
ASTM C260 or C233	Residue (solids)	3.15 wt %	2.82 to 3.52 wt %

*The acceptance criteria are based on the measurements of the original lot and a 12% range.
**ASTM C260 for air-entraining admixtures does not require infrared analysis. Therefore, the infrared analysis for chemical composition testing is determined by ASTM C494 using the oven-dried residue as determined by ASTM C260/C233.

If the sample does not pass the acceptance criteria, the Airalon 3000 55-gal drum shall be rejected, and the Company shall be notified.

5.5 Mixing Water

Water that has been filtered through at least a 20-micron filter and has a chlorine content that is <4 mg/L (4 ppm, 0.0004% by mass) shall be used for the mixing of Packcrete. Record the manufacturer, model number, and serial number of the water filter showing that it is at least a 20 micron filter on Form B (Attachment E). The water temperature shall be between 50 and 80°F. Form B in Attachment E shall be used to document and record the water temperature and that the chlorine requirements are met each day before mixing starts.

6. Facility and Process Equipment Requirements

A written plan shall be submitted to the Company for approval that defines the cleaning process, including cleaning solutions used, equipment, and work and storage environments.

6.1 Cleaning Instructions

NO CHLORINE PRODUCTS (sodium hypochlorite) shall be used in the cleaning materials. Potable water shall be used and, if required, some mild soap (tri-sodium phosphate) may be included to clean all processing equipment and manufactured drum bodies and lids before casting. Chlorine is known by many names on the ingredient list (e.g., sodium hypochlorite, hypochlorite, chloramine, bleach, hydrochloric acid, trihalomethanes, and generic disinfection by-products). Not all cleaning products list their ingredients, therefore, only cleaning materials that disclose all ingredients shall be used.

If the mixer sits for >15 min between mixer batches, the mixer shall be flushed thoroughly with potable water before reuse. Before the start of mixing operations described in Sect. 7, the mixer shall be clear of foreign materials or loose previous mixing residues from the inner surface of the mixer.

Manufactured drum bodies and lids that have passed geometric inspection must be cleaned and protected prior to the casting operation to prevent the introduction of foreign materials into the assemblies. The assemblies shall be inspected and wiped clean prior to casting to ensure no visible contaminants are present inside the casting cavity.

6.2 Equipment Requirements

All process equipment used for mixing, casting, and baking of the Packcrete shall be (1) identified in the Seller's operating procedures with the operational tolerances and (2) in good working condition.

6.2.1 Scales Requirements
Scales used for weight measurements shall be calibrated and traceable to National Institute of Standards and Technology. All weighing operations of assemblies and materials shall be conducted on digital certified scales with a minimum accuracy of 0.5 lb.

6.2.2 Plaster or Mortar Mixers
The Multiquip's Whiteman WM70S-H8 (8-hp Honda engine) and the Whiteman WM70PE (1.5-hp electric motor) mixers with a 7 ft^3 capacity have been used previously for Packcrete mixing. The WM70PE machine mixes 7 ft^3 of material running at a slow rotation speed with the mixer vanes measuring between 19-27 rpm. The motor speed controller was set to a value of 28–38 rpm. Other models of plaster/mortar mixers may be used if the rotation speed and mix times are qualified in accordance with the requirements in Sect. 7 and approved by the Company. The maximum batch size that mixes well in the WM70PE mixer is approximately 2.7 ft^3 using 22.5 lb of vermiculite. The electric motor bogs down with larger loads. The Whiteman WM90PE (3-hp electric motor) mixer with a 9 ft^3 capacity is recommended to mix larger volumes. Blastcrete Equipment Co. has the D3522MP (mixer pump) that can mix batches up to 5 ft^3 and dump them into a hopper and start mixing another batch. The hopper feeds a peristaltic pump that pumps the material to the end of the 2" diameter hose. No labor is required to move the mixed Packcrete using the mixer pump. Other mixers models may be used by the Seller if qualified in accordance with the requirements in Sect. 7 and approved by the Company.

6.2.3 Low Profile Platform Vibrator
The VIBCO Low Profile Platform Vibrator (24-in. wide × 36-in. long) with the SCR-1000 adjustable eccentric vibrator, or a Company-approved equal, must be selected based upon the maximum estimated wet cast weight (EWCW). The vibration force and duration must be controllable for the container size and weight in accordance with the requirements in Sect. 7.3.1.6. Other models may be used by the Seller if qualified in accordance with the requirements in Sect. 7 and approved by the Company. Verify that the Low Profile Platform Vibrator selected has the capacity to generate the forces required in Sect. 7.3.1.6 and to cast the specific Type-B shipping package. If other vibration equipment is used for a SSP, Sect. 6.2.3 and 7.3.1.6 must document all changes in the SSP casting using the PLQ equipment specification.

6.2.4 Table Vibrator
A standard table vibrator from VIBCO with at least a 6- by 12-in. table top and an electric motor vibrator producing up to 100 lb of force should be used. This vibrator is required to vibrate small 4.5-gal or sample pipes cast during production when the table in 6.2.3 will be loaded with the shipping package.

6.2.5 Time Clocks
The Company recommends the use of two different types of time clocks. The first is a digital 24-h clock with the date that identifies the processes. The start time and date shall become a part of the unique identifier [e.g., alpha prefix (B, BQ, M, P, or SA) plus a 10-digit number for the start date and time of the process using a 24-h format (1021131415 is used for October 21, 2013, at 2:15 p.m.)] for the qualification, mixing, and baking processes.

The second type of time clock is a magnetic digital timer that measures both the mixer and vibration cycle times. One timer should be used to measure each operation. The magnet lets the operators connect it to the mixer housing or other steel support.

6.2.6 Furnace with Temperature Recorded and Controller
The furnace shall be a vented gas-fired or a forced convection fresh air circulating electric furnace with the heat zone verified with thermocouples to 500 ± 25°F at the baking location of the containers in the furnace.

6.3 WORK ENVIRONMENTS

The temperature and humidity of the material storage, casting, and curing environments can have a major impact on casting densities. Variations in mixing air, water, and curing temperatures can also influence the baked density. The Company requires controlled work and material storage environments.

6.3.1 Mixing and Casting
Mixing and casting operations shall be performed out of direct sunlight and rain with an air temperature of 70 ± 20°F.

6.3.2 Mixing and Casting Water
Mixing and casting operations shall be performed with water that complies with the requirements in Sect. 5.5.

6.3.3 Curing Storage
Curing storage shall be in an environment with an air temperature of 70 ± 20°F with the containers covered with plastic.

6.3.4 Portland Cement and Vermiculite Storage
Bags of Portland cement and vermiculite that have been opened for more than one work shift shall be discarded unless they are stored in a waterproof container in a dry location.

7. PACKCRETE PRELIMINARY LOT QUALIFICATION

Packcrete PLQ requires using documented and approved equipment, equipment settings, operating procedures, containers, and raw materials that have passed third party inspections in Sect. 5.4. Packcrete properties are influenced by the raw materials (Sect. 5), equipment (Sect. 6), and process controls. The Packcrete PLQ is shown in Fig. 2.

This section provides the PLQ requirements for establishing a mix setup for casting the 4.5-gal pail, 30-gal drum, SSSP, and SSP. Section 7.5 establishes a process setup and adjusts the mixing and casting process if required to obtain the required wet and baked densities. Once the process setup is established, the Seller may cast a set of PLQ castings in a 30-gal drum and a set of six sample pipes. When the densities are acceptable, the 30-gal drum and sample pipes are sent for additional testing that is performed as defined in Sect. 9.

The PLQ options 1 and or 2 and sub-options are selected by the Seller based upon the Packcrete casting experience they have with the PLQ and SSP equipment specifications. It is recommended that new Sellers start with option 1 until they are confident to move to option 2. Before a Seller will be approved to cast a SSP by the Company confirmation samples must be cast and tested from a simulated specific shipping package (SSSP).

Once the PLQ setup is Company approved, the Seller shall follow Form A to produce a Form B (Attachment E) for each Packcrete batch and next follow the shipping package specific casting specification and cast a simulated shipping package. For FLQ the SSPES will reference this equipment specification for many mixing, casting, curing, baking, and testing operations. The difference between PLQ and FLQ is that the samples for testing come from a 30-gal drum or a SSSP. Depending upon the casting results and where the forms are used, the casting forms in Attachment E could be for approval as part of a certification data package.

7.1 PROCESSING SETUP REQUIREMENTS

The Packcrete processing setup requirements ensure that the Seller is following Company approved procedures, using acceptable raw materials, and that fabricated hardware has passed all inspections. Each casting's serial number shall be traceable to the lots of materials used in the mixing process. All changes shall be documented in the Seller's procedures and approved by the Company. Final lot qualification (FLQ) will occur in the SSPES. FLQs are possible using the six cast pipes and samples cut and tested from the SSSP. Tested samples must pass the testing requirements described in Sect. 9. Additional production sample set testing is defined in Sect. 8.2.

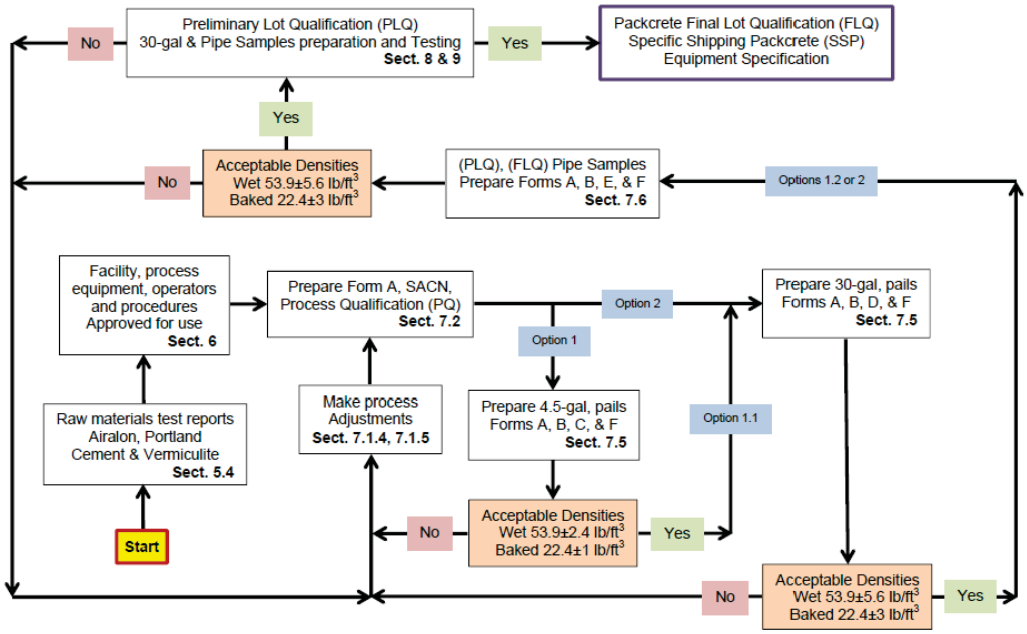


Fig. 2. Packcrete preliminary lot qualification.

7.1.1 Setup Verification
It is recommended that new casting setups begin by using the nominal setup and casting the 4.5-gal pails documented on Form A (Attachment E) and identified by the SACN. Mixers and vibration tables must be qualified following this specification using the proper adjustments of rpm (frequency) (Sect. 7.3.1.5), and force settings based on the wet cast weight estimate (Sect. 7.3.1.6). Once confident in the SACN, the Seller may apply the manufacturing process to the 30-gal drum to gain more casting experience.

7.1.2 Preliminary Lot Qualifications (PLQs)
Following a SACN, and casting the 30-gal drum requires Forms A, B, D, E, and F for PLQ castings per Sect. 7.5. The Seller is responsible for the PLQ baked Packcrete to have a density of 22.4 ± 3 lb/ft^3 and has the option to adjust the mixing recipe amounts in accordance with Sect. 7.1.4 or 7.1.5 and requalify the mixing, casting, vibration, curing, and baking processes to bring the baked density to the nominal values. Process changes made to processing times, adjustments to process equipment settings, or dry weight percent within a lot of raw materials require a new Form A to be approved by the Company.

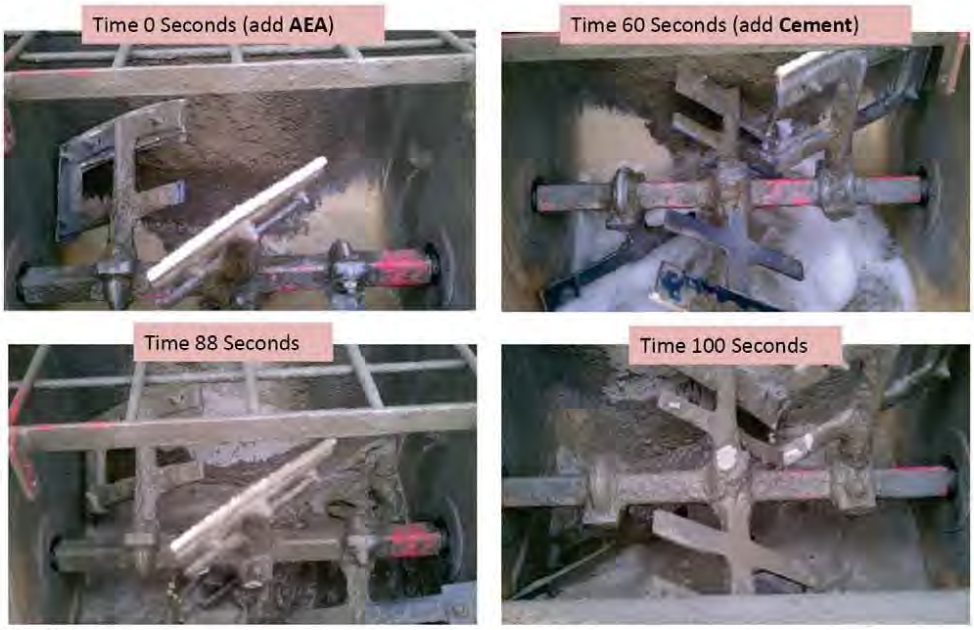
7.1.3 Final Lot Qualifications
The FLQ processes and testing are in this and the SSP equipment specification. FLQ is used to mitigate the risk of rejecting the baked Packcrete in the container's body and lid during production. FLQ requires material property testing confirmation using sample pipes and SSSP castings baked Packcrete to have a density of 22.4 ± 3 lb/ft^3. FLQ is only completed after the Company has reviewed the FLQ testing results in comparison to acceptance criteria documented in RP-802282-0002, and the Form A SACN is signed by either the STR or TR or both. Once the Company has approved the SACN, it may be used for production parts. Equipment replacement of like-for-like process equipment does not need to be re-qualified.

7.1.4 Change Control—Hardware or Process Settings for Mixing, Vibrating, Curing, and Baking
Any hardware change to the mixing or vibrating hardware shall be documented on a new Form A and reapproved by the Company. Each vibration force setting, time duration, temperature, and mixing recipe variable for the process qualification (PQ) shall be recorded on Forms C, D, E, and SSP and shall be repeated during production and documented on Forms D, E, and SSP. The Seller is responsible to follow this specification to generate a process that meets the baked density acceptance range. Hardware settings for the mixer rpm and mixing time for each additive are fixed using Form A.

7.1.5 Mixing Recipe Amounts and Adjustments

This section defines the amounts of materials needed to mix Packcrete. To mix Packcrete, the first step in the mixing operation is to add water and Airalon 3000 to the mixing bin and mix until the mixture is saturated with tiny bubbles as shown in Fig. 3. The second step is to add Portland cement to the mixture and mix until a sloppy wet bubbly cement mixture is achieved. The third step is to add vermiculite to the mixture and mix until the vermiculite is fully coated with the wet cement mixture. The fourth step is to stop the mixer and verify the vermiculite is fully coated, as shown in Fig. 4. Mixing beyond the point when the vermiculite is fully coated will lead to higher wet and baked densities. The fifth step is to perform the ASTM C860, Sect. 6.2, Ball-In-Hand Test, to verify that the proper amount of water is in the mixture.

The Packcrete recipe in this section is based on the maximum weight of vermiculite that the WM70PE mixer can mix without bogging down or stopping. The vermiculite dry weight percent of 37.5% should be used as a starting recipe for the 4.5-gal sample casting to generate a recommended wet density range of 53.9 ± 2.4 lb/ft^3 (51.5 to 56.3 lb/ft^3) that should yield a required baked density range of 22.4 ± 1 lb/ft^3 (21.4 to 23.4 lb/ft^3). The 4.5-gal samples are smaller volumes; therefore, the density target range is different from the FLQ and production process ranges (i.e., recommended wet density range of 53.9 ± 5.6 lb/ft^3 and a recommended baked density range of 22.4 ± 3 lb/ft^3). The wet density will vary from batch to batch. If an adjustment to the average wet density recipe is needed, it must be made with written Company approval following Form A by adjusting the vermiculite dry weight percent between 35.5 and 39.5%, which should change the average wet density by about ±1 lb/ft^3. Higher vermiculite dry weight percent results in lower amounts of Portland cement and lower densities.



Note: AEA—Airalon.

Fig. 3. Mixing Packcrete.

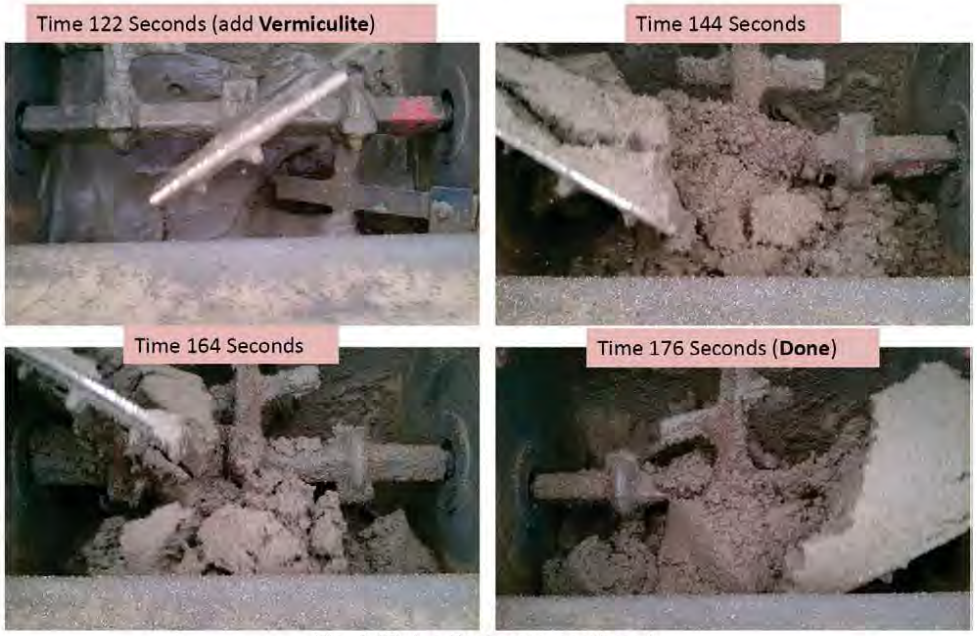


Fig. 4. Mixing Packcrete, continued.

Table 3 provides the nominal recipe for a large batch (2.7 ft^3) and a small batch (1.8 ft^3). Table 4 provides the maximum adjustments needed to increase and decrease the wet density by ~1 lb/ft^3. Each value in the tables is calculated by the equations in this section. The vermiculite dry weight percent also determines the Portland cement dry weight percent, and each dry weight requires its own amount of water to pass the ASTM C860, Sect. 6.2, Ball-In-Hand Test. In Table 4, adjustments in the amount of Portland cement and water in pounds were needed to increase or decrease the wet density of the starting mixture, with the vermiculite and Airalon 3000 remaining fixed. Adjusting the wet density from 52.9 to 55.0 lb/ft^3 requires the addition of 6.42 lb of Portland cement and 3.85 lb (6.42 lb × 0.6) of water. The amount of water needed for the casting was based upon passing the ASTM C860, Sect. 6.2, Ball-In-Hand Test, during development. If the Ball-In-Hand Test fails, the water content must be adjusted accordingly.

The Tables 3 and 4 values are calculated using these equations:

For 22.5 lb of vermiculite and a nominal vermiculite dry weight percent of 37.5%, the amount of cement is calculated on a dry weight percent as follows:

Cement = verm × (1/%V – 1) = verm × (1/0.375 – 1) = verm × 1.6667
Cement = 22.5 × 1.6667 = 37.5 lb

The water mass is calculated by the following equation.

Water = verm × 3.11 + cement × 0.6
Water = 22.5 × 3.11 + 37.5 × 0.6 = 92.48 lb

The Airalon 3000 is measured by a graduated cylinder and is calculated using the following equation:

Airalon = verm / 0.375 (lb/ml) = 22.5 lb / 0.375 (lb/ml) = 60 ml

Table 3. Nominal recipe for a large batch and a small batch at wet density of 53.9 lb/ft3

Material	Target wet density	Airalon 3000	Vermiculite	Vermiculite [a]	Portland cement	Water	Volume
Units	lb/ft3	ml	dry wt %	lb	lb	lb	ft3
Tolerance	±2.4	±2		±0.1	±0.1	±0.3	
Average large mixer load	53.9	60	37.5%	22.5	37.5	92.48	~2.7
Average small mixer load	53.9	40	37.5%	15.0	25.0	61.65	~1.8

[a] All mixer load sizes must be qualified before use. Use the vermiculite weight ratio to calculate the Airalon 3000, Portland cement, and water weights.

If the Packcrete setup described in Sect. 7.1.1 generates a wet density that is too high, the Seller may increase the amount of vermiculite to 39.5% weight percent to reduce the wet density. If the Packcrete wet density is too low, the Seller may reduce the amount of vermiculite to 35.5% weight percent to increase the wet density. Once changes have occurred in the Packcrete recipe, a new Form A shall be generated and new LQ testing shall be performed, as described per Sect. 7.1.2.

Table 4. Extreme recipes for a large Packcrete batch at wet densities of 52.9 and 55.0 lb/ft3

Material	Target wet density	Airalon 3000	Vermiculite	Vermiculite [a]	Portland cement	Water	Volume
Units	lb/ft3	ml	Dry wt %	lb	lb	lb	ft3
Tolerance	±2.4	±2		±0.1	±0.1	±0.3	
Lower density mixer load	52.9	60	39.5%	22.5	34.46	90.65	~2.7
Higher density mixer load	55.0	60	35.5%	22.5	40.88	94.50	~2.7

[a] All mixer load sizes must be qualified before use. Use the vermiculite weight ratio to calculate the Airalon 3000, Portland cement, and water weights.

7.2 SETUP APPROVAL CONTROL NUMBER (FORM A) FOR PROCESS QUALIFICATION

The purpose of the Packcrete setup process is to define and control the required mixer recipe material weights, mixer rotation speed, and mix times to properly mix and cast Packcrete. Form A (Attachment E) identifies the SACN that defines these recipe and mixing settings. The Seller shall create a new Form A for any unique vermiculite weight % or process setup change as defined in Sect. 7.1. The first time through the PLQ process, use the nominal recipe found in Table 3. If needed, the Packcrete recipe may be modified following the requirements in Sect. 7.1.5 up to the limits found in Table 4.

7.2.1.1 Using Form A, record the SACN.

7.2.1.2 Record the vermiculite wt %, mix volume (estimated), water weight, Airalon 3000, Portland cement, and vermiculite in accordance with Sect. 7.1.5. This defines the nominal recipe. Adjustments require written Company approval using Form A.

7.2.1.3 Record the serial number, manufacturer, and model number of the water filter in accordance with Sect. 5.5.

7.2.1.4 Record the mixer serial number, manufacturer, model number, speed control setting, and blade rotation speed in accordance with Sect. 6.2.2.

7.2.1.5 Record the vibration equipment serial number, manufacturer, model number, vibration speed setting, and vibration time in accordance with Sects. 6.2.3 and 7.3.1.6.

7.2.1.6 Use the Form A setup on a practice casting, such as the 4.5-gal pail or 30-gal drum, and document the results using the forms in Appendix E. The Seller may also proceed to preliminary lot qualifying of raw materials by

casting a set of six sample pipes per Sect. 9. Set up the casting following the requirements in Sect. 7.3 and perform casting following the requirements in Sect. 7.4.

7.2.1.7 Provide Form A that defines the mixing setup with the casting Forms C, D, E, and F (Appendix E) or form(s) in the SSPES that control the mixing, vibration casting, furnace, and baking to the Company as proof that baked density was within the acceptable limits. The Company TR and/or STR shall sign and concur with either wet ink or pdf electronic signatures on Form A for approval once the PLQ testing results have been confirmed to be acceptable. If needed go to the shipping container specification to cast a simulated shipping container used to cut testing samples for PQ.

7.2.1.8 FLQ and Company approval are required before any container production may start. Confirmatory testing results of a set of six sample pipes and testing samples cut from a SSSP cut and tested following Sect. 9.

7.3 PROCESSING PREPARATION FOR SAMPLES AND PARTS

The purpose of processing samples and parts is to create and document a controlled Packcrete casting that follows an approved mixing setup defined on Form A. The same processes are used for casting samples and parts, with the vibration force being adjusted for EWCW of the container and on partial fillings of containers being vibrated for 10 s and turned off and vibrated for 1 min after filling is completed. These and other processing forms data are recorded on Forms C, D, and E or form(s) in the SSPES (for the SSSP).

7.3.1 Setup—Mixing, Vibration Casting, and Curing Samples and Parts

The active mixing setup approved settings for that casting are on Form A (Attachment E) and identified by the SACN shall be followed for that container size. The Packcrete setup approval process is documented in Sect. 7.2 prior to proceeding to the PLQ process of casting the 30-gal drum documented in Sect. 7.5. The 4.5-gal pail Form C and 30-gal drum Form D have also been used to train and become familiar with Packcrete processing.

A concrete curing vibrator such as McMaster-Carr 7693T18, may be used to vibrate the Packcrete after pouring in a casting that is too large to move or use a vibration table to minimize large air bubbles. Additional vibrators and methods may be used to obtain acceptable Packcrete density in a simulated casting. Specific models of vibrators shall only be used if their use and applicable settings are qualified per the SSPES and documented in approved procedures.

Each unique EWCW of a sample or part shall have the vibration table force set as shown in Sect. 7.3.1.6 for the VIBCO SCR-1000. For a different VIBCO vibration motors use, contact the Company for the proper settings. For samples, document the casting information on the proper Forms C, D, and E (Attachment E) or form(s) in the SSPES. Follow the SSPES for casting in shipping containers. For optional samples, use Forms C, D, and E or form(s) in the SSPES to record casting data. Adjustments shall be made to the casting vibration force settings based on the EWCW of the sample. The Seller shall complete the following steps:

7.3.1.1 Ensure that the mixer specified on Form A for SACN is properly cleaned in accordance with Sect. 6.1, and inspect its working surfaces for residues or foreign materials (e.g., oil, grease, or non-Packcrete material affixed to the surfaces) and excess waste material; clean if required.

7.3.1.2 Verify that the mixer blades are operating within the qualified mixer rotation speed range for the qualified mixing times. Determining total mixing rotations requires both the mixer speed and the time that the mixer runs at that rotation speed. The total number of rotations of the mixer blades shall be controlled by settings on Form A by SACN for each mix time and recipe ingredient. The mixer rotation speed and/or mix times may be modified to obtain the total number of mixer blade rotations. For the WM70PE mixer, see Sect. 6.2.2. Other mixer rotation speeds and times shall be qualified as needed.

7.3.1.3 Ensure that the mixer can transfer the Packcrete from the mixer into the container on the vibration table. If not, adjust the locations. Hand loading is also acceptable.

7.3.1.4 Verify that the force counter weights of the vibration table are set to generate a vibration of ~2.1 times the wet cast weight estimate per Sect. 7.3.1.6. Record this setting on the casting form. The speed setting is specified on Form A for the SACN.

7.3.1.5 Verify that the vibration setting on the table speed is set as specified on Form A for the SACN. The vibration casting frequency for SCR-1000, or a Company-approved equal, shall be held fixed at 80% of 4000 rpm speed, generating ~53 Hz (3200 vpm) to properly cast Packcrete (Sect. 6.2.3). Ensure that the speed setting

is fixed and not free to change. Higher vibration forces (Sect. 7.3.1.6), frequency, and durations result in higher wet and baked densities.

7.3.1.6 Vibration force is defined by the manufacturer and shown in Attachment D for the VIBCO SCR-1000. (The table in Attachment D was used to select a force at a setting and to create an equation that defines the forces between the settings.) Verify that the force eccentric counter weights of the vibration table (shown in Fig. 5) are set in accordance with Table 5 or the equations in the section generated from the force settings in Attachment D. The vibration intensity (vibration force / wet cast weight estimate) must be around 2.1±.6 times the EWCW. Since the EWCW is ~38 lb for the 4.5-gal metal pail, 74 lb for the 30-gal drum EWCW is ~255 lb with a vibration force of 532 lb, the PQ for each size casting must have the unique vibration force modified for that casting. To generate force settings between the table values, use the following equation to estimate the vibration force at a set value:

For the VIBCO SCR−1000

$VForce = -33.9 \times Set\ No.^2 + 449.6 \times Set\ No. - 380$ lbf

$VForce = -33.9 \times 1.1^2 + 449.6 \times 1.1 - 380 = 74$ lbf (Set No.@ 1.1)

Use a 2.1 vibration intensity force multiplier for the EWCWs and round to the nearest tenth for loads less than 500 lb. If the EWCW is between 500 to 730 lb, the maximum vibration force setting of SCR-1000 is 6, and the vibration force is 1100 lb. For containers over 730 lb, a different vibration source must be developed.

For the VIBCO SCR-1000

$Set\ No. = 6.63 - (150612 - 285 \times EWCW)^{.5} / 67.8$

$Set\ No. = 6.63 - (150612 - 285 \times 38)^{.5} / 67.8$

Set No. = 1.1 (EWCW@38 lb)

Table 5. Vibration settings

Casting	SCR-1000 Set No. [a]	Vibration force [b] (lb)	Estimated wet cast weight [c] (lb)	Vibration intensity
4.5-gal metal pail	1.1	74	38	1.94
30-gal metal drum	2.5	532	255	2.09

[a] Vibration force setting numbers for the VIBCO SCR-1000 are shown in Attachment D. For other vibration motors, document the changes in the specific shipping package equipment specification and contact the Company for force settings and approval.

[b] Recommended vibration force settings for the VIBCO SCR-1000 shown in Attachment D. Vibrate for 10 s for partial fills and 1 min after filling is completed.

[c] The EWCW is for one full casting mold using an estimated wet casting density of 53.9 lb/ft3.



Fig. 5. VIBCO SCR−1000 default eccentric counter weight set at 3 (675 lb).

7.3.1.7 Inspect the inner surfaces of the empty container. Ensure that it is free of oil, grease, free liquids, and waste material; clean as needed per Sect. 6.1.

7.3.1.8 Prepare the Packcrete raw materials by performing the following actions:

7.3.1.8.1 Transfer the SACN from Form A to Form B.

7.3.1.8.2 Transfer the required measurement amounts from Form A to Form B.

7.3.1.8.3 Record the water chlorine measurement on Form B each day.

7.3.1.8.4 Verify that the mixing area has acceptable environmental setup per Sect. 6.3.1.

7.3.1.8.5 Verify that the mixing area has acceptable mixing water per Sect. 6.3.2.

7.3.1.8.6 Verify that the curing area has acceptable environmental setup per Sect. 6.3.3.

7.3.1.8.7 Verify that the bags of materials were stored properly and are not damaged per Sect. 6.3.4.

7.4 PROCESS—MIXING AND VIBRATION CASTING, CURING, AND BAKING FOR SAMPLES AND PARTS

The active mixing setup approval settings on Form A (Attachment E) identified by the SACN from Sect. 7.2 shall be followed once approved. Mixers and vibration table speed setting are qualified following Form A for the rpm or frequency (Sect. 7.3.1.5). The vibration force (Sect. 7.3.1.6) must be calculated for each unique casting size. Record the vibration force setting on casting Forms C, D, and E (Attachment E) or form(s) in the SSPES for each casting. Place a check on the casting form next to the setting once the vibration motor is set. For optional samples Forms C, D, and E or form(s) in the SSPES are used to record casting data. Adjustments shall be made to the casting vibration force settings based on the wet cast weight estimate.

7.4.1 Process—Mixing and Vibration Casting for Samples and Parts

The Seller shall complete the following steps:

7.4.1.1 Weigh and record the container weight “clean and empty” on Forms C, D, and E (Attachment E) or form(s) in the SSPES.

7.4.1.2 Weigh and record the container weight "filled with water" on Forms C and D or form(s) in the SSPES. For Form E, the "filled with water" weight is replaced with a calculated volume and wet cast weight estimate. Record the container volume.

7.4.1.3 Record the MCN, SACN, Vermiculite wt. %, Water Filter replacement date and weather is current on Form B.

7.4.1.4 Verify that the mixer speed rpm is set according to SACN.

7.4.1.5 On Form B, record daily mix water's chlorine value and check that it is acceptable.

7.4.1.6 Weigh and record the mixing water's temperature on Form B and the air temperature.

7.4.1.7 Inspect material bags for visible damage; discard damaged bags (such as water damage) and check that they are acceptable.

7.4.1.8 Weigh and record the Portland cement and vermiculite to the recipe on Form A for the SACN using a certified scale and record on Form B.

7.4.1.9 Measure the amount of Airalon 3000 shown in the recipe on Form A for the SACN in a graduated cylinder and record on Form B.

7.4.1.10 Add water and Airalon 3000 to the mixer and mix for at least 1 min, add Portland cement to the mixer and mix for at least 1 min, and add vermiculite to the mixer and mix for 50–70 s in accordance with the SACN recorded on Form A. For each mix, record the MCN and the SACN on a unique mixing Form B.

7.4.1.11 Ensure that the mixture is uniform and thoroughly mixed with minimal visible dry material and free liquids remaining in the mixer. If required, adjust the mix times until the mixture is uniform and modify the SACN and send it for Company approval.

7.4.1.12 If the mix looks too dry or wet, perform the ASTM C860, Sect. 6.2, Ball-In-Hand Test. If the test fails, adjust the water content accordingly, record any changes to be applied on the next mixer batch, generate a new Form A to request approval for a new SACN, and discard the mixer load. Contact the Company to approve the new Form A and new SACN.

7.4.1.13 Record the vibration table force setting on the casting Forms C, D, and E or form(s) in the SSPES in accordance with Table 5 in Sect. 7.3.1.6 if applicable. If other vibration sources are used document them in SACN (Form A).

7.4.1.14 Set the vibration speed setting on the table (SCR-1000 @ 80%) per Sect. 7.3.1.5 and record it on Forms C, D, and E or form(s) in the SSPES. Ensure that the speed setting is fixed and not free to change.

7.4.1.15 Start and stop the vibration table based on the vibration cycle time. For partial castings, vibrate the container 10 s and stop. Once the casting is full, vibrate for 1 min and record the vibration setting, vibration force, and vibration intensity on Forms C, D, and E or form(s) in the SSPES.

7.4.1.16 While the casting is wet, scrape the casting opening, clean the container, and measure and record the actual wet cast weight on Forms C, D, and E or form(s) in the SSPES.

7.4.1.17 Calculate the wet density, record the wet density on Forms C, D, and E or form(s) in the SSPES and verify that the wet density is within the acceptable limits on the casting forms. Section 7.1.5 defines the recommended wet density range. If the wet density is not within the acceptable limits, it is recommended to discard the container load, adjust the vermiculite dry weight percent and water weight as defined in Sect. 7.1.5, obtain written Company approval by repeating the SACN Form A, and repeat steps starting with Sect. 7.4.1.1. If the adjustment limits are met and the wet density is still out of specification, contact the Company.

7.4.2 Process—Curing for Samples and Parts

The Seller shall complete the following steps:

7.4.2.1 If the curing area has an acceptable environment as defined in Sect. 6.3 and the cast wet density is acceptable, move to curing area.

7.4.2.2 Cover the casting with plastic and initial cure for 4–30 h.

7.4.2.3 For sample pipes, after initial curing and before baking, the plug in the sample pipe will need to be removed. Scrape both ends of the casting to a flatness of 0.02 in. The flush cast side needs to be finished to a depth of 0.3 ± 0.05 in. and the plug side needs to finished to a height of 4.5 ± 0.05 in. from the fill hole end. This flatness can be obtained by using a drill press and large flat bottom bit made from sheet metal and welded to a small rod. The bit should just fit inside the sample pipe, and as the drill bit turns, the sample pipe is slid in a small circle, scraping the bottom of the casting flat. Remove the scraped Packcrete shavings from the sample pipe before baking.

7.4.2.4 After scraping, clean the parts, cover them with plastic, and store in the curing area until fully cured.

7.4.2.5 Cure at least 7 days before baking based upon the estimated BCN − MCN and record cure time on Forms C, D, E, and SSP.

7.4.2.6 Weigh and record the before baking weight on Forms C, D, and E or form(s) in the SSPES.

7.4.3 Process—Baking for Samples and Parts

The Seller shall complete the following steps.

7.4.3.1 Using a large vented furnace separate the castings as much as possible to ensure proper airflow and radiation heat transfer for each casting.

7.4.3.2 Place the cured castings into the furnace.

7.4.3.3 Record the BCN on Forms C through E for all casting parts in the furnace.

7.4.3.4 For parts, on Form F, record the number of each casting loaded into the furnace. Calculate the sub-total volume of each casting type and the total volume of the furnace load for the BQCN.

7.4.3.5 Calculate and record the actual cure time on Forms C, D, and E or form(s) in the SSPES for all casting parts before the furnace is started. Assure the cure time is over 7 days.

7.4.3.6 Set the initial furnace set point temperature to 200°F.

7.4.3.7 Hold the temperature at 200°F for 4 h and record date and times on Form F.

7.4.3.8 Increase the furnace set point temperature to 275°F.

7.4.3.9 Hold the temperature at 275°F for 1 h and record date and times on Form F.

7.4.3.10 Increase the furnace set point temperature to 350°F.

7.4.3.11 Hold the temperature at 350°F for 1 h and record date and times on Form F.

7.4.3.12 Increase the furnace set point temperature to 425°F.

7.4.3.13 Hold the temperature for at 425°F 1 h and record date and times on Form F.

7.4.3.14 Increase the furnace set point temperature to 500°F.

7.4.3.15 Hold the temperature at 500°F steady state and record date and times on Form F.

7.4.3.15.1 For baking small samples, a qualified baking time of at least 40 h has been shown to be successful. Record the 500°F bake time on Form F. Optionally, the samples may be placed in the furnace with simulated shipping package specific parts following Form F.

7.4.3.15.2 Record the 500°F baking time on Form F for the volume of castings in the furnace by placing a bottom center thermocouple (BCT) to measure the temperature of the bottom center of the simulated shipping package specific parts inner liner for the current furnace loading located at the coolest location in the furnace (near the door edge seals). For the 30-gal drum, place the BCT in the center of the casting, 6-in. deep. Record the minimum 500°F holding time when the BCT temperature is >425°F and no increase in the BCT over 2°F in 6 h of baking. This minimum 500°F baking time shall be recorded along with the furnace cubic foot casting volume to qualify the unique furnace load with the BQCN plus the volume in cubic feet.

7.4.3.15.3 A qualified baking time at 500°F shall be used for simulated shipping package specific parts, and samples of equal or less casting volume identified by the BQCN and recorded on Form F. The BCT is not required.

7.4.3.16 After the minimum baking time is met for 500°F, turn off the furnace and let the castings slowly cool down with the door closed for at least 8 h.

7.4.3.17 Remove castings and allow cooling in air until they reach ambient temperature.

7.4.3.18 Weigh and record the after baking weights on Forms C, D, and E or form(s) in the SSPES.

7.4.3.19 Calculate and record the baked density on Forms C, D, and E or form(s) in the SSPES using the equation at the bottom of the form.

7.4.3.20 Verify that the baked density is within the recommended acceptable limits at the bottom of the form.

7.4.3.20.1 For an SACN casting with the acceptable baked density, submit completed Forms A, B, C, and F for 4.5-gal pail sample to the Company for approval with the PLQ testing results. If approved, go to Sect. 7.6.

7.4.3.20.2 For an unacceptable baked density and this is the first failure, go to Sect. 7.4.1 and repeat this process.

7.4.3.20.3 For an unacceptable baked density and multiple failures have occurred, go to Sect. 7.1.4 or 7.1.5 and adjust the weight percent of vermiculite in the mixture and repeat the SACN casting in Sect. 7.4.1.

7.4.3.20.4 For an unacceptable baked density and multiple failures have occurred and the vermiculite weight percent is at the acceptable bounds shown in Sect. 7.1.5, contact the Company for guidance.

7.5 SETUP APPROVAL PROCESS VERIFICATION—4.5-GAL PAIL OR 30-GAL DRUM

The 4.5-gal pail or 30-gal drum have been used to verify the mixing setup control number (SACN) process that generates an acceptable wet and baked density following the requirements in Sects. 7.3 and 7.4. The 4.5-gal pail needs Forms A, B, C, and F while the 30-gal drum needs Forms A, B, D, and F (Attachment E) are needed to document this effort. Use these small castings if needed to verify the lots of material and process settings. Once these are verified, proceed to shipping package specific specification and perform a process and LQ castings.

7.6 PACKCRETE PIPE SAMPLES FOR PRELIMINARY AND FINAL LOT QUALIFICATION

Pipe samples are required for both preliminary and final lot qualifications. The pipe sample casting requires a different stand-alone vibration table setup that vibration casts at least two pipe samples for each mixer load going into the production run mixes. This stand-alone table needs a maximum force of 100 lb and a speed of 3200 vibrations per minute, generating a frequency of 53 Hz. VIBCO supplies a standalone table that meets these requirements. The SACN used will be different than the SACN for the VIBCO SCR-1000. Follow Sects. 7.3 and 7.4 and use Forms A, B, E, and F (Attachment E) to document pipe sample casting. Section 8 describes pipe sample preparation requirements, and Sect. 9 describes pipe sample testing. Send the manufacturing and testing results to the Company for evaluation. Once the testing data is accepted by the Company, the current Form As will be approved and signed by the Company.

8. PACKCRETE PLQ AND PRODUCTION TEST SAMPLES

The purpose of this section is to describe exception(s) to the processing steps described in detail in Sect. 7 for each type of sample if additional Packcrete testing samples are needed. Each unique vibration casting process is addressed.

In addition to its unique casting control form [Forms C, D, and E or form(s) in the SSPES], Forms A, B, and F are needed for each sample and each type of sample to ensure that vibration force is adjusted to generate a vibration intensity approximately 2.1 times the estimated wet weight as required in Sect. 7.3.1.6. This ensures that the samples for the 4.5-gal pail, 30-gal drum, sample pipes, SSSP are set to the proper force setting.

Each Packcrete sample shall be marked and tracked from its origin.

8.1 PACKCRETE 4.5-GAL PAILS

Form C defines the data required to vibration cast the 4.5-gal pails according to the requirements in Sect. 7.5 and is used to gain casting experience.

8.2 PACKCRETE PRODUCTION SAMPLING SET

The production sampling set shall consist of a 30-gal drum (Sect. 8.5) or SSSP casting following the SSPES and six pipes (Sect. 8.7). This sample set shall be tested in accordance with Sects. 9.2–9.6. The results should be sent to the Company. The 30-gal drum may only be used to replace the SSSP casting in the production sampling set once equivalences has been demonstrated with test results.

8.3 PACKCRETE 30-GAL SAMPLE DRUM

Each 30-gal sample drum manufacturing method shall follow the requirements in Sects. 7.3 and 7.4. Mark and record the Packcrete 30-gal sample drum information on Form D (Attachment E).

8.4 PACKCRETE BRICK SAMPLES PER ASTM C862

Packcrete bricks (9 × 4.5 × 2.5 in.) manufactured for tests that comply with the requirements of ASTM C862 shall be cut from a 30-gal casting that meets the requirements of both Sect. 7 and ASTM C862, note 7.

8.5 PACKCRETE SAMPLE PIPES

Each pipe sample manufacturing method shall be qualified as defined in Sect. 7. Mark and record the unique pipe sample information on Form E (Attachment E). A watertight plug should be inserted into one end 4.8-in. deep from the fill hole. The Packcrete shall be cast into the pipe sample flush and scraped following the instructions in Sect. 7.4.2.3.1. The EWCW of a single pipe sample is ~7.5 lb.

9. PACKCRETE FINAL LOT QUALIFICATION PROPERTIES LIMITS

Chemical and mechanical properties shall be evaluated to document and qualify the lot of raw materials for use in producing Packcrete. Some of these values are defined in Sects. 5–7, and others are not. This section defines additional testing and references RP-802282-0002 for the acceptance ranges. The PLQ test samples may be taken from a 30-gal drum. FLQ test samples may be taken from a SSSP and a set of six sample pipes. Additional material test sample production is defined in Sect. 8 when directed by the Company. A 30-gal drum (preliminary) or SSSP (final) and a six pipe sample set are used for this testing.

9.1 WET AND BAKED DENSITIES

The casting specification uses the wet density as a manufacturing guide to help control the baked density; therefore, the wet density is not important to the safety of the shipping package. The baked density for each casting shall be within the acceptable range of 22.4 ± 3 lb/ft^3, as defined in Sect. 7. The density of the containers will be tested by the Seller for 100% of the castings in accordance with Company-approved procedures.

9.2 DYNAMIC IMPACT CRUSH STRENGTH

Determination of the dynamic impact crush strength involves a set of high-speed compression impact tests performed by the Company using cast sample pipes, as defined in Sect. 8.6. A total of six sample pipes are needed for these tests. These tests shall be tested at each temperature in accordance with "Instructions for Operating 20K-Pound MTS High-Rate Load Frame and Thermotron Test Chamber and Performance of High-Rate Impact Tests," from Y/DW-2345. The acceptable bounding values are listed in RP-802282-0002.

9.3 CHEMICAL COMPOSITIONS OF THE CONSTITUENTS

Three samples taken from a 30-gal drum (preliminary) or SSSP (final) are needed for verifying the chemical composition. Each sample shall be oven dried at 45°C. Oxide analysis X-ray fluorescence spectrometry samples shall be fused at 1000°C with $Li_2B_4O_7/LiBO_2$. X-ray fluorescence oxide analysis shall meet the precision

and accuracy requirements for rapid methods per ASTM C114-11b requirements. The Packcrete chemical composition acceptable bounding values are listed in RP-802282-0002.

9.4 THERMAL CONDUCTIVITY

Three samples cut from a 30-gal drum (preliminary) or SSSP (final) casting with an acceptable baked density are needed for verifying the thermal conductivity. The thermal conductivity of the samples is measured following ASTM C1113. The thermal conductivity is measured at 20, 100, 200, 300, 400, 500, 600, 700, and 800°C. The three test values shall be averaged at each temperature. These averaged values shall be between the acceptable values listed in RP-802282-0002.

9.5 SPECIFIC HEAT CAPACITY

Three samples cut from a 30-gal drum (preliminary) or SSSP (final) casting with an acceptable baked density are needed for verifying the specific heat capacity. The specific heat capacity shall be tested from 35 to 995°C and in 10°C increments following ASTM E1269 requirements. The three test values shall be averaged at each temperature. These values shall be between the acceptable values listed in RP-802282-0002.

9.6 LINEAR THERMAL COEFFICIENT OF EXPANSION

Three samples cut from a 30-gal drum (preliminary) or SSSP (final) casting with an acceptable baked density are needed for verifying the linear thermal coefficient of expansion. The linear thermal coefficient of expansion shall be tested following ASTM E228 requirements at a temperature range of −170 to 290°C at 10°C increments. The average of the three tests values from −40 to 150°C shall be between the acceptable values listed in RP-802282-0002.

9.7 ELASTIC MODULUS

The elastic modulus for Packcrete is derived from dynamic impact strength testing results defined in Sect. 9.2, and this property has been found to not be important to the safety of the shipping package. The average test values shall be between the acceptable values listed in RP-802282-0002.

9.8 POISSON'S RATIO

Uncompressed (elastic) and compressed (plastic) Poisson's ratio in the past has been assumed based upon similar types of material and the state of the material. The exact value is not important to the safety of the shipping package. Further explanation is found in RP-802282-0002.

ATTACHMENTS

ATTACHMENT A: SUBMITTAL CHECK LIST

Instructions to Supplier for Preparation of Submittals

Note 1 –All correspondence shall be addressed to the Technical Representative identified by the Company. The Supplier shall forward submittals via transmittal letter to the Company at the address specified in the contract.

Note 2 – The submittal must have adequate detail so that full compliance with the requirements may be determined. For example, a simple off-the-shelf item to be used in an assembly may only need a manufacturer's cut-sheet to show compliance, but a factory acceptance test (FAT) developed and submitted by the Seller must have each test step detailed with acceptance criteria consistent with the requirements.

a. Review submittal before transmitting to the Company to verify conformance with requirements of the contract documents (e.g., field measurements, field construction criteria, or manufacturer's catalog numbers).
b. Coordinate submittals with the work requirements and the contract documents.
c. Organize Submittals
    - Do not use highlight marker or color coding on submittals.
    - The minimum resolution used for scanning submittals shall be 300 dpi x 300 dpi.
    - For submittals containing color information important to the record, a 24-bit color setting should be used.
    - Submittals are to be legible and in the format specified on the submittal checklist.
    - Pen and ink changes are to be made in non-erasable ink, legible, dated and initialed.
    - Mark specific options provided for the work, and cross out options not provided.
    - Each submittal shall be sent as a single pdf file unless otherwise specified.
d. Label submittals with the applicable item number, reference, and requirement description as summarized in the Submittal Checklist.
    NOTE: Unlabeled submittals will be returned to the Seller without review.
e. Include with submittals a transmittal letter that identifies individual documents by specification section/paragraph number and purpose(s) of submittal (i.e., for substitution, review, information, approval, etc.)
    - Transmittal for submittals shall be numbered using the purchase order number followed by a 4-digit sequential number. (Example: 430001111-0001).
    - Embedded comments or questions that are not included on the transmittal may not be addressed/resolved by the Company.
f. Direction will be given at the time of award to either upload submittals to a company provided URL address or send by email to a company provided email address.
g. If using a company provided URL to upload submittals, notify the Company via email when submittals have been placed.

UCN-22212V (3-15)

Instructions to Supplier for Preparation of Submittals, Continued

h. If a submittal is being resubmitted, then reference the applicable item number, reference, and requirement description and identify it as a resubmittal.
i. Company response will only be returned to the Supplier for those submittals with a Submittal Purpose of "For Action," unless it is determined that a submittal transmitted "For Information" is not acceptable.
j. AFTER written approval is obtained, THEN proceed with work requiring approved submittals.
k. Maintain a copy of the company-approved submittal and status page on file.

SUBMITTAL SCHEDULE				FORMAT		SUBMITTAL PURPOSE	
AA	After Award	PTM	Prior to Mobilization	CD	Compact Disk	FI	For Information
AI	After Issue	PTS	Prior to Shipment	DVD	Digital Video Disk	FA	For Action
AIT	After Inspection/Test	PTT	Prior to Test	EM	E-Mail		
AM	After Mobilization	PTW	Prior to Weld	EN	Electronic (Native)		
AP	After Proposal/Bid	Q	As Required	EP	Electronic (PDF)		
ATS	At Time of Shipment (Separately)	R	As Requested	O	Original		
B	Before Balance of Payment	WP	With Proposal/Bid	P	Prints/Photocopies		
NTP	Notice to Proceed			PH	Photographs		
PTC	Prior to Construction/Commencing Work			S	Sample		
PTD	Prior to Delivery			X	X-rays		
PTF	Prior to Fabrication						
PTFA	Prior to Final Acceptance/At Completion						
PTL	Prior to Lift						

Packcrete Casting Submittal Check List

Item No.	Reference	Requirement Description	Schedule	Format [a]	No. of Copies	Submittal Purpose
	3.8	Manufacturing Plan	PTF	EP	1	FA
	3.9.1	Excel Submittal Checklist	Q	EM, EN	AR	FI
	3.9.1	Approval Data documents for Packcrete processes procedures for weighing, mixing, pouring, vibrating, curing, and baking.	PTF	EP	1	FA
	3.9.2[a]	Raw Material Test Reports and Third Party Test Laboratory Certificate of Conformance (COC)	PTF	EP	1	FA
	3.9.2[a]	Copy of mixing materials COC	PTF	EP	1	FA
	3.9.2[a]	Certification Data Package	PTD	EP	1	FA
	3.9.2[a]	Approved Procedures used	PTF	EP	1	FA
	4	Quality Assurance Plan	WP	EP	1	FA
	4.7	Training and Qualification of Personnel	PTF	EP	1	FA
	6.	Written Plan for cleaning, equipment, work, and storage environments	PTF	EP	1	FA
	7.2	Mixing Setup Control Number (SACN) Process Verification (Form A)	PTF	EP	1	FA
	7.5	Setup Approval Process Verification—4.5-gal Pail or 30-gal Drum	PTF	EP	1	FA, FI
	7.6	Lot Qualification Castings	PTF	EP	1	FA, FI
	9.3	Chemical Compositions of the Constituents	PTF	EP	1	FI
	9.4	Thermal Conductivity	PTF	EP	1	FA
	9.5	Specific Heat Capacity	PTF	EP	1	FA
	9.6	Linear Thermal Coefficient of Expansion	PTF	EP	1	FA
	9.7	Elastic Modulus	PTF	EP	1	FA

Packcrete Casting Submittal Check List

Item No.	Reference	Requirement Description	Schedule	Format [a]	No. of Copies	Submittal Purpose
	Att. E Form A	Packcrete Setup Approval	PTF	EP	1	FA, FI
	Att. E Form B	Packcrete Mixing for Samples and Parts	PTD	EP	1	FA, FI
	Att. E Form C	Packcrete Sample 4.5-Gal Pail Vibration Casting Control	PTD	EP	1	FA, FI
	Att. E Form D	Packcrete Sample 30-Gal Drum Vibration Casting Control	PTD	EP	1	FA, FI
	Att. E Form E	Packcrete Sample Pipes Vibration Casting Control	PTD	EP	1	FA, FI
	Att. E Form F	Packcrete Furnace and Baking	PTD	EP	1	FA, FI

[a] The Certification Data Package must also have one printed hard copy of the entire certification data.

ATTACHMENT B: REQUEST FOR WAIVER/DEVIATION SAMPLE FORMS

CLICK HERE FOR INSTRUCTIONS

CNS consolidated nuclear security, llc

REQUEST FOR WAIVER OR DEVIATION (RFWD)

1. REQUEST TYPE	2. SHEET 1 OF
☐ DEVIATION (Supplier Initiated) ☐ WAIVER (Supplier Initiated) ☐ Change (CNS Initiated)	3a. NUMBER 3b. SAP DMS NUMBER

4. SUPPLIER	5. P.O. NO. / ITEM NO.	6. PROGRAM / PROJECT	7. DOCUMENT NO. / REV.
8. COMPONENT NAME	9. PART OR IDENTIFYING NO.	10. ☐SERIAL or ☐ LOT NO.	11. LOT SIZE

12. SPEC. REF. NO.	13. SPECIFICATION REQUIREMENTS	14. DESCRIPTION OF WAIVER/DEVIATION/CHANGE	15. SUPPLIER PLAN FOR CORRECTIVE ACTION
1)			
2)			
3)			
4)			

16. INITIATING ENTITY REPRESENTATIVE (print /sign)	17. TITLE	18. COMPANY	19. DATE

RESPONDING ENTITY EVALUATION (TO BE COMPLETED BY RESPONDING ENTITY EVALUATOR)

20. SPEC. REF. NO.	21. EVALUATION COMMENTS	22. EVALUATOR (print/sign) / DATE	23. RECOMMENDED DISPOSITION
1)			☐ ACCEPT ☐ REJECT
2)			☐ ACCEPT ☐ REJECT
3)			☐ ACCEPT ☐ REJECT
4)			☐ ACCEPT ☐ REJECT

24. ARE DESIGN DRAWING(S), SPECIFICATION(S), DATA SHEET(S), INSPECTION PLANS(S), OR SURVEILLANCE PLAN(S), ETC. CHANGES REQUIRED? ☐ YES ☐ NO
IF YES, LIST DOCUMENTS REQUIRING CHANGES (TO BE COMPLETED BY CNS REPRESENTATIVE)

Y60-015, 4.2.4.3.4.7.4.8 & 4.11
UCN-13816B (01-15)

SHEET ___ OF ___

CLICK HERE FOR AN ADDITIONAL PAGE

APPPOVALS (CNS Approvals Require Same Affected Functions/Organizations Approval As Original Document)			
25. ENTITY	26. NAME (print/ sign)	27. DATE	28. APPROVE/REJECT RECOMMENDED DISPOSITIONS
CNS Customer/Program Manager:			☐ APPROVED ☐ REJECTED
CNS Technical Representative:			☐ APPROVED ☐ REJECTED
CNS Design Authority Representative:			☐ APPROVED ☐ REJECTED
CNS Project Representative:			☐ APPROVED ☐ REJECTED
CNS Quality Engineer:			☐ APPROVED ☐ REJECTED
Design Engineering:			☐ APPROVED ☐ REJECTED
Product/Packaging Engineering:			☐ APPROVED ☐ REJECTED
Procurement Representative:			☐ APPROVED ☐ REJECTED
CNS Other (List):			☐ APPROVED ☐ REJECTED
Supplier Representative:			☐ APPROVED ☐ REJECTED

Y60-015, 4.2.4.3,4.7,4.8 & 4.11
UCN-13816B (01-15)

CNS

REQUEST FOR WAIVER OR DEVIATION (RFWD)
(Continuation)

1. REQUEST TYPE	2. SHEET ____ of ____
☐ DEVIATION (Supplier Initiated) ☐ WAIVER (Supplier Initiated) ☐ Change (CNS Initiated)	3a. NUMBER 3b. SAP DMS NUMBER

4. SUPPLIER	5. P.O. NO. / ITEM NO.	6. PROGRAM / PROJECT	7. DOCUMENT NO. / REV.
8. COMPONENT NAME	9. PART OR IDENTIFYING NO.	10. ☐SERIAL or ☐ LOT NO.	11. LOT SIZE

	12. SPEC. REF. NO.	13. SPECIFICATION REQUIREMENTS	14. DESCRIPTION OF WAIVER/DEVIATION/CHANGE	15. SUPPLIER PLAN FOR CORRECTIVE ACTION
1)				
2)				
3)				
4)				

16. INITIATING ENTITY REPRESENTATIVE (print /sign)	17. TITLE	18. COMPANY	19. DATE

RESPONDING ENTITY EVALUATION (TO BE COMPLETED BY RESPONDING ENTITY EVALUATOR)

	20. SPEC. REF. NO.	21. EVALUATION COMMENTS	22. EVALUATOR (print/sign) / DATE	23. RECOMMENDED DISPOSITION
1)				☐ ACCEPT ☐ REJECT
2)				☐ ACCEPT ☐ REJECT
3)				☐ ACCEPT ☐ REJECT
4)				☐ ACCEPT ☐ REJECT

24. ARE DESIGN DRAWING(S), SPECIFICATION(S), DATA SHEET(S), INSPECTION PLANS(S), OR SURVEILLANCE PLAN(S), ETC. CHANGES REQUIRED? ☐ YES ☐ NO
IF YES, LIST DOCUMENTS REQUIRING CHANGES (TO BE COMPLETED BY CNS REPRESENTATIVE)

Y60-015, 4.2,4.3,4.7,4.8 & 4.11
UCN-13816C (01-15)

RFWD Completion Instructions

INITIATING ENTITY

The following fields are to be completed by the INITIATING ENTITY. The purpose of Block No.1 through 20 is the identification of the Waiver/Deviation/Change. For Waivers and Deviations, the Initiating Entity is the Supplier. For Changes, the Initiating Entity is Y-12.

1. **REQUEST TYPE –** Check the appropriate block:
   - DEVIATION (Supplier initiated, prior to production)
   - WAIVER (Supplier initiated, during or after production)
   - CHANGE (Y-12 initiated, after award of contract)

2. **SHEET/FORM PAGES –** Complete Page of Page(s), including any attachments or supporting documents. Each page's Sheet/Form block must be completed (i.e., Page 1 of 2; Page 2 of 2; Page 3 of 3; Pages 10 of 10, etc.).

3. **3.a NUMBER –** An identifying, sequential numbering system acceptable to supplier and Y-12 (e.g., Purchase Order Number + sequential number – [examples 430001234-1, 430001234-2,etc].
   3.b SAP DMS NUMBER – Y-12

4. **SUPPLIER –** Supplier Name associated with the Waiver, Deviation, or Change.

5. **PURCHASE ORDER (P.O.) NUMBER/ITEM NUMBER –** From the Y-12 issued P.O. and the item number associated with the P.O.

6. **PROGRAM/PROJECT –** Program or project name, if applicable.

7. **DOCUMENT NUMBER and REVISION –** Drawing or Specification Number and Revision.

8. **COMPONENT NAME –** Name take from Y-12 design document(s).

9. **PART OR IDENTIFYING NUMBER –** Part Name or unique reference number.

10. **SERIAL OR LOT NUMBER –** Check the appropriate box and enter the Serial Number or Lot Number, if applicable.

11. **LOT SIZE –** Total quantity of parts affected by the WAIVER/DEVIATION/CHANGE.

12. **SPECIFICATION REFERENCE NUMBER –** Paragraph number or drawing reference/location of characteristic(s) to be waived/deviated/changed (each characteristic requires individual line).

13. **SPECIFICATION REQUIREMENT –** Requirement(s) extracted from the specification/drawing.

14. **DESCRIPTION OF WAIVER/DEVIATION/CHANGE –** Written explanation of what characteristic is to be waived/deviated/changed (e.g., technical or material requirement is violated, requirement in supplier document is violated, nonconformance cannot be corrected by continuing the original process or rework, item does not conform to the original requirement, but can be restored to condition that it will function unimpaired, Y-12 is directing the Supplier to make a change to what is specified in the contract document(s), etc.).

Y60-015, 4.2,4.3,4.7,4.8 & 4.11
UCN-13816B INST (01-15)

RFWD Completion Instructions (continuation)

15. **SUPPLIER PLAN FOR CORRECTIVE ACTION –** Written explanation of corrective action(s) taken or planned to address each waiver/deviation characteristic identified which may include disposition recommendations such as accept/use-as-is, rework to specification, repair to usable condition, return to vendor, reject/scrap, etc., if applicable. This block does not apply to Y-12 initiated changes. (NOTE: If more SPEC. REF. NOs. are needed , a TAB key at the last entry of Block No.15 will insert an additional line, else "mouse click" to Block No. 16).

16. **INITIATING ENTITY REPRESENTATIVE –** Name (print/signature) of the authorized representative of the Initiator (Supplier or Y-12) submitting the Waiver/Deviation/Change.

17. **TITLE –** Title of the Initiating Entity Representative from Block No.16.

18. **COMPANY –** Company affiliation of the Initiator (Y-12 or Supplier).

19. **DATE –** Date Waiver/Deviation/Change initiated.

Responding Entity Evaluation

The following fields are to be completed by the RESPONDING ENTITY EVALUATOR. The purpose of Block 20 through 23 is the evaluation of the proposed Waiver/Deviation/Change. For Waivers and Deviations, the Responding Entity is Y-12. For Changes, the Responding Entity is the Supplier.

20. **SPECIFICATION REFERENCE NUMBER –** Item(s) transposed from Block No.12 above, to be evaluated.

21. **EVALUATION COMMENTS –** Written evaluation of each Waiver/Deviation/Change requested by the Initiating Entity.

22. **EVALUATOR/DATE –** Name (print/signature) of the Evaluator for the responding Entity and the Date of the evaluation. The Evaluator is one who is technically qualified to evaluate the proposed Waiver/Deviation/Change.

23. **RECOMMENDED DISPOSITION –** Based on the evaluation and the comments provided in Block 21, the Evaluator's recommendation to either Accept or Reject each Waiver/Deviation/Change Item. For Waivers and Deviations, this represents the Y-12 Evaluator's intended recommendation to other Y-12 functions/organizations for acceptance or rejection of each proposed waived/deviated item. For Changes, this represents the Supplier's intended acceptance or rejection of each proposed change initiated by Y-12.

Y-12 Representative

24. **ARE DESIGN DRAWINGS(S), SPECIFICATIONS, OR DATA SHEET(S) CHANGES REQUIRED –** Indicate (Yes or No) if changes to the original contract documents or supporting/operational documents are warranted because of the Waiver/Deviation/Change.

Y60-015, 4.2,4.3,4.7,4.8 & 4.11
UCN-13816B INST (01-15)

RFWD Completion Instructions (continuation)

Approvals

Y-12 approvals require the same affected functions/organizational approval as the original document (Applicability is determined by the original document approvals and the governing document procedures). The Technical Representative is responsible for identifying and obtaining the appropriate approvals and processing the RFWDC form.

25. **ENTITY** – The required list of approvers may include:
    - Y-12 Customer/Program Manager (i.e., end user)
    - Y-12 Technical Representative
    - Y-12 Design Authority Representative, as applicable (otherwise, N/A)
    - Y-12 Project Representative, as applicable (otherwise, N/A)
    - Y-12 Quality Engineer, as applicable (otherwise, N/A)
    - Design Engineering, as applicable (otherwise, N/A)
    - Product/Packaging Engineering, as applicable (otherwise, N/A)
    - Procurement Representative, as applicable (otherwise, N/A)
    - Y-12 Other – List additional function positions required to approve, if applicable.
    - Supplier Representative – Person with overall responsibility and authority to approve information and dispositions as documented on this form.

26. **NAME** – Name (print/signature) of each person fulfilling the roles denoted in Block No. 25.

27. **DATE** – Date of approval signature.

28. **APPROVE/REJECT RECOMMENDED DISPOSITION** – Based on the information provided in Block No. 21, each Approver is to approve or reject the Recommended Disposition noted in Block No. 23. Checking the Approved block means the Approver accepts all recommended dispositions provided in Block No. 23. Checking the Rejected block means the Approver rejects one or more of the recommended dispositions provided in Block No. 23.

Note: Communication between the supplier and Y-12 for RFWDC's must be handled by the Y-12 Subcontract Administrator.

Y60-015, 4.2,4.3,4.7,4.8 & 4.11
UCN-13816B INST (01-15)

ATTACHMENT C: AIRALON 3000 INFRARED ANALYSIS

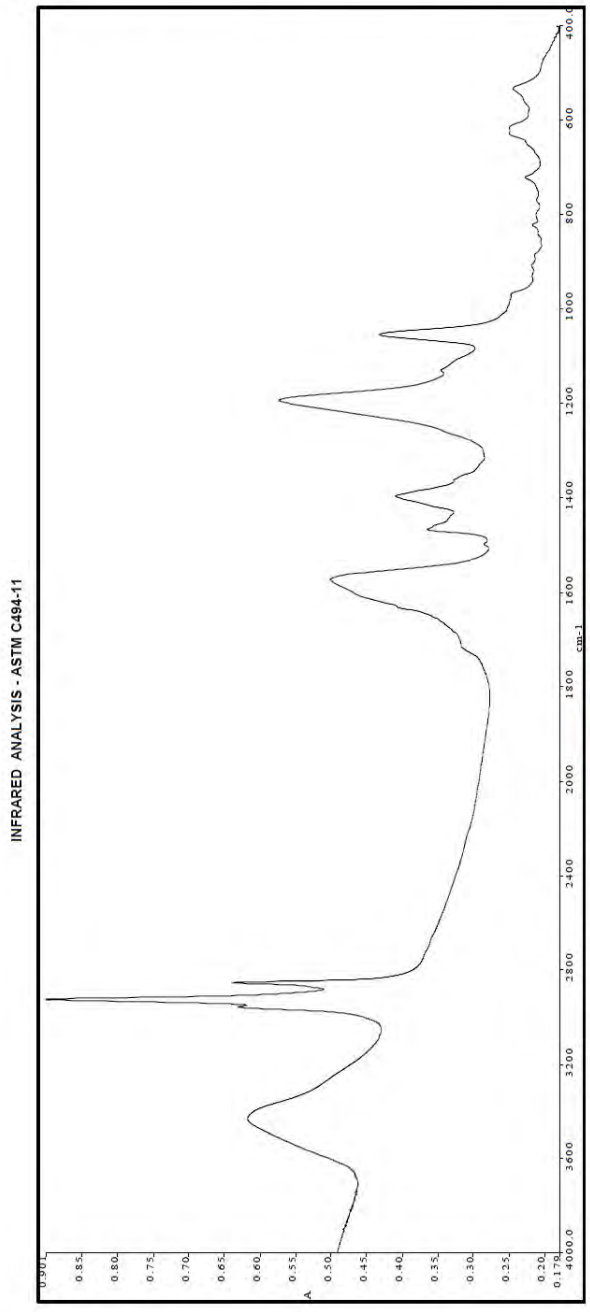


Figure 1 Infrared spectrum of Airalon 3000 Lot No. H0610D750921 (CTL ID 3446802); KBr disk per ASTM C494-11

APPROVED
By hsmith at 3:31 pm, 9/23/13

Notes:
1. This scan represents specifically the sample submitted.
2. The scan was conducted on a Perkin Elmer Spectrum 100 FT-IR Spectrometer.
3. ASTM C260 does not specify a test method for infrared analysis, therefore the infrared analysis was conducted by ASTM C494 modified to use the ASTM C233 residue.
4. This report may not be reproduced except in its entirety.

ATTACHMENT D: VIBCO VIBRATION FORCE SETTINGS

CENTRIFUGAL FORCE (IMPACT)

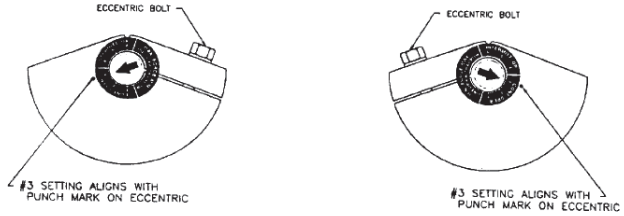
All the electric vibrators have eccentrics attached to the motor shaft. Some are permanently fixed and some are adjustable as per below.

Model 2P (see 2P-75, 2P-100, US-450, SCR-200 below), 4P, 6P, 8P, FC, SFC, US-900, 1600, SCR-500, 1000 vibrators have adjustable eccentrics to give higher or lower impact to suit the application. They are adjustable as follows: Remove the end covers, both sides of the vibrator. The eccentrics will then be in view. There are two different systems of eccentrics. **First system:** The outside eccentric is secured to the inside one with a socket head cap screw. There is either 3 or 6 holes in the outside eccentric. Remove the set screw and turn eccentric to desired position, the diagram below will tell the force at the different positions. **NOTE:** The eccentric should be set at the same number on each side of the vibrator to give uniform vibration.

Second system: The eccentrics are clamped onto the shaft. They are also marked from 1 to 6. Loosen bolt holding eccentrics to shaft and swing eccentric on shaft, line up desired number (force as per table below) with arrow stamped in shaft. Secure bolt firmly. **NOTE:** Set eccentrics on both sides of vibrator on the same number.

Force (Impact) at Different Eccentric Settings in Lbs.

Model	1	2	3	4	5	6	Model	1	2	3	4	5	6
2P-75	50	75*	100										
2P-100	50	100*	150				6P-1500	800	1000	1200*	1300	1400	1500
2P-150	75	150*	300				6P-2500	1200	1600	1900*	2100	2350	2500
2P-200	150	300*	450				6P-5000	2450	3050	3850*	4150	4350	4500
2P-450	50	350	650*	900	1000	1100	6P-7500	3650	4800	5700*	6300	6650	7000
2P-800	50	500	950*	1300	21500	1700	8P-500	150	225	300*	360	425	500
2P-1700	800	1000	1500*	2000	2300	2500	8P-750	200	400	525*	650	700	750
2P-2500	0	1000	1900*	2600	3100	3500	8P-1000	200	400	600*	750	875	1000
4P-350	75	150*	300				8P-1250	700	900	1050*	1110	1190	1250
4P-600	230	270	350	425	480	500	8P-2500	1370	1750	2150*	2250	2375	2500
4P-700	0	160	325*	450	575	700	8P-4000	2100	2700	3200*	3350	3575	3750
4P-1000	275	350	550*	700	870	1000	US-900	600	950*	1100			
4P-1400	250	500	750*	1000	1200	1400	US-1600	1100	1600*	1900			
4P-2000	650	850	1200*	1500	1800	2000	SCR-200	50	125*	200			
4P-3000	1500	1800	2200	2500	2700	3000	SCR-500	150	300*	500			
4P-5000	2500	3500	3800*	4100	4300	5000	SCR-1000	50	350	675*	900	1000	1100
4P-10000	5475	7660	8550*	9000	9450	10000	SFC-100	50	100*	150			
4P-15000	8200	10500	12800*	13600	14300	15000	SFC-300	75	150*	300			
6P-300	0	100	225*	250	275	300	FC-100	75	150*	300			
6P-500	50	150	225*	300	400	500	FC-400	150	300*	450			
6P-1000	200	500	625*	750	875	1000	* Normal setting - higher settings for intermittent use only						



To Adjust Eccentric Settings:

1. Remove both end covers of vibrators.
2. Loosen the bolt that holds the eccentric to the shaft.
3. Turn the eccentric on the shaft to adjust force output. Align the arrow on the shaft to the desired setting. The higher the number, the greater the force.
   NOTE: Both ends of vibrator must be at same setting.
4. Tighten eccentric bolts and reinstall end covers.
5. Figures above show eccentrics at factory setting (#3 setting).

ATTACHMENT E: PACKCRETE PROCESSING FORMS

Form A Packcrete Setup Approval
Form B Packcrete Mixing for Samples and Parts
Form C Packcrete Sample 4.5-Gal Pail Vibration Casting Control
Form D Packcrete Sample 30-Gal Drum Vibration Casting Control
Form E Packcrete Sample Pipes Vibration Casting Control
Form F Packcrete Furnace and Baking

Form A ***Packcrete Setup Approval***	Specification Number	Revision
	Issue date (mm/dd/yy)	Revision date (mm/dd/yy)
Caster's company name (Seller's name)	Setup Approval Control Number (SACN) [a] SA _____	
Check control mix times ☐ ☐ ☐ Water and Airalon—at least 1 min, Portland cement—at least 1 min more, vermiculite—50–70 s more.		

Equipment	Manufacturer	Model No.	Serial No.	Operator	Witness
Mixer					
Vibration table					

Measurement	Comments	Measure	Units	Operator	Witness
Vermiculite (wt %)			%		
Estimated mix volume			ft^3		
Mixer speed control setting			rpm		
Mixer blade rotation speed [b]	Measured rpm [1200 / time_____ (s)]		rpm		
Vibration speed setting [c]	80% (4000 rpm, 53 Hz)		%		
Vibration time once full	1 min		min		
Water weight			lb		
Airalon 3000 (AEA)	Material Test Report No.		ml		
Type III Portland cement	Material Test Report No.		lb		
Vermiculite, Type 1, Grade 3	Material Test Report No.		lb		

Company TR approver [d]	Date	Company STR approver [d]	Date

[a] SA alpha prefix plus a 10-digit control number is used to document the starting date and time of the setup approval using a 24-h format (i.e., SA1021081515 is used for October 21, 2008, at 3:15 p.m.).
[b] Measure the time required to rotate the mixer blades 20 times and calculate the measured rpm [1200 / time (s)].
[c] The vibration speed setting follow Sect. 7.3.1.5 and the force setting must follow Sect. 7.3.1.6 based upon the castings wet weight.
[d] Written Company approval is required to execute this form. Either wet ink or pdf electronic signatures are acceptable from the technical representative (TR) or subcontract technical representative (STR) after the Lot Qualification testing is successfully completed.

Form B ***Packcrete Mixing For Samples and Parts***		Specification Number	Revision
		Issue date (mm/dd/yy)	Revision date (mm/dd/yy)
Caster's company name (Seller's name)		Y-12 observers present	
Mix Control Number (MCN) [a] M _ _ _ _ _ _ _ _ _ _		Setup Approval Control Number (SACN) [b] SA _ _ _ _ _ _ _ _ _ _	
Part Serial Number / 's		Packaging name	
Water Filter [c]	Replacement Date (mm/dd/yy)	Pass	Fail
Check control mix times ☐ ☐ ☐ Water and Airalon—at least 1 min, Portland cement—at least 1 min more, vermiculite—50–70 s more.			

Measurement	Comment		Measure	Units	Operator	Witness
Vermiculite (wt %)				%		
Estimated mix volume				ft^3		
Mixer speed setting				rpm		
Daily mix water chlorine [c]	Pass	Fail		ppm		
Water temperature [d]				°F		
Water weight [d]				lb		
Air temperature				°F		
Airalon 3000 (AEA)				ml		
Verify cement bag quality [e]	Pass	Fail				
Type III Portland cement				lb		
Verify vermiculite bag quality [e]	Pass	Fail				
Vermiculite, Type 1, Grade 3				lb		
Wet density	Target 53.9 ± 5.6 lb/ft^3 (48.3–59.5 lb/ft^3)			lb/ft^3		

[a] M, P, or SA alpha prefix plus a 10-digit control number is used to document the starting date and time of the Mixing process using a 24-h format (i.e., M1021081515 is used for October 21, 2008, at 3:15 p.m.).
[b] SACN—Setup Approval Control Number is obtained from Form A and indicates the date and time that the setup approval was started.
[c] Potable water that has been filtered through at least a 20-micron filter and has chlorine content <4 mg/l (4 ppm, 0.0004% by mass). Record the date the filter shall be replaced and check the box to document its maintained.
[d] Record the water weight and temperature within 10 min from completion of the weighing process.
[e] Record the bags quality. A damaged bag that appears to have been wet or to have been torn open and is leaking prior to shift start shall not be used.

Form C ***Packcrete Sample 4.5-Gal Pail*** ***Vibration Casting Control***		Specification Number	Revision
		Issue date (mm/dd/yy)	Revision date (mm/dd/yy)
Caster's company name (Seller's name)		Y-12 observers present	
Mix Control Number (MCN) [a] M_ _ _ _ _ _ _ _ _ _		Serial Number	

Measurement	Comment	Measure	Units	Operator	Witness
Clean and empty	Estimated 2.96 lb		lb		
Filled with water [b]	Estimated 42.46 lb		lb		
Water temperature [b]			°F		
Container volume	Estimated 0.634 ft^3		ft^3		
Vibration table force setting [c]	#1.1, 74 lbf		lbf		
Wet cast weight	Estimated 38 lb		lb		
Vibration intensity ~ 2.1	Force / Wet Weight				
Vibration table speed setting [c]	80%		%		
Full vibration time	1 min		min		
Wet cast weight	Target 36.69–39.73 lb		lb		
Wet density [d]	Target 53.9 ± 2.4 lb/ft^3		lb/ft^3		
Measured wet density (51.5 to 56.3 lb/ft^3) acceptance				Accept	Reject [d]
Scrape the top and weigh			lb		
Cure time (at least 7 days)	BCN – MCN		days		
Before baking weight			lb		
Baking Control Number (BCN) [a]					
After baking weight			lb		
Baked density [e]	Target 22.4 ± 1 lb/ft^3		lb/ft^3		
$\frac{Baked_Density}{Wet_Density}$					
Measured baked density (21.4 – 23.4 lb/ft^3) acceptance				Accept	Reject [d]

[a] M, or B alpha prefix plus a 10-digit control number is used to document the starting date and time of the process using a 24 h format (i.e., M1021081515 or B1021081515 is used for October 21, 2008, at 3:15 p.m.).
[b] Record the water weight and temperature within 10 min from completion of the weighing process.
[c] Document the vibration force (Sect. 7.3.1.6), frequency (Sect. 7.3.1.5) settings and duration are set.
[d] The recommended wet density of 51.5–56.3 lb/ft^3 and baked density of 21.4–23.4 lb/ft^3 is to ensure castings on Form F have a baked density within 19.4–25.4 lb/ft^3. The Seller may waive these recommendations and proceed at risk. Upon rejection, contact the Company and send the casting records.

$$\text{Volume} = \frac{(WithWater - CleanAndEmpty)}{62.3}\ ft^3 @ 70°F \qquad \text{Wet density} = \frac{(WetCast - CleanAndEmpty)}{\text{Volume}}\ lb/ft^3$$

$$\text{Baked density} = \frac{(AfterBaking - CleanAndEmpty)}{\text{Volume}}\ lb/ft^3$$

Form D ***Packcrete Sample 30-Gal Drum*** ***Vibration Casting Control***	Specification Number	Revision
	Issue date (mm/dd/yy)	Revision date (mm/dd/yy)
Caster's company name (Seller's name)	Y-12 observers present	
	Serial Number	

Measurement	Comment	Measure	Units	Operator	Witness
Clean and empty	Estimated 28 lb		lb		
Filled with water [b]	Estimated 288 lb		lb		
Water temperature [b]			°F		
Container volume	Estimated 4.2 ft^3		ft^3		
Wet cast weight	Estimated 255 lb		lb		
Vibration table force setting [c]	#2.5, 532 lbf		lbf		
Vibration intensity ~ 2.1	Force / Est. Wet Wgt.				
Vibration table speed setting [c]	80%		%		
Operation	**Mix Control Number (MCN) [a]**	**Vibration duration [e]**	**Time**	**Operator**	**Witness**
Pour Start 1 [e]		10	s		
Pour Start 1 [e]		10	s		
Pour Start 1 [e]		10	s		
Full vibration time		1	min		
Wet cast weight	Target 224–284 lb		lb		
Wet density [e]	Target 53.9 ± 5.6 lb/ft^3		lb/ft^3		
Measured wet density (48.3 – 59.5 lb/ft^3) acceptance				Accept	Reject [d]
Scrape the top and weigh			lb		
Cure time (at least 7 days)	BCN – MCN		days		
Before baking weight			lb		
Baking Control Number (BCN) [a]					
After baking weight			lb		
Baked density [e]	Target 22.4 ± 3 lb/ft^3		lb/ft^3		
$\frac{Baked_Density}{Wet_Density}$					
Measured baked density (19.4 – 25.4 lb/ft^3) acceptance				Accept	Reject [d]

[a] M alpha prefix plus a 10-digit control number is used to document the starting date and time of the process using a 24 h format (i.e., M1021081515 is used for October 21, 2008, at 3:15 p.m.).
[b] Record the water weight and temperature within 10 min from completion of the weighing process.
[c] Document the vibration force (Sect. 7.3.1.6), frequency (Sect. 7.3.1.5) settings and duration are set.
[d] The recommended wet density of 48.3–59.5 lb/ft^3 and baked density of 19.4–25.4 lb/ft^3 is to ensure castings.
[e] For partial casts, vibrate the drum 10 s and stop. Once full, vibrate for 1 min.

$$\text{Volume} = \frac{(WithWater - CleanAndEmpty)}{62.3}\ ft^3 @ 70°F$$

$$\text{Wet density} = \frac{(WetCast - CleanAndEmpty)}{\text{Volume}}\ lb/ft^3$$

$$\text{Baked density} = \frac{(AfterBaking - CleanAndEmpty)}{\text{Volume}}\ lb/ft^3$$

Form E ***Packcrete Sample Pipes*** ***Vibration Casting Control***	Specification Number	Revision
	Issue date (mm/dd/yy)	Revision date (mm/dd/yy)

Caster's company name (Seller's name)	Y-12 observers present
Mix Control Number (MCN) [a] M_ _ _ _ _ _ _ _ _ _	Serial Number [b]

Measurement	Comment	Measure	Units	Operator	Witness
Empty container weight			lb		
Container volume	Estimate		ft^3		
Wet cast weight	Estimate		ft^3		
Vibration table force setting [c]			lb		
Vibration intensity ~ 2.1	Force / Wet Weight				
Vibration table speed setting [c]	80%		%		
Full vibration time [c]	1 min		min		

Baked measurement	___-P1	___-P2	___-P3	___-P4	___-P5	___-P6	Operator	Witness
Label sample [b]								
Before Baking [d]								
Internal diameter (ID) (in.) [d]								
Clean and empty (lb) [d]								
Wet cast (lb) [d]								
After baking (lb) [d]								
Baked internal height (BIH) (In.) [d]								
Volume (ft^3) [d]								
Wet density (lb/ft^3)								
Baked density (lb/ft^3) [d]								
$\frac{Baked_Density}{Wet_Density}$								

Cure time (at least 7 days)	BCN – MCN		days		
Baking Control Number (BCN) [a] B_ _ _ _ _ _ _ _ _ _					

[a] M, or B alpha prefix plus a 10-digit control number is used to document the starting date and time of the process using a 24-h format (i.e., M1021081515 or B1021081515 is used for October 21, 2008, at 3:15 p.m.).
[b] A record Serial Number plus a unique pipe number is assigned to each casting.
[c] Document the vibration force (Sect. 7.3.1.6), frequency (Sect. 7.3.1.5) settings and duration are set.
[d] Use these weights to calculate the wet density and baked density as shown below, then contact the Company for disposition.

$$\text{Volume} = \frac{ID^2 \times BIH}{2200.16} \ ft^3$$

$$\text{Wet density} = \frac{(WetCast - CleanAndEmpty)}{\text{Volume}} \ lb/ft^3$$

$$\text{Baked density} = \frac{(AfterBaking - CleanAndEmpty)}{\text{Volume}} \ lb/ft^3$$

Form F ***Packcrete Furnace and Baking***		Specification Number	Revision
		Issue date (mm/dd/yy)	Revision date (mm/dd/yy)
Baking company name (Baker's name)		Caster's company name (Seller's Name)	
Baking Control Number (BCN) [a] B _ _ _ _ _ _ _ _ _ _	Bake Qualification Control Number-Vol (BQCN-Vol) [a] BQ _ _ _ _ _ _ _ _ _ _ - _ _ _	Furnace Serial Number	
Bake start date (mm/dd/yy)	Bake start time (24-h format)	Computer data file name [b]	

Measurement	Pass	Fail	Operator	Witness

Baking process control	Furnace (check or NA)	Start time	Start date	Stop time	Stop date	Operator	Witness
Baking Cycle 1 200°F for 4 h							
Baking Cycle 2 275°F for 1 h							
Baking Cycle 3 350°F for 1 h							
Baking Cycle 4 425°F for 1 h							
Time BCT temperature >425°F [c]							
Time at least 6 h, BCT < 2°F increase							

Part baked	Estimated volume (ft^3)	Number in furnace	Subtotal (ft^3)			Operator	Witness
Samples							
4.5-gallon pail	0.63						
30-gallon drum	4.20						
4NPS pipes	0.03						
Total volume (ft^3)							

Comments

[a] B and BQ are alpha prefix plus a 10-digit control number is used to document the start date and the time of baking and process qualification using a 24-h format (i.e., B1021081515 is used for October 21, 2008, at 3:15 p.m.). For the BQCN-Vol, the "-Vol" represents the maximum total oven casting volume in cubic feet that is qualified (i.e., BQ1021081515-150 is qualified for a casting load of 150 ft^3).

[b] The sample baking cycle time and temperature data could be presented both in a digital and graphical form. For example, an Excel file showing the original data and time verses temperature plots shall be acceptable.

[c] BCT—bottom center thermocouple. Calculate the baked density as shown on Form F following this furnace heating cycle phase. Record the 500°F holding time when the core temperature is >425°F and no increase in the BCT over 2°F in 6 h of baking.

Classification: UNCLASSIFIED

DOCUMENT CHANGE NOTICE (DCN)

PAGE 1 OF 1

SECTION 1: ORIGINATOR INFORMATION

2. ORIGINATOR (PRINT NAME)	BADGE NO.	3. PHONE NUMBER	4. DATE
Jonathan Weigand	80724	865-241-5358	2/19/2019

SECTION 2: DOCUMENT/DCN INFORMATION

5. DOCUMENT NO.	6. SHEET/PAGE NO(S). (IF APPLICABLE)	7. REV	8. DCN NO.
SPC M801794-0003 001 00	Sect. 5.4.1, Pg. 14, Par. 1, Sent. 1	0	001

9. DCN TITLE	10. SSC UNID(S).
Acceptance of Vermiculite for Packcrete Qualification	NA

11. DESCRIPTION OF DOCUMENT REVISION (ATTACH SKETCH, MARKUP OF ORIGINAL DOCUMENT, OR CONTINUATION SHEET(S) AS REQUIRED)

The sentence in Sect. 5.4.1, Pg. 14, Par. 1, Sent. 1 should be changed to read "...a bulk density between 6.4 and 8.7 lb/ft3." instead of "...a bulk density between 6.4 and 8 lb/ft3."

During fabrication of MD-2 packagings, a larger acceptance range of the Vermiculite's bulk density allowed for an acceptable baked density and caused no adverse effects on the mechanical and chemical properties of Packcrete.

See RFWD 62 generated from MD-2 fabrication for further detail.

12. INITIATING CHANGE DOCUMENT(S)

RFWD 62 from MD-2 fabrication

SECTION 3: DCN APPROVALS

13. PRINT NAME AND TITLE	14. BADGE NUMBER	15. SIGNATURE	16. DATE
J. P. Weigand (PTE)	80724	JONATHAN WEIGAND (Affiliate)	2/19/2019
17. PRINT NAME AND TITLE	18. BADGE NUMBER	19. SIGNATURE	20. DATE
G. A. Byington (DE)	23504	GERALD BYINGTON (Affiliate)	2/25/2019
21. PRINT NAME AND TITLE	22. BADGE NUMBER	23. SIGNATURE	24. DATE
S. K. Thomas (PE)	39719	Stan (TSW) Thomas	03/05/2019
25. PRINT NAME AND TITLE	26. BADGE NUMBER	27. SIGNATURE	28. DATE
R. D. Aigner (DV)	31762		
29. PRINT NAME AND TITLE	30. BADGE NUMBER	31. SIGNATURE	32. DATE
J. C. Anderson (DM)	30609		
33. PRINT NAME AND TITLE	34. BADGE NUMBER	35. SIGNATURE	36. DATE
J. C. Payton (QA)	81202	Jack (PAY) Payton	3/5/2019
PRINT NAME AND TITLE	BADGE NUMBER	SIGNATURE	DATE
PRINT NAME AND TITLE	BADGE NUMBER	SIGNATURE	DATE
PRINT NAME AND TITLE	BADGE NUMBER	SIGNATURE	DATE

MANAGER ACKNOWLEDGMENT/APPROVAL OF DCN COUNT EXCEEDING LIMIT (>5)

PRINT NAME AND TITLE	BADGE NUMBER	SIGNATURE	DATE

SECTION 4: DCN STATUS

37. ☐ APPROVED BUT NOT EFFECTIVE

37a. PRINT NAME AND TITLE	37b. BADGE NUMBER	37c. SIGNATURE	37d. DATE

38. ☒ EFFECTIVE

38a. PRINT NAME AND TITLE	38b. BADGE NUMBER	38c. SIGNATURE	38d. DATE
J. P. Weigand (PTE)	80724	JONATHAN WEIGAND (Affiliate)	2/19/2019

39. ☐ CANCELLED

39a. PRINT NAME AND TITLE	39b. BADGE NUMBER	39c. SIGNATURE	39d. DATE
	40. DERIVATIVE CLASSIFIER/UCNI REVIEWING OFFICIAL SIGNATURE This document has been reviewed and confirmed to be UNCLASSIFIED and contains no UCNI. Name: Stan Thomas Date: 03/05/2019 eDC/RO ID: 114562		41. DATE 03/05/2019

UCN-20991 (10-14)

Appendix 1.3.12
SPC M801580-0003, *ES-3100 Packcrete Final Lot Qualification and Production Processing*

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EQUIPMENT SPECIFICATION

APPROVAL / REVISION PAGE

** For Company Use Only - Do Not Provide To Supplier **

QUALITY LEVEL	PROTECTION LEVEL	BUILDING
Q	C	N/A

PROJECT TITLE: Shipping Containers

JOB TITLE: Production Design Definition

ITEM DESCRIPTION: ES-3100 Packcrete Final Lot Qualification and Production Processing

UNID: YAREA-CMH-042

REVISIONS

REV. NO.	DESCRIPTION OF REVISION
00	Initial issue.

REFERENCE DOCUMENTS & OTHER INFORMATION

Recommended Suppliers:
TBD

In-Storage Maintenance Requirements – None (Material will not be shipped to Y-12.)

References for Company Use:

Reference Receipt Inspection: NA (Material will not be shipped to Y-12.)

Design Verification Record: DV-801580-0018

Installation Drawings: M2E801580A002, *Body Weldment*, and M2E801580A008, *Top Plug Weldment*

Other reference documents needed by the Seller: None

This shipping package was designed for an offsite use and will not be received or used in the Y-12 National Security Complex. Acceptance occurs at the Seller's location.

This document has been reviewed by a Y-12 DC/ UCNI RO and has been determined to be UNCLASSIFIED and contains no UCNI. This review does not constitute clearance for Public Release.
Name: Date:
Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2019.08.28 14:47:27 -04'00'

APPROVALS

PRINT	SIGNATURE/DATE	PRINT	SIGNATURE/DATE
PREPARED BY: L. C. Hooper	Lloyd Hooper Digitally signed by Lloyd Hooper Date: 2019.08.28 11:51:36 -04'00'	DISCIPLINE MANAGER: J. C. Anderson	James C (J5A) Anderson Digitally signed by James C (J5A) Anderson Date: 2019.08.29 16:38:49 -04'00'
DESIGN VERIFICATION: R. D. Aigner	Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2019.08.29 16:10:16 -04'00'	SYSTEM ENGINEER: R. D. Aigner	Roger D (R7A) Aigner Digitally signed by Roger D (R7A) Aigner Date: 2019.08.28 14:47:51 -04'00'
PACKAGING ENGINEER: N. A. Laney	Noelani A (NL1) Laney 2019.08.28 16:49:02 -04'00'	OPERATIONS/SYSTEM OWNER: S. K. Thomas	Stan (TSW) Thomas Digitally signed by Stan (TSW) Thomas Date: 2019.08.29 15:58:16 -04'00'
NUCLEAR PROC. ENGINEER: J. E. Cook	Jeffrey E (2XK) Cook Digitally signed by Jeffrey E (2XK) Cook Date: 2019.08.29 13:14:26 -04'00'	QUALITY ENGINEER: J. R. Burchfield	Jason (JR6) Burchfield Digitally signed by Jason (JR6) Burchfield Date: 2019.08.28 12:47:19 -04'00'

ES-3100 Packcrete Final Lot Qualification and Production Processing

TABLE OF CONTENTS

1. Scope **3**
1.1 General Description of the Item 3
1.2 Background 4
2. References **4**
2.1 Definitions 4
2.2 Codes/Standards/Orders/Regulations 5
2.3 Applicable Documents 5
3. Item Requirements **5**
3.1 Performance Requirements 6
3.2 Fabrication and Assembly Requirements 6
3.3 Schedule 6
3.4 Deliverables and Submittals Documents 6
3.4.1 Approval Data Documents 6
3.4.2 Certification Data Documents 7
3.5 Packaging, Handling, Shipping, and Storage Requirements 7
3.5.1 Receiving and Material Storage Instructions 7
3.5.2 Damaged Packages 7
3.5.3 Storage of Raw Materials 7
3.6 Marking and Identification Requirements 7
3.7 Requests for Waiver or Deviation 7
4. Quality Assurance Requirements **8**
4.1 Final Acceptance Test Method 8
4.2 Inspection/Testing Requirements 8
4.3 Surveillance and Audits 8
4.3.1 Quality Hold Points 8
4.3.2 Quality Observations 9
4.4 Acceptance Criteria 9
4.5 Personnel Qualifications/Certifications 9
4.6 Training and Qualification of Personnel 9
4.6.1 Operator and Witness Training and Qualifications 9
4.7 Documentation Retention 10
4.8 Nonconformance Control 10
5. Packcrete Raw Material Requirements **10**
5.1 Procuring Packcrete Raw Materials 10
5.2 Receiving and Material Storage Instructions 10
5.2.1 Damaged Packages 10
5.2.2 Storage of Raw Materials 10
5.3 Sample Plan for Third Party Testing 10
5.4 Material Procurement and Acceptance Criteria 11
5.4.1 Vermiculite Acceptance Criteria 11
5.4.2 Portland cement Acceptance Criteria 12
5.4.3 Airalon 3000 Acceptance Criteria 12
6. Facility and Process Equipment Requirements **13**
6.1 CLEANING INSTRUCTIONS 13
6.2 EQUIPMENT REQUIREMENTS 13
6.3 WORK ENVIRONMENTS 14
6.3.1 Mixing and Casting 14
6.3.2 Mixing and Casting Water 14
6.3.3 Curing Storage 14
6.3.4 Portland Cement and Vermiculite Storage 14

7. Packcrete Processing 14
7.1 Processing Setup Requirements 15
7.2 Mixing Setup Approval Control Number 15
7.3 Processing Preparation for SES3100, ES-3100, and Samples 15
7.4 Process—Mixing and Vibration Casting, Curing, and Baking for Samples and Parts 15
7.5 Setup Approval Process Verification—4.5-gal Pail or 30-gal Drum 16
7.6 Lot Qualification and Packcrete Sample Pipes 16
7.7 Final Lot Qualification Castings—SES3100 Body and Plug 16
7.7.1 Setup—Mixing and Vibration Casting an SES3100 Body or Plug 16
7.7.2 Process—Mixing and Vibration Casting an SES3100 Body or Plug 17
7.7.3 Process—Curing an SES3100 Body or Plug 17
7.7.4 Process—Baking an SES3100 Body or Plug 17
7.8 Production Processing an ES-3100 Body or Plug 17
7.8.1 Setup—Mixing, Vibration Casting, and Curing an ES-3100 Body or Plug 17
7.8.2 Process—Mixing and Vibration Casting an ES-3100 Body or Plug 18
7.8.3 Process—Curing an ES-3100 Body or Plug 18
7.8.4 Process—Baking an ES-3100 Body or Plug 18
8. Packcrete Lot Qualification and Production Test Samples 19
9. Packcrete Material Lot Qualification Properties Limits 19
Attachments 20
Attachment A: Submittal CheckList 20
Attachment B: ABBREVIATIONS AND ACRONYMS 22
Attachment C: Packcrete Processing Form 23
Form ES3100 Packcrete Vibration Casting 24

FIGURES

Fig. 1. Full-scale close-up view of a baked Packcrete section. 3
Fig. 2. ES-3100 shipping container. 4
Fig. 3 ES-3100 Packcrete FLQ and production processing. 15

TABLE

Table 1. Recommended vibration settings 15

1. SCOPE

This specification incorporates aspects of SPC M801794-0003, *Packcrete Preliminary Lot Qualification*. The Seller shall produce a preliminary lot qualification, via SPC M801794-0003, for casting Packcrete in "generic" applications. The preliminary lot qualification provides the quality assurance and technical requirements for qualifying the Seller for casting Packcrete in a "specific" application known as the ES-3100 shipping package.

This specification provides the Seller's production requirements for production units of the ES-3100 shipping package. Since these two specifications must work closely together in sequence in order to document and accomplish final lot qualification (FLQ), and production processing, the information in the two specifications that applies to both will be referenced when necessary in this specification.

The Company (Y-12 National Security Complex) will provide training and direct oversight for the casting Packcrete when the Subcontractor does not have prior Packcrete casting experience.

The product produced from this specification is protected under U.S. Patent 6,299,950 B1. The U.S. Government has rights in this product pursuant to Contract No. DE-NA0001942 between the U.S. Department of Energy and Consolidated Nuclear Security, LLC.

1.1 General Description of the Item

Packcrete is a fireproof, lightweight cast refractory. It is comprised of water, Airalon 3000 (air entraining agent), Portland cement, and vermiculite defined in SPC M801794-0003. A full-scale sample section of Packcrete is shown in Fig. 1 with a centimeter scale.



Fig. 1. Full-scale close-up view of a baked Packcrete section.

1.2 Background

The ES-3100 is a Type-B shipping package for fissile hazardous materials that must comply with strict manufacturing standards. Packcrete is a noncombustible impact and thermal barrier that will be cast into the ES-3100 shipping container to protect the containment vessel from damage. Figure 2 shows the Packcrete casting as a light brown color.

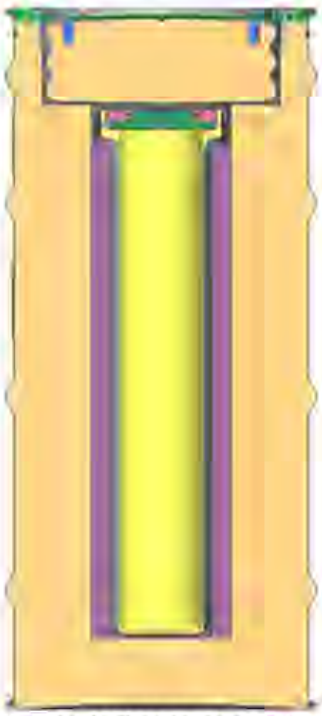


Fig. 2. ES-3100 shipping container.

2. REFERENCES

2.1 Definitions

See SPC M801794-0003 for definitions that are not included here. Those definitions also apply to this work in this specification.

Confinement Boundary Assembly (CBA) – An assembly with an assigned serial number that is made from components uniquely manufactured following JS-YMN3-801580-A002 (*Equipment Specification ES-3100 Drum Assembly*) and process serial-numbered components specified in M2E801580A002 (*Body Weldment*) and M2E801580A008 (*Top Plug Weldment*).

ES-3100 body – The ES-3100 body is defined by M2E801580A002. The body has an estimated empty weight of 88 lb without the bottom cover and 103 lb with the welded bottom cover. The estimated fillable Packcrete volume is 4.8 ft^3.

ES-3100 plug –The ES-3100 top plug is defined by M2E801580A008. The top plug has an estimated empty weight of 7.4 lb without the bottom sheet and 9.6 lb with the welded bottom sheet. The estimated fillable Packcrete volume is 0.43 ft^3.

SES3100 body – A simulated ES-3100 (SES3100) body for casting a mock-up of the ES-3100 drum assembly made from two standard carbon steel drums. The simulated ES-3100 consists of a 55-gal carbon steel open-head drum which has a 20-gal carbon steel drum secured to the bottom center. The 20-gal drum is secured by tack welding or suitable fasteners. The lid of the 55-gal drum has an opening 15" in diameter through which Packcrete can be poured into the drum. The SES3100 body has an estimated empty weight of 77 lb and a fillable Packcrete volume of ~4.7 ft^3. The SES3100 body is used to qualify the casting process.

SES3100 plug – The SES3100 plug for casting a mock-up of the ES-3100 top plug made from cylindrically rolled carbon steel sheet welded to a circular carbon steel sheet bottom. The rolled carbon steel cylinder is 0.06-in. thick with an inner diameter of 14.0-in. and height of 5.0-in. The carbon steel sheet bottom is 0.06-in. thick with a diameter of 14.12-in. The SES3100 has an estimated empty weight of 6.6 lb and a fillable Packcrete volume of ~0.45 ft^3. The SES3100 plug is used to qualify the casting process.

2.2 Codes/Standards/Orders/Regulations

ASME NQA-1-2017	Quality Assurance Requirements for Nuclear Facility Applications
10 CFR Part 71	Packaging and Transportation of Radioactive Material
ASTM C114	Standard Test Methods for Chemical Analysis of Hydraulic Cement
ASTM C136	Standard Test Method for Sieve Analysis of Fine and Coarse Aggregates
ASTM C150/C150M	Standard Specification for Portland Cement
ASTM C233/C233M	Standard Test Method for Air-Entraining Admixtures for Concrete
ASTM C260/C260M	Standard Specification for Air-Entraining Admixtures for Concrete
ASTM C494/C494M	Standard Specification for Chemical Admixtures for Concrete
ASTM C516	Standard Specification for Vermiculite Loose Fill Thermal Insulation
ASTM C520	Standard Test Methods for Density of Granular Loose Fill Insulations
ASTM C860	Standard Test Method for Determining the Consistency of Refractory Castable Using the Ball-In Hand Test
ASTM C862	Standard Practice for Preparing Refractory Concrete Specimens by Casting
ASTM C1113	Standard Test Method for Thermal Conductivity of Refractories by Hot Wire (Platinum Resistance Thermometer Technique)
ASTM E70	Standard Test Method for pH of Aqueous Solutions with the Glass Electrode
ASTM E228	Standard Test Method for Linear Thermal Expansion of Solid Materials with a Push-Rod Dilatometer
ASTM E1269	Heat Capacity by Differential Scanning Calorimetry
ANSI/ISO/IEC 17025	General requirements for the competence of testing and calibration laboratories

2.3 Applicable Documents

The following documents apply when casting Packcrete into the ES-3100 shipping containers.

JS-YMN3-801580-A002	*Equipment Specification ES-3100 Drum Assembly*
M2E801580A002	*Body Weldment*
M2E801580A008	*Top Plug Weldment*
SPC M801794-0003	*Packcrete Preliminary Lot Qualification*

3. ITEM REQUIREMENTS

Packcrete must be cast into a stainless-steel shell specified in M2E801580A002 and M2E801580A008, collectively known as the CBA. The manufacturing controls are based on a finished baked density of 22.4 ± 3 lb/ft^3 that controls the proper thermal and impact properties. The in-process serial numbers for the plug and drum body shall be recorded on Form ES3100 of Attachment C, "Packcrete Processing Form". The final CBA serial number shall include references to the in-process serial numbers.

3.1 Performance Requirements

The Seller has no responsibilities for performance of Packcrete beyond the measured density of 22.4 ± 3 lb/ft^3 when the requirements of this specification are completed.

3.2 Fabrication and Assembly Requirements

See production processing in Sect. 7.8.

3.3 Schedule

A manufacturing plan with written, step-by-step process plans shall be submitted to the Company [Y-12 National Security Complex, Consolidated Nuclear Security, LLC (CNS)] for approval and used by the Seller to comply with requirements in this specification. At a minimum, the plan shall include:

- material control and materials to be procured,
- subtiers to be used, and control thereof,
- quality program used to buy and manufacture,
- major fabrication steps and sequence of operations,
- Packcrete sampling schedule (see note below),
- hold points to be determined for Company involvement,
- all in-process inspection/examination, and
- dimensional inspections and testing.

Note: Additional Packcrete sample sets are required for future material testing. As such, a Packcrete sample set must be generated at the end of test unit production, at the end of full-scale production, and as required during full-scale production. A Packcrete sample set is to consist of one 30-gal drum and eight sample pipes as described in SPC M801794-0003.

3.4 Deliverables and Submittals Documents

There are two types of submittals associated with this specification: (1) approval data documents and (2) certification data documents. The submittal schedule, submittal format, number of copies, and submittal purpose are shown in Attachment A, "Submittal Checklist." Some of these quality records are generated following SPC M801794-0003.

All records shall be identified based on ES-3100 assembly serial numbers. The Seller shall maintain quality-related documentation in accordance with requirements in the purchase order and this specification. The Company reserves the right to request any such documentation and to witness all aspects of the manufacturing process in accordance with this specification.

3.4.1 Approval Data Documents

Approval data documents are identified in Attachment A. Approval data documents include written procedures and personnel qualifications, which must be approved by the Company prior to conducting the work defined in Sect. 7.

With each submittal transmitted to the Company, the Seller will include an updated submittal checklist using an Excel spreadsheet. The checklist shall identify all of the documents to be submitted and the status of each. All submitted documents shall be identified with document title, document number, revision level, computer filename, and submission date. The reply date of and disposition by the Company shall be included in the Excel spreadsheet for documents already submitted and dispositioned by the Company.

The Seller shall generate documentation in compliance with the Company-approved quality assurance plan (QAP). All records shall be identified based on the component serial numbers traceable to the CBA serial number.

The Company reserves the right to request any additional documentation used in fabrication or raw material qualification.

Procedures shall be submitted to the Company for approval prior to use in accordance with Attachment A and shall identify all mixing and vibrating equipment models and settings required to complete the casting process. Approvals of submittals must be received from the Company prior to implementing any activities involving these procedures. Submittal version control must be exercised to ensure correct and approved versions are used. All fabrication activities used to make Packcrete must be described in approved written procedures.

3.4.2 Certification Data Documents

Certification data documents are identified in Attachment A and documentation of measurements, testing, and calculations created during the performance of the work described in Sect. 7 are documented in Form ES3100 of Attachment C.

Certification data documents include raw material test reports in accordance with the requirements of Sect. 5.

The Seller shall provide a certification data package that connects all specified processing data collected to the particular ES-3100 serial number prior to delivery of the ES-3100 assemblies.

3.5 Packaging, Handling, Shipping, and Storage Requirements

3.5.1 Receiving and Material Storage Instructions

Packcrete raw materials procured per this specification shall be marked and received with a traceable Certificate of Conformance (COC).

3.5.2 Damaged Packages

The Seller shall not accept and/or use damaged packages of Packcrete raw materials. Damaged packages are those that are visually determined to be wet, have been wet, have been torn open, or are leaking.

3.5.3 Storage of Raw Materials

Packcrete raw materials shall be stored in a dry location and protected from damage and moisture with an air temperature range of 70 ± 20°F and compliant with the manufacturers recommended practices.

3.6 Marking and Identification Requirements

Packcrete as a material is not marked in any way. The procurement and processing records (forms) for Packcrete raw materials and procedures used shall be tracked by the manufacturing serial numbers for the drum body and plug.

3.7 Requests for Waiver or Deviation

Any requested exceptions, deviations, or proposed changes to the requirements of this specification by the Seller after award and before acceptance shall be submitted using UCN-13816B. The Seller shall request an electronic copy of the form with instructions from the subcontract technical representative or subcontract administrator.

4. QUALITY ASSURANCE REQUIREMENTS

The Seller shall have implemented and maintain a quality system in accordance with ASME NQA-1 2008, 1a-2009, Part 1, Sections 1-18 and/or 10 CFR 71 Subpart H and DOE O 414.1D Attachment 3, with respect to Suspect Counterfeit Items. A copy of the Seller's QA Program Manual shall be submitted with the bid in accordance with Attachment A for review and approval. The Seller shall comply and conduct all work in accordance with their Quality Assurance program and this Equipment Specification.

The Seller shall submit a QAP for the scope of this work that describes the quality assurance policies and practices to be implemented in fabricating the ES3100 shipping container, and identifying, controlling, and verifying the quality of Packcrete processes (weighing, mixing, pouring, vibrating, curing, and baking). The Seller's QAP shall ensure full compliance with all requirements, tests, inspections, reports, documentation, and approvals contained within this specification. The Seller's QAP shall include the requirements for the process controls for the operations, the qualifications of the operator(s) and witness(es), and verification records. In addition, Seller's Quality Assurance (QA) Program shall comply with Subpart 2.14, Quality Assurance Requirements for Commercial Grade items and Services. Company will provide the critical characteristics for any items or services to be dedicated.

4.1 Final Acceptance Test Method

The final acceptance test method includes verification that 100% of the ES-3100 shipping packages contain Packcrete with a finished baked density of 22.4 ± 3 lb/ft^3 and the process used to achieve that density followed the prescribed steps included in Sect. 7.

Final acceptance will be based on compliance with the approval data documents as verified through surveillance activities by the Company, compliance with the technical requirements in this specification as verified through surveillance activities by the Company, and final review and acceptance of the certification data package documents that apply to Packcrete.

4.2 Inspection/Testing Requirements

See Sect. 7 and 8 for additional information.

4.3 Surveillance and Audits

The Company shall reserve the right to evaluate the Seller's QAP and subtiers to ensure compliance with this specification at the Company's discretion. The Company shall be allowed to witness any of the processes associated with this specification during the performance of the contract.

4.3.1 Quality Hold Points

4.3.1.1 Raw Material Lots Must Be Qualified

Before any materials are used in FLQ castings and production castings, the material test reports shall show that the materials meet the testing requirements and acceptance criteria specified in SPC M801794-0003, Sect. 5.4. Documentation of the material qualifications from SPC M801794-0003 shall be part of the certification data package for this specification.

4.3.1.2 Components Must Pass Geometric Inspection Requirements

Before the ES-3100 drum body weldment (M2E801580A002) and top plug (M2E801580A008) are cast with Packcrete, the Seller must have evidence (a Company-approved inspection report plan) that the design requirements, which cannot be verified after the casting, have been met. Additional precautions must be taken to ensure that the bottom diameter of the drum (casting opening) stays within a tolerance of ±0.03 in. prior to casting the Packcrete (M2E801580A002) and within a tolerance of ±0.12 in. throughout casting, weighing, handling, vibrating, curing, and baking of the Packcrete filled drum.

The Seller shall not cast Packcrete into the drum body or top plug until (1) the Company has reviewed and provided its documented approval of the Certified Material Test Reports for the metals involved, (2) the Company has reviewed and provided its documented approval of the diamond I dimensional data on the metal parts that cannot be verified after casting, and (3) the authorized nuclear inspector has reviewed and provided its documented approval of the welds that cannot be verified after casting.

4.3.1.3 Company Approval that Raw Materials and Setup are Lot Qualified

Each change to the final setup approved on Form A (SPC M801794-0003) must be documented on a new Form A and reapproved by the Company. These changes may include hardware, mixing amounts, mixing rotation speed, mixing times, vibration speed setting (Sect. 7.3), and vibration time. Vibration force changes for each unique casting shall be documented on Form ES3100 of this specification.

Modifications to the vermiculite dry weight percent shall require FLQ testing and written Company approval. Changing from one lot of raw materials to another shall require FLQ testing and written Company approval. Approval requires positive testing results of FLQ testing defined in SPC M801794-0003 in Sect. 9. Several months of lead time will be needed to perform these tests and for the results to be evaluated by the Company

4.3.2 Quality Observations

The Company reserves the right to perform quality observations of the Packcrete casting process at any time. Observations will include, but not be limited to, LQs, first article evaluation casting, and initial production casting.

4.4 Acceptance Criteria

The acceptance criteria for fabrication and assembly requirements are based on the baked density of 22.4 ± 3 lb/ft$_3$, and evidence that Packcrete was cast in compliance with this specification.

4.5 Personnel Qualifications/Certifications

Personnel qualified and trained as operators and witnesses shall be able to follow and perform written instructions and procedures and accurately record operations involving weighing, mixing, casting, vibrating, curing, and baking processes.

4.6 Training and Qualification of Personnel

Note: If the Subcontractor does not have prior experience in Packcrete casting, the Company will provide training and direct oversight on the processes.

The Seller shall provide the Company (1) a plan for qualifying and training personnel and (2) documented evidence that personnel have been qualified and trained in accordance with the Seller's procedures approved by the Company to ensure their competence in the use of process procedures and specifications. The Seller must ensure all operators use and follow written procedures for the respective processes. Submit the training plans for Company approval.

4.6.1 Operator and Witness Training and Qualifications

Each operator and witness who performs Packcrete processing activities shall be trained and qualified. This requires the operator and witness to (1) have read the operating procedures and (2) have experience making the measurements, filling out the forms, and successfully performing the activity. Operator and witness qualifications shall be documented and submitted to the Company for approval with the casting forms as evidence that personnel have been qualified and trained.

4.6.1.1 Packcrete mixing and vibration casting training shall consist of successfully completing mixing and casting activities described in Sects. 7.2 and 7.3.

4.6.1.2 Packcrete curing and baking process training shall consist of successfully completing curing and baking activities described in Sect. 7.4.

4.7 Documentation Retention

Documentation of all inspection and test results shall be maintained by the Seller for 3 years after acceptance by the Company. The Company shall have access to this documentation to ensure compliance with all requirements. The Seller shall not destroy quality records without notifying the Company in advance to confirm that the Company does not have a need for the records.

4.8 Nonconformance Control

The Seller shall have an approved procedure for the control of non-conformances, waivers, and deviation requests during the execution of this specification. A nonconforming component shall not be used unless it has been specifically approved by the Company (see Sect. 3.12). The disposition of a nonconforming component shall be documented. Any nonconforming component shall be clearly identified, and each nonconformance report shall be traceable to the actual component affected. A copy of each approved nonconformance report for a component shall be provided to the Company as a part of the certification data package.

5. PACKCRETE RAW MATERIAL REQUIREMENTS

This section defines the requirements for Packcrete raw material procurement, receiving, storage, sampling, testing, and acceptance.

5.1 Procuring Packcrete Raw Materials

The Seller shall procure the Packcrete raw materials (i.e., vermiculite, Portland cement, and Airalon 3000) in accordance with the requirements in Sect. 5.4.

5.2 Receiving and Material Storage Instructions

Packcrete raw materials procured per this specification shall be marked and received with a traceable Certificate of Conformance (COC).

5.2.1 Damaged Packages

The Seller shall not accept and/or use damaged packages of Packcrete raw materials. Damaged packages are those that are visually determined to be wet, have been wet, have been torn open, or are leaking.

5.2.2 Storage of Raw Materials

Packcrete raw materials shall be stored in a dry location and protected from damage and moisture with an air temperature range of 70 ± 20°F and compliant with the manufacturers recommended practices.

5.3 Sample Plan for Third Party Testing

Packcrete raw materials must be purchased in accordance with Sect. 5.4. The plan will require each lot of sampled material to be tested by an independent third party. A sample plan must be created by the Seller to determine the definition of appropriate lot and sample size(s) in order to achieve reasonable assurance that the sample size chosen provides an adequate representation of the purchased item(s) quality. The sample plan shall comply with guidelines as directed by the Company. The lot size is defined in Sect. 5.4.

5.4 Material Procurement and Acceptance Criteria

Packcrete raw MTRs shall be provided with the COCs. The Seller shall also provide a CMTR from a qualified third party testing laboratory in accordance with the requirements in this section.

Note 1: One lot of Airalon 3000 is comprised of a single 55-gal drum that is (1) marked with a manufacturer's lot number and (2) noted in the manufacturer's COC.

Note 2: One lot of Portland cement is comprised of bags received against the same purchase order that have a date code (1) noted in the COC and (2) within the time period noted on the MTR provided with the manufacturer's COC.

Note 3: One lot of vermiculite is comprised of bags received against the same purchase order that have the same manufacturer's lot number noted in the manufacturer's COC.

5.4.1 Vermiculite Acceptance Criteria

The raw material manufacturer shall provide a COC package that includes the following, as a minimum: (1) the Buyer's purchase order number; (2) the date(s) of manufacture; (3) a statement that the material complies with ASTM C516; (4) a signature by the supplier's official or quality manager; and (5) a Certificate of Analysis in accordance with ASTM C516 for bulk density and grading. The COC shall also include the lot numbers in the order and the number of bags for each lot number.

All bags in the order shall come from a single manufacturing run in order to ensure consistency from bag to bag in terms of chemical composition, bulk density, and particle size distribution.

The manufacturer shall mark each bag as being vermiculite, Type 1, Grade 3, per ASTM C516 requirements. The manufacturer shall also mark each bag with (1) the lot number, (2) the manufacturing line identifier, and (3) a date code showing when the material was manufactured and bagged.

The manufacturer shall maintain quality records that connect the lot number, manufacturing line identifier, or date codes to the raw materials, manufacturing processes, operating procedures, and other manufacturing specifics associated with the manufacturing run.

Bagged vermiculite shall be stored in an area where vibrations from adjacent equipment and handling or movement are minimized, and be stored and transported in a manner that protects the bags and materials from exposure to water.

Bulk density and grading shall be independently tested by a third party testing laboratory in accordance with ASTM C516 (Type 1, Grade 3 Fine). When tested in accordance with Sect. 9.1.1 of ASTM C516 and ASTM C520, third party testing must show each sample has a bulk density between 6.4 and 8 lb/ft3. When tested in accordance with Sect. 9.1.2 of ASTM C516 and ASTM C136, all samples must have a particle size distribution that complies with Table 1.

Table 1. Particle size distribution acceptance criteria

U.S. Sieve No.	Weight % passing through the sieve
8	90 to 100
16	40 to 82
30	0 to 35
50	0 to 20
100	0 to 10
200	0 to 2

If all samples do not pass the bulk density and particle size distribution acceptance criteria, the lot shall be rejected by the Seller and the Company should be notified.

5.4.2 Portland cement Acceptance Criteria

The manufacturer shall provide a COC package for each purchase order that includes the following, as a minimum: (1) the Buyer's purchase order number; (2) the date(s) of manufacture; (3) a statement that the material complies with ASTM C150; (4) a signature by the supplier's official or quality manager; (5) an MTR in accordance with ASTM C150; and (6) a statement that all bags in the order were bagged during the time period stated in the MTR. The COC package shall also include the lot number in the order and the numbers of bags in each lot number.

The manufacturer shall mark each bag as being Portland cement, Type III, per ASTM C150 requirements. The manufacturer shall also mark each bag with a date code showing the week and year the material was bagged. All bags in the order/lot shall have a date code that is within the valid time period stated in the MTR.

The manufacturer shall maintain quality records that connect the lot number or date codes to the raw materials, manufacturing processes, operating procedures, and other manufacturing specifics associated with the manufacturing run.

The packaging practices of the manufacturer are acceptable unless stated otherwise in the Buyer's purchase order. Material shall be stored and transported in a manner that protects the bags and materials from exposure to water.

A CMTR shall be provided from a third party independent testing laboratory showing that all samples comply with ASTM C150, Table 1, Type III standard chemistry requirements when tested in accordance with the test methods specified in ASTM C114, Table 1.

If all samples do not pass the acceptance criteria, the lot shall be rejected by the Seller, and the Company should be notified.

5.4.3 Airalon 3000 Acceptance Criteria

The manufacturer shall provide a COC package with each purchase order that must include the following as a minimum: (1) the Buyer's purchase order number; (2) the date(s) of manufacture; (3) a statement attesting to the fact that the material complies in concentration, composition, and performance to ASTM C260 requirements; (4) a statement providing the chloride content of the material; and (5) a signature by the supplier's official or quality manager. The COC package shall also include the lot number, the date codes, and the number of containers in the order for each date code.

The manufacturer shall mark each container as being Airalon 3000 per ASTM C260 requirements. The manufacturer shall also mark each container with (1) the lot number and (2) a date code showing when the material was manufactured and containerized.

The manufacturer shall maintain quality records that connect the lot number or date codes to the raw materials, manufacturing processes, operating procedures, and other manufacturing specifics associated with the manufacturing run.

A CMTR shall be provided from a third party independent testing laboratory that shows that each 55-gal drum of Airalon 3000 complies with the acceptance criteria in Table 2.

Table 2. Airalon 3000 55-gal drum acceptance criteria

Reference	Test	Original lot	Acceptance criteria*
ASTM C494, C260, or C233	Infrared analysis**	Attachment C in SPC M801794-0003	Essentially similar to Attachment C in SPC M801794-0003
ASTM C494, C260, or C233	Specific gravity	1.01 S.G	0.91 to 1.13 S.G.
ASTM C260 or C233	pH	10.25 pH	9.15 to 11.48 pH
ASTM C260 or C233	Residue (solids)	3.15 wt %	2.82 to 3.52 wt %

*The acceptance criteria are based on the measurements of the original lot and a 12% range.
**ASTM C260 for air-entraining admixtures does not require infrared analysis. Therefore, the infrared analysis for chemical composition testing is determined by ASTM C494 using the oven-dried residue as determined by ASTM C260/C233. If the sample does not pass the acceptance criteria, the Airalon 3000 55-gal drum shall be rejected, and the Company shall be notified.

5.5 Mixing Water

Water that has been filtered through at least a 20-micron filter and has a chlorine content that is <4 mg/L (4 ppm, 0.0004% by mass) shall be used for the mixing of Packcrete. Record the manufacturer, model number, and serial number of the water filter showing that it is at least a 20 micron filter on Form B (Attachment E). The water temperature shall be between 50 and 80□F. Form B in Attachment E shall be used to document and record the water temperature and that the chlorine requirements are met each day before mixing starts.

6. FACILITY AND PROCESS EQUIPMENT REQUIREMENTS

A written plan shall be submitted to the Company for approval that defines the cleaning process, including cleaning solutions used, equipment, and work and storage environments.

6.1 Cleaning Instructions

NO CHLORINE PRODUCTS (sodium hypochlorite) shall be used in the cleaning materials. Potable water shall be used and, if required, some mild soap (tri-sodium phosphate) may be included to clean all processing equipment and manufactured drum bodies and lids before casting. Chlorine is known by many names on the ingredient list (e.g., sodium hypochlorite, hypochlorite, chloramine, bleach, hydrochloric acid, trihalomethanes, and generic disinfection by-products). Not all cleaning products list their ingredients; therefore, only cleaning materials that disclose all ingredients shall be used.

If the mixer sits for >15 min between mixer batches, the mixer shall be flushed thoroughly with potable water before reuse. Before the start of mixing operations described in Sect. 7, the mixer shall be clear of foreign materials or loose previous mixing residues from the inner surface of the mixer.

Manufactured drum bodies and lids that have passed geometric inspection must be cleaned and protected prior to the casting operation to prevent the introduction of foreign materials into the assemblies. The assemblies shall be inspected and wiped clean prior to casting to ensure no visible contaminants are present inside the casting cavity.

6.2 Equipment Requirements

All process equipment used for mixing, casting, and baking of the Packcrete shall be (1) identified in the Seller's operating procedures with the operational tolerances and (2) in good working condition. See SPC M801794-0003 Section 6.2 for these requirements.

6.3 Work Environments

The temperature and humidity of the material storage, casting, and curing environments can have a major impact on casting densities. Variations in mixing air, water, and curing temperatures can also influence the baked density. The Company requires controlled work and material storage environments.

6.3.1 Mixing and Casting

Mixing and casting operations shall be performed out of direct sunlight and rain with an air temperature of 70 ± 20°F.

6.3.2 Mixing and Casting Water

Mixing and casting operations shall be performed with water that complies with the requirements in Sect. 5.5.

6.3.3 Curing Storage

Curing storage shall be in an environment with an air temperature of 70 ± 20°F with the containers covered with plastic.

6.3.4 Portland Cement and Vermiculite Storage

Bags of Portland cement and vermiculite that have been opened for more than one work shift shall be discarded unless they are stored in a waterproof container in a dry location.

7. PACKCRETE PROCESSING

This specification utilizes portions of SPC M801794-0003. If conflicts occur between this specification and SPC M801794-0003, this specification shall supersede. SPC M801794-0003 uses casting Forms A, B, C, D, E, and F, and this specification uses casting Form ES3100. The casting forms from both equipment specifications become part of certification data for this specification.

SPC M801794-0003, *Packcrete Preliminary Lot Qualification*

Form A	Packcrete Setup Approval
Form B	Packcrete Mixing for Samples and Parts
Form C	Packcrete Sample 4.5-Gal Pail Vibration Casting Control
Form D	Packcrete Sample 30-Gal Drum Vibration Casting Control
Form E	Packcrete Sample Pipes Vibration Casting Control
Form F	Packcrete Furnace and Baking

SPC M801580-0003, *ES-3100 Packcrete Final Lot Qualification and Production Processing*

Form ES3100	Packcrete Vibration Casting SES3100 and ES-3100 for Body and Plug

ES-3100 Packcrete FLQ and production processing is shown in Fig. 3.

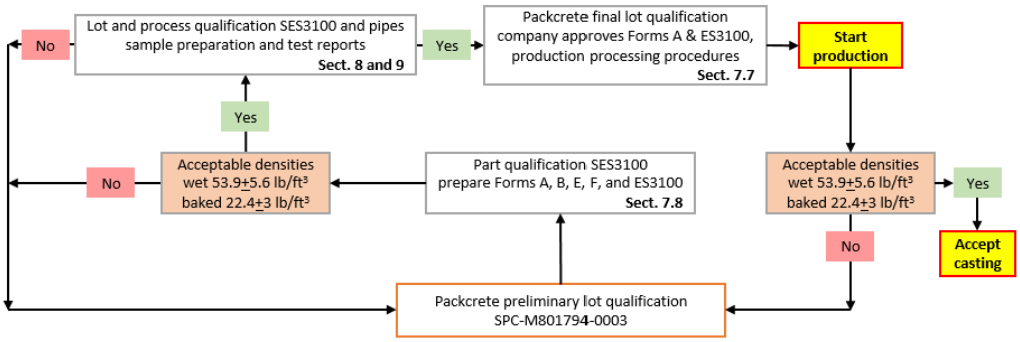


Fig. 3 ES-3100 Packcrete FLQ and production processing.

7.1 Processing Setup Requirements

See SPC M801794-0003, Section 7.1 for these requirements.

7.2 Mixing Setup Approval Control Number

See SPC M801794-0003, Section 7.2 for these requirements.

7.3 Processing Preparation for SES3100, ES-3100, and Samples

The purpose of the processing preparation for samples and parts is to create and document a controlled Packcrete casting that follows an approved mixing setup defined on Form A (SPC M801794-0003, Attachment E). The same processes are used for casting samples and parts with the vibration force being adjusted for the EWCW of the container. A partially filled container is vibrated for 10 s, vibrator is turned off, and a completely filled container is vibrated for 1 min (SPC M801794-0003, Sect. 7.3). These and other processing data are recorded on Forms C, D, E, and F in SPC 801794-0003 and Form ES3100 (Attachment C).

Table 1. Recommended vibration settings

Casting	SCR-1000 Set No. [a]	Vibration force [b] (lb)	Estimated wet cast weight [c] (lb)	Vibration intensity [d]
SES3100 plug	1.1	74	31	2.39
ES-3100 plug	1.1	74	31	2.39
SES3100 body	3.1	688	330	2.08
ES-3100 body	3.3	735	347	2.12

[a] Vibration force setting numbers for the VIBCO SCR-1000 are shown in Attachment D in SPC M801794-0003. For other vibration motors, document the changes in Form A of SPC M801794-0003 and Form ES3100 and contact the Company for force settings and approval.
[b] Recommended vibration force settings for the VIBCO SCR-1000 are shown in Attachment D in SPC M801794-0003. Vibrate 10 s for partial fills and 1 min after filling is completed.
[c] The EWCW is for one full casting mold using an estimated wet casting density of 53.9 lb/ft^3.
[d] The vibration intensity has a tolerance of ±0.6 that may change the setting number and the vibration force.

7.4 Process—Mixing and Vibration Casting, Curing, and Baking for Samples and Parts

Process mixing and vibration casting, curing, and baking for samples and parts are found in SPC M801794-0003, Section 7.4.

7.5 Setup Approval Process Verification—4.5-gal Pail or 30-gal Drum

The 4.5-gal pail or 30-gal drum have been used to verify the mixing setup control number (SACN) process that generates an acceptable wet and baked density following the requirements in Sects. 7.3 and 7.4. The 4.5-gal pail needs Forms A, B, C, and F from SPC M801794-0003, while the 30-gal drum needs Forms A, B, D, and F (Attachment E) from SPC M801794-0003 are needed to document this effort. Use these small castings if needed to verify the lots of material and process settings. Once these are verified, proceed to shipping package specific specification and perform a process and LQ castings.

7.6 Lot Qualification and Packcrete Sample Pipes

Pipe samples are required for both preliminary and final lot qualifications. The pipe sample casting requires a different stand-alone vibration table setup that vibration casts at least two pipe samples for each mixer load going into the production run mixes. This stand-alone table needs a maximum force of 100 lb and a speed of 3200 vibrations per minute, generating a frequency of 53 Hz. VIBCO supplies a standalone table that meets these requirements. The SACN used will be different than the SACN for the VIBCO SCR-1000. Follow Sects. 7.3 and 7.4 and use Forms A, B, E, and F (Attachment E) to document pipe sample casting. Section 8 describes pipe sample preparation requirements, and Sect. 9 describes pipe sample testing. Send the manufacturing and testing results to the Company for evaluation. Once the testing data is accepted by the Company, the current Form As will be approved and signed by the Company.

7.7 Final Lot Qualification Castings—SES3100 Body and Plug

The purpose of FLQ is to create and document a full-scale test of Packcrete casting (SES3100 body or plug) to validate (qualify) the raw materials, equipment, and process necessary to achieve an acceptable end product with an acceptable baked density. Furthermore, raw material testing shall be performed in accordance with Sect. 9 in SPC M801794-0003 before the raw materials are released for production processing. After the Company accepts the SES3100 castings and documentation, the Seller may proceed to the production process documented in Sect. 7.8. Optional samples for testing and their required forms are described in Sect. 8, but they will use the setup and processes described in Sect. 7.6 (SPC M801794-0003).

Process qualification (PQ) acceptance testing requires test articles from an SES3100 body and plug and sample pipes qualified in accordance with Sect. 9 (SPC M801794-0003). Section 8 of SPC M801794-0003 defines how the samples are to be made, and Sect. 9 (SPC M801794-0003) describes how the samples are to be tested. After the Company has evaluated the testing results, the Seller may be approved to start production castings or may be asked to reject the lots of raw materials and repeat the SES3100 FLQ process. During production, additional sample testing may be necessary to gather information to assure the process can be repeated on parts.

Each PQ shall document the entire manufacturing process using the materials that have successfully completed the material testing and are approved by the Company on Form A (SPC M801794-0003). The Packcrete setup approval process is documented in Sect. 7.2 (SPC M801794-0003). The Packcrete mixing setup shall follow the approved setup on Form A (SPC M801794-0003). Additional adjustments to the vibration force shall be made in accordance with Sect. 7.3 to properly manufacture a SES3100 body and plug Packcrete castings.

7.7.1 Setup—Mixing and Vibration Casting an SES3100 Body or Plug

To cast the SES3100 container, the active Setup Approval Control Number (SACN) mixing setup approval settings on Form A (SPC M801794-0003) shall be identified and followed. The Packcrete setup approval process is documented in Sect. 7.2 (SPC M801794-0003). It is required that the Seller complete casting using an SES3100 body and plug and record data on Forms B and F in SPC M801794-0003 and Form ES3100 (Attachment C) prior to proceeding to the production process described in Sect. 7.8.

The Seller shall complete setup in accordance with Sect. 7.3 for an SES3100 body or plug, recording data measurements on Form E (checking the appropriate boxes for PQ and body or plug).

7.7.2 Process—Mixing and Vibration Casting an SES3100 Body or Plug

For an SES3100 container, the active SACN mixing setup approval settings on Form A (SPC M801794-0003) shall be identified and followed. The Packcrete setup approval process documented in Sect. 7.2 (SPC M801794-0003) shall be followed for an SES3100 body or plug and the data recorded on Forms B and F in SPC M801794-0003 and Form ES3100 (Attachment C) prior to proceeding to the production process described in Sect. 7.8.

Each unique casting of a container must have the vibration force calculated as described in Sect. 7.3 that shall match the "body" or "plug" setting on Form ES3100 (Attachment C) with the vibration force adjusted to the proper setting. The Seller shall complete Sect. 7.4.1 (SPC M801794-0003) for an SES3100 body or plug, recording measurements on Forms A, B, and F in SPC M801794-0003 and Form ES3100 (checking the appropriate boxes for PQ and body or plug).

7.7.3 Process—Curing an SES3100 Body or Plug

The Seller shall follow the requirements in Sect. 7.4.2 (SPC M801794-0003) for curing an SES3100 body or plug and record measurements on Form ES3100 (checking the appropriate boxes for PQ and body or plug).

7.7.4 Process—Baking an SES3100 Body or Plug

After casting, initial curing, scraping, and final curing, place a thermocouple in at least one SES3100 body at the top center of the casting with the tip 5- to 6-in. deep to record the core temperature. It is acceptable to use a rod or drill to generate the proper depth thermocouple hole. The SES3100 body shall be baked with the core temperature thermocouple in place to determine the minimum baking time at 500°F. A bottom center thermocouple (BCT) can be used to determine the temperature of the bottom center of the inner liner for the current furnace loading. The minimum baking time at 500°F may be determined by no increase in the BCT over 2°F in 6 h of baking. Each SES3100 body has ~4.7 ft^3 of casting and will lose ~148 lb of water. If required, the furnace set point temperature may need to be adjusted to ensure that the temperature near the package is within the tolerance of ±10°F for the setting requirement.

7.7.4.1 Calculate and record the baked density using the equation at the bottom of Form ES3100. The acceptable baked density is 22.4 ± 3 lb/ft^3 (19.4–25.4 lb/ft^3) for the SES3100 casting.

7.7.4.2 If the baked density is acceptable, follow Sect. 9 (SPC M801794-0003) and send samples for lot qualification testing. Submit completed SES3100 Forms A, B, and F in SPC M801794-0003 and Form ES3100 (Attachment C) with the sample pipe casting Forms A, B, E, and F in SPC M801794-0003 to the Company for approval. Once Company has approved, production processing may start following Sect. 7.8.

7.8 Production Processing an ES-3100 Body or Plug

The purpose of the production process is to create and document the production Packcrete casting (ES-3100 body or plug) based on approved lot qualified materials and processes documented in Sect. 7.7. This practice has validated the raw materials, equipment, and processes necessary to achieve an acceptable end product and baked density. Optional samples may be required for testing and their required forms are described in Sect. 8, but they will use the setup and processes described in Sect. 7.6 (SPC M801794-0003). Each production process shall follow an approved Form A (SPC M801794-0003) identified by a SACN. The production processing shall be documented on Forms B and F in SPC M801794-0003 and Form ES3100 (Attachment C).

NOTE: It is important that the runout (roundness) of the drum body casting opening stays within ±0.03 in. prior to the Packcrete casting process as stated on M2E801580A002. In-process inspections are used to verify that the container stays acceptable during the casting and baking processes. Failure to meet the diametrical tolerance after the Packcrete casting and baking is grounds for rejection.

7.8.1 Setup—Mixing, Vibration Casting, and Curing an ES-3100 Body or Plug

Each production process shall follow an approved Form A (SPC M801794-0003) identified by a SACN and PQ as described in Sect. 7.6 (SPC M801794-0003).

The Seller shall complete the following steps:

7.8.1.1 Vibration table force and speed settings shall meet the requirements defined in Sect. 7.3, and they shall be documented on Form ES3100.

7.8.1.2 Processing as described in Sect. 7.3 shall be completed for an ES-3100 body or plug, recording measurements on Form B in SPC M801794-0003 (checking the appropriate boxes for production process and body or plug).

7.8.2 Process—Mixing and Vibration Casting an ES-3100 Body or Plug

Each production process shall follow an approved Form A in accordance with Sect. 7.4 (SPC M801794-0003) that is identified by a SACN.

The different vibration table force settings are shown in Sect. 7.3, shall match the "body" or "plug" setting in Table 1, and shall be documented on Form ES3100.

The Seller shall complete Step 7.4.1 (SPC M801794-0003) for an ES-3100 body or plug, recording measurements on Form B (SPC M801794-0003) and Form ES3100 (checking the appropriate boxes for production process and body or plug).

The Seller shall record on Form ES3100 that the drum casting opening and drum plug sheet metal diameters are within the manufacturing tolerances of ±0.12 and ±0.06, respectively. These measurements must be made after weighing and handling and before casting.

7.8.3 Process—Curing an ES-3100 Body or Plug

Each production process shall follow an approved Form A identified by a SACN and PQ described in Sect. 7.4 (SPC M801794-0003) and recorded on Form B (SPC M801794-0003).

The Seller shall complete the steps described in Sect. 7.4.2 (SPC M801794-0003) for an ES-3100 body or plug and record measurements on Form ES3100 (checking the appropriate boxes for production process and body or plug).

7.8.4 Process—Baking an ES-3100 Body or Plug

After casting, initial curing, scraping, and final curing, place a BCT on the bottom center of the inner liner of the ES-3100 body. The BCT shall be used to determine the temperature of the bottom center of the inner liner for the current furnace loading. The minimum baking time at 500°F may be determined by no increase in the BCT over 2°F in 6 h of baking. If required, the furnace set point temperature may be adjusted to ensure that the temperature near the package is within the tolerance of ±10°F for the setting requirement.

Each ES-3100 body and plug has ~4.8 ft^3 of casting and will lose ~151 lb of water. Therefore, each unique furnace loading must be qualified with thermocouple readings to determine the minimum baking time at 500°F for that volume of castings, or real time temperature measurements may be recorded. For real time temperature measurements, the ES-3100 body shall be baked with the BCT in place to determine the temperature of the bottom center of the inner liner for the current furnace loading. A real time measurement furnace may be used in the future as a Baking Qualification Control Number-Vol (BQCN-Vol) that controls the minimum baking time for a volume of cast material loaded into the furnace. The cast Packcrete volume in cubic feet is recorded on Form F (SPC M801794-0003). The BQCN-Vol time at 500°F may be used for oven loads up to the qualified volume without real time measurements being required.

The Seller shall complete the final following steps.

7.8.4.1 Complete the steps in Sect. 7.4.3 (SPC M801794-0003) for an ES-3100 body or plug and record measurements on Form ES3100 (Attachment C) and Form F in SPC M801794-0003 (checking the appropriate boxes for production process and body or plug).

7.8.4.2 Calculate and record the baked density of the cured mixture using the equation at the bottom of Form ES3100. The acceptable baked density is 22.4 ± 3 lb/ft^3 (19.4–25.4 lb/ft^3).

7.8.4.2.1 If the baked density is not acceptable, reject the part and contact the Company for information and future casting improvements.

7.8.4.2.2 If the baked density is acceptable, follow the instructions in Attachment A and submit completed Forms A–F (SPC M801794-0003) and Form ES3100 to the Company for approval.

7.8.4.2.3 Weld the covers on to complete the drum body weldment or top plug weldment in accordance with M2E801580A002 or M2E801580A002 and JS-YMN3-801580-A002.

7.8.4.3 Insert copies of the approved raw material test reports; SACN, SES3100 casting, and lot qualification reports; and production casting forms into the certified data package that are used to define the production process in accordance with the instructions in Attachment A.

7.8.4.4 Verify that the stainless-steel shell, as shown in M2E801580A002 and M2E801580A008, have passed geometric inspection before casting begins.

8. PACKCRETE LOT QUALIFICATION AND PRODUCTION TEST SAMPLES

The Packcrete lot qualification and production test samples requirements are found in SPC M801794-0003. The 30-gal drum may be used to replace the SES3100 casting in the production sampling set once equivalences have been demonstrated with test results.

9. PACKCRETE MATERIAL LOT QUALIFICATION PROPERTIES LIMITS

Packcrete material lot qualification properties limits are found in SPC M801794-0003.

ATTACHMENTS

ATTACHMENT A: SUBMITTAL CHECKLIST

Instructions to Supplier for Preparation of Submittals

Note 1 --All correspondence shall be addressed to the Technical Representative identified by the company. The Supplier shall forward submittals via transmittal letter to the Company at the address specified in the contract.

Note 2 -- The submittal must have adequate detail so that full compliance with the requirements may be determined. For example, a simple off-the-shelf item to be used in an assembly may only need a manufacturer's cut-sheet to show compliance, but a factory acceptance test (FAT) developed and submitted by the Seller must have each test step detailed with acceptance criteria consistent with the requirements.

a. Review submittal before transmitting to the Company to verify conformance with requirements of the contract documents (e.g., field measurements, field construction criteria, or manufacturer's catalog numbers).
b. Coordinate submittals with the work requirements and the contract documents.
c. Organize Submittals
   - Do not use highlight marker or color coding on submittals.
   - The minimum resolution used for scanning submittals shall be 300 dpi x 300 dpi.
   - For submittals containing color information important to the record, a 24-bit color setting should be used.
   - Submittals are to be legible and in the format specified on the submittal checklist.
   - Pen and ink changes are to be made in non-erasable ink, legible, dated and initialed.
   - Mark specific options provided for the work, and cross out options not provided.
   - Each submittal shall be sent as a single pdf file unless otherwise specified.
d. Label submittals with the applicable item number, reference, and requirement description as summarized in the Submittal Checklist. Unlabeled submittals will be returned to the Seller without review.
e. Include with submittals a transmittal letter that identifies individual documents by specification section.
   - Transmittal for submittals shall be numbered using the purchase order number followed by a 4-digit sequential number. (Example: 430001111-0001).
   - Embedded comments or questions that are not included on the transmittal may not be addressed/resolved by the Company.
f. Direction will be given at the time of award to either upload submittals to a company provided URL address or send by email to a company provided email address.
g. If using a company provided URL to upload submittals, notify the Company via email when submittals have been placed.
h. After review of a submittal, the Company will assemble comments and provide a status on the documents. An example of this submittal status stamp is shown below.

DOCUMENT REVIEW STATUS		
1	☐ Work may proceed.	
2	☐ Revise & resubmit. Work may proceed subject to incorporation of changes indicated.	
3	☐ Revise & resubmit. Work may not proceed.	
4	☐ Review not required. Work may proceed.	
Permission to proceed does not constitute acceptance or approval of design details, calculations, analysis, test methods developed or selected by the supplier and does not relieve supplier from full compliance with contractual obligations.		
REVIEWED BY:	Print Name/Signature :	Date:

i. If a submittal is being resubmitted, then reference the applicable item number, reference, and requirement description and identify it as a resubmittal.
j. Company response will only be returned to the Supplier for those submittals with a Submittal Purpose of "For Action," unless it is determined that a submittal transmitted "For Information" is not acceptable.
k. AFTER written approval is obtained, THEN proceed with work requiring approved submittals.
l. When approval submittals are required, work done before Company approval is at the Seller's risk.
m. Maintain a copy of the company-approved submittal and status page on file.

UCN-22212 (12-18)

SUBMITTAL CHECKLIST

SCHEDULE				FORMAT		PURPOSE	
AA	After Award	PTF	Prior to Fabrication	CD	Compact Disk	FA	For Action
AI	After Issue	PTFA	Prior to Final Acceptance/at Completion	DVD	Digital Video Disk	FI	For Information
AIT	After Inspection Test	PTL	Prior to Lift	EM	E-Mail		
AM	After Mobilization	PTM	Prior to Mobilization	EN	Electronic (Native)		
AP	After Proposal/Bid	PTS	Prior to Shipment	EP	Electronic (PDF)		
ATS	At Time of Shipment (Separately)	PTT	Prior to Test	O	Original		
B	Before Balance of Payment	PTW	Prior to Weld	P	Prints/Photocopies		
NTP	Notice to Proceed	Q	As Required	PH	Photographs		
PTC	Prior to Construction/Commencing Work	R	As Requested	S	Sample		
PTD	Prior to Delivery	WP	With Proposal/Bid	X	X-rays		

Item No.	Reference	Requirement Description	Schedule	Format [a]	No. of Copies	Submittal Purpose
	3.8	Manufacturing plan	PTF	EP	1	FA
	3.9.1	Submittal checklist (Excel spreadsheet)	Q	EM, EN	AR	FI
	3.9.1	Packcrete processes procedures for weighing, mixing, pouring, vibrating, curing, and baking.	PTF	EP	1	FA
	3.9.2 [a]	Raw material test reports and third party test laboratory Certificate of Conformance	PTF	EP	1	FA
	3.9.2 [a]	Copy of mixing materials Certificate of Conformance	PTF	EP	1	FA
	3.9.2 [a]	Certification data package	PTD	EP	1	FA
	4	Quality assurance plan	WP	EP	1	FA
	7.8	Production processing an ES-3100 body or plug	PTF	EP	1	FA
	Form A [b]	Packcrete Setup Approval	PTD	EP	1	FA
	Form B [b]	Packcrete Mixing for Samples and Parts	PTD	EP	1	FA
	Form D [b]	Packcrete Sample 30-Gal Drum Vibration Casting Control	PTD	EP	1	FA
	Form E [b]	Packcrete Sample Pipes Vibration Casting Control	PTD	EP	1	FA
	Form F [b]	Packcrete Furnace and Baking	PTD	EP	1	FA
	Form ES3100 [c]	Packcrete Vibration Casting (SES3100 and ES-3100 for body and plug)	PTD	EP	1	FA

[a] The certification data package must also have one printed hard copy of the entire certification data.
[b] SPC M801794-0003.
[c] Attachment C.

ATTACHMENT B: ABBREVIATIONS AND ACRONYMS

See SPC M801794-0003 for acronyms that are not included here.

ASME	American Society of Mechanical Engineers
CBA	Confinement Boundary Assembly
LLC	Limited Liability Company
QA	Quality Assurance
SES3100	Simulated ES-3100

ATTACHMENT C: PACKCRETE PROCESSING FORM

Form ES3100 Packcrete Vibration Casting

Note: The following forms are in Attachment E of SPC M801794-0003.

Form A Packcrete Setup Approval
Form B Packcrete Mixing for Samples and Parts
Form C Packcrete Sample 4.5 Gal Pail Vibration Casting Control
Form D Packcrete Sample 30 Gal Drum Vibration Casting Control
Form E Packcrete Sample Pipes Vibration Casting Control
Form F Packcrete Furnace and Baking

Form ES3100 ***Packcrete Vibration Casting*** [ ] Lot Qualification (SES3100) [ ] Production Process (ES-3100) [ ] Plug [ ] Body		Specification Number	Revision
		Issue date (mm/dd/yy)	Revision date (mm/dd/yy)
Caster's company name		Y-12 observers present	
Packaging name (i.e., ES-3100 or SES3100) [a]		Part Serial Number	

Measurement	Comment	Measure	Units	Operator	Witness
Clean and empty			lb		
Filled with water [c]	Water temp. °F		lb		
Container volume			ft^3		
Wet cast weight	Estimate		lb		
Vibration table force setting [d]	SES3100 plug: #1.1, 74 lbf ES-3100 plug: #1.1, 74 lbf SES3100 body: #3.1, 688 lbf ES-3100 body: #3.3, 735 lbf		lb		
Vibration table speed setting [d]	80%		%		
Vibration intensity ~1.1 to 3.3	Force / wet weight				
Ensure ES-3100 casting: Drum body opening Ø±0.12 in. Drum plug body Ø±0.06 in.	Pass	Fail			
Operation	**Mix Control Number (MCN)**	**Vibration duration [e]**	**Time**	**Operator**	**Witness**
Pour Start 1 [e]		10	s		
Pour Start 2 [e]		10	s		
Pour Start 3 [e]		10	s		
Full vibration time		1	min		
Measurement	**Comment**	**Measure**	**Units**	**Operator**	**Witness**
Wet cast weight	Actual		lb		
Wet density	Target 53.9 ± 5.6 lb/ft^3		lb/ft^3		
Measured wet density (48.3 – 59.5 lb/ft^3) acceptance				Accept	Reject [f]
Scrape the top and weigh			lb		
Cure time (at least 7 days)	BCN – MCN_1		days		
Baking Control Number (BCN) [b]					
After baking weight			lb		
Baked density	Target 22.4 ± 3 lb/ft^3		lb/ft^3		
$\frac{Baked_Density}{Wet_Density}$					
Measured baked density (19.4 – 25.4 lb/ft^3) acceptance				Accept	Reject [f]

[a] ES-3100 drawings are M2E801580A002, *Body Weldment*, and M2E801580A008, *Top Plug Weldment or SES3100 Body or Plug*.
[b] B are alpha prefixes plus a 10-digit control number is used to document the date and time that process qualification was started using a 24-h format (i.e., B1021081515 is used for October 21, 2008, at 3:15 p.m.).
[c] Record the water weight and temperature within 10 min from completion of the weighing process.
[d] Document the vibration force and frequency settings (Sect. 7.3) and duration established by the PQ.
[e] For partial casts, vibrate the drum 10 s and stop. Once full, vibrate for 1 min.
[f] Upon rejection, contact the Company and send the casting records.

$$\text{Volume} = \frac{(WithWater - CleanAndEmpty)}{62.3}\ ft^3 @ 70°F$$

$$\text{Wet density} = \frac{(WetCast - CleanAndEmpty)}{\text{Volume}}\ lb/ft^3$$

$$\text{Baked density} = \frac{(AfterBaking - CleanAndEmpty)}{\text{Volume}}\ lb/ft^3$$

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Appendix 1.3.13
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2. STRUCTURAL EVALUATION

The ES-3100 package is used to ship highly enriched uranium (HEU) in the following forms: oxide; oxide with thorium; bulk and broken metal shapes; uranyl nitrate crystals (UNX); and unirradiated research reactor fuel elements and components, and uranium compounds. Content will be packed in various size convenience cans made of stainless, tin-plated carbon steel, aluminum, or nickel alloy, and polyethylene, glass, or Teflon fluorinated ethylene propylene (FEP) bottles. The cans shall have a diameter of ≤ 12.7 cm (5 in.) and heights of ≤ 25.4 cm (10 in.). Two or more cans having a diameter of ≤ 12.7 cm (5 in.) and a maximum height of ≤ 25.4 cm (10 in.) may be brazed together to form a can assembly of up to 76.2 cm (30 in.) in height (Fig. 1.4). Any combination of these cans shall be allowed in a single package, as long as the total length of the can stack (with spacers when required) does not exceed the inside working height of the containment vessel. Any closure on the convenience can is allowed. Containment vessel arrangements that utilize closed metal cans with diameters >10.8 cm (4.25 in.) will provide for at least 43 $in.^3$ of free or void volume for gas expansion and offgassing of material at temperatures associated with Normal Conditions of Transport (NCT) or Hypothetical Accident Conditions (HAC). The contents that cannot be packaged in the proposed cans due to the contents' overall dimensions, such as the unirradiated research reactor fuel elements and components, will be bundled together and protected on each end with an open-ended can (Fig. 1.4). When space is available inside the containment vessel, stainless-steel metal scrubbers will be placed on the top and bottom of this partially canned assembly, or an empty convenience can will be placed on the top or bottom of this assembly inside the containment vessel. Solid form HEU contents that will not fit in a convenience can may be bagged only with no convenience can required around the content. However, the usage of convenience cans for these contents is not prohibited. Stainless-steel metal scrubbers may be placed on the top and bottom of this assembly inside the containment vessel. Additionally, glass bottles with enriched uranium oxide may be packed inside metal convenience cans. These glass bottles with enriched uranium oxide containing UO_2-Mg will be treated as pyrophoric material and packaged in a sealed and inerted container. Polyethylene, nylon, or Teflon bags may be used inside or outside any convenience can as long as the loading restrictions in Sect. 1.2.2.8 are met. If Teflon bottles are used as convenience containers, the total amount of offgassing material (including Teflon bottles, polyethylene, nylon, or Teflon bagging, and lifting slings) is limited to 1490 g per package. If metal cans, polyethylene bagging, nylon bagging, Teflon bagging or polyethylene bottles are used as convenience containers, the total amount of offgassing material (including polyethylene bottles, polyethylene bagging, nylon bagging, Teflon bagging, and lifting slings) is limited to 500 g per package (see Sect. 6.2.4, Item 7). The maximum payload inside the containment vessel will be as follows and as shown in Table 2.1: (1) 24-kg oxide or compounds (up to 100% enrichment in ^{235}U); (2) HEU oxide shall be in the form of U_3O_8-Al, UO_2-Mg, UO_2-ZrO_2, UO_2, UO_3, U_3O_8, UO_2-Th, or UO_2-ThO_2 ; (3) 24 kg of UNX crystals; (4) 35.2 kg of uranium metal and alloy (up to 100% enrichment in ^{235}U); (5) HEU metal and alloy may be in the form of broken pieces, ingots, buttons, small castings, cylinders, or fuel elements (rods, plates, or tubes); and (6) the maximum weight of all contents, including nuclear material, convenience containers, polyethylene bags, nylon bags, Teflon bags, spacers, slings, etc., shall not exceed 40.82 kg (90 lb). Uranium and transuranic isotopic allowances are defined in Chap. 4. As shown in Chap. 1, some thorium (^{232}Th) compounds or oxides mixed with uranium are proposed for transport. Shipping of ^{232}Th is bounded by the analysis using uranium for containment or hydrogen gas generation as shown in Appendices 4.5.1 and 3.5.4 due to the following: (1) the A_2 of ^{232}Th is unlimited; (2) the decay energy of ^{232}Th is less than all other uranium isotopes; and (3) the half-life of ^{232}Th is significantly longer than the uranium isotopes. Mass limits and total weights for each shipping arrangement are defined and described in Sect. 2.1.3. The 40.82-kg (90-lb) maximum containment vessel content weight and 35.2-kg (77.60-lb) HEU content weight limits have been established as a bounding case for the maximum structural, thermal, and

containment limit for the shipping package. There is no minimum content weight requirement. The content masses and forms used for the proposed content do not take into consideration limits based on shielding and subcriticality.

As described in the following sections, design analysis, similarity, drop simulations, and the full-scale testing documented herein demonstrates that the ES-3100 package is in compliance with the requirements of Title 10 Code of Federal Regulations (CFR) 71 and Title 49 CFR 100–178 when it is used to ship contents described above. The maximum bounding activity of the contents (35.2 kg of HEU) is 7.2554×10^{-1} TBq (19.6092 Ci) and occurs 10 years after initial fabrication. When the maximum activity-to-A_2 value is reached at ~70 years from material fabrication, the corresponding activity is 7.2456×10^{-1} TBq (19.5827 Ci). The corresponding maximum number of A_2s carried is 4.7528×10^{3}. This information is further discussed in Chap. 4.

Table 2.1. Proposed HEU contents for shipment in the ES-3100

Form	Chemical or physical description	Total weight of HEU contents kg (lb)
HEU oxide	U_3O_8-Al, UO_2-Mg, UO_2, UO_3, U_3O_8, product oxides (UO_2, UO_3, U_3O_8) mixed with ThO_2, ZrO_2, or thorium metal	24 (52.91)
Uranyl nitrate crystals	$UO_2(NO_3)_2 \cdot 6H_2O$	24 (52.91)
HEU metal and alloy	Specific geometric shapes (spheres, cylinders, square bars or slugs) or broken metal pieces, rods, plates, or tubes	35.2 (77.60)

2.1 DESCRIPTION OF STRUCTURAL DESIGN

2.1.1 Discussion

The principal structural members of the shipping package consist of the following: the drum assembly, the containment vessel, packaging material, and the contents. Each of these will be described and discussed in the following sections.

2.1.1.1 Drum assembly

The drum assembly of the shipping package is defined as the structure that maintains the position of and provides protection to the impact and thermal barrier surrounding the containment vessel. Preserving the location of the containment vessel within the packaging prevents reduction of the shielding and subcriticality effectiveness. The drum assembly for the ES-3100 consists of an internally flanged Type 304 or 304L stainless-steel 30-gal modified drum with two Type 304 or 304L stainless-steel inner liners, one filled with noncombustible cast refractory insulation and impact limiter (Kaolite 1600 or Packcrete) and one filled with noncombustible cast neutron absorber (Cat 277-4), a stainless-steel top plug with cast refractory insulation, silicone rubber pads, silicon bronze hex-head nuts, and a stainless-steel lid and bottom (Drawing M2E801580A031, Appendix 1.3.7). The nominal weight of these components is 131.89 kg (290.76 lb).

The drum's diameters (inner diameter of 18.25 in.) and corrugations meet the requirements of Military Standard MS27683. All other dimensions are controlled by Drawing M2E801580A004 (Appendix 1.3.7). Modifications to the drum from MS27683 include the following: (1) the overall height was increased; (2) the drum was fabricated with two false wire open ends; and (3) a

0.27-cm (12-gauge, 0.1046-in.)–thick concave cover was welded to the bottom false wire opening (Drawing M2E801580A005, Appendix 1.3.7). Four 0.795-cm (0.313-in.)–diam equally spaced holes are drilled in the top external sidewall to prevent a pressure buildup between the drum and inner liner. The holes are sealed with a plastic plug to provide a moisture barrier for the cast refractory insulation during NCT. The cavity created by the inner liner for placement of a containment vessel is a three-tiered volume. The uppermost tier accommodates the top plug and has an inside diameter of 37.52-cm (14.77-in.) and is 13.26-cm (5.22-in.) deep. The second tier has an inside diameter of 21.84-cm (8.60-in.) that is 5.59-cm (2.20-in.) deep. The third tier has a 15.85-cm (6.24-in.) inside diameter that is 78.31-cm (30.83-in.) deep.

The volume between the mid liner and the drum and the top plug's internal volume is completely filled with the noncombustible cast refractory insulation called Kaolite 1600 from Thermal Ceramics, Inc. or Packcrete. Kaolite properties, such as mechanical, thermal conductivity, and impact, are presented in Y/DW-1661, ORNL-TM-2003/49, Y/DW-1890, and Y/DW-1972. Material properties for Packcrete are presented in RP 802282-0002. The volume inside the center liner tube is filled with a noncombustible cast neutron poison (absorber) material called Cat 277-4, which is created by mixing Cat 277-0 material from Shieldwerx (SWX-277-0) and boron carbide (B_4C). The material is composed of aluminum, magnesium, calcium, boron, carbon, silicon, sulfur, sodium, iron, and water. The final mixture will have an average density of 110 lb/ft^3. Cat 277-4 properties, such as thermophysical, mechanical, and neutron activation, are presented in ORNL/TM-2004/290, Y/DW-1987, Y/DZ-2585, COR-NDA-04-93, and Y/DV-1914. BoroBond4, another noncombustible neutron absorber, was used only in prototype test packages instead of Cat 277-4. The drum body, inner liners, and lid are fabricated from 0.15-cm (16-gauge, 0.0598-in.)–thick Type 304 or 304L stainless-steel sheet. A rolled stainless-steel flange with a 5.08 × 5.08 × 0.64-cm (2 × 2 × 0.25-in.)–thick modified stainless-steel structural angle is welded around the top of the mid inner liner. The mid inner liner is then welded to the inside surface of the drum along this flange. Eight ⅝-11-UNC-2A studs welded to the drum and silicon bronze nuts provide the structural attachment for the drum lid, and are torqued to 40.67 ± 6.78 N·m (30 ± 5 ft-lb) at assembly. The drum lid's diameter and shape meet the requirements of Military Standard MS27683. All other dimensions are controlled by Drawings M2E801580A006 and M2E801580A007, Appendix 1.3.7. The stiffener ring (Find Number 3 on Drawing M2E801580A006, Appendix 1.3.7) provides the lid with an inner flange. The stiffener ring was incorporated in the ES-3100 package for use during handling and transport to protect the lid closure studs and nuts. During transport, the stiffener ring helps position drum tie-down adapters that are used for tie-down of a single unit configuration in Safeguards Transporters (SGTs) in accordance with the National Nuclear Security Administration (NNSA) Technical Manual. The drum is marked by two stainless-steel data plates. The data plate lettering and mounting requirements on the drum are shown on Drawings M2E801580A010 and M2E801508A031 (Appendix 1.3.7), respectively. Painting and marking requirements for the drum are shown on Drawing M2E801580A001 (Appendix 1.3.7). Two lugs are welded to the mid inner liner and project through the drum lid at assembly. Each lug has a 0.953-cm (0.38-in.)–diam hole through which a tamper-indicating device (TID) can be threaded.

The volume between the drum and mid-liner is filled with a lightweight noncombustible cast refractory material called Kaolite 1600 or Packcrete. The top plug is also filled with either of these materials and represent the thermal insulation and impact-limiting barrier. The material is composed of portland cement, water, and vermiculite and has an average density of 358.8 kg/m^3 (22.4 lb/ft^3). The procedures for manufacturing and documenting Kaolite 1600 material, JS-YMN3-801580-A003 (Appendix 1.3.4), and Packcrete material, SPC M801794-0003 (Appendix 1.3.11) and SPC M801580-0003 (Appendix 1.3.12), are referenced on Drawings M2E801580A002 and M2E801580A008 (Appendix 1.3.7) for the drum assembly weldment and top plug weldment, respectively. The insulation has a maximum continuous service temperature limit of 871°C (1600°F) due to the presence of the vermiculite and portland cement.

The volume between the most inward liner and the mid-liner is filled with a noncombustible cast neutron-absorber (poison) material from Thermo Electronic Corp. called Cat 277-4. The material is a high alumina borated concrete composed of aluminum, magnesium, calcium, boron, carbon, silicon, sulfur, sodium, iron, and water. The final mixture has an average density of 1681.9 kg/m^3 (105 lb/ft^3). The procedure for manufacturing and documenting the installation of this material, JS-YMN3-801580-A005 (Appendix 1.3.5), is referenced on Drawing M2E801580A002 (Appendix 1.3.7). This neutron-absorber material has a maximum continuous service temperature limit of 150°C (302°F) in order to retain the bound mass of water in the final cured mixture for subcriticality control.

The top plug is fabricated in accordance with Drawing M2E801580A008 with an overall diameter of 36.50 cm (14.37 in.) and a height of 13.41 cm (5.28 in.). The plug's rim, bottom sheet, and top sheet are fabricated from 0.15-cm (16-gauge, 0.0598-in.)–thick Type 304 or 304L stainless-steel sheet per American Society of Mechanical Engineers (ASME) SA-240. Four lifting inserts are welded into the top sheet for loading and unloading operations. Again, the internal volume of the top plug is filled with Kaolite 1600 or Packcrete material.

Three silicone rubber pads complete the drum assembly. One pad is placed on the bottom of the most inward liner to support the containment vessel during transport. Another pad is placed on the top shelf of the mid-liner to support the top plug during transport. The final pad is placed over the top of the containment vessel during transport. The pads are molded to the shapes as defined on Drawing M2E801580A009 (Appendix 1.3.7). The material is silicone rubber with a Shore A durometer reading of 22 ± 5.

2.1.1.2 Containment boundary

The containment vessel's body, lid assembly, and inner O-ring provide the containment boundary (Fig. 1.3). The O-ring material is ethylene propylene diene monomer (EPDM) [see Tables 2.7 and 2.15]. Two methods of fabrication may be used to fabricate the containment vessel body of the ES-3100 package as shown on Drawing M2E801580A012 (Appendix 1.3.7). The first method uses a standard 5-in., schedule 40 stainless-steel pipe per ASME SA-312 Type TP304L, a machined flat-head bottom forging per ASME SA-182, Type F304L, and a machined top flange forging per ASME SA-182, Type F304L. The nominal outside diameter of the 5-in. schedule 40 pipe is machined to match the nominal wall thickness of 0.100 in. Each of these pieces is joined with circumferential welds as shown on Sheet 2 of Drawing M2E801580A012 (Appendix 1.3.7). The top flange is machined to match the schedule 5-in. pipe, to provide two concentric half-dovetailed O-ring grooves in the flat face, to provide locations for two 18-8 stainless-steel dowel pins, and to provide the threaded portion for closure using the lid assembly. The second method of fabrication uses flow forming to create the complete body (flat bottom, cylindrical body, and flange) from a single forged billet or bar with final material properties in accordance with ASME SA-182, Type F304L. The top flange area using this fabrication technique is machined identically to that of the welded forging method. The lid assembly, which completes the containment boundary structure, consists of a sealing lid, closure nut, and external retaining ring (Drawing M2E801580A014, Appendix 1.3.7). The containment vessel sealing lid (Drawing M2E801580A015, Appendix 1.3.7) is machined from Type 304 stainless-steel bar with final material properties in accordance with ASME SA-479. The containment vessel closure nut (Drawing M2E801580A016, Appendix 1.3.7) is machined from a Nitronic 60 stainless-steel bar with material properties in accordance with ASME SA-479. These two components are held together using an external retaining ring made from Type 302 stainless steel. A weld is used to seal around a plug that is inserted inside the hole used for machining the pathway for leak testing between the O-rings. Since this plug and weld are outside the containment boundary, the weld is not important to safety. However, it is important to operation because its sealing capability is needed to properly conduct the preshipment leak test. This weld is addressed in Paragraph 3.4 of the containment vessel equipment specification

(JS-YMN3-801580-A001, Appendix 1.3.3). In this specification, the weld is inspected visually and using dye penetrant. The requirements of Subsections NB-5110 and NB-5350 of the *ASME Boiler and Pressure Vessel Code* (ASME Code) also apply. The sealing lid is further machined to accept a ⅜-16 swivel hoist ring bolt to facilitate loading and unloading, to provide a leak-check port between the elastomeric O-rings, and notched along the perimeter to engage two dowel pins. The lid assembly, with the O-rings in place on the body, are joined together by torquing the closure nut and sealing lid assembly to 162.70 ± 6.78 N·m (120 ± 5 ft-lb). The sealing lid portion of the assembly is restrained from rotating during this torquing operation by the two dowel pins installed in the body flange. A leak-check port is located between the O-rings in the containment vessel to facilitate a pressure rise or drop leakage test following assembly or 10 CFR 71 compliance testing. This port is sealed during transport using a modified VCO threaded plug. Only the inner O-ring is considered a part of the containment boundary.

There are no penetrations of, connections to, or fittings for the sealed containment boundary. To meet the requirements for package certification, the containment boundary must remain intact during all conditions of transport. This integrity must be demonstrated by test or other acceptable methodology for NCT and HAC as described in 10 CFR 71.

2.1.1.3 Packaging materials

Contents may be packed in four ways: first, various size convenience cans made of stainless steel, tin-plated carbon steel, aluminum, or nickel-alloy, and polyethylene bottles or Teflon FEP bottles may be used (including bottles inside metal cans); second, contents that cannot be packaged in the proposed cans due to the contents' overall dimensions, such as the unirradiated research reactor fuel elements, will be bundled together and protected on each end with an open-ended can (Fig. 1.4); third, solid form contents that will not fit in a convenience can may be bagged only with no convenience can required around content (however, usage of convenience can is allowed); fourth, glass bottles with enriched uranium oxide (UO_2-Mg) will be packed inside a sealed and inerted container and treated as pyrophoric contents.

The convenience cans shall have a diameter of ≤ 12.7 cm (5 in.) and a height of ≤ 76.2 cm (30 in.). Any combination of these cans shall be allowed in a single package, as long as the total length of the can stack (with spacers and pads as required) does not exceed the inside working height of the containment vessel (~31 in.). Any closure on the convenience can is allowed. Multiple short cans may be brazed together. Containment vessel arrangements that utilize closed metal cans with diameters >10.8 cm (4.25 in.) will provide for at least 55 $in.^3$ of free or void volume for gas expansion and offgassing of material at temperatures associated with NCT or HAC. The polyethylene bottles have a diameter of ~12.54 cm (4.94 in.) and a height of ~22.1 cm (8.7 in.). A total of three polyethylene bottles may be loaded into the containment vessel. The Teflon FEP bottles have a diameter of ~11.91 cm (4.69 in.) and a height of ~23.88 cm (9.4 in.). A total of three Teflon FEP bottles may be loaded into the containment vessel. Polyethylene, nylon, or Teflon bags may be used inside or outside any convenience can or bottle. In some packing arrangements, silicone rubber pads may be used between convenience cans. Also, some arrangements will require can spacers between cans (see Table 1.3). These spacers are thin stainless-steel cans filled with the noncombustible cast neutron poison. Each convenience can and spacer is equipped with a stainless-steel band clamp and nylon coated wire for loading and unloading operations. The spacers are ~10.49 cm (4.13 in.) in diameter by 4.45 cm (1.75 in.) in height and have a maximum weight of ~0.71 kg (1.56 lb). In order to minimize displacement of convenience containers during transport, stainless-steel scrubbers or polyethylene, nylon, or Teflon bags may be added on the top or bottom of the last can or bottle in the containment vessel.

When bundling fuel elements, stainless-steel metal scrubbers will be placed on the top and bottom of this partially canned assembly, or an empty convenience can will be placed on the top or bottom of this assembly inside the containment vessel.

If partial loading configurations are employed and empty cans or bottles are used, these empty cans or bottles will require a minimum 0.32-cm (⅛-in.)–diam hole to be placed through the lid.

2.1.2 Design Criteria

The ES-3100 packaging/content combination addressed in this safety analysis report for packaging (SARP) is intended to ship contents with a maximum activity of 7.2554×10^{-1} TBq (19.6092 Ci) at 10 years from initial fabrication; the maximum number of A_2s carried is 4.7528×10^{3} at 70 years following initial fabrication (Table 4.4). Based on the guidance from U.S. Nuclear Regulatory Commission (NRC) Regulatory Guide 7.11, *Fracture Toughness Criteria of Base Material for Ferritic Steel Shipping Cask Containment Vessels with a Maximum Wall Thickness of 4 Inches (0.1 m)*, this package is classified in NUREG-1609 (Table 1.1) and Table 2.2 as a Category I shipping package. Therefore, the containment vessel is designed (using nominal dimensions for each component), fabricated, and inspected in accordance with the ASME Code, Sect. III, Div. 1, Subsection NB. The design and subsequent verification comply with the requirements of 10 CFR 71. The structural requirements for the packaging under NCT are addressed in Sect. 2.6. The structural requirements for the packaging under HAC are addressed in Sect. 2.7.

Table 2.2. Category designations for Type B packages

Contents form	Category I	Category II	Category III
Normal form	>3000 A_2 or >1.11 PBq (30,000 Ci)	Between 3000 A_2 and 30 A_2, and not >1.11 PBq (30,000 Ci)	<30 A_2 and <1.11 PBq (30,000 Ci)

The drum assembly of the shipping package is defined as the structure that maintains the position of and provides protection to the impact barrier, thermal barrier, and neutron poison surrounding the containment vessel. Because the location of the containment vessel in the packaging is stable, the shielding and subcriticality effectiveness of the package is not reduced. The drum assembly for the ES-3100 consists of an internally flanged Type 304 or 304L stainless-steel 30-gal modified drum with two Type 304 or 304L stainless-steel inner liners, one filled with noncombustible cast refractory insulation and impact limiter and one filled with noncombustible cast neutron absorber; a stainless-steel top plug with cast refractory insulation, silicone rubber pads, silicon bronze hex-head nuts, and a stainless-steel lid and bottom (Drawing M2E801580A001, Appendix 1.3.7). The drum assembly is maintained when there are no breaches in the drum surface, the lid remains attached, the relative position of the containment vessel is not altered significantly, and no substantial amount of insulation is exposed following testing stipulated in 10 CFR 71.71 and 73. The drum assembly's design requirements for compliance testing are as follows:

1. The drum lid shall remain attached to the drum under all loading conditions.
2. No opening in the drum shall occur large enough to pass a 10-cm cube [10 CFR 71.43(a)].
3. The outer drum's effective diameter shall exceed requirements to maintain subcriticality and shielding effectiveness.
4. The drum assembly shall provide the structural and thermal protection needed to ensure the containment vessel meets the test leakage criteria for both NCT and HAC of $\leq 1.0 \times 10^{-7}$ ref-cm^3/s.
5. Neutron poison remains in place and retains the amount of water needed to maintain subcriticality.

In accordance with NUREG/CR-3854, Part 4.2 for a Category I shipping package, an acceptable specification for a drum used in any of the component safety groups is U.S. Department of Transportation (DOT) Specification 17C or better. It should be noted that the Specification 17C package is no longer included in the DOT regulations (49 CFR 178). The drum used in the ES-3100 is fabricated in accordance with the dimensional requirements of MS27683 and modified as shown on Drawing M2E801580A004 (Appendix 1.3.7). The fabrication requirements for the ES-3100 drum assembly are shown in JS-YMN3-801580-A002 (Appendix 1.3.2). Material, fabrication, and quality control criteria are generally equivalent to those imposed for a DOT Specification 17C drum. The drum weld seam is pressure tested to 68.95 kPa (10 psi) gauge in accordance with MIL-D-6054F. As discussed in Sect. 1.2.1.1, the drum used for the ES-3100 is equivalent to or better than that stipulated by NUREG/CR-3854 for a Category I shipping package. In accordance with DOE, a performance-based package is an approved, quality-controlled, hazardous material container that has been tested or analyzed to demonstrate its ability to maintain confinement and/or containment of its contents under both normal use and credible accident conditions as stipulated in 10 CFR 71. The drum assembly and containment vessel have been maintained for the ES-3100 shipping package as demonstrated by test results documented in the test report (ORNL/NTRC-013) and the analytical comparisons discussed in Sects. 2.6 and 2.7.

The codes and standards used for design, analysis, and fabrication of the containment vessel's components are satisfied by complying with the appropriate paragraphs in Sect. III, Div. 1, Subsection NB, and Sect. IX of the ASME Code. Nominal dimensions, not minimum dimensions, were used in the design analysis of the containment vessel components. Though not explicitly expressed, the load combinations and tests stated in NRC Regulatory Guide 7.8, *Load Combinations for the Structural Analysis of Shipping Casks*, are used in the structural evaluation of the containment vessel for both NCT and HAC as depicted in Table 2.3. Acceptance criteria for the containment vessel stresses are shown in Table 2.4 and locations are depicted in Fig. 2.1.

The design internal pressure of 699.82 kPa (101.5 psi) gauge for the containment vessel was determined based on its stress capability before the ASME Code evaluations shown in DAC M900000-0002 and DAC-M900000-0003 were started. The containment vessel is tested with an internal pressure of 1034.21 kPa (150 psi) gauge or 1.48 times the design pressure, which exceeds the requirement stipulated in Sect. III, Paragraph NB-6221 (a minimum hydrostatic test pressure of 1.25 times the design pressure) and the regulatory requirement of 10 CFR 71.85(b) (1.5 times the maximum normal operating pressure). As shown in Table 2.6, the containment vessel design stresses are well below the allowable stresses (see Fig. 2.1 for stress locations). Therefore, this ES-3100 containment vessel is capable of shipping at a higher internal pressure. The external pressure requirement from 10 CFR 71.73(c)(6) is 150 kPa (21.7 psi) gauge. These design and operating pressures were used to calculate the stresses (DAC-M900000-0002 and DAC-M900000-0003) in all components of the containment vessel, which are well below the allowable limits at all operating conditions. The maximum normal operating pressure calculated for NCT in accordance with 10 CFR 71.4 and 10 CFR 71.71(c)(1) for the bounding load case is 210.29 kPa (30.50 psia). For conservatism and for use in subsequent analyses in Sects. 2 and 4 during NCT, the maximum gas temperature and the maximum normal operating pressure in the containment vessel are rounded up to 90°C (194°F) and 210.29 kPa (30.50 psia), respectively. The maximum internal gauge pressure calculated for NCT is 185.29 kPa (26.87 psi), which is the maximum normal operating pressure minus the reduced external pressure condition of 10 CFR 71.71(c)(3) [210.29−25.00 kPa] (Sect. 2.6.3). A summary of the package's design, NCT, and HAC pressures and temperatures is presented in Appendices 3.5.1 and 3.5.2. Allowable stress intensity limits and calculated stresses at the design evaluation conditions for the containment vessel are summarized in Tables 2.4–2.6. The stresses used in the design of all metal containment vessel components are in the elastic range of the material properties. For conditions addressed by analysis, the margin of safety (M.S.) is calculated and defined as:

$$\text{Margin of Safety} = \text{Allowable Stress} / \text{Actual Stress} - 1.$$

Table 2.3. Summary of load combinations for normal and hypothetical accident conditions of transport

Normal or accident condition	Applicable initial condition								Fabrication stresses	SARP reference
	Ambient temperature		Insolation		Decay heat		Internal pressure			
	38°C	-29°C	Max	0	Max	0	Max	Min		
Normal conditions (analyze separately)										
Hot environment (38°C ambient temperature)			X		X		X		X	Sect. 2.6.1
Cold environment (−40°C ambient temperature)				X		X		X	X	Sect. 2.6.2
Increased external pressure (20 psia)		X		X		X		X	X	Sect. 2.6.4
Minimum external pressure (3.5 psia)	X		X		X		X		X	Sect. 2.6.3
Vibration and shock:	X		X		X		X		X	Sect. 2.6.5 [a]
Normally incident to the mode of transport		X		X		X		X	X	
Free drop	X		X		X		X		X	Sect. 2.6.7[b]
1.2-m drop		X		X		X		X	X	
Compression test	X		X		X		X		X	Sect. 2.6.9 [a]
		X		X		X		X	X	
Penetration test	X		X		X		X		X	Sect. 2.6.10 [a]
		X		X		X		X	X	
Accident conditions (apply sequentially)										
Free drop: 9-m drop	X		X		X		X		X	Sect. 2.7.1 [c]
		X		X		X		X	X	
Crush: 9-m drop	X		X		X		X		X	Sect. 2.7.2 [c]
		X		X		X		X	X	
Puncture: 1-m drop onto bar	X		X		X		X		X	Sect. 2.7.3 [c]
		X		X		X		X	X	
Thermal: fire accident	X		X		X		X		X	Sect. 2.7.4

[a] This condition was conducted at room temperature with atmospheric pressure inside the containment vessel.

[b] This condition was conducted at ambient temperature at the time of the test except for Test Unit-2 (TU-2). The containment vessel was at atmospheric pressure except for TU-2. Justification for compliance with the environmental requirements of NRC Regulatory Guide 7.8 is provided in Sect. 2.6.

[c] This condition was conducted at ambient temperature at the time of the test except for TU-2. The containment vessel was at atmospheric pressure except for TU-2. Justification for compliance with the environmental requirements of NRC Regulatory Guide 7.8 is provided in Sect. 2.7.

Table 2.4. Containment vessel allowable stress

Stress category	Maximum allowable stress	
	Level A (NCT)	Level D (HAC)
Primary membrane stress intensity	S_m	Lesser of 2.4 S_m and 0.7 S_u
Primary membrane + primary bending stress intensity	1.5 S_m	Lesser of 3.6 S_m and S_u
Range of primary + secondary stress intensity	3.0 S_m	Not applicable
Fatigue stress range	S_a @ 10^6 cycles	< 2 S_a @ 10 cycles
Buckling	No buckling	No buckling

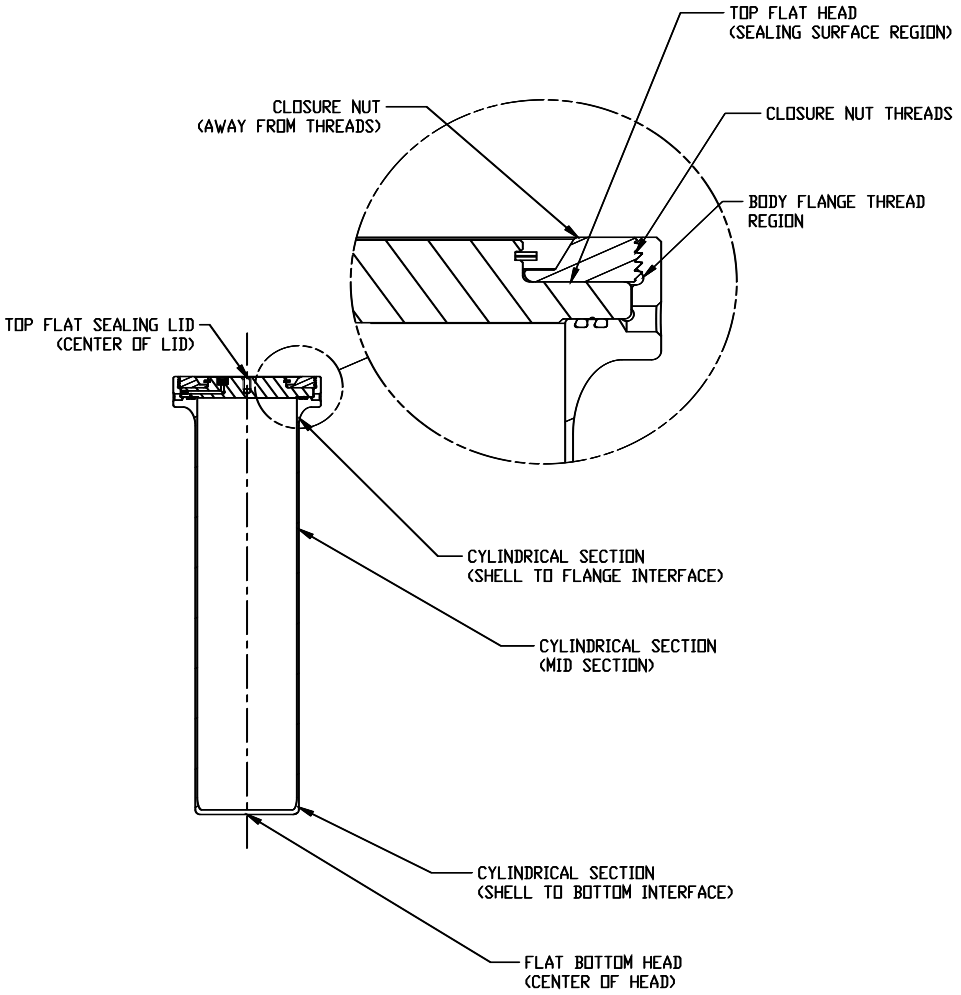


Fig. 2.1. Containment vessel calculated stress locations.

Table 2.5. Allowable stress intensity (S_m) for the containment vessel materials of construction

Description	Specification	S_m [a] (up to 148.9°C)	S_m [a, b] (up to 176.7°C)	S_m [a] (up to 204.44°C)
Pipe body (Method 1)	ASME SA-312 seamless pipe, Type TP304L stainless steel	1.151×10^5 kPa (16,700 psi)	1.120×10^5 kPa (16,250 psi)	1.083×10^5 kPa (15,800 psi)
Formed body, end cap, and flange (Method 2)	ASME SA-182, Type F304L stainless steel	1.151×10^5 kPa (16,700 psi)	1.120×10^5 kPa (16,250 psi)	1.083×10^5 kPa (15,800 psi)
Flange and end cap (Method 1)	ASME SA-182 forging, Type F304L stainless steel	1.151×10^5 kPa (16,700 psi)	1.120×10^5 kPa (16,250 psi)	1.083×10^5 kPa (15,800 psi)
Containment vessel sealing lid	ASME SA-479, Type 304 stainless steel	1.379×10^5 kPa (20,000 psi)	1.331×10^5 kPa (19,300 psi)	1.282×10^5 kPa (18,600 psi)
Containment vessel closure nut (as ASME SA-193 bolting)	ASME SA-479, UNS-S21800, Nitronic 60 stainless steel	7.584×10^4 kPa (11,000 psi)	7.205×10^4 kPa (10,450 psi)	6.826×10^4 kPa (9,900 psi)

[a] *ASME Boiler and Pressure Vessel Code*, Sect. II, Part D, Tables 2A and 4 at 148.9°C (300°F) and 204.44°C (400°F).
[b] The values shown at 176.7°C (350°F) have been interpolated.

Table 2.6. ES-3100 containment vessel design evaluation allowable stress comparisons

Stress locations shown in Fig. 2.1	Internal pressure design evaluation containment boundary stress [a] @ 699.82 kPa (101.5 psi) gauge		External pressure design evaluation containment boundary stress [a] @ −149.62 kPa (−21.7 psi) gauge		Allowable pressure, stress, or shear capacity [a]
	kPa (psi) or kg (lb)	M.S. [b]	kPa (psi) or kg (lb)	M.S. [b]	kPa (psi) or kg (lb)
Top flat portion of sealing lid (center of lid)	1.142×10^4 (1656)	18	2.441×10^3 (354)	82	1.999×10^5 (29,000) [c]
Closure nut ring (away from threaded portion)	3.420×10^4 (4960)	3.2	1.902×10^4 (2759) [d]	5.7	1.081×10^5 (15,675) [c]
Top flat head (sealing surface region)	2.897×10^4 (4202)	6.9	7.087×10^3 (1028) [d]	28	1.999×10^5 (29,000) [c]
Cylindrical section (middle) internal pressure	1.948×10^4 (2825)	5.8			1.120×10^5 (16,250) [e]
Cylindrical section (middle) external pressure			1.496×10^2 (21.7)	5.1	7.584×10^2 (110) [f]
Cylindrical section (shell-to-flange interface)	2.697×10^4 (3912)	6.2	5.766×10^3 (836)	29	1.682×10^5 (24,400) [c]
Cylindrical section (shell-to-bottom interface)	5.856×10^4 (8493)	2.9	1.252×10^4 (1816)	13	1.682×10^5 (24,400) [c]
Body flange thread load, kg (lb)	1.696×10^3 (3740)	15	9.072×10^2 (2000) [d]	29	2.608×10^4 (57,500) [g]
Body flange thread region (under cut region)	5.689×10^4 (8251)	3.0	2.839×10^4 (4117) [d]	5.9	1.682×10^5 (24,400) [c]
Flat bottom head (center)	4.895×10^4 (7100)	3.4	1.047×10^4 (1518)	16	1.682×10^5 (24,400) [c]
Closure nut thread load, kg (lb)	1.696×10^3 (3740)	20	9.072×10^2 (2000) [d]	37	3.353×10^4 (73,911) [g]

[a] Stresses are calculated using pressures, gasket and closure nut preload, and nominal dimensions for all containment vessel components (DAC-M900000-0003). Calculated stresses for external pressure were determined by multiplying the stress at the design conditions by a factor equal to the ratio of external pressure to design pressure plus the contribution from preload. Allowable stress values are taken from Table 2.5 up to 176.7°C (350°F).

[b] Margin of safety = allowable stress/actual stress.

[c] Stress interpreted as the sum of $P_l + P_b$; allowable stress intensity value is $1.5 \times S_m$.

[d] Stress and shear load in these areas is dominated by the 162.7 ± 6.8 N·m (120 ± 5 ft-lb) preload. Pressure ignored.

[e] Stress interpreted as the primary membrane stress (P_m); allowable stress intensity value is S_m.

[f] Allowable external pressure [kPa (psi)].

[g] Allowable shear capacity is defined as $0.6 \times S_m \times$ thread shear area for the body material. Thread shear area = 38.026 cm^2 (5.894 $in.^2$). Allowable shear capacity is defined as $1.2 \times S_m \times$ thread shear area for the closure nut material.

In NRC Regulatory Guide 7.11, below Table 1, the following quote is found: "Although NUREG/CR-1815 (Ref. 2) addresses the use of ferritic steels only, it does not preclude the use of austenitic stainless steels. Since austenitic stainless steels are not susceptible to brittle failure at temperatures encountered in transport, their use in containment vessels is acceptable to the staff and no tests are needed to demonstrate resistance to brittle failure." According to NRC Regulatory Guide 7.11, because the containment vessel is manufactured from Type 304L stainless steel (which is an austenitic stainless steel), "no tests are needed to demonstrate resistance to brittle failure." Therefore, brittle or fatigue failures are not anticipated under any design, transport, accident, or storage condition (Sects. 2.6 and 2.7). Material specifications for the ES-3100 packaging components are listed in Table 2.7.

Table 2.7. ES-3100 packaging material specifications

Component	Specifications
	Drum assembly
Drum washers	1.375 OD × 0.812 ID × 0.25 in. thick, 300 Series stainless steel
Drum threaded weld studs	5/8-11 × 7/8 long, ARC FT, Type 304 or 304L stainless-steel studs
Drum hex nuts	⅝-11 UNC-2B, silicon bronze C65100
Drum lid weldment	Modified 30-gal, 16-gauge (MS27683) lid, Type 304 or 304L stainless steel; and an 11-gauge-thick sheet, Type 304 or 304L stainless steel, ASME SA-240
Drum weldment	Modified 30-gal, 16-gauge (MS27683), Type 304 or 304L stainless steel, ASME SA-240, manufactured per Drawing M2E801580A004 (Appendix 1.3.7)
Drum plugs	Nylon plastic plug, Micro Plastic, Inc.
	Impact limiter, insulation enclosure, neutron absorber, and drum packing material
Insulation and impact limiter (not removable)	Lightweight cast refractory insulation, Kaolite 1600 or Packcrete, 358.8 ± 48.1 kg/m^3 (22.4 ± 3 lb/ft^3) density, cast in stainless-steel shells in the drum and top plug
Neutron absorber	Cat 277-4, 1681.9 + 240.3/−80.1 kg/m^3 (105 + 15/−5 lb/ft^3) density
Top plug (removable)	Type 304 or 304L stainless steel, ASME SA-240 (body), ASME SA-479 (lifting inserts)
Inner liners	Type 304 or 304L stainless steel, ASME SA-240 (body), ASME SA-479 (modified angle)
Silicone pads	Silicone rubber, 22 ± 5 Shore A, color black/gray
Aluminum foil duct tape	McMaster Carr Part # 7616A21, temperature range −40 to 121°C (−40 to 250°F)
	Containment vessel
Containment vessel plug	Part # 04-2126, Modified VCO threaded plug with O-ring, brass
Containment vessel hoist ring	3052T56, Swivel hoist ring, alloy steel (not used for shipment)
Containment vessel	Method 1: Type TP304L stainless steel ASME SA-312 (seamless pipe body); Type F304L, stainless steel, ASME SA-182 (flange and end cap); Type 304, stainless steel, ASME SA-479 (sealing lid), Nitronic 60 stainless steel per ASME SA-479, UNS-S21800 (closure nut) Method 2: Type F304L stainless-steel ASME SA-182 (body, flange, and end cap); Type 304, stainless steel, ASME SA-479 (sealing lid), Nitronic 60 stainless steel per ASME SA-479, UNS-S21800 (closure nut) All components per *ASME Boiler and Pressure Vessel Code*, Sect. II, Part D, Table 2A

Table 2.7. ES-3100 packaging material specifications

Component	Specifications
Containment vessel O-rings	Elastomer, ethylene propylene diene monomer, Specification M3BA712A14B13F17 in ASTM D 2000 per SPC M801580-0002 (Appendix 1.3.9)
Containment vessel lid assembly retaining ring	Smalley Steel Ring Co., Part #WSM-400-S02, Type 302 stainless steel
Containment vessel O-ring lubricant	Clear dimethyl siloxane polymer
Containment vessel closure nut lubricant	Krytox #240AC
Containment vessel body dowel pins	0.2501/0.2503-in. OD × 0.50-in. long, 18-8 stainless steel
	Containment vessel packing material
Convenience cans	Stainless steel, aluminum, or tinned carbon steel with stainless-steel can handles and nylon-coated stainless-steel wire; nickel-alloy (200 series, passivated) in nylon mesh bag
Convenience bottles	Polyethylene, glass, or Teflon FEP
Silicone rubber pads	Silicone rubber, 22 ± 5 Shore A, color black/gray
Can spacers	Stainless-steel can filled with Cat 277-4
Bagging	Polyethylene, nylon, and Teflon
Metal scouring scrubbers	Stainless steel, McMaster Carr Part #7361T13

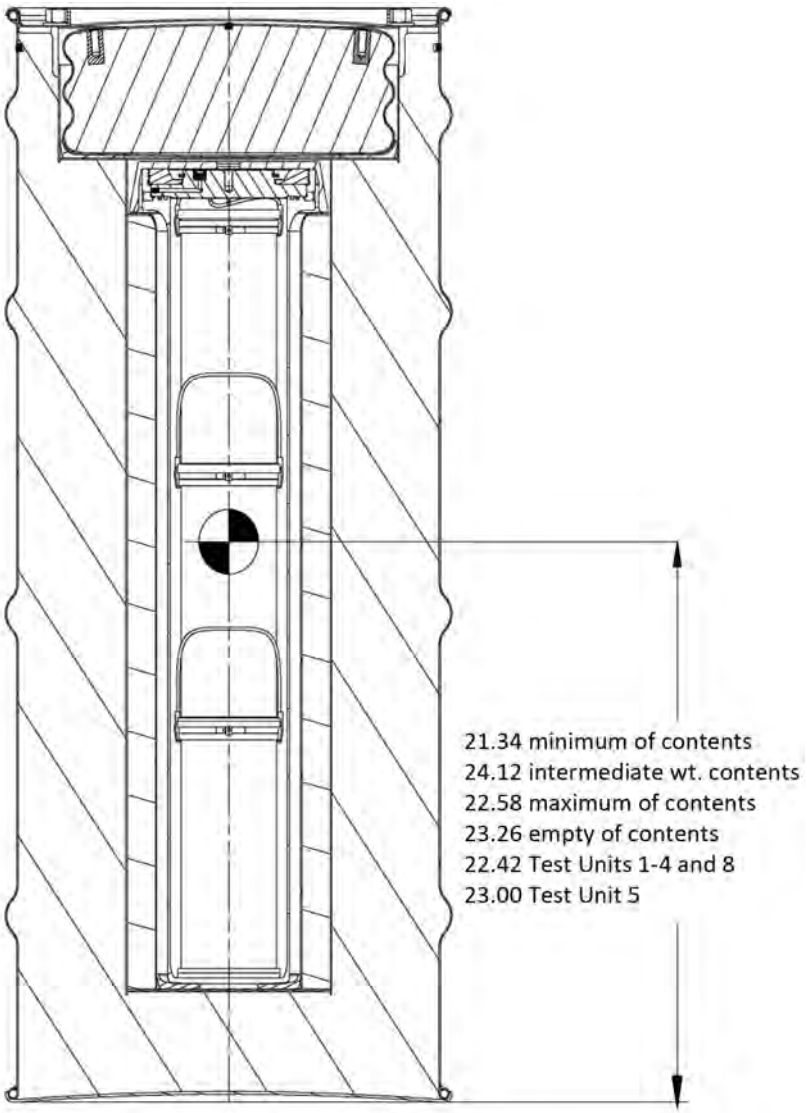
2.1.3 Weights and Centers of Gravity

The weights of the packaging components for the actual proposed contents ready for shipment and the test units are provided in Tables 2.8 and 2.9. The values listed for the test weights are the actual data recorded during compliance testing. The remaining weights listed for the shipping package are calculated weights. Nominal dimensions and densities were used in the calculations. Miscellaneous parts (nuts and washers) are included.

The range of the centers of gravity for the ES-3100 shipping package with the various HEU arrangements and the test packages is shown in Fig. 2.2. A summary of the calculations is provided in Table 2.10.

2.1.4 Identification of Codes and Standards for Package Design

Based on the discussion in Sect. 2.1.2, the shipping package has been designed and analyzed and will be fabricated, tested and maintained to the requirements of a Category I package. In accordance with the references from NUREG/CR-1815, Table 2.11 describes the appropriate codes and standards that are and will be used to comply with Category I packaging. These requirements have been extracted from NUREG/CR-3854 and NUREG/CR-3019.



Note: Dimensions are in inches.

Fig. 2.2. ES-3100 shipping package center of gravity locations.

Table 2.8. Packaging weights for various ES-3100 shipping package arrangements

Item [a, b]	Three 10-in. tall can configuration [kg (lb)] [c, d]	Six 4.875-in. tall can configuration [kg (lb)]	Five 4.875-in. tall can configuration [kg (lb)]	Six 4.75-in. tall can configuration [kg (lb)]	Three 8.75-in. tall can configuration [kg (lb)] [e]	Three 8.7-in. tall bottle configuration [kg (lb)]	Three 9.4-in. tall bottle configuration [kg (lb)]	Empty containment vessel configuration [kg (lb)]	ES-3100 with maximum weight contents [kg (lb)]
Drum assembly									
Drum assembly (drum body, lid, bottom, mid liner, inner liner, cast refractory insulation, cast neutron absorber, nuts, washers, and data plates) [f]	121.96 (268.87)	121.96 (268.87)	121.96 (268.87)	121.96 (268.87)	121.96 (268.87)	121.96 (268.87)	121.96 (268.87)	121.84 (268.61)	121.96 (268.87)
Top plug	8.9 (19.6)	8.9 (19.6)	8.9 (19.6)	8.9 (19.6)	8.9 (19.6)	8.9 (19.6)	8.9 (19.6)	8.9 (19.6)	8.9 (19.6)
Silicone support pads	1.04 (2.29)	1.04 (2.29)	1.04 (2.29)	1.04 (2.29)	1.04 (2.29)	1.04 (2.29)	1.04 (2.29)	1.04 (2.29)	1.04 (2.29)
Total drum assembly weight	**131.89 (290.76)**	**131.89 (290.76)**	**131.89 (290.76)**	**131.89 (290.76)**	**131.89 (290.76)**	**131.89 (290.76)**	**131.89 (290.76)**	**131.78 (290.50)**	**131.89 (290.76)**
Containment vessel									
Containment vessel (flange, dowel pins, cylindrical body, and end cap)	10.18 (22.44)	10.18 (22.44)	10.18 (22.44)	10.18 (22.44)	10.18 (22.44)	10.18 (22.44)	10.18 (22.44)	10.18 (22.44)	10.18 (22.44)
Lid assembly (sealing lid, VCO plug, retaining ring, closure nut and O-rings)	4.92 (10.85)	4.92 (10.85)	4.92 (10.85)	4.92 (10.85)	4.92 (10.85)	4.92 (10.85)	4.92 (10.85)	4.92 (10.85)	4.92 (10.85)
Total containment vessel weight	**15.10 (33.29)**	**15.10 (33.29)**	**15.10 (33.29)**	**15.10 (33.29)**	**15.10 (33.29)**	**15.10 (33.29)**	**15.10 (33.29)**	**15.10 (33.29)**	**15.10 (33.29)**

Table 2.8. Packaging weights for various ES-3100 shipping package arrangements

Item [a, b]	Three 10-in. tall can configuration [kg (lb)] [c, d]	Six 4.875-in. tall can configuration [kg (lb)]	Five 4.875-in. tall can configuration [kg (lb)]	Six 4.75-in. tall can configuration [kg (lb)]	Three 8.75-in. tall can configuration [kg (lb)] [e]	Three 8.7-in. tall bottle configuration [kg (lb)]	Three 9.4-in. tall bottle configuration [kg (lb)]	Empty containment vessel configuration [kg (lb)]	ES-3100 with maximum weight contents [kg (lb)]
				Contents					
Convenience cans with handles	0.72 (1.59)	1.0 (2.22)	0.84 (1.85)	--	0.67 (1.47)	--	--	--	--
Silicone vibration pads	0.11 (0.23)	0.l8 (0.41)	0.16 (0.353)	--	0.11 (0.23)	--	--	--	--
Nickel cans	--	--	--	1.84 (4.07)	--	--	--	--	--
Polyethylene bottles	--	--	--	--	--	0.345 (0.76)	--	--	--
Teflon FEP bottles	--	--	--	--	--	--	0.99 (2.18)	--	--
Spacers with handles	--	--	1.88 (4.14)	--	1.25 (2.76)	--	--	--	--
Polyethylene, nylon, or Teflon bagging or lifting sling	0.5 (1.10)	0.5 (1.10)	0.5 (1.10)	0.5 (1.10)	0.5 (1.10)	0.155 (0.34)	0.50 (1.10)	--	--
Metal scouring pads	--	--	--	--	0.14 (0.30)	--	--	--	--
HEU or HEU/Alloy content	35.2 (77.60)	35.2 (77.60)	35.2 (77.60)	24 (52.91)	35.2 (77.60)	24.0 (52.91)	24.0 (52.91)	--	--
Total proposed content weight	**36.52 (80.52)**	**36.89 (81.33)**	**38.57 (85.04)**	**26.34 (58.08)**	**37.86 (83.46)**	**24.50 (54.01)**	**25.49 (56.19)**	**0**	**40.82 (90)**
Total shipping package weight	**183.51 (404.57)**	**183.88 (405.38)**	**185.56 (409.09)**	**173.33 (382.13)**	**184.84 (407.51)**	**171.49 (378.07)**	**172.47 (380.24)**	**146.88 (323.79)**	**187.81 (414.05)**

[a] Calculated weight using Pro/ENGINEER software with nominal dimensions and densities.
[b] Shipping weight increases by ~2.5 lb if a radio-frequency identification tag is included.
[c] The weight of this configuration bounds the weight of the bundled fuel rods, tubes, or plates with open-ended cans on either end.
[d] The weight of this configuration bounds the weight of the three 25.4-cm (10-in.)–high cans brazed together containing fuel rods, tubes, or plates.
[e] The weight of this configuration bounds the weight of the two 22.2-cm (8.75-in.)–high cans that are brazed together containing the TRIGA fuel elements.
[f] Weight excluding tamper indicating device.

Table 2.9. Compliance test unit weights

Item	Test Unit [a] [kg (lb)]						
	1	**2**	**3**	**4**	**5**	**6**	**8**
Drum body assembly [b]	126.6 (279)	127.9 (282)	127.9 (282)	127.9 (282)	128.8 (284)	--	128.4 (283)
Top plug	9.5 (21)	9.5 (21)	9.53 (21)	8.6 (19)	9.5 (21)	--	10.9 (24)
Drum silicone support pads	0.9 (2)	0.9 (2)	0.9 (2)	0.5 (1)	0.9 (2)	--	1.3 (2.8)
Containment vessel [c]	15.4 (34)	15.0 (33)	15.0 (33)	14.5 (32)	15.0 (33)	15.0 (33)	14.5 (32)
Mock-up test contents [d]	49.9 (110)	49.9 (110)	50.3 (111)	49.9 (110)	3.6 (8)		49.9 (110)
Contents						6.3 (14) [e]	
Total test unit weight	**202.3 (446)**	**202.8 (447)**	**203.7 (449)**	**201.8 (445)**	**157.4 (347)**	**21.3 (47)**	**204.6 (451)**

[a] Total weight may be different from sum of individual component weights due to scale tolerance of ±0.45 kg (1 lb).
[b] This weight includes the drum, mid liner, inner liner, cast refractory, cast neutron absorber, bottom, lid, washers and nuts.
[c] This weight includes containment vessel cylindrical body, end cap, flanged top, and lid assembly.
[d] This weight includes convenience cans, silicone rubber pads, can handles, spacers (if required), and HEU mockup.
[e] This weight was added to reduce buoyancy of containment vessel during 15-m (50-ft) immersion test.

2.2 MATERIALS

2.2.1 Material Properties and Specifications

The mechanical properties and specifications of the packaging materials are presented in Tables 2.12–2.17. See the drawings in Appendix 1.3.7 for details of all components. Design temperature ranges are listed where they are required to establish the allowable stresses used in the design calculations for the containment vessel (DAC-M900000-0002 and DAC-M900000-0003). Service temperature ranges for the remaining shipping container components were obtained from the references shown in Tables 2.12–2.17.

Kaolite 1600 property values are presented in Table 2.14, and additional Kaolite property and source information is presented in the Kaolite material safety data sheet, ORNL-TM-2003/49, Y/DW-1890, Y/LF-565, and the e-mail communication from Moody to Bales (Moody 2004). Packcrete material properties are presented in RP 802282-0002. ORNL/TM-2004/290, Y/DW-1987, Y/DZ-2585, COR-NDA-04-93, and Y/DV-1914 contain the Cat 277-4 property and source information. Y/DW-1968 contains detailed technical data on strength and thermal expansion of BoroBond4. (BoroBond4 was used in the prototype test units, but it is not used in the package to be certified.)

2.2.2 Chemical, Galvanic, or Other Reactions

A package must be of materials and construction to ensure that there will be no significant chemical, galvanic, or other reaction among the packaging components, among package contents, or between the packaging components and the package contents, including a possible reaction resulting from inleakage of water, to the maximum credible extent. Account must be taken for the behavior of materials under irradiation.

Table 2.10. Calculated center of gravity for the various ES-3100 shipping arrangements

Content description	Distance from drum's bottom (in.)
Cylinders, bars, slugs, broken metal—35,200 g (77.60 lb) maximum—no can spacers	
3 full 4.88-in. cans + 3 empty 4.88-in. cans	21.139
2 full 4.88-in. cans + 4 empty 4.88-in. cans	21.405
1 full 4.88-in. can + 5 empty 4.88-in. cans	22.066
3 full 10-in. cans	22.071
2 full 10-in. cans + 1 empty 10-in. can	21.762
1 full 10-in. can + 2 empty 10-in. cans	22.075
3 full 8.75-in. cans	21.875
2 full 8.75-in. cans + 1 empty 8.75-in. can	21.662
1 full 8.75-in. can + 2 empty 8.75-in. cans	22.060
Cylinders, bars, slugs, broken metal—35,200 g (77.60 lb) maximum—with can spacers	
3 full 8.75-in. cans + 2 spacers	22.245
2 full 8.75-in. cans + 1 empty 8.75-in. can + 2 spacers	21.802
1 full 8.75-in. can + 2 empty 8.75-in. cans + 2 spacers	22.072
3 full 4.88-in. cans + 2 empty 4.88-in. cans + 3 spacers	21.471
2 full 4.88-in. cans + 3 empty 4.88-in. cans + 3 spacers	21.500
1 full 4.88-in. can + 4 empty 4.88-in. cans + 3 spacers	22.028
UNX crystals 24,000 g (52.91 lb) maximum—with no spacers	
3 full 8.94-in.–high Teflon FEP bottles + bagging	22.674
2 full 8.94-in.–high Teflon FEP bottles + 1 empty 8.94-in.–high Teflon FEP bottle + bagging	22.383
1 full 8.94-in.–high Teflon FEP bottle + 2 empty 8.94-in.–high Teflon FEP bottles + bagging	22.543
Oxide—24,000 g (52.91 lb) maximum—with no spacers	
6 full 4.75-in.–high nickel cans + bagging	22.631
5 full 4.75-in.–high nickel cans + 1 empty 4.75-in.–high nickel can + bagging	22.434
4 full 4.75-in.–high nickel cans + 2 empty 4.75-in.–high nickel cans + bagging	22.343
3 full 4.75-in.–high nickel cans + 3 empty 4.75-in.–high nickel cans + bagging	22.366
2 full 4.75-in.–high nickel cans + 4 empty 4.75-in.–high nickel cans + bagging	22.511
1 full 4.75-in.–high nickel can + 5 empty 4.75-in.–high nickel cans + bagging	22.787
Oxide—24,000 g (52.91 lb) maximum—with no spacers	
3 full 8.7-in.–high polyethylene bottles + bagging	22.372
2 full 8.7-in.–high polyethylene bottles + 1 empty 8.7-in.–high polyethylene bottle + bagging	22.210
1 full 8.7-in.–high polyethylene bottle + 2 empty 8.7-in.–high polyethylene bottles + bagging	22.480

Table 2.11. Applicable codes and standards for Category I packaging

	Containment *ASME Boiler and Pressure Vessel Code*, Sect. III, Subsection NB	Criticality [a]
Materials		Cat 277-4 [a]
Base materials	NB-2000 (except NB-2300) and NB-4100	
Welding materials	NB-2400	
Fabrication		
Forming, fitting, aligning, and joint preparation	NB-4200	
Welding	NB-4400	
Qualification of procedures and personnel	NB-4300	
Examination	NB-5000	[b]
Acceptance testing	NB-6000	[c]
Quality assurance	Subpart H in Title 10, CFR, Part 71	

[a] NUREG/CR-3854 states, "The designer may specify a neutron-absorber material by a commercial trade name or as a mixture of elements or common compounds. When appropriate, qualification data should be included to demonstrate that the material functions as specified. When special absorber materials are used to control criticality, an acceptance test should be performed for each container to ensure that the absorber material has been properly installed."

[b] NUREG/CR-3854 states, "Packages designed to transport fissile material which contain neutron-absorber material should be tested to demonstrate the presence of the neutron-absorber material. The test description should include information similar to that requested for gamma shield testing 3.2.1. Fabrication records of the absorber material and its installation and testing should be maintained."

[c] NUREG/CR-3854 states, "Gamma scanning or probing may be used to demonstrate the soundness of the neutron absorber. Alternatively, ultrasonic testing may be used. Whatever method is used, the following information should be provided in the test procedure:

(1) Description of the measuring technique including the electronics;
(2) The source type and strength used to measure the neutron absorber effectiveness;
(3) The standards and methods used to calibrate the source, sensors, and other pertinent equipment;
(4) The grid pattern used to check the neutron absorber;
(5) The type of gamma sensor used to measure the neutron absorber effectiveness;
(6) The specific test requirements and measurements;
(7) The acceptance criteria."

Table 2.12. Mechanical properties of the metallic components of the drum assembly

Drum, bottom cover, and lid	ASME SA-240, Type 304 or 304L, stainless-steel plate	
Inner liners	ASME SA-240, Type 304 or 304L, stainless-steel plate	
Top plug weldment	ASME SA-240, Type 304 or 304L, stainless-steel plate	
Materials of construction [a]	ASME SA-240, Type 304	ASME SA-240, Type 304L
Allowable stress, MPa (ksi) at:		
−40°C (−40°F)	137.9 (20)	115.1 (16.7)
37.78°C (100°F)	137.9 (20)	115.1 (16.7)
93.33°C (200°F)	115.1 (16.7)	115.1 (16.7)
148.89°C (300°F)	103.4 (15.0)	115.1 (16.7)
Ultimate strength, MPa (ksi) at:		
−40°C (−40°F)	517.1 (75)	482.6 (70)
37.78°C (100°F)	517.1 (75)	482.6 (70)
93.33°C (200°F)	489.5 (71)	455.7 (66.1)
148.89°C (300°F)	456.4 (66.2)	422.0 (61.2)
Yield strength, MPa (ksi) at:		
−40°C (−40°F)	206.8 (30)	172.4 (25)
37.78°C (100°F)	206.8 (30)	172.4 (25)
93.33°C (200°F)	172.4 (25)	147.5 (21.4)
148.89°C (300°F)	154.4 (22.4)	132.4 (19.2)
Elongation in 5.08 cm (2 in.) (%)	40 [b]	40 [b]
Coefficient of thermal expansion, cm/cm/°C (in./in./°F) at:		
−40°C (−40°F)[c]	0.00001476 (0.0000082)[c]	0.00001476 (0.0000082)[c]
37.78°C (100°F)	0.00001548 (0.0000086)	0.00001548 (0.0000086)
93.33°C (200°F)	0.00001602 (0.0000089)	0.00001602 (0.0000089)
148.89°C (300°F)	0.00001656 (0.0000092)	0.00001656 (0.0000092)
Modulus of elasticity, GPa (Mpsi) at:		
−40°C (−40°F)	197.2 (28.6)	197.2 (28.6)
37.78°C (100°F)	194.0 (28.14)	194.0 (28.14)
93.33°C (200°F)	190.3 (27.6)	190.3 (27.6)
148.89°C (300°F)	186.2 (27.0)	186.2 (27.0)

[a] *ASME Boiler and Pressure Vessel Code*, Sect. II, Part D, Subpart 1, Tables 1A, U, and Y-1; and Subpart 2, Tables TE-1, Column B, and TM-1.
[b] *ASME Boiler and Pressure Vessel Code*, Sect. II, Part A, for ASME SA-240 material.
[c] MIL-HDBK-5H.

Table 2.13. Mechanical properties of the lid fastening components for the drum assembly

Drum weld studs	Specification
Material	ASTM A 493 Type 304/304L stainless steel
Fabrication standard	ASTM F 593
Service temperature range, °C (°F)	−40 to 816 (−40 to 1500) [a]
Maximum allowable stress, S, MPa (ksi) at temperature [a]	
−29°C to 38°C (−20 to 100°F)	129.6 (18.8)
93.3°C (200°F)	115.1 (16.7)
148.9°C (300°F)	103.4 (15.0)
Coefficient of thermal expansion, cm/cm/°C (in./in./°F) [a]	
21.1°C (70°F)	1.53×10^{-5} (8.5×10^{-6})
93.3°C (200°F)	1.60×10^{-5} (8.9×10^{-6})
148.9°C (300°F)	1.66×10^{-5} (9.2×10^{-6})
Drum hex-head nuts	**Specification**
Material	silicon bronze
Fabrication standard	ASTM F 467
UNS designation	C65100 [b]
Minimum proof stress, MPa (ksi)	485 (70) [b]
Drum washer	**Specification**
Drum	1.375-in. OD × 0.812-in. ID × 0.25 in. thick, Series 300 stainless steel

[a] *ASME Boiler and Pressure Vessel Code*, Sect. II, Part D, Subpart 1, Table 3; and Subpart 2, Table TE-1, Group 3, B value.
[b] ASTM F 467.

Table 2.14. Mechanical properties of the cast refractory insulation

Material composition	Cast refractory, Kaolite 1600 [a]	Cast refractory, Packcrete [b]
Flexural tensile strength, kPa (psi) Standard deviation, kPa (psi)	133 (19.4) [c] 32 (4.7) [c]	– –
Average coefficient of thermal expansion, cm/cm/°C (in./in./°F)	9.07×10^{-6} (5.04×10^{-6}) [d]	– [e]
Average modulus of rupture per ASTM C 133, kPa (psi)	258.6 (37.5) [f]	–
Normal operating temperature, °C (°F)	−40 to 871 (−40 to 1600) [f]	−40 to 871 (−40 to 1600) [f]
Density after curing, kg/m^3 (lb/ft^3)	358.8 (22.4) [f]	358.8 (22.4) [e]
Force/deflection curves	– [g]	– [e]

[a] JS-YMN3-801580-A002 (Appendix 1.3.4)
[b] SPC M801794-0003 (Appendix 1.3.11) and SPC M801580-0003 (Appendix 1.3.12).
[c] Y/DW-1661.
[d] Moody 2004.
[e] RP 802282-0002.
[f] Thermal Ceramics, 1999.
[g] Y/DW-1972 and Y/DW-1890.

Table 2.15. Mechanical properties of containment vessel O-rings

Ethylene propylene diene monomer	
Specification	ASTM D 2000, M3BA712A14B13F17 [a, b]
Normal service temperature range, °C (°F)	−40 to 150 (−40 to 302) [b, c]
Permissible exposure time at 150°C (302°F), h	1000 [c]
Hardness durometer, Shore A	70 ± 5 [b]
Minimum elongation, %	100 [b]
Fabrication method	Molded [b]

[a] ASTM D 2000.
[b] SPC M801580-0002 (Appendix 1.3.9).
[c] *Parker O-Ring Handbook*, Sect. 2.13.2 and Fig. 2-28, p. 2-27.

Table 2.16. Mechanical properties of the metallic components of the containment vessel

Containment vessel: body, flange, and seal lid	Specification
Material of construction: stainless steel, Type 304L	ASME SA-312 (pipe); ASME SA-182 (flange, formed body, or end cap); ASME SA-479 (seal lid)
Design temperature range, °C (°F)	−40 to 176.67 (−40 to 350)
Minimum ultimate strength, MPa (ksi)	482.6 (70) [a]
Yield strength, 0.2% offset, MPa (ksi) at temperature	
37.8°C (100°F)	172 (25) [a]
149°C (300°F)	132 (19.2) [b]
176.67°C (350°F)	126.52 (18.35) [b]
204.44°C (400°F)	120.66 (17.5)
Elongation in 5.08 cm (2 in.), %	30 [c]
Modulus of elasticity, GPa (Mpsi) at temperature [b]	
−40°C (−40°F)	197.2 (28.60)
37.78°C (100°F)	194.0 (28.14)
93.33°C (200°F)	190.3 (27.60)
121.11°C (250°F)	188.2 (27.30)
148.89°C (300°F)	186.2 (27.00)
176.67°C (350°F)	184.4 (26.75)
204.44°C (400°F)	182.71 (26.50)
Allowable stresses (S_m)[d] at temperature	
Welded pipe, MPa (ksi)	
149°C (300°F)	115.14 (16.7)
176.67°C (350°F)	112.03 (16.25)
204.44°C (400°F)	108.94 (15.80)
Forged flanges, lids, end caps, MPa (ksi)	
at 149°C (300°F)	115.14 (16.7)
176.67°C (350°F)	112.03 (16.25)
204.44°C (400°F)	108.94 (15.80)
Coefficient of thermal expansion, cm/cm/°C (in./in./°F) at temperature [e]	
−40°C (−40°F)	0.00001476 (0.00000820)
37.78°C (100°F)	0.00001548 (0.00000860)
93.33°C (200°F)	0.00001602 (0.00000890)
121.11°C (250°F)	0.00001638 (0.00000910)
148.89°C (300°F)	0.00001656 (0.00000920)
176.67°C (350°F)	0.00001674 (0.00000930)
204.44°C (400°F)	0.00001710 (0.00000950)
Containment vessel closure nut	**Specification**
Material of construction	Nitronic 60, UNS-S21800
Elongation, %	10–12 [f]
Design temperature range, °C (°F)	−40 to 204.44 (−40 to 400)
Ultimate strength, MPa (ksi), room temperature	1655–1813 (240–263) [f]
Yield strength, 0.2% offset, MPa (ksi), room temperature	1344–1496 (195 − 217) [f]
Coefficient of thermal expansion, cm/cm/°C (in./in./°F) at temperatures [e]	
93.33°C (200°F)	0.0000158 (0.0000088)
204.40°C (400°F)	0.00001660 (0.0000092)

[a] Listed in the appropriate material specification identified under materials of construction.
[b] *ASME Boiler and Pressure Vessel Code,* Sect. II, Part D, Tables Y-1 and TM-1.
[c] *ASME Boiler and Pressure Vessel Code*, Sect. II, Part A for ASME SA-312, SA-182, or SA-479 material.
[d] *ASME Boiler and Pressure Vessel Code,* Sect. II, Part D, Table 2A.
[e] *ASME Boiler and Pressure Vessel Code*, Sect. II, Part D, Subpart 2, Table TE-1, Column B, except that −40°C is from MIL-HDBK-5H, Table 2.7.1.0.
[f] Value presented in ARMCO NITRONIC 60 Stainless Steel Product Data Bulletin, S-56b.

Table 2.17. Mechanical properties of the cast neutron absorber

Material	Cat 277-4
Service temperature range, °C (°F)	−40 to 150 (−40 to 302)
Modulus of elasticity in tension, GPa (Mpsi) at temperatures [a]	
−40°C (−40°F)	13.72 (1.991)
21.11°C (70°F)	4.72 (0.684)
37.78°C (100°F)	2.78 (0.403)
Coefficient of thermal expansion, cm/cm/°C (in./in./°F) at temperatures [b]	
−40°C (−40°F)	12.700×10^{-6} (7.056×10^{-6})
−20°C (−4°F)	13.000×10^{-6} (7.222×10^{-6})
0°C (32°F)	13.000×10^{-6} (7.222×10^{-6})
40°C (104°F)	12.600×10^{-6} (7.000×10^{-6})
60°C (140°F)	11.599×10^{-6} (6.444×10^{-6})
80°C (176°F)	10.400×10^{-6} (5.778×10^{-6})
100°C (212°F)	9.700×10^{-6} (5.389×10^{-6})
120°C (248°F)	9.101×10^{-6} (5.056×10^{-6})
Poisson's ratio	
−40°C (−40°F)	0.33 [a]
21.11°C (70°F)	0.28
37.78°C (100°F)	0.25
Density, g/cm^3 (lb/in.^{3})	1.682 (0.0608)

[a] Y/DW-1987.
[b] ORNL/TM-2004/290.

Analysis. Starting with the outer components, the packaging consists of the drum (austenitic Type 304 stainless steel), weld studs (austenitic stainless steel), nuts (silicon bronze), insulation (cast refractory), neutron absorber (Cat 277-4), silicone support pads, containment vessel (austenitic Type 304L stainless steel), closure nut (Nitronic 60), silicone support pads, can spacers (stainless steel and Cat 277-4), stainless-steel scrubbers, convenience cans (stainless steel, tin-plated carbon steel, aluminum, or nickel-alloy [series 200, passivated]), polyethylene or Teflon FEP bottles, glass bottles inside convenience can, polyethylene, nylon, or Teflon bags, and the HEU contents.

The cast refractory insulation (Kaolite 1600 – original design) is contained between the drum and mid-liner and within the top plug assembly's stainless-steel sheet metal. Due to the alkaline nature of this material, greater permanence of the surrounding structure is assured. Also, this material has been used successfully for years as an insulation heat treatment liner adjacent to metal surfaces of furnaces. Since the Packcrete cast refractory insulation is fabricated from the same base materials as Kaolite 1600 and is located in the same locations, the same nonreactive condition with metals is expected.

The cast neutron absorber (Cat 277-4) is contained between the most inward liner and mid-liner. During the casting process, the chlorine content is limited to 100 parts per million. The small quantity of chlorine will not affect the stainless-steel liners.

The nuts used to attach the drum to the lid are silicon bronze. All other metal components of the packaging are stainless steel, Nitronic 60, or tinned steel. All stainless-steel components are passivated per ASTM A 380, Paragraph 6.4, and Table A2.1, Part II. Prior to assembly, the packaging will be kept inside a building or transported between buildings in an enclosed truck. The assembled components are protected from the weather and inspected at the time of packaging; therefore, the package will not contain any free water (other than absorbed water in the encapsulated Kaolite or Packcrete) at the time it

is loaded for transport. Under NCT, the only moisture present will be the relative humidity or moisture absorbed by the cast refractory or neutron-absorber materials. When the package is subjected to a water-spray type environment, some water may leak into the cavity formed by the inner liner and occupied by the containment vessel. To minimize the possibility of any potentially corrosive situation, a visual examination of the interior surface of the inner liner and the exterior surface of the containment vessel shall be conducted prior to packing and following transport of the shipping package (see Chap. 7). Any free water present and any corrosion discovered shall be promptly removed.

The ES-3100 containment vessel is fabricated from ASME SA-182, Type 304L stainless steel that is solution annealed and quenched, cleaned, and passivated (JS-YMN3-801580-A001, Appendix 1.3.3). This low carbon (<0.03 wt % carbon) grade of austenitic stainless steel is more resistant to the precipitation of chromium carbide precipitation along the grain boundaries, due to its low carbon content. The solution anneal relieves residual stresses resulting from the method of fabrication and it ensures that the alloy is not susceptible to intergranular corrosion as demonstrated by testing in accordance with ASTM A 262. Cleaning and passivation treatments in accordance with ASTM A 380 enhance the thin, chromium-oxide film that forms on the alloy surface. During content loading operations (Sect. 7.1.1.2) and periodic maintenance (Sect. 8.2.5.2) the interior and exterior surfaces of the containment vessel are routinely inspected for signs of moisture, corrosion, and physical damage.

During immersion under HAC, water can enter the holes at the top of the drum, be absorbed into the cast refractory material, and fill all void spaces within the drum and inner liner. The insulating value of the insulation material may be decreased, and an overall weight increase would occur. The most important consideration is that the containment boundary remain intact and leaktight. This situation has been evaluated by completely immersing the containment vessel in a tank simulating 0.9- and 15-m (3- and 50-ft) immersion depths. The containment vessel remained intact and water tight, as demonstrated by the analysis and testing discussed in Sect. 2.7.

Physical contact between the convenience cans and the containment vessel wall, bottom, or top is minimized when the silicone support pads are used. The polyethylene or Teflon FEP bottles may be in contact with the stainless steel of the containment vessel, but will not react. During normal shipping operations, the cans and bottles will provide separation of the HEU contents from the containment vessel walls. The contents that cannot be packaged in the proposed cans due to the contents' overall dimensions, such as the unirradiated research reactor fuel elements, will be bundled together and protected on each end with an open-ended can (Fig. 1.4). When space is available inside the containment vessel, stainless-steel metal scrubbers will be placed on the top and bottom of this partially canned assembly, or an empty convenience can will be placed on the top or bottom of this assembly inside the containment vessel. Some solid form content may only be packed inside polyethylene, nylon, or Teflon bagging only. The bagging will prevent the uranium material from contacting the stainless-steel containment vessel. Stainless-steel metal scrubbers may be placed on the top and bottom of this assembly. Additionally, glass bottles with enriched uranium oxide (UO_2-Mg) will be packed inside sealed and inerted containers and treated as a pyrophoric content. The passivated nickel-alloy cans are galvanically similar to the stainless steel of the containment vessel and thus will not react. Aluminum clad components, alloys, and convenience cans oxidize quickly when exposed to moisture in the air. Therefore, there will not be any galvanic reaction between the aluminum and the containment vessel materials. Additionally, polyethylene, nylon, or Teflon bagging may be used around the convenience container as required by packaging personnel (in some cases the HEU is bagged inside the convenience container). Therefore, galvanic corrosion between the containment vessel wall and convenience containers or contents is highly unlikely. In addition, with the exception of UNX crystals, the environment inside the containment vessel is free of electrolytic solutions, further ensuring that there will be no galvanic reactions occurring inside the containment vessel.

For pyrophoric considerations, broken metal and alloy pieces shall be of a size that: (a) the specific surface area does not exceed 1 cm^2/g, or (b) will not pass freely through a mesh size of ⅜ in. (9.53 mm). Incidental small particles which do not pass the size restriction tests, and powders, foils, turnings, and wires may only be shipped if they are in a sealed, inerted container. Enriched uranium oxide in glass bottles (UO_2-Mg) will be shipped in a sealed, inerted container.

The material testing documented in Y/DZ-2720 does not identify the composition of the volatiles or gases generated during testing. Since Teflon FEP, a fluorine-containing polymer, is used to transport uranyl nitrate crystals and one of the uranium compounds is uranium tetrafluoride (UF_4), the possible development of a corrosive environment inside the containment vessel is investigated. Based on the following literature, FEP is notable among polymers for its high thermal stability. It decomposes at temperatures above ~260°C (500°F). In air or in oxygen, FEP decomposes in one way at lower temperatures and in another at higher temperatures. In this discussion, "oxygen" implies oxygen at a pressure of 300 torr. In air, the partial pressure of oxygen is near 150 torr. Below ~525°C, the decomposition of FEP is first order, and the main decomposition product is hexafluoropropylene (C_3F_6), although tetrafluoroethylene (C_2F_4) is a near second in abundance (Leidecker, Teflon thermal decomposition). The carbon-fluorine compound is one of the strongest compounds found in organic chemistry (its dissociation energy is 460 kJ/mol). The carbon chain is nearly completely covered by fluorine atoms and is, therefore, protected against external influences. This results in the exceptionally high chemical resistance of FEP (Daikin America). Based on the preceding statements, it is reasonable to conclude that most, if not all, of the gas coming from any decomposition of the Teflon FEP bottles would be hexafluoropropylene and tetrafluoroethylene rather than fluorine gas. The maximum temperature predicted (NCT or HAC) inside the ES-3100 containment vessel at the location near the Teflon FEP bottles is 198.04°C (388.48°F). This temperature is considerably below the lower limit of the FEP decomposition temperature [260°C (500°F)]. Due to the difference between the decomposition temperature of FEP [260°C (500°F)] and the maximum predicted temperature from testing [198.04°C (388.48°F)], essentially no C_3F_6 or C_2F_4 and no fluorine is expected to form during transport. Uranium tetrafluoride is a solid composed of agglomerating particles with a texture similar to baking soda. It is nonvolatile, nonhydroscopic, and only slightly soluble in water. A corrosive environment with fluorine as the base is not anticipated for either the uranium tetrafluoride compound or the Teflon bottles. It should be noted that the offgassing rate and quantity used for Teflon FEP at lower temperatures in Appendices 3.5.1 and 3.5.2 are very conservative estimates. The actual values shown for the Teflon bottle sample in Y/DZ-2720 may have resulted from the cumulative tolerance in the testing setup and data recording and not from actual offgassing.

Uranyl nitrate crystals are formed by dissolving uranium metal or any of the uranium oxides in nitric acid and the UNX crystalline precipitates are acquired through a variety of extraction, filtration, and purification processes. The UNX crystals are soluble in water, forming a weak nitric acid solution. Anhydrous uranyl nitrate [Formula: $UO_2(NO_3)_2$; molecular weight: 394.0; Chemical Abstract Service (CAS) Registry No. 10102-06-4] dissolves in water and when exposed to moist air it forms a mixture of the uranyl nitrate hydrates. Uranyl nitrate hexahydrate (UNH) [Formula: $UO_2(NO_3)_2 \cdot 6H_2O$; molecular weight: 502.1; CAS Registry No. 13520-83-7] separates out of solutions of uranyl nitrate at room temperature. The formation of uranyl nitrate hydrates in solution can be influenced by the addition of nitric acid. The higher the nitric acid concentration, the less water molecules take part in the hydrate formation (e.g., trihydrates, dihydrates). Thermal decomposition of UNX crystals has been studied in detail in support of nuclear fuel reprocessing. As presented for shipment, the UNX crystals exist as crystalline solids; however, the melting point for UNH, trihydrate, and dihydrate is reported as ~60°C, 113°C, and 184°C, respectively (Marshall 1951). Heating of UNH crystals up to 200°C results in a stepwise release of water molecules of crystallization (Dash 1999 and Kozlova 2007), which in a closed system results in the partial dissolution of the crystals. During transport of UNH crystals, crystalline solids and a saturated solution of uranyl nitrate will coexist at a temperature above ~60°C (MCW-1424). Given that the NCT maximum containment vessel temperature with insolation is 89.60°C (193.28°F) and the HAC maximum predicted temperature inside the containment vessel at the

location near the Teflon bottles is 198.04°C (388.48°F), the uranyl nitrate dihydrate and lower hydrates will remain in a solid phase during transportation. However, the trihydrate and higher hydrate crystals will release water molecules of crystallization upon heating above their melting point, thus converting them into a lower hydrate species, which require a successively higher temperature to release additional water molecules. The melting point for hexahydrate (~60°C) will be exceeded during NCT and HAC, and the melting point for trihydrate (~113°C) crystals will be exceeded during HAC. The solubility of uranyl nitrate is reported in ARH-724 ADD to be 55.9 and 81.1 lb $UO_2(NO_3)_2$ per 100 lb of saturated solution at 77 and 191°F, respectively. Released water molecules will partially dissolve the UNX crystals forming a weak nitric acid solution (<5% HNO_3). Upon cooling, the uranyl nitrate hydrate melt will recrystallize to a solid form.

While the Teflon bottles have proven to be fully capable of containing UNX crystals during normal shipping operations, there has been no effort to qualify these convenience containers under NCT and HAC testing conditions stipulated in 10 CFR 71.71 and 10 CFR 71.73, respectively. Consequently, solid/liquid UNX contents are therefore assumed to be in contact with the containment vessel internals. The general bulk corrosion can be estimated with published corrosion data for Type 304L stainless steel in nitric acid. Conservatively assuming an exposure to 5% nitric acid for 51 weeks at 200°F (NCT) and 1 week at 300°F (HAC) with corrosion rate data from NiDI Technical Series No. 10 075 (corrosion rate ranges of 0.000–0.005 and 0.005–0.020 in. per year at 200°F and 300°F, respectively), the estimated general corrosion would be 0.0001–0.0053 in. per 12-month exposure. However, given the conservative seal times stipulated in Table 1.3a, these corrosion rates would be reduced to 0.0001–0.0020 in. per 4-month exposure and to 0.0001–0.0012 in. per 2-month exposure. For comparison purposes, using corrosion rate data (0.0000–0.0039 and 0.0039–0.0394 in. per year at 212°F and 302°F, respectively) from the Outokumpu Corrosion Handbook, the estimated general corrosion rates would be 0.0001–0.0046 in. per 12-month exposure, 0.0001–0.0021 in. per 4-month exposure, and 0.0001–0.0014 in. per 2-month exposure. The average general corrosion would be 0.0025 in. per 12-month exposure, 0.0011 in. per 4-month exposure, and 0.0007 in. per 2-month exposure. Under the maximum seal time limit authorized (4 months in Table 1.3a), the average corrosion rate of ~0.001 in. or even the maximum corrosion rate of ~0.002 in. would not have a significant impact on the containment vessel integrity. It should be noted that these calculated corrosion rates are conservative given that the nitric acid concentration will progressively decrease during the exposure interval (i.e., as the nitric acid reacts) and that the maximum HAC temperature was imposed for 1 week with the maximum NCT temperature imposed for the remaining balance of the exposure interval.

As opposed to general corrosion in which all parts of the exposed surface corrode at approximately the same rate, pitting corrosion occurs when discrete areas of the alloy undergo localized attack while the bulk material remains virtually unaffected. Pitting corrosion can occur under acidic conditions involving a high concentration of chlorides, aeration, and moderately high temperatures. It can be inhibited by approaches commonly used to reduce corrosion in general: environment, alloy composition and structure, potential, and temperature. Various inorganic chemicals, including nitrates, will inhibit pitting when added to corrosive solutions. Type B and fissile material packages of UNX solutions with free acid are routinely transported in accordance with NRC requirements [e.g., NRC Certificate of Compliance Nos. 9250 and 9291 for the Model No. 5X22 Package and Liqui-Rad (LR) Transport Unit Package, respectively]. UNX crystals have been routinely transported in stainless-steel containment vessels in accordance with NRC requirements [e.g., NRC Certificate of Compliance Nos. 9250 and 9315 for the Model No. 5X22 Package and ES-3100 Package, respectively]. There have been no reported occurrences of pitting corrosion issues related to the transportation of UNX crystals or solutions in these referenced packages. Routine visual inspections of the ES-3100 containment vessel internals during loading and maintenance operations will identify general or pitting corrosion problems before they would present any significant impact on the containment vessel integrity.

The containment boundary remains intact even when the drum and inner liner are filled with water; therefore, the package is acceptable to the maximum credible extent from the standpoint of chemical, galvanic, or other reactions.

2.2.3 Effects of Radiation on Materials

All materials are affected to some extent by ionizing radiation, although low exposure levels do not typically cause appreciable effects (i.e., changes in the physical and mechanical properties). Upon exposure to ionizing radiation, a fraction of the incident energy is dissipated by interactions with the orbital electrons or nuclei of individual atoms. In sufficient quantities, the cumulative effects of these interactions may result in properties that differ from those of the unirradiated material. The radiation effects in a given material are proportional to the dose (amount of radiation absorbed), irrespective of the type of radiation.

The contents of the ES-3100 package are not irradiated, and the calculated total dose rates (Chap. 5) are well below those required to significantly damage any of the package materials by radiolytic interactions. The safety-related packaging components most vulnerable to radiation-induced degradation are the containment vessel EPDM O-rings. According to the *Parker O-Ring Handbook*, practically all elastomers suffer no change of their physical properties at a cumulative dose up to 1×10^6 rad. In addition, select EPDM compounds have been successfully tested at 1×10^7 rad of gamma radiation. Based on the calculated dose rate of 0.5 rad/h (Sect. 5.4.4), the maximum cumulative dose for the containment boundary O-ring location would be $<5 \times 10^3$ and $<1 \times 10^4$ rad for an exposure period of 1 or 2 years, respectively. Since the maximum absorbed dose is well below the 1×10^6 rad threshold, there will be no significant degradation of the O-ring material properties due to irradiation. Also, no significant degradation or activation of the other packaging materials of construction is expected at the calculated total dose rates.

Section 4.5.2.3 of NUREG-1609 requires the applicant to demonstrate that any combustible gases generated in the package during a period of one year do not exceed 5% (by volume) of the free gas volume in any confined region of the package. No credit should be taken for getters, catalysts, or other recombination devices. Appendix 3.5.4 evaluates the various packaging arrangements for the generation of hydrogen gas due to the radiolysis of water vapor, free water, interstitial water, polyethylene, nylon, or Teflon bags, and polyethylene or Teflon bottles. When the content mass and the material composition are limited as shown in Appendix 3.5.4, the combustible gas concentration limit stated in NUREG-1609 is not exceeded. Getters, catalysts, or other recombination devices are not employed in any of the containment vessel packaging arrangements.

2.3 FABRICATION AND EXAMINATION

2.3.1 Fabrication

2.3.1.1 Drum assembly fabrication

The drum assembly is fabricated in accordance with JS-YMN3-801580-A002 (Appendix 1.3.2), JS-YMN3-801580-A003 (Appendix 1.3.4), SPC M801794-0003 (Appendix 1.3.11), SPC M801580-0003 (Appendix 1.3.12) and JS-YMN3-801580-A005 (Appendix 1.3.5). The latter four specifications control the casting of the Kaolite 1600, Packcrete, and Cat 277-4 materials inside the drum liners and the top plug.

The drum assembly and top plug are fabricated according to the design drawings (Appendix 1.3.7), and the portions of the codes, standards, and regulations to the extent described below:

1. *ASME Boiler and Pressure Vessel Code*, Sect. VIII, Div. 1, 2001 ed. with 2002 and 2003 addenda;
2. *ASME Boiler and Pressure Vessel Code*, Sect. II, Parts A and C, 2001 ed. with 2002 and 2003 addenda;
3. *ASME Boiler and Pressure Vessel Code*, Sect. IX, 2001 ed. with 2002 and 2003 addenda;
4. Military Standard MS27683, *Drum, Metal—Shipping and Storage 16 to 80 Gallons*; and
5. ASTM A 380, *Standard Practice for Cleaning, Descaling, and Passivation of Stainless Steel Parts, Equipment, and Systems*.

Detailed dimensional requirements and the materials of construction are called out on the drawings in Appendix 1.3.7. Except for the weld studs, documented certified material test reports (CMTRs) are provided for all materials used in weldments for the fabrication of the drum, including weld filler metal. The CMTRs are traceable to heat numbers and demonstrate compliance with the SA or SFA Series material specifications called out. For all other materials, documented Certificates of Compliance (CoCs) are provided certifying that the materials provided comply with the requirements stated on the drawings and specifications. All welding is done in accordance with welding procedure specifications that are written and performance qualified in accordance with the ASME Code, Sect. IX. All welders are performance qualified to weld using these procedures, and their qualifications are documented in accordance with the ASME Code, Sect. IX. The welding fabrication requirements stated in the ASME Code, Sect. VIII, Div. 1, Paragraphs UW-26–UW-48, are met. All butt welds in rolled sheet, pipe, and angle joints are full penetration butt welds. With the exception of the seam welds in the drum body, all welds shall be done by the gas tungsten arc welding (GTAW), gas metal arc welding (GMAW), plasma arc welding, or a capacitor discharge stud welding process. The weld filler metal used in the fabrication of the drum assembly is procured to comply with the SFA specifications of Sect. II, Part C, of the ASME Code that are stated in the welding procedure specifications. Weld filler metal is traceable to heat numbers, and CMTRs are furnished for each heat of weld wire filler. The control of weld filler permits a weld examiner to be able to determine the heat number of the weld filler used in any weld on the drum assembly. Weld symbols are provided on the drawings, indicating for each weld the type of weld and the dimensions of weld. These weld symbols are interpreted in accordance with AWS A2.4.

2.3.1.2 Containment boundary fabrication

The containment boundary consists of the containment vessel, lid assembly, and inner O-ring. The containment vessel is manufactured in accordance with the applicable requirements in the ASME Code, Sect. III, Div. 1, Subsection NB, for Class 1 Components as described on the drawings in Appendix 1.3.7 and JS-YMN3-801580-A001 (Appendix 1.3.3). The containment vessel is fabricated according to the design drawings and the following codes, standards, and regulations as described in JS-YMN3-801580-A001.

1. *ASME Boiler and Pressure Vessel Code*, Sect. III, Div. 1, Subsections NB and NCA, Class 1 Components, 2001 ed. with 2002 and 2003 addenda;
2. *ASME Boiler and Pressure Vessel Code*, Sect. II, Parts A and C, 2001 ed. with 2002 and 2003 addenda;
3. *ASME Boiler and Pressure Vessel Code*, Sect. IX, 2001 ed. with 2002 and 2003 addenda; and
4. ASTM A 380, *Standard Practice for Cleaning, Descaling, and Passivation of Stainless Steel Parts, Equipment, and Systems*.

Detailed dimensional requirements and the materials of construction are called out on the drawings in Appendix 1.3.7. CMTRs are provided for the materials used to fabricate these components in accordance with NCA-3860 of the ASME Code. The suppliers of these materials will meet the requirements of NCA-3800 of the ASME Code. Such parts are traceable to each containment vessel by means of a serial number. The fabricator maintains control of materials to ensure this traceability. Other metallic materials and the O-ring seals are supplied with CoCs in accordance with NCA-3862(g) and (h) of the ASME Code. The weld filler metal used in the fabrication, and repair welding as permitted, of the containment vessels meets the requirements of ASME Code, Sect. III, Subsection NB, Paragraph NB-2400. It is procured to comply with the SFA specifications of Sect. II, Part C, of the ASME Code that is stated in the fabricator's welding procedure specifications. Weld metal is procured traceable to heat numbers, and CMTRs are furnished for each heat of weld wire filler used. The results of the delta ferrite determination are included in the CMTR for the weld filler metal (see Paragraph NB-2433). There are two containment vessel assemblies shown on Drawing M2E801580A012 (Appendix 1.3.7), Parts M2E801580A012-1 and M2E801580A012-4. Part M2E801580A012-4 is fabricated by welding a forged bottom and forged top flange to a cylindrical shell machined from seamless pipe as shown on the drawing. All welds on the containment vessels are accomplished by either the GTAW or GMAW process, manual or automatic, at the discretion of the fabricator unless specifically called out on the drawings. Backing rings, even if removed after the weld has been made, are not used. As previously stated, weld symbols are provided on the drawings, indicating the type of weld and dimensions of the weld. These weld symbols are interpreted in accordance with AWS A2.4. The forming, fitting, and alignment requirements stated in Paragraph NB-4200 are met in the fabrication of the containment vessels unless more stringent requirements are called out on the design drawings.

The preferred fabrication method for the containment vessel body (Part M2E801580A012-1) is from a single forged billet or bar by any process that meets the requirements stated in JS-YMN3-801580-A001 (Appendix 1.3.3) and shown on the design drawings. The formed, heat treated, and finished machined containment vessel body shall meet the applicable requirements of ASME SA-182 for Grade F304L for a forged component. After final forming, parts are solution annealed and quenched per the requirements of ASME SA-182 for Grade F304L. A certified heat treatment report is provided stating the following information for each furnace charge: the serial numbers of the containment vessel bodies heat treated in the furnace charge, the time and date of the heat treating, the person responsible for the heat treating, the time-temperature profile of the furnace and representative parts of the furnace charge, the quench medium, and all other pertinent details of the heat treating. Such a heat treating report is required for all heat treating, both in-process annealing and final heat treatment.

2.3.2 Examination

2.3.2.1 Examination of the drum assembly fabrication

The drum and top plug assemblies are examined and tested according to the design drawings and the applicable portions of the codes, standards, and regulations described below:

1. *ASME Boiler and Pressure Vessel Code*, Sect. VIII, Div. 1, 2001 ed. with 2002 and 2003 addenda;
2. *ASME Boiler and Pressure Vessel Code*, Sect. V, 2001 ed. with 2002 and 2003 addenda; and
3. SNT-TC-1A-1992, *Recommended Practice for Nondestructive Testing Personnel Qualification and Certification*, American Society for Nondestructive Testing, December 1992.

All welded or weld-repair surfaces shall be visually examined by a qualified weld examiner for indications of inclusions, cracks, or porosity using a written weld examination procedure. Weld examiners are qualified to perform visual weld inspections in accordance with SNT-TC-1A, *Personnel Qualification and Certification in Nondestructive Testing*, or ANSI/ASNT CP-189, *Qualification and Certification of Nondestructive Testing Personnel*, published by the American Society for Nondestructive Testing. The ASME Code, Sect. IX, is to be employed as the applicable requirement. Section VIII of the ASME Code is invoked for acceptance criteria for Code-specified examinations, which are to be performed in accordance with the provisions of ASME Code, Sect. V. Any indication of inclusions, cracks, or porosity in the welds is cause for rejection. The item may be reworked to meet the specifications. The weld examination procedures, the weld examiners' qualifications, and the weld examination reports are submitted to Consolidated Nuclear Security, LLC (CNS) for record keeping. The acceptance criteria for joint fit-up and alignment or for visual examination of welds are given in the ASME Code, Sect. VIII, Div. 1, Paragraphs UW-31 through UW-36. In addition, any visible defects such as lack of fusion, lack of penetration, linear or crack-like defects, and visible porosity, are cause for rejection. Straightening, flattening, and forming by mechanical or thermal means of some features and components after welding may be required to ensure proper assembly. The surfaces of areas of the weldment that have been reworked are visually examined to ensure that no cracks are present or that the weldment has not been degraded. Welds that are adjacent to these areas are also visually examined. The acceptance criterion is that no cracks are found. The areas worked and the visual inspections are noted on the dimensional inspection report. The external seam weld of the drum assembly is pressure tested by attaching removable lids on both the top and bottom false wire locations and injecting water and air inside the assembly up to the final pressure of 170.30 kPa (24.7 psia). After all testing, inspection, and final machining are complete, the drum assembly and top plug are dimensionally inspected. The dimensions and features such as flatness and run-out to be inspected are indicated on the design drawings. A written inspection report is prepared, submitted, and maintained for each ES-3100 drum assembly.

The above examination criteria address the stainless-steel components. However, the drum assembly also consists of the Kaolite 1600 or Packcrete material and the Cat 277-4 neutron poison. Acceptance criteria for the Kaolite 1600 installation are addressed by JS-YMN3-801580-A003 (Appendix 1.3.4) and the acceptance criteria for the Packcrete installation are addressed by SPC M801794-0003 (Appendix 1.3.11) and SPC M801580-0003 (Appendix 1.3.12). These specification controls and documents the raw materials used for mixing, casting and vibration methodology, and the baking of the material inside the drum assembly. The final acceptance criterion is achieved by producing a cast Kaolite 1600 or Packcrete material density of 358.8 ± 48 kg/m^3 (22.4 ± 3 lb/ft^3). Acceptance criteria for the installation of Cat 277-4 neutron poison are addressed in JS-YMN3-801580-A005 (Appendix 1.3.5). This specification also controls and documents the raw materials used for mixing, casting, and vibration methodology, and the final density of the casting [1682 +240/−80 kg/m^3 (105 +15/−5 lb/ft^3)]. Further examination criteria to verify the concentration and homogeneity of the Cat 277-4 in each drum assembly are also provided in JS-YMN3-801580-A005. The various parameters specified in NUREG/CR-3854 and in Table 2.11 for a neutron poison are addressed in detail in this specification.

2.3.2.2 Examination of the containment vessel fabrication

The containment vessel is examined and tested according to the design drawings and applicable portions of the following codes, standards, and regulations as described below:

1. *ASME Boiler and Pressure Vessel Code*, Sect. III, Div. 1, Subsections NB and NCA, Class 1 Components, 2001 ed. with 2002 and 2003 addenda;
2. ANSI N14.5-1997, *American National Standard for Radioactive Materials—Leakage Tests on Packages for Shipment*;

3. *ASME Boiler and Pressure Vessel Code*, Sect. V, Subsection A, Article 10, Appendix IX, "Helium Mass Spectrometer Test—Hood Technique," 2001 ed., and 2002 and 2003 addenda;

4. *ASME Boiler and Pressure Vessel Code*, Sect. V, Article 6, "Liquid Penetrant Examination," 2001 ed., and 2003 addenda; and

5. SNT-TC-1A-1992, *Recommended Practice for Nondestructive Testing Personnel Qualification and Certification*, American Society for Nondestructive Testing, December 1992.

Procured materials are examined in accordance with the applicable paragraphs of NB-2500 and meet the stated acceptance criteria. The results of these examinations are included with the CMTRs provided to CNS. All welded or weld-repair surfaces are visually examined by a qualified weld examiner for indications of inclusions, cracks, or porosity. The ASME Code, Sect. IX, provides the applicable requirements. Section III of the ASME Code is invoked for acceptance criteria for Code-specified examinations, which are to be performed in accordance with ASME Code, Sect. V. Prior written approval is obtained for any weld repair on materials, and the weld repair areas are both surface and volumetrically examined. The repair area is noted in a sketch supplied with the CMTR for the material that was weld repaired, and the documented results of the weld examination are provided to CNS. The markings on the weldment materials are not removed until after all weld examination is complete. The heat numbers of base metals and weld filler are required on all weld examination reports. Control of weld filler by the fabricator makes it possible for a weld examiner to determine the heat number of the weld filler used in any weld on the containment vessel.

As previously stated, the containment vessel body may be fabricated by two different methods (Appendix 1.3.7, Drawing M2E801580A012). Part M2E801580A012-4 is fabricated by welding a forged bottom and forged top flange to a cylindrical shell machined from seamless pipe as shown on the drawing. Prior to welding these components, all weld preparation areas and the surfaces within one inch of the weld are examined visually and with liquid penetrant. The acceptance criteria for these examinations are those stated in Paragraphs NB-5130(a) through NB-5130(d). The requirements in ASME Code, Paragraphs NB-5110, NB-5120, NB-5210, NB-5220, NB-5260, and NB-5300 apply to the containment vessels. The plug weld shown on Drawing M2E801580A015 (Appendix 1.3.7) shall be examined visually and with penetrant. The requirements in Paragraphs NB-5110 and NB-5350 apply to the plug weld. Materials used in the penetrant examination of welds and in the final surface examinations of finished components shall be specifically recommended by their suppliers for use with austenitic stainless steels, and copies of the certification of contaminant content of materials used shall be supplied with the examination reports (ASME Code, Sect. V, Article 6, T-641). Repair welding shall meet the applicable requirements of NB-2500. Certified written weld examination reports together with the corresponding material surface examination reports and weld map shall be submitted as stated in the procurement specification for the containment vessel. Weld examination reports for all weld and surface examinations shall include the containment vessel serial number, a weld map showing the location of the weld and examination area, the welder's name, the examiner's name, the time and date of the weld examination, the examination procedure number(s) used, the WPS number, the heat numbers of the joined materials, the heat number of the weld filler, and examiner's remarks. The examiner's remarks shall include the results of the examination and the acceptance or rejection of the weld based on the stated criteria. One set of radiographs shall be provided with the radiographic examination reports. If a weld or surface is rejected, a description of the defect and a sketch showing the location shall be provided.

The nonwelded containment vessel body, Part M2E801580A012-1, shall be formed from a single forged billet or bar by any process that meets the requirements stated in JS-YMN3-801580-A001 (Appendix 1.3.3) and shown on the design drawings (Appendix 1.3.7). The formed, heat treated, and finished machined containment vessel body shall meet the applicable requirements of ASME SA-182 for Grade F304L for a forged component. Mechanical properties are verified by testing of coupons. The test coupons are to be machined from the same heats of materials used to form the containment vessel bodies

and shall have the same or greater amount of cold work (plastic strain) as the containment vessels will have as a result of the forming process. The mechanical tensile testing of coupons shall be done in accordance with ASME SA-370. A minimum of six test coupons shall be tested for each final heat treatment furnace charge. The first set of three test coupons, chosen at random, shall be tested without being heat treated. The second set of three or more test coupons shall be heat treated together with the containment vessel bodies and then tested. The heating rates and maximum temperatures of the test coupons shall be representative of the entire furnace charge. Test coupons are not required to be heat treated with intermediate processing annealing steps but are required in the final heat treatment furnace charge. The results of all the testing of the sample coupons shall be documented, certified, and reported to CNS. The mechanical properties test report shall contain the following information: (1) a descriptor of the furnace charge which the test coupons are to represent; (2) the times and dates of the heat treating and the testing; (3) the person responsible for the testing; (4) a statement that these coupons are tested prior to or after heat treatment; (5) a description of the testing, including a sketch of the tensile test specimen; (6) the make, model, serial number, and current calibration data of the machine(s) used in the testing; (7) reference to the written testing procedure that was used; (8) the resulting measured yield strength, ultimate strength, percent elongation and percent reduction in area; and (9) any pertinent remarks.

2.4 GENERAL REQUIREMENTS FOR ALL PACKAGES

The general design standards for all packages in accordance with 10 CFR 71.43(a) through (c) are addressed in the following paragraphs.

2.4.1 Minimum Package Size—10 CFR 71.43(a)

Requirement: The smallest overall dimension of a package shall not be <10 cm (4 in.).

Compliance: The drum's outside diameter over the rolled rings is 49.20 cm (19.37 in.), and the outside height including the lid is 110.49 cm (43.50 in.). The minimum outside diameter of the ES-3100 containment vessel is 13.36 cm (5.26 in.), and the overall height is 82.30 cm (32.40 in.). Therefore, the packaging meets this requirement.

2.4.2 Tamper-Indicating Feature—10 CFR 71.43(b)

Requirement: The outside of the package must incorporate a feature, such as a seal, that is not readily breakable and that, while intact, would be evidence that the package has not been opened by unauthorized persons.

Compliance: The removable drum head is attached to the body by eight ⅝-11-UNC-2B silicon bronze nuts and ⅝-in. nominal washers. Two 0.51-cm (0.20-in.)–thick lugs with 0.953-cm (0.38-in.)–diam holes (Drawing M2E801580A005, Appendix 1.3.7) project through slots in the drum lid and provide attachment for TIDs. These TIDs consist of a stainless-steel cable with an aluminum crimp closure or equivalent. The requirement is satisfied by the TIDs, which are installed as specified in Sect. 7.1.2.2. The TID is only required when the containment vessel has HEU in the package. It is not required for empty shipments, but may be installed if required by site-specific requirements.

2.4.3 Positive Closure—10 CFR 71.43(c)

Requirement: Each package must include a containment system securely closed by a positive fastening device that cannot be opened unintentionally or by pressure that may arise within the package.

Compliance: The fastened lid on the drum with tamper-indicating features provides assurance that the drum assembly will not be unintentionally breached. The containment vessel is sealed using the lid assembly and closure nut to ensure that it will be breached only through a deliberate effort, and then only after the drum assembly has been breached. The design of the containment vessel is analyzed in DAC-M900000-0003 for a differential pressure of 699.82 kPa (101.5 psi) internal and 150 kPa (21.7 psi) external. The internal design pressure exceeds the maximum differential pressure of 185.29 kPa (26.87 psi) [210.29 − 25] attained during NCT (Sect. 2.6.3). The containment vessel is also analyzed in DAC-M900000-0002 for a differential pressure of 1378.95 kPa (200 psi) internal. This internal pressure exceeds the maximum HAC (Appendix 3.5.2) pressure differential of 1105.23 kPa [160.3 psi (175 psia -14.7 psia)]. In addition, calculation results are provided in Sects. 2.6.1 and 2.7.4.3 to demonstrate that the stresses in the containment vessel and closure nut threads do not exceed the stress limits established by the ASME Code for NCT and HAC. Therefore, the containment boundary will not be breached during any mode of transport due to pressurization of the containment boundary.

2.5 LIFTING AND TIE-DOWN STANDARDS FOR ALL PACKAGES

This section addresses the requirements of 10 CFR 71.45, "Lifting and Tie-Down Standards for All Packages."

2.5.1 Lifting Devices

Requirement. Any lifting attachment that is a structural part of a package must be designed with a minimum safety factor of three against yielding when used to lift the package in the intended manner, and it must be designed so that failure of any lifting device under excessive load would not impair the ability of the package to meet other requirements of 10 CFR 71, Subpart E. Any other structural part of the package that could be used to lift the package must be capable of being rendered inoperable for lifting the package during transport, or must be designed with strength equivalent to that required for lifting attachments.

Analysis. The ES-3100 packages, as delivered for transport, have no lifting devices or structural parts that can be used for lifting. Therefore, the lifting devices requirements of 10 CFR 71.45 are not applicable.

2.5.2 Tie-Down Devices

Requirement. If there is a system of tie-down devices that is a structural part of the package, the system must be capable of withstanding, without generating stress in any material of the package in excess of its yield strength, a static force applied to the center of gravity of the package having a vertical component of two times the weight of the package with its contents, a horizontal component along the direction in which the vehicle travels of ten times the weight of the package with its contents, and a horizontal component in the transverse direction of five times the weight of the package with its contents. Any other structural part of the package that could be used to tie down the package must be capable of being rendered inoperable for tying down the package during transport, or must be designed with strength equivalent to that required for tie-down devices. Each tie-down device that is a structural part of a package must be designed so that failure of the device under excessive load would not impair the ability of the package to meet other requirements of this part.

Analysis. The ES-3100 package, as delivered for transport, has no tie-down devices that are structural parts of the package. Therefore, the tie-down requirements of 10 CFR 71.45 are not applicable. The package is secured in the conveyance using blocking, bracing, and tie-down equipment that meets industry-standard practices to prevent shifting during NCT. When using an SGT, safe tie-down and transport of the package is accomplished by methods explained in the NNSA Technical Manual. For single-unit tie-down, a drum tie-down adapter is positioned on top of the drum and two chains, passing through the adapter, are attached to equipment positioned on the floor of the transport vehicle. The welded ring on the drum lid helps to initially position this drum tie-down adapter as well as prevent inadvertent assembly damage to the studs and nuts. Another method of securing the ES-3100 package is by the use of a Cargo-Restraint Transporter or Cargo Pallet Assembly. In these methods, a frame is positioned around the base and top of either five or six packages. These frames are then chained or locked to the floor as depicted in the NNSA Technical Manual. Tension is applied to the chains to eliminate any slack. The downward load resulting from the chain tensioning is insignificant when compared to the compression loading as specified in 10 CFR 71.71(c)(9).

2.6 NORMAL CONDITIONS OF TRANSPORT

This section demonstrates compliance with 10 CFR 71.43(f) and with 10 CFR 71.51(a)(1) and (b) following the tests and NCT conditions stipulated in 10 CFR 71.71. Package structural evaluation is performed by the combination of full-scale testing, similarity, and analysis as described in the following sections. A summary of 10 CFR 71.71 tests for the ES-3100 package is shown in Table 2.18. The essentially unyielding surface used for the 1.2-m (4-ft) drop test was the indoor drop test pad at the National Transportation Research Center (NTRC). All 9-m (30-ft) drop and crush tests were conducted at the outside drop pad at NTRC. The indoor pad consists of a 5.08-cm (2-in.)–thick steel plate embedded inside a reinforced concrete pad ~127-cm (50-in.) thick. The outside drop pad consists of a 10.16-cm (4-in.)–thick steel plate embedded inside a reinforced concrete pad ~167.6-cm (66-in.) thick. An article has been prepared by the NTRC staff to describe the integrity of these test pads (Shappert 1991). It is shown that the package will not experience any loss in shielding effectiveness or spacing and will not release any radioactive content or undergo leakage of water into the containment vessel during exposure to NCT. The four tests (water spray, free drop, compression, and penetration) made on Test Unit-4 (TU-4) were conducted in the 20.8 to 22.4°C (69.4 to 72.4°F) range, with the 1.2-m drop test conducted at 22.4°C (72.4°F). The maximum regulatory reference air leakage rate is $\leq 1.4025 \times 10^{-4}$ ref-cm^3/s. Compliance with this permitted activity release limit is not dependent on filters or mechanical cooling systems. Following NCT compliance testing, the package was subjected to the sequential HAC test battery. Original compliance testing was conducted on test units fabricated using Kaolite 1600 as the thermal barrier and impact-absorbing material. Due to the lack of Kaolite 1600 material from the manufacturer that meets specified density requirements, a substitute inorganic castable refractory material, identified as Packcrete, was developed. To confirm the thermal-insulating and impact-limiting material equivalency of Packcrete to the previously used Kaolite 1600 material, numerous material properties were evaluated and the results are documented in RP 802282-0002. These material tests have shown that the Packcrete is functionally equivalent to Kaolite 1600. Therefore, the test results and conditions analyzed in this section using Kaolite 1600 are also applicable to Packcrete.

The ES-3100 package was tested in accordance with a test plan developed by the NTRC at the Oak Ridge National Laboratory (ORNL) [ORNL/NTRC-013]. Testing of ES-3100 prototype units was performed at the NTRC facility, except as noted below. Six full-scale test units were assembled with content weights ranging from 3.6 kg (8 lb) to 50.3 kg (111 lb). One of these test units (TU-4) was subjected to the tests specified in 10 CFR 71.71(c)(5) through (c)(10) excluding (c)(8) prior to the HAC sequential tests stipulated in 10 CFR 71.73 and shown in Table 2.18. Tables 2.18 and 2.19 summarize the testing procedure and the drop orientations for each ES-3100 test unit. The contents used as surrogate

payloads for the test units are shown on Drawings M2E801580A029 and M2E801580A027. In the light-weight configuration, the contents consist of three 25.4-cm (10-in.)-high convenience cans with handles, and four silicone rubber pads. These convenience cans, handles and silicone rubber pads are identical to those proposed for transport. The bottom convenience can was filled with steel grit until the convenience can and grit assembly weighed ~3 kg (6.6 lb). The actual weight of the steel grit was 2.77 kg (6.11 lb). The total content weight for the light-weight content configuration including the convenience cans, silicone rubber pads, can handles, and steel grit was ~3.6 kg (8 lb). In the heavy-weight configurations, the surrogate payload consists of three steel cylindrical shaped components with handles, two can spacers filled with neutron-absorbing material and handles, and six silicone rubber pads. These components weighed a total of ~50 kg (110.2 lb). These different weight assemblies bound the range of possible content configurations and structural deformation resulting from compliance testing.

Title 10 CFR 71.71(b) specifies that the tests for NCT be conducted at the most unfavorable ambient temperature within the range of −29 to 38°C (−20 to 100°F). The drum is fabricated from Type 304 stainless steel, and the containment vessel is fabricated from Type 304L stainless steel, which is particularly suitable for low-temperature service. The Izod impact strength for the stainless steel used in the package components remains constant over a large range [specifically, from 21.11 to −195.5°C (70 to −320°F)] (*Stainless Steel Handbook*). Tensile strength increases from a minimum of 4.826×10^5 to 1.696×10^6 kPa (70,000 to 246,000 psi), and the yield strength increases ~10% over the same temperature range. The EPDM O-rings in the containment vessel have a normal service temperature range of −40 to 150°C (−40 to 302°F) [Table 2.15]. The normal service temperature range of the drum and containment vessel is −40 to 426.7°C (−40 to 800°F) [ASME Code, Sect. II, Part D]. At −29°C (−20°F), the impact-limiting material has been shown by tests to be stiffer than at 22.4°C (72.4°F).

Table 2.18. Summary of NCT—10 CFR 71.71 tests for ES-3100 package

Test [a]	TU-1 (heavy) 12° slap-down	TU-2 (heavy) side drop	TU-3 (heavy) center of gravity over top corner	TU-4 (heavy) top down	TU-5 (light) 12° slap-down
Operational leak test (CALT5 or VTI Smart Station)	1	1	1	1	1
NCT—10 CFR 71.71(c)(5) Vibration				5	
NCT—10 CFR 71.71(c)(6) Water spray				2	
NCT—10 CFR 71.71(c)(7) 1.2 m (4 ft) free drop	2	2	2	3	2
NCT—10 CFR 71.71(c)(9) Compression				6	
NCT—10 CFR 71.71(c)(10) Penetration				4	

[a] The numbers 1 through 6 indicate the sequence of the tests.

This condition has been evaluated by the compliance testing conducted on TU-2. TU-2 was chilled prior to being subjected to any structural testing (i.e., 1.2-m NCT drop, 9-m HAC drop, HAC crush, and HAC puncture tests). This unit was chilled to a nominal temperature of −40°C (−40°F). This was accomplished by placing the unit in an environmental chamber in Building 5800 at ORNL with initially setting of the chamber at ~ −57°C (−70°F) for 24 h. After this initial period, the control on the environmental chamber was set to ~ −43°C (−45°F) for another 48 h. Prior to the initiation of structural testing of this unit, it was removed from the environmental chamber and placed in an insulated box. Once transported to the NTRC, sequential structural testing as shown in Table 2.19 was performed as quickly as possible. The other test units were first subjected to the free drop from 1.2 m (4 ft) test prior to the HAC testing of 10 CFR 71.73. These additional tests were conducted to show that the NCT testing would not reduce the effectiveness of the package to withstand HAC testing. The reduction in tensile strength of the stainless steel from 22.4 to 38°C (73 to 100°F) is only ~2%, and the impact-limiting material test trends show that the impact-limiting material may become slightly softer. However, these slight reductions in tensile strength and absorption characteristics should not affect the results significantly compared to those conducted at 38°C (100°F).

Table 2.19. Summary of HAC—10 CFR 71.73 tests for the ES-3100 package

Test [a]	TU-1 (heavy) 12° slap-down	TU-2 (heavy) side drop	TU-3 (heavy) center of gravity over top corner	TU-4 (heavy) top down	TU-5 (light) 12° slap-down	TU-6 [b] 15-m immersion
10 CFR 71.73(c)(1) Free drop 9 m (30 ft)	1	1	1	1	1	
10 CFR 71.73(c)(2) Crush 9 m (30 ft)	2	2	2	2	2	
10 CFR 71.73(c)(3) Puncture 1 m (40 in.)	3, 4, 5, 6	3	3	3	3	
Preheat to >38°C (100 °F) before thermal test	7	4	4	4	4	
10 CFR 71.73(c)(4) Thermal 800°C (1475°F)	8	5	5	5	5	
Operational leak test of containment vessel (CALT5or VTI Smart Station)	9	6	6	6	6	1
Full containment boundary leak test (He Leak Test)	10	7	7	7	7	
10 CFR 71.73(c)(5) Immersion test fissile materials—0.9 m (3 ft)	11	8	8	8	8	
10 CFR 71.73(c)(6) Immersion test—all packages 15 m (50 ft)						2

[a] The numbers 1–11 indicate the sequence of the tests.
[b] TU-6 is only a containment vessel with ballast to ensure nonbuoyancy.

Title 10 CFR 71.71(b) also states that the initial internal pressure within the containment system during NCT drop testing shall be considered as the maximum normal operating pressure. The maximum normal operating pressure is defined in 10 CFR 71.4 as the maximum gauge pressure that would develop in the containment system in a period of 1 year under the heat conditions specified in 10 CFR 71.71(c)(1). The internal pressure developed under these conditions in the ES-3100 containment vessel is calculated in Appendix 3.5.1 and discussed in Sects. 2.6.1.1 and 3.3.2. As noted in these sections, the internal pressure is calculated and rounded up to 210.29 kPa (30.50 psia). Since the decay heat of the proposed contents is ~5 W, little or no impact on the pressure or temperature of the package components will result during NCT. As shown in DAC-M900000-0003, the design absolute pressure of the containment vessel is 801.17 kPa (116.2 psia), and the hydrostatic test pressure stipulated in JS-YMN3-801580-A001 is 1135.57 kPa (164.7 psia). Thus, increasing the internal pressure of the containment vessel to a maximum of 210.29 kPa (30.50 psia) during NCT would have no detrimental effect. Table 2.20 provides a summary of the pressures and temperatures in the various shipping configurations. As discussed in Sect. 2.6.1.4, the containment vessel and the closure nut stresses for this pressure condition are well below the allowable stress values.

Table 2.20. Summary of temperatures and pressures for NCT

Average gas evaluation temperature °C (°F)	Containment vessel absolute internal pressure kPa (psia)
−40 (−40) [a]	76.74 (11.13)
25.0 (77) [b]	101.35 (14.70)
89.60 (193.28) [c]	133.30 (19.333) [d]
89.60 (193.28) [c]	208.75 (30.276) [e]
90.00 (194) [f]	210.29 (30.50) [f]

[a] Analysis conducted with no decay heat load in accordance with 10 CFR 71.71(c)(2).
[b] Assembly temperature and pressure.
[c] These values have been calculated in DAC M801940-0002 with 5-W decay heat and insolation.
[d] This value has been calculated in Appendix 3.5.1 for containment vessel arrangements Number 1 and 11.
[e] This value has been calculated in Appendix 3.5.1 for containment vessel arrangement Number 7.
[f] The values have been calculated in Appendix 3.5.1 and rounded up for conservatism.

Title 10 CFR 71.71(c) specifies that the package service temperature must extend from −40 to 38°C (−40 to 100°F) with insolation. As shown in Sect. 3.3.1 and calculated in DAC M801940-0002, the upper service temperature with insolation is calculated and rounded up to 90°C (194°F) for an empty ES-3100 containment vessel. Thermal cycling of the packages from 90°C (194°F) to −40°C (−40°F) is considered an unlikely event, and the change would occur over a long period of time.

In any event, the 130°C (234.00°F) thermal cycle would not result in brittle fracture or fatigue failure in the packaging. The acceptability of the packaging against brittle fracture is discussed in Sect. 2.6.2. The only concern for fatigue or endurance failure is related to the cyclic pressure changes in the containment vessel as the temperature varies from low to high. A 25°C (77°F) ambient temperature normally exists for the containment vessel during assembly. The containment vessel is sealed at an absolute pressure of ~101.35 kPa (14.70 psi). The internal absolute pressure at an average gas temperature of 90°C (194.0°F) is 210.29 kPa (30.50 psi) for the ES-3100 containment vessel (Table 2.20). The absolute internal pressure at −40°C or −40°F is 76.74 kPa (11.13 psi) for the containment vessel. Therefore, the maximum cyclic pressure differential for the containment vessel from low to high temperatures is (210.29 − 76.74) kPa or 133.55 kPa (19.37 psi). This cyclic pressure is insignificant

when considering the integrity of the containment vessel as shown by the stress levels discussed in Sect. 2.6.1.3.

The ES-3100 package has been tested to determine the effectiveness of the package following a sequential NCT 1.2-m (4-ft) drop test and an HAC test battery. Testing conducted on TU-4 showed that there would be no loss or dispersal of radioactive contents, no significant increase in external surface radiation levels if the actual contents had been subjected to these tests, and no substantial reduction in the effectiveness of the packaging to survive the HAC testing. Thus, the requirements of 10 CFR 71.43(f) are satisfied.

Because some contents may be transported by air, the following criteria and guidance have been incorporated into various sections of this SARP.

1. International Atomic Energy Agency (IAEA) SSR-6, para. 621, states: "Packages containing radioactive material, to be transported by air, shall be capable of withstanding, without loss or dispersal of radioactive contents from the containment system, an internal pressure that produces a pressure differential of not less than the maximum normal operating pressure plus 95 kPa."

2. In order to also comply with 49 CFR 173.410(i)(2), the range of temperature evaluated will be from −40 to 55°C (ambient temperature).

3. According to IAEA SSG-26, para. 621.3, the evaluation at an ambient temperature of 55°C does not consider the solar radiation input; however, self-heating of the package is taken into account.

A thermal analysis has been conducted that predicts various temperatures of the shipping package evaluated at an ambient temperature of 55°C (131°F) with no insolation but does include 5 W of internal decay heating. The results are shown in Table 3.15 for this condition. The maximum temperature predicted for the containment vessel is 64.44°C (147.99°F). This temperature will be used in subsequent analyses as the maximum average gas temperature inside the containment vessel during air transport. An analysis has been conducted in Appendix 3.5.1 to determine the maximum normal operating pressure (MNOP) for air transport. Table 9 in Appendix 3.5.1 shows the results of this analysis, where the MNOP is determined to be 22.68 kPa (3.29 psig) for air transport. This value of 22.68 kPa (3.29 psig) is bounded by the value determined for ground transportation shown in Table 2.20. To comply with IAEA SSR-6, para. 621, an analysis is shown in Appendix 4.5.2 using an upstream pressure of 117.68 kPa (17.07 psia) and a downstream pressure of 0 kPa (0 psia). This provides the maximum pressure differential of 22.68 kPa + 95 kPa (3.29 + 13.78 psi). The analysis in Appendix 4.5.2 for air transport shows that the leaktight criteria obtained on test units is substantially below the calculated results for air transport. Therefore, the requirements of 10 CFR Part 71.51(a)(1) are satisfied. The containment vessel has also been evaluated at the maximum pressure differential shown in Table 9 of Appendix 3.5.1. The margin of safety for each component is significantly large enough to conclude that this maximum pressure differential determined for air transport does not degrade the structural integrity of the containment vessel (Table 2.21a).

2.6.1 Heat

Requirement. An ambient temperature of 38°C (100°F) in still air and insolation, as stated in 10 CFR 71.71(c)(1).

Analysis. An increase in ambient temperature to 38°C (100°F) with insolation will have no effect on the ability of the containment vessel to provide containment.

The maximum normal operating pressure is defined in 10 CFR 71.4 as the maximum gauge pressure that would develop in the containment system in a period of 1 year under the heat conditions specified in 10 CFR 71.71(c)(1). The internal pressure developed under these conditions in the ES-3100 containment vessel is calculated in Appendix 3.5.1 and discussed in Sects. 2.6.1.1 and 3.3.2. As noted in these sections, the internal pressure varies with temperature. Based on the isotopic determination of the proposed contents, a conservative maximum decay heat of 5 W is used for the maximum internal heat load in evaluating the package for NCT (Sect. 3.1.2). The maximum calculated and rounded internal absolute pressure in the containment vessel with insolation and using the bounding case parameters is 210.29 kPa (30.50 psia). The design absolute pressure of the containment vessel is 801.17 kPa (116.20 psia), and the hydrostatic test pressure is 113.55 kPa (164.7 psia). Thus, increasing the internal pressure of the containment vessel to a maximum of 210.29 kPa (30.50 psia) during NCT would have no detrimental effect. Table 2.20 provides a summary of the pressures and temperatures for the various shipping configurations. As discussed in Sect. 2.6.1.4, the containment vessel and closure nut stresses for these pressure conditions are well below the allowable stress values. If the package is exposed to solar radiation at 38°C (100°F) in still air, the conservatively calculated temperatures at the top of the drum, on the top surface of the containment vessel, and on the containment vessel near the O-ring sealing surfaces are 119.38°C (246.88°F), 89.60°C (193.28°F), and 89.53°C (193.15°F), respectively (Sect. 3.3.1 and Table 3.16). For conservatism, the O-ring sealing surface temperature will be assumed to be 89.60°C (193.28°F). Nevertheless, these temperatures are within the service limits of all packaging components, including the O-rings. The normal service temperature range of the EPDM O-rings used in the containment vessel is −40 to 150°C (−40 to 302°F) [Table 2.15].

2.6.1.1 Summary of pressures and temperatures

An ambient temperature of 25°C (77°F) is assumed for the packaging at assembly. Since there are four ventilation holes near the top of the drum, and holes in the liner encapsulating the neutron poison material that are not hermetically sealed, the drum assembly will not become pressurized as the temperature increases. The containment vessel is sealed; thus, the internal pressure will change with temperature. Maximum calculated pressures at various temperatures (Sect. 3.3.1) are listed in Table 2.20.

2.6.1.2 Differential thermal expansion

The drum, inner liners, and containment vessel are all constructed of Type 304 or 304L stainless steel. Radial and vertical expansion among these components will not cause any interferences or thermally induced stresses due to design clearances at assembly. Due to similarities of the coefficient of thermal expansion between Type 304/304L and the containment vessel closure nut material (ASME SA-479), the compression of the O-rings does not change appreciably during the temperature excursion from 25°C (77°F) to the maximum adjusted temperature of 93.33°C (200.00°F).

The Kaolite 1600 or Packcrete insulation and Cat 277-4 material is poured and cast in place during the fabrication of the drum weldment (Drawing M2E801580A002, Appendix 1.3.7). Although some contraction of these materials may occur during curing, it is assumed for analysis purposes that a zero gap will exist between the Kaolite or Packcrete and the bounding drum and mid liner, and a zero gap exists between the Cat 277-4 and the two liners. Due to differences in coefficients of thermal expansion, some radial and axial interferences are expected due to thermal growth of the inner liners. These radial and axial interferences and induced stresses are calculated in DAC M801940-0003 using Packcrete as well as Kaolite 1600. The results are summarized in Table 2.20a. The computed thermal stresses are compared to the allowable stress for the drum material. The ASME BPVC, Sect. VIII, Division 1, UG-22(h) is used to evaluate the stresses in the drum and inner liner walls caused by temperature gradients and differential thermal expansion. An allowable stress of 3 × S as provided by UG-23 is compared to the calculated stresses. The “S” value is taken from the ASME BPVC, Sect. II, Part D,

Subpart 1, Table 1A, for ASME SA-240, Type 304, stainless steel up to 300°F and has a value of 15 ksi (Table 2.12). Therefore, the allowable stress for these calculations is 45 ksi. These results show that the stresses induced by either insulation are minimal and do not reduce the effectiveness of the drum assembly.

The effects of differences in coefficient of thermal expansion between the HEU contents and their associated convenience cans, polyethylene or Teflon FEP bottles are not addressed. No credit is taken for the ability of the convenience can or bottle to maintain its structural integrity during transport. Section 4 of this document assumes the HEU content is in the form of an aerosol and all is available for release; therefore, no credit for the convenience can, polyethylene, nylon, or Teflon bagging, or bottle is taken. Based on assembly clearances and the flexibility of the polyethylene or Teflon FEP bottles, no radial or vertical interferences will develop during NCT. Based on assembly clearances and insignificant differences in the coefficient of thermal expansion between the stainless-steel, tin-plated carbon steel, aluminum, or nickel-alloy convenience cans and the stainless-steel containment vessel, no radial or vertical interferences will develop during NCT testing.

Table 2.20a. Maximum calculated stress in the drum assembly components during NCT hot conditions (100°F, decay heat, solar insolation)

Case [a]	Time from initial solar application (h)	Drum angle	Drum side wall	Drum bottom	Drum inner liner	Drum lid weldment
		Calculated Von Mises stress (ksi) [b, c]				
3	34.85	7.48				
3	2.21		10.40			
3	0.74			5.47		
3	0.08				15.57	
6	0.25					11.82
Allowable stress (3 × S) [d]		45 ksi				

[a] Simulations discussed in DAC M801940-0003.
[b] The values shown are the maximum calculated for either insulation material.
[c] Stress, case number, and time from initial solar application extracted from Table 8-1 of DAC M801940-0003.
[d] Allowable stress up to 300°F where "S" (15 ksi) is from Table 2.12 for the stainless-steel drum assembly components.

2.6.1.3 Stress calculations

During normal conditions, stresses are only imposed by changes in internal pressure of the containment vessel as the temperature varies slowly over the operating range (Table 2.20). Stress levels imposed on the package during NCT are insignificant, as shown in Tables 2.21, 2.21a, and 2.22. These tabulated stresses were determined by multiplying the stress at the design conditions (DAC-M900000-0003 and Table 2.6) by a factor equal to the ratio of operating pressures to design pressures and adding any contribution from the closure nut preload. This methodology is based on linear elastic material behavior. As shown in Sect. 2.6.1.4, all stresses in the containment vessel components are well below the ASME Code allowable stress intensity limits.

2.6.1.4 Comparison with allowable stresses

NCT containment vessel stresses are calculated in accordance with the load combinations listed in Table 2.3 and their values are shown in Tables 2.21, 2.21a, and 2.22. The hot environment, cold environment, reduced external pressure, increased external pressure condition, and vibration normally incident to transport are addressed in Sects. 2.6.1, 2.6.2, 2.6.3, 2.6.4, and 2.6.5, respectively. The fatigue or endurance limits for austenitic stainless steel are normally assumed to be about one-half the ultimate tensile strength (*Design Guidelines for the Selection and Use of Stainless Steel*, pp. 17–18). For Type 304 stainless steel, one-half the ultimate tensile strength is 2.4×10^5 kPa (35,000 psi). Tensile and compressive hoop stresses of the magnitude shown in Tables 2.21, 2.21a, and 2.22 are insignificant compared to the endurance limit of 2.4×10^5 kPa (35,000 psi). As shown in Tables 2.21, 2.21a, and 2.22, the containment vessel stresses during NCT are insignificant. Even at the maximum test temperature and internal pressure (Sect. 3.4.3), the stresses in the containment boundaries were insignificant when compared with the allowable stress intensities shown in Tables 2.4 and 2.5. Corresponding calculated stress regions are shown in Fig. 2.1. Thermal expansion or contraction issues are addressed in Sects. 2.6.1.2 and 2.6.2.

2.6.2 Cold

Requirement. An ambient temperature of −40°C (−40°F) in still air and shade, as required by 10 CFR 71.71(c)(2).

Analysis. The drum is fabricated from Type 304 stainless-steel sheet (Table 2.7). As discussed in Sect. 2.6, stainless steel is excellent for low-temperature service, particularly regarding tensile and impact strength. The thermal insulation (Kaolite 1600 or Packcrete) is a lightweight noncombustible cast refractory made from portland cement and vermiculite. The only moisture available for freezing at −40°C (−40°F) would be moisture that had not been removed during the curing and cool-down phase of fabrication. Because there will be no free water present for freezing and the insulation is a bonded mass of random fibers and cement, the properties of the insulation will not change appreciably. The matrix may become less flexible when subjected to the cold temperature, but the inner liner will remain in the position in which it was placed at the time of fabrication. The Kaolite 1600 or Packcrete insulation and Cat 277-4 materials are poured and cast in place during the fabrication of the drum weldment (Drawing M2E801580A002, Appendix 1.3.7). Although some contraction of these materials may occur during curing, it is assumed for analysis purposes that a zero gap will exist between the Kaolite or Packcrete and the bounding drum and mid liner and a zero gap exists between the Cat 277-4 and the two liners. Due to differences in the coefficient of thermal expansion, some radial and axial interference is expected due to contraction of the outer drum and inner liners. These radial and axial interferences and induced stresses are calculated in DAC M801940-0003 for both Kaolite 1600 and Packcrete. The resulting maximum stresses for these drum components are shown in Table 2.22a. The computed thermal stresses are compared to the allowable stress for the drum material. The ASME BPVC, Sect. VIII, Division 1, UG-22(h) is used to evaluate the stresses in in the drum and inner liner walls caused by temperature gradients and differential thermal expansion. An allowable stress of 3 × S as provided by UG-23 is compared to the calculated stresses. The “S” value is taken from the ASME BPVC, Sect. II, Part D, Subpart 1, Table 1A, for ASME SA-240, Type 304L, stainless steel at -40°F and has a value of 16.7 ksi (Table 2.12). Therefore, the allowable stress for these calculations is 50.1 ksi. These results show that the stresses induced are minimal and do not reduce the effectiveness of the drum assembly.

Table 2.21. ES-3100 containment vessel evaluation for both hot and cold conditions

Stress locations shown in Fig. 2.1	Hot conditions [10 CFR 71.71(c)(1)] containment vessel stress [a] @ 108.94 kPa (15.80 psi) gauge		Cold conditions [10 CFR 71(c)(2)] containment vessel stress [a] @ −24.61 kPa (−3.57 psi) gauge		Allowable pressure, stress, or shear capacity [a]
	kPa (psi) or kg (lb)	M.S. [b]	kPa (psi) or kg (lb)	M.S. [b]	kPa (psi) or kg (lb)
Top flat portion of sealing lid (center of lid)	1.777×10^3 (258)	112	4.015×10^2 (58)	498	1.999×10^5 (29,000) [c]
Closure nut ring (away from threaded portion)	5.323×10^3 (772)	20.3	1.902×10^4 (2759) [d]	5.7	1.081×10^5 (15,675) [c]
Top flat head (sealing surface region)	4.510×10^3 (654)	44	7.088×10^3 (1028) [d]	28	1.999×10^5 (29,000) [c]
Cylindrical section (middle) internal pressure	3.032×10^3 (440)	37			1.120×10^5 (16,250) [e]
Cylindrical section (middle) external pressure			2.461×10^1 (3.57)	31	7.584×10^2 (110) [f]
Cylindrical section (shell to flange interface)	4.220×10^3 (612)	40	9.483×10^2 (138)	177	1.682×10^5 (24,400) [c]
Cylindrical section (shell to bottom interface)	9.115×10^3 (1322)	18	2.060×10^3 (299)	82	1.682×10^5 (24,400) [c]
Body flange threads load, kg (lb)	9.072×10^2 (2000) [d]	29	9.072×10^2 (2000) [d]	29	2.608×10^4 (57,500) [g]
Body flange thread region (under cut region)	2.839×10^4 (4117) [d]	5.9	2.839×10^4 (4117) [d]	5.9	1.682×10^5 (24,400) [c]
Flat bottom head (center)	7.620×10^3 (1105)	22	1.722×10^3 (250)	98	1.682×10^5 (24,400) [c]
Closure nut thread load, kg (lb)	9.072×10^2 (2000) [d]	37	9.072×10^2 (2000) [d]	37	3.353×10^4 (73,911) [g]

[a] Stresses are calculated using pressures, gasket and closure nut preload, and nominal dimensions for all containment vessel components (DAC-M900000-0003). Calculated stresses for external pressure were determined by multiplying the stress at the design conditions by a factor equal to the ratio of external pressure to design pressure plus the contribution from preload. Allowable stress values are taken from Table 2.5 up to 176.7°C (350°F).

[b] Margin of safety = allowable stress/actual stress.

[c] Stress interpreted as the sum of $P_l + P_b$; allowable stress intensity value is $1.5 \times S_m$.

[d] Stress and shear load in these areas is dominated by the 162.7 ± 6.8 N·m (120 ± 5 ft-lb) preload. External pressure component is ignored.

[e] Stress interpreted as the primary membrane stress (P_m); allowable stress intensity value is S_m.

[f] Allowable external pressure [kPa (psi)].

[g] Allowable shear capacity is defined as $0.6 \times S_m \times$ thread shear area for the body material. Thread shear area = 38.026 cm^2 (5.894 $in.^2$). Allowable shear capacity is defined as $1.2 \times S_m \times$ thread shear area for the closure nut material.

Table 2.21a. ES-3100 containment vessel evaluation for internal pressure developed during air transport in accordance with IAEA SSR-6, Paragraph 620

Stress locations shown in Fig. 2.1	Containment vessel stress [a] @ 117.68 kPa (17.07 psi) gauge		Allowable pressure, stress, or shear capacity [a]
	kPa (psi) or kg (lb)	M.S. [b]	kPa (psi) or kg (lb)
Top flat portion of sealing lid (center of lid)	1.920×10^3 (279)	104	1.999×10^5 (29,000) [c]
Closure nut ring (away from threaded portion)	5.751×10^3 (834)	18.8	1.081×10^5 (15675)[c]
Top flat head (sealing surface region)	4.872×10^3 (707)	41	1.999×10^5 (29,000) [c]
Cylindrical section (middle) internal pressure	3.276×10^3 (475)	34	1.120×10^5 (16,250) [e]
Cylindrical section (shell to flange interface)	4.536×10^3 (658)	37	1.682×10^5 (24,400) [c]
Cylindrical section (shell to bottom interface)	9.848×10^4 (1428)	22	1.682×10^5 (24,400) [c]
Body flange threads load, kg (lb)	9.072×10^2 (2000) [d]	29	2.608×10^4 (57,500) [f]
Body flange thread region (under cut region)	2.839×10^4 (4117) [d]	5.9	1.682×10^5 (24,400) [c]
Flat bottom head (center)	8.233×10^3 (1194)	20	1.682×10^5 (24,400) [c]
Closure nut thread load, kg (lb)	9.072×10^2 (2000) [d]	37	3.353×10^4 (73,911) [f]

[a] Calculated stresses were determined by multiplying the stress at the design conditions (Table 2.6) by a factor equal to the ratio of operating pressures to design pressures (independent of pressure direction) plus contributions from preload. Allowable stress values are taken from Table 2.5 up to 176.7°C (350°F).

[b] Margin of safety = allowable stress/actual stress.

[c] Stress interpreted as the sum of $P_l + P_b$; allowable stress intensity value is $1.5 \times S_m$.

[d] Stress and shear load in these areas are dominated by the 162.7 ± 6.8 N·m (120 ± 5 ft-lb) preload.

[e] Stress interpreted as the primary membrane stress (P_m); allowable stress intensity value is S_m.

[f] Allowable shear capacity is defined as $0.6 \times S_m \times$ thread shear area for the body material. Thread shear area = 38.026 cm^2 (5.894 $in.^2$). Allowable shear capacity is defined as $1.2 \times S_m \times$ thread shear area for the closure nut material.

Table 2.22. NCT ES-3100 containment vessel stress compared to the allowable stress at reduced and increased external pressures

Stress locations shown in Fig. 2.1	Reduced external pressure [10 CFR 71.71(c)(3)] containment boundary stress [a] @ 185.29 kPa (26.87 psi) gauge		Increased external pressure [10 CFR 71.71(c)(4)] containment boundary stress [a] @ −63.26 kPa (−9.18 psi) gauge		Allowable pressure, stress, or shear capacity [a]
	kPa (psi) or kg (lb)	M.S. [b]	kPa (psi) or kg (lb)	M.S. [b]	kPa (psi) or kg (lb)
Top flat portion of sealing lid (center of lid)	3.023×10^3 (438)	66	1.033×10^3 (150)	194	1.999×10^5 (29,000) [c]
Closure nut ring (away from threaded region)	9.055×10^3 (1313)	11.9	1.902×10^4 (2759) [d]	5.7	1.081×10^5 (15675) [c]
Top flat head (sealing surface region)	7.671×10^3 (1113)	26	7.088×10^3 (1028) [d]	28	1.999×10^5 (29,000) [c]
Cylindrical section (middle) internal pressure	5.157×10^3 (748)	22			1.120×10^5 (16,250) [e]
Cylindrical section (middle) external pressure			6.329×10^1 (9.18)	12	7.584×10^2 (110) [f]
Cylindrical section (shell-to-flange interface)	7.141×10^3 (1036)	24	2.438×10^3 (354)	69	1.682×10^5 (24,400) [c]
Cylindrical section (shell-to-bottom interface)	1.550×10^4 (2249)	11	5.297×10^3 (768)	32	1.682×10^5 (24,400) [c]
Body flange threads load, kg (lb)	9.980×10^2 (2200) [d]	26	9.072×10^2 (2000) [d]	29	2.608×10^4 (57,500) [g]
Body flange thread region (under cut region)	3.101×10^4 (4498) [d]	5.4	2.839×10^4 (4117) [d]	5.9	1.682×10^5 (24,400) [c]
Flat bottom head (center)	1.296×10^4 (1880)	13	4.428×10^3 (642)	38	1.682×10^5 (24,400) [c]
Closure nut thread load, kg (lb)	9.980×10^2 (2200) [d]	34	9.072×10^2 (2000) [d]	37	3.353×10^4 (73,911) [g]

[a] Stresses are calculated using pressures, gasket and closure nut preload, and nominal dimensions for all containment vessel components (DAC-M900000-0003). Calculated stresses for external pressure were determined by multiplying the stress at the design conditions by a factor equal to the ratio of external pressure to design pressure plus the contribution from preload. Allowable stress values are taken from Table 2.5 up to 176.7°C (350°F).

[b] Margin of safety = allowable stress/actual stress.

[c] Stress interpreted as the sum of $P_l + P_b$; allowable stress intensity value is $1.5 \times S_m$.

[d] Stress and shear load in these areas is dominated by the 162.7 ± 6.8 N·m (120 ± 5 ft-lb) preload. External pressure component is ignored.

[e] Stress interpreted as the primary membrane stress (P_m); allowable stress intensity value is S_m.

[f] Allowable external pressure [kPa (psi)].

[g] Allowable shear capacity is defined as $0.6 \times S_m \times$ thread shear area for the body material. Thread shear area = 38.026 cm^2 (5.894 $in.^2$). Allowable shear capacity is defined as $1.2 \times S_m \times$ thread shear area for the closure nut material.

Table 2.22a. Maximum calculated stress in the drum assembly components during NCT cold conditions (-40°F, no decay heat, no solar insolation)

Case [a]	Time from initial solar application (h)	Drum angle	Drum side wall	Drum bottom	Drum inner liners	Drum lid weldment
		Calculated Von Mises stress (ksi) [b, c]				
7	0.25	3.11				
8	1.94		9.61			
8	0.74			4.54		
8	0.74				16.09	
8	0.08					7.77
Allowable stress (3 × S) [d]		50.1 ksi				

[a] Simulations discussed in DAC M801940-0003.
[b] The values shown are the maximum calculated for either insulation material.
[c] Stress, case number, and time from initial solar application extracted from Table 8-1 of DAC M801940-0003.
[d] Allowable stress up at -40°F where "S" (16.7 ksi) is from Table 2.12 for the stainless-steel drum assembly components.

The containment vessel is fabricated from Type 304L stainless steel, which is suitable for low-temperature service, particularly regarding impact resistance. This material does not show a transition from ductile to brittle failure at this temperature [−40°C (−40°F)]. The ASME Code, Sect. III, Subsection NB-2311, exempts impact testing of Type 304L stainless steels. The Izod impact strength for Type 304 stainless steel is 149.14 N·m (110 ft-lb) from 21.11 to −195.5°C (70 to −320°F). The tensile strength increases from ~4.826×10^5 to 1.696×10^6 kPa (70,000 to 246,000 psi) between 21.11 and −195.5°C (70 and −320°F), and the yield strength increases ~10% over the same range. NRC Regulatory Guide 7.6, Part B, states, "these designs were made of austenitic stainless steel which is ductile even at low temperatures. Thus, this guide does not consider brittle fracture." The drum, inner liner, top plug, and containment vessel are made from austenitic stainless steel. Similarly, the containment vessel closure nut material is a galling and wear resistant austenitic stainless steel. Therefore, brittle fracture of these structural materials at −40°C (−40°F) is not possible.

The specified O-rings used in the containment vessel have a continuous service temperature range of −40 to 150°C (−40 to 302°F) [Table 2.15]. The low temperature extreme has been verified by compliance testing of TU-2 (Sect. 2.7.1.2). TU-2 was pre-chilled to a nominal temperature of −40°C (−40°F). This was accomplished by placing the units in an environmental chamber in Building 5800 at ORNL and initially setting the chamber control to −56.7°C (−70°F) for 24 h. After this initial period, the control on the environmental chamber was set to −42.8°C (−45°F) for at least 48 h. Prior to the initiation of structural testing of this unit, it was removed from the environmental chamber and placed in an insulated box and transported to NTRC for testing.

As previously noted, the containment vessels will be assembled for shipment in a temperature environment of ~25°C (77°F). If the package should be exposed to −40°C (−40°F) for an extended period, all components will equalize near this low temperature. The absolute internal pressure inside the containment vessel would decrease to a pressure of 76.74 kPa (11.13 psi), assuming no decay heating (Table 2.20). Therefore, the pressure differential across the containment vessel at −40°C (−40°F) is −24.61 kPa (−3.57 psia) {[76.739 − 101.35 kPa] (11.13 − 14.7 psia)}. Due to similarities between the coefficient of thermal expansion for Type 304 or 304L stainless steel and the containment vessel closure nut material (ARMCO NITRONIC, ASME SA-479), the compression of the O-rings does not change appreciably during the temperature excursion from 25°C (77°F) to −40°C (−40°F). The calculated stresses shown in Tables 2.21 and 2.21a were determined by multiplying the stress at the design

conditions (DAC-M900000-0003 and Table 2.6) by a factor equal to the ratio of operating pressure to design pressure and adding any contribution from the closure nut preload. This methodology is based on linear elastic material behavior. As shown in Sect. 2.6.1.4, all stresses in the containment vessel components are well below the ASME Code allowable stress intensity limits. As demonstrated by the information presented above, the packaging is acceptable for NCT at −40°C (−40°F).

2.6.3 Reduced External Pressure

Requirement. An absolute external pressure of 25 kPa (3.5 psi) is required by 10 CFR 71.71(c)(3).

Analysis. Reducing the absolute external pressure from ambient pressure to 25 kPa (3.5 psi) will have no effect on the drum assembly because the plastic plugs and aluminum tape covering the ventilation holes for the Cat 277-4 will allow the internal pressure of the drum assembly to equalize. This reduced pressure and a maximum internal pressure produces the maximum pressure differential across the containment vessel of 185.29 kPa (26.87 psi) [210.29 − 25]. The containment vessel is designed and fabricated in accordance with Sects. III and IX of the ASME Code for an internal pressure differential of 699.82 kPa (101.5 psi) as shown in DAC-M900000-0003. A summary of the resulting stress intensities at various locations identified in Fig. 2.1 on the containment vessel in comparison with the ASME Code allowable limits for this condition is shown in Table 2.22. These tabulated stresses were determined by multiplying the stress at the design conditions (DAC-M900000-0003 and Table 2.6) by a factor equal to the ratio of operating pressures to design pressures and adding any contribution from the closure nut preload. This methodology is based on linear elastic material behavior. As shown in Table 2.22, all stresses in the containment vessel components are well below the ASME Code allowable stress intensity limits. Therefore, the ES-3100 packaging is acceptable for NCT at an absolute external pressure of 25 kPa (3.5 psi).

2.6.4 Increased External Pressure

Requirement. An absolute external pressure of 140 kPa (20 psi) is required by 10 CFR 71.71(c)(4).

Analysis. Increasing the absolute external pressure from ambient pressure to 140 kPa (20 psi) would have no effect on the drum assembly because the plastic plugs and aluminum tape covering the ventilation holes for the Cat 277-4 will allow the internal pressure of the drum assembly to equalize. At this increased external pressure, the maximum pressure differential across the containment vessel would be −63.26 kPa (76.74 − 140 kPa) [−9.18 psi], assuming the vessel's absolute pressure and temperature to be 76.74 kPa (11.13 psi) and −40°C (−40°F), respectively. Each containment vessel is designed and fabricated in accordance with Sects. III and IX of the ASME Code for a minimum external pressure of 150 kPa (21.7 psi) gauge. A comparison of the resulting stress intensities at various locations on the containment vessel (Fig. 2.1) with the ASME Code allowable limits for this condition is shown in Table 2.22. These tabulated stresses were determined by multiplying the stress at the design conditions (DAC-M900000-0003 and Table 2.6) by a factor equal to the ratio of operating pressures to design pressures and adding any contribution from the closure nut preload. This methodology is based on linear elastic material behavior. As shown in Table 2.22, all stresses in the containment vessel components are well below the ASME Code allowable stress intensity limits. Therefore, the ES-3100 packaging is acceptable for NCT at an external absolute pressure of 140 kPa (20 psi).

2.6.5 Vibration

Requirement. Vibration normally incident to transportation is required by 10 CFR 71.71(c)(5).

Analysis. Vibration testing on a prototypical ES-3100 package (TU-4) was conducted in accordance with the ES-3100 test plan and documented in the test report (ORNL/NTRC-013). Testing was conducted with the package restrained as shown in Fig. 2.3. The containment vessel was assembled with the mock-up content weighing 49.90 kg (110 lb). The total weight of the test unit was 201.8 kg (445 lb). The unit was subjected to an endurance test with random vibrations modeled after the power spectral density plot for the SGT vibration envelope in the vertical axis (Cap 2002). At this level of vibration intensity, the test compares with MIL-STD-810F. MIL-STD-810F is a standard random vibration test for basic transportation vibrations generated by a large truck or tractor-trailer combination. MIL-STD-810F defines 60 min of testing as equal to 1609 km (1000 miles) of common carrier transportation. Assuming that the two random vibration tests are similar in intensity, TU-4 had ~6436 km (4000 miles) of simulated random vibration testing. Based on a nominal shipping distance of 3218 km (2000 miles), TU-4 was subjected to a test that was approximately two times more severe than that required by 10 CFR 71.71(c)(5). As shown by the following paragraphs, containment, shielding effectiveness, and subcriticality were maintained even when the package was subjected to such an arduous environment.

The test was run at ~22.8°C (73°F) rather than at the high or low temperatures specified for NCT. This was reasonable because the thermal coefficients of expansion of the flange and closure nut materials are very close. Therefore, the temperature extremes would not have a significant effect on the closure tightness.

Summarizing 10 CFR 71.43(f), the tests and conditions of NCT shall not substantially reduce the effectiveness of the packaging to withstand HAC sequential testing. The effectiveness of the ES-3100 to withstand HAC sequential testing is not diminished through application of the tests and conditions stipulated in 10 CFR 71.71. The justification for this statement is provided by physical testing of both the ES-2M (GAB1296-2) and ES-3100 (ORNL/NTRC-013) test packages. Due to the similarities in design, fabrication, and construction materials of the ES-2M and the ES-3100 packages, the physical characteristics of the Kaolite 1600 and Packcrete will hold true for both designs. The integrity of the Kaolite 1600 and Packcrete is not significantly affected by the NCT vibration and 1.2-m drop tests. Prior to testing the ES-2M design, each test unit was radiographed to determine the integrity of the Kaolite 1600 impact and insulation material. Following casting of the material inside the drum, some three-dimensional curving cracks were seen in some packages near the thinner top sections from the bottom of the liner to the bottom drum edge. After vibration testing, radiography of the ES-2M TU-4 showed that the lower half of the impact limiter was broken into small pieces. In order to evaluate these findings, TU-4 was reassembled and subjected to HAC sequential testing. After vibration and impact testing, many three-dimensional curving cracks were seen around the impact areas, and the inner liner was visibly deformed. Nevertheless, TU-4 maintained the adequate spacing required for shielding effectiveness and subcriticality. Temperatures at the containment boundary were also similar to other packages not subjected to vibration testing prior to HAC testing. No inleakage of water was recorded following immersion. Additionally, TU-4 of the ES-3100 test series was subjected to tests and conditions stipulated in 10 CFR 71.71(c)(5) through (c)(10), excluding (c)(8). Following completion of both the NCT and HAC tests, the containment vessel was removed, and a full-body helium leak test was conducted to the leaktight criterion ($\leq 2 \times 10^{-7}$ cm^3/s) in accordance with ANSI N14.5-1997.



Note: MD-1 test unit removed during actual testing.

Fig. 2.3. ES-3100 vibration testing arrangement.

Following compliance testing of the ES-3100 shipping package, minor changes were incorporated into the proposed design as described in Sect. 2.7.1.5. During the vibration test, the shipping package is restrained from movement in the vertical direction with a tie-down arrangement similar to that used on an SGT for a single package. Based on the acceleration spectral density presented in the letter from J. S. Cap to G. W. Crowder (Cap 2002), the largest contributor to shipping package motion is in the vertical direction. Since the containment vessel and contents are not restrained within the inner liner cavity, the containment vessel is free to bounce up and down. In the vertical direction, the top plug and the bottom of the inner liner restrict the movement of this vessel. Because the inner liner contour has not changed with respect to the containment vessel, and there are clearances between the containment vessel flange and the inner liner in the vertical direction, the cast neutron poison and inner liner are not directly impacted by the movement of the containment vessel. Therefore, changes in the neutron poison and minor radial dimension changes in the mid liner will not affect the outcome of vibration testing. Based on the success of the previously tested units and the fact that these proposed changes will have little or no effect on testing, vibration normally incident to transport does not reduce the effectiveness of the packaging during HAC testing. Thus, the requirements of 10 CFR 71.43(f) are satisfied.

Procedures will be followed to ensure that the packaging is assembled as specified (Chap. 7). The drum, lid, and fasteners are refurbished as required before each use. The ⅝-in.–diam flange nuts

on the drum are torqued to 40.67 N·m (30 ft-lb) nominal. The closure nut on the containment vessel is torqued to 162.7 N·m (120 ft-lb) nominal. The package is acceptable for vibration normally incident to transport in an SGT.

2.6.6 Water Spray

Requirement. A water spray that simulates exposure to rainfall of ~5.08 cm (2 in.) per hour for at least 1 h is required by 10 CFR 71.71(c)(6).

Analysis. A water spray of 5.08 cm (2 in.) per hour was directed from above and around the periphery of the ES-3100 TU-4 for a minimum of 1 h as shown in Fig. 2.4. The drum had four plastic plug-sealed ventilation holes near the top that prevent water from entering the insulation cavity. Aluminum duct tape covering the installation holes in the mid liner prevents water from entering the neutron poison cavity. There was evidence of water leakage into the volume between the containment vessel and the inner liner at the conclusion of the test. Water entered this cavity through the holes provided in the lid for the TID lugs, but none penetrated the containment boundary. The criticality analysis shown in Chap. 6 was conducted with moderation by water to the most reactive credible extent and close full reflection of the containment system by water on all sides. Because the package remained subcritical under these conditions, the ES-3100 package is acceptable for use under the water spray conditions of NCT.



Fig. 2.4. Water spray test arrangement for TU-4.

2.6.7 Free Drop

Requirement. A free drop of 1 m (4 ft) onto a flat, essentially unyielding, horizontal surface in a position for which maximum damage is expected is required by 10 CFR 71.71(c)(10). This test shall be made between 1½ and 2½ h after the conclusion of the water spray test (Sect. 2.6.6).

Analysis. The ES-3100 test package, TU-4, previously sprayed with water (Sect. 2.6.6) with a measured gross weight of 201.85 kg (445 lb) and containing a content weight of 49.90 kg (110 lb), was tested in accordance with 10 CFR 71.71(c)(7). The temperature and pressure at the time of the drop test was 22.8°C (73°F) and ~101.35 kPa (14.70 psi), respectively. As discussed in Sect. 2.6, the response of the test package would not have been significantly different if it had been tested at the extremes of the temperature range dictated by 10 CFR 71.71(b) with the containment vessel at the maximum normal operating pressure.

The essentially unyielding surface used for this test was the indoor drop test pad at the NTRC. All 9-m (30-ft) drop and crush tests were conducted at the outside drop pad at the NTRC. The indoor pad consists of a 5.08-cm (2-in.)–thick steel plate embedded inside a reinforced concrete pad ~127-cm (50-in.) thick. The outside drop pad consists of a 10.16-cm (4-in.)–thick steel plate embedded inside a reinforced concrete pad ~167.6-cm (66-in.) thick. An article has been prepared by the NTRC staff to describe the integrity of these test pads (Shappert 1991).

TU-4 was dropped from 1.2 m (4 ft) in a vertical position, with the drum's top initially striking the unyielding surface (Fig. 2.5). This attitude was assumed to be the most vulnerable orientation for producing damage to the sealing surfaces of the containment vessel and for introducing buckling into the cylindrical portion of the containment vessel body. The long axis of the drum was 0° from vertical. The test package made a free fall, with initial contact on the drum's lid. Damage consisted of shortening the drum height from 110.81 cm (43⅝ in.) to 110.49 cm (43½ in.) There were no breaks in the drum assembly. Additional details and sketches can be obtained from the test report (ORNL/NTRC-013). Based on the HAC analytical structural deformation results shown in Sect. 2.7.8, the drop test damage would be nearly identical had this test been conducted on the proposed configuration using the Cat 277-4 neutron absorber. On this basis, the ES-3100 package meets the requirements of 10 CFR 71.71(c)(7).

In addition to the tests conducted on TU-4, all test units (except TU-6) were initially subjected to a free drop of 1.2 m (4 ft) onto a flat, essentially unyielding horizontal surface. As shown in Table 2.18, the orientations for these drops were two drops bottom to lid slapdown with the long axis of the drum ~12° from parallel to the drop pad; one drop with the long axis of the test unit parallel to the drop pad; two drops with the center of gravity drop over the drum/lid interface with the long axis of the drop rotated ~24.6° from perpendicular to the drop pad; and one with the long axis of the drum perpendicular to the drop pad. Package description, damage from testing, and drop orientation concerns are discussed in Sect. 2.7.1 for each test unit. Following the 1.2-m (4-ft) drop, each of these test units was subjected to the full HAC sequential test battery. The robustness of the ES-3100 containment vessel was demonstrated through whole boundary helium leak testing to $\leq 2.0 \times 10^{-7}$ cm^3/s (leaktight). This helium leak test eclipses the required criteria for both NCT and HAC based on the bounding case contents. Visual inspection of the containment boundaries showed no distortion or deformation from testing. Therefore, based on the various drop orientations, the severity of the HAC test sequence, and the testing conducted on TU-4, the ES-3100 shipping package has been shown to meet the requirements of 10 CFR 71.43, 71.51(a)(1), and 71.71(c)(7).



Fig. 2.5. NCT free drop test on TU-4.

2.6.8 Corner Drop

Requirement. 10 CFR 71.71(c)(8) requires a free drop onto each corner of the package in succession, or in the case of a cylindrical package, onto each quarter of each rim, from a height of 0.3 m (1 ft) onto a flat, essentially unyielding, horizontal surface. This test applies only to fiberboard, wood, or fissile material rectangular packages not exceeding 50 kg (110 lb) and fiberboard, wood, or fissile material cylindrical packages not exceeding 100 kg (220 lb).

Analysis. This test is not applicable because the range of package weights for the ES-3100 [146.88 kg (323.79 lb) to 187.81 kg (414.05 lb)] exceeds the weight restrictions defined in the preceding paragraph for fissile material cylindrical packages.

2.6.9 Compression

Requirement. Title 10 CFR 71.71(c)(9) requires that packages weighing up to 5000 kg (11,000 lb) must be subjected for a period of 24 h to a compressive load applied uniformly to the top and bottom of the package in the position in which the package would normally be transported. The compressive load must be the greater of the following:

1. the equivalent of five times the weight of the package or

2. the equivalent of 13 kPa (2.0 psi) multiplied by the vertically projected area of the package.

Analysis. The proposed maximum weight of the ES-3100 shipping package is calculated to be 187.81 kg (414.05 lb) [Table 2.8]. As shown on Drawing M2E801580A010 (Appendix 1.3.7), the data plate states that the maximum gross weight of the ES-3100 shipping package is 190.51 kg (420 lb). In accordance with Item 1 above, the minimum compressive load would be 5 × 190.51 kg or 952.55 kg (2100 lb). The vertically projected area of the package is 1891 cm^2 (293.16 $in.^2$) or the area of the lid weldment. Based on Item 2 above, the minimum compressive load would be 13 kPa × 1891 cm^2 or 250.72 kg (552.75 lb). Therefore, the approach stipulated in Item 1 above represents the greatest compressive load for this configuration. A conservative 1043 kg (2300 lb) compressive load was uniformly applied to the top and bottom of TU-4 for at least 24 h (Fig. 2.6). The test package had been sprayed with water as noted in Sect. 2.6.6. No change in height or diameter of the test unit resulted from the test.

Due to the design of the ES-3100 drum lid, the applied compressive load was distributed equally around the lid and supported primarily through the outer drum contour and Kaolite 1600 substrate. Little or no load is transferred to the neutron poison (BoroBond4 in TU-4) and internal liners. Therefore, the changes in the design of the liners and neutron poison proposed for this shipping package should not impact the outcome resulting from compression testing. Based on the results of compliance testing of TU-4, the insignificant changes in the design, and the possible substitution of Kaolite 1600 with Packcrete the ES-3100 package meets the requirements of 10 CFR 71.71(c)(9).



Fig. 2.6. Compression test on TU-4.

2.6.10 Penetration

Requirement. Impact of the hemispherical end of a vertical steel cylinder of 3.2-cm (1.25-in.) diam and 6-kg (13-lb) mass dropped from a height of 1 m (40 in.) onto the exposed package surface that is expected to be most vulnerable to puncture is required by 10 CFR 71.71(c)(10). The long axis of the cylinder must be perpendicular to the package surface. **Analysis.** A 6-kg (13-lb) steel cylinder was dropped from 1 m (40 in.) onto the surface of TU-4, which was previously subjected to water spray, free drop, vibration and compression tests. The penetration bar impacted the side of the drum at the welded seam near the package's center of gravity. The bar did not penetrate the drum, but an indentation 0.64-cm (0.25-in.) deep was recorded at the drum seam weld as shown in Fig. 2.7. The magnitude of this indentation is insignificant. Based on the HAC analytical structural deformation results shown in Sect. 2.7.8, the magnitude of indentation would be nearly identical had this test been conducted on the proposed configuration using the Cat 277-4 neutron absorber. On this basis, the ES-3100 package meets the requirements of 10 CFR 71(c)(10).



Fig. 2.7. Penetration test damage on TU-4.

2.7 HYPOTHETICAL ACCIDENT CONDITIONS

This section demonstrates compliance with 10 CFR 71.73, "Hypothetical Accident Conditions." It shows that the package will experience no loss in shielding effectiveness or spacing and no release of radioactive content or leakage of water into the containment vessel during HAC. A summary of the tests and analyses conducted on the ES-3100 configuration is shown in Table 2.23. Original compliance testing was conducted on test units fabricated using Kaolite 1600 as the thermal barrier and impact-absorbing material. Due to the lack of Kaolite 1600 material from the manufacturer that meets specified density requirements, a substitute inorganic castable refractory material, identified as Packcrete, was developed. To confirm the thermal-insulating and impact-limiting material equivalency of Packcrete to the previously used Kaolite 1600 material, numerous material properties were evaluated and the results are documented in RP 802282-0002. These material tests have shown that the Packcrete is functionally equivalent to Kaolite 1600. Therefore, the test results and conditions analyzed in this section using Kaolite 1600 are also applicable to Packcrete.

Title 10 CFR 71.51 requires that the ES-3100 package satisfy the standards under HAC specified in 10 CFR 71.73. For the tests specified in 10 CFR 71.73, six test packages were subjected to the five sequential tests: free drop, crush, puncture, thermal, and immersion. The configuration for TU-1 through TU-4 used full-scale shipping packages with steel mock-ups similar to the maximum contents to be shipped in the ES-3100 configuration. TU-5, also a full-scale shipping package, was dropped with a mock-up of the lightest component proposed for shipping at that time. All test units were first subjected to the NCT free drop from 1.2 m (4 ft). In addition to the 1.2-m (4-ft) drop, TU-4 was also subjected to the full battery of tests in accordance with applicable paragraphs of 10 CFR 71.71(c)(5) through (c)(10) except (c)(8). These preliminary tests were conducted to provide evidence that the ES-3100's ability to withstand HAC testing was not degraded through NCT testing. Demonstration of the ES-3100 package's ability to satisfy the requirements of HAC is provided in the following sections. A summary of the test results is provided in each area of Sect. 2.7; details are documented in the test report (ORNL/NTRC-013).

Although physical testing of the ES-3100 containers was performed generally at or near room temperature except for TU-2, the effectiveness of the Kaolite insulating material at various temperature extremes was examined through the use of laboratory testing and structural analysis of a similar package, the ES-2LM (DAC-EA-900000-A002). For low-temperature service, Kaolite specimens were tested at −28.89 and −40°C (−20 and −40°F). These tests showed little change in the response of the material as compared to room temperature. Furthermore, structural analyses for bounding soft and stiff material cases were run. The Kaolite 1600 data used in these bounding analyses were from laboratory experiments that used a heavily cured sample (stiff) and a sample to which borax had been added (soft) [Y/DW-1661]. Following the production run for the ES-2100 and DPP-2 shipping containers, new casting specimens were available for compression testing. In order to reduce the total cost of Kaolite testing, specimens were tested to approximately −40°C (−40°F) to cover both the cold conditions stipulated in 10 CFR 71.71(c)(2) and the −29°C (−20°F) temperature stipulated in 10 CFR 71.71(b)(1) and at 38°C (100°F). The results of Kaolite specimen testing are documented in Y/DW-1890 and Y/DW-1972. Upon further review of the data, the new test data was somewhat stiffer in the cold/high-density specimens than the data previously used in Y/DW-1972. Therefore, in order to encompass the extremes of all existing data, additional drop simulation sequences using the new bounding curves have been conducted on the ES-3100 package as documented in DAC-EA-801699-A001 and DAC-EA-801699-A002. In addition to the analytical effort, TU-2 was pre-chilled to a nominal temperature of −40°C (−40°F). This was accomplished by placing the unit in an environmental chamber in Building 5800 at ORNL and initially setting the chamber control to −56.7°C (−70°F) for 24 h. After this initial period, the control on the environmental chamber was set to −42.8°C (−45° F) for at least 48 h. Prior to the initiation of structural testing of this unit, the unit was removed from the environmental chamber and placed in an insulated box

and transported to the NTRC. High-temperature [up to 38°C (100°F)] behavior was not addressed. However, in light of the fact that the insulation material is typically used as a cast refractory insulation in furnace applications and that structural tests were performed in the range of 20.8 to 30.6°C (69.4 to 87°F) or just 7.4 to 17.2°C (13 to 30°F) below the high-temperature limit, it is not anticipated that any decline in impact absorption would be detrimental at 38°C (100°F).

Extensive computer impact simulation and analysis was conducted using LS-DYNA software. The results are documented in DAC-EA-801699-A001 and DAC-EA-801699-A002. Early in the design phase, simulation was used to determine areas of large structural deformation and stress concentrations. Prior to the compliance testing in accordance with 10 CFR 71.71, simulation was used to determine the drop orientation that would cause the most structural damage to the drum assembly and thereby propose a worst-case scenario for potential breeching of the containment vessel. Prior drop test programs have shown the slapdown orientation to cause the most structural degradation of a drum-style container. Computer software LS-DYNA was used to simulate a 9-m (30-ft) drop orientation at a slapdown angle of 12° with a friction factor of $\mu = 0.0$ as calculated using the computer code Slapdown, Version 05.20.93. Slapdown calculated that no matter what friction factor was assumed, the lid-end velocity peaked at ~14° (DAC-EA-801699-A001, Appendix 6.11). The maximum lid-end velocity versus the slapdown angle is presented in Fig. 6.11.6 of DAC-EA-801699-A001, and the logic for the development of this figure is explained in Appendix 6.11 of DAC-EA-801699-A001. Because of the mitigating effects of the length-to-diameter ratios and the relative closeness of the 12° increase in velocity to the maximum values (shown in DAC-EA-801699-A001, Fig. 6.11.6), the 12°slapdown is considered the worst-case slapdown. Based on the correlation of data obtained from preliminary drop tests of the similar ES-2M configuration and computer-simulated drops, several orientations were eliminated from the drop test matrix (Table 2.23). Several other impact simulations have been conducted using a wide range of material properties for the impact limiter material (Kaolite 1600) to determine the variance in structural deformation. Results of these simulations are documented in DAC-EA-900000-A002, Sect. 5.6. Although the analysis shows some variance, the magnitude of difference was not large enough to degrade the performance of the drum assembly and containment boundary. Due to the similarities in design, fabrication, and material used in construction of the shipping packages, these same results would hold true for the ES-3100 package with Kaolite 1600 or Packcrete.

Title 10 CFR 71.73(b) requires that the HAC tests, except for the water immersion tests, be conducted at the most unfavorable ambient temperature within the range of −29 to 38°C (−20 to 100°F). This requirement was previously discussed in Sect. 2.6 for NCT, in which it was concluded that the tests performed at 70 to 90°F ambient temperatures should provide essentially the same results, except for thermal, as those made at any ambient temperature between −29 to 38°C (−20 to 100°F). Buckling failures are not anticipated for this package design. This assumption is based on the fact that no evidence of buckling occurred when the package was subjected to the compression test in accordance with 10 CFR 71.71(c)(9); the water immersion tests in accordance with 10 CFR 71.73(c)(5) and 71.73(c)(6); and the 1.2- and 9-m drop test conducted on TU-4. ASME Code calculations further substantiate that buckling failures of the containment vessel are not anticipated for this package design (DAC-M900000-0003).

Title 10 CFR 71.73(b) states that the HAC initial pressure within the containment vessel during testing shall be considered as the maximum internal normal operating pressure. The internal pressures in the ES-3100 containment vessel at various temperatures for NCT are discussed in Sects. 3.3.1 and 3.3.2 and tabulated in Table 2.20. The maximum normal absolute operating pressure due to insolation and the bounding case parameters is 210.29 kPa (30.50 psia) for the containment vessel. This pressure is well below the design internal gauge pressure of 699.82 kPa (101.5 psi). Increasing the internal pressure in the containment vessel to 210.29 kPa (30.50 psia) before free drop (Sect. 2.7.1), crush (Sect. 2.7.2), puncture (Sect. 2.7.3), or water immersion (Sect. 2.7.5) testing would have no detrimental effect on the containment vessel's structural integrity due to the low stresses shown in Tables 2.21 and 2.21a. Temperature and pressure increases in the containment vessel due to the compliance thermal tests are discussed and evaluated in Sects. 2.7.4 and 3.4.3. A summary of these pressures is presented in Appendix 3.5.2.

Summarizing 10 CFR 71.43(f) and 71.55(d)(4), the tests and conditions of NCT will not substantially reduce the effectiveness of the packaging to withstand HAC sequential testing. The effectiveness of the ES-3100 to withstand HAC sequential testing is not diminished through application of the tests and conditions stipulated in 10 CFR 71.71. The justification for this statement is provided by physical testing of both the ES-2M and ES-3100 test packages, and the analytical structural deformation predicted in DAC-EA-801699-A001 and DAC-EA-801699-A002 (summarized in Sect. 2.7.8). Due to the similarities in design, fabrication, and material used in construction of both the ES-2M and the ES-3100 package, the physical characteristics of the Kaolite 1600 will hold true for both designs. The integrity of the Kaolite 1600 is not significantly affected by the NCT vibration and 1.2-m (4-ft) drop tests. Prior to testing the ES-2M design, each test unit was radiographed to determine the integrity of the Kaolite 1600 impact and insulation material. Following casting of the material inside the drum, some three-dimensional curving cracks were seen in some packages near the thinner top sections from the bottom of the liner to the bottom drum edge. After vibration testing, radiography of the ES-2M TU-4 showed that the lower half of the impact limiter was broken into small pieces. In order to evaluate these findings, TU-4 was reassembled and subjected to HAC sequential testing. After vibration and impact testing, many three-dimensional curving cracks were seen around the impact areas, and the inner liner was visibly deformed. Nevertheless, the ES-2M TU-4 maintained the adequate spacing required for shielding effectiveness and subcriticality. Temperatures at the containment boundary were also similar to other packages not subjected to vibration testing prior to HAC testing. No inleakage of water was recorded following immersion. Additionally, TU-4 of the ES-3100 test series was subjected to tests and conditions stipulated in 10 CFR 71.71(c)(5) through (c)(10), excluding (c)(8). Following completion of these NCT tests, the test unit was subjected to the full HAC test battery. Following these tests, the containment vessel was removed and subjected to a full-body helium leak test. Criteria for a leaktight condition were achieved. Based on the success of these units, vibration normally incident to transport does not reduce the effectiveness of the packaging during HAC testing. Thus, the requirements of 10 CFR 71.43(f) and 71.55(d)(4) are satisfied.

Table 2.23. Test and analysis summary for the ES-3100 package [a]

Container	NCT water spray, compression, penetration, vibration	1.2-m (4-ft) drop	9-m (30-ft) drop and crush test				1.2-m (4-ft) puncture drop	Preheat >38°C (100°F)	HAC thermal burn test	O-ring cavity leak check (operational)	Full-body helium leak test [b]	0.9-m (3-ft) immer. test	15-m (50-ft) immer. test
			Top drop	Center of gravity over lid corner	Bottom to lid slapdown	Side drop							
TU-1		1—YES			12° 2—YES		3—YES [c]	4—YES	5—YES	6−YES $\leq 1.0 \times 10^{-4}$ ref. cm^3/s	7—YES 1.6×10^{-7} cm^3/s	8—YES	
TU-2		1—YES				2—YES	3—YES	4—YES	5—YES	6−YES $\leq 1.0 \times 10^{-4}$ ref. cm^3/s	7—YES Pulsing between 1.0×10^{-9} to 1.4×10^{-6} cm^3/s	8—YES	
TU-3		1—YES		24.6° 2—YES			3—YES	4—YES	5—YES	6−YES $\leq 1.0 \times 10^{-4}$ ref. cm^3/s	7—YES 1.0×10^{-7} cm^3/s	8—YES	
TU-4	YES	1—YES	2—YES				3—YES	4—YES	5—YES	6−YES $\leq 1.0 \times 10^{-4}$ ref. cm^3/s	7—YES 2.0×10^{-7} cm^3/s	8—YES	
TU-5		1—YES			12° 2—YES		3—YES	4—YES	5—YES	6−YES $\leq 1.0 \times 10^{-4}$ ref. cm^3/s	7—YES 3.1×10^{-8} cm^3/s	8—YES	
TU-6										1−YES $\leq 1.0 \times 10^{-4}$ ref. cm^3/s			2—YES
Impact analysis		YES	YES	YES	YES	YES							
Thermal analysis	YES [d]							YES	YES [d]				

[a] Numbering refers to sequence of activities.
[b] Full-body helium leak test conducted following HAC testing. Leakage value recorded after 20 min of the test period.
[c] TU-1 was puncture tested in four different orientations.
[d] Thermal analysis was conducted to determine time for cooling to −40°C and to evaluate the application of decay heating and insolation during the cool-down phase.

2.7.1 Free Drop

Requirement. A free drop of 9 m (30 ft) onto a flat, unyielding, horizontal surface, striking the surface in a position for which maximum damage is expected is required by 10 CFR 71.73(c)(1).

Analysis. Six test packages were drop tested from 9 m (30 ft) in accordance with 10 CFR 71.73(c)(1) with the setup as shown in Fig. 2.8. A description of the drop pad is presented in Sect. 2.6.7. Four different drop positions were used in the testing based on the analytical results from LS-DYNA drop simulations. The ES-3100 test units were designated as TU-1 through TU-5. TU-4 was subjected to the full NCT testing (water spray, 1.2-m (4-ft) drop, compression, penetration, and vibration) prior to HAC testing. The gross weight of the ES-3100 test units varied between 157.4 kg (347 lb) and 204.6 kg (451 lb). Mock-up components weighing between 3.6 kg (8 lb) [TU-5] and 50.3 kg (111 lb) [TU-3] were used during testing. Discussion of the damage to each test package resulting from the 9-m (30 ft) drop is given in subsequent paragraphs. Rationale for the four drop positions is included in the discussion for each test unit. Minor changes to the mid liner and the substitution of the neutron poison from BoroBond4 to Cat 277-4 are further evaluated in Sect. 2.7.8.



Fig. 2.8. 9-m drop test arrangement for all test units.

2.7.1.1 End drop

TU-4, weighing 201.8 kg (445 lb), was dropped from 9-m (30 ft) with the long axis of the drum perpendicular to the impact surface within 0.2°. The mock-up components are shown on Drawing M2E801580A027. The concern for this drop orientation was that the containment vessel assembly would crush, buckle or compress the insulation to a thickness that would result in excessive O-ring temperatures during the thermal testing cycle. Following initial impact, the package bounced very little before landing on its side. The damage to the drum consisted of reducing the overall height from 43.5 in. [following the 1.2-m (4-ft) drop] to a minimum 42.63 in. The diameter of the drum was measured at six locations along the long axis of the package and at two radial locations. The measurements and pictorials of the damage are recorded on Test Form 1 of Procedure TTG-PRF-08 shown in the test report data sheets (ORNL/NTRC-013) and are summarized in Tables 2.24 and 2.25 and Fig. 2.9.

Table 2.24. Recorded height damage to TU-4 from 1.2- and 9-m drop tests (in.)

	0°	90°	180°	270°
Predrop height	43.50	43.50	43.63	43.63
Post 1.2-m drop height	43.50	43.50	43.50	43.50
Post 9-m drop height	43.00	43.13	42.88	42.63

Table 2.25. Recorded diametrical damage to TU-4 from 1.2- and 9-m drop tests (in.)

Axial measurement location	0 to 180°			90 to 270°		
	Predrop test	Post 1.2-m drop test	Post 9-m drop test	Predrop test	Post 1.2-m drop test	Post 9-m drop test
Top false wire	19.25	19.25	19.25	19.38	19.38	19.38
Top rolling hoop	19.25	19.25	19.13	19.25	19.25	19.88
CG & top rolling hoop	19.25	19.25	19.81	19.25	19.25	19.38
CG rolling hoop	19.13	19.13	19.13	19.25	19.25	19.25
Bottom rolling hoop	19.13	19.13	19.25	19.25	19.25	19.25
Bottom false wire	19.38	19.38	19.25	19.25	19.25	19.25



Fig. 2.9. 9-m drop test damage on TU-4.

2.7.1.2 Side drop

TU-2, weighing 202.8 kg (447 lb), was chilled to −40°C (−40°F) prior to conducting the drop tests. This unit was sequentially dropped from 1.2 m (4 ft), 9 m (30 ft), crushed from 9 m (30 ft), and puncture tested with the long axis of the drum parallel to the impact surface. The mock-up component used in TU-2 is shown on Drawing M2E801580A027; it weighed 49.9 kg (110 lb). There were two concerns for this drop orientation. The primary concern was that the containment vessel assembly would crush or compress the insulation to a thickness that would result in excessive O-ring temperatures during the thermal testing cycle. Another concern was that the cold temperatures might cause excessive loads and deformation in the containment vessel body during impact. This, in turn, might cause leaking above the regulatory limit to occur. The test package made a free fall with initial contact occurring between the rolling hoops of the drum and the impact surface with the ambient temperature at 24.2°C (75°F). Since it was important to evaluate the package at the regulatory minimum temperature, individual results of each test were not recorded. Time required to measure the package between drops would have allowed the package to further increase in temperature. Tables 2.26, 2.27, and 2.28 and Fig. 2.10 show cumulative results of damage to TU-2 from drop testing.

Table 2.26. Recorded diametrical damage to TU-2 from NCT and HAC drop testing (in.)

Axial measurement location	0 to 180°		90 to 270°	
	Predrop test	Post drop test [a]	Predrop test	Post drop test [a]
Top false wire	19.25	17.63	19.25	19.81
Top rolling hoop	19.25	17.38	19.25	19.75
CG & top rolling hoop	19.25	17.00	19.25	20.00
CG rolling hoop	19.25	16.00	19.25	20.25
Bottom rolling hoop	19.25	15.50	19.25	20.13
Bottom false wire	19.25	18.00	19.25	19.38

[a] Includes cumulative damage from 1.2-m drop, 9-m drop, and crush test.

Table 2.27. Recorded flat contour damage to TU-2 from NCT and HAC drop tests (in.)

Axial measurement location	Flat width @ 0°	Flat width @ 180°
Top false wire	8	6.25
Top rolling hoop	9	8.88
CG & top rolling hoop	10.13	9.63
CG rolling hoop	9.88	12.00
Bottom rolling hoop	9.88	14.88
Bottom false wire	9.38	0
Crease (see Fig. 2.10 for location)	–	15.25

Table 2.28. Recorded height damage to TU-2 from NCT and HAC drop tests (in.)

	0°	90°	180°	270°
Predrop height	43.50	43.50	43.50	43.50
Post-drop height [a]	44.75	43.75	42.75	43.63

[a] Includes cumulative damage from 1.2-m drop, 9-m drop, and crush test.



Fig. 2.10. Cumulative damage from 9-m drop and crush testing on TU-2.

2.7.1.3 Corner drop

TU-3, weighing 203.7 kg (449 lb), was dropped from 9 m (30 ft), with the long axis of the drum at an oblique angle of 24.8° (desired angle was 24.6°) from the impact surface. The mock-up component used in TU-3 is shown on Drawing M2E801580A027; it weighed 50.3 kg (111 lb). The primary concern for this drop orientation was that the combination of plastic deformation at impact on the corner of the drum and the crushing or compacting of the adjacent insulation by the containment vessel flange would result in excessive O-ring temperatures during thermal testing. Another concern was that the mock-up contents would be forced against the containment vessel lid at impact. This, in turn, might yield the flange or closure nut, resulting in loss of containment. The test package made a free fall, with initial contact occurring between the top rim of the drum and the impact surface with the ambient temperature at 28°C (82.4°F). A secondary contact occurred between the bottom drum rim and the impact surface. No drum studs, nuts, or washers were lost due to the impact. The lid was still firmly attached to the drum assembly, with no visible separations or rips; thus, the position of the containment vessel inside the drum (and therefore the contents of the shipping container) was maintained. A general description of damage to TU-3 is summarized in Tables 2.29 and 2.30. A picture of the damage is shown in Fig. 2.11.

Table 2.29. Recorded height damage to TU-3 from 1.2- and 9-m drop tests (in.)

	0°	90°	180°	270°
Predrop height	43.50	43.50	43.50	43.50
Post 1.2-m drop height	43.00	43.50	43.63	43.50
Post 9-m drop height	40.63	43.25	43.75	43.38

Table 2.30. Recorded diametrical damage to TU-3 from 1.2- and 9-m drop tests (in.)

Axial measurement location	0 to 180°			90 to 270°		
	Predrop test	Post 1.2-m drop test	Post 9-m drop test	Pre drop test	Post 1.2-m drop test	Post 9-m drop test
Top false wire	19.25	19.25	19.25	19.13	19.38	19.19
Top rolling hoop	19.13	19.13	18.63	19.13	19.25	19.88
CG & top rolling hoop	19.13	19.13	19.13	19.13	19.25	19.38
CG rolling hoop	19.13	19.13	19.13	19.13	19.25	19.38
Bottom rolling hoop	19.13	19.13	19.13	19.13	19.25	19.38
Bottom false wire	19.13	19.13	19.13	19.13	19.25	19.25



Fig. 2.11. TU-3 damage from 1.2- and 9-m drop tests.

2.7.1.4 Oblique drops

Two oblique (slapdown) drops were conducted in the same attitude with maximum and minimum content weights to determine the structural response on the package in accordance with NRC Regulatory Guide 7.8. Paraphrasing Regulatory Position 1.6, a local structural response might be greater during an impact test if the weight of the contents were less than the maximum. Therefore, TU-1 and TU-5 contained the maximum and minimum weight configurations, respectively.

2.7.1.4.1 TU-1 slapdown

TU-1, weighing 202.3 kg (446 lb), was dropped from 9 m (30 ft) with the long axis of the unit at an oblique angle of 12.2° (desired angle was 12°) to the essentially unyielding surface. The mock-up component used in TU-1 is shown on Drawing M2E801580A027; it weighed 49.90 kg (110 lb). Based on Sect. 3.1 of NRC Regulatory Guide 7.8, the structural performance of the package must be evaluated for the minimum and maximum weight of the contents. Therefore, this unit was tested above the maximum proposed content weight to see if the containment vessel would react differently from the much lighter mock-up content used in TU-5 in a similar drop orientation. The primary concern was that the orientation would cause greater angular acceleration of the contents near the package top. This in turn would cause the containment vessel to crush or compress the insulation to a thickness that would result in excessive O-ring temperatures during the thermal testing cycle. The test package made a free fall with initial contact occurring between the rolling hoops of the drum and the impact surface with the ambient temperature at 28°C (82.4°F). No drum studs, nuts, or washers were lost due to the impact. The lid was still firmly attached to the drum assembly, with no visible separations or rips; thus, the position of the containment vessel inside the drum (and therefore the contents of the shipping container) was maintained. A general description of damage is provided in Tables 2.31, 2.32, and 2.33 and Fig. 2.12.

Table 2.31. Recorded height damage to TU-1 from 1.2- and 9-m drop tests (in.)

	0°	90°	180°	270°
Predrop height	43.50	43.50	43.50	43.50
Post 1.2-m drop height	43.50	43.50	43.50	43.50
Post 9-m drop height	42.63	43.38	43.25	43.38
Buckle	44.50			

Table 2.32. Recorded diametrical damage to TU-1 from 1.2- and 9-m HAC drop tests (in.)

Axial measurement location	0 to 180°			90 to 270°		
	Predrop test	Post 1.2-m drop test	Post 9-m drop test	Predrop test	Post 1.2-m drop test	Post 9-m drop test
Top false wire	19.25	19.13	18.50	19.25	19.25	19.38
Top rolling hoop	19.25	19.00	18.50	19.25	19.25	19.38
CG & top rolling hoop	19.25	19.13	18.50	19.25	19.25	19.38
CG rolling hoop	19.25	19.13	18.63	19.25	19.25	19.38
Bottom rolling hoop	19.25	19.00	18.63	19.25	19.25	19.25
Bottom false wire	19.25	19.00	17.81	19.25	19.25	19.38

Table 2.33. Recorded flat contour damage to TU-1 from 1.2- and 9-m drop tests (in.)

Axial measurement location	Flats width maximum post 1.2-m drop	Flats width maximum post 9-m drop
Top false wire	5.25	8.00
Top rolling hoop	4.38	7.38
CG & top rolling hoop	4.50	7.13
CG rolling hoop	3.00	6.38
Bottom rolling hoop	4.00	6.75
Bottom false wire	4.63	10

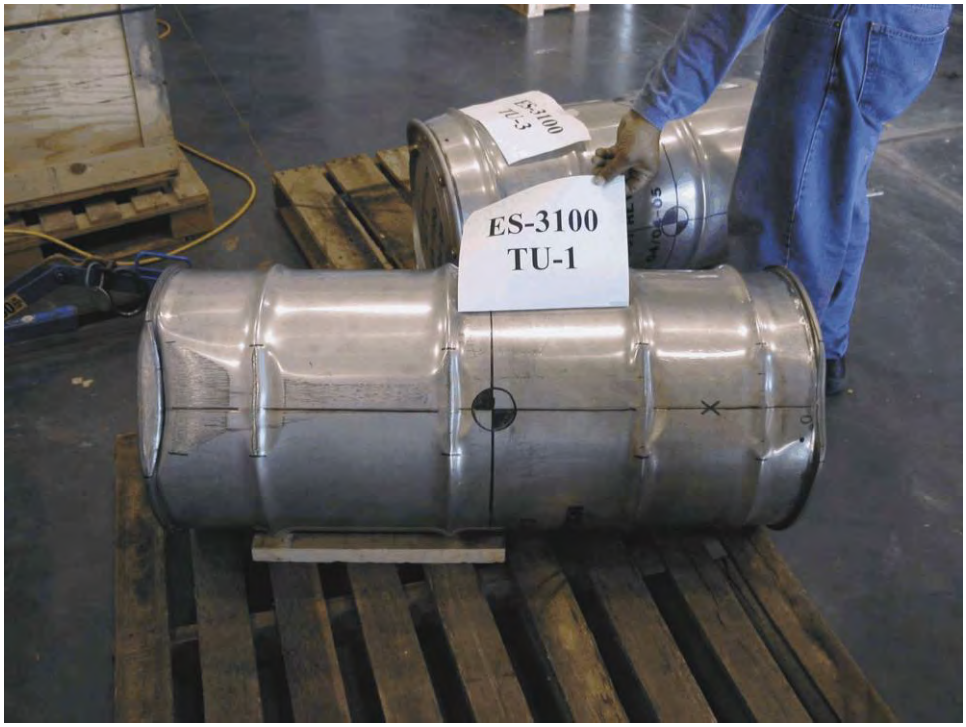


Fig. 2.12. 1.2- and 9-m drop test damage on TU-1.

2.7.1.4.2 TU-5 slapdown

TU-5, weighing 157.4 kg (347 lb), was dropped from 9 m (30 ft), with the long axis of the drum at an oblique angle of 12.5° (desired angle was 12°) from the impact surface. The mock-up component (Drawing M2E801580A029), weighing 3.6 kg (8 lb), was the hardware; the majority of the mass was located near the bottom of the containment vessel (ORNL/NTRC-013). Based on Sect. 3.1 of NRC Regulatory Guide 7.8, the structural performance of the package must be evaluated for the minimum and maximum weight of the contents. Therefore, this unit was tested at the minimum proposed weight to see if the containment vessel would react differently from the much heavier mock-up content used in TU-1 in a similar drop orientation. The test package made a free fall with initial contact occurring between the bottom rim of the drum and the impact surface with the ambient temperature at 30.6°C (87°F). A secondary contact occurred between the top drum lid and the impact surface. No drum studs, nuts, or washers were lost during this impact test. The lid was still firmly attached to the drum assembly, with no visible separations or rips; thus, the position of the containment vessel inside the drum (and therefore the contents of the shipping container) was maintained. A general description of damage is provided in Tables 2.34, 2.35, and 2.36 and Fig. 2.13.

Table 2.34. Recorded height damage to TU-5 from 1.2- and 9-m drop tests (in.)

	0°	90°	180°	270°
Predrop height	43.50	43.50	43.50	43.50
Post 1.2-m drop height	43.88	43.50	43.50	43.50
Post 9-m drop height	44.50	43.50	43.38	43.50

Table 2.35. Recorded diametrical damage to TU-5 from 1.2- and 9-m HAC drop tests (in.)

Axial measurement location	0 to 180°			90 to 270°		
	Predrop test	Post 1.2-m drop test	Post 9-m drop test	Predrop test	Post 1.2-m drop test	Post 9-m drop test
Top false wire	19.25	18.88	18.75	19.38	19.38	19.38
Top rolling hoop	19.25	19.00	18.75	19.25	19.25	19.38
CG & top rolling hoop	19.25	19.13	18.75	19.25	19.25	19.38
CG rolling hoop	19.25	19.13	18.75	19.25	19.25	19.25
Bottom rolling hoop	19.25	19.13	18.75	19.25	19.25	19.25
Bottom false wire	19.25	19.13	18.44	19.25	19.25	19.31

Table 2.36. Recorded flat contour damage to TU-5 from 1.2- and 9-m drop testing (in.)

Axial measurement location	Maximum width of flats post 1.2-m drop	Maximum width of flats post 9-m drop
Top false wire	5.38	8.38
Top rolling hoop	4.25	8.38
CG & top rolling hoop	3.88	7.63
CG rolling hoop	2.50	7.50
Bottom rolling hoop	3.25	8.25
Bottom false wire	5.00	9.25



Fig. 2.13. 1.2- and 9-m drop test damage to TU-5.

2.7.1.5 Summary of results

Damage resulting from physical testing is quantitatively described including photographs in Sect. 2.7.1. The full-scale test units were fabricated in accordance with drawings created for production hardware. During the procurement process for the full-scale test units, several small changes were suggested by the manufacturer to improve the efficiency and to reduce the cost of fabrication. These changes were incorporated and tested. However, following compliance testing the following changes have been made to the proposed production hardware. First, a change in the neutron poison from BoroBond4 to Cat 277-4 has been adopted; second, the mid liner design has been changed to a continuous shell by reducing the diameter of the step in the inner liner for the containment vessel flange from 22.35 cm (8.8 in.) to 21.84 cm (8.6 in.); and third, the silicone rubber pad thickness on the drum assembly bottom liner was increased by ~0.15 cm (0.06 in.). The second change increased the amount of Kaolite 1600 around the containment vessel flange, increased the final volume of the neutron poison, and slightly decreased the volume of the Kaolite 1600 adjacent to the neutron poison. The third change was made to stiffen the rubber pad so it would remain in place during vibration normally incurred during transport. In order to evaluate the impact of these changes, analytical drop simulations were conducted and documented in DAC-EA-801699-A001 and DAC-EA-801699-A002. The drop simulations were conducted in the same attitude and temperature regime as those conducted during the compliance testing phase for certification. The results of the structural deformation from compliance testing, drop simulation using BoroBond4, and drop simulations using Cat 277-4 material are presented in Sect. 2.7.8. The analytical structural deformation results shown in Tables 2.52–2.61 are nearly identical for the two neutron poisons. The analytical results are also well representative of the results recorded during compliance testing. Analytical strain prediction in the structural components is also compared. Although there are minor differences between simulations, the overall magnitude of the strains is very similar. The thermal aspects of these changes are addressed in Chap. 3. NCT and HAC results predicted for an undamaged package show that the change in neutron poison actually reduces the final temperature of the containment vessel components. Therefore, the substitution of Cat 277-4 material and the minor changes in the inner and mid liners for production hardware should not reduce the effectiveness of the packaging when subjected to the regulatory requirements of 10 CFR 71, and the results of compliance testing would be analogous.

2.7.2 Crush

Requirement. Title 10 CFR 71.73(c)(2) requires that the specimen be subjected to a dynamic crush test in which the specimen is placed on a flat, essentially unyielding, horizontal surface so as to suffer maximum damage by the drop of a 500-kg (1100-lb) mass from 9 m (30 ft) onto the specimen. The mass must consist of a solid mild steel plate 1 m (40 in.) by 1 m (40 in.) and must fall in a horizontal attitude. The crush test is required only when the specimen has a mass ≤ 500 kg (1100 lb), an overall density ≤ 1000 kg/m^3 (62.4 lb/ft^3) based on external dimensions, and radioactive contents >1000 A_2 not as special form radioactive material. For packages containing fissile material, the radioactive contents >1000 A_2 criterion does not apply.

Analysis. Six test packages were subjected to the dynamic crush test from 9 m (30 ft) in accordance with 10 CFR 71.73(c)(2). The previously drop-tested packages (described in Sect. 2.7.1) were restrained in the orientation used for drop testing. Discussion of the damage to each test package that resulted from the crush test is given in subsequent paragraphs, with details given in the test reports (ORNL/NTRC-013). Rationale for the three drop positions is included in Sect. 2.7.1 for each test unit. The impact of the steel plate only increased the overall concern for each orientation.

TU-1, weighing 202.3 kg (446 lb), was positioned in a horizontal attitude with the damaged portion of the test unit, resulting from prior drop tests, placed on the drop pad (0° mark facing down on

test pad). The 500-kg (1100-lb) crush plate was centered over the sealing lid location on the containment vessel and dropped from 9 m (30 ft) and squarely contacted the top false wire of the drum at an ambient temperature of 29°C (84.2°F). Following initial impact, the package bounced very little before landing on its side. No drum studs, nuts, or washers were lost due to the impact. The lid was still firmly attached to the drum, with no visible separation or rips; thus, the position of the thermal barrier and neutron poison was maintained. A summary of the resulting damage is shown in Tables 2.37, 2.38, and 2.39. Since the length of the crush plate did not encompass the entire length of the test package, a crush edge indentation is recorded in Table 2.39. A pictorial of the damage is shown in Fig. 2.14.

Table 2.37. Recorded height damage to TU-1 from the 9-m crush test

(in.)

	0°	90°	180°	270°
Pre-crush height	44.50	43.38	43.25	43.38
Post 9-m crush test height	44.88	43.38	44.00	43.63

Table 2.38. Recorded diametrical damage to TU-1 from the 9-m crush test

(in.)

Axial measurement location	0 to 180°		90 to 270°	
	Precrush test	Post 9-m crush test	Precrush test	Post 9-m crush test
Top false wire	18.50	15.63	19.38	20.63
Top rolling hoop	18.50	16.00	19.38	20.43
CG & top rolling hoop	18.50	16.25	19.38	20.25
CG rolling hoop	18.63	16.50	19.38	19.88
Bottom rolling hoop	18.63	18.25	19.25	19.50
Bottom false wire	17.81	17.81	19.38	19.25

Table 2.39. Recorded flat contour damage to TU-1 from the 9-m crush test

(in.)

Axial measurement location	Flats width maximum @ 0°	Flats width maximum @ 180°
Top false wire	9.00	8.50
Top rolling hoop	10.00	10.00
CG & top rolling hoop	10.00	10.13
CG rolling hoop	9.00	10.63
Bottom rolling hoop	8.25	--
Bottom false wire	9.75	--
Dent where edge of plate struck test unit	--	9.13



Fig. 2.14. Cumulative damage following 9-m crush on TU-1.

TU-2 (chilled package), weighing 202.8 kg (447 lb), was positioned in a horizontal attitude with the long axis of the drum parallel with respect to the drop pad. The damaged portion of the test unit, resulting from prior drop tests, was placed nearest the drop pad (0° mark facing down on pad). The 500-kg (1100-lb) crush plate was centered over the test unit's center of gravity and dropped from 9 m (30 ft) squarely onto the top false wire of the drum at an ambient temperature of 26.8°C (80.4°F). Following initial impact, the package bounced very little before landing on its side. No drum studs, nuts, or washers were lost due to the impact. The lid was still firmly attached to the drum, with no visible separation or rips; thus, the position of the thermal barrier and neutron poison was maintained. A summary of the cumulative damage is shown in Tables 2.26, 2.27, and 2.28 in Sect. 2.7.1.2. Figure 2.10 is a photograph of the damage.

TU-3, weighing 203.7 kg (449 lb), was positioned in the same oblique attitude as previously drop tested from 9 m (30 ft). The long axis of the drum was at an oblique angle of 24.7° (desired angle was 24.6°) from the impact surface with the damaged portion of the lid in contact with the drop pad (0° mark in contact with pad). The 500-kg (1100-lb) crush plate was dropped from 9 m (30 ft) with the center of gravity of both the plate and test unit in line at an ambient temperature of 30.5°C (86.9°F). The initial impact of the plate was with the edge of the drum bottom. A secondary contact occurred between the bottom drum rim and the impact surface. One drum stud was sheared from the test unit; however, the lid was still firmly attached to the drum, with no visible separation or rips. Therefore, the thermal barrier and neutron poison was maintained in position. Tables 2.40, 2.41, and 2.42 describe the measured damage which is recorded on Test Form 3 (ORNL/NTRC-013). A photograph of the damage to TU-3 is shown in Fig. 2.15.

Table 2.40. Recorded height damage to TU-3 from the 9-m crush test (in.)

	0°	90°	180°	270°
Precrush height	40.63	43.25	43.75	43.38
Post 9-m crush test height	39.38	42.43	39.13	42.50

Table 2.41. Recorded flat contour damage to TU-3 from the 9-m crush test (in.)

Axial measurement location	Flats width maximum pre-crush	Flats width maximum post-crush
Top of test unit	14.00	18.38
Bottom of test unit	0.00	17.88

Table 2.42. Recorded diametrical damage to TU-3 from the 9-m crush test (in.)

Axial measurement location	0 to 180°		90 to 270°	
	Pre-crush test	Post 9-m crush test	Pre-crush test	Post 9-m crush test
Top false wire	19.25	19.25	19.19	19.06
Top rolling hoop	18.63	18.75	19.88	20.25
CG & top rolling hoop	19.13	19.25	19.38	19.75
CG rolling hoop	19.13	19.13	19.38	19.25
Bottom rolling hoop	19.13	19.13	19.38	19.75
Bottom false wire	19.13	18.00	19.25	19.38



Fig. 2.15. Cumulative damage following 9-m crush test on TU-3.

TU-4, weighing 201.8 kg (445 lb), was positioned vertically with the previously damaged drum top in contact with the drop pad. The 500-kg (1100-lb) crush plate was dropped from 9 m (30 ft) and squarely contacted the bottom of the test unit. The center of the 500-kg (1100-lb) crush plate was positioned over the radial test unit's center of gravity, in this case over the center of the drum's bottom at an ambient temperature of 29.8°C (85.6°F). Following initial impact, the package bounced very little before landing on its side. No drum studs, nuts, or washers were lost due to the impact. The lid was still firmly attached to the drum, with no visible separation or rips; thus, the position of the thermal barrier and neutron poison was maintained. A summary of the resulting damage is shown in Tables 2.43 and 2.44, and a photograph is shown in Fig. 2.16.

Table 2.43. Recorded height damage to TU-4 from the 9-m crush test (in.)

	0°	90°	180°	270°
Precrush height	43.00	43.13	42.88	42.63
Post 9-m crush test height	39.38	40.38	40.63	39.75

Table 2.44. Recorded diametrical damage to TU-4 from the 9-m crush test (in.)

Axial measurement location	0 to 180°		90 to 270°	
	Pre-crush test	Post 9-m crush test	Pre-crush test	Post 9-m crush test
Top false wire	19.25	19.25	19.38	19.38
Top rolling hoop	19.13	20.00	19.88	20.13
CG & top rolling hoop	19.81	20.00	19.38	20.06
CG rolling hoop	19.13	19.43	19.25	19.50
Bottom rolling hoop	19.25	19.94	19.25	20.00
Bottom false wire	19.25	19.25	19.25	19.25

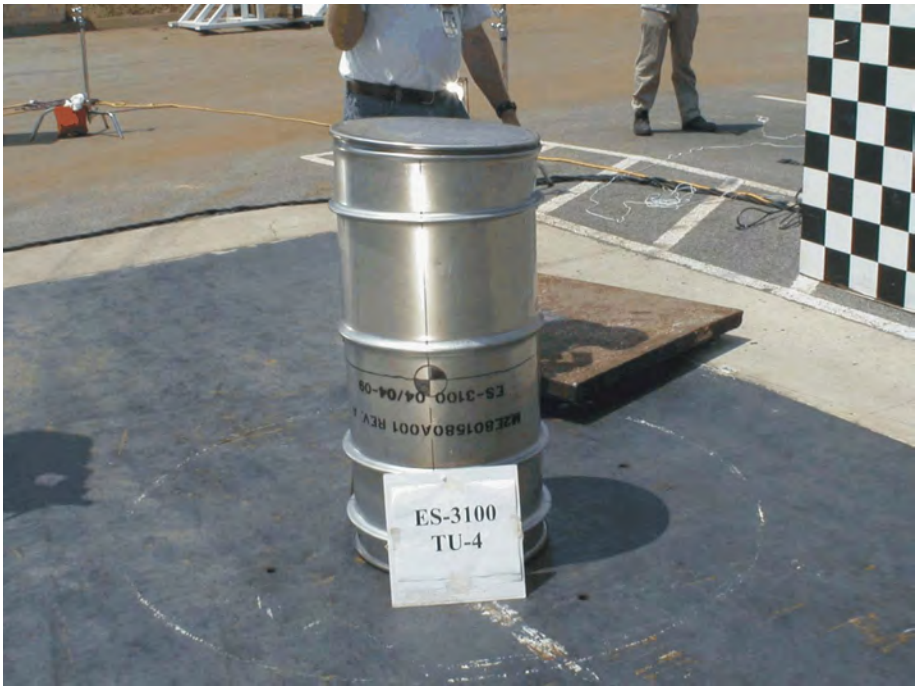


Fig. 2.16. Cumulative damage from 9-m drop and crush testing on TU-4.

TU-5, weighing 157.4 kg (347 lb), was positioned in a horizontal attitude with the damaged portion of the test unit resulting from prior drop tests placed on the drop pad (0° mark facing down on test pad). The 500-kg (1100-lb) crush plate was centered over the test unit's center of gravity and dropped from 9 m (30 ft) squarely onto the top false wire of the drum at an ambient temperature of 29.6°C (85.3°F). Following initial impact, the package bounced very little before landing on its side. No drum studs, nuts, or washers were lost due to the impact. The lid was still firmly attached to the drum, with no visible separation or rips; thus, the position of the thermal barrier and neutron poison was maintained. A summary of the resulting damage is shown in Tables 2.45, 2.46, and 2.47. Figure 2.17 is a photograph of the damage. Since the length of the crush plate did not encompass the entire length of the test package, additional indentations are recorded on Test Form 3 (ORNL/NTRC-013).

Table 2.45. Recorded height damage to TU-5 from the 9-m crush test

(in.)

	0°	90°	180°	270°
Precrush height	44.50	43.50	43.38	43.50
Post 9-m crush test height	45.00	43.50	43.75	43.88

Table 2.46. Recorded diametrical damage to TU-5 from the 9-m crush tests

(in.)

Axial measurement location	0 to 180°		90 to 270°	
	Pre-crush test	Post 9-m crush test	Pre-crush test	Post 9-m crush test
Top false wire	18.75	18.69	19.38	19.38
Top rolling hoop	18.75	17.13	19.38	19.63
CG & top rolling hoop	18.75	17	19.38	20
CG rolling hoop	18.75	16.75	19.25	20
Bottom rolling hoop	18.75	16.50	19.25	19.75
Bottom false wire	18.44	17.00	19.31	19.38

Table 2.47. Recorded flat contour damage to TU-5 from the 9-m crush test

(in.)

Axial measurement location	Flats width maximum @ 0°	Flats width maximum @ 180°
Top false wire	8.88	0.00
Top rolling hoop	8.50	12.50
CG & top rolling hoop	8.00	12.00
CG rolling hoop	8.75	11.38
Bottom rolling hoop	10.25	11.38
Bottom false wire	11.38	10.50



Fig. 2.17. Cumulative damage from 9-m drop and crush testing on TU-5.

Conclusion. As noted in the discussion above, plastic deformation of the drum occurred in all test packages at the impacted areas. However, the position of the impact-limiting material (Kaolite) and neutron poison material (BoroBond in TU-1 through TU-5) was maintained in all test packages. The largest area of deformation along the side of the test packages was a flat measuring 31.75 cm (12.50 in.) wide at the drum's top rolling hoop and ending with a width of 26.67 cm (10.50 in.) at the drum bottom in TU-5. Since the Packcrete material is functionally equivalent to the Kaolite 1600 material, similar results would be expected for Packcrete.

2.7.3 Puncture

Requirement. A free drop of 1 m (40 in.) from a position to obtain maximum damage onto the upper end of a solid, vertical, cylindrical, 15-cm (6-in.)–diam mild steel bar mounted on an unyielding horizontal surface, is required by 10 CFR 71.73(c)(3). The bar must be ≥20 cm (8 in.) long with the top end rounded to 6-mm (0.25-in.) maximum radius. The long axis of the bar must be vertical.

Analysis. The six units previously dropped and crushed from 9-m (30 ft) [Sects. 2.7.1 and 2.7.2] were dropped from 1 m (40 in.) in accordance with 10 CFR 71.73(c)(3). The puncture bar was bolted to the steel plate of the inside drop pad surface at NTRC (see Sect. 2.6.7 regarding the indoor drop test pad). A description of the drop orientations and results are shown in Table 2.48. Figures 2.18–2.24a show the results of puncture testing.

Conclusion. Although all test units were deformed by this puncture test, no drum surfaces were breached, thereby maintaining the integrity of the thermal barrier and neutron poison. Again, due to the fact that Packcrete is functionally equivalent to Kaolite 1600, similar results would be expected.

Table 2.48. 1-m (40-in.) puncture drop test description and results

Test Unit	Test unit's long axis drop orientation	Axial and radial location from drum lid [a]	Recorded damage [indentation depth (in.)] [b]	Photograph
1	Horizontal	Test unit's CG (0° mark)	0.63	Fig. 2.18
1	Horizontal	8 in. down (180° mark)	0.38	Fig. 2.20
1	28° oblique from vertical	Drum lid's edge (90° mark)	Three impact locations 1. 0.63 2. 0.38 3. 0.13	Fig. 2.18
1	40° oblique from vertical	In line with test unit's CG (270° mark)	Two impact locations 1. 0.75 2. 0.13	Fig. 2.19
2	Horizontal	Test unit's CG (0° mark)	0.13	Fig. 2.21
3	24.6° oblique from vertical	In line with test unit's CG (270° mark)	Two impact locations 1. Additional flattening of lid 2. 0.88	Fig. 2.22
4	Vertical	Center of drum's lid & CG	0.13	Fig. 2.23
5	Horizontal	8 in. down (0° mark)	0.13	Fig. 2.24

[a] See detailed description of test units in Sect. 5.4.3 of ORNL/NTRC-013.
[b] For detailed description of damaged locations, see Test Form 4 for TU-1, TU-3, TU-4, and TU-5 and Test Form 3 for TU-2 (ORNL/NTRC-013).



Fig. 2.18. 28° oblique and horizontal puncture tests on TU-1.



Fig. 2.19. 40° oblique puncture test on TU-1.



Fig. 2.20. Horizontal puncture test over TU-1's containment vessel flange.



Fig. 2.21. Horizontal CG puncture test on TU-2.



Fig. 2.22. 24.6° oblique puncture test on TU-3.



Fig. 2.23. Vertical puncture test on TU-4.



Fig. 2.24. Horizontal puncture test over TU-5's containment vessel flange.

2.7.4 Thermal

Requirement. Exposure of the specimen fully engulfed, except for a simple support system, in a hydrocarbon fuel/air fire of sufficient extent and in sufficiently quiescent ambient conditions to provide an average emissivity coefficient of at least 0.9, with an average flame temperature of at least 800°C (1475°F) for a period of 30 min, or any other thermal test that provides the equivalent total heat input to the package and that provides a time-averaged environmental temperature of 800°C (1475°F). The fuel source must extend horizontally at least 1 m (40 in.) but may not extend more than 3 m (10 ft) beyond any external surface of the specimen, and the specimen must be positioned 1 m (40 in.) above the surface of the fuel source. For purposes of calculation, the surface absorptivity must be either that value which the package may be expected to possess if exposed to the fire specified or 0.8, whichever is greater; and the convective coefficient must be that value which may be demonstrated to exist if the package were exposed to the fire specified. Artificial cooling may not be applied after cessation of external heat input, and any combustion of materials of construction must be allowed to proceed until it terminates naturally.

Analysis. The six test units previously subjected to both NCT and HAC drop testing were thermally tested in accordance with 10 CFR 71.73(c)(4). To determine the maximum temperatures reached during thermal testing, temperature-indicating patches were placed at various locations throughout the test packages at assembly. The temperature range for each patch used is identified in Table 2.49. When the temperature of an indicator was reached, the color would change to black (i.e., blackout temperature). The range of possible blackout temperatures of the patches was from 51.67 to 260°C (125 to 500°F). For TU-1 through TU-5, Table 2.49 defines the number and location of the temperature-indicating patches. A temperature adjustment to compensate for conducting the HAC compliance tests with BoroBond4 and substituting Cat 277-4 for the production shipping containers was evaluated. This adjustment was determined by using an undamaged package and subjecting it to a thermal environment representative of that required by 10 CFR 71.73(c)(4). Based on the analytical results shown in DAC-PKG-801699-A001 and DAC-PKG-801940-A001, the containment vessel in a package using Cat 277-4 would be 2.5 to 8°F cooler than a package with BoroBond4. Therefore, the results from TU-5 are used without further adjustment due to the change in neutron poison.

Prior to the beginning of the thermal test, the No. 3 furnace at Timken Steel Company in Latrobe, Pennsylvania, was characterized for temperature and heat recovery times. Oxygen content in stack gases of the furnace was not monitored because it was not anticipated that any of the package's materials of construction were combustible. There was some burning of the silicone pads which are placed between the inner liners and the top plugs of the packages. However, it should be noted that this furnace employs "pulsed" fire burners. This type of burner is unique in that the natural gas flow rate is varied based on furnace controller demands, but the flow of air through the burners is constant, even when no gas is flowing, thereby ensuring a very rich furnace atmosphere capable of supporting any combustion of package materials of construction. The support stand was welded to a large steel plate which had been placed on the floor of the furnace prior to heating. This steel plate acted as the radiating surface at the bottom of the furnace as well as providing the ability to hold the test stand rigidly in place. Before heating the furnace, workers practiced loading and unloading test packages from the cold furnace to assure that the furnace door would not remain open >90 s during each loading. In fact, the maximum time the door was open during any loading was 64 s.

Table 2.49. Thermax temperature-indicating patches for test units

Patch location	Internal surface	External surface	Temperature range °C (°F)	Test report figure [a]
Inner liner of drum assembly		8 (full range [b]) 10 (5B & 5C)	52 to 260 (125 to 500) "B" 77–127 (171–261) [c] "C" 132–182 (270–360) [d]	5.3
Top plug weldment		4 (full range)	52 to 260 (125 to 500)	5.31
Containment vessel body flange	8 (4B & 4C)	8 (4B & 4C)	"B" 77–127 (171–261) "C" 132–182 (270–360)	5.28
Containment vessel body (end cap and cylinder)		5 (B)	"B" 77–127 (171–261)	5.28
Containment vessel sealing lid	4 (B)	4 (B)	"B" 77–127 (171–261)	5.29
Test mock-up components		6 (B)	"B" 77–127 (171–261)	5.26 & 5.27

[a] ORNL/NTRC-013.
[b] Full range labels consist of two strips; the first strip spans from 1250–3000°F in 250°F increments, and the second strip spans from 3250–5000°F in 250°F increments.
[c] Temperature-indicating labels described as "B" labels read between 1710°F and 2610°F in increments of between 90°F and 110°F.
[d] Temperature-indicating labels described as "C" labels read between 2700°F and 3600°F in increments 90°F and 110°F.

A total of 18 thermocouples was installed on the furnace surfaces and on the test package support stand (ORNL/NTRC-013). All units were tested in a horizontal attitude with the end of the package facing the right and left side walls of the furnace. The test units were thermally tested with the 0° mark on the drum facing the floor of the furnace.

TU-1 through TU-5 were preheated to >38°C (100°F) by placing the packages in an environmental chamber, which was heated by a torpedo-type kerosene space heater controlled by a mechanical bulb thermostat with a control range of 38 to 93°C (100 to 200°F). The general construction of the environmental chambers was similar: a welded steel frame with fiberglass insulation panels or blankets. The set-point temperature of the environmental chambers was monitored and adjusted for the duration of the preheat cycle. Initially, the thermostat was set to 66°C (150°F) for ~23 h to 24 h. The thermostat set point was then reduced to ≥43°C (110°F) for the remainder of the preheat cycle. All of packages were preheated for at least 47 h. Six thermocouples were attached to the exterior surface of each test package after preheating. Metal retainer clips were welded to the drum to hold the thermocouples in place. The thermocouple tips were inserted underneath the metal clips and the wire was wrapped around the metal clip. To eliminate any radiant heat exchange between the thermocouples and the furnace walls, the tips and metal clips were covered with a ceramic coating.

No test package was loaded into the furnace until all functioning thermocouples on the furnace walls and support stand had a reading of 800°C (1475°F) or higher. All packages were placed in the preheated furnace on the support stand positioned with the long axis horizontal, the package lid facing toward a furnace side wall and oriented as described above. These packages were exposed to the radiation environment for a minimum of 30 min after all functioning furnace thermocouples, and at least five of the six test package exterior surface thermocouples, reached 800°C (1475°F). During the testing, the thermocouple temperature data were recorded every 15 s.

A minimum of 24 h prior to the beginning of all testing, the furnace was turned on with a set-point temperature of 871°C (1600°F). After each test, the furnace was allowed to reheat for a minimum of 45 min after obtaining the set-point temperature before testing the next unit. The furnace control temperature data recorder ran continuously for the duration of the preheat. No test package was loaded into the furnace until all functioning thermocouples on the furnace walls and support stand had a reading of 800°C (1475°F) or higher.

Each test package was removed from the furnace and placed in an area where it was not exposed to artificial cooling. As the furnace door was opened for each test unit, smoking or flaming was visible from the TID lug hole at 0°. Flaming continued on some packages for 22 min and smoking continued up to 1 h on others. All of the packages were allowed to cool naturally to room temperature. The post-thermal test weights of each unit were recorded on Test Form 1 (ORNL/NTRC-013). The drums were disassembled, and the damage was photographed. The post-thermal test weight of each loaded containment vessel was also recorded. Each package was visually inspected, and the condition of the package and any observations were recorded.

After the containment vessels were removed from TU-1 through TU-5, two different leak tests were performed on each containment vessel. An operational leak test was conducted between the O-rings using either a CALT5 leak tester or a VTI smart station vacuum decay leak detector. Following this operational leak test, a full body helium leak test was conducted. Details of these leak tests are provided in the test report (ORNL/NTRC-013) and the results are summarized in Table 2.23. All six containment vessels were then removed from the drum assembly and immersed under a head of water of at least 0.9 m (3 ft) in a horizontal position for a period of ≥8 h. Following the immersion test of 10 CFR 71.73(c)(6), the containment vessels of TU-1 through TU-5 were opened to remove the contents, gather available data, and look for signs of water in-leakage. No water in-leakage was detected in any of the units.

The blackout temperatures on the surface of the containment boundaries, inner liners, and mock-up components used in TU-1 through TU-5 are given in the test report (Test Form 5 for each test unit). Maximum blackout temperatures recorded on the surface of all test units are tabulated in Table 2.50. These values and temperature adjustments are discussed in Sect. 3.4.3.

Conclusion. All six test packages were intact following the 30-min exposure to the high- temperature thermal environment as required in 10 CFR 71.73(c)(4). Examination during disassembly showed that the containment vessel surfaces, flanges, fasteners, sealing surfaces, and O-rings were not damaged by the thermal testing. All six containment vessel assemblies met the subsequent 0.9-m (3-ft) water immersion test and maintained a full-body helium leak rate $\leq 2.0 \times 10^{-7}$ cm^3/s. Following compliance testing, minor changes were made to the mid liner, and the neutron poison was changed from BoroBond4 to Cat 277-4. In order to evaluate the impact of these changes, extensive analytical drop simulations were utilized. The models, material properties, and drop orientations are described in DAC-EA-801699-A001 and DAC-EA-801699-A002. Results comparing structural deformation and maximum strains in the various material of construction are shown in Sect. 2.7.8. Based on the HAC analytical structural deformation results shown in Sect. 2.7.8, similar compliance test results would be expected had testing been conducted on packages employing the new proposed Cat 277-4 neutron poison. Therefore, the requirements of 10 CFR 71.73(c)(4) were satisfied, and containment was maintained.

Table 2.50. Maximum HAC temperatures recorded on the test packages' interior surfaces

Temperature patch location [a]	ES-3100 Test Unit				
	1	2	3	4	5
	[°C (°F)]	[°C (°F)]	[°C (°F)]	[°C (°F)]	[°C (°F)]
Top plug bottom	149 (300)	163 (325)	177 (350)	177 (350)	177 (350)
Inner liner					
Flange step wall	135 (275)	163 (325)	135 (275)	135 (275)	135 (275)
BoroBond4 step	107 (225)	135 (275)	107 (225)	177 (350)[b]	121 (250)
CV body wall high	99 (210)	99 (210)	99 (210)	99 (210)	104 (219)
CV body wall middle	99 (210)	93 (199)	116 (241)[b]	93 (199)	99 (210)
Bottom flat portion	104 (219)	99 (210)	99 (210)	127 (261)	110 (230)
Containment vessel					
Lid (external top)	116 (241)	110 (230)	116 (241)	127 (261)	127 (261)
Lid (internal)	104 (219)	104 (219)	110 (230)	110 (230)	116 (241)
Flange (external)	116 (241)	110 (230)	110 (230)	116 (241)	121 (250)
Flange (internal)	104 (219)	99 (210)	116 (241)[b]	104 (219)	116 (241)
Body wall mid height	99 (210)	88 (190)	99 (210)	82 (180)	93 (199)
Bottom end cap (center)	99 (210)	99 (210)	88 (190)	110 (230)	99 (210)
Mock-up					
Side top	82 (180)	77 (171)	77 (171)	77 (171)	99 (210)
Side middle	77 (171)	77 (171)	77 (171)	77 (171)	93 (199)
Side bottom	77 (171)	77 (171)	77 (171)	77 (171)	88 (190)

[a] Refer to figures for exact locations and to Test Form 5 for recorded values (ORNL/NTRC-013).
[b] Temperature-indicating patch may have been damaged due to impact with surrounding structure. See Test Form 5 in ORNL/NTRC-013 for additional information.

2.7.4.1 Summary of pressures and temperatures

The ES-3100 shipping packages will typically be loaded at an ambient temperature and absolute pressure of ~25°C (77°F) and 101.35 kPa (14.70 psi), respectively. If the temperature of the package increases during shipment due to external temperature or insolation, the drum will not pressurize because four ventilation holes are drilled near the top of the drum, and the drum is not sealed at the drum lid–flange interface. The containment vessel is sealed at assembly. The internal pressure will increase due to transport temperatures, insolation (Sect. 3.3.1), decay heating, and the temperatures during HAC (Sect. 3.4.3). Temperature and pressures are summarized in Tables 3.5 and 3.7.

The maximum HAC adjusted internal absolute pressure in the containment vessel of the ES-3100 has been calculated and rounded up to 1206.58 kPa (175.00 psia). This predicted pressure is based on a conservative maximum average gas temperature of 167.39°C (333.31°F) as shown in Sect. 3.4.3 and Appendix 3.5.2.

2.7.4.2 Differential thermal expansion

The drum, inner liner, and containment vessel are all constructed of Type 304 or 304L stainless steel. Because of design clearances used during assembly, radial and vertical expansion among these components will not cause any interferences or thermally induced stresses. Due to similarities of the coefficient of thermal expansion between Type 304 or 304L and the containment vessel closure nut (ASTM A 479 and ARMCO Nitronic 60), the compression of the O-rings and the closure nut and containment vessel thread load do not change appreciably during the temperature excursion from 25°C (77°F) to the maximum adjusted containment vessel temperature of 198.04°C (388.48°F) [Sect. 3.4.3].

The Kaolite 1600 or Packcrete insulation and Cat 277-4 neutron poison are poured and cast in place during the fabrication of the drum assembly weldment (Drawing M2E801580A002, Appendix 1.3.7). This process produces a zero gap between the insulation and the bounding drum and inner liner and zero gap between the neutron poison and the mid and inner liners. Because of differences in coefficients of thermal expansion, some radial and axial interferences are expected from thermal growth of the liners. These radial and axial interferences have been addressed by the HAC thermal test. The results show that the stresses induced are minimal and do not reduce the effectiveness of the drum assembly.

Since there are ample clearances between the various size convenience containers and HEU contents, no induced thermal stresses from differences in coefficient of thermal expansion will exist.

2.7.4.3 Stress calculations

The temperature gradient on the containment vessel was essentially uniform from top to bottom during the thermal tests (Table 2.50). The gradient around the periphery of the six test units was also essentially uniform and similar to the vertical gradient. As noted in the ES-3100 test report, the temperatures recorded on the containment vessels of all the test units were fairly uniform, both vertically and circumferentially. The maximum temperature variation on the containment vessels was ~50°F (from the test temperatures reported in Table 2.50). No damage would be expected on the containment vessel from thermal stresses resulting from a temperature differential of this magnitude. This conclusion is based on the guidelines given in the ASME Code, Sect. III, Div. 1. Thermal stress is defined as a self-balancing stress produced by a nonuniform distribution of temperature (ASME Code, Sect. III, Paragraph NB-3213.13). This paragraph further states that there are two types of thermal stresses: general thermal stress and local thermal stress. An example of a general stress is that produced by an axial temperature distribution in a cylindrical shell (ASME Code, Paragraph NB-3213.9). This general stress is further classified as a secondary stress (that is, a normal stress or a shear stress developed by the constraint of adjacent materials or by self-constraint of the structure) [ASME Code, Paragraph NB-3213.9]. Paragraph NB-3213.9 further states that the basic characteristic of a secondary stress is that it is self-limiting. Local yielding and minor distortions can satisfy the conditions that cause the stress to occur, and failure from a single application would not be expected. An example of a local thermal stress is a small hot spot in the wall of a pressure vessel (ASME Code, Paragraph NB-3213.13). Local thermal stress is associated with almost complete suppression of the differential expansion and thus produces no significant distortion. Such stresses are considered only from a fatigue standpoint. Fatigue will not result from a one-time cyclic event such as an accidental fire.

The principal effect of the elevated temperature on stress levels is caused by the increase in the internal pressure. The calculated stresses as shown in Table 2.51 were determined by multiplying the stress at the evaluation conditions (DAC-M900000-0002) by a factor equal to the ratio of operating pressures to evaluation pressures and adding any contribution from the closure nut preload. This methodology is based on the application of linear elastic material behavior. As shown in Sect. 2.7.4.4, all

stresses in the containment vessel components (based on nominal dimensions for the components) are well below the ASME Code allowable stress intensity limits.

2.7.4.4 Comparison with allowable stresses

As noted in Sect. 2.7.4.3, the differential stresses resulting from temperatures recorded during HAC are negligible. Also, as shown in Table 2.51, stresses of this low magnitude do not affect the adequacy of the packaging. Corresponding calculated stress regions are shown in Fig. 2.1.

2.7.5 Immersion—Fissile Material

Requirement. In those cases for which water leakage into the containment boundary has not been assumed for criticality analysis, the specimen must be immersed under a 0.9-m (3-ft) head of water in an attitude for which maximum leakage is expected, as required by 10 CFR 71.73(c)(5).

Analysis. The containment vessels for the ES-3100 test packages (TU-1 through TU-5) were removed from their respective drum assemblies following the thermal tests described in Sect. 2.7.4. After examination for damage (distortion, warpage, heating), the volume between the O-rings was pressurized, and the O-ring seals were leak checked in accordance with either the CALT5 manufacturer's instructions manual using the CALT5 leak tester or the VTI instructions manual using the VTI smart station vacuum decay leak detector. Following the O-ring cavity check, the containment vessel lids were drilled and tapped for a full-body helium leak check. The seals remained functional on all vessels, and the integrity of the containment vessel structure was maintained (indicated by a helium leak rate $\leq 2.0 \times 10^{-7}$ cm^3/s). Following these leak tests, each unit was then submerged under a 0.9-m (3-ft) head of water for at least 8 h. No water leakage into the vessel was seen in any of the test units. The results of this test are recorded on the data sheet of Procedure TTG-PRF-14 shown in test report ORNL/NTRC-013 for units TU-1 through TU-5. It should be noted that the criticality analysis does assume water leakage into the ES-3100 containment vessel; however, the 0.9-m (3-ft) immersion tests were performed anyway.

2.7.6 Immersion—All Packages

Requirement. A separate, undamaged specimen must be immersed under water at a pressure equivalent to a 15-m (50-ft) head of water, as required by 10 CFR 71.73(c)(6). This requirement may be satisfied by an external pressure of 150 kPa (21.7 psi) gauge.

Analysis. Immersion under a 15-m (50-ft) head of water would result in water entering the drum because the plastic plugs covering the four ventilation holes could fail, and the drum/lid flange is not gasketed. The ES-3100 containment vessel has been designed and tested for an external pressure of 150 kPa (21.7 psi) gauge and an internal gauge pressure of 699.82 kPa (101.5 psi), using nominal dimensions for all vessel components. Each containment vessel design incorporates an O-ring seal of verified integrity to provide assurance that no water will penetrate the containment boundary. The containment vessel of TU-6 was subjected to this 15-m (50-ft) water immersion test. No visible signs of water leakage into the containment boundary were recorded.

2.7.7 Deep Water Immersion Test (for Type B Packages Containing More than 10^5 A_2)

The amount of A_2s proposed for transport is ~4753. Therefore, the deep water immersion test is not applicable.

Table 2.51. HAC ES-3100 containment vessel stress compared to the allowable stress

Stress locations shown in Fig. 2.1	Thermal condition 10 CFR 71.73 (c)(4) [a] @1105.23 kPa (160.30 psi) gauge & 167.39°C (333.31°F)		Internal pressure evaluation [a, b] @ 1378.95 kPa (200 psi) gauge	Allowable pressure, or stress [a] up to 204.44°C (400°F)
	kPa (psi)	M.S. [c]	kPa (psi)	kPa (psi)
Top flat portion of sealing lid(edge of hole in center of lid)	1.902×10^4 (2,758)	10.1	2.173×10^4 (3,152.2)	1.924×10^5 (27,900) [d]
Closure nut ring (away from threaded portion)	3.486×10^4 (5,056)	2.9	3.984×10^4 (5,778)	1.024×10^5 (14,850) [d]
Top flat head (sealing surface region)	4.564×10^4 (6,620)	4.2	5.216×10^4 (7,565.8)	1.924×10^5 (27,900) [d]
Cylindrical section (middle) internal pressure	3.480×10^4 (5,047)	3.1	3.977×10^4 (5,768)	1.089×10^5 (15,800) [e]
Cylindrical section (middle) external pressure			1.496×10^2 (21.7)	7.584×10^2 (110) [f]
Cylindrical section (shell-to-flange interface)	4.353×10^4 (6,314)	3.8	4.975×10^4 (7,215.9)	1.634×10^5 (23,700) [d]
Cylindrical section (shell-to-bottom interface)	1.009×10^5 (14,639)	1.6	1.153×10^5 (16,730)	1.634×10^5 (23,700) [d]
Body flange threads joint	1.726×10^5 (25,031)	1.9	1.972×10^5 (28,607)	2.608×10^4 (47,400) [g]
Body flange thread region (under cut region)	8.065×10^4 (11,698)	2.0	9.218×10^4 (13,369)	1.634×10^5 (23,700) [c]
Flat bottom head (center)	8.436×10^4 (12,236)	1.9	9.642×10^4 (13,984)	1.634×10^5 (23,700) [c]
Closure nut threads joint	4.467×10^4 (6,479)	4.6	5.105×10^4 (7404.1)	3.353×10^4 (29,700) [g]

[a] Stresses are calculated using pressures, gasket and closure nut preload, and nominal dimensions for all containment vessel components (DAC-M900000-0002). Allowable stress values are taken from Table 2.5 up to 204.44°C (400°F).
[b] Immersion conditions have been evaluated with results shown in Table 2.6 under the external pressure design evaluation column.
[c] Margin of safety = allowable stress/actual stress.
[d] Stress interpreted as the sum of $P_l + P_b$; allowable stress intensity value is $1.5 \times S_m$.
[e] Stress interpreted as the primary membrane stress (P_m); allowable stress intensity value is S_m.
[f] Allowable external pressure [kPa (psi)].
[g] Stress interpreted as the sum of $P_l + P_b + Q$; allowable stress intensity value is $3.0 \times S_m$.

2.7.8 Summary of Damage

After testing six full scale ES-3100 test packages under HAC, the drum, drum lid, and top plug were damaged as expected. The containment vessel flange, O-ring grooves, and closure nut were not damaged. Plastic deformation occurred in the six drum assemblies in the impact areas from the 1.2-m (3.9-ft) and 9-m (30-ft) drop, crush and subsequent puncture tests. No breaks were noted in the drum assembly, and no insulation was exposed. The resultant damage did not reduce the effective center-to-center package spacing to a point of criticality concern (Chap. 6).

The full-scale test units (TU-1 through TU-6) were fabricated in accordance with drawings created for production hardware. During the procurement process for the full-scale test units, several small changes were suggested by the manufacturer to improve the efficiency and to reduce the cost of fabrication. These changes were incorporated and tested. However, after compliance testing on the first seven test units, the following changes have been made to the proposed production hardware. First, a change in the neutron poison from BoroBond4 to Cat 277-4 has been adopted; second, the mid liner design has been changed to a continuous shell by reducing the diameter of the step in the inner liner for the containment vessel flange from 22.35 cm (8.8 in.) to 21.84 cm (8.6 in.); and third, the silicone rubber pad thickness on the drum assembly bottom liner was increased by ~0.15 cm (0.06 in.). The second change increased the amount of Kaolite 1600 around the containment vessel flange, increased the final volume of the neutron poison, and slightly decreased the volume of the Kaolite 1600 adjacent to the neutron poison. The third change was made to stiffen the rubber pad so it would remain in place during vibration normally incurred during transport. In order to evaluate the impact of the above changes on the original HAC test units (TU-1 through TU-5), analytical drop simulations were conducted and documented in DAC-EA-801699-A001 and DAC-EA-801699-A002. The drop simulations were conducted in the same attitude and temperature regime as those conducted during the compliance testing phase for certification. Temperature dependent material properties were used in the analysis. The results of the structural deformation from compliance testing, drop simulation using BoroBond4, and drop simulations using Cat 277-4 material are presented in the following tables and figures. The analytical structural deformation results shown in Tables 2.52–2.61 are nearly identical for the two neutron poisons. The analytical results are also well representative of the results recorded during compliance testing as depicted in Figs. 2.25–2.30. Analytical strain prediction in the structural components is also compared for the two neutron poisons. Although there are minor differences between the compliance testing and drop simulations, the overall magnitude of the strains is very similar. The thermal aspects of these changes are addressed in Chap. 3. NCT and HAC results predicted for an undamaged package show that the change in neutron poison actually reduces the final temperature of the containment vessel components. Therefore, the substitution of Cat 277-4 material and the minor changes in the inner and mid liners for production hardware should not reduce the effectiveness of the packaging when subjected to the regulatory requirements of 10 CFR 71.71 and 71.73, and the results of compliance testing would be analogous. Some of the test units lost ~0.45 kg (1 lb) of their gross weight due to boiling off of the water trapped in the refractory and BoroBond4 materials (Table 2.62).

Assuming all water loss is from the neutron poison, the BoroBond4 material lost ~9.4% of its water content. Using the temperature data recorded during HAC testing shown in Table 2.50 and applying the temperature adjustments discussed in Sect. 3.4.3, the average temperature of the neutron poison would be ~150°C (302°F). Since the ES-3100 test units were not fabricated packages with Cat 277-4, thermogravimetric analysis (TGA) was used to compare the neutron poison's propensity to lose water. The results of this analysis are shown in Y/DV-1914, *Summary of TGA Testing of Borated Concrete and Adhesive-Backed Silicone Foam*. Samples of both BoroBond4 and Cat 277-4 were TGA tested, and the results were compared at 150°C (302°F). The BoroBond4 samples lost ~ 61.6% of their original water content. The dry Cat 277-4 lost a maximum of only 6.61%. The BoroBond4 TGA samples lost ~6.5 times the amount of water lost by the ES-3100 test units during HAC compliance testing. Assuming comparable results would be expected for the Cat 277-4 material due to similarity in the structural configuration, installation methodology, and LS-DYNA drop simulation structural deformation results, the Cat 277-4 water loss would be only 1.02%. Criticality safety analysis assumes a greater percent loss; therefore, additional conservatism is being applied in this SARP.

The maximum blackout temperature recorded adjacent to the O-rings during testing was 127.22°C (241°F) [Table 2.50]. Using the adjustments discussed in Sect. 3.4.2, the maximum adjusted temperature at the containment boundary O-rings during shipment under HAC was calculated to be 186.79°C (368.23°F). As shown in Fig. 2-24 of the *Parker O-Ring Handbook*, these O-ring materials

can survive at the predicted temperature shown in Table 3.29 [186.79°C (368.23°F)] for ~ five hours. Based on the O-ring temperature curve shown in Fig. 7-24 of DAC M801940-0002, the O-ring temperature would have fallen ~40°F to 328°F over that 5 hour period. At ~328°F, the O-ring should be able to survive ~20 hours. The total length of time above the continuous service temperature of 150°C (302°F) for the EPDM O-ring is ~11 hours. Based on the predicted data and the curves from *Parker O-Ring Handbook*, the thermally tested packages with all the conservative adjustments would remain below the acceptable time at temperature limits. Therefore, these adjusted temperatures would not adversely affect the containment vessel O-rings.

Table 2.52. Diametrical damage comparison of TU-1 with analytical predictions

(in.)

Axial measurement location	0 to 180°			90 to 270°		
	Test results	Analytical results with BoroBond	Analytical results with Cat 277-4	Test results	Analytical results with BoroBond	Analytical results with Cat 277-4
Top false wire	15.63	15	14.9	20.63	20.7	20.7
Top rolling hoop	16	15.3	15.1	20.44	20.8	20.8
CG & top rolling hoop	16.25	15.9	15.7	20.25	20.6	20.7
CG rolling hoop	16.5	16.4	16.2	19.88	20.1	20.4
Bottom rolling hoop	18.25	18.3	18.1	19.5	19.6	19.8
Bottom false wire	17.81	18.1	18	19.25	19.4	19.4

Table 2.53. Flat contour damage comparison of TU-1 with analytical results

(in.)

Axial measurement location	Flats width @ 0°			Flats width @ 180°		
	Test results	Analytical results with BoroBond	Analytical results with Cat 277-4	Test results	Analytical results with BoroBond	Analytical results with Cat 277-4
Top false wire	9	10.5	10.5	8.5	10.5	10.9
Top rolling hoop	10	11	11	10	11	11
CG & top rolling hoop	10	10.1	10.1	10.13	10.1	10.1
CG rolling hoop	9	8.4	8.4	10.63	10.1	10.1
Bottom rolling hoop	8.25	7.6	7.6	---	0	0
Bottom false wire	9.88	10.1	10.1	---	0	0



Fig. 2.25. Visual comparison of the cumulative damage on the crush side surface after the three drop tests (from top to bottom: TU-1, analytical results with BoroBond, analytical results with Cat 277-4).

Table 2.54. Cumulative analytical 12° slapdown drop tests maximum effective plastic strain results

Component	Component material	Effective plastic strain (in./in.)			
		Offset crush		Centered crush	
		Model with BoroBond	Model with Cat 277-4	Model with BoroBond	Model with Cat 277-4
CV body	Type 304L stainless steel	0.0457	0.0564	0.0741	0.0643
CV lid	Type 304L stainless steel	0.0005	0.0013	0.0006	0.0018
CV closure nut	SA-479 Nitronic 60	0.0000	0.0001	0.0003	0.0000
Angle	Type 304 stainless steel	0.1045	0.1070	0.0917	0.0944
Drum	Type 304 stainless steel	0.3972	0.3920	0.3537	0.3443
Drum bottom	Type 304 stainless steel	0.2877	0.2879	0.2919	0.3000
Liner	Type 304 stainless steel	0.2702	0.2060	0.2363	0.2846
Lid	Type 304 stainless steel	1.0797	0.9689	1.0795	0.5828
Lid stiffener	Type 304 stainless steel	0.0838	0.0894	0.0303	0.0288
Drum lid studs	Type 304 stainless steel	>0.57	0.4018	0.3174	0.2390
Lid hex nut	Silicon bronze - C65100	0.0086	0.0028	0.0000	0.0000
Drum washer	300 series stainless steel	0.1003	0.0790	0.0597	0.0775
Top plug weldment	Type 304 stainless steel	0.2715	0.2665	0.1636	0.1644

Table 2.55. Diametrical damage comparison of TU-2 with analytical predictions (in.)

Axial measurement location	0 to 180°			90 to 270°		
	Test results	Analytical results with BoroBond	Analytical results with Cat 277-4	Test results	Analytical results with BoroBond	Analytical results with Cat 277-4
Top false wire	17.63	18.1	18	19.81	19.6	19.6
Top rolling hoop	17.38	16.6	16.6	19.75	19.75	20.1
CG & top rolling hoop	17	16.5	16.5	20	20	20.4
CG rolling hoop	16	16.3	16.3	20.25	20.25	20.5
Bottom rolling hoop	15.5	16.1	16.1	20.13	20.13	20
Bottom false wire	18	17.6	17.6	19.25	19.38	19.4

Table 2.56. Flat contour damage comparison of TU-2 with analytical predictions (in.)

Axial measurement location	Flats width @ 0°			Flats width @ 180°		
	Test results	Analytical results with BoroBond	Analytical results with Cat 277-4	Test results	Analytical results with BoroBond	Analytical results with Cat 277-4
Top false wire	8	9.2	9.2	6.25	0	0
Top rolling hoop	9	8.4	9.3	8.88	10.1	10.1
CG & top rolling hoop	10.13	8.4	8.4	9.63	8.4	9.3
CG rolling hoop	9.88	9.3	9.3	12	9.3	9.3
Bottom rolling hoop	9.88	9.3	9.3	14.88	10.1	10.1
Bottom false wire	9.38	10.1	10.1	0	0	0



Fig. 2.26. Visual comparison of the cumulative damage on the rigid surface side after the four drop tests (from left to right: TU-2, analytical results with BoroBond, analytical results with Cat 277-4).



Fig. 2.27. Visual comparison of the cumulative damage on the crush plate side after the three drop tests (from left to right: TU-2, analytical results with BoroBond, analytical results with Cat 277-4).

Table 2.57. Cumulative analytical side drop test maximum effective plastic strain results

Component	Component material	Effective plastic strain (in./in.)	
		Model with BoroBond	Model with Cat 277-4
CV body	Type 304L stainless steel	0.0462	0.0525
CV lid	Type 304L stainless steel	0.0004	0.0004
CV closure nut	SA-479 Nitronic 60	0.0000	0.0005
Angle	Type 304 stainless steel	0.0816	0.0845
Drum	Type 304 stainless steel	0.2623	0.2814
Drum bottom	Type 304 stainless steel	0.2807	0.2827
Liner	Type 304 stainless steel	0.2005	0.2022
Lid	Type 304 stainless steel	0.6411	0.6413
Lid stiffener	Type 304 stainless steel	0.0217	0.0171
Drum studs	Type 304 stainless steel	0.1753	0.2364
Drum hex nut	Silicon bronze - C65100	0.0000	0.0018
Drum washer	300 series stainless steel	0.1034	0.0439
Top plug weldment	Type 304 stainless steel	0.1258	0.1286

Table 2.58. Diametrical damage comparison of TU-3 with analytical predictions [diameter (in.)]

Axial measurement location	0 to 180°			90 to 270°		
	Test results	Analytical results with BoroBond	Analytical results with Cat 277-4	Test results	Analytical results with BoroBond	Analytical results with Cat 277-4
Top false wire	19.25	19	19	19.06	19	19
Top rolling hoop	18.75	18.9	18.9	20.25	20.6	20.6
CG & top rolling hoop	19.25	19.4	19.4	19.75	19.9	19.8
CG rolling hoop	19.13	19.3	19.3	19.25	19.4	19.4
Bottom rolling hoop	19.13	19.3	19.3	19.75	20.4	20.4
Bottom false wire	18	18.6	18.6	19.38	19.4	19.4



Fig. 2.28. Visual comparison of the cumulative bottom damage after the three drop tests (from top to bottom: TU-3, analytical results with BoroBond, analytical results with Cat 277-4).

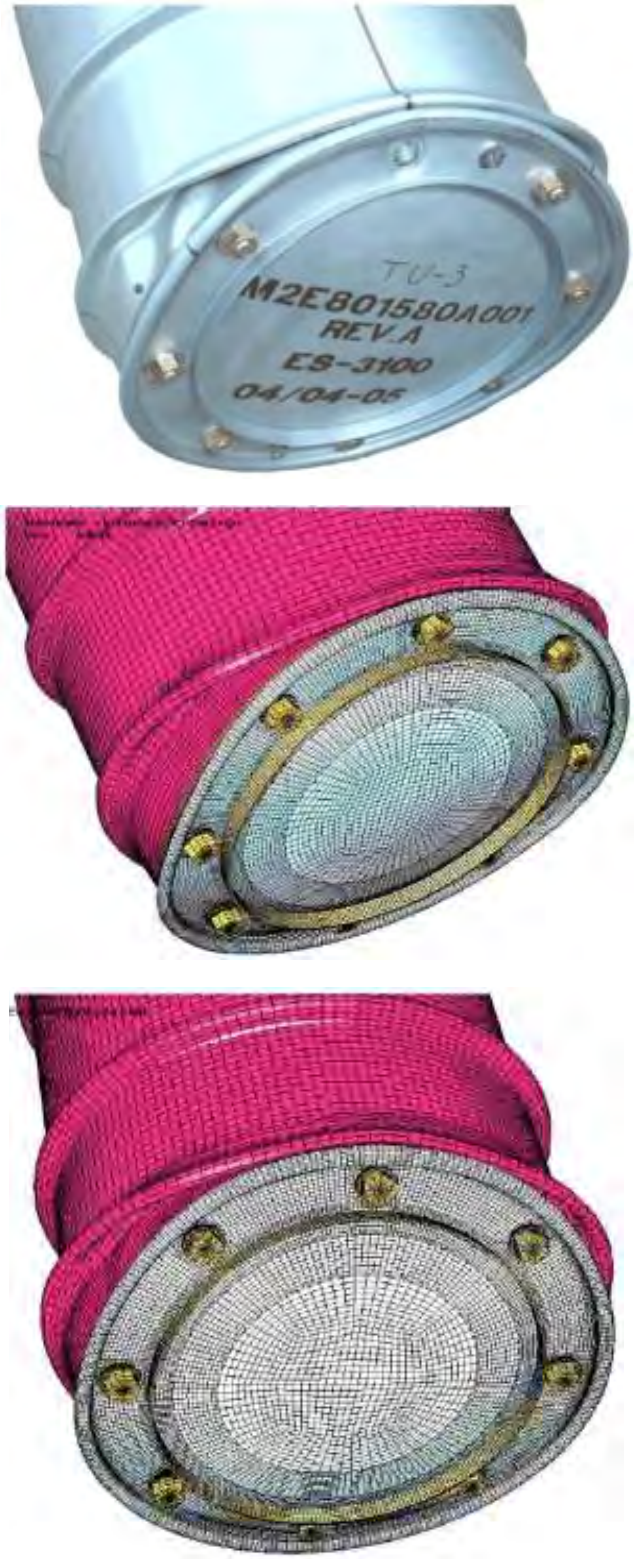


Fig. 2.29. Visual comparison of the cumulative lid damage after the three drop tests (from top to bottom: TU-3, analytical results with BoroBond, analytical results with Cat 277-4).

Table 2.59. Cumulative analytical corner drop test maximum effective plastic strain results

Component	Component material	Effective plastic strain (in./in.)	
		Model with BoroBond	Model with Cat 277-4
CV body	Type 304L stainless steel	0.0364	0.0371
CV lid	Type 304L stainless steel	0.0024	0.0051
CV closure nut	SA-479 Nitronic 60	0.0000	0.0002
Angle	Type 304 stainless steel	0.0464	0.0462
Drum	Type 304 stainless steel	0.3787	0.3830
Drum bottom	Type 304 stainless steel	0.0731	0.0761
Liner	Type 304 stainless steel	0.5507	0.5254
Lid	Type 304 stainless steel	0.3579	0.3622
Lid stiffener	Type 304 stainless steel	0.0272	0.0272
Drum studs	Type 304 stainless steel	0.5578	0.5598
Drum hex nut	Silicon bronze - C65100	0.2258	0.2266
Drum washer	300 series stainless steel	0.1111	0.1528
Top plug weldment	Type 304 stainless steel	0.1170	0.1166

Table 2.60. Diametrical damage comparison of TU-4 with analytical predictions [diameter (in.)]

Axial measurement location	0 to 180°			90 to 270°		
	Test results	Analytical results with BoroBond	Analytical results with Cat 277-4	Test results	Analytical results with BoroBond	Analytical results with Cat 277-4
Top false wire	19.25	19.3	19.3	19.38	19.3	19.3
Top rolling hoop	20.00	20.2	20.1	20.13	20.2	20.1
CG & top rolling hoop	20.00	20.2	20.2	20.06	20.2	20.2
CG rolling hoop	19.44	20.1	20.1	19.5	20.1	20.1
Bottom rolling hoop	19.94	20.5	20.5	20	20.5	20.5
Bottom false wire	19.25	19.4	19.4	19.25	19.4	19.4



Fig. 2.30. Visual comparison of the cumulative damage after the three drop tests (from left to right: TU-4, analytical results with BoroBond, analytical results with Cat 277-4).

Table 2.61. Cumulative analytical top drop test maximum effective plastic strain results

Component	Component material	Effective plastic strain (in./in.)	
		Model with BoroBond	Model with Cat 277-4
CV body	Type 304L stainless steel	0.0053	0.0083
CV lid	Type 304L stainless steel	0.0034	0.0072
CV closure nut	SA-479 Nitronic 60	0.0000	0.0011
Angle	Type 304 stainless steel	0.0304	0.0308
Drum	Type 304 stainless steel	0.1258	0.1237
Drum bottom	Type 304 stainless steel	0.0312	0.0267
Liner	Type 304 stainless steel	0.3585	0.3812
Lid	Type 304 stainless steel	0.1415	0.1389
Lid stiffener	Type 304 stainless steel	0.0098	0.0100
Drum studs	Type 304 stainless steel	0.1541	0.1535
Drum hex nuts	Silicon bronze - C65100	0.0170	0.0173
Drum washer	300 series stainless steel	0.0510	0.0506
Top plug weldment	Type 304 stainless steel	0.0944	0.0960

Table 2.62. ES-3100 test package weights before and after 10 CFR 71.73(c)(4) HAC testing

Test Unit	Pre-test [a] weight [kg (lb)]	Post-test [a] weight [kg (lb)]	Thermal test weight loss [kg (lb)]	BoroBond4 or Cat 277-4 original weight [kg (lb)]	Water weight in BoroBond4 or Cat 277-4 [kg (lb)]	Water loss percent [d] (%)
1	202.3 (446)	202.3 (446)	0.0 (0)	20.7 (45.64) [b]	4.91 (10.82) [c]	0.00
2	202.8 (447)	202.8 (447)	0.0 (0)	20.5 (45.19) [b]	4.86 (10.72) [c]	0
3	203.7 (449)	203.2 (448)	0.45 (1)	20.5 (45.19) [b]	4.87 (10.74) [c]	9.31
4	201.8 (445)	201.4 (444)	0.45 (1)	20.4 (44.97) [b]	4.84 (10.66) [c]	9.38
5	157.4 (347)	156.9 (346)	0.45 (1)	20.6 (45.42) [b]	4.89 (10.77) [c]	9.29

[a] ORNL/NTRC-013.
[b] Weight of BoroBond4 and water obtained from casting data (Barton).
[c] This weight is based on TGA measurements and calculation showing that the minimum water percent is 23.71%.
[d] All weight loss attributed to loss of water in BoroBond4 or 277-4.

Following the thermal test, all six containment boundaries were subjected to leak testing of the O-ring cavity as well as the full-body helium leak check. To verify the entire containment boundary, all test units were drilled and tapped for a helium leak check using the procedure documented in the test report (ORNL/NTRC-013). The procedure consisted of creating a near vacuum inside the containment vessel and supplying a helium environment around the exterior of the assembly. The maximum recorded helium leak rate for any of these containment vessels was 2.0×10^{-7} cm^3/s as documented after 17 min of leak checking. This procedure measures leakage in the opposite direction to leakage from the vessel. It could be postulated that the additional pressure differential (ambient on the exterior and a near vacuum inside) would help to further compress the O-rings during this test. However, since the containment vessel closure nut is screwed down, the additional pressure does not compress the O-ring more than a few ten thousands of an inch based on mismatch between the internal and external threaded joint. Only rotation of the closure nut will alter O-ring compression significantly. Pictures taken of all containment vessel tops following testing showed that the closure nut had rotated a maximum of 0.15 cm (0.060 in.) [Fig. 2.31] from its original radial position obtained during assembly (Fig. 2.32) except for TU-4, which showed no rotation. Based on the pitch of the closure nut, this rotation translates into only 0.0009 cm (0.00035 in.) decompression of the O-rings. This compares to the original nominal compression of 0.064 cm (0.025 in.). According to the *Parker O-Ring Handbook*, the minimum squeeze for all seals, regardless of cross section, should be ~0.018 cm (0.007 in.). Using the nominal compression of 0.064 cm (0.025 in.) and subtracting the decompression from rotation and the minimal pressure differential compression, there is ample O-ring compression. Therefore, the leak test in either direction for this containment vessel arrangement is valid. As required in 10 CFR 71.73(c)(5), the containment vessels were submerged under a 0.9-m (3-ft) head of water following the leakage tests, with no water in-leakage permitted. Following this immersion test, the containment vessels were opened. The lid assembly, with the O-rings in place on the body, are joined together by torquing the closure nut and sealing lid assembly to 162.7 ± 6.8 N·m (120 ± 5 ft-lb). The lowest break-loose torque value of 40.7 N·m (30 ft-lb) was recorded for TU-4. Visual inspection following the testing indicated that neither the vessel bodies, the O-rings, the seal areas, nor the vessel lid assemblies were damaged during the tests. In TU-5, the convenience cans had buckled from the pressure differential caused during the leak testing operation. However, the containment vessel wall showed little or no signs of impact. Therefore, based on the success of these seven test units (including the containment vessel of TU-6) and the analytical drop simulation effort, the structural integrity of the ES-3100 package, with the previously mentioned modifications, meets all the applicable requirements of 10 CFR 71.73 for transport of the proposed contents.



Fig. 2.31. Containment vessel markings at assembly (swivel hoist ring removed prior to testing).

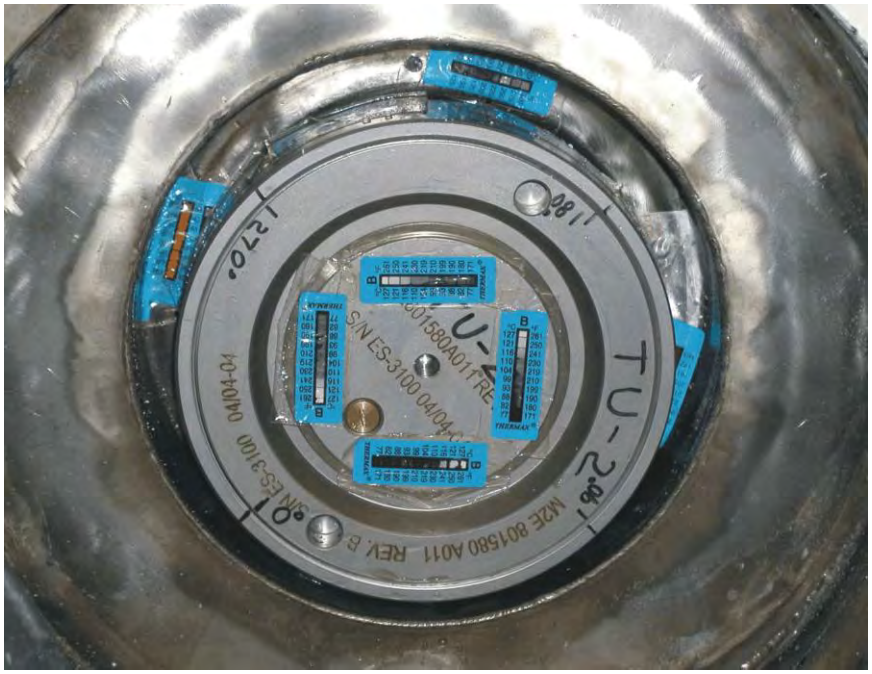


Fig. 2.32. Containment vessel marking after compliance testing.

2.8 ACCIDENT CONDITIONS FOR AIR TRANSPORT OF PLUTONIUM

The proposed contents to be shipped in the ES-3100 have only trace amounts of transuranic isotopes. Since the contents contain no more than an A_2 quantity of plutonium in any isotope or form and will be shipped in accordance with 10 CFR 71.5 per 10 CFR 71.88(a)(3), the requirements in 10 CFR 71.74 are not applicable.

2.9 ACCIDENT CONDITIONS FOR FISSILE MATERIAL PACKAGES FOR AIR TRANSPORT

The expanded tests specified in 10 CFR 71.55(f)(1), (2), or (3) for fissile material package designs for air transportation were not conducted. The issue of subcriticality is addressed in Chap. 6 with content mass limits as addressed in Sect. 1.2.2 for air transport.

2.10 SPECIAL FORM

The package does not include any special form of radioactive material. Hence, the requirements of 10 CFR 71.75 and 71.77 are not applicable.

2.11 FUEL RODS

The contents do not utilize cladding for the containment of radioactive materials. Therefore, this requirement is not applicable.

2.12 APPENDIX

Appendix 2.12.1 Chapter 2 References 2-103

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Appendix 2.12.1
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3. THERMAL EVALUATION

Design analysis, similarity, and full-scale testing (see Chap. 2) have demonstrated that the ES-3100 shipping package is in compliance with the applicable requirements of Title 10 Code of Federal Regulations (CFR) 71 (10 CFR 71) when used to ship highly enriched uranium (HEU) having a maximum gross weight up to 35.2 kg (77.60 lb). The ES-3100 has a nominal gross shipping weight that ranges from 146.88 kg (323.79 lb) to 187.81 kg (414.05 lb) for the empty and maximum weight containment vessel configurations shown in Table 2.8, respectively.

3.1 DESCRIPTION OF THERMAL DESIGN

The drum assembly of the shipping package is defined as the structure that maintains the position of and provides the impact and thermal barrier surrounding the containment boundary. Preserving the location of the containment boundary within the packaging prevents reduction of the shielding and subcriticality effectiveness. The nominal weight of the drum assembly is 131.89 kg (290.76 lb).

The ES-3100 package is evaluated for a maximum heat source of 5 W (Sect. 3.1.2); however, no active cooling systems or specific thermal design features are required. A lightweight cast refractory insulation between the inner liner and the drum provides thermal protection of the contents from external heat sources.

Thermal criteria are applied to the package in accordance with 10 CFR 71 for Normal Conditions of Transport (NCT) and Hypothetical Accident Conditions (HAC). These requirements specify that each package design provide containment, shielding, and criticality safety at temperatures ranging from −40 to 38°C (−40 to 100°F) with full insolation. Also, in accordance with *Packaging and Transportation of Radioactive Material* [10 CFR 71.43(g)], a package must be designed, constructed, and prepared for transport so in still air at 38°C (100°F) and in the shade no accessible surface of a package would have a temperature exceeding 50°C (122°F) in a nonexclusive use shipment, or 85°C (185°F) in an exclusive use shipment. In addition, each package will experience no significant reduction in effectiveness as the result of being exposed to a thermal radiation environment of 800°C (1475°F) for 30 min with an emissivity coefficient of at least 0.9.

The maximum internal pressures and thermal stresses for both NCT and HAC are discussed and calculated (Sects. 3.3.2, 3.3.3, and 3.4.3) for use in the structural evaluation. The calculated pressures are well below the design pressures of the package components, and the effect of thermal stresses on the package is negligible (Sects. 2.6.1.2 and 2.7.4.2).

Compliance with the NCT thermal requirements is shown by analysis (Sect. 3.3.1). Since the components to be shipped have a maximum decay heat load of 5 W, a thermal analysis was conducted for the ES-3100 package (DAC M801940-0002) using both Kaolite 1600™ and Packcrete material properties. The maximum predicted temperature on the exterior of the package, while stored at 38°C (100°F) in the shade, is 39.42°C (102.96°F) [Table 3.14, Node K]. The analysis shows that no accessible surface of the package would have a temperature exceeding 50°C (122°F). Therefore, the requirement of 10 CFR 71.43(g) would be satisfied. If the package is exposed to solar radiation at 38°C (100°F) in still air, the conservatively calculated temperatures at the top of the drum, center of containment vessel lid, and on the containment vessel near the O-ring sealing surfaces are 119.38°C (246.88°F), 89.60°C (193.28°F), and 89.53°C (193.15°F), respectively (Sect. 3.3.1 and Table 3.16). For

conservatism, the O-ring sealing surface temperature will be assumed to be 89.60°C (193.28°F). At the low-temperature range and neglecting decay heating, the package components would stabilize at −40°C (−40°F), which is within normal operating limits of the packaging materials (Sect. 2.2).

Six full-scale packages were subjected to the HAC thermal test following the drop, crush and puncture tests (Sects. 2.7.1 through 2.7.3). All of these test packages were exposed to a thermal radiation environment of >800°C (>1475°F) for well over 30 min in a furnace. Other temperature conditions before and during the thermal testing are given in ORNL/NTRC-013 for the furnace, test packages, and package supports. The maximum temperature recorded during the tests on the external surface of any of the containment vessels was 127.2°C (261°F). This containment vessel maximum temperature reading is the highest value shown in Table 3.4. This temperature was recorded on Test Unit (TU)-4 and TU-5 on the containment vessel sealing lid. The maximum internal temperature adjacent to the O-rings was 116°C (241°F). Temperature adjustments are then added to the containment vessel's maximum recorded temperature to correct for measuring accuracy, insolation heating before the thermal test, internal decay heating, insolation heating during cool down, location of crush plate damage, neutron poison substitution, thermal capacitance difference between mockups and actual contents, and impact limiting material variations. Detailed discussion of each temperature adjustment is provided in Sect. 3.4.3. Although TU-5 was tested with a mock-up that represented the lightest proposed content at that time, a new lower weight limit has been established (empty containment vessel). The containment vessel's recorded temperature values were lower on all other test units, which consisted of much heavier mock-up contents. Therefore, a temperature correction is needed for weight differences of the contents shipped and the tested weights.

3.1.1 Design Features

The drum assembly for the ES-3100 consists of an internally flanged Type 304L stainless-steel 30-gal modified drum with two Type 304L stainless-steel inner liners, one filled with noncombustible cast refractory insulation and impact limiter and one filled with noncombustible cast neutron poison; a stainless-steel top plug with noncombustible cast refractory insulation, silicone rubber pads, silicon bronze hex-head nuts, and a stainless-steel lid and bottom (Drawing M2E801580A031, Appendix 1.3.7). The drum's diameter (inner diameter of 18.25 in.) and corrugations meet the requirements of Military Standard MS27683. All other dimensions are controlled by Drawing M2E801580A004 (Appendix 1.3.7). Modifications to the drum from MS27683 include the following: (1) the overall height was increased; (2) the drum was fabricated with two false wire open ends; and (3) a 0.27-cm (12-gauge, 0.1046-in.)–thick concave cover was welded to the bottom false wire opening (Drawing M2E801580A005, Appendix 1.3.7). Four 0.795-cm (0.313-in.)–diam equally spaced holes are drilled in the top external sidewall to prevent a pressure buildup between the drum and inner liner. The holes are filled with a plastic plug to provide a moisture barrier for the cast refractory insulation during NCT. The cavity created by the inner liners is a three-tiered volume with a 37.52-cm (14.77-in.) inside diameter 13.26-cm (5.22-in.) deep, a 21.84-cm (8.60-in.) inside diameter 5.59-cm (2.20-in) deep, and an additional 15.85-cm (6.24-in.) inside diameter 78.31-cm (30.83-in.) deep. Drum and inner liner wall thickness is 0.15 cm (16 gauge, 0.0598 in.).

The volume between the drum and mid liner is filled with a lightweight noncombustible cast refractory material called Kaolite 1600 (Kaolite product data sheet) or Packcrete. Both materials are composed of portland cement, water, and vermiculite and have an average density of 358.8 kg/m^3 (22.4 lb/ft^3). The procedures for manufacturing and documenting Kaolite 1600 material, JS-YMN3-801580-A003 (Appendix 1.3.4), and Packcrete material, SPC M801794-0003 (Appendix 1.3.11) and SPC M801580-0003 (Appendix 1.3.12), are referenced on Drawings M2E801580A002 and M2E801580A008 (Appendix 1.3.7) for the drum body weldment and top plug weldment, respectively.

Both insulation types have a maximum continuous service temperature limit of 871°C (1600°F) due to the presence of the vermiculite and portland cement.

The volume inside the center liner tube is filled with a noncombustible cast neutron poison (absorber) material called Cat 277-4, which is created by mixing Cat 277-0 material from Shieldwerx (SWX-277-0) and boron carbide (B_4C). The material is composed of aluminum, magnesium, calcium boron, carbon, silicon, sulfur, sodium, iron, and water. The final mixture will have an average density of 1762 kg/m^3 (110 lb/ft^3). The procedure for manufacturing and documenting this material, JS-YMN3-801580-A005 (Appendix 1.3.5), is referenced on Drawing M2E801580A002 (Appendix 1.3.7). This neutron poison material has a maximum continuous service temperature limit of 150.0°C (302°F). At this temperature, the moisture inside the Cat 277-4 material remains an integral part of the composite material, and moisture content loss is negligible.

The top plug is fabricated in accordance with Drawing M2E801580A008 (Appendix 1.3.7), with an overall diameter of 36.50 cm (14.37 in.) and a height of 13.41 cm (5.28 in.). The plug's rim, bottom sheet, and top sheet are fabricated from 0.15-cm (16-gauge, 0.0598-in.)–thick Type 304/304L stainless-steel sheet per ASME SA-240. Four lifting inserts are welded into the top sheet for loading and unloading operations. The internal volume of the top plug assembly is filled with either Kaolite 1600 in accordance with JS-YMN3-801580-A003 (Appendix 1.3.4) or Packcrete in accordance with SPC M801794-0003 (Appendix 1.3.11) and SPC M801580-0003 (Appendix 1.3.12).

Three silicone rubber pads complete the drum assembly. One pad is placed on the bottom of the most inward liner to support the containment vessel during transport. Another pad is placed on the top shelf of the mid liner to support the top plug during transport. The final pad is placed over the top of the containment vessel lid and closure nut assembly. Pads are molded to the shapes as defined on Drawing M2E801580A009 (Appendix 1.3.7) using silicone rubber with a Shore A durometer of 22 ± 5.

3.1.2 Content's Decay Heat

The maximum decay heat and radioactivity of the contents (Chap. 4) are based on a maximum of 35.2 kg of HEU in the isotopic and mass distribution at fabrication as shown in Table 3.1.

Table 3.1. Isotopic mass and weight percent for the HEU contents [a]

Nuclide	Weight percent	Mass (g)
^{232}U	0.000004	0.001408
^{233}U	0.600000	211.200000
^{234}U	2.000000	704.000000
^{235}U	54.819996	19,296.638592
^{236}U	40.000000	14,080.000000
^{238}U	0.000000	0.000000
Transuranic	0.080000 [b]	28.160000
^{237}Np	2.500000	880.000000
Total	**100.000000**	**35,200.000000**

[a] Weight percent values of individual isotopes are those that generate the largest activity within the allowable ranges presented in Sect. 1.2.2.

[b] The transuranic weight percent of 0.080000 applies to ground transport only. The maximum transuranic weight percent in contents transported by air will be 0.004000.

Using the ORIGEN-S program (NUREG/CR-0200) for determining decay heat values and predicting the isotopic decay patterns from 0 to 70 years from original fabrication, the following decay heat loads are predicted and shown in Table 3.2. Isotopic mass distribution has been calculated in Chap. 4 and shown in Table 2 of Appendix 4.5.1. The maximum decay heat load is rounded up from 3.494 to 5 W, and 5 W is used in subsequent analyses for temperature predictions. Contributions from the transuranics and ^{237}Np at the bottom of Table 3.2 remain constant for the time period evaluated. The decay heat per gram value used for the transuranic isotopes was an average of the decay heat values for ^{238}Pu, ^{239}Pu, ^{240}Pu, ^{241}Pu, ^{242}Pu and ^{241}Am. As shown in Chap. 1, some Thorium (^{232}Th) compounds or oxides mixed with uranium are proposed for transport. Shipping of ^{232}Th is bounded by the analysis using uranium for containment or hydrogen gas generation shown in Appendix 3.5.4 due to the following: (1) the A_2 of ^{232}Th is unlimited; (2) the decay energy of ^{232}Th is less than all other uranium isotopes; and (3) the half-life of ^{232}Th is significantly longer than the uranium isotopes.

3.1.3 Summary Tables of Temperatures

3.1.3.1 NCT summary tables

Thermal evaluation of the ES-3100 package design for NCT was performed by analysis (DAC-PKG-801699-A001, DAC-PKG-801940-A001, and DAC M801940-0002). The ES-3100 shipping container has been conservatively evaluated empty of all containment vessel internal components for NCT. A summary of the maximum and minimum predicted temperatures for the drum assembly and containment vessel are shown in Table 3.3. A comprehensive discussion of the NCT evaluation is provided in Sect. 3.3.

3.1.3.2 HAC temperature summary tables

Thermal evaluation of the package design for HAC was performed by a combination of physical testing and analysis. Temperature indicators (patches) were placed on the surface of each containment vessel, inner liner, and mock-up component during thermal testing. The blackout temperatures that occurred during thermal testing are recorded for each test unit; the maximum blackout temperatures are listed in Table 3.4. In order to more accurately predict the final HAC temperatures, the blackout temperatures are increased to account for (1) the temperature interval between blackout dots; (2) the temperature increase due to the effects of applying solar insolation prior to the HAC thermal test; (3) the temperature increase due to the decay heat load of the actual contents being shipped; (4) the temperature increase due to the effects of applying solar insolation during post-HAC thermal test cool down; (5) effects of crushing at different locations along the body of the shipping package; (6) thermal capacitance difference in the proposed contents and hardware used during testing; and, (7) temperature difference resulting from variations in impact limiting material properties (Kaolite 1600 vs Packcrete). A summary of the maximum and minimum predicted temperatures for the drum assembly and containment vessel is shown in Table 3.5. A comprehensive discussion of the HAC evaluation is provided in Sect. 3.4.

Table 3.2. Decay heat for 35.2 kg of HEU content (watts)

Decay heat (Watts per gram)	Isotope	Decay time								
		0 years	5 years	10 years	20 years	30 years	40 years	50 years	60 years	70 years
1.7920E-02	Pb-210	0.0000E+00	2.535964E-12	1.955594E-11	1.463541E-10	4.579875E-10	1.015647E-09	1.854660E-09	3.028017E-09	4.529408E-09
2.6280E+03	Pb-212	0.0000E+00	4.773325E-05	5.328363E-05	4.958338E-05	4.477305E-05	4.070278E-05	3.678051E-05	3.330227E-05	3.015706E-05
2.8650E+02	Bi-210	0.0000E+00	2.500751E-11	1.927998E-10	1.433898E-09	4.517486E-09	1.000300E-08	1.831195E-08	2.984767E-08	4.456984E-08
2.4500E+05	Bi-212	0.0000E+00	4.214730E-04	4.698388E-04	4.387465E-04	3.972902E-04	3.592885E-04	3.257780E-04	2.950312E-04	2.670481E-04
1.4420E+02	Po-210	0.0000E+00	3.472645E-10	2.680638E-09	1.990171E-08	6.275130E-08	1.391089E-07	2.548637E-07	4.132651E-07	6.193899E-07
5.1130E+03	Rn-222	0.0000E+00	7.235482E-09	2.894193E-08	1.155517E-07	2.599014E-07	4.607670E-07	7.199484E-07	1.033126E-06	1.407499E-06
1.8230E+03	Ra-223	0.0000E+00	1.189035E-08	4.502854E-08	1.639320E-07	3.359551E-07	5.452674E-07	7.844815E-07	1.044803E-06	1.319195E-06
5.4700E+03	Ra-224	0.0000E+00	8.625971E-04	9.627200E-04	9.011059E-04	8.163866E-04	7.378287E-04	6.677427E-04	6.045882E-04	5.475952E-04
2.8380E+01	Ra-225	0.0000E+00	5.994152E-07	1.294737E-06	2.589474E-06	3.884210E-06	5.172953E-06	6.473684E-06	7.732456E-06	9.051169E-06
2.8600E-02	Ra-226	0.0000E+00	6.302640E-09	2.517029E-08	1.006812E-07	2.255258E-07	4.007110E-07	6.262368E-07	9.000895E-07	1.224283E-06
1.5200E-02	Ra-228	0.0000E+00	3.124058E-15	1.048485E-14	3.124058E-14	5.499198E-14	7.959929E-14	1.044206E-13	1.294558E-13	1.544911E-13
2.0290E+03	Ac-225	0.0000E+00	3.428182E-05	6.256431E-05	1.251286E-04	1.876929E-04	2.498287E-04	3.123930E-04	3.745288E-04	4.370931E-04
3.5000E-02	Ac-227	0.0000E+00	1.614311E-10	6.139787E-10	2.222211E-09	4.559248E-09	7.429885E-09	1.067202E-08	1.418433E-08	1.789927E-08
1.7460E+04	Ac-228	0.0000E+00	4.376020E-13	1.470146E-12	4.376020E-12	7.694912E-12	1.116131E-11	1.465229E-11	1.814328E-11	2.165884E-11
1.1250E+03	Th-227	0.0000E+00	1.204834E-08	4.580540E-08	1.660717E-07	3.408269E-07	5.535723E-07	7.967100E-07	1.059385E-06	1.339428E-06
2.6850E+01	Th-228	0.0000E+00	8.242674E-04	9.187935E-04	8.582968E-04	7.788949E-04	7.032741E-04	6.389964E-04	5.784997E-04	5.217840E-04
6.0870E-03	Th-229	0.0000E+00	3.856882E-05	5.502484E-05	1.099211E-04	1.645603E-04	2.198423E-04	2.738386E-04	3.291206E-04	3.844025E-04
5.8220E-04	Th-230	0.0000E+00	5.697049E-06	1.135311E-05	2.274721E-05	3.410032E-05	4.549442E-05	5.697049E-05	6.803670E-05	7.951277E-05
5.7940E+02	Th-231	0.0000E+00	4.550499E-05	4.550499E-05	4.550499E-05	4.550499E-05	4.550499E-05	4.550499E-05	4.550499E-05	4.550499E-05
2.6590E-09	Th-232	0.0000E+00	5.428104E-12	1.089364E-11	2.178729E-11	3.268093E-11	4.342483E-11	5.428104E-11	6.551160E-11	7.636781E-11
9.5900E+00	Th-234	0.0000E+00	0.000000E+00	0.000000E+00	0.000000E+00	0.000000E+00	0.000000E+00	0.000000E+00	0.000000E+00	0.000000E+00
1.4390E-03	Pa-231	0.0000E+00	1.343862E-07	2.690500E-07	5.386554E-07	8.079830E-07	1.074534E-06	1.343862E-06	1.613190E-06	1.879741E-06
5.2710E+01	Pa-233	0.0000E+00	0.000000E+00	0.000000E+00	0.000000E+00	0.000000E+00	0.000000E+00	0.000000E+00	0.000000E+00	0.000000E+00
7.0800E-01	U-232	9.9686E-04	9.470208E-04	9.021619E-04	8.174285E-04	7.396731E-04	6.698926E-04	6.070902E-04	5.492721E-04	4.974351E-04
2.8070E-04	U-233	5.9280E-02	5.927847E-02	5.927771E-02	5.927518E-02	5.927266E-02	5.927011E-02	5.926762E-02	5.926507E-02	5.926252E-02
1.7910E-04	U-234	1.2609E-01	1.260924E-01	1.260907E-01	1.260871E-01	1.260837E-01	1.260801E-01	1.260766E-01	1.260732E-01	1.260697E-01
6.0000E-08	U-235	1.1578E-03	1.157798E-03	1.157798E-03	1.157798E-03	1.157798E-03	1.157798E-03	1.157798E-03	1.157798E-03	1.157798E-03
2.0000E-06	U-236	2.4656E-02	2.465563E-02	2.465562E-02	2.465561E-02	2.465561E-02	2.465560E-02	2.465559E-02	2.465559E-02	2.465558E-02
8.5111E-09	U-238	0.0000E+00	0.000000E+00	0.000000E+00	0.000000E+00	0.000000E+00	0.000000E+00	0.000000E+00	0.000000E+00	0.000000E+00
1.1580E-01	transuranic	3.261285E+00	3.261285E+00	3.261285E+00	3.261285E+00	3.261285E+00	3.261285E+00	3.261285E+00	3.261285E+00	3.261285E+00
2.0100E-05	Np-237	1.768800E-02	1.768800E-02	1.768800E-02	1.768800E-02	1.768800E-02	1.768800E-02	1.768800E-02	1.768800E-02	1.768800E-02
	Total watts	**3.491158E+00**	**3.493385E+00**	**3.493638E+00**	**3.493521E+00**	**3.493358E+00**	**3.493217E+00**	**3.493107E+00**	**3.493016E+00**	**3.492946E+00**

Table 3.3. Summary of results of evaluation for the ES-3100 under NCT

Conditions	Calculated results	Allowable limit	SARP reference
Minimum package temperature, °C (°F)	−40 (−40)	−40 (−40)	Sect. 3.3.1
Maximum drum temperature with insolation, °C (°F)	119.38 (246.88) [a]	N/A	Sect. 3.3.1
Maximum containment vessel temperature with insolation, °C (°F)	89.60(193.28) [a]	427 (800) [b]	Sect. 3.3.1
Maximum O-ring temperature, °C (°F)	89.53 (193.15) [a]	150 (302) [c]	Sect. 3.3.1

[a] DAC M801940-0002, Table 7-3.
[b] *ASME Boiler and Pressure Code*, Sect. II, Part D, maximum allowable temperature for Sect. III, Div. 1, Subsection NB vessel.
[c] Maximum ethylene propylene diene monomer O-ring seal life up to 150°C (302°F) for 1000 h of continuous service (*Parker O-Ring Handbook*, Fig. 2-28).

Table 3.4. Maximum HAC temperatures recorded on the test packages' interior surfaces

Temperature patch location [a]	ES-3100 Test Unit				
	1	2	3	4	5
	[°C (°F)]	[°C (°F)]	[°C (°F)]	[°C (°F)]	[°C (°F)]
Top plug bottom	149 (300)	163 (325)	177 (350)	177 (350)	177 (350)
Inner liner					
Flange step wall	135 (275)	163 (325)	135 (275)	135 (275)	135 (275)
BoroBond4 step	107 (225)	135 (275)	107 (225)	177 (350) [b]	121 (250)
Adjacent to containment vessel body wall high	99 (210)	99 (210)	99 (210)	99 (210)	104 (219)
Adjacent to containment vessel body wall middle	99 (210)	93 (199)	116 (241)	93 (199)	99 (210)
Bottom flat portion	104 (219)	99 (210)	99 (210)	127 (261)	110 (230)
Containment boundary					
Lid (external top)	116 (241)	110 (230)	116 (241)	127 (261)	127 (261)
Lid (internal)	104 (219)	104 (219)	110 (230)	110 (230)	116 (241)
Flange (external)	116 (241)	110 (230)	110 (230)	116 (241)	121 (250)
Flange (internal)	104 (219)	99 (210)	116 (241) [b]	104 (219)	116 (241)
Body wall mid height	99 (210)	88 (190)	99 (210)	82 (180)	93 (199)
Bottom end cap (center)	99 (210)	99 (210)	88 (190)	110 (230)	99 (210)
Mock-up					
Side top	82 (180)	77 (171)	77 (171)	77 (171)	99 (210)
Side middle	77 (171)	77 (171)	77 (171)	77 (171)	93 (199)
Side bottom	77 (171)	77 (171)	77 (171)	77 (171)	88 (190)

[a] Refer to figures for exact locations and to Tables 5.3 through 5.7 in ORNL/NTRC-013 for recorded values.
[b] Temperature-indicating patch may have been damaged due to impact with surrounding structure.

Table 3.5. Summary of results of evaluation under HAC for the ES-3100 shipping arrangement using bounding case parameters

Condition	Results	Design limits	SARP reference
Maximum adjusted containment vessel temperature during testing, °C (°F)	198.04 (388.48)	426.67 (800) [a]	Sect. 3.4.3
Maximum adjusted O-ring temperature, °C (°F)	186.79 (368.23) [b]	150 (302) [b]	Sect. 3.4.3

[a] *ASME Boiler and Pressure Code*, Sect. II, Part D, maximum allowable temperature for Sect. III, Div. 1, Subsection NB vessel.

[b] Maximum ethylene propylene diene monomer O-ring seal life at 186.79°C (368.23°F) is on the order of about 5 hours (*Parker O-Ring Handbook*, Fig. 2-24). Limit shown is for 1000 h of continuous service at a temperature up to 150°C (302°F).

3.1.4 Summary Tables of Maximum Pressures

3.1.4.1 Maximum NCT pressures

Table 3.6 summarizes the results from Appendix 3.5.1 in which the pressure of the containment vessel when subjected to the tests and conditions of NCT per 10 CFR 71.71 has been determined for the most restrictive containment vessel arrangements (CVAs) shipped in the ES-3100. The most restrictive CVAs are those in which the void volume inside the containment vessel is minimized based on content volumes and those CVAs that carry the largest mass of items that offgas at the predicted temperatures during NCT. Several convenience container heights are proposed for shipment (Fig. 1.4). Shipping configurations will use these containers in any configuration as long as it does not exceed the HEU weight limit and form and does not exceed the height constraint of the containment vessel. However, in order to determine the worst-case shipping configuration, the arrangements that minimize the void volume inside the containment vessel are analyzed as follows:

1. one shipment will contain six cans with external dimensions of 10.8-cm (4.25-in.) diam by 12.38-cm (4.875-in.)–high cans;

2. one shipment will contain five cans with external dimensions of 10.8-cm (4.25-in.) diam by 12.38-cm (4.875-in.)–high cans and three can spacers;

3. one shipment will contain three cans with external dimensions of 10.8-cm (4.25-in.) diam by 22.23-cm (8.75-in.) high and two can spacers;

4. one shipment will contain three cans with external dimensions of 10.8-cm (4.25-in.) diam by 25.4 cm (10 in.) high;

5. one shipment will contain six nickel cans with external dimensions of 7.62-cm (3.00-in.) diam by 12.07-cm (4.75-in.) high;

6. one shipment will contain three polyethylene bottles with external dimensions of 12.54-cm (4.94-in.) diam by 22.1-cm (8.7-in.) high;

7. one shipment will contain three Teflon bottles with external dimensions of 11.91-cm (4.69-in.) diam by 23.88-cm (9.4-in.) high;

8. one shipment will contain a brazed assembly of two cans with final external dimensions of 10.8-cm (4.25-in.) diam by 44.46-cm (17.50-in.) high. An empty can with external dimensions of 10.8-cm (4.25-in.) diam by 22.23-cm (8.75-in.) high will be placed on top or bottom of the 44.46-cm (17.50-in.)-high can;

9. one shipment will contain fuel rods, or tubes, or plates greater than 43.18 cm (17.00 in.) in length. These items are bundled together and protected on both ends with an open-ended can with external dimensions of ≤12.7-cm (5.0-in.) diam by ≤ 22.23-cm (8.75-in.) high. Total assembly height will be ≤77.47 cm (30.5 in.). If space is available inside the containment vessel, stainless-steel metal scrubbers will be added on the bottom and top of this assembly or an empty can will be placed on top or bottom of this partially canned assembly;

10. one shipment will contain three cans brazed together with external dimensions of 4.25-in. diam by ~30-in. high; and

11. one shipment will contain closed cans with diameters >4.25 in. In this situation, the void volume inside the loaded containment vessel must be ≥43 in.[3]

Table 3.6. Total pressure inside the containment vessel at 89.60°C (193.28°F)

CVA [a]	n_a [b] (lb-mol)	n_v [b] (lb-mol)	n_{po} [b] (lb-mol)	n_{bo} [b] (lb-mol)	n_{tf} [b] (lb-mol)	n_{H2} [b] (lb-mol)	n_{O2} [b] (lb-mol)	n_T [b] (lb-mol)	P_T (psia)
1	6.4075E-04	2.0884E-05	0.0000E+00	0.0000E+00	0.0000E+00	3.5761E-05	1.7881E-05	7.1528E-04	19.333
7	4.5248E-04	2.5459E-04 [c]	0.0000E+00	0.0000E+00	2.2296E-05	2.4457E-05	1.2228E-05	7.6605E-04	30.276
11	6.1157E-05	1.9932E-06	0.0000E+00	0.0000E+00	0.0000E+00	3.4133E-06	1.7067E-06	6.8270E-05	19.333

[a] This assumes that the internal convenience cans, polyethylene or Teflon FEP bottles, and Cat 277-4 spacer cans are not sealed.
[b] n_a—molar quantity of dry air in the gas mixture;
n_v—molar quantity of water vapor in the gas mixture;
n_{po}—molar quantity of gas due to offgassing of the silicone rubber pads;
n_{bo}—molar quantity of gas due to offgassing of the polyethylene, nylon, or Teflon bags; polyethylene bottles; and lifting sling;
n_{tf}—molar quantity of gas due to offgassing of the Teflon bottles;
n_{H2}—molar quantity of hydrogen gas due to radiolysis of water;
n_{O2}—molar quantity of oxygen gas due to radiolysis of water; and
n_T—total molar quantity in the gas mixture.
[c] This value is the molar quantity of water vapor generated from the efflorescence of UNX crystals.

These arrangements are shown in Fig. 1.4. To determine the ES-3100's maximum normal operating pressure, the following assumptions have been used in the calculations:

1. the HEU contents are loaded into convenience cans, and convenience cans are placed inside the containment vessel at standard temperature (T_{amb}) and pressure (P_t) [25°C (77°F) and 101.35 kPa (14.7 psia)] with air at a maximum relative humidity of 100% for all configurations except for CVA 7; CVA 7 assumes the air is 100% dry;

2. the convenience cans and bottles are assumed to not be sealed to maximize the void volume inside the containment vessel;

3. convenience can and bottle geometry does not change during pressure increase inside containment vessel;

4. if metal convenience cans are used, the total amount of polyethylene, nylon, or Teflon bagging and lifting slings is limited to 500 g per containment vessel shipping arrangement;

5. the mass of offgassing material (polyethylene, nylon, or Teflon bagging , Teflon bottles, silicone pads, lifting slings) is assumed to be 1490 g for the offgassing evaluation of CVA 7;

6. CVA 11 uses metal cans and, therefore, is limited to 500 g of polyethylene, nylon, or Teflon bagging and lifting slings.

The offgassing material limits identified in assumptions 4 and 5 have been established based on the needs of shippers. All configurations are limited to 500 g of polyethylene, nylon, or Teflon in the form of bags, slings, and/or polyethylene bottles. When the requirement to ship material in Teflon bottles arose, the upper limit of 1490 g of offgassing material was established. This limit is a combination of three Teflon bottles (330 g per bottle) and the original 500-g allowance for polyethylene, nylon, or Teflon bagging material. These offgassing material limits have been used in calculations pertaining to containment vessel pressure, radioactive material leakage criteria, and criticality control. Therefore, portions of the safety basis for this shipping package have been based on these material limits.

NUREG-1609, Sect. 4.5.2.3, requires the applicant to demonstrate that any combustible gases generated in the package during a period of one year do not exceed 5% (by volume) of the free gas volume in any confined region of the package. No credit should be taken for getters, catalysts, or other recombination devices. The analysis conducted in Appendix 3.5.4 evaluates the different packaging arrangements for the generation of hydrogen gas due to the radiolysis of water vapor, free water, interstitial water, polyurethane, nylon, or Teflon bags, and polyurethane or Teflon bottles. By limiting the mass and the material composition as shown in Appendix 3.5.4, the combustible gas concentration limit stated in NUREG-1609 is not exceeded. These limits are further discussed and shown in Tables 1.3 and 1.3a. Getters, catalysts, or other recombination devices are not employed in any of the containment vessel packaging arrangements. The analysis conducted in Appendix 3.5.1 predicts the maximum normal operating pressure inside the containment vessel for the various packaging arrangements and masses discussed previously. This appendix also includes the hydrogen gas generation predicted by Appendix 3.5.4.

The uranyl nitrate crystals (UNX) in any hydrated state are very efflorescent and will lose water molecules at the temperature shown in Table 3.3 [89.60°C (193.28°F)]. As shown in Table 3.6, the containment vessel pressure is calculated to be 208.75 kPa (30.276 psia) with the contribution from UNX crystal efflorescence. This calculation is shown in greater detail in Appendix 3.5.1.

3.1.4.2 Maximum HAC pressures

Table 3.7 summarizes the results from Appendix 3.5.2 in which the pressure of the containment vessel when subjected to the tests and conditions of HAC per 10 CFR 71.73 has been determined for the most restrictive CVAs shipped in the ES-3100. The shipping configurations discussed in Sect. 3.1.4.1 are evaluated for HAC. To determine the maximum pressure generated inside the ES-3100's containment vessel due to HAC conditions, the following assumptions have been used in the calculations:

1. the initial pressure inside the containment vessel is the maximum normal operating pressure shown in Table 3.6 for each CVA at standard temperature [25°C (77°F)];

2. the convenience cans and bottles are assumed to not be sealed in order to maximize the void volume inside the containment vessel;

3. convenience can and bottle geometry does not change during pressure increase inside containment vessel or because of damage from compliance testing;

4. if metal convenience cans are used, the total amount of polyethylene, nylon, or Teflon bagging and lifting slings is limited to 500 g per containment vessel shipping arrangement;

5. the mass of offgassing material (polyethylene, nylon, or Teflon bagging, Teflon bottles, silicone pads, lifting slings) is assumed to be 1490 g for the offgassing evaluation of CVA 7;

6. CVAs that utilize closed convenience cans with a diameter greater than 10.8 cm (4.25 in.) will have a minimum void volume of ≥55 $in.^3$ for gas evolution and expansion;

7. hydrogen and oxygen molar quantities calculated in Appendix 3.5.1 are conservatively added to the gas mixture for HAC; and

8. the contribution in pressure generated by the efflorescence of UNX crystals is incorporated into the results for CVA 7.

Table 3.7. Total pressure inside the containment vessel at 167.39°C (333.31°F) [a] with efflorescence

CVA	n_{MNOP} [b] (lb-mol)	n_{po} [b] (lb-mol)	n_{bo} [b] (lb-mol)	n_{tf} [b] (lb-mol)	n_{r-H2} [b] (lb-mol)	n_{r-O2} [b] (lb-mol)	n_{CE-WV} [b,c] (lb-mol)	n_T [b] (lb-mol)	P_T (psia)
1	8.7016E-04	1.6486E-05	4.0537E-04	0.0000E+00	3.5761E-05	1.7881E-05	0.0000E+00	1.3457E-03	44.168
7	9.3193E-04	0.0000E+00	4.0537E-04	2.2296E-05	2.4457E-05	1.2229E-05	2.2490E-03	3.6453E-03	174.950
11	8.3054E-05	1.6487E-05	4.0537E-04	0.0000E+00	3.4133E-06	1.7067E-06	0.0000E+00	5.1003E-04	174.949

[a] This assumes that the internal convenience cans, polyethylene or Teflon FEP bottles, and Cat 277-4 spacer cans are not sealed.
[b] n_{MNOP}—molar quantity of the gas mixture at maximum normal operating pressure at standard temperature [25°C (77°F)];
n_{po}—molar quantity of gas due to offgassing of the silicone rubber pads;
n_{bo}—molar quantity of gas due to offgassing of the polyethylene, nylon, or Teflon bags, polyethylene bottles, and lifting sling;
n_{tf}—molar quantity of gas due to offgassing of the Teflon bottles;
n_{r-H2}—molar quantity of hydrogen gas due to radiolysis of water;
n_{r-O2}—molar quantity of oxygen gas due to radiolysis of water;
n_{CE-WV}—molar quantity of water vapor due to efflorescence of UNX crystals; and
n_T—total molar quantity in the gas mixture.
[c] Efflorescence of UNX crystals as water vapor.

The offgassing material limits identified in assumptions 4 and 5 have been established based on the needs of shippers. All configurations are limited to 500 g of polyethylene, nylon, or Teflon in the form of bags, slings, and/or polyethylene bottles. When the requirement to ship material in Teflon bottles arose, the upper limit of 1490 g of offgassing material was established. This limit is a combination of three Teflon bottles (330 g per bottle) and the original 500 g allowance for polyethylene, nylon, or Teflon bagging material. These offgassing material limits have been used in calculations pertaining to containment vessel pressure, radioactive material leakage criteria, and criticality control. Therefore, portions of the safety basis for this shipping package have been based on these material limits.

3.2 MATERIAL PROPERTIES AND COMPONENT SPECIFICATIONS

3.2.1 Material Properties

Thermal properties at various temperatures for the stainless steel used in the fabrication of the drum, noncombustible cast refractory (Kaolite 1600) and Packcrete, noncombustible neutron poison [BoroBond 4 (initial design) or Cat 277-4 (final design)], silicone rubber pads, and air are listed in Table 3.8. Properties used to evaluate thermal stresses due to differences in coefficient of thermal expansion are listed in Table 3.9.

3.2.2 Component Specifications

Component specifications are listed in Tables 3.10 and 3.11.

Table 3.8. Thermal properties of the materials used in the thermal analysis

Material	Temperature (°F)	Thermal conductivity (Btu/h-in.-°F)	Density ($lb_m/in.^3$)	Specific heat (Btu/lb_m-°F)	Emissivity
Stainless steel	−279.67	0.443 [a]	0.285 [a]	0.065 [a]	0.22 [a]
	−99.67	0.607	–	0.096	–
	260.33	0.799	–	0.123	–
	620.33	0.953	–	0.133	–
	980.33	1.088	–	0.139	–
	1340.33	1.223	–	0.146	–
	1700.33	1.348	–	0.153	–
	2240.33	1.526	–	0.163	–
Kaolite 1600	68	0.0093 [b]	0.011 [c]	0.2 [d]	–
	212	0.0091	–	–	–
	392	0.0081	–	–	–
	572	0.0072	–	–	–
	1112	0.0082	–	–	–
Packcrete [e]	68	0.0042–0.0074	0.01123–0.0147	–	–
	95	–	–	0.0948–0.4203	–
	212	0.0044–0.0076	–	–	–
	221	–	–	0.1294–0.5060	–
	392	0.0048–0.0080	–	–	–
	572	0.0052–0.0084	–	–	–
	581	–	–	0.0841–0.5125	–
	1103	–	–	0.0556–0.3145	–
	1112	0.0064–0.0070	–	–	–
Neutron poison (Cat 277-4)	−31	0.0457 [f]	0.0579 [g]	0.125 [f]	–
	73.4	0.0485	–	0.186	–
	140	0.04	–	0.239	–
	212	0.0295	–	0.242	–
	302	0.0305	–	0.291	–
Neutron poison (BoroBond4)	25	0.0450 [h]	0.0683 [h]	0.2160 [h]	–
	77	0.0576	–	–	–
	100	0.0632	–	–	–
	104	0.0642	–	–	–
Silicone rubber	–	0.0161 [i]	0.047 [i]	0.300 [i]	1.0 [j]

Table 3.8. Thermal properties of the materials used in the thermal analysis

Material	Temperature (°F)	Thermal conductivity (Btu/h-in.-°F)	Density ($lb_m/in.^3$)	Specific heat (Btu/lb_m-°F)	Emissivity
Air	−9.67	1.074×10^{-3} [a]	4.064×10^{-5} [a, k]	0.240 [a]	–
	80.33	1.266×10^{-3}	–	0.241	–
	170.33	1.445×10^{-3}	–	0.241	–
	260.33	1.628×10^{-3}	–	0.242	–
	350.33	1.796×10^{-3}	–	0.244	–
	440.33	1.960×10^{-3}	–	0.246	–
	530.33	2.114×10^{-3}	–	0.248	–
	620.33	2.258×10^{-3}	–	0.251	–
	710.33	2.393×10^{-3}	–	0.254	–
	800.33	2.523×10^{-3}	–	0.257	–
	890.33	2.644×10^{-3}	–	0.260	–
	980.33	2.759×10^{-3}	–	0.263	–
	1070.33	2.870×10^{-3}	–	0.265	–
	1160.33	2.985×10^{-3}	–	0.268	–
	1250.33	3.096×10^{-3}	–	0.270	–
	1340.33	3.212×10^{-3}	–	0.273	–
	1520.33	3.443×10^{-3}	–	0.277	–

[a] Incropera and DeWitt.
[b] ORNL/TM-2003/49.
[c] Based on a baked density of 19.4 lbm/ft^3 (0.011 lbm/$in.^3$). Specification JS-YMN3-801580-A003 (Appendix 1.3.4) requires a baked density of 22.4 ± 3 lbm/ft^3. Using a lower value for the Kaolite density results in higher temperatures on the containment vessel because the heat capacity of the Kaolite is minimized—allowing more heat to flow to the containment vessel; therefore, the thermal analyses are performed using a low-end density of 19.4 lbm/ft^3. The HAC analyses also consider a high-end density of 30 lbm/ft^3.
[d] Breuer, fax communication to J. C. Anderson.
[e] RP 802282-0002 and DAC M801940-0002 for complete set of thermal properties for Packcrete as a function of temperature.
[f] ORNL/TM-2004/290. Specific heat values are presented in MJ/m^3-K and converted to mass-based units using a density of 105 lbm/ft^3.
[g] Based on a cured density of 100 lbm/ft^3 (0.0579 lbm/$in.^3$). Y/DW-1987, presents a range of measured densities between ~100 and 110 lbm/ft^3 for Cat 277-4. Therefore, in order to minimize the heat capacity of the material and allow more heat to be transferred to the containment vessel, the lower-end value is used. The HAC analyses also consider a high-end density of 110 lbm/ft^3.
[h] Hall, e-mail communication with presentation attachment to G. A. Byington.
[i] Therm 1.2.
[j] Conservatively modeled as 1.0.
[k] Constant density evaluated at 100°F.

Table 3.9. Mechanical properties of the materials used in the static stress analyses

Material	Temperature (°F)	Modulus of elasticity (psi)	Poisson's ratio	Density ($lb_m/in.^3$)	Coefficient of thermal expansion (in./in./°F)
Stainless steel	−40	28.6E+06 [a]	0.29 [b]	0.285 [d]	8.2E-06 [e]
	100	28.14E+06	—	—	8.6E-06
	200	27.6E+06	—	—	8.9E-06
	300	27.0E+06	—	—	9.2E-06
Kaolite	—	29,210 [c]	0.01 [c]	0.013 [f]	5.04E-06 [g]
Packcrete [h] (LTC, LSH, HD) [i]	−40	4,100/33,220	0.01	0.0147	2.31E-06/4.58E-06
	−22	—	—	—	2.42E-06/4.65E-06
	−4	—	—	—	2.53E-06/4.73E-06
	14	—	—	—	2.63E-06/4.81E-06
	32	—	—	—	2.73E-06/4.88E-06
	50	—	—	—	2.82E-06/4.95E-06
	68	—	—	—	2.89E-06/5.02E-06
	86	—	—	—	2.95E-06/5.07E-06
	104	—	—	—	2.97E-06/5.11E-06
	122	—	—	—	2.96E-06/5.14E-06
	140	—	—	—	2.91E-06/5.15E-06
	158	—	—	—	2.80E-06/5.15E-06
	176	—	—	—	2.68E-06/5.14E-06
	194	—	—	—	2.51E-06/5.12E-06
	212	—	—	—	2.29E-06/5.08E-06
	230	—	—	—	2.06E-06/5.03E-06
	248	—	—	—	1.84E-06/4.98E-06
	266	—	—	—	1.64E-06/4.91E-06
	284	—	—	—	1.46E-06/4.85E-06
	302	—	—	—	1.31E-06/4.79E-06
Neutron absorber (Cat 277-4)	−40	1.991E+06 [j]	0.33 [j]	0.0608 [j]	7.056E-06 [k]
	−4	—	—	—	7.222E-06
	32	—	—	—	7.222E-06
	70	0.984E+06	0.28	—	—
	100	0.403E+06	0.25	—	—
	104	—	—	—	7.000E-06
	140	—	—	—	6.444E-06
	176	—	—	—	5.778E-06
	212	—	—	—	5.389E-06
	248	—	—	—	5.056E-06
	284	—	—	—	4.889E-06
	302	—	—	—	4.833E-06

[a] *ASME Boiler and Pressure Vessel Code*, Sect. II, Part D, Subpart 2, Tables TE-1, B column, and TM-1.
[b] STRAIN 2.0.
[c] DAC-EA-801699-A001. (The Poisson's ratio of Kaolite is assumed to be a small value of 0.01.)
[d] Incropera and DeWitt.
[e] MIL-HDBK-5H.
[f] Specification JS-YMN3-801580-A003 (Appendix 1.3.4) requires a baked density of 22.4 ± 3 lbm/ft^3.
[g] E-mail communication, Ken Moody (Thermal Ceramics, Inc.) to Paul Bales (BWXT Y-12), December 9, 2004.
[h] RP 802282-0002 000 02, *Packcrete Material Properties.*
[i] Low thermal conductivity (LTC), low specific heat (LSH), high density (HD) Packcrete variation determined from thermal analysis performed in DAC M801940-0002. These properties resulted in the highest NCT temperatures.
[j] Y/DW-1987.
[k] ORNL/TM-2004/290. Coefficient of thermal expansion at each temperature taken as the maximum of values for Runs 2, 3, and 5.

Table 3.10. ES-3100 packaging material specifications

Component	Specifications
	Drum assembly
Drum washers	1.375 OD × 0.812 ID × 0.25 in. thick, 300 Series stainless steel
Drum threaded weld studs	5/8-11 × 7/8-in. long, ARC FT, Type 304 or 304L stainless-steel studs
Drum hex nuts	5/8-11 UNC-2B, silicon bronze C65100
Drum lid weldment	Modified 30-gal, 16-gauge (MS27683) lid, Type 304 or 304L stainless steel; and an 11-gauge-thick sheet, Type 304 or 304L stainless steel, ASME SA-240
Drum weldment	Modified 30-gal, 16-gauge (MS27683), Type 304 or 304L stainless steel, ASME SA-240, manufactured per Drawing M2E801580A004 (Appendix 1.3.7)
Drum plugs	Nylon plastic plug, Micro Plastic, Inc.
	Impact limiter, insulation enclosure, neutron absorber, and drum packing material
Insulation and impact limiter (not removable)	Lightweight cast refractory insulation, Kaolite 1600 or Packcrete, 358.8 ± 48.1 kg/m^3 (22.4 ± 3 lb/ft^3) density, cast in stainless-steel shells in the drum and top plug
Neutron absorber	Cat 277-4, 1681.9 + 240.3/−80.1 kg/m^3 (105 + 15/−5 lb/ft^3) density
Top plug (removable)	Type 304 or 304L stainless steel, ASME SA-240 (body), ASME SA-479 (lifting inserts)
Inner liners	Type 304 or 304L stainless steel, ASME SA-240 (body), ASME SA-479 (modified angle)
Silicone pads	Silicone rubber, 22 ±5 Shore A, color black/gray
Aluminum foil duct tape	McMaster Carr Part # 7616A21, temperature range −40 to 121°C (−40 to 250°F)
	Containment vessel
Containment vessel plug	Part # 04-2126, Modified VCO threaded plug with O-ring, brass
Containment vessel hoist ring	3052T56, Swivel hoist ring, alloy steel (not used for shipment)
Containment vessel	Method 1: Type TP304L stainless steel ASME SA-312 (seamless pipe body); Type F304L, stainless steel, ASME SA-182 (flange and end cap); Type 304, stainless steel, ASME SA-479 (sealing lid), Nitronic 60 stainless steel per ASME SA-479, UNS-S21800 (closure nut) Method 2: Type F304L stainless-steel ASME SA-182 (body, flange, and end cap); Type 304, stainless steel, ASME SA-479 (sealing lid), Nitronic 60 stainless steel per ASME SA-479, UNS-S21800 (closure nut) All components per *ASME Boiler and Pressure Vessel Code*, Sect. II, Part D, Table 2A
Containment vessel O-rings	Elastomer, ethylene propylene diene monomer, Specification M3BA712A14B13F17 in ASTM D 2000 per SPC M801580-0002 (Appendix 1.3.9)
Containment vessel lid assembly retaining ring	Smalley Steel Ring Co., Part #WSM-400-S02, Type 302 stainless steel
Containment vessel O-ring lubricant	Clear dimethyl siloxane polymer
Containment vessel closure nut lubricant	Krytox #240AC
Containment vessel body dowel pins	0.2501/0.2503-in. OD × 0.50-in. long, 18-8 stainless steel

Table 3.10. ES-3100 packaging material specifications

Component	Specifications
Containment vessel packing material	
Convenience cans	Stainless steel, aluminum, or tinned carbon steel with stainless-steel can handles and nylon-coated stainless-steel wire; nickel-alloy (200 series, passivated) in nylon mesh bag
Convenience bottles	Polyethylene, glass, or Teflon FEP
Silicone rubber pads	Silicone rubber, 22 ±5 Shore A, color black/gray
Can spacers	Stainless-steel can filled with Cat 277-4
Bagging	Polyethylene, nylon, or Teflon
Metal scouring scrubbers	Stainless steel, McMaster Carr Part #7361T13

Table 3.11. Component allowable service temperature and pressure

Component	Allowable service temperature range [°C (°F)]	Allowable pressure range [kPa (psia)]
Drum assembly		
Stainless-steel drum and lid	−40 to 871 (−40 to 1600) [a]	48.3 (7)
Silicon bronze nuts	−40 to 871 (−40 to 1600) [a]	N/A
Stainless-steel washers	−40 to 871 (−40 to 1600) [a]	N/A
Stainless-steel mid liner	−40 to 871 (−40 to 1600) [a]	N/A
Stainless-steel inner liner	−40 to 871 (−40 to 1600) [b]	N/A
Stainless-steel top plug weldment	−40 to 871 (−40 to 1600) [a]	N/A
Kaolite 1600	−40 to 871 (−40 to 1600) [a]	N/A
Packcrete	−40 to 871 (−40 to 1600) [a]	N/A
Cat 277-4	−40 to 150 (−40 to 302) [c]	N/A
Silicone rubber pads	−40 to 232 (−40 to 450)	N/A
Containment vessel		
Stainless-steel body and sealing lid	−40 to 427 (−40 to 800) [d]	149.62 (21.7) external 699.82 (101.5) internal
Nitronic 60 closure nut	−40 to 427 (−40 to 800) [d]	149.62 (21.7) external 699.82 (101.5) internal
Stainless-steel retaining ring	−40 to 427 (−40 to 800) [d]	N/A
Dowel pins	−40 to 427 (−40 to 800) [d]	N/A
Brass VCO plug (with O-ring)	−40 to 204 (−40 to 400) [e]	
Ethylene propylene diene monomer O-rings	−40 to 150 (−40 to 302) [e]	5.52×10^3 (800) with no backing rings [e]
Containment vessel silicone pads	−40 to 232 (−40 to 450)	N/A

[a] This limit is established by the proximity of the Kaolite 1600 or Packcrete material.
[b] This limit is established based on the fact that the inner liner material is identical to the drum material.
[c] This limit is established based on criticality limits of moisture loss.
[d] This limit is established by the *ASME Boiler and Pressure Vessel Code*.
[e] This limit is provided by the *Parker O-Ring Handbook* for each material's continuous service limit.

3.3 THERMAL EVALUATION UNDER NORMAL CONDITIONS OF TRANSPORT

Thermal evaluation of the package design for NCT was performed by analysis and documented in DAC-PKG-801699-A001, DAC-PKG-801940-A001, and DAC M801940-0002.

DAC-PKG-801699-A001 uses a two-dimensional axisymmetric finite element model of the ES-3100 shipping container constructed using MSC.Patran and imported as an orphaned mesh into ABAQUS/CAE for application of boundary conditions, interactions, and loads. MSC.Patran and ABAQUS/CAE have been benchmarked against physical test data for a Y-12 packaging application and shown to provide accurate results (DAC-PKG-801805-A003). The model was constructed of DCAX4 (four-node linear axisymmetric heat transfer quadrilateral) and DCAX3 (3-node linear axisymmetric heat transfer triangular) elements for evaluation for NCT and HAC. The actual contents of the ES-3100 shipping container were not specifically modeled—instead, the content source heat load (if desired) was modeled by applying a uniform heat flux to the inner surfaces of the containment vessel. This was a conservative approach in that package temperatures will not be reduced in a transient analysis by the heat capacity of the contents. Thermal properties of the materials used in the analysis are presented in Table 3.8. Prior to the change of neutron absorber from BoroBond4 to Cat 277-4, parameters, such as Kaolite 1600 density, BoroBond4 thermal conductivity, and decay heat loads, were varied to encompass the range of potential variations in material properties. The available thermal conductivity information on BoroBond4 was limited to moderate temperatures in the range of −3.89°C (25°F) to 40°C (104°F) [Hall 2004]. Using the available thermal conductivity data for BoroBond4, thermal analyses for NCT and HAC were performed and are documented in DAC-PKG-801699-A001. Nodal locations for temperatures presented are shown in Fig. 3.1.

Based on the results reported in DAC-PKG-801699-A001 and shown in Tables 3.12 and 3.13, it was determined that the higher temperatures occurred when the lowest density of the Kaolite 1600 was used. Therefore, a subsequent analysis using the proposed Cat 277-4 neutron absorber at 100 lb/ft^3 during NCT with a Kaolite 1600 density of 19.4 lb/ft^3 was conducted and documented in DAC-PKG-801940-A001. A two-dimensional axisymmetric finite element model of the ES-3100 shipping container was constructed using ANSYS software for application of boundary conditions, interactions, and loads. A schematic of the finite element model is presented in Fig. 3.2 with details of the upper and lower portions of the model shown in Figs. 3.3 and 3.4, respectively. The model consists of five materials: stainless steel (drum, liners, and containment vessel), Kaolite 1600, 277-4 neutron absorber, silicone rubber, and air in the gaps between the drum liner and containment vessel and between the drum liner and top plug. Degree-of-freedom “ties” are made at the interfaces of the different material regions in order to allow the heat to flow through the model. The actual contents of the ES-3100 shipping container are not specifically modeled—instead, the content source heat load (if desired) is modeled by applying a uniform heat flux to the inner surfaces of the containment vessel. This is a conservative approach in that package temperatures will not be reduced in a transient analysis by the heat capacity of the contents. Comparing results of similarly located nodes, the results from DAC-PKG-801940-A001 are slightly lower than the results for a given decay heat than those shown in Table 3.12. Therefore, the use of the Cat 277-4 properties will not have a negative impact on subsequent analysis.

Due to the lack of Kaolite 1600 material from the manufacturer that meets specified density requirements, a substitute inorganic castable refractory material, identified as Packcrete, was developed. To confirm the thermal-insulating and impact-limiting material equivalency of Packcrete to the previously used Kaolite 1600 material, numerous material properties were evaluated and the results are documented in RP 802282-0002. These Packcrete properties and the properties of 277-4 and low density Kaolite 1600 were then used in DAC M80194-0002 to determine the temperature profiles of the ES-3100 shipping package for NCT. A geometric model of the ES-3100 package is created using PTC Creo Parametric and imported into ANSYS Mechanical, where a two-dimensional (2-D) axisymmetric FEA model is constructed for application of boundary conditions, interactions, and loads. The ES-3100 convenience cans and content are not modeled in the DAC. Instead, a heat flux ranging from 0 to 5 W is applied

to the CV inner surfaces. Details of the upper and lower portions of the model are shown in Figs. 3.5 and 3.6, respectively. Nodal locations for temperatures presented are shown in Fig. 3.7.

3.3.1 Heat and Cold

The ambient temperature requirement for NCT is 38°C (100°F). The general standard of 10 CFR 71.43(g) states: "A package must be designed, constructed, and prepared for transport so that in still air at 38°C (100°F) and in the shade, no accessible surface of a package would have a temperature exceeding 50°C (122°F) in a nonexclusive use shipment, or 85°C (185°F) in an exclusive use shipment." Since the components to be shipped have an assumed decay heat load of 5 W, a thermal analysis was conducted for the ES-3100 package without full solar insolation. Results for steady-state condition at 38°C in the shade are shown in Table 3.14. The maximum predicted temperature, while stored at 38°C (100°F) in the shade, for the external drum assembly and the containment vessel is 39.42°C (102.96°F) and 47.79°C (118.02°F), respectively. The analysis shows that no accessible surface of the package would have a temperature exceeding 50°C (122°F). Therefore, the requirement of 10 CFR 71.43(g) would be satisfied for either transportation mode (exclusive use or nonexclusive use).

For materials to be shipped by air transport, the International Atomic Energy Agency (IAEA) SSR-6, para. 621, states: "Packages containing radioactive material, to be transported by air, shall be capable of withstanding, without loss or dispersal of radioactive contents from the containment system, an internal pressure that produces a pressure differential of not less than the maximum normal operating pressure plus 95 kPa." Therefore to comply with these IAEA SSR-6 requirements, a thermal analysis was conducted for the ES-3100 package at 55°C in the shade. Results for this steady-state condition at 55°C in the shade are shown in Table 3.15. These values for temperature and pressure are subsequently used in Chapter 4 to determine the leakage criteria that satisfies the requirements of ANSI N14.5.

If the package is exposed to solar radiation at 38°C (100°F) in still air with an internal decay heat load of 5W, the conservatively calculated temperatures at the top of the drum, on the top surface of the containment vessel, and on the containment vessel near the O-ring sealing surfaces, are 119.38°C (246.88°F), 89.60°C (193.28°F), and 89.53°C (193.15°F), respectively, for the ES-3100 (Table 3.16). These temperatures are within the service limits of all packaging components, including the O-rings. The normal service temperature range of the O-rings used in the containment boundary is −40 to 150°C (−40 to 302°F) for the ethylene propylene diene monomer (EPDM) O-rings [Table 3.11] in accordance with *Parker O-Ring Handbook.* Thus, the seal will not be affected by this maximum normal operating temperature. The acronyms for various material properties shown in Tables 3.14 through 3.16 are identified as follows:

ASH – average specific heat for Packcrete;
LSH – low specific heat for Packcrete;
HSH – high specific heat for Packcrete;
LTC – low thermal conductivity for Packcrete;
HTC – high thermal conductivity for Packcrete;
LD – low density for Packcrete;
HD – high density for Packcrete;
277LD – 277-4 material low density;
277HD – 277-4 material high density; and
Kaolite LD – Kaolite low material density.

These material properties are further discussed and identified in DAC M80194-0002.

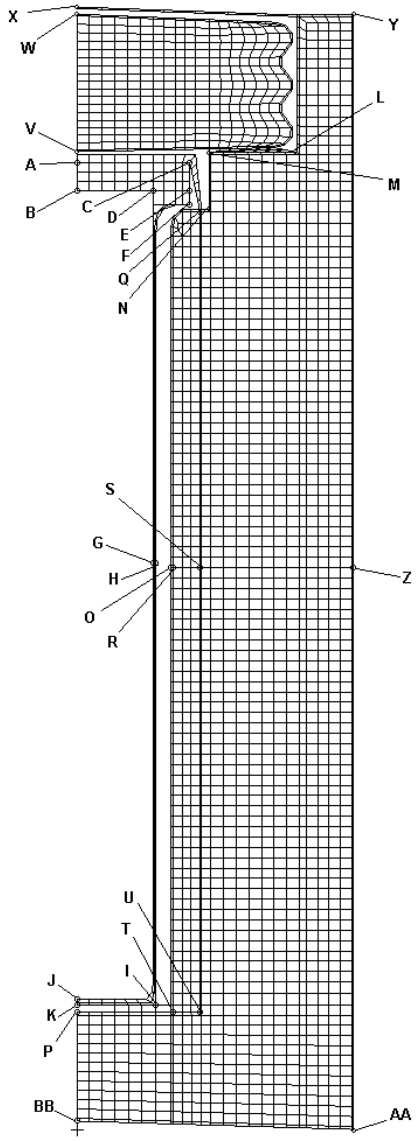


Fig. 3.1. MSC.Patran axisymmetric finite element model of the ES-3100 shipping container with BoroBond 4—nodal locations of interest (elements representing air not shown for clarity).

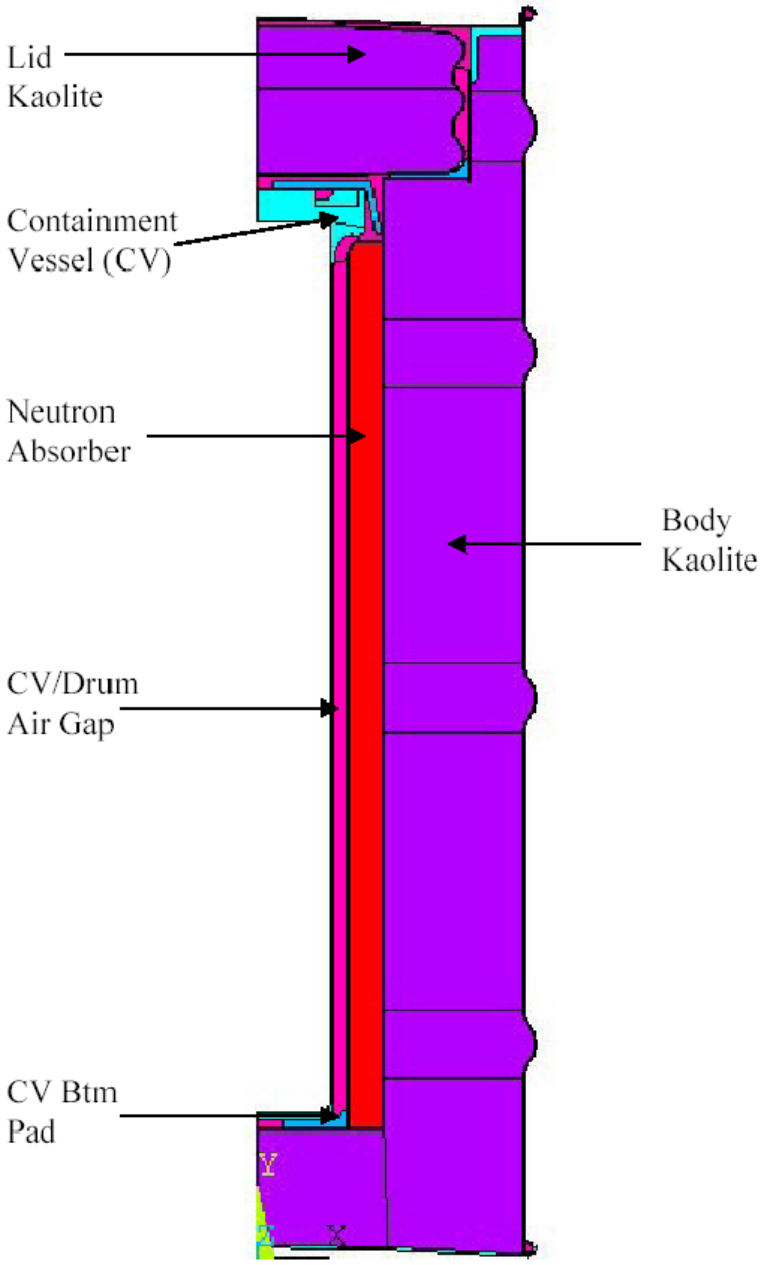


Fig. 3.2. ANSYS axisymmetric finite element model of the ES-3100 shipping container with Cat 277-4.

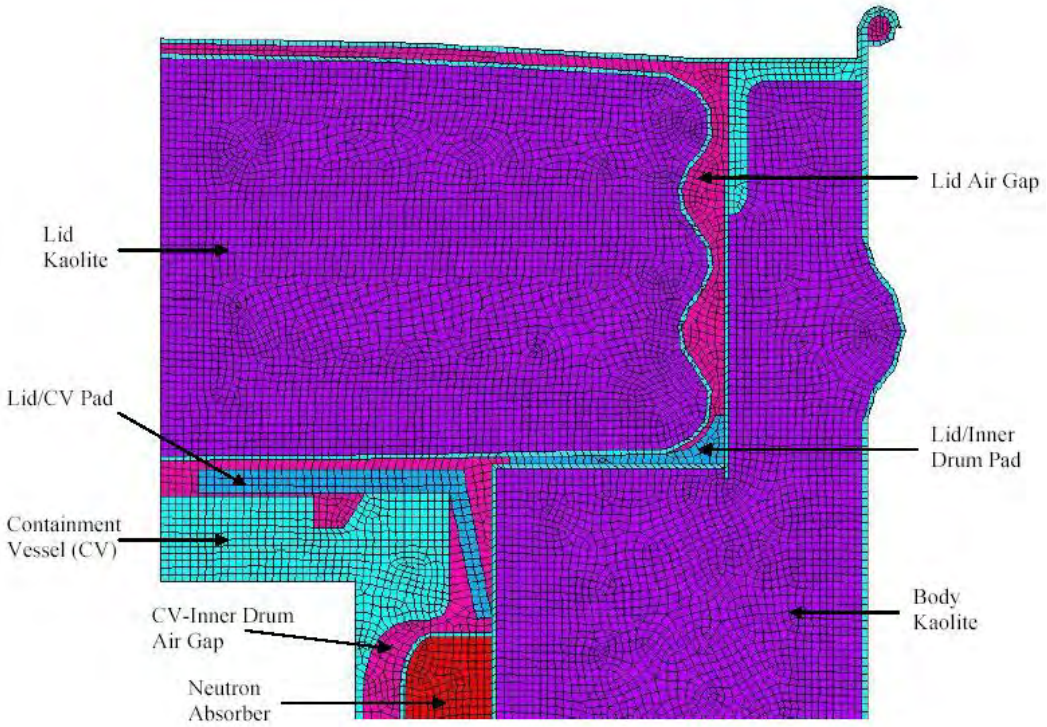


Fig. 3.3. ANSYS axisymmetric finite element model of the ES-3100 shipping container with Cat 277-4 (upper portion detail).

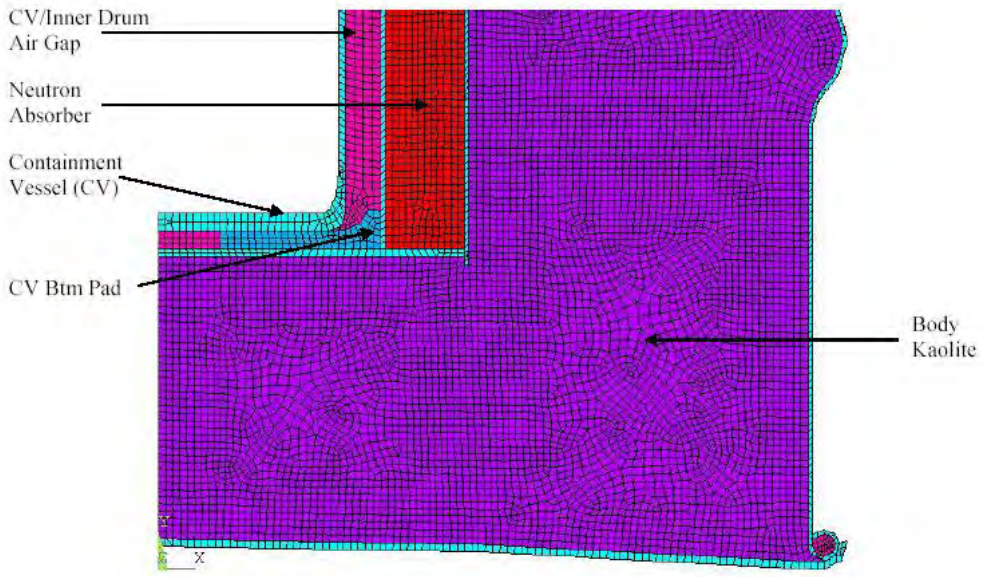


Fig. 3.4. ANSYS axisymmetric finite element model of the ES-3100 shipping container with Cat 277-4 (lower portion detail).

Table 3.12. Maximum "quasi steady-state" temperatures during NCT for the ES-3100 shipping container with various content heat loads—Kaolite density of 19.4 lb/ft^3 and BoroBond4

Node [a]	Location	Maximum "quasi steady-state" temperature, °C (°F) [c]			
		0 W	0.4 W	20 W	30 W
A	CV [d] lid, top, center	88.30 (190.95)	88.62 (191.52)	103.84 (218.91)	111.35 (232.42)
B	CV lid, bottom, center	88.28 (190.90)	88.60 (191.48)	103.90 (219.03)	111.45 (232.62)
C	CV lid, top, outer	88.32 (190.97)	88.63 (191.54)	103.61 (218.50)	111.00 (231.80)
D	CV flange at interface, inner [b]	88.24 (190.83)	88.56 (191.41)	103.87 (218.96)	111.42 (232.55)
E	CV flange at interface, outer [b]	88.25 (190.84)	88.56 (191.41)	103.77 (218.78)	111.27 (232.28)
F	CV flange, bottom, outer	88.24 (190.82)	88.55 (191.39)	103.75 (218.75)	111.25 (232.24)
G	CV shell, mid-height, inner	83.04 (181.47)	83.61 (182.50)	110.50 (230.89)	123.46 (254.23)
H	CV shell, mid-height, outer	83.04 (181.47)	83.61 (182.50)	110.49 (230.88)	123.45 (254.21)
I	CV bottom, outer	83.36 (182.04)	83.75 (182.74)	102.58 (216.64)	111.99 (233.59)
J	CV bottom, center, inner	88.37 (182.07)	83.76 (182.77)	102.70 (216.86)	112.17 (233.91)
K	CV bottom, center, outer	88.37 (181.07)	83.76 (182.77)	102.69 (216.84)	112.15 (233.87)
L	Drum liner, plug cavity, outer	98.72 (209.70)	98.80 (209.85)	102.63 (216.73)	104.58 (220.24)
M	Drum liner, plug cavity, inner	94.43 (201.97)	94.58 (202.24)	101.92 (215.46)	105.65 (222.16)
N	Drum liner, CV flange cavity, outer	89.43 (192.97)	89.63 (193.34)	99.83 (211.70)	105.01 (221.02)
O	Drum liner, CV cavity, mid-height, inner	83.12 (181.62)	83.43 (182.18)	98.63 (209.54)	106.40 (223.52)
P	Drum liner, CV cavity, bottom, inner	83.62 (182.52)	83.96 (183.13)	100.36 (212.65)	108.60 (227.48)
Q	Borobond4, top, outer	88.82 (191.88)	89.04 (192.27)	99.65 (211.38)	105.04 (221.07)
R	Borobond4, mid-height, inner	83.12 (181.62)	83.43 (182.18)	98.63 (209.53)	106.39 (223.51)
S	Borobond4, mid-height, outer	83.03 (181.46)	83.33 (182.00)	97.91 (208.23)	105.36 (221.65)
T	Borobond4, bottom, inner	83.55 (182.39)	83.85 (182.93)	98.58 (209.45)	106.03 (222.86)
U	Borobond4, bottom, outer	83.51 (182.31)	83.80 (182.83)	97.82 (208.07)	104.90 (238.82)
V	Drum plug liner, bottom, center	112.01 (233.62)	112.05 (233.69)	113.95 (237.11)	114.90 (238.82)
W	Drum plug liner, top, center	92.09 (197.77)	92.31 (198.16)	102.93 (217.27)	108.26 (226.87)
X	Drum lid, top, center	118.01 (244.42)	118.03 (244.45)	118.77 (245.79)	119.15 (246.47)
Y	Drum lid, top, outer	107.33 (225.19)	107.34 (225.22)	108.22 (226.80)	108.67 (227.60)
Z	Drum, mid-height, outer	92.27 (198.08)	92.30 (198.14)	93.81 (200.86)	94.58 (202.24)
AA	Drum bottom, outer	91.70 (197.06)	91.74 (197.13)	93.61 (200.49)	94.54 (202.18)
BB	Drum bottom, center	88.82 (191.88)	88.93 (192.07)	93.84 (200.91)	96.30 (205.35)

[a] See Fig. 3.1.
[b] Approximate location of the CV O-ring.
[c] Temperatures calculated in DAC-PKG-801699-A001.
[d] CV—containment vessel.

Table 3.13. Maximum "quasi steady-state" temperatures during NCT for the ES-3100 shipping container with various content heat loads—Kaolite density of 30 lb/ft^3 and BoroBond4

Node [a]	Location	Maximum "quasi steady-state" temperature, °C (°F) [c]			
		0 W	0.4 W	20 W	30 W
A	CV [d] lid, top, center	86.56 (187.81)	86.88 (188.38)	102.98 (215.74)	109.59 (229.26)
B	CV lid, bottom, center	86.56 (187.80)	86.88 (188.38)	102.16 (215.90)	109.71 (229.47)
C	CV lid, top, outer	86.54 (187.78)	86.86 (188.34)	101.89 (215.41)	109.31 (228.75)
D	CV flange at interface, inner [b]	86.47 (187.64)	86.79 (188.21)	102.09 (215.77)	109.67 (229.40)
E	CV flange at interface, outer [b]	86.44 (187.59)	86.76 (188.16)	102.00 (215.61)	109.53 (229.15)
F	CV flange, bottom, outer	86.42 (187.56)	86.74 (188.13)	101.99 (215.58)	109.51 (229.12)
G	CV shell, mid-height, inner	81.52 (178.74)	82.09 (179.76)	109.01 (228.21)	121.98 (251.57)
H	CV shell, mid-height, outer	81.52 (178.74)	82.09 (179.76)	109.00 (228.19)	121.97 (251.55)
I	CV bottom, outer	81.32 (178.37)	81.71 (179.08)	100.57 (213.02)	109.99 (229.99)
J	CV bottom, center, inner	81.37 (178.47)	81.77 (179.18)	100.73 (213.31)	110.21 (230.38)
K	CV bottom, center, outer	81.37 (178.47)	81.77 (179.18)	100.72 (213.29)	110.19 (230.34)
L	Drum liner, plug cavity, outer	97.74 (207.93)	97.82 (208.07)	101.65 (214.96)	103.59 (218.47)
M	Drum liner, plug cavity, inner	92.91 (199.23)	93.06 (199.50)	100.40 (212.72)	104.13 (219.43)
N	Drum liner, CV flange cavity, outer	87.69 (189.84)	87.90 (190.21)	98.09 (208.57)	103.27 (217.43)
O	Drum liner, CV cavity, mid-height, inner	81.30 (178.35)	81.61 (178.90)	96.82 (206.27)	104.13 (219.43)
P	Drum liner, CV cavity, bottom, inner	81.52 (178.74)	81.86 (179.35)	98.30 (208.94)	106.56 (223.80)
Q	Borobond4, top, outer	87.36 (189.25)	87.58 (189.64)	98.19 (208.74)	103.57 (218.43)
R	Borobond4, mid-height, inner	81.30 (178.35)	81.61 (178.90)	98.81 (206.26)	104.58 (220.24)
S	Borobond4, mid-height, outer	81.37 (178.46)	81.66 (178.99)	96.24 (205.23)	103.69 (218.64)
T	Borobond4, bottom, inner	81.67 (179.01)	81.98 (179.56)	96.73 (206.12)	104.19 (219.55)
U	Borobond4, bottom, outer	81.78 (179.21)	82.07 (179.72)	96.11 (205.00)	103.23 (217.81)
V	Drum plug liner, bottom, center	111.30 (232.35)	111.34 (232.42)	113.25 (235.85)	114.21 (237.57)
W	Drum plug liner, top, center	90.70 (195.26)	90.92 (195.66)	101.53 (214.76)	106.87 (224.36)
X	Drum lid, top, center	117.74 (243.93)	117.75 (243.96)	118.50 (245.30)	118.88 (245.98)
Y	Drum lid, top, outer	107.04 (224.68)	107.06 (224.71)	107.94 (226.29)	108.39 (227.10)
Z	Drum, mid-height, outer	91.86 (197.36)	91.90 (197.41)	93.42 (200.15)	94.18 (201.53)
AA	Drum bottom, outer	91.00 (195.79)	91.04 (195.86)	92.92 (199.26)	93.87 (200.96)
BB	Drum bottom, center	87.21 (188.97)	87.31 (189.15)	92.26 (198.07)	94.74 (202.54)

[a] See Fig. 3.1.
[b] Approximate location of the CV O-ring.
[c] Temperatures calculated in DAC-PKG-801699-A001.
[d] CV—containment vessel.

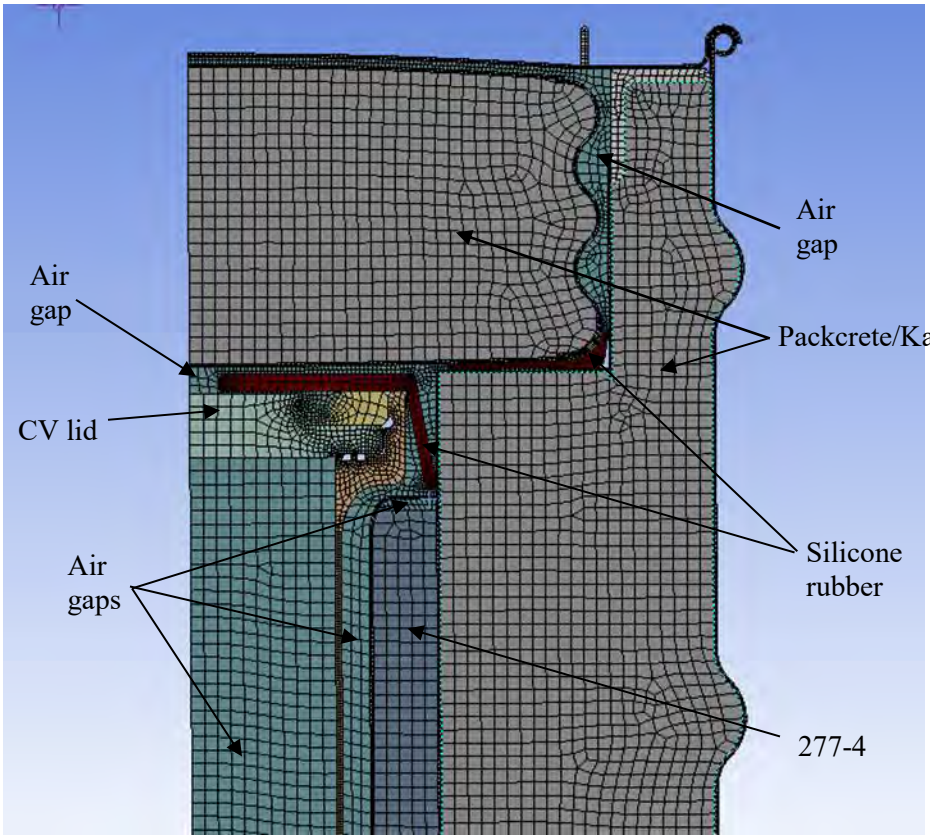


Fig. 3.5. ANSYS axisymmetric FEA model of the ES-3100 upper portion.

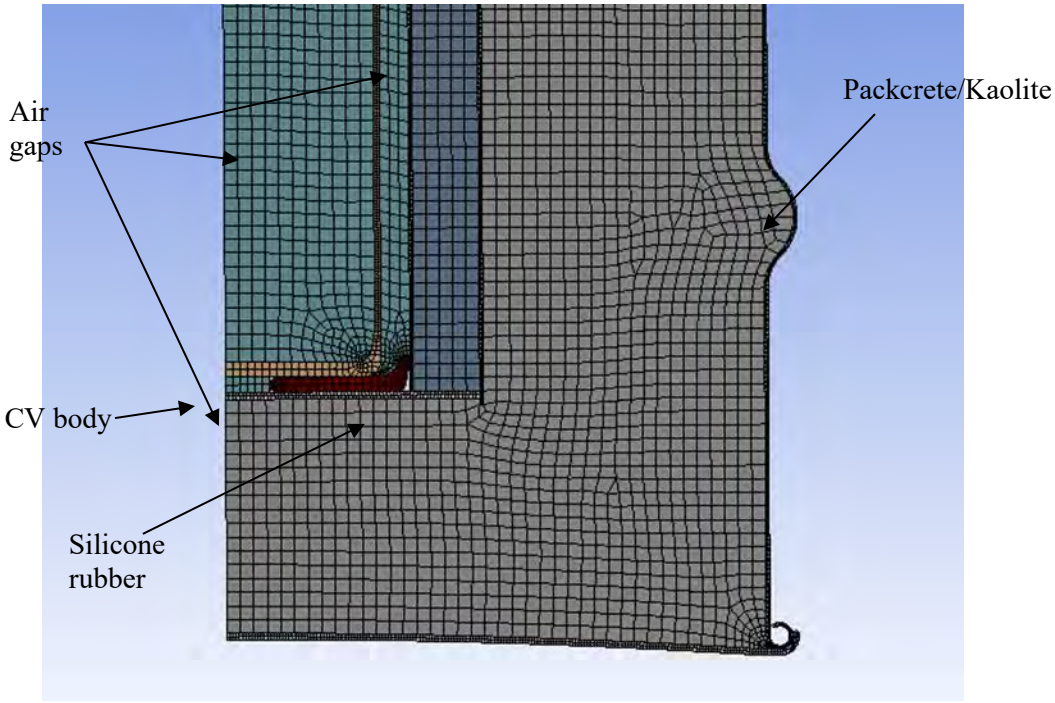


Fig. 3.6. ANSYS axisymmetric FEA model of the ES-3100 lower portion.

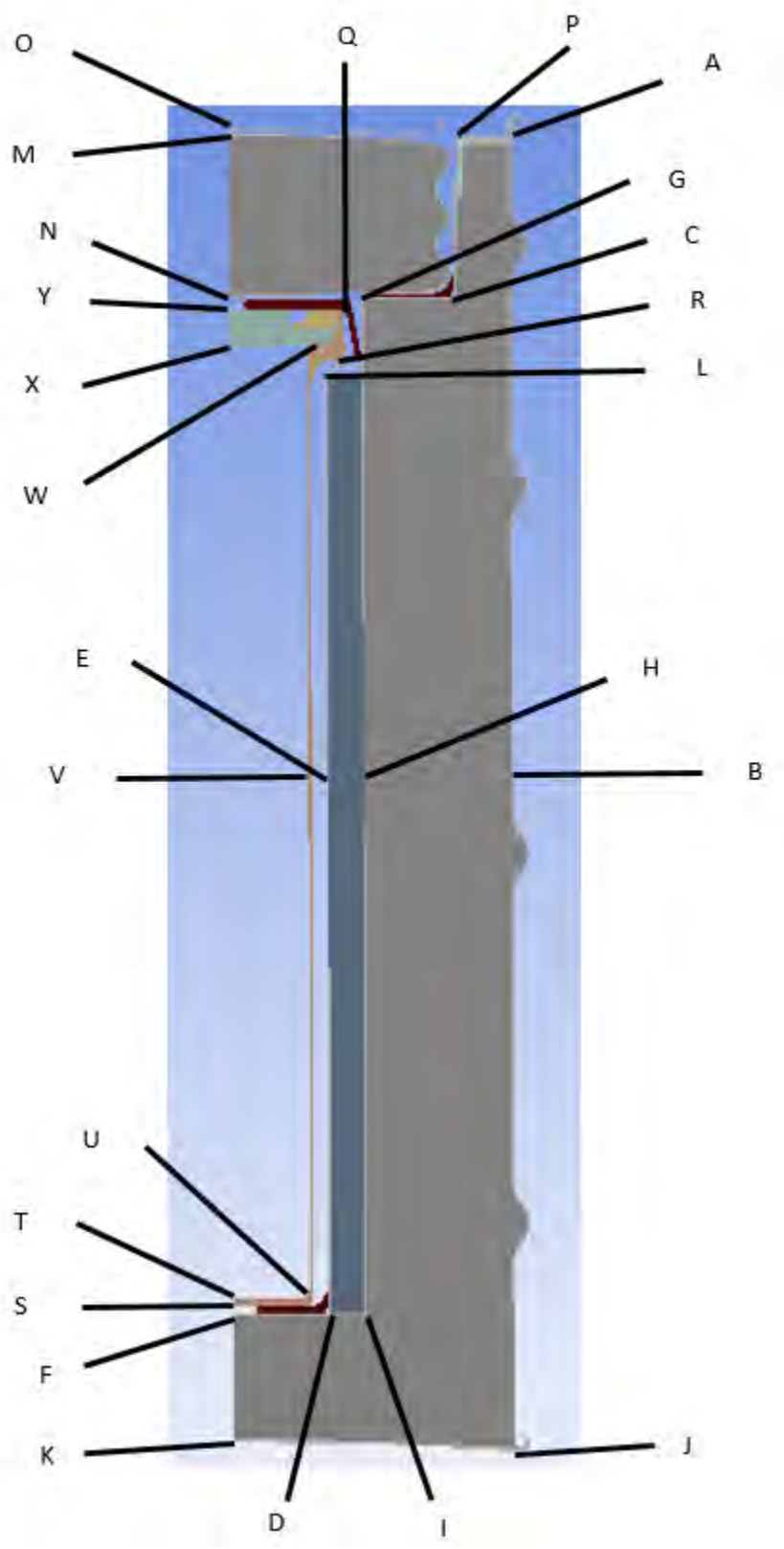


Fig. 3.7. ES-3100 nodal temperature locations of interest.

Table 3.14. Steady state temperatures (5 W and 38°C ambient conditions)

Node ID [a]	Location		ASH, HTC, HD, 277HD	ASH, HTC, HD, 277LD	ASH, LTC, LD, 277HD	ASH, LTC, LD, 277LD	HSH, LTC, LD, 277HD	HSH, LTC, LD, 277LD	LSH, HTC, HD, 277HD	LSH, HTC, HD, 277LD	Kaolite LD, 277LD
	x (cm)	y (cm)	Temperature (°C)								
A	23.33	108.39	37.99	37.99	38.05	38.04	38.05	38.05	37.99	37.99	37.98
B	23.33	54.61	38.30	38.30	38.26	38.25	38.26	38.26	38.30	38.30	38.31
C	18.76	94.96	38.95	38.95	39.43	39.38	39.40	39.41	38.95	38.95	38.84
D	7.92	11.16	42.19	42.19	44.53	44.47	44.51	44.51	42.19	42.19	41.55
E	7.92	54.62	42.11	42.11	44.21	44.15	44.20	44.20	42.11	42.11	41.54
F	0.00	11.16	42.66	42.66	45.01	44.95	44.99	44.99	42.66	42.66	42.03
G	11.00	94.91	39.88	39.88	40.76	40.67	40.71	40.72	39.88	39.88	39.68
H	11.07	54.61	41.85	41.85	43.96	43.90	43.94	43.95	41.85	41.85	41.27
I	11.00	11.15	41.91	41.91	44.26	44.21	44.24	44.24	41.91	41.91	41.28
J	23.77	-0.27	38.51	38.51	38.53	38.53	38.53	38.53	38.51	38.51	38.49
K	0.00	0.55	39.32	39.32	39.42	39.41	39.42	39.42	39.32	39.32	39.27
L	8.32	88.84	40.83	40.83	42.16	41.99	42.05	42.06	40.83	40.83	40.53
M	0.00	108.64	38.25	38.25	38.26	38.25	38.26	38.26	38.25	38.25	38.26
N	0.00	95.21	40.71	40.71	41.76	41.68	41.74	41.74	40.71	40.71	40.45
O	0.00	109.11	38.02	38.02	38.04	38.04	38.04	38.04	38.02	38.02	38.03
P	18.72	108.47	38.03	38.03	38.11	38.10	38.10	38.10	38.03	38.03	38.01
Q	9.53	93.97	42.27	42.27	43.45	43.34	43.41	43.41	42.27	42.27	42.01
R	9.44	90.25	42.32	42.32	43.52	43.40	43.47	43.47	42.32	42.32	42.07
S	0.00	11.83	43.89	43.89	46.19	46.13	46.18	46.17	43.89	43.89	43.27
T	0.00	12.47	43.89	43.89	46.20	46.13	46.18	46.18	43.89	43.89	43.28
U	6.10	12.61	43.89	43.89	46.19	46.13	46.17	46.17	43.89	43.89	43.27
V	6.43	54.63	45.82	45.82	47.79	47.73	47.78	47.78	45.82	45.82	45.30
W	6.75	91.08	42.37	42.37	43.56	43.45	43.51	43.52	42.37	42.37	42.11
X	0.00	91.21	42.36	42.36	43.55	43.44	43.51	43.51	42.36	42.36	42.11
Y	0.00	94.02	42.34	42.34	43.53	43.41	43.48	43.49	42.34	42.34	42.08

[a] See Fig. 3.7 for pictorial of node locations.

Table 3.15. Steady state temperatures (5 W and 55°C ambient conditions)

Node ID [a]	Location		ASH, HTC, HD, 277HD	ASH, HTC, HD, 277LD	ASH, LTC, LD, 277HD	ASH, LTC, LD, 277LD	HSH, LTC, LD, 277HD	HSH, LTC, LD, 277LD	LSH, HTC, HD, 277HD	LSH, HTC, HD, 277LD	Kaolite LD, 277LD
	x (cm)	y (cm)	Temperature (°C)								
A	23.33	108.39	55.17	55.17	55.21	55.21	55.22	55.21	55.17	55.17	55.16
B	23.33	54.61	55.45	55.45	55.40	55.40	55.41	55.40	55.45	55.45	55.46
C	18.76	94.96	56.05	56.05	56.39	56.38	56.45	56.37	56.05	56.05	55.95
D	7.92	11.16	59.25	59.25	61.32	61.32	61.45	61.35	59.25	59.25	58.67
E	7.92	54.62	59.20	59.20	61.05	61.04	61.16	61.03	59.20	59.20	58.67
F	0.00	11.16	59.70	59.70	61.75	61.74	61.89	61.78	59.70	59.70	59.11
G	11.00	94.91	56.92	56.92	57.55	57.54	57.65	57.51	56.92	56.92	56.74
H	11.07	54.61	58.92	58.92	60.78	60.78	60.89	60.77	58.92	58.92	58.38
I	11.00	11.15	58.98	58.98	61.06	61.06	61.19	61.09	58.98	58.98	58.40
J	23.77	-0.27	55.65	55.65	55.65	55.65	55.67	55.66	55.65	55.65	55.64
K	0.00	0.55	56.44	56.44	56.49	56.49	56.52	56.49	56.44	56.44	56.39
L	8.32	88.84	57.80	57.80	58.77	58.74	58.90	58.69	57.80	57.80	57.54
M	0.00	108.64	55.41	55.41	55.39	55.39	55.40	55.38	55.41	55.41	55.41
N	0.00	95.21	57.70	57.70	58.46	58.46	58.59	58.40	57.70	57.70	57.45
O	0.00	109.11	55.21	55.21	55.20	55.20	55.21	55.20	55.21	55.21	55.21
P	18.72	108.47	55.21	55.21	55.26	55.26	55.27	55.25	55.21	55.21	55.19
Q	9.53	93.97	59.13	59.13	59.97	59.96	60.13	59.90	59.13	59.13	58.88
R	9.44	90.25	59.19	59.19	60.04	60.03	60.19	59.96	59.19	59.19	58.93
S	0.00	11.83	60.89	60.89	62.88	62.87	63.03	62.91	60.89	60.89	60.32
T	0.00	12.47	60.89	60.89	62.88	62.88	63.04	62.91	60.89	60.89	60.32
U	6.10	12.61	60.88	60.88	62.87	62.86	63.02	62.90	60.88	60.88	60.31
V	6.43	54.63	62.61	62.61	64.30	64.30	64.44	64.29	62.61	62.61	62.12
W	6.75	91.08	59.23	59.23	60.08	60.07	60.23	60.00	59.23	59.23	58.97
X	0.00	91.21	59.23	59.23	60.07	60.06	60.22	59.99	59.23	59.23	58.97
Y	0.00	94.02	59.21	59.21	60.04	60.04	60.20	59.97	59.21	59.21	58.95

[a] See Fig. 3.7 for pictorial of node locations.

Table 3.16. NCT maximum quasi steady state temperatures

Node ID [a]	Location		ASH, HTC, HD, 277HD		ASH, HTC, HD, 277LD		ASH, LTC, LD, 277HD		ASH, LTC, LD, 277LD		HSH, LTC, LD, 277HD		HSH, LTC, LD, 277LD		LSH, HTC, HD, 277HD		LSH, HTC, HD, 277LD		Kaolite LD, 277LD	
			0 W	5 W	0 W	5 W	0 W	5 W	0 W	5 W	0 W	5 W	0 W	5 W	0 W	5 W	0 W	5 W	0 W	5 W
	x (cm)	y (cm)	Temperature (°C)																	
A	23.33	108.39	109.23	109.42	109.21	109.42	109.59	109.83	109.57	109.85	109.04	109.33	109.06	109.31	109.56	109.73	109.54	109.75	109.41	109.58
B	23.33	54.61	90.88	91.28	90.89	91.30	91.53	91.88	91.54	91.91	91.01	91.39	91.02	91.38	91.36	91.71	91.37	91.76	91.19	91.57
C	18.76	94.96	98.70	99.94	98.55	99.98	99.16	100.89	98.97	101.01	96.41	98.41	96.46	98.27	100.44	101.55	100.35	101.66	100.12	101.22
D	7.92	11.16	72.30	76.86	72.53	77.09	69.90	76.61	70.05	77.00	68.05	75.13	68.27	75.20	74.55	78.61	74.63	78.79	75.38	79.02
E	7.92	54.62	75.76	80.55	76.03	80.84	72.88	79.64	73.18	80.18	71.15	78.40	71.42	78.50	78.07	82.38	78.27	82.77	79.30	83.24
F	0.00	11.16	71.87	76.91	72.09	77.17	69.62	76.80	69.77	77.20	67.75	75.39	67.97	75.46	74.08	78.63	74.16	78.80	74.84	78.94
G	11.00	94.91	90.98	93.28	90.85	93.34	90.13	93.31	89.94	93.58	86.59	90.26	86.79	90.07	93.52	95.52	93.40	95.74	93.67	95.56
H	11.07	54.61	75.95	80.35	76.25	80.61	72.95	79.34	73.25	79.90	71.19	78.05	71.48	78.14	78.29	82.25	78.50	82.58	79.52	83.14
I	11.00	11.15	72.51	76.78	72.75	77.00	70.03	76.44	70.18	76.84	68.15	74.90	68.36	74.97	74.75	78.58	74.85	78.70	75.60	78.99
J	23.77	-0.27	75.82	76.18	75.82	76.18	75.35	75.68	75.34	75.70	74.63	74.99	74.64	74.99	76.29	76.59	76.28	76.62	76.52	76.84
K	0.00	0.55	64.40	65.36	64.41	65.37	62.69	63.61	62.69	63.65	61.27	62.26	61.30	62.24	65.44	66.26	65.42	66.33	66.23	67.08
L	8.32	88.84	82.97	86.35	83.06	86.50	80.89	85.73	80.95	86.15	77.75	83.10	78.06	83.00	85.57	88.72	85.60	88.79	86.18	89.09
M	0.00	108.64	114.74	115.14	114.67	115.13	116.41	116.86	116.37	116.88	114.79	115.28	114.79	115.23	115.64	116.01	115.59	116.04	115.03	115.42
N	0.00	95.21	88.49	91.56	88.42	91.62	86.47	90.84	86.27	91.21	82.78	87.72	83.04	87.48	91.00	94.09	90.92	94.09	91.29	94.29
O	0.00	109.11	118.70	118.92	118.67	118.91	119.53	119.77	119.50	119.78	118.70	118.96	118.70	118.93	119.17	119.37	119.15	119.38	118.86	119.08
P	18.72	108.47	111.74	111.97	111.71	111.98	112.25	112.56	112.22	112.58	111.56	111.92	111.58	111.90	112.15	112.37	112.13	112.39	111.94	112.16
Q	9.53	93.97	82.49	87.28	82.48	87.36	80.84	86.93	80.70	87.24	77.82	84.62	78.08	84.42	85.04	89.39	84.92	89.54	85.45	89.49
R	9.44	90.25	82.39	87.23	82.41	87.31	80.74	86.90	80.61	87.22	77.73	84.60	77.98	84.40	84.93	89.33	84.84	89.51	85.36	89.46
S	0.00	11.83	72.15	78.46	72.38	78.75	69.79	78.25	69.93	78.63	67.95	76.94	68.19	77.01	74.41	80.14	74.51	80.34	75.24	80.51
T	0.00	12.47	72.15	78.46	72.38	78.76	69.79	78.26	69.93	78.64	67.95	76.95	68.19	77.01	74.41	80.14	74.51	80.35	75.24	80.52
U	6.10	12.61	72.19	78.50	72.42	78.78	69.80	78.27	69.94	78.65	67.97	76.96	68.21	77.03	74.45	80.17	74.56	80.38	75.29	80.56
V	6.43	54.63	75.20	83.73	75.41	84.00	72.65	83.01	72.87	83.46	70.97	81.80	71.20	81.88	77.53	85.39	77.68	85.69	78.54	86.04
W	6.75	91.08	82.36	87.24	82.39	87.34	80.72	86.92	80.59	87.24	77.71	84.62	77.96	84.43	84.90	89.34	84.82	89.53	85.34	89.49
X	0.00	91.21	82.44	87.30	82.47	87.42	80.80	86.99	80.66	87.31	77.78	84.68	78.05	84.50	84.99	89.40	84.90	89.60	85.42	89.56
Y	0.00	94.02	82.46	87.30	82.49	87.41	80.83	86.99	80.69	87.31	77.81	84.68	78.07	84.49	85.01	89.40	84.92	89.60	85.44	89.56

[a] See Fig. 3.7 for pictorial of node locations.

Using the temperatures calculated for the conditions of 10 CFR 71.71(c)(1), Appendix 3.5.1 predicts that the absolute maximum normal operating pressure inside the containment vessel will be 208.75 kPa (30.276 psia). For conservatism and for use in Chaps. 2 and 4 during NCT, the maximum gas temperature and the absolute maximum normal operating pressure in the containment vessel are rounded up to 90°C (194°F), and 210.29 kPa (30.50 psia), respectively. The design absolute pressure of the containment vessel is 801.17 kPa (116.2 psia), and the hydrostatic test pressure is 1135.57 kPa (164.7 psia). Thus, increasing the internal pressure of the containment vessel to a maximum of 210.29 kPa (30.50 psia) during NCT would have no detrimental effect. Stresses generated in the containment vessel at this pressure are insignificant compared to the materials of construction allowable stress. Table 2.20 provides a summary of the pressures and temperatures for NCT. As discussed in Sect. 2.6.1.4, the containment vessel and vessel closure nut stresses for these pressure conditions are below the allowable stress values.

Prior to testing the ES-2M design (a similarly constructed shipping package), each test unit was radiographed to determine the integrity of the Kaolite 1600 impact and insulation material. Following casting of the material inside the drum, some three-dimensional curving cracks were seen in some packages near the top thinner sections from the bottom of the liner to the bottom drum edge. After vibration testing, radiography of the ES-2M TU-4 showed that the lower half of the impact limiter was broken into small pieces (GAB1296-2). To evaluate these findings, TU-4 was reassembled and subjected to HAC sequential testing (GAB1296-2). After vibration and impact testing, many three-dimensional curving cracks were seen around the impact areas, and the inner liner was also visibly deformed. Nevertheless, temperatures at the containment boundary were similar to other packages not subjected to vibration testing prior to HAC testing. No inleakage of water was recorded following immersion. Also, TU-4 of the ES-3100 shipping package was subjected to the full NCT test battery including vibration.

Following these tests, the containment vessel of the ES-2M TU-4 was removed, and a full body helium leak check was performed. The test unit passed the leak-tight criteria in accordance with ANSI N14.5-1997. The containment vessel was then reassembled into the previously tested drum assembly and subjected to the complete HAC testing. Based on the success of this unit and the similar design of the ES-2M, it can be concluded that vibration normally incident to transport does not reduce the effectiveness of the ES-3100 packaging during HAC testing. The ES-3100 has been tested to determine the effectiveness of the package following a sequential NCT 1.2-m (4-ft) drop test and HAC test battery. Throughout all of the vibration and structural testing, the effectiveness of the Kaolite 1600 material as an impact limiter and thermal insulation was not substantially reduced. Since Packcrete is essentially the same composition as Kaolite 1600, Packcrete should perform functionally equivalent to Kaolite 1600. Therefore, the substitution of Kaolite 1600 with Packcrete should not degrade the ability of the package to meet the requirements of 10 CFR 71.

Also, in accordance with 10 CFR 71.71(c)(2), the containment vessel pressure must be calculated at −40°C (−40°F). Given the initial conditions of temperature, relative humidity, no silicone rubber or polyethylene, nylon, or Teflon bag offgassing, the pressure is calculated as follows:

$$P_1 \text{ @ } 25°C = P_a + P_v + P_{fo},$$

where

P_a = 98.15 kPa (14.236 psia), (Appendix 3.5.1)
P_v = 3.20 kPa (0.464 psia), (Appendix 3.5.1)
P_{fo} = 0. (no offgassing, Appendix 3.5.1)

At −40°C (−40°F), the partial pressure of the water vapor is conservatively assumed to be zero. Therefore, the final pressure of the mixture at −40°C (−40°F) is calculated according to the ideal gas law based solely on the partial pressure of the air.

$$\frac{P_1 V_1}{T_1} = \frac{P_2 V_2}{T_2},$$

where

P_1 = 98.15 kPa (14.236 psia),
T_1 = 25°C (298.15 K),
T_2 = −40°C (233.15 K),
V_1 = V_2, and

rearranging and solving for P_2,

P_2 = $P_1 (T_2 / T_1)$,
= (98.15)(233.15 / 298.15),
= 76.76 kPa (11.13 psia).

The cold condition for NCT specified in 10 CFR 71.71 is an ambient temperature in still air and shade of −40°C (−40°F). The 35.2 kg (77.60 lb) of HEU contents in the ES-3100 package generates a maximum bounding decay heat load of 5 W. However, in accordance with Nuclear Regulatory Commission (NRC) Regulatory Guide 7.8, the thermal effects of this internal heat source are neglected during evaluation of the package performance at −40°C (−40°F). When exposed to this condition, the package component temperatures will stabilize over time at a temperature approaching −40°C (−40°F). The package has been examined for use at −40°C (−40°F) (Sect. 2.6.2). No detrimental effects on the package structure or sealing capability result from this minimum temperature requirement. The normal service temperature range of the EPDM O-rings used in the containment boundary is −40 to 150°C (−40 to 302°F) [Table 3.11] in accordance with the *Parker O-Ring Handbook*; thus, the seal will not be affected by this minimum package temperature in accordance with 10 CFR 71.71(c)(2). Leak testing conducted on TU-2 to the leak tight criteria stipulated by ANSI N14.5-1997 following compliance testing provides justification of the above statements.

Summarizing 10 CFR 71.43(f), the tests and conditions of NCT shall not substantially reduce the effectiveness of the packaging to withstand HAC sequential testing. The effectiveness of the ES-3100 to withstand HAC sequential testing is not diminished through application of the tests and conditions stipulated in 10 CFR 71.71. The justification for this statement is provided by physical testing of both the ES-2M and ES-3100 test packages. Due to the similarities in design, fabrication, and material used in construction of both the ES-2M and the ES-3100 package, the Kaolite 1600 physical characteristics will hold true for both designs. The integrity of the Kaolite 1600 is not significantly affected by the NCT vibration and 1.2-m (4-ft) drop tests. As previously stated, Packcrete is essentially the same composition as Kaolite 1600. Based on similarity of material properties, Packcrete should perform functionally equivalent to Kaolite 1600. Therefore, the substitution of Kaolite 1600 with Packcrete should not degrade the ability of the package to meet the requirements of 10 CFR 71.

3.3.2 Maximum Normal Operating Pressure

The stainless-steel drum and cast refractory system will not pressurize as a result of temperature increases because of four ventilation holes (0.795 cm [0.313 in.] in diameter) drilled in the drum side wall 3.81 cm (1.5 in.) from the flanged top and equally spaced around the drum. The holes are filled with nylon plugs, but they are not hermetically sealed. The inner liner encapsulating the noncombustible

neutron poison (Cat 277-4) will not pressurize as a result of temperature increases because of three ventilation holes (0.635 cm [0.25 in.] in diameter) and a slot (1.63 cm [0.64 in.] in width and 4.17 cm [1.64 in.] in length) drilled into this inner liner. These features are covered during transport with aluminum tape to prevent contamination of the neutron poison. This tape does not represent a hermetic seal.

The maximum normal operating pressure is defined in 10 CFR 71.4 as the maximum gauge pressure that would develop in the containment system in a period of one year under the heat conditions specified in 10 CFR 71.71(c)(1). The internal pressure developed under these conditions in the ES-3100 containment vessel is calculated in Appendix 3.5.1 for the most restrictive containment vessel configurations. For conservatism, the decay heat of 5 W was used for the maximum internal heat load in evaluating the package for NCT. The maximum calculated adjusted internal absolute pressure in the containment vessel with solar insolation and the bounding case parameters is 208.75 kPa (30.276 psia). This pressure incorporates offgassing of the silicone rubber pads, polyethylene bottles, Teflon bottles, and polyethylene, nylon, or Teflon bagging and hydrogen gas generation from the radiolysis of water and/or other packing materials. The initial environment inside the containment vessel when assembled is at ambient temperature and pressure with 100% relative humidity. The heat-transfer capability of the packaging is not degraded due to gap creation caused by differences in the fabrication material's coefficient of thermal expansion. Modeling assumed nominal gaps and position based on the engineering drawings of Appendix 1.3.7. Therefore, the maximum normal operating pressure is 107.39 kPa (15.576 psig). For conservatism and for use in Chapters 2 and 4 during NCT, the maximum gas temperature and the absolute maximum normal operating pressure in the containment vessel are rounded up to 90°C (194°F), and 210.29 kPa (30.50 psia), respectively.

For materials to be shipped by air transport, the IAEA SSR-6, para. 621, states: "Packages containing radioactive material, to be transported by air, shall be capable of withstanding, without loss or dispersal of radioactive contents from the containment system, an internal pressure that produces a pressure differential of not less than the maximum normal operating pressure plus 95 kPa." Therefore to comply with these IAEA SSR-6 requirements, an analysis of the ES-3100 package with a steady state condition at 55°C in the shade was conducted with results shown in Table 3.15. The maximum normal operating pressure in the ES-3100 CV is calculated in Appendix 3.5.1 using the highest temperature predicted for the containment vessel [64.44°C (147.99°F)] (Node V in Table 3.15) as the average gas temperature throughout the containment vessel void volume. In this case, the maximum pressure differential across the containment vessel boundary is the resultant pressure plus 95 kPa or 117.69 kPa (17.07 psi.). These values for temperature and pressure are subsequently used in Chapter 4 to determine the leakage criteria that satisfies the requirements of ANSI N14.5.

3.3.3 Maximum Thermal Stresses

The temperature of the package under NCT will vary from a low of −40°C (−40°F) throughout the package to a maximum of 119.38 and 89.60°C (246.88 and 193.28°F) on the surface of the drum and the containment vessel, respectively (Sect. 3.3.1). The slow temperature increase or decrease experienced in normal conditions between these limits will result in an essentially uniform temperature change throughout the package. All materials of construction are within this operating temperature range (Table 3.11). Most of the components of the packaging are completely unrestrained. Therefore, any thermal stresses in the packaging components as the temperature varies between the extremes listed above will have no effect on the ability of the packaging to maintain containment, shielding integrity, and nuclear subcriticality. The maximum stresses due to pressure under NCT for the containment vessel are given in Tables 2.21 and 2.22. These values are significantly below the allowable stresses for the packaging components. The Kaolite 1600 or Packcrete insulation and Cat 277-4 materials are poured and cast in place during the fabrication of the drum weldment (Drawing M2E801580A002, Appendix 1.3.7). This situation produces a zero gap between these materials and the bounding drum and inner liners. Due

to differences in coefficients of thermal expansion, some radial and axial interference is expected due to thermal growth or contraction of the inner liners. These radial and axial interferences and induced stresses are calculated in DAC M801940-0003. The results show that the stresses induced are minimal and do not reduce the effectiveness of the drum assembly. Further discussion of these stresses is provided in Sects. 2.6.1.2 and 2.6.2.

The containment vessel, which is Type 304L austenitic (iron-nickel-chromium) stainless steel, is designed and fabricated in accordance with Sects. III SubSect. NB and IX of the *ASME Boiler and Pressure Vessel Code*. The two sealing surfaces of each containment boundary are joined together by torquing the closure nut inside the containment vessel body to 162.7 ±6.8 N·m (120 ±5 lbf-ft). The O-ring material is EPDM.

The design temperature range of the containment vessel is −29 to 176.7°C (−20 to 400°F) (DAC-M900000-0002). However, the package has been evaluated to −40°C (−40°F) (Sect. 2.6.2). The thermal properties of the stainless-steel container body, lid, and closure nut are not critical at these temperatures. The O-ring seal is important for the containment properties of the containment vessel. The normal service temperature range for the EPDM O-ring is −40 to 150°C (−40 to 302°F) [Table 3.11] for 1000 h of continuous service.

3.4 THERMAL EVALUATION UNDER HYPOTHETICAL ACCIDENT CONDITIONS

3.4.1 Initial Conditions

Six full-scale packages were tested in the sequence shown in Table 2.19. Each ES-3100 test package was subjected to the 1.2-m (4-ft) drop test in accordance with 10 CFR 71.71(c)(5) prior to the sequential HAC tests in accordance with 10 CFR 71.73 (free drop, crush, puncture, thermal, and immersion tests). One of these units (TU-4) had previously completed the tests and conditions stipulated in 10 CFR 71.71(c)(5) through (c)(10), excluding (c)(8). Two different mock-up configurations were used to represent the minimum and maximum proposed shipping weight and to simulate various center of gravity locations. The structural and thermal interface between the mock-up component and the containment vessel was designed to match that of the actual hardware proposed for transport. Based on LS-DYNA drop simulations (DAC-EA-801699-A001 and DAC-EA-801699-A002) the six test units with their associated test weights represent the worst drop orientations for the ES-3100 package. TU-5 used a near replicate of the lightest weight contents for its mock-up component. NCT free-drop, 9-m (30-ft) free drop, 9-m (30-ft) crush and puncture tests were made as specified in 10 CFR 71.71(c)(1), and 73(c)(1) through (c)(3) on all six full-scale test packages prior to thermal testing. The results of this testing are discussed in Sects. 2.7.1, 2.7.2, and 2.7.3. The 1.2-m (4-ft), 9-m (30-ft) drop and crush test orientations were as follows: two tests with the long axis of drum at an oblique angle of 12° to impact surface; a center of gravity over the corner of the drum lid; a drop with the long axis of drum parallel with the impact surface; and a vertical drop on to the drum lid. The subsequent 40-in. puncture drops were made at various orientations as shown in Table 2.19.

Prior to the thermal test, each test unit was preheated to the maximum temperature extreme in accordance with 10 CFR 71.73(b). Since the containment vessels were initially assembled at ~101.35 kPa (14.7 psia) at 25°C (77°F), the initial internal containment vessel pressure was ~105.70 kPa (15.33 psia) at 38°C (100°F) using the ideal gas law. In accordance with 10 CFR 71.73(b)(1), the internal pressure should be that calculated for the maximum normal operating pressure or the adjusted calculated value of 210.29 kPa (30.50 psia). This slight pressure differential has little or no effect on the thermal test results. The maximum decay heat load of the contents is calculated to be 5 W based on 35.2 kg of HEU. Analysis of the ES-3100 package after thermal HAC tests both with and without the decay heat load has been performed. The average projected temperature increase during HAC due to a 5 W heat source

without insolation for Kaolite 1600 or Packcrete , as calculated in DAC M801940-0002, would be ~5.17°C (9.30°F) at the CV top (node Y), ~5.18°C (9.33°F) at the CV O-ring (node W), ~8.05°C (14.49°F) at the CV mid body (node V), and ~6.55°C (11.78°F) at the CV bottom (node T). This decay heat adjustment as well as the various other adjustments like applying solar insolation prior to and following the thermal test are discussed and evaluated in Sect. 3.4.2.

3.4.2 Fire Test Conditions

Full-scale testing in accordance with 10 CFR 71.73 for HAC was conducted on prototypical packages. Therefore, no analyses were conducted to show compliance with the HAC thermal test. However, analyses were conducted and are discussed in Sect. 3.4.3 to determine the thermal impacts of an internal 5W heat source, application of insolation prior to the thermal test, application of insolation during cool down, location of crush plate impact on test unit, thermal capacitance differences between test hardware and proposed shipping hardware and the substitution of Kaolite 1600 with Packcrete.

Full-scale testing of six ES-3100 test units was conducted in accordance with 10 CFR 71.73(c)(4) for HAC. A single full-scale ES-3100 test unit (TU-4) was assembled and subjected to both NCT and to the sequential tests specified in 10 CFR 71.73(c). The furnace used for thermal testing was the No. 3 Furnace at Timken Steel Company in Latrobe, Penn., which is a gas-fired furnace. Oxygen content in stack gases from the furnace were not monitored because it was not anticipated that any of the package's materials of construction were combustible. There was some burning of the silicone pads which are placed between the inner liners and the top plugs of the packages. However, it should be noted that this furnace employs "pulsed" fire burners. This type of burner is unique in that the natural gas flow rate is varied based on furnace controller demands, but the flow of air through the burners is constant, even when no gas is flowing, thereby ensuring a very rich furnace atmosphere capable of supporting any combustion of package materials of construction.

The most significant change to the definition of the HAC thermal test in the current 10 CFR 71 is the requirement for calculation purposes to base convective heat input on "that value which may be demonstrated to exist if the package was exposed to the fire specified." This is not especially significant for this package because it was tested in the gas-fired furnace with burners placed in an attitude which produced a strong convective swirl. Careful examination of the thermal test data indicates that the total heat imparted to the packages was significantly greater than the required total heat specified in 10 CFR 71.73(c)(4). Compliance with ASTM E 2230, *Standard Practice for Thermal Qualification of Type B Packages for Radioactive Material*, was accomplished by the method described in Sect. 7.3 of this standard. This standard is in general agreement with Paragraph 2.2.1 ("Steady-state Method of Compliance") of SG 140.1 entitled *Combination Test/Analysis Method Used to Demonstrate Compliance to DOE Type B Packaging Thermal Test Requirements (30 Minute Fire Test)*.

Prior to the beginning of the thermal test, the furnace was characterized for temperature and heat recovery times. The support stand was welded to a large steel plate which had been placed on the floor of the furnace prior to heating. This steel plate acted as the radiating surface at the bottom of the furnace, as well as providing the ability to hold the test stand rigidly in place. Before heating the furnace, workers practiced loading and unloading test packages from the cold furnace to ensure that the furnace door would not remain open >90 s during each loading. In fact, the maximum time the door was open during any loading was 64 s. As discussed in *Test Report of the ES-3100 Package* (ORNL/NTRC-013), six thermocouples were affixed to the drum assembly's exterior surface. Metal retainer clips were welded to the exterior surface to hold the thermocouples in place. The thermocouple tips were inserted underneath the metal clips, and the wire was wrapped around the metal clip. To eliminate any radiant heat exchange between the thermocouples and the furnace walls, the tips and metal clips were covered with a ceramic coating. Three thermocouples were mounted on each of the walls of the furnace, as well as on the furnace floor, on the furnace door, and three thermocouples were mounted on the test stand.

A minimum of 24 h prior to the beginning of all testing, the furnace was turned on with a set-point temperature of 871°C (1600°F). Following each test, the furnace set point was adjusted to 871°C (1600°F) for at least 45 min prior to the beginning of the next test. The furnace control data recorder ran continuously for the entire duration of the preheat cycle test. TU-1 through TU-5 were preheated to >38°C (100°F) by placing the packages in an environmental chamber, which was heated by a torpedo-type kerosene space heater controlled by a mechanical bulb thermostat with a control range of 38 to 93°C (100 to 200°F). The environmental chambers were similar: a welded steel frame with fiberglass insulation panels. Figure 3.8 shows the chamber used for TU-1 through TU-5, which was heated from the bottom with four floor register vents located around the perimeter and a 20.32-cm (8-in.)–diam manual dampened center venting stove pipe.

The set point temperature of the environmental chamber was monitored and adjusted for the duration of the preheat cycle. Initially, the thermostat was set to 66°C (150°F) for ~23 h. The thermostat set point was then reduced to 43°C (110°F) for the remainder of the preheat cycle (24 h). All packages were preheated for at least 47 h. No test package was loaded into the furnace until 15 of the 18 thermocouples monitoring the furnace had a reading of 800°C (1475°F) or higher. All packages were placed in the preheated furnace on the support stand with the long axis positioned horizontally, and the package lid facing toward a furnace side wall (Fig. 3.9). These packages were exposed to the radiation environment for a minimum of 30 min after all functioning furnace thermocouples and at least four of the six test package exterior surface thermocouples reached a temperature of 800°C (1475°F). During the testing of each package, the thermocouple temperature data recorder was set to record every 15 s.

After each test, the furnace was allowed to reheat for a minimum of 45 min after obtaining the set point temperature before testing the next unit. The furnace control temperature data recorder ran continuously for the duration of the preheat. No test package was loaded into the furnace until all functioning thermocouples on the furnace walls and support stand had again reached a temperature of 800°C (1475°F) or higher.

All units were tested in a horizontal attitude with the top end of the package facing to the right side wall of the furnace and the 0° mark on the drum facing the floor of the furnace. The data from each of the thermal tests, as shown in the test report, show that at least four of the six external drum thermocouples reached temperatures well in excess of 800°C (1475°F) and remained above 800°C (1475°F) during the 30-min thermal testing. Similarly, all other surfaces of the furnace, including the support stand, exceeded 800°C (1475°F) during the timed portion of the thermal test. For the test specified in the regulations, regardless of the amount of heat input by convection, radiation, or conduction, the maximum temperature the skin of the package could reach would be 800°C (1475°F). That is, the source of the heat in the regulatory specified test is at 800°C (1475°F). Heat can only be transferred from a hotter source to a colder source. Thus, regardless of the mode of heat transfer, the greatest temperature a specimen exposed to the 10 CFR 71.73(c)(4) thermal test can attain is 800°C (1475°F). Therefore, the fact that these test packages attained temperatures well in excess of 800°C (1475°F) is an excellent indication that the thermal tests performed not only met the requirements of 10 CFR 71.73(c)(4) but actually exceeded them markedly. The results of these tests are provided in the test report (ORNL/NTRC-013).

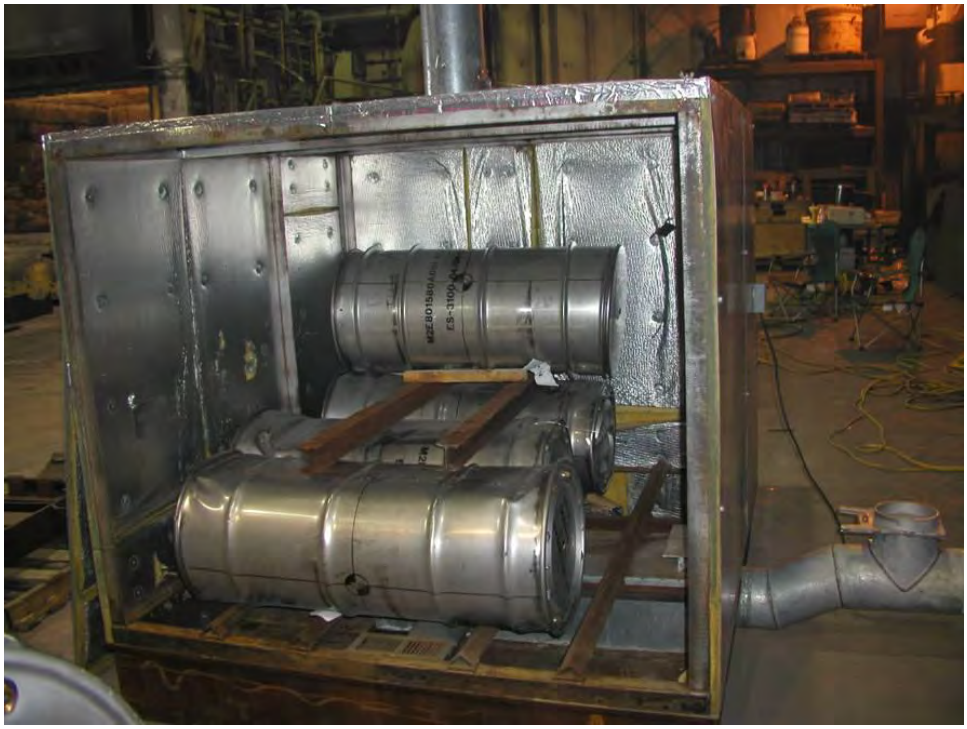


Fig. 3.8. TU-1 through TU-5 preheat arrangement.



Fig. 3.9. Test unit insertion into furnace.

Each test package was removed from the furnace and placed in an area where it was not exposed to artificial cooling (Figs. 3.10 and 3.11). As the furnace door was opened for each test unit, flaming or smoking was visible at the tamper-indicating device (TID) holes in the drum/lid interface. Flaming continued on some of the packages for a short duration; the longest flame duration was 22 min after removal from the furnace. Smoke was also visible from each of the packages and continued after flames were no longer visible. The packages continued to smoke between 12 and 60 min after removal from the furnace. All the packages were allowed to cool naturally to room temperature. The post-thermal testing weights of each unit are summarized in Table 3.17. The drums were disassembled, and the damage was photographed. Each package was visually inspected, and the condition of the package and any observations were recorded.

3.4.3 Maximum Temperatures and Pressure

The six test units previously subjected to both NCT and HAC drop testing were thermally tested in accordance with 10 CFR 71.73(c)(4). To determine the maximum temperatures reached during thermal testing, temperature-indicating patches were placed at various locations throughout the test package at assembly. The temperature range for each patch used is identified in Table 3.18. When the temperature of an indicator was reached, the color would change to black (i.e., blackout temperature). The range of possible blackout temperatures of the patches was from 51.67 to 260°C (125 to 500°F). For TU-1 through TU-5, Table 3.18 defines the number and location of the temperature-indicating patches. A temperature adjustment was evaluated to compensate for conducting the HAC compliance tests with BoroBond4 and substituting Cat 277-4 for the production shipping containers. This adjustment was determined by using an undamaged package and subjecting it to a thermal environment representative of that required by 10 CFR 71.73(c)(4). Based on the analytical results shown in DAC-PKG-801699-A001 and DAC-PKG-801940-A001, the containment vessel in a package using Cat 277-4 would be from 2.5 to 8°F cooler than a package with BoroBond4. Therefore, the results from TU-5 are used without further adjustment for substitution of 277-4 in the final production hardware.

Since the structural and thermal interface between the various mock-ups and containment vessels is the same as the actual hardware, the use of steel mock-ups to simulate the contents is not expected to affect the results of the thermal test significantly. The total maximum weight of the test packages ranged from 157.4 kg (347 lb) to 203.7 kg (449 lb). The ES-3100 package has a nominal gross shipping weight that ranges from 146.88 kg (323.79 lb) to 187.81 kg (414.05 lb) for the minimum and maximum weight containment vessel configurations shown in Table 2.8, respectively. However, the effect on temperature is evaluated in the following paragraphs due to thermal capacitance differences between the mock-up and the actual contents.



Fig. 3.10. Test unit removal from furnace.



Fig. 3.11. Test unit cool down and monitoring arrangement.

Table 3.17. ES-3100 test package weights before and after 10 CFR 71.73(c)(4) HAC testing

Test Unit	Pre-test [a] weight [kg (lb)]	Post-test [a] weight [kg (lb)]	Thermal test weight loss [kg (lb)]	BoroBond4 or Cat 277-4 original weight [kg (lb)]	Water weight in BoroBond4 or Cat 277-4 [kg (lb)]	Water loss percent d (%)
1	202.3 (446)	202.3 (446)	0.0 (0)	20.7 (45.64) [b]	4.91 (10.82) [c]	0.00
2	202.8 (447)	202.8 (447)	0.0 (0)	20.5 (45.19) [b]	4.86 (10.72) [c]	0
3	203.7 (449)	203.2 (448)	0.45 (1)	20.5 (45.19) [b]	4.87 (10.74) [c]	9.31
4	201.8 (445)	201.4 (444)	0.45 (1)	20.4 (44.97) [b]	4.84 (10.66) [c]	9.38
5	157.4 (347)	156.9 (346)	0.45 (1)	20.6 (45.42) [b]	4.89 (10.77) [c]	9.29

[a] ORNL/NTRC-013.
[b] Weight of BoroBond4 and water obtained from casting data (Barton).
[c] This weight is based on thermogravimetric analysis measurements and calculation showing that the minimum water percent is 23.71%.
[d] All weight loss attributed to loss of water in BoroBond4 or Cat 277-4.

Table 3.18. Thermax temperature-indicating patches for test units

Patch location	Internal surface	External surface	Temperature range [°C (°F)]	Test report figure [a]
Inner liner of drum assembly		17 (Full Range)	52–260 (125–500)	5.30
Top plug weldment		4 (Full Range)	52–260 (125–500)	5.31
Containment vessel body flange	8 (4B & 4C)	8 (4B & 4C)	"B" 77–127 (171–261) "C" 132–182 (270–360)	5.28
Containment vessel body (end cap and cylinder)		5 (B)	"B" 77–127 (171–261)	5.28
Containment vessel sealing lid	4 (B)	4 (B)	"B" 77–127 (171–261)	5.29
Test mock-up components		6 (B)	"B" 77–127 (171–261)	5.26 & 5.27

[a] ORNL/NTRC-013.

In order to predict the maximum temperature for the packaging components during HAC with Kaolite 1600 or Packcrete, transient thermal analyses were performed on the finite element model of the ES-3100 shipping container (undamaged configuration) to simulate HAC as prescribed by 10 CFR 71.73(c)(4) [DAC M801940-0002]. A 30-min fire of 800°C (1475°F) was simulated by applying natural convection and radiant exchange boundary conditions to all external surfaces of the drum (assuming the drum is in a horizontal orientation) with various content heat loads up to 5 W. There are heat flux boundary conditions simulating insolation applied to the model before and after the 30-minute fire. The initial temperature distribution within the package having content heat loads as previously stated is obtained from their respective quasi steady-state (with solar insolation) analyses when the maximum O-ring temperature is reached. The initial temperature distribution within the package having no content heat load (0 W) is assumed to be at a uniform temperature equal to the ambient temperature of 38°C (100°F). The content heat load is then simulated by applying a uniform heat flux to the internal surfaces of the elements representing the containment vessel. This is further discussed in DAC M801940-0002.

Following the 30-min fire transient analyses, 48-h cool-down transient thermal analyses are performed using the temperature distribution at the end of the fire as the initial temperature distribution. During post-fire cool-down, natural convection and radiant exchange boundary conditions are applied to all external surfaces of the drum (assuming the drum is in a horizontal orientation). Additionally, cases are analyzed in which insolation is included during the post-fire cool-down. For the cases in which insolation is applied to the model during cool-down, insolation is applied during the first 12-h period following the 30-min fire, and then alternated (off, then on) as was done for NCT. These simulations are compared to determine the impact of applying solation insolation during the cool-down phase.

Based on the previous analysis of the ES-3100 package using BoroBond4 (DAC-PKG-801699-A001), it was noted that using the low-end density of Kaolite 1600 results in higher containment vessel temperatures than using the high-end density of Kaolite 1600. For this reason, the NCT and HAC thermal analyses with Kaolite 1600 were run using a density of 19.4 lb/ft^3. Similarly, the low-end density of the Cat 277-4 material (100 lb/ft^3) was also used in these analyses (DAC M801940-0002). The Packcrete insulation material has been further evaluated with numerous thermal properties as a function of temperature recorded in RP 802282-0002. The maximum temperatures calculated for the ES-3100 shipping container for HAC are summarized in Tables 3.19 through 3.26 for the analyses using Packcrete with various thermal properties combinations. The maximum temperatures calculated for the ES-3100 shipping container during HAC using Kaolite 1600 with a density of 19.4 lb/ft^3 and Cat 277-4 with a density of 100 lb/ft^3 are summarized in Table 3.27. The acronyms for various material properties shown in Tables 3.19 through 3.27 are identified as follows:

ASH – average specific heat for Packcrete;
LSH – low specific heat for Packcrete;
HSH – high specific heat for Packcrete;
LTC – low thermal conductivity for Packcrete;
HTC – high thermal conductivity for Packcrete;
LD – low density for Packcrete;
HD – high density for Packcrete;
277LD – 277-4 material low density;
277HD – 277-4 material high density; and
Kaolite LD – Kaolite low material density.

As previously stated, temperature indicators (patches) were placed on the surface of each containment vessel, inner liner, and mock-up component in TU-1 through TU-5. The blackout temperatures that occurred during thermal testing are recorded for each test unit; the maximum blackout temperatures are listed in Table 3.4. A maximum blackout temperature of 116°C (241°F) was recorded in the vicinity of the O-rings on the containment vessel of TU-5. As discussed below, this temperature will be conservatively adjusted to correlate the test conditions to shipping conditions with decay heat and solar insolation. The blackout temperatures are increased to account for (1) the temperature interval between blackout dots; (2) the temperature increase due to the effects of applying solar insolation prior to the HAC thermal test; (3) the temperature increase due to the decay heat load of the actual contents being shipped; (4) the temperature increase due to effects of applying solar insolation during cool-down; (5) effects of crushing at different locations along the body of the shipping package; (6) thermal capacitance difference in the proposed contents and hardware used during testing; and (7) temperature difference occurring when using Packcrete vs Kaolite 1600.

The initial adjustment for the blackout readings is an increase of 6.11°C (11.0°F) from the patch that blacked out. The highest blackout reading indicates that the actual temperature is somewhere between the highest temperature indicated and the next higher temperature.

The second adjustment compensates for applying solar insolation in accordance with 10 CFR 71.71(c)(2) prior to the thermal test. The temperature profile of the package that is used prior to analytical thermal test is the temperature distribution when the maximum inner O-ring temperature location is achieved. Averaging the individual change at each node of interest for all runs shown in Tables 3.18 through 3.26, the temperature increase at Node Y is 31.14°C (56.06°F); at Node W is 31.11°C (56.00°F); at Node V is 26.67°C (48.00°F); and at Node T is 24.74°C (44.54°F).

The third temperature adjustment considered is the temperature increase due to the decay heat load of the actual contents being shipped. Averaging the individual change at each node of interest for all runs shown in Tables 3.18 through 3.26 due to 5W decay heat load, the temperature increase at Node Y is 5.28°C (9.51°F); at Node W is 5.30°C (9.54°F); at Node V is 8.25°C (14.85°F); and at Node T is 6.75°C (12.15°F).

The fourth adjustment is a temperature increase to represent the effect of insolation heat flux on the package immediately following the conclusion of the thermal HAC test. Averaging the individual change at each node of interest for all runs shown in Tables 3.18 through 3.26 due to insolation during cool-down, the temperature increase at Node Y is 5.47°C (9.85°F); at Node W is 5.32°C (9.57°F); at Node V is 7.23°C (13.01°F); and at Node T is 5.52°C (9.94°F).

The fifth temperature adjustment considered is the temperature increase to the containment vessel based on the location of impact from the 500 kg (1100 lb) crush plate. Based on the differences in location of the crush plate between TU-1 and TU-2, crushing the shipping package with the center of gravity of the plate directly above the containment vessel flange increases the containment vessel temperature on average ~6.11°C (11°F).

Table 3.19. HAC maximum temperatures using Packcrete (ASH, HTC, HD, 277HD)

Node ID [a]	Location		Content heat load					
			0 W			5 W		
			Insolation conditions [b]					
			SB – no SA – no	SB – yes SA – no	SB – yes SA – yes	SB – no SA – no	SB – yes SA – no	SB – yes SA – yes
	x (cm)	y (cm)	Temperature (°C)					
A	23.33	108.39	789.56	790.14	790.15	789.64	790.15	790.16
B	23.33	54.61	790.96	791.41	791.42	791.00	791.44	791.45
C	18.76	94.96	292.52	321.39	322.29	294.11	322.64	324.25
D	7.92	11.16	100.12	125.08	129.58	104.03	129.25	133.76
E	7.92	54.62	87.71	114.48	121.28	91.64	119.02	125.82
F	0	11.16	98.81	123.65	128.13	103.13	128.14	132.70
G	11	94.91	171.22	204.47	209.61	173.45	206.81	212.24
H	11.07	54.61	87.72	114.95	120.84	91.33	118.96	124.94
I	11	11.15	102.28	127.47	131.66	105.93	131.35	135.57
J	23.77	-0.27	799.70	799.76	799.77	799.71	799.76	799.77
K	0	0.55	789.42	789.90	789.91	789.47	789.95	789.95
L	8.32	88.84	106.18	137.33	142.24	109.15	140.65	145.61
M	0	108.64	713.01	721.15	721.15	713.91	721.30	721.30
N	0	95.21	128.31	162.17	167.60	131.13	165.33	170.88
O	0	109.11	784.06	785.87	785.88	784.26	785.90	785.90
P	18.72	108.47	758.61	761.06	761.06	758.92	761.10	761.11
Q	9.53	93.97	101.21	132.95	138.80	105.60	136.98	143.20
R	9.44	90.25	101.05	132.67	138.63	105.48	136.81	143.07
S	0	11.83	95.69	120.38	125.82	100.94	125.92	131.48
T	0	12.47	95.68	120.37	125.81	100.94	125.92	131.48
U	6.1	12.61	95.58	120.30	125.74	100.81	125.82	131.38
V	6.43	54.63	89.35	115.99	123.38	96.25	123.32	130.51
W	6.75	91.08	101.01	132.57	138.57	105.47	136.78	143.06
X	0	91.21	101.11	132.68	138.75	105.58	136.95	143.24
Y	0	94.02	101.16	132.76	138.80	105.61	137.00	143.27

[a] See Fig. 3.7 for pictorial of node locations.
[b] Insolation conditions in accordance with DAC M801940-0002, Sect. 6.6.1.3.
SB = solar heat flux applied before the HAC fire.
SA = solar heat flux applied after the HAC fire.

Table 3.20. HAC maximum temperatures using Packcrete (ASH, HTC, HD, 277LD)

Node ID [a]	Location		Content heat load					
			0 W			5 W		
			Insolation conditions [b]					
			SB – no SA – no	SB – yes SA – no	SB – yes SA – yes	SB – no SA – no	SB – yes SA – no	SB – yes SA – yes
	x (cm)	y (cm)	Temperature (°C)					
A	23.33	108.39	789.56	790.07	790.08	789.64	790.09	790.10
B	23.33	54.61	790.96	791.35	791.36	791.00	791.40	791.41
C	18.76	94.96	292.52	318.69	320.11	294.12	320.34	321.70
D	7.92	11.16	101.80	125.64	130.32	105.63	130.14	134.73
E	7.92	54.62	89.65	115.34	122.20	93.69	120.09	126.92
F	0	11.16	100.45	124.18	128.85	104.69	129.02	133.61
G	11	94.91	171.47	202.43	207.87	173.61	205.15	210.71
H	11.07	54.61	89.70	115.73	121.80	93.35	120.08	126.09
I	11	11.15	103.96	128.04	132.35	107.57	132.24	136.52
J	23.77	-0.27	799.70	799.75	799.76	799.71	799.76	799.76
K	0	0.55	789.42	789.88	789.88	789.47	789.93	789.94
L	8.32	88.84	107.57	137.36	142.37	110.50	140.98	146.02
M	0	108.64	713.01	720.37	720.37	713.91	720.67	720.67
N	0	95.21	128.57	160.63	166.20	131.41	164.12	169.77
O	0	109.11	784.06	785.74	785.74	784.26	785.79	785.80
P	18.72	108.47	758.61	760.81	760.81	758.92	760.90	760.90
Q	9.53	93.97	102.07	132.26	138.48	106.37	137.01	143.21
R	9.44	90.25	101.93	132.04	138.33	106.27	136.82	143.10
S	0	11.83	97.38	120.96	126.67	102.71	126.86	132.46
T	0	12.47	97.38	120.95	126.67	102.71	126.86	132.46
U	6.1	12.61	97.28	120.89	126.60	102.60	126.77	132.37
V	6.43	54.63	91.07	116.73	124.19	98.12	124.14	131.49
W	6.75	91.08	101.88	131.95	138.28	106.25	136.78	143.08
X	0	91.21	101.97	132.06	138.43	106.34	136.90	143.25
Y	0	94.02	102.01	132.14	138.48	106.37	136.95	143.28

[a] See Fig. 3.7 for pictorial of node locations.
[b] Insolation conditions in accordance with DAC M801940-0002, Sect. 6.6.1.3.
SB = solar heat flux applied before the HAC fire.
SA = solar heat flux applied after the HAC fire.

Table 3.21. HAC maximum temperatures using Packcrete (ASH, LTC, LD, 277HD)

Node ID [a]	Location		Content heat load					
			0 W			5 W		
			Insolation conditions [b]					
			SB – no SA – no	SB – yes SA – no	SB – yes SA – yes	SB – no SA – no	SB – yes SA – no	SB – yes SA – yes
	x (cm)	y (cm)	Temperature (°C)					
A	23.33	108.39	790.72	791.25	791.26	790.86	791.28	791.29
B	23.33	54.61	793.90	794.16	794.17	793.93	794.19	794.20
C	18.76	94.96	307.63	335.10	335.79	310.90	337.31	338.01
D	7.92	11.16	80.28	105.35	109.14	86.38	111.85	115.57
E	7.92	54.62	74.43	100.93	108.40	80.59	107.86	115.09
F	0	11.16	79.53	104.59	108.46	86.04	111.49	115.28
G	11	94.91	171.76	204.85	208.44	175.36	208.39	212.03
H	11.07	54.61	74.08	100.59	108.01	79.89	107.09	114.31
I	11	11.15	81.22	106.50	110.00	87.10	112.76	116.23
J	23.77	-0.27	800.03	800.07	800.08	800.04	800.08	800.08
K	0	0.55	792.92	793.23	793.23	792.99	793.27	793.27
L	8.32	88.84	95.00	126.51	130.34	99.47	131.49	135.25
M	0	108.64	742.70	747.78	747.78	743.98	748.09	748.09
N	0	95.21	119.74	153.65	157.69	123.86	158.17	162.26
O	0	109.11	789.56	790.78	790.78	789.96	790.86	790.87
P	18.72	108.47	762.67	764.97	764.97	763.32	765.10	765.10
Q	9.53	93.97	92.95	124.80	129.55	98.60	130.65	135.48
R	9.44	90.25	92.70	124.51	129.27	98.41	130.35	135.25
S	0	11.83	78.10	102.94	107.78	85.80	111.20	115.77
T	0	12.47	78.10	102.94	107.78	85.81	111.20	115.77
U	6.1	12.61	78.04	102.88	107.74	85.73	111.14	115.73
V	6.43	54.63	76.47	103.05	109.92	85.70	112.69	119.22
W	6.75	91.08	92.62	124.43	129.19	98.38	130.28	135.21
X	0	91.21	92.82	124.68	129.45	98.55	130.48	135.46
Y	0	94.02	92.87	124.76	129.52	98.59	130.55	135.51

[a] See Fig. 3.7 for pictorial of node locations.
[b] Insolation conditions in accordance with DAC M801940-0002, Sect. 6.6.1.3.
SB = solar heat flux applied before the HAC fire.
SA = solar heat flux applied after the HAC fire.

Table 3.22. HAC maximum temperatures using Packcrete (ASH, LTC, LD, 277LD)

Node ID [a]	Location		Content heat load					
			0 W			5 W		
			Insolation conditions [b]					
			SB – no SA – no	SB – yes SA – no	SB – yes SA – yes	SB – no SA – no	SB – yes SA – no	SB – yes SA – yes
	x (cm)	y (cm)	Temperature (°C)					
A	23.33	108.39	790.72	791.26	791.27	790.86	791.27	791.28
B	23.33	54.61	793.90	794.17	794.18	793.93	794.19	794.20
C	18.76	94.96	307.63	335.30	336.00	310.82	336.89	337.58
D	7.92	11.16	81.64	106.70	110.66	87.71	113.07	117.06
E	7.92	54.62	75.88	102.74	110.01	82.14	109.17	116.61
F	0	11.16	80.87	105.93	109.98	87.36	112.65	116.68
G	11	94.91	171.90	205.29	208.76	175.44	208.54	211.99
H	11.07	54.61	75.58	102.43	109.60	81.45	108.48	115.82
I	11	11.15	82.57	107.89	111.51	88.42	114.04	117.70
J	23.77	-0.27	800.03	800.07	800.08	800.04	800.08	800.08
K	0	0.55	792.92	793.23	793.24	792.99	793.27	793.27
L	8.32	88.84	96.23	127.75	131.63	100.65	132.71	136.48
M	0	108.64	742.70	747.92	747.92	743.98	748.00	748.00
N	0	95.21	119.89	153.74	157.96	123.97	158.18	162.37
O	0	109.11	789.56	790.83	790.83	789.96	790.84	790.85
P	18.72	108.47	762.67	765.00	765.01	763.32	765.05	765.05
Q	9.53	93.97	93.67	125.47	130.37	99.27	131.27	136.20
R	9.44	90.25	93.49	125.14	130.11	99.09	131.03	136.00
S	0	11.83	79.46	104.49	109.34	87.18	112.30	117.18
T	0	12.47	79.46	104.48	109.34	87.19	112.30	117.19
U	6.1	12.61	79.40	104.43	109.31	87.12	112.24	117.15
V	6.43	54.63	77.75	104.77	111.54	87.11	113.77	120.73
W	6.75	91.08	93.44	125.03	130.03	99.07	130.99	135.96
X	0	91.21	93.62	125.22	130.26	99.24	131.20	136.20
Y	0	94.02	93.67	125.31	130.33	99.26	131.26	136.24

[a] See Fig. 3.7 for pictorial of node locations.
[b] Insolation conditions in accordance with DAC M801940-0002, Sect. 6.6.1.3.
SB = solar heat flux applied before the HAC fire.
SA = solar heat flux applied after the HAC fire.

Table 3.23. HAC maximum temperatures using Packcrete (HSH, LTC, LD, 277HD)

Node ID [a]	Location		Content heat load					
			0 W			5 W		
			Insolation conditions [b]					
			SB – no SA – no	SB – yes SA – no	SB – yes SA – yes	SB – no SA – no	SB – yes SA – no	SB – yes SA – yes
	x (cm)	y (cm)	Temperature (°C)					
A	23.33	108.39	786.39	786.80	786.81	786.37	786.82	786.83
B	23.33	54.61	788.12	788.50	788.51	788.18	788.52	788.53
C	18.76	94.96	245.61	269.71	270.98	246.13	271.55	272.77
D	7.92	11.16	71.90	95.93	102.13	78.18	101.93	108.71
E	7.92	54.62	69.54	95.06	103.78	75.94	101.22	110.79
F	0	11.16	71.50	95.50	101.74	78.25	101.88	108.79
G	11	94.91	130.60	161.42	163.91	132.92	164.94	167.33
H	11.07	54.61	69.33	94.81	103.60	75.40	100.81	110.23
I	11	11.15	72.35	96.45	102.44	78.34	102.18	108.69
J	23.77	-0.27	797.94	798.01	798.02	797.95	798.02	798.02
K	0	0.55	787.04	787.45	787.46	787.11	787.49	787.50
L	8.32	88.84	82.26	111.39	116.13	86.57	116.34	121.30
M	0	108.64	698.42	701.59	701.59	697.02	701.74	701.74
N	0	95.21	94.76	125.64	129.31	98.42	130.34	133.90
O	0	109.11	782.00	782.09	782.09	781.31	782.11	782.12
P	18.72	108.47	749.83	750.97	750.98	749.46	751.04	751.05
Q	9.53	93.97	82.31	111.73	116.62	87.83	117.52	122.81
R	9.44	90.25	82.16	111.49	116.43	87.73	117.35	122.68
S	0	11.83	70.84	94.96	101.79	78.83	102.24	110.08
T	0	12.47	70.84	94.96	101.79	78.83	102.25	110.08
U	6.1	12.61	70.80	94.92	101.80	78.79	102.21	110.07
V	6.43	54.63	70.72	96.38	104.43	80.25	105.15	114.09
W	6.75	91.08	82.12	111.43	116.38	87.73	117.33	122.67
X	0	91.21	82.28	111.63	116.57	87.88	117.52	122.86
Y	0	94.02	82.32	111.69	116.63	87.90	117.56	122.89

[a] See Fig. 3.7 for pictorial of node locations.
[b] Insolation conditions in accordance with DAC M801940-0002, Sect. 6.6.1.3.
SB = solar heat flux applied before the HAC fire.
SA = solar heat flux applied after the HAC fire.

Table 3.24. HAC maximum temperatures using Packcrete (HSH, LTC, LD, 277LD)

Node ID [a]	Location		Content heat load					
			0 W			5 W		
			Insolation conditions [b]					
			SB – no SA – no	SB – yes SA – no	SB – yes SA – yes	SB – no SA – no	SB – yes SA – no	SB – yes SA – yes
	x (cm)	y (cm)	Temperature (°C)					
A	23.33	108.39	786.39	786.77	786.78	786.37	786.80	786.81
B	23.33	54.61	788.12	788.48	788.49	788.18	788.51	788.52
C	18.76	94.96	245.61	268.74	269.99	246.12	270.87	272.11
D	7.92	11.16	72.86	96.56	102.88	78.87	102.46	109.37
E	7.92	54.62	70.65	95.86	104.62	76.88	102.06	111.53
F	0	11.16	72.49	96.13	102.49	78.91	102.38	109.45
G	11	94.91	130.69	161.13	163.38	133.01	164.47	166.91
H	11.07	54.61	70.46	95.63	104.44	76.35	101.58	110.97
I	11	11.15	73.31	97.07	103.19	79.07	102.71	109.34
J	23.77	-0.27	797.94	798.01	798.01	797.95	798.01	798.02
K	0	0.55	787.04	787.44	787.45	787.11	787.49	787.49
L	8.32	88.84	83.00	111.81	116.62	87.31	116.70	121.72
M	0	108.64	698.41	701.32	701.32	697.02	701.58	701.58
N	0	95.21	94.93	125.45	129.04	98.64	130.04	133.68
O	0	109.11	782.00	782.04	782.04	781.31	782.08	782.09
P	18.72	108.47	749.83	750.87	750.88	749.46	750.99	750.99
Q	9.53	93.97	82.82	111.94	116.89	88.33	117.63	123.03
R	9.44	90.25	82.68	111.72	116.71	88.24	117.47	122.91
S	0	11.83	71.87	95.59	102.57	79.48	102.99	110.76
T	0	12.47	71.87	95.59	102.58	79.48	102.99	110.77
U	6.1	12.61	71.83	95.56	102.58	79.44	102.97	110.76
V	6.43	54.63	71.81	97.08	105.27	81.10	105.81	114.82
W	6.75	91.08	82.64	111.65	116.67	88.24	117.44	122.90
X	0	91.21	82.79	111.83	116.84	88.38	117.62	123.08
Y	0	94.02	82.83	111.89	116.89	88.40	117.65	123.10

[a] See Fig. 3.7 for pictorial of node locations.
[b] Insolation conditions in accordance with DAC M801940-0002, Sect. 6.6.1.3.
SB = solar heat flux applied before the HAC fire.
SA = solar heat flux applied after the HAC fire.

Table 3.25. HAC maximum temperatures using Packcrete (LSH, HTC, HD, 277HD)

Node ID [a]	Location		Content heat load					
			0 W			5 W		
			Insolation conditions [b]					
			SB – no SA – no	SB – yes SA – no	SB – yes SA – yes	SB – no SA – no	SB – yes SA – no	SB – yes SA – yes
	x (cm)	y (cm)	Temperature (°C)					
A	23.33	108.39	791.80	792.16	792.17	791.82	792.23	792.24
B	23.33	54.61	794.41	794.69	794.70	794.43	794.75	794.76
C	18.76	94.96	352.26	375.21	375.64	353.24	379.17	379.50
D	7.92	11.16	112.86	139.48	141.97	116.68	144.19	146.61
E	7.92	54.62	91.96	120.86	125.30	96.02	125.85	130.22
F	0	11.16	110.15	136.81	139.17	114.34	141.85	144.21
G	11	94.91	219.04	248.33	251.29	220.19	252.49	255.21
H	11.07	54.61	92.79	122.50	125.38	96.41	127.09	129.88
I	11	11.15	118.01	145.13	147.20	121.51	149.62	151.64
J	23.77	-0.27	800.42	800.45	800.45	800.42	800.45	800.46
K	0	0.55	792.84	793.19	793.19	792.87	793.25	793.25
L	8.32	88.84	120.00	151.52	155.22	122.84	155.71	159.34
M	0	108.64	744.87	748.02	748.02	745.25	748.72	748.72
N	0	95.21	160.33	192.16	195.96	162.66	196.55	200.17
O	0	109.11	790.27	790.69	790.70	790.40	790.82	790.82
P	18.72	108.47	767.06	768.26	768.27	767.19	768.54	768.55
Q	9.53	93.97	109.75	142.73	147.68	113.78	148.02	152.85
R	9.44	90.25	109.54	142.36	147.45	113.64	147.69	152.65
S	0	11.83	103.79	129.91	133.84	109.20	135.99	139.90
T	0	12.47	103.78	129.90	133.84	109.20	135.99	139.90
U	6.1	12.61	103.63	129.75	133.70	109.03	135.82	139.74
V	6.43	54.63	93.53	121.93	128.06	100.60	129.67	135.54
W	6.75	91.08	109.47	142.22	147.37	113.62	147.59	152.61
X	0	91.21	109.58	142.31	147.55	113.76	147.66	152.80
Y	0	94.02	109.64	142.38	147.62	113.79	147.74	152.84

[a] See Fig. 3.7 for pictorial of node locations.
[b] Insolation conditions in accordance with DAC M801940-0002, Sect. 6.6.1.3.
SB = solar heat flux applied before the HAC fire.
SA = solar heat flux applied after the HAC fire.

Table 3.26. HAC maximum temperatures using Packcrete (LSH, HTC, HD, 277LD)

Node ID [a]	Location		Content heat load					
			0 W			5 W		
			Insolation conditions [b]					
			SB – no SA – no	SB – yes SA – no	SB – yes SA – yes	SB – no SA – no	SB – yes SA – no	SB – yes SA – yes
	x (cm)	y (cm)	Temperature (°C)					
A	23.33	108.39	791.80	792.16	792.17	791.79	792.19	792.21
B	23.33	54.61	794.41	794.70	794.71	794.43	794.73	794.75
C	18.76	94.96	352.28	375.36	375.75	352.81	377.50	377.88
D	7.92	11.16	115.14	141.66	144.23	118.93	145.82	148.33
E	7.92	54.62	94.59	123.30	127.71	98.59	127.78	132.18
F	0	11.16	112.19	138.76	141.24	116.39	143.29	145.74
G	11	94.91	218.78	248.80	251.77	220.33	251.62	254.69
H	11.07	54.61	95.49	124.98	127.93	99.11	129.09	131.95
I	11	11.15	120.25	147.32	149.46	123.78	151.23	153.33
J	23.77	-0.27	800.42	800.45	800.45	800.42	800.45	800.45
K	0	0.55	792.84	793.19	793.20	792.87	793.24	793.24
L	8.32	88.84	122.12	153.48	157.19	124.85	156.98	160.71
M	0	108.64	744.87	748.07	748.07	744.84	748.39	748.39
N	0	95.21	160.29	192.43	196.21	162.72	195.85	199.65
O	0	109.11	790.27	790.70	790.71	790.29	790.76	790.76
P	18.72	108.47	767.06	768.28	768.29	767.05	768.40	768.41
Q	9.53	93.97	110.93	143.89	148.81	114.88	148.26	153.40
R	9.44	90.25	110.74	143.52	148.61	114.75	147.96	153.22
S	0	11.83	106.06	131.94	136.10	111.40	137.60	141.65
T	0	12.47	106.05	131.93	136.09	111.40	137.60	141.65
U	6.1	12.61	105.91	131.84	135.97	111.25	137.44	141.51
V	6.43	54.63	95.84	123.96	130.29	102.79	131.31	137.30
W	6.75	91.08	110.68	143.38	148.53	114.74	147.87	153.18
X	0	91.21	110.77	143.53	148.69	114.85	148.01	153.36
Y	0	94.02	110.83	143.59	148.75	114.88	148.05	153.40

[a] See Fig. 3.7 for pictorial of node locations.
[b] Insolation conditions in accordance with DAC M801940-0002, Sect. 6.6.1.3.
SB = solar heat flux applied before the HAC fire.
SA = solar heat flux applied after the HAC fire.

Table 3.27. HAC maximum temperatures using Kaolite (Kaolite LD, 277LD)

Node ID [a]	Location		Content heat load					
			0 W			5 W		
			Insolation conditions [b]					
			SB – no SA – no	SB – yes SA – no	SB – yes SA – yes	SB – no SA – no	SB – yes SA – no	SB – yes SA – yes
	x (cm)	y (cm)	Temperature (°C)					
A	23.33	108.39	790.31	790.93	790.94	790.38	790.96	790.97
B	23.33	54.61	792.56	792.90	792.91	792.59	792.92	792.93
C	18.76	94.96	313.66	341.64	342.95	315.03	342.80	344.11
D	7.92	11.16	107.05	132.97	137.18	110.31	136.38	140.58
E	7.92	54.62	89.44	118.58	124.83	92.99	122.36	128.62
F	0	11.16	104.52	130.54	134.93	108.31	134.36	138.73
G	11	94.91	191.33	222.05	226.36	193.25	223.98	228.28
H	11.07	54.61	90.15	120.07	124.90	93.35	123.45	128.24
I	11	11.15	110.62	136.35	140.42	113.69	139.49	143.54
J	23.77	-0.27	799.83	799.87	799.87	799.83	799.87	799.88
K	0	0.55	791.29	791.71	791.72	791.34	791.75	791.75
L	8.32	88.84	114.33	146.02	151.10	116.96	148.84	153.89
M	0	108.64	730.87	737.03	737.03	731.29	737.07	737.07
N	0	95.21	143.06	175.23	179.64	145.31	177.87	182.27
O	0	109.11	787.50	788.65	788.66	787.58	788.60	788.61
P	18.72	108.47	761.49	763.80	763.80	761.70	763.82	763.82
Q	9.53	93.97	105.24	138.50	145.29	109.18	142.69	149.25
R	9.44	90.25	105.08	138.26	145.07	108.99	142.48	149.07
S	0	11.83	99.52	125.64	131.44	104.44	130.55	136.32
T	0	12.47	99.51	125.63	131.43	104.43	130.55	136.32
U	6.1	12.61	99.40	125.56	131.33	104.30	130.46	136.21
V	6.43	54.63	90.48	119.30	127.15	97.16	125.77	133.55
W	6.75	91.08	105.04	138.21	145.02	108.95	142.46	149.05
X	0	91.21	105.20	138.41	145.21	109.04	142.67	149.26
Y	0	94.02	105.25	138.49	145.28	109.09	142.73	149.30

[a] See Fig. 3.7 for pictorial of node locations.
[b] Insolation conditions in accordance with DAC M801940-0002, Sect. 6.6.1.3.
SB = solar heat flux applied before the HAC fire.
SA = solar heat flux applied after the HAC fire.

The sixth adjustment compensates for the shipment of very small quantities of HEU, rather than the steel mock-ups, and removes the requirement for a minimum content weight. The higher content weight was used for testing to cover the possibility of shipping larger components without retesting. The larger content weight gave conservative structural deformation test results to the drum assembly than would the actual shipping weight. One effect, however, of using the larger test mass could be to reduce the containment vessel's temperature rise during the thermal test because the mock-up acts like a heat sink. In order to evaluate this temperature adjustment, a mock-up of the originally lightest proposed shipment was used in TU-5. The structural and thermal interface between the mock-up components and the containment vessel was designed to match that of the actual shipping hardware, thereby providing the same conductive heat path for thermal testing. As shown by the test results, both the containment vessel and mock-up components of TU-5 recorded higher temperatures than the other test units. This supports the theory that the heavier mock-ups act as heat sinks for the containment vessel. Since the earlier compliance testing, even lower amounts of material are proposed for shipment in the ES-3100. In order to quantify the magnitude of this adjustment, a heat transfer balance is conducted below. This method represents a conservative approach to estimating the adjustment and is not intended to reflect the actual temperature difference. Since the blackouts were recorded on the surface of the mock-up component, adjusted temperatures of 64°C (219°F), 99°C (210°F), and 93°C (199°F) for the top can, middle can, and bottom can are assumed for the following heat transfer equations. The amount of heat absorbed by the mock-up components during the thermal test of TU-5 is calculated as follows:

$$Q = C_{pi} \times (T_{maxi} - T_{mini}) \times W_{Mi}$$

The mockup components for TU-5 consisted of three 10-in.–high steel cans. Two of the upper cans were empty. The bottom can contained 5.9 lb of steel grit. Each individual can weighed ~0.70 lb. Two temperature-indicating patches were placed around the external mid height diameter of each can ~180° apart. The blackout readings on the top, mid, and bottom cans were 99°C (210°F), 93°C (199°F), and 88°C (190°F), respectively. Each of these readings is increased by either 5 or 6°C (9 or 11°F) due to the accuracy of the patches. Therefore, the top can, middle can, and bottom can and steel grit reached an adjusted temperature of 104°C (219°F), 99°C (210°F), and 93°C (199°F), respectively. Therefore, the mockup contents absorbed ~ 9.476×10^4 J as calculated below:

$$\begin{aligned} Q_A &= \sum C_{pi} \times (T_{maxi} - T_{mini}) \times W_{Mi}, \\ &= 460.5 \times (104 - 37.78) \times (0.318) + 460.5 \times (99 - 37.78) \times (0.318) + 460.5 \\ &\quad \times (93 - 37.78) \times (2.99), \\ &= 94760.2 \text{ J}, \end{aligned}$$

where

Q_A = absorbed heat by mockup contents,
C_{pi} = specific heat of the steel cans and grit,
= 460.5 J/kg-°C (0.11 Btu/lb-°F),

T_{maxi} = recorded mock-up can temperatures,
= 104°C (219°F), (top can)
= 99°C (210°F), (middle can)
= 93°C (199°F), (bottom can and steel grit)

T_{mini} = temperature of preheated test units,
= 37.78°C (100°F),

W_{MI} = mock-up component weights for TU-5,
= 0.318 kg (0.70 lb), (top can)
= 0.318 kg (0.70 lb), (middle can)
= 2.99 kg (6.60 lb). (bottom can and steel grit)

The sixth temperature adjustment caused by adding this 9.476×10^4 J (89.81Btu) of heat from the mockup contents into the containment vessel can then be calculated by using the following equation:

$$\begin{aligned} dT &= Q_A / (C_{pcv} \times W_{cv}), \\ &= 9.476 \times 10^4 \text{ J} / (502.36 \text{ J/kg-°C} \times 14.97 \text{ kg}), \\ &= 12.60°C \text{ (22.68°F)}, \end{aligned}$$

where

C_{pcv} = specific heat of the stainless steel containment vessel,
= 502.36 J/kg-°C,

W_{cv} = mass of the empty stainless steel containment vessel,
= 14.97 kg.

The sixth temperature adjustment is 12.60°C (22.68°F).

The seventh temperature adjustment compensates for conducting the HAC compliance tests with Kaolite 1600 vs Packcrete. From the results shown in the last column of Table 3.27 for Kaolite 1600 and the last column of Table 3.26 for Packcrete (material properties that caused the highest temperature increase), the temperature increase at Node Y is 4.10°C (7.38°F); at Node W is 4.13°C (7.44°F); at Node V is 3.75°C (6.75°F); and at Node T is 5.33°C (9.59°F).

Table 3.28 summarizes the numerous temperature adjustments needed for the containment vessel.

Table 3.28. Predicted temperature adjustments (°F) for containment vessel due to HAC

Node ID [a]	Analytical temperature adjustments							Total temp adjustment
	1	2	3	4	5	6	7	
Y	11.00	56.06	9.51	9.85	11.00	22.68	7.38	127.48
W	11.00	56.00	9.54	9.57	11.00	22.68	7.44	127.23
V	11.00	48.00	14.85	13.01	11.00	22.68	6.75	127.29
T	11.00	44.54	12.157	9.94	11.00	22.68	9.59	120.90

[a] See Fig. 3.7 for details of node locations.

Table 3.29 shows the results of adding the seven temperature adjustments previously discussed to the black-out temperatures for the containment vessel with the 3.6-kg (8-lb) mock-up (TU-5). These adjusted temperatures would not adversely affect the stainless-steel components of the containment vessel. EPDM O-rings are rated for reliable service for a continuous 1000 h at −40 to 150°C (−40 to 302°F) [Table 3.11]. As shown in Fig. 2-28 of the *Parker O-Ring Handbook*, these O-ring materials can survive at the predicted temperature shown in Table 3.29 (368.23°F) for ~five hours. Based on the O-ring temperature curve shown in Fig. 7-24 of DAC M801940-0002, the O-ring temperature would have fallen ~40°F to 328°F over that 5 hour period. At ~328°F, the O-ring should be able to survive ~20 hours. The total length of time above the continuous service temperature of 150°C (302°F) for the EPDM O-ring is ~11 hours. Based on the predicted data and the curves from *Parker O-Ring Handbook*, the thermally tested packages with all the conservative adjustments would remain below the acceptable time at temperature limits. Therefore, these adjusted temperatures would not adversely affect the containment vessel O-rings.

Table 3.29. Predicted temperatures of the containment vessel due to HAC

Node ID [a]	Analytical temperature adjustments (°F)	Maximum blackout temperature on TU-5 (°F)	Final predicted temperature (°F)
Y	127.48	261	388.48
W [b]	127.23	241	368.23
V	127.29	199	326.29
T	120.90	210	330.90

[a] See Fig. 3.7 for node locations.
[b] This is the nodal location nearest the inner O-ring location.

To determine the maximum pressure inside the containment vessel as a result of thermal testing, the average adjusted gas temperature must be calculated based on the above results. The approach used is to divide the containment vessel volume into three distinct equal regions and then average the three together. The first volume is represented by the gas adjacent to the containment vessel lid and flange region and the top convenience can. Based on the temperature recorded near the O-rings [116.11°C (241°F)] and the temperature recorded on the external surface of the convenience can [98.89°C (210°F)], the average temperature of the gas in this region is 107.50°C (225.50°F). Using the temperature adjustment of 70.67°C (127.23°F) for this region, the adjusted average temperature in the first region is 178.17°C (352.73°F). The second volume is represented by the gas adjacent to the second convenience can from the top. Based on the temperature recorded on the containment vessel wall and convenience can [92.78°C (199°F)], the average temperature of gas in this region is 92.78°C (199°F). Using the temperature adjustment of 70.72°C (127.29°F) for this region, the adjusted average temperature in the second region is 163.50°C (326.29°F). The third and final volume is represented by the gas adjacent to the bottom convenience can. Again based on the convenience can temperature [87.78°C (190°F)] and the containment vessel end cap temperature [98.89°C (210°F)], the average temperature of gas in this region is 93.33°C (200°F). Using the temperature adjustment of 67.17°C (120.90°F) for this region, the adjusted average temperature in the third region is 160.50°C (320.90°F). Averaging these three temperatures, an average adjusted gas temperature of 167.39°C (333.31°F) is determined for the containment vessel.

As shown in Appendix 3.5.2, the maximum adjusted average gas temperature and pressure in the containment vessel during accident conditions was calculated to be 167.39°C (333.31°F), and 1206.24 kPa (174.95 psia), respectively. For conservatism and for use in Chaps. 2 and 4, the maximum adjusted average gas temperature and pressure in the containment vessel during accident conditions are rounded up to 167.78°C (334°F) and 1206.58 kPa (175.00 psia), respectively.

The maximum adjusted temperature on the surface of the containment vessel, adjacent to the O-rings, was 186.79°C (368.23°F). This is well within the design range for the packaging. The full body helium leak test on all test units following thermal testing meets the “leaktight” criteria in accordance with ANSI N14.5-1997. Visual inspection following testing and unloading indicated that no distortion or damage occurred in the containment vessel wall, sealing lid, closure nut, O-rings, or sealing surfaces. No water was visible inside the containment vessel following the 0.9-m (3-ft) water immersion test or the 15-m (50-ft) water immersion test on TU-6.

The ES-3100 package satisfies the requirements of 10 CFR 71.73 for transport of the 35.2-kg (77.60-lb) arrangements shown in Table 2.8. Section 2.7 has additional details to support this conclusion.

3.4.4 Maximum Thermal Stresses

The maximum adjusted HAC temperature of the ES-3100 containment vessel was based upon the thermal testing results in the vicinity of the O-rings. The maximum temperature recorded in the vicinity of the ES-3100 O-rings (241°F) is shown in Table 3.4. As shown in Sect. 3.4.3, the maximum temperature for the containment vessel at the O-ring location was adjusted for the ES-3100 package to 186.79°C (368.23°F). As previously discussed and as shown in Fig. 2-28 of the *Parker O-Ring Handbook*, this O-ring material can survive at the predicted temperature shown in Table 3.29 (368.23°F) for ~five hours. Based on the O-ring temperature curve shown in Fig. 7-24 of DAC M801940-0002, the O-ring temperature would have fallen ~40°F to 328°F over that 5 hour period. At ~328°F, the O-ring should be able to survive ~20 hours. The total length of time above the continuous service temperature of 150°C (302°F) for the EPDM O-ring is ~11 hours. Based on the predicted data and the curves from *Parker O-Ring Handbook*, the thermally tested packages with all the conservative adjustments would remain below the acceptable time at temperature limits. Hence, no damage would be expected to the O-rings during HAC.

The test packages were all preheated to >38°C (100°F) prior to being placed in the furnace, which was heated to >800°C (1475°F). As noted in the test report (ORNL/NTRC-013), the temperatures recorded on the containment vessels of TU-1 through TU-5 were fairly uniform, both vertically and circumferentially. The maximum temperature variation on the containment vessels was ~50°F (from the test temperatures reported in Table 3.4). No damage would be expected on the containment vessel from thermal stresses resulting from a temperature differential of this magnitude. This conclusion is based on the guidelines given in *ASME Boiler and Pressure Vessel Code*, Sect. III. Thermal stress is defined as a self-balancing stress produced by a non-uniform distribution of temperature (*ASME Boiler and Pressure Vessel Code*, Sect. III, NB-3213.13). This paragraph further states that there are two types of thermal stresses: general thermal stress and local thermal stress. An example of a general stress is that produced by an axial temperature distribution in a cylindrical shell (NB-3213.9). This general stress is further classified (NB-3213.9) as a secondary stress (that is, a normal stress or a shear stress developed by the constraint of adjacent materials or by self-constraint of the structure). NB-3213.9 further states that the basic characteristic of a secondary stress is that it is self-limiting. Local yielding and minor distortions can satisfy the conditions that cause the stress to occur, and failure from a single application would not be expected. An example of a local thermal stress is a small hot spot in the wall of a pressure vessel (NB-3213.13). Local thermal stress is associated with almost complete suppression of the differential expansion and thus produces no significant distortion. Such stresses are considered only from a fatigue standpoint. Fatigue will not result from a one-time cyclic event such as an accidental fire.

Following the thermal test, the volume between the O-rings on the five containment vessels (Sect. 2.7.4) was then leak tested and met the air leak-rate criterion of 10^{-4} ref-cm^3/s. Following the O-ring leak check, the six containment vessels were drilled and tapped for full body helium leak testing. All six containment vessels passed the leak rate criteria for leaktightness per ANSI N14.5-1997. The containment vessels were then submerged under a pressure equivalent to 0.9 m (3 ft) of water for 8 h, with no leakage noted (Sect. 2.7.5). Visual inspection following testing and disassembly also indicated that no distortion or damage occurred in the containment vessel wall, sealing lid, closure nut, O-rings, or sealing surfaces. These tests and observations demonstrate that thermal stresses produced during testing did not affect the containment capability of the containment vessel.

3.4.5 Accident Conditions for Fissile Material Packages for Air Transport

The expanded fire test conditions specified in 10 CFR 71.55(f)(1)(iv) for fissile material package designs for air transportation was not conducted. The issue of subcriticality is addressed in Chap. 6 with content mass limits as addressed in Chap. 1 for air transport.

3.5 APPENDIX

Appendix 3.5.1 Containment Vessel Pressure due to Normal Conditions of Transport for the Proposed Contents 3-55
Appendix 3.5.2 Containment Vessel Pressure due to Hypothetical Accident Conditions for the Proposed Contents 3-65
Appendix 3.5.3 Silicone Rubber Thermal Properties from Therm 1.2 Database 3-73
Appendix 3.5.4 Estimates of Hydrogen Buildup in the ES-3100 Package Containing Highly Enriched Uranium 3-75
Appendix 3.5.5 Chapter 3 References 3-89

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Appendix 3.5.1
Containment Vessel Pressure due to Normal Conditions of Transport for the Proposed Contents

The following calculations determine the pressure of the containment vessel when subjected to the tests and conditions of Normal Condition of Transport per 10 CFR 71.71 for the most restrictive convenience can arrangements shipped in the ES-3100. The following packaging arrangements are evaluated for shipment:

1. one shipment will contain six cans with external dimensions of 4.25-in. diam by 4.875-in. high;
2. one shipment will contain five cans with external dimensions of 4.25-in. diam by 4.875-in. high and three can spacers, top can will be empty;
3. one shipment will contain three cans with external dimension of 4.25-in. diam by 8.75-in. high and two can spacers;
4. one shipment will contain three cans with external dimension of 4.25-in. diam by 10-in. high;
5. one shipment will contain six cans with external dimension of 3.00-in. diam by 4.75-in. high;
6. one shipment will contain three polyethylene bottles with external dimensions of 4.94-in. diam by 8.7-in. high;
7. one shipment will contain three Teflon FEP bottles with external dimensions of 4.69-in. diam by 9.4-in. high;
8. one shipment will contain a brazed assembly of two cans with final external dimensions of 4.25-in. diam by 17.50-in. high. An empty can with external dimensions of 4.25-in. diam by 8.75-in. high will be placed on top or bottom of the 17.50-in.–high can;
9. one shipment will contain fuel rods, or tubes, or plates greater than 17.00 in. in length. These items are bundled together and protected on both ends with an open-ended can with external dimensions of ≤5.0-in. diam by ≤ 8.75-in. high. Total assembly height will be ≤30.5 in. If space is available inside the containment vessel, stainless-steel metal scrubbers will be added on the bottom and top of this assembly or an empty convenience can will be placed on the top or bottom of the assembly;
10. one shipment will contain three cans brazed together with external dimensions of 4.25-in. diam by ~30-in. high; and
11. one shipment will contain closed cans with diameters >4.25 in. In this situation, the void volume inside the loaded containment vessel must be ≥42.779 $in.^3$ in order to not exceed the previously high pressure prediction for containment vessel arrangement (CVA) 7.

To determine this pressure, the following assumptions have been made:

1. The highly enriched uranium (HEU) contents are loaded into convenience cans which are placed inside the ES-3100 containment vessel at standard temperature (T_{amb}) and pressure (P_t) [25°C (77°F) and 101.35 kPa (14.7 psia)] with air at a maximum relative humidity of 100% for all configurations except for CVA 7. CVA 7 assumes the air is 100% dry.

2. The convenience cans are assumed to not be sealed.

3. Convenience can and bottle geometry does not change during pressure increase inside containment vessel.

4. If metal convenience cans are used, the total amount of polyethylene, nylon, or Teflon bagging and lifting slings is limited to 500 g per containment vessel shipping arrangement.

5. The mass of offgassing material (polyethylene, nylon, or Teflon bagging , Teflon bottles, silicone pads, lifting slings) is assumed to be 1490 g for the offgassing evaluation of CVA 7.

6. CVA 11 uses metal cans and, therefore, is limited to 500 g of polyethylene, nylon, or Teflon bagging and lifting slings.

The offgassing material limits identified in assumptions 4 and 5 have been established based on the needs of shippers. All configurations are limited to 500 g of polyethylene, nylon, or Teflon in the form of bags, slings, and/or polyethylene bottles. When the requirement to ship material in Teflon bottles arose, the upper limit of 1490 g of offgassing material was established. This limit is a combination of three Teflon bottles (330 g per bottle) and the original 500 g allowance for polyethylene, nylon, or Teflon bagging material. These offgassing material limits have been used in calculations pertaining to containment vessel pressure, radioactive material leakage criteria, and criticality control. Therefore, portions of the safety basis for this shipping package have been based on these material limits.

Applying Dalton's law concerning a mixture of gases, the properties of each component are considered as though each component exists separately at the volume and temperature of the mixture. Therefore, the molar quantities of each constituent inside the containment vessel (i.e., dry air, water vapor, polyethylene, nylon, or Teflon bagging, and silicone rubber) must be calculated individually.

To calculate these molar properties, the void volume of the containment vessel must be determined. The volume inside an empty ES-3100 containment vessel was determined from ALGOR finite element software to be 623.38 $in.^3$ (10,215.36 cm^3).

I. Molar quantity determination for dry air and water vapor

According to *Fundamentals of Classical Thermodynamics* (Van Wylen), "Relative humidity (Φ) is defined as the ratio of the mole fraction in the mixture to the mole fraction of vapor in a saturated mixture at the same temperature and total pressure."

Since the vapor is considered an ideal gas, the definition reduces to the ratio of the partial pressure of the vapor (P_v) as it exists in the mixture to the saturation pressure of the vapor (P_g) at the same temperature.

Therefore,

$$\Phi = P_v / P_g .$$

From the above equation and interpolating the values given in Table A.1.1 of *Fundamentals of Classical Thermodynamics* (Van Wylen), the partial pressure of the water vapor at saturation is:

$$\begin{aligned} P_v &= 1.0\ (0.464)\ \text{psia}, \\ &= 0.464\ \text{psia}. \end{aligned}$$

The partial pressure of the dry air (P_a) in the volume:

$$\begin{aligned} P_a &= P_t - P_v , \\ &= 14.7 - 0.464, \\ &= 14.236\ \text{psia}. \end{aligned}$$

From the ideal gas law, the number of water vapor moles and dry air moles in the void volume (V_V) for each CVA is calculated as follows:

$$n_v = \frac{P_v \times V_v}{R_u \times T_{amb} \times 12}, \quad n_a = \frac{P_a \times V_v}{R_u \times T_{amb} \times 12}.$$

To determine the number of moles, the void volume of the air mixture must be determined. The void volume (V_V) in the containment vessel for each CVA is calculated as follows:

$$V_V = V_{ECV} - V_{SP} - V_{PB} - V_{SCC} - V_{CS} - V_{CH},$$

where

V_{ECV} = volume inside an empty containment vessel,
V_{SP} = silicone pad volume,
V_{PB} = polyethylene, nylon, or Teflon bagging or lifting sling volume,
V_{SCC} = structural volume of the convenience cans or bottles,
V_{CS} = external volume of the can spacers,
V_{CH} = external volume of the convenience can handles.

A summary for each CVA is shown in Table 1.

The bounding case for oxide material contained in 4.25-in–diam cans based on the volumes listed in Table 1 is CVA 1 at 588.46 in.^{3} CVA 1's void volume is the lowest of the volumes shown in Table 1 for configurations that are used to transport the materials in the form of oxide. CVA 2 and CVA 3 have smaller volumes primarily due to the use of can spacers. Can spacers are not required when transporting oxides. To determine the minimum volume for this configuration, the mass limit of 15.13 kg of oxides is used in conjunction with the lowest density oxide of 7.3 kg/L (UO_3). The resulting volume is 15.13 kg / 7.3 kg/L × 1 ft^3 / 28.32 L × 1728 in.^{3} / ft^3 = 126.464 in.^{3} Therefore, the bounding volume for CVA 1 is 574.66 in.^{3} − 126.464 in.^{3} = 448.20 in.^{3}

Table 1. Containment vessel void volume for each CVA

	CVA	V_{ECV} (in.^{3})	V_{SP} [a] (in.^{3})	V_{PB} (in.^{3})	V_{SCC} (in.^{3})	V_{CS} (in.^{3})	V_{CH} (in.^{3})	V_V (in.^{3})
1	Six 4.875-in.–high cans Seven silicone pads Six can handles	623.38	9.35	30.51	7.84	0.00	1.02	574.66
2	Five 4.875-high cans Nine silicone pads Three Cat 277-4 spacers Eight can handles	623.38	12.03	30.51	6.47	60.60	1.36	512.41
3	Three 8.75-in.–high cans Two Cat 277-4 spacers Six silicone pads Five can handles	623.38	8.02	30.51	5.14	40.40	0.85	538.46
4	Three 10-in.–high cans Four silicone pads Three can handles	623.38	5.35	30.51	5.56	0.00	0.51	581.45
5	Six 4.75-in.–high nickel cans	623.38	0.00	30.51	12.64	0.00	1.02	579.21
6	Three 4.94-in.–OD polyethylene bottles	623.38	0.00	9.46	21.05	0.00	0.00	592.87
7	Three 4.69-in.–OD Teflon FEP bottles	623.38	0.00	30.51	27.95	0.00	0.00	564.92
8	One 17.5-in.–high can loaded One 8.75-in.–high can empty Three silicone pads Two can handles	This configuration is bounded by CVA 3						
9	Two open-ended cans One empty convenience can with height ≤ 8.75-in. Three silicone pads Two can handles	This configuration is bounded by CVA 4 [b]						
10	Three 10-in. cans brazed together Two silicone pads One can handle	This configuration is bounded by CVA 4						
11	Closed convenience cans with diameters greater or equal to 4.25-in. Seven silicone pads							42.779 (min.)

[a] This assumes that the internal convenience cans, polyethylene or Teflon FEP bottles, and Cat 277-4 spacer cans are not sealed.
[b] Although CVA 9 may slightly exceed the height of the combined three 25.4 cm (10 in.) can height (CVA 4), the open-ended cans and contents produce a larger void volume and thereby lower overall pressure inside the containment vessel.

Only CVA 7 can accommodate the uranyl nitrate crystals (UNX) held in the Teflon bottles. CVA 7 is limited to 9.17 kg of the uranyl nitrate hexahydrate crystals and 11.9 kg of uranyl nitrate trihydrate crystals (see Appendix 3.5.4). For the bounding pressure calculation, the smallest resulting free volume in CVA 7 is then 564.92 − 11.9 kg / 2.81 kg/L × 1 ft^3 / 28.32 L × 1728 in.^{3} / ft^3 = 564.92 in.^{3} − 258.4 in.^{3} = 306.52 in.^{3}. The bounding case for all materials contained in cans with a diameter >4.25 in. is determined by not exceeding the maximum predicted HAC pressure previously determined for CVAs 1 and 7. A minimum void volume of 42.779 in.^{3} in the containment vessel has been calculated. This value is conservatively rounded up to 43 in.^{3}

Using the above molar equations and bounding volumes, the number of moles for water vapor and dry air in the vessel for CVAs 1, 7, and 11 are summarized in Table 2.

Table 2. Water vapor and dry air molar summary for each CVA

CVA	P_a (psia)	P_v (psia)	V_V (in.^{3})	R_u (ft-lb/lb-mol·R)	T_{amb} (R)	n_v (lb-mol)	n_a (lb-mol)
1	14.236	0.464	448.20	1545.32	537	2.0884E-05	6.4075E-04
7	14.700 [a]	0.000 [a]	306.52	1545.32	537	0.0000E+00	4.5248E-04
11	14.236	0.464	42.779	1545.32	537	1.9933E-06	6.1157E-05

[a] This represents a worst case set of conditions due to the later addition of water vapor from efflorescence of the UNX crystals.

II. Molar quantity determination due to offgassing for each containment vessel arrangement

The maximum temperature calculated for the containment vessel is 89.60°C (193.28°F). This temperature is assumed to be constant throughout the containment vessel and contents. Therefore, the polyethylene, nylon, or Teflon bags, polyethylene bottles, Teflon FEP bottles, and silicone rubber can pads are assumed to be at this temperature.

Using the above calculated results and the specific gas generation of polyethylene, nylon, or Teflon bags and silicone rubber pad measurements at temperatures up to 170°C (338°F) conducted by the Y-12 Development Division, the amount of gas (V_{bo} and V_{po}) generated due to offgassing of the polyethylene, nylon, or Teflon bags and/or polyethylene bottles, and silicone rubber can pads at any temperature is estimated by first determining the offgassing volume per unit mass at temperature and multiplying that by the total mass of the bags and can supports inside the containment vessel. Based on testing at a temperature of 93.33°C (200°F), no recordable offgassing occurred in the polyethylene, nylon, or Teflon bags and/or polyethylene bottles, or silicone rubber pad material as documented in Y/DZ-2585. The data showed that the Teflon FEP material offgassing volume per unit mass (V_{tf}) was conservatively assumed to be 0.25 cm^3/g@STP (Y/DZ-2720). These values are used to determine the offgassing volumes as shown below:

$V_{po} = W_p \times 0.0 / 16.387$ (in.^{3}) (offgassing volume of silicone rubber pads)

$V_{bo} = W_b \times 0.0 / 16.387$ (in.^{3}) (offgassing volume of polyethylene, nylon, or Teflon bags and/or polyethylene bottles or lifting sling)

$V_{tf} = W_{tf} \times 0.25 / 16.387$ (in.^{3}) (offgassing volume of Teflon bottles)

From the ideal gas law, the number of gas moles in the volume at standard temperature and pressure is as follows:

$$n_{io} = \frac{P_v \times V_i}{R_u \times T_{amb} \times 12}.$$

A summary of the results obtained using the above equations for the bounding CVA is presented in Tables 3, 4, and 5.

Table 3. Molar quantity of gas generated due to the silicone rubber pad offgassing [a]

CVA	W_p (g)	V_{po} (in.^{3})	P_V (psia)	R_u (ft-lb/lb-mol·R)	T_{amb} (R)	n_{po} (lb-mol)
1	186.74	0.00	14.7	1545.32	537	0.0000E+00
7	0.00	0.00	14.7	1545.32	537	0.0000E+00
11	186.74	0.00	14.7	1545.32	537	0.0000E+00

[a] Silicone rubber pad weight determined from Table 2.8.

Table 4. Molar quantity of gas generated due to the polyethylene, nylon, or Teflon bag, sling and/or polyethylene bottle offgassing

CVA	W_b (g)	V_{bo} (in.^{3})	P_V (psia)	R_u (ft-lb/lb-mol·R)	T_{amb} (R)	n_{bo} (lb-mol)
1	500.00	0.00	14.7	1545.32	537	0.0000E+00
7	500.00	0.00	14.7	1545.32	537	0.0000E+00
11	500.00	0.00	14.7	1545.32	537	0.0000E+00

Table 5. Molar quantity of gas generated due to the Teflon bottle offgassing

CVA	W_{tf} (g)	V_{tf} (in.^{3})	P_V (psia)	R_u (ft-lb/lb-mol·R)	T_{amb} (R)	n_{tf} (lb-mol)
7	990.00	15.10	14.7	1545.32	537	2.2296E-05

III. Gas generation due to radiolysis of water

Buildup of hydrogen gas (H_2) and oxygen gas (O_2) in the ES-3100 containment vessel due to radiolysis is incorporated into the pressure calculation by assuming that 5 mol % of the free volume is hydrogen gas. Since each mole of H_2 generated is accompanied by 0.5 mol of O_2, the concentration of H_2 will reach 5 mol % when volume of H_2 is 0.05405 times the initial void volume (see Sect. 3.5.4.8 of Appendix 3.5.4). Using the ideal gas law, the number of gas moles of hydrogen in the volume at standard temperature and pressure is:

$$n_r = \frac{P_v \times V_r}{R_u \times T_{amb} \times 12},$$

where

n_r = individual molar quantity for hydrogen and oxygen gas;
V_r = volume of gas assumed generated by radiolysis.

A summary of the results for hydrogen and oxygen generation due to radiolysis using the above equation is presented in Table 6.

Table 6. Molar quantity of oxygen and hydrogen gas generation due to radiolysis

CVA	V_v (in.^{3})	V_h (in.^{3})	P_v (psia)	R_u (ft-lb/lb-mol·R)	T_{amb} (R)	n_{r-H2} (lb-mol)	n_{r-O2} (lb-mol)
1	448.20	24.23	14.7	1545.32	537.0	3.5761E-05	1.7881E-05
7	306.52	16.57	14.7	1545.32	537.0	2.4457E-05	1.2228E-05
11	42.779	2.31	14.7	1545.32	537.0	3.4133E-06	1.7066E-06

IV. Molar quantity of gas generated due to the efflorescence nature of the uranyl nitrate crystals

The UNX crystals in any hydrated state will decompose and lose water molecules at the temperature shown in Table 3.3 [193.28°F (89.60°C)]. The partial pressure of water vapor in this mixture is conservatively estimated to be the saturated vapor pressure (P_{sv}) of water at 193.28°F or 10.062 psia. Using the ideal gas law, the molar quantity of water vapor (n_v) in this volume at the maximum containment vessel temperature and the saturated vapor pressure is:

$$n_v = \frac{P_{sv} \times V_v}{R_u \times T_{cv} \times 12},$$

$$= (10.062 \times 306.52) / (1545.32 \times 12 \times 653.28),$$
$$= 2.5459 \times 10^{-4} \text{ lb-mol},$$

where

n_v = molar quantity for water vapor;
V_v = void volume of containment vessel;
T_{cv} = maximum temperature of containment vessel; and
P_{sv} = interpolated saturated vapor pressure of water at temperature from *Fundamental of Classical Thermodynamic* (Van Wylen), Table A.1.1, p. 650.

V. Total pressure due to offgassing and NCT temperatures inside the containment vessel

The total pressure of the mixture at 89.60°C (193.28°F), P_T, for the bounding CVA is the sum of each of the previously calculated molar quantities. Table 7 summarizes the molar constituents and total pressure of each bounding CVA. The following equation is used to calculated the final containment vessel pressure:

$$P_{89.60°C} = (\sum n_i \times R \times T \times 12) / V_{GMV},$$

where

n_i = individual molar quantity for each gas,

T = average gas temperature,
= 89.60°C (193.28°F),

V_{GMV} = V_v = gas mixture volume.

Table 7. Total pressure inside the containment vessel at 89.60°C (193.28°F)

CVA [a]	n_a [b] (lb-mol)	n_v [b] (lb-mol)	n_{po} [b] (lb-mol)	n_{bo} [b] (lb-mol)	n_{tf} [b] (lb-mol)	n_{H2} [b] (lb-mol)	n_{O2} [b] (lb-mol)	n_T [b] (lb-mol)	P_T (psia)
1	6.4075E-04	2.0884E-05	0.0000E+00	0.0000E+00	0.0000E+00	3.5761E-05	17881E-05	7.1428E-04	19.333
7	4.5248E-04	2.5459E-04 [c]	0.0000E+00	0.0000E+00	2.2296E-05	2.4457E-05	1.2228E-05	7.6605E-04	30.276
11	6.1157E-05	1.9933E-06	0.0000E+00	0.0000E+00	0.0000E+00	3.4133E-06	1.7066E-06	6.8270E-05	19.333

[a] This assumes that the internal convenience cans, polyethylene or Teflon FEP bottles, and Cat 277-4 spacer cans are not sealed.
[b] n_a—molar quantity of dry air in the gas mixture;
n_v—molar quantity of water vapor in the gas mixture;
n_{po}—molar quantity of gas due to offgassing of the silicone rubber pads;
n_{bo}—molar quantity of gas due to offgassing of the polyethylene, nylon, or Teflon bags, polyethylene bottles, and lifting sling;
n_{tf}—molar quantity of gas due to offgassing of the Teflon bottles;
n_{H2}—molar quantity of hydrogen gas due to radiolysis of water;
n_{O2}—molar quantity of oxygen gas due to radiolysis of water; and
n_T—total molar quantity in the gas mixture.
[c] This value is the molar quantity of water vapor generated from the efflorescence of UNX crystals.

VI. Total pressure at −40°C (−40°F)

At −40°C (−40°F), the partial pressure of the water vapor is conservatively assumed to be zero. Therefore, the final pressure of the mixture at −40°C (−40°F) is calculated according to the ideal gas law based solely on the partial pressure of the air.

$$\frac{P_1 V_1}{T_1} = \frac{P_2 V_2}{T_2},$$

where

P_1 = 14.236 psi,
T_1 = 77°F = 536.67 R,
T_2 = −40°F = 419.67 R,
V_1 = V_2.

Rearranging and solving for P_2,

P_2 = $P_1 (T_2 / T_1)$,
= (14.236)(419.67 / 536.67),
= 11.13 psia.

VII. Maximum containment vessel pressure differential in accordance with air transport guidance

The methodology used to determine the maximum pressure differential for air transport in accordance with IAEA SSR-6, paragraphs 620 and 621 incorporate the following assumptions.

1. The three containment vessel arrangements previously discussed in this appendix will be evaluated.
2. Evaluation will be conducted at the maximum containment vessel temperature shown in Table 3.15 for air transport.
3. Maximum containment vessel temperature was determined using an ambient temperature of 55°C, self-heating of the package contents, and no insolation.
4. Maximum pressure differential is the maximum normal operating pressure (MNOP) plus 95 kPa.

A value of 147.99°F was determined and documented in DAC M801940-0002 and is used as an average temperature of the containment vessel. The molar quantity results shown in Table 8 will be evaluated at this temperature as shown in Table 9. UNX crystals will not be transported by air. Therefore, there is no longer a need to evaluate CVA 7.

Table 8. Total molar quantities inside the containment vessel

CVA [a]	n_a [b] (lb-mol)	n_v [b] (lb-mol)	n_{po} [b] (lb-mol)	n_{bo} [b] (lb-mol)	n_{tf} [b] (lb-mol)	n_{H2} [b] (lb-mol)	n_{O2} [b] (lb-mol)	n_T [b] (lb-mol)
1	6.4075E-04	2.0884E-05	0.0000E+00	0.0000E+00	0.0000E+00	3.5761E-05	1.7881E-05	7.1528E-04
11	6.1157E-05	1.9933E-06	0.0000E+00	0.0000E+00	0.0000E+00	3.4133E-06	1.7066E-06	6.8270E-05

[a] This assumes that the internal convenience cans, polyethylene or Teflon FEP bottles, and Cat 277-4 spacer cans are not sealed.
[b] n_a—molar quantity of dry air in the gas mixture;
n_v—molar quantity of water vapor in the gas mixture;
n_{po}—molar quantity of gas due to offgassing of the silicone rubber pads;
n_{bo}—molar quantity of gas due to offgassing of the polyethylene, nylon, or Teflon bags, polyethylene bottles, and lifting sling;
n_{tf}—molar quantity of gas due to offgassing of the Teflon bottles;
n_{H2}—molar quantity of hydrogen gas due to radiolysis of water;
n_{O2}—molar quantity of oxygen gas due to radiolysis of water; and
n_T—total molar quantity in the gas mixture.
[c] This value is the molar quantity of water vapor generated from the efflorescence of UNX crystals.

In accordance with IAEA SSR-6, para. 621, the maximum differential pressure (P_{DIFF}) generated under air transport conditions is the maximum normal operating pressure calculated in Table 9 plus 95 kPa (13.78 psi). This pressure differential will be used in Table 2.21a to evaluate the containment vessel structural integrity for air transport.

Table 9. Containment vessel MNOP at 64.44°C (147.99°F)

CVA	n_T (lb-mol)	P_{MNOP} (psia)	P_{DIFF} (psig)
1	7.1528E-04	3.29	17.07
11	6.8270E-05	3.29	17.07

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Appendix 3.5.2
Containment Vessel Pressure due to Hypothetical Accident Conditions for the Proposed Contents

The following calculations determine the pressure of the containment vessel when subjected to the tests and conditions of Hypothetical Accident Conditions per 10 CFR 71.73 for the most restrictive convenience can arrangements shipped in the ES-3100 package. The following packaging arrangements are evaluated for shipment:

1. one shipment will contain six cans with external dimensions of 4.25-in. diam by 4.875-in. high;
2. one shipment will contain five cans with external dimensions of 4.25-in. diam by 4.875-in. high and three can spacers, the top can is empty;
3. one shipment will contain three cans with external dimensions of 4.25-in. diam by 8.75-in. high and two can spacers;
4. one shipment will contain three cans with external dimensions of 4.25-in. diam by 10-in. high;
5. one shipment will contain six nickel cans with external dimensions of 3.00-in. diam by 4.75-in. high;
6. one shipment will contain three polyethylene bottles with external dimensions of 4.94-in. diam by 8.7-in. high;
7. one shipment will contain three Teflon FEP bottles with external dimensions of 4.69-in. diam by 9.4-in. high;
8. one shipment will contain a brazed assembly of two cans with final external dimensions of 4.25-in. diam by 17.50-in. high. An empty can with external dimensions of 4.25-in. diam by 8.75-in. high will be placed on top or bottom of the 17.50-in.–high can;
9. one shipment will contain fuel rods, or tubes, or plates greater than 17.00 in. in length. These items are bundled together and protected on both ends with an open-ended can with external dimensions of ≤5.0-in. diam by ≤ 8.75-in. high. Total assembly height will be ≤30.5 in. If space is available inside the containment vessel, stainless-steel metal scrubbers will be added on the bottom and top of this assembly or an empty convenience can will be placed on the top or bottom of the assembly;
10. one shipment will contain three cans brazed together with external dimensions of 4.25-in. diam by ~30-in. high; and
11. one shipment will contain closed cans with diameters >4.25 in. In this situation, the void volume inside the loaded containment vessel must be ≥42.779 $in.^3$ in order to not exceed the previously high pressure prediction for containment vessel arrangement (CVA) 7.

To determine this pressure, the following assumptions have been made.

1. The highly enriched uranium (HEU) contents are loaded into convenience cans and placed inside the ES-3100 containment vessel at standard temperature [25°C (77°F)] and at the maximum normal operating pressure (see Table 7 of Appendix 3.5.1).
2. The convenience cans are assumed to not be sealed.
3. Convenience can and bottle geometry does not change during pressure increase inside containment vessel.
4. If metal convenience cans are used, the total amount of polyethylene, nylon, or Teflon bagging and lifting slings is limited to 500 g per containment vessel shipping arrangement.
5. The mass of offgassing material (polyethylene, nylon, or Teflon bagging , Teflon bottles, silicone pads, lifting slings) is assumed to be 1490 g for the offgassing evaluation of CVA 7.
6. Hydrogen and oxygen molar quantities calculated in Appendix 3.5.1 are conservatively added to the gas mixture for HAC.
7. The contribution in pressure generated by the efflorescence of uranyl nitrate crystals (UNX) is incorporated into the results for CVA 7.
8. CVA 11 uses metal cans and, therefore, is limited to 500 g of polyethylene, nylon, or Teflon bagging and lifting slings.

The offgassing material limits identified in assumptions 4 and 5 have been established based on the needs of shippers. All configurations are limited to 500 g of polyethylene, nylon, or Teflon in the form of bags, slings, and/or polyethylene bottles. When the requirements to ship material in Teflon bottles arose, the upper limit of 1490 g of offgassing material was established. This limit is a combination of three Teflon bottles (990 g) and the original 500 g allowance for polyethylene, nylon, or Teflon bagging material. These offgassing material limits have been used in calculations pertaining to containment vessel pressure, radioactive material leakage criteria, and criticality control. Therefore, portions of the safety basis for this shipping package have been based on these material limits.

Applying Dalton's law concerning a mixture of gases, the properties of each component are considered as though each component exists separately at the volume and temperature of the mixture. Therefore, the molar quantities of each constituent inside the containment vessel (i.e., dry air, water vapor, polyethylene, nylon, or Teflon bagging and/or polyethylene bottles, silicone rubber pads, and Teflon bottles) must be calculated individually.

To calculate these molar properties, the void volume of the containment vessel must be determined. The volume inside an empty ES-3100 containment vessel was determined from ALGOR finite element software to be 623.38 $in.^3$ (10,215.36 cm^3).

I. Molar quantity determination based on MNOP

To use the maximum normal operating pressure at standard temperature, the number of lb-mol of gas needs to be increased using the following equation:

$$n_{MNOP} = \frac{P_T \times V_v}{R_u \times T_{amb} \times 12} \ (molar\ equation)\ .$$

Using P_T from Table 1 and the molar equation, the total number of moles is summarized in Table 2.

Table 1. Total pressure inside the containment vessel at 89.60°C (193.28°F) [a]

CVA	n_a [b] (lb-mol)	n_v [b] (lb-mol)	n_{po} [b] (lb-mol)	n_{bo} [b] (lb-mol)	n_{tf} [b] (lb-mol)	n_{H2} [b] (lb-mol)	n_{O2} [b] (lb-mol)	n_T [b] (lb-mol)	P_T (psia)
1	6.4075E-04	2.0884E-05	0.0000E+00	0.0000E+00	0.0000E+00	3.5761E-05	1.7881E-05	7.1528E-04	19.333
7	4.5248E-04 [c]	2.5459E-04 [c]	0.0000E+00	0.0000E+00	2.2296E-05	2.4457E-05	1.2228E-05	7.6605E-04	30.276
11	6.11576E-05	1.99338E-06	0.0000E+00	0.0000E+00	0.0000E+00	3.413385E-06	1.7067E-06	6.827077E-05	19.333

[a] This assumes that the internal convenience cans, polyethylene or Teflon FEP bottles, and Cat 277-4 spacer cans are not sealed.
[b] n_a—molar quantity of dry air in the gas mixture;
n_v—molar quantity of water vapor in the gas mixture;
n_{po}—molar quantity of gas due to offgassing of the silicone rubber pads;
n_{bo}—molar quantity of gas due to offgassing of the polyethylene, nylon, or Teflon bags, polyethylene bottles, and lifting sling;
n_{tf}—molar quantity of gas due to offgassing of the Teflon bottles;
n_{H2}—molar quantity of hydrogen gas due to radiolysis of water;
n_{O2}—molar quantity of oxygen gas due to radiolysis of water; and
n_T—total molar quantity in the gas mixture.
[c] For CVA 7, using 100% dry air at containment vessel closure and the saturated vapor pressure at temperature for the water vapor constituent, the highest pressure is generated.

Table 2. Molar summary at MNOP and 25°C (77°F)

CVA	P_T (psia)	V_V (in.^{3})	R_u (ft-lb/lb-mol·R)	T_{amb} (R)	n_{MNOP} (lb-mol)
1	19.333	448.20	1545.32	537	8.7016E-04
7	30.276	306.52	1545.32	537	9.3193E-04
11	19.333	42.779	1545.32	537	8.3054E-05

II. Molar quantity determination due to offgassing for each containment vessel arrangement

To determine the maximum pressure inside the containment vessel as a result of thermal testing, the average adjusted gas temperature must be calculated based on the above results. The approach used is to divide the containment vessel volume into three distinct equal regions and then average the three together. The first volume is represented by the gas adjacent to the containment vessel lid and flange region and the top convenience can. Based on the temperature recorded near the O-rings [116.11°C (241°F)] and the temperature recorded on the external surface of the convenience can [98.89°C (210°F)], the average temperature of the gas in this region is 107.50°C (225.50°F). Using the temperature adjustment of 70.67°C (127.23°F) for this region (Sect. 3.4.3), the adjusted average temperature in the first region is 178.17°C (352.73°F). The second volume is represented by the gas adjacent to the second convenience can from the top. Based on the temperature recorded on the containment vessel wall and convenience can [92.78°C (199°F)], the average temperature of gas in this region is 92.78°C (199°F). Using the temperature adjustment of 70.72°C (127.29°F) for this region (Sect. 3.4.3), the adjusted average temperature in the second region is 163.50°C (326.29°F). The third and final volume is represented by the gas adjacent to the bottom convenience can. Again based on the convenience can temperature [87.78°C (190°F)] and the containment vessel end cap temperature [98.89°C (210°F)], the average temperature of gas in this region is 93.33°C (200°F). Using the temperature adjustment of 67.17°C (120.90°F) for this region (Sect. 3.4.3), the adjusted average temperature in the third region is 160.50°C (320.90°F). Averaging these three temperatures, an average adjusted gas temperature of 167.39°C (333.31°F) is determined for the containment vessel.

Using the above calculated results and the specific gas generation of polyethylene, nylon, or Teflon bags and silicone rubber pads measurements at temperatures up to 170°C (338°F) conducted by the Y-12 Development Division (Y/DZ-2585), the amount of gas generated due to offgassing of the silicone rubber can pads, the polyethylene, nylon, or Teflon bags and/or polyethylene bottles, and the Teflon FEP bottles at 167.39°C (333.31°F), (V_{po}, V_{bo}, and V_{tf}) is estimated by first determining the offgassing volume per unit mass at temperature and multiplying that by the total mass of the bags, bottles, slings, and silicone rubber can supports inside the containment vessel. Based on testing at an approximate temperature of 170°C (338°F), values of ~9.0 and ~0.98 cm^3/g @STP for the polyethylene, nylon, or Teflon bagging and/or polyethylene bottles, and silicone rubber pads, respectively, were taken from the curves for the offgassing volume per unit mass as documented in Y/DZ-2585. The data showed that the Teflon FEP material offgassing volume per unit mass (V_{tf}) was conservatively assumed to be 0.25 cm^3/g@STP (Y/DZ-2720). These values are used to determine the offgassing volume as shown below:

$V_{po} = W_p \times 0.98 / 16.387\ (in.^3)$ (offgassing volume of silicone rubber pads)

$V_{bo} = W_b \times 9.0 / 16.387\ (in.^3)$ (offgassing volume of polyethylene, nylon, or Teflon bags, polyethylene bottles, and lifting sling)

$V_{tf} = W_{tf} \times 0.25 / 16.387\ (in.^3)$ (offgassing bottles of Teflon FEP bottles)

From the ideal gas law, the number of gas moles in the volume is as follows:

$$n_i = \frac{P_v \times V_i}{R_u \times T_{amb} \times 12}.$$

A summary of the results obtained using the above equations for CVAs 1, 7, and 11 is presented in Tables 3, 4, and 5.

Table 3. Molar quantity of gas generated due to the silicone rubber pad offgassing [a]

CVA	W_p (g)	V_{po} ($in.^3$)	P_V (psia)	R_u (ft-lb/lb-mol·R)	T_{amb} (R)	n_{po} (lb-mol)
1	186.74	11.17	14.7	1545.32	537	1.6486E-05
7	0.00	0.00	14.7	1545.32	537	0.0000E+00
11	186.74	11.17	14.7	1545.32	537	1.6486E-05

[a] Silicone rubber pad weight determined from Table 2.8.

Table 4. Molar quantity of gas generated due to polyethylene, nylon, or Teflon bag, sling, and/or polyethylene bottle offgassing

CVA	W_b (g)	V_{bo} (in.^{3})	P_V (psia)	R_u (ft-lb/lb-mol·R)	T_{amb} (R)	n_{bo} (lb-mol)
1	500.00	274.61	14.7	1545.32	537	4.0537E-04
7	500.00	274.61	14.7	1545.32	537	4.0537E-04
11	500.00	274.61	14.7	1545.32	537	4.0537E-04

Table 5. Molar quantity of gas generated due to the Teflon FEP bottle offgassing

CVA	W_{tf} (g)	V_{tf} (in.^{3})	P_V (psia)	R_u (ft-lb/lb-mol·R)	T_{amb} (R)	n_{tf} (lb-mol)
7	990.00	15.10	14.7	1545.32	537	2.2296E-05

III. Gas generation due to radiolysis of water

Buildup of hydrogen gas (H_2) and oxygen gas (O_2) in the ES-3100 containment vessel due to radiolysis is incorporated into the pressure calculation by assuming that 5 mol % of the free volume is hydrogen gas. Since each mole of H_2 generated is accompanied by 0.5 mol of O_2, the concentration of H_2 will reach 5 mol % when volume of H_2 is 0.05405 times the initial void volume (see Sect. 3.5.4.8 of Appendix 3.5.4). Using the ideal gas law, the number of gas moles of hydrogen in the volume at standard temperature and pressure is:

$$n_r = \frac{P_v \times V_r}{R_u \times T_{amb} \times 12},$$

where

n_r = individual molar quantity for hydrogen and oxygen gas,
V_r = volume of gas assumed generated by radiolysis.

A summary of the results for hydrogen and oxygen generation due to radiolysis using the above equation is presented in Table 6.

Table 6. Molar quantity of oxygen and hydrogen gas generation due to radiolysis

CVA	V_v (in.^{3})	V_h (in.^{3})	P_v (psia)	R_u (ft-lb/lb-mol·R)	T_{amb} (R)	n_{r-H2} (lb-mol)	n_{r-O2} (lb-mol)
1	448.20	24.23	14.7	1545.32	537.0	3.5761E-05	1.7881E-05
7	306.52	16.57	14.7	1545.32	537.0	2.4457E-05	1.2228E-05
11	42.779	2.31	14.7	1545.32	537.0	3.4133E-06	1.7066E-06

IV. Molar quantity of gas generated due to the efflorescence nature of the uranyl nitrate crystals

The UNX crystals in any hydrated state will decompose and lose water molecules at the average gas temperature shown in Sect. 3.4.3 [167.39°F (333.31°C)]. The partial pressure of water vapor in this mixture is conservatively estimated to be the saturated vapor pressure (P_{sv}) of water at 333.31°F or 107.94 psia. Using the ideal gas law, the molar quantity of water vapor (n_v) in this volume at the maximum containment vessel temperature and the saturated vapor pressure is:

$$\begin{aligned} n_v &= (P_{sv} \times V_v) / (R_u \times T_{cv} \times 12); \\ &= (107.94)(306.52) / (1545.32 \times 12 \times 793.31); \\ &= 2.2490 \times 10^{-3} \text{ lb-mol}; \end{aligned}$$

where

n_v = individual molar quantity for water vapor;
V_v = void volume of containment vessel;
T_{cv} = average gas temperature inside the containment vessel = 460 + 333.31 R; and
P_{sv} = interpolated saturated vapor pressure of water at temperature from *Fundamental of Classical Thermodynamic* (Van Wylen), Table A.1.1, p. 650.

V. Total pressure due to offgassing and HAC temperatures inside the containment vessel with efflorescence of uranyl nitrate crystals

The total pressure of the mixture at 167.39°C (333.31°F), P_T, for each CVA is the sum of each of the previously calculated molar quantities. Table 7 summarizes the molar constituents and total pressure of each CVA. The following equation is used to calculate the final containment vessel pressure:

$$P_{167.39°C} = (\sum n_i \times R \times T \times 12) / V_{GMV},$$

where

n_i = individual molar quantity for each gas,

T = average gas temperature,
= 167.39°C (333.31°F),

V_{GMV} = V_v,
= gas mixture volume.

Table 7. Total pressure inside the containment vessel at 167.39°C (333.31°F) with efflorescence

CVA [a]	n_{MNOP} [b] (lb-mol)	n_{po} [b] (lb-mol)	n_{bo} [b] (lb-mol)	n_{tf} [b] (lb-mol)	n_{r-H2} [b] (lb-mol)	n_{r-O2} [b] (lb-mol)	n_{CE-WV} [b, c] (lb-mol)	n_T [b] (lb-mol)	P_T (psia)
1	8.7016E-04	1.6486E-05	4.0537E-04	0.0000E+00	3.5761E-05	1.7881E-05	0.0000E+00	1.3457E-03	44.168
7	9.3193E-04	0.0000E+00	4.0537E-04	2.2296E-05	2.4457E-05	1.2228E-05	2.2490E-03	3.6453E-03	174.950
11	8.3054E-05	1.6487E-05	4.0537E-04	0.0000E+00	3.4133E-06	1.7067E-06	0.0000E+00	5.1003E-04	174.949

[a] This assumes that the internal convenience cans, polyethylene or Teflon FEP bottles, and Cat 277-4 spacer cans are not sealed.

[b] n_{MNOP}—molar quantity of the gas mixture at maximum normal operating pressure at standard temperature [25°C (77°F)];
n_{po}—molar quantity of gas due to offgassing of the silicone rubber pads;
n_{bo}—molar quantity of gas due to offgassing of the polyethylene, nylon, or Teflon bags, polyethylene bottles, and lifting sling;
n_{tf}—molar quantity of gas due to offgassing of the Teflon bottles;
n_{r-H2}—molar quantity of hydrogen gas due to radiolysis of water;
n_{r-O2}—molar quantity of oxygen gas due to radiolysis of water;
n_{CE-WV}—molar quantity of water vapor due to efflorescence of UNX crystals; and
n_T—total molar quantity in the gas mixture.

[c] Efflorescence of UNX crystals as water vapor.

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Appendix 3.5.3
Silicone Rubber Thermal Properties from Therm 1.2 Database

The thermal properties for silicone rubber used in the thermal analyses of the ES-3100 shipping container were obtained from the Therm 1.2 Thermal Properties Database by R. A. Bailey. Since Therm 1.2 is not a publicly available program, screen captures from Therm 1.2 of the data for silicone rubber are presented in Figs. 1 and 2 in English and SI units, respectively.

```
                  silicone rubber, medium k (see ref 5)
         ------------------------------------------------------------
         Density                              .04696548   lb/in**3
         Specific Heat                        .3          Btu/lb°F
         Conductivity                         .01612725   Btu/hr in°F
         Maximum Material Temp             545.0          °F
         silicone rubber, medium k (see ref 5)
         ------------------------------------------------------------
References:
    fleming p           private collection of plastics data           1968
                        materials engr  matl selector issue           1967
                        metals handbook  8th ed                       1961
    moyer j             private collection of thermal data            1968
Material properties quality
    Density                 -  Good data, or no way of estimating quality.
    Specific Heat           -  Poor or conflicting data.  Used best or average.
    Conductivity            -  Poor or conflicting data.  Used best or average.
    Transition Temperature  -  Good data, or no way of estimating quality.
    Latent Heat             -  No data.  Made no estimate.
    Specific Heat Tables    -  No data.  Made no estimate.
    Conductivity Tables     -  No data.  Made no estimate.
```

Fig. 1. Silicone rubber thermal properties from Therm 1.2 (English units).

```
         silicone rubber, medium k (see ref 5)
         ------------------------------------------------------------
         Density                          1300.0          kg/m**3
         Specific Heat                    1255.2          J/kg°K
         Conductivity                         .33472      J/sec m°K
         Maximum Material Temp             558.15         °K
         silicone rubber, medium k (see ref 5)
         ------------------------------------------------------------
References:
    fleming p           private collection of plastics data           1968
                        materials engr  matl selector issue           1967
                        metals handbook  8th ed                       1961
    moyer j             private collection of thermal data            1968
Material properties quality
    Density                 -  Good data, or no way of estimating quality.
    Specific Heat           -  Poor or conflicting data.  Used best or average.
    Conductivity            -  Poor or conflicting data.  Used best or average.
    Transition Temperature  -  Good data, or no way of estimating quality.
    Latent Heat             -  No data.  Made no estimate.
    Specific Heat Tables    -  No data.  Made no estimate.
    Conductivity Tables     -  No data.  Made no estimate.
```

Fig. 2. Silicone rubber thermal properties from Therm 1.2 (SI units).

Appendix 3.5.4
Estimates of Hydrogen Buildup in the ES-3100 Package Containing Highly Enriched Uranium

3.5.4.0 Summary

Table 3.5.4.1 below indicates that the ES-3100 package with Containment Vessel Arrangement 1 (CVA 1, see Appendix 3.5.1) and a 15.13-kg load of uranium oxide with 3 wt % water, will generate 5 mol % of hydrogen in the void space of the containment vessel in ~1.44 years (17 months). With CVA 7, a load of 4.75 kg of uranyl nitrate hexahydrate crystals [$UO_2(NO_3)_2 \cdot XH_2O$, X = 6, 21.6 wt % water] or a load of 6.70 kg of uranyl nitrate trihydrate crystals (X=3, 12.1 wt % water) will generate 5 mol % of hydrogen in ~1.16 years (14 months). With CVA 7, a load of 9.17 kg of hexahydrate crystals will generate 5 mol % in ~0.45 years (5.3 months) while a load of 11.90 kg of trihydrate crystals will generate 5 mol % in ~0.46 years (5.5 months).

Table 3.5.4.1 Summary of load weights and shipment durations

Weight (kg)	Water		Time to 5 mol % hydrogen (y/month) [c]
	X	wt %	
Oxides [CVA 1] [a]			
15.13	UO_2	3.0	1.47/17.6
15.13	U_3O_8	3.0	1.46/17.5
15.13	UO_3	3.0	1.44/17.3
$UO_2(NO_3)_2 \cdot XH_2O$ [CVA 7] [b]			
4.75	6	21.64	1.16/13.9
6.70	3	12.13	1.17/14.0
9.17	6	21.64	0.445/5.3
11.90	3	12.13	0.463/5.5

[a] CVA 1 consists of six steel cans (see Sect. 3.1.4.1).
[b] CVA 7 consists of three Teflon bottles (see Sect. 3.1.4.1).
[c] The values have been rounded down for conservatism.

3.5.4.1 Introduction

There is a concern that hydrogen gas (H_2) could build up to dangerous levels in the ES-3100 package. Consequently, it is necessary to estimate the combination of shipping weight and transit time that limits the H_2 concentration in the package to 5 mol % (established as a limit for the purposes of this analysis). The H_2 can be generated by radiolysis and/or chemical reaction involving any material containing hydrogen. Of the anticipated materials to be shipped, the only chemical reaction would be metal reacting with water (or water vapor) to form H_2 and a metal oxide. It will be shown that radiolysis of water is the major source of H_2 for uranium oxides and uranyl nitrate crystals.

The materials that may be shipped in the ES-3100 include highly enriched uranium (HEU) in the form of uranium oxide (UO_3, U_3O_8, and UO_2) and uranyl nitrate crystals [UNX or $UO_2(NO_3)_2 \cdot XH_2O$]. The water associated with oxides ranges from 0 to 3 wt % (Sect. 1.2.2). The water in UNX ranges from X = 0 to X = 6 (0 to 21.6 wt %). The molecular weights of uranyl nitrate [$UO_2(NO_3)_2$] and H_2O are 391 and 18 g/mol, respectively, so the fraction of water in UN6 is $6 \times 18 / (391 + 6 \times 18) = 0.216$. There is no liquid water (sorbed or interstitial) associated with any of the other contents. However, the air in the void

spaces of the package contains water vapor (humidity). It will be shown that the maximum amount of H_2 from humidity is below 5 mol %.

3.5.4.2 Initial hydrogen in convenience containers

It was suggested that convenience containers stored for a long period of time could accumulate significant amounts of H_2 in the containers before being placed in the ES-3100. The convenience containers are Teflon bottles for UNX, and cans or polyethylene bottles for other materials. An estimate of the accumulated H_2 is given in this section.

The ES-3100 has several containment vessel arrangements (CVAs, see Appendix 3.5.1, Table 1) for the convenience containers. CVA 7 consists of three Teflon bottles and is the only arrangement for UNX. CVAs 5 (nickel alloy cans) and 6 (polyethylene bottles) can only be used for oxides while the remaining CVAs (steel cans) may be used for oxides or metal. The bounding arrangement for oxides is CVA 1 (6 steel cans) because it has the smallest free volume [574.66 in.^{3} (Appendix 3.5.1, Table 1)].

The H_2 generated in a container can leak out through tiny spaces in imperfect lids and by permeation or diffusion through the walls of the container. The largest leaks are through the lids but these are difficult to characterize. Consequently, this calculation conservatively considers only permeation and diffusion through the cylindrical surfaces. Because permeation is usually a faster mechanism than diffusion and is more likely with plastics, the permeation model was used for the Teflon bottles. Since metals are not very permeable, the diffusion model was used for the cans.

The rate of gas loss through permeation is based on an equation in *Perry's Chemical Engineers' Handbook* (p. 6-39, Eq. 6-170). The resulting expression is

$$d(n_P) / dt = -P_T \times \Delta P \times A_T / \tau_T \times \rho_G \times (1 + \Delta P / P_0),$$

where

n_P = the amount of gas in the three Teflon bottles, mol;
t = time, y;
P_T = the permeability of H_2 through Teflon, $cm^2/y \cdot Pa$;
ΔP = the pressure increase over the initial value, Pa;
A_T = the cylindrical area of three Teflon bottles (each is 4.69-in. diam × 9.4-in. tall) 2682.8 cm^2 (Y/HDPO/03-43);
τ_T = the thickness of each bottle, 0.13 cm (Y/HDPO/03-43);
ρ_G = the molar density of an ideal gas at 25°C and 1 atm, 4.087×10^{-5} mol/cm^3;
P_0 = the initial pressure in the bottles, 101,325 Pa (1 atm); and

$1 + \Delta P / P_0$ corrects the gas density for the pressure increase.

The permeability of H_2 through Teflon at 25°C is 3.12×10^{-5} $cm^2/y \cdot Pa$, which is equivalent to 9.89×10^{-8} $cm^2/s \cdot Bar$ (*Parker O-Ring Handbook*, Table 3-24, p.3-30).

At steady state, the permeation rate is balanced by the gas generation rate.

$$1.5 \times d(n_{H2}) / dt = P_T \times \Delta P \times A_T / \tau_T \times \rho_G \times (1 + \Delta P / P_0),$$

$$\rightarrow \Delta P \times (1 + \Delta P / P_0) = [1.5 \times d(n_{H2}) / dt] / [P_T \times A_T / \tau_T \times \rho_G],$$

where

$d(n_{H2}) / dt$ = the H_2 generation rate, 0.01379 mol/y for 4750 g of $UO_2(NO_3)_2 \cdot 6H_2O$ (see Sect. 3.5.4.7);
1.5 = a factor to account for the oxygen released with the hydrogen.

As an example for 4750 g of $UO_2(NO_3)_2 \cdot 6H_2O$, the above expression for ΔP with the above parameters is $\Delta P = \{[1.5 \times 0.01379 \text{ mol/y}] / [3.12 \times 10^{-5} \text{ cm}^2/\text{y} \cdot \text{Pa} \times (2682.8 \text{ cm}^2 / 0.13 \text{ cm}) \times 4.087 \times 10^{-5} \text{ mol/cm}^3]\} / (1 + \Delta P / 101{,}325 \text{ Pa})$. $\Delta P = 779.5$ Pa satisfies the above expression.

The steady-state mole fraction and H_2 amount are

$$f_{H2B} = (2 / 3) \times \Delta P / (P_0 + \Delta P),$$
$$n_{H2B} = f_{H2B} \times V_B \times \rho_G \times (1 + \Delta P / P_0) = V_B \times \rho_G \times (2 / 3) \times \Delta P / P_0,$$
$$V_B = 6840 - Wt_{UNX} / \rho_{UN6},$$

where

f_{H2B} = the mole fraction of H_2 in the bottles;
n_{H2B} = the amount of H_2 in the three bottles, mol;
2 / 3 = a factor to account for the fact that 1 / 3 of the pressure increase is due to oxygen;
V_B = the free volume of the 3 bottles, cm^3 [5149.6 cm^3 for 4750 g of $UO_2(NO_3)_2 \cdot 6H_2O$];
6840 = the empty void volume of three Teflon bottles, 6840 cm^3 (Y/HDPO/03-43);
Wt_{UNX} = the total weight of UNX in the containers, g;
ρ_{UN6} = the theoretical density of UN6 and, lacking data for other UNX hydrates, is also applied to all the hydrates, 2.81 g/cm^3 (CRC Handbook, p. 4-94).

For the example of 4750 g of $UO_2(NO_3)_2 \cdot 6H_2O$, the above equation becomes

$$n_{H2B} = 5149.6 \text{ cm}^3 \times 4.087 \times 10^{-5} \text{ mol/cm}^3 \times (2 / 3) \times 779.5 \text{ Pa} / 101{,}325 \text{ Pa},$$
$$= 0.001079 \text{ mol.}$$

The rate of H_2 loss through diffusion is based on an equation in *Perry's Chemical Engineers' Handbook* (p. 5-47, Eq. 5-189). The resulting expression is

$$d(n_{H2C}) / dt = -D \times \Delta C \times A_D / \tau_D,$$

where

n_{H2C} = the amount of H_2 in the 6 cans, mol;
$d(n_{H2C}) / dt$ = the rate of H_2 lost through diffusion from the 6 cans, mol/y;
D = the diffusivity, cm^2/y;
ΔC = the H_2 concentration increase over the initial value, mol/cm^3;
A_D = the cylindrical area of six steel cans, (each is 4.25-in. diam × 4.88-in. tall, see Sect. 1, Fig. 1.4), 2522.2 cm^2;
τ_D = the thickness of the can (assumed to be 0.012 in.), 0.0305 cm.

At steady state, the diffusion rate is balanced by the H_2 generation rate.

$$d(n_{H2}) / dt = D \times \Delta C \times A_D / \tau_D \rightarrow \Delta C$$
$$= [d(n_{H2}) / dt] / [D \times A_D / \tau_D]$$

The steady-state H_2 amount and mole fraction are

$$n_{H2C} = V_C \times \Delta C,$$
$$f_{H2C} = (V_C \times \Delta C) / (V_C \times \rho_G) = \Delta C / \rho_G,$$
$$V_C = V_0 - Wt_{OX} / \rho_{OX},$$

where

f_{H2C} = the mole fraction of H_2 in the cans;
V_C = the free volume in 6 cans, cm^3 (5001.3 cm^3 for 15,130 g of U_3O_8);
V_0 = the free volume of the 6 empty cans, 6806.8 cm^3;
Wt_{OX} = the total weight of uranium oxides in the containers, g;
ρ_{OX} = the theoretical density of uranium oxides, 7.3 g/cm^3 for UO_3, 8.38 for U_3O_8, and 10.97 for UO_2 (CRC Handbook, p. 4-94).

H_2 diffusion is discussed at http://www1.eere.energy.gov/hydrogenandfuelcells/pdfs/03_babu_transfer.pdf, p. 42 (Sudarsanam 2005). There is a wide range of values for diffusivity at room temperatures and a suggested value of ~5×10^{-7} cm^2/s (15.8 cm^2/y) is probably a low number for plain steel without welds or rough surfaces. This is the value used for calculating the diffusion loss rate of H_2 from the cans.

For 15,130 g of U_3O_8, the value of $d(n_{H2}) / dt$ is 0.01185 mol/y (see Sect. 3.5.4.7). ΔC = 0.01185 mol/y / [15.8 cm^2/y × 2522.2 cm^2 / 0.0305 cm] = 9.078E-09 mol/cm^3. The amount of H_2 in the 6 cans is n_{H2C} = 5001.3 cm^3 × 9.078E-09 mol/cm^3 = 4.540E-05 mol.

The above analysis assumed the material to be shipped is distributed equally to the maximum number of convenience containers for the specified CVAs (3 bottles for CVA 7 and 6 cans for CVA 1). If the material can be packed into fewer convenience containers, the amount of initial H_2 would be less. The expressions for C and n_{H2C} indicate that n_{H2C} is proportional to $V_C / A_D = (V_0 - Wt_{OX} / \rho_{OX}) / A_D$. If the empty volume and surface area of a single can is v and a, respectively, the above proportionality becomes $(Nc \times v - Wt_{OX} / \rho_{OX}) / (Nc \times a) = v / a - Wt_{OX} / (Nc \times a \times \rho_{OX})$ where Nc is the number of cans (1 to 6). As Nc increases, $Wt_{OX} / (Nc \times a \times \rho_{OX})$ decreases so that less is subtracted from v / a. The result is increasing n_{H2C}.

3.5.4.3 Hydrogen generation by chemical reaction with water

Metals can combine with the oxygen in water to release H_2. The only source of water for metals is the humidity of the air in the void spaces of the package. The air is assumed to be at 25°C, 1 atm (101.325 kPa) and 100% relative humidity. The vapor pressure of water at 25°C is 3.1690 kPa (CRC Handbook, p. 6-8), so the initial concentration of water vapor is 3.1690 / 101.325 = 0.031 mol fraction. Since 1 mol of water vapor produces 1 mol of H_2 and the oxygen is bound up as solid metal oxides, this reaction does not change the total gas pressure. Therefore, if all the water vapor reacts with the metal, the maximum concentration of H_2 is also 0.031 mol fraction, which is below the 5 mol % limit.

3.5.4.4 Radiation energy calculations

The radiation energy that drives radiolysis can be estimated from the decay rate and maximum decay energy of each radionuclide that makes up the HEU compounds (oxides and crystals). The bounding information to calculate these terms and the results are given in Table 3.5.4.2. It should be noted that the transuranic concentration can be much higher for HEU metal. As shown in Chap. 1, some Thorium (^{232}Th) compounds or oxides mixed with uranium are proposed for transport. Shipping of ^{232}Th is bounded by the analysis using uranium for the hydrogen gas generation due to the following: (1) the A_2 value of ^{232}Th is unlimited; (2) the decay energy of ^{232}Th is less than all other uranium isotopes; and (3) the half-life of ^{232}Th is significantly longer than the uranium isotopes. Therefore, the radiation energy is less for ^{232}Th compounds or oxides.

Table 3.5.4.2. Radiation energy calculations

Nuclide	$Wt\%_n$ [a]	MW_n [b] (g/mol)	T_{Hn} [b] (y)	α_{Mn} [b] (MeV)	D_{Rn} [c] [atms/(g y)]	Nuclide contr [c] [MeV/(gU y)]
^{232}U	4.00E-06	232.0371	6.89E+01	5.414	2.61E+19	5.65E+12
^{233}U	6.00E-01	233.0396	1.59E+05	4.909	1.13E+16	3.32E+14
^{234}U	2.00E+00	234.0409	2.45E+05	4.856	7.28E+15	7.07E+14
^{235}U	5.49E+01	235.0439	7.04E+08	4.679	2.52E+12	6.48E+12
^{236}U	4.00E+01	236.0456	2.34E+07	4.569	7.56E+13	1.38E+14
^{238}U	0.00E+00	238.0508	4.46E+09	4.185	3.93E+11	0.00E+00
Transur	4.00E-03			5.476 [d]	4.73E+17	1.04E+14
^{237}Np	2.50E+00	237.0482	2.14E+06	4.957	8.23E+14	1.02E+14
Total	1.00E+02					1.395E+15

[a] Wt % from Appendix 4.5.1 (Table 1). Maximum transuranic for compounds is 40 µg/gU and 0.60 MBq/gU activity.
[b] MW is molecular weight; T_H is half life; and α is the maximum energy emitted (*CRC Handbook of Chemistry and Physics*, pp. 11-140 and 11-141).
[c] D_R is decay rate, and Nuclide Contr is the contribution of each nuclide to the total rate of decay energy.
[d] Transuranic α assumed to be equal to ^{246}Cm.

The decay rate per gram of the n^{th} radionuclide is

$$D_{Rn} = [\ln(2) / T_{Hn}] \times A_N / MW_n;$$
$$= \text{the decay rate of the } n^{th} \text{ radionuclide, atoms/y;}$$

T_{Hn} = half life of the n^{th} radionuclide, y;
A_N = Avogadro's number, 6.022×10^{23} molecules/mol;
MW_n = the molecular (atomic) weight of the n^{th} radionuclide, g/mol.

All the radionuclides in Table 3.5.4.2 are primarily α emitters, and the total rate of radiation dose is given as

$$D_E = \sum_{n=1}^{N} \frac{Wt\%_n \times D_{Rn} \times \alpha_{Mn}}{100},$$

where

D_E = the total rate of decay energy per gram of uranium, Mev/(gU y);
$Wt\%_n$ = the weight percent of the n^{th} radionuclide in the uranium;
α_{Mn} = the α energy emitted in the decay of the n^{th} radionuclide, MeV; and
N = the total number of radionuclides.

The above calculation of D_E for HEU is 1.395×10^{15} MeV/(gU y).

3.5.4.5 Hydrogen generation by radiolysis of polyethylene

Almost all the radiation energy from HEU is due to alpha particles with energies of 4–5 MeV (Table 3.5.4.2). These particles are not very penetrating and will only deposit their energy into materials that are in intimate contact with the uranium atoms (i.e., the water of hydration in uranyl nitrate crystals and the water associated with the oxides). The polyethylene, nylon, or Teflon is in the form of bottles and

bags that surround the uranium and the only alpha particles that reach the polyethylene, nylon, or Teflon come from the outer range of alpha particle penetration within the HEU.

Equations 1.9 and 1.10 on p. 9 in *Handbook of Radioactivity Analysis* approximate the range of alpha particle penetration in air, and other materials for α energy in the range of 4 to 7 MeV. These are combined to give the following expression for calculating the range in HEU (metal, oxide, or crystals).

$$R = 9.6 \times 10^{-7} \times \alpha_{MA}^{3/2} \times (MW_A)^{1/2} / \rho,$$

where

R = the range of alpha particle penetration in the HEU, m;
α_{MA} = the average α energy emitted by the HEU, ~4.9 MeV (Table 3.5.4.2);
MW_A = the average molecular weight of the HEU, ~235.5 g/mol (Table 3.5.4.2); and
ρ = the density of the HEU, g/cm^3.

The range increases with decreasing ρ, and the smallest value for ρ is ~1.5 g/cm^3. {The smallest approximate bulk density of HEU oxide, *Cost-Effectiveness of Utilizing Surplus Depleted Uranium (DU)*, [WM-4009]}. The resulting range is 1.07×10^{-4} m.

The radius of a polyethylene bottle is 0.0627 m [4.94-in. diam (Table 2.10), configuration designated as CVA 6]. If the HEU oxide fills the bottle, the alpha particles generated in the outer range come from the HEU between 0.0627 and $(0.0627 - 1.07 \times 10^{-4}$ m). For an infinite cylinder, the fraction of the total radiation within this range is $[(0.0627)^2 - (0.0627 - 1.07 \times 10^{-4})^2] / (0.0627)^2 = 0.00339$. Half of this radiation would be directed toward the center of the cylinder, and much of the outward-directed portion would be absorbed passing through the HEU. Consequently, the radiation absorbed by the polyethylene would be much less than 1% of that absorbed by the water, and the H_2 generated in the polyethylene would be correspondingly less than that generated in the water.

3.5.4.6 Hydrogen generation by radiolysis of water

Assuming an infinite amount of water is available, the radiolytic hydrogen generation rate is given by the following expression (based on NUREG/CR-6673, p. 31, Eq. 4.7):

$$d(n_{H2}) / dt = (D_H / 100) \times [G(H_2) / A_N],$$

where

n_{H2} = the amount of hydrogen generated, mol;
t = time, y;
D_H = the decay energy absorbed by the water, eV/y; and
$G(H_2)$ = a radiolytic hydrogen generation factor for alpha radiation in water, molecules H_2/100 eV absorbed by water.

3.5.4.7 Radiolytic hydrogen generation factors for alpha radiation in water

A bounding value for $G(H_2)$ with alpha radiation is 1.6 molecules H_2/100 eV absorbed by water (NUREG/CR-6673, p. 12, Table 3.1). However, 2003 experimental data from Oak Ridge National Laboratory suggest lower $G(H_2)$ values [*Alpha Radiolysis of Sorbed Water on Uranium Oxides and Uranium Oxyfluorides* (ORNL/TM-2003/172) and *Water Sorption and Radiolysis Studies for Neptunium Oxides* (ORNL/TM-2003/194)]. Table 3.5.4.3 lists the $G(H_2)$ values derived from these experiments. The largest of the ORNL values (1.02) is used for the hydrogen generation calculations.

Table 3.5.4.3. $G(H_2)$ values derived from alpha radiolysis experiments

Sample description	$e^-(H_2O)$	e^-(rem)	f_{H2O}	Gf	molecules/100 eV		
					G'(gas) [a]	G'(H_2)	G(H_2)
Icenhour and Toth, ORNL/TM-2003/172, 2003							
Fig. 3.3. Samp A-2-2, UO_3, 10% H_2O, 350°C	0.0556	0.3689	0.1000	0.1309	0.1507	0.1005	0.77
Fig. 3.5. Samp A-4-1 U_3O_8, 2% H_2O, 650°C	0.0111	0.4000	0.0200	0.0270	0.0113	0.0075	0.28
Icenhour et al., ORNL/TM-2003/194, 2004							
Fig. 4.12. Samp Al 3, NpO_2, 8% H_2O, 650°C	0.0444	0.3728	0.0800	0.1065	0.1100	0.0733	0.69
Fig. 4.11. Samp Al 2, NpO_2, 1% H_2O, 650°C	0.0056	0.4012	0.0100	0.0137	0.0210	0.0140	1.02
Fig. 4.13. Samp Al 4, NpO_2, 1% H_2O, 800°C	0.0056	0.4012	0.0100	0.0137	0.0060	0.0040	0.29
Fig. 4.14. Samp Al 5, NpO_2, 0.5% H_2O, 650°C	0.0028	0.4032	0.0050	0.0068	0.0043	0.0029	0.42

[a] G'(gas) for ORNL/TM-2003/172 is based on a measured slope in Fig. 3.3 or 3.5. For ORNL/TM-2003/194, the values are listed on Figs. 4.11–4.14.

The G'(gas) value is the initial slope of the gas yield (mmol/g material) versus the decay energy (MGy) converted to units of molecules of gas per 100 eV. G'(gas) for ORNL/TM-2003/172 is based on a measured slope in Fig. 3.3 or 3.5 while the values for ORNL/TM-2003/194 are listed on Figs. 4.11 through 4.14. Figure 3.5.4.1 is from ORNL/TM-2003/172 (p. 9, Fig. 3.5) with lines added to outline the initial slope and facilitate reading values. From Fig. 3.5.4.1, the gas yield difference along the slope is $0.023 - (-0.0005) = 0.0235$ millimol/g or $0.0235 \times A_N / 1000 = 1.42 \times 10^{19}$ molecules/g. The decay energy difference along the slope is 20.0 MGy or $20.0 \times 6.24 \times 10^{21} = 1.25 \times 10^{23}$ eV (6.24×10^{21} eV/g = 1 MGy). Therefore, G'(gas) is $1.42 \times 10^{19} / 1.25 \times 10^{23}) \times 100 = 0.0113$ molecules gas/100 eV. It is assumed the gas is due to the decomposition of H_2O and has a molar composition of 2/3 H_2 and 1/3 oxygen (O_2). The derived G'(H_2) is 2/3 of the G'(gas) value or 0.00756 molecules H_2/100 eV decay energy.

The radiation calculated in Table 3.5.4.2 is the decay energy rather than the energy absorbed by the water associated with the material. The energy absorbed by the associated water, D_H, is approximately equal to the decay energy, D_E, multiplied by the fraction of electrons associated with the water or

$$Gf = e^-(H_2O) / e^-(mat),$$

where

$$e^-(mat) = \sum_{i=1}^{I} e^-(mat_i);$$

Gf = the fraction of electrons associated with the water;
$e^-(H_2O)$ = the number of electrons associated with the water, electrons/molecule;
e^-(mat) = the total number of electrons associated with the molecular species; electrons/molecule;
$e^-(mat_i)$ = the contribution of the i^{th} molecular species to e^-(mat); and
I = the total number of molecular species.

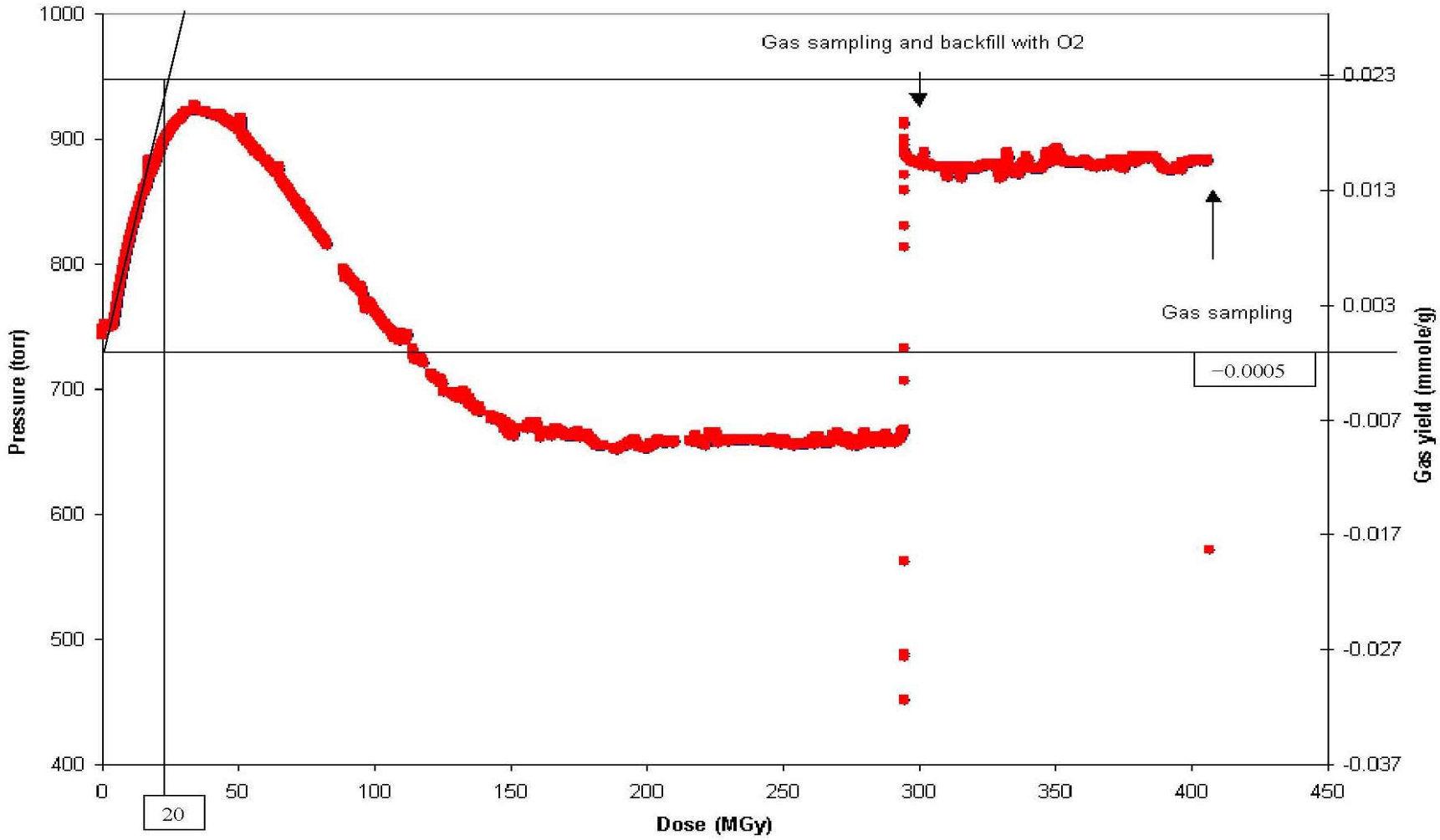


Fig. 3.5.4.1. Pressure and gas yield as a function of dose.

Note: Based on Fig. 3.5 in *Alpha Radiolysis of Sorbed Water on Uranium Oxides and Uranium Oxyfluorides* (ORNL/TM-2003/172), Sample A-4-1 (5.64 g U_3O_8 with 2 wt % H_2O, spiked with 0.0249 g ^{244}Cm).

The energy absorbed by the water is

$$D_H = Gf \times D_E,$$

and

$$G'(H_2) = Gf \times G(H_2) \rightarrow G(H_2) = G'(H_2) / Gf.$$

Two methods to calculate Gf are reported in *Calculation of Hydrogen Generation Rates for Storage of Post-KIS Oxide in 9975 Shipping Containers* (Calculation No. N-CLC-K-00219, p. 9 and 10). In the more rigorous of the two methods, Gf is estimated from the material stoichiometry and molecular weights. Using this more rigorous method, $e^-(mat_i)$ is calculated as

$$e^-(mat_i) = f_i \times \sum_{i=1}^{J} \frac{n_{i,j} \times Z_{i,j}}{MW_i},$$

where

f_i = the weight fraction of the i^{th} molecular species,
MW_i = the molecular weight of the i^{th} species,
$n_{i,j}$ = the number of moles of the j^{th} element in the i^{th} species,
J = the total number of elements in the i^{th} species, and
$Z_{i,j}$ = the atomic number of the j^{th} element in the i^{th} species.

According to the preceding equation, the expression for the number of electrons associated with the water is

$$e^-(H_2O) = f_{H2O} \times 10 / (16 + 2) = f_{H2O} \times 0.5556.$$

A mixture of water and U_3O_8 (assuming all the uranium is ^{235}U) is

$$e^-(mat) = f_{H2O} \times 0.5556 + f_{U3O8} \times (3 \times 92 + 8 \times 8) / (3 \times 235 + 8 \times 16) = f_{H2O} \times 0.5556 + f_{U3O8} \times 0.4082$$

where

f_{H2O} = the weight fraction of water and

f_{U3O8} = the weight fraction of U_3O_8
= $1 - f_{H2O}$ if no other material is present.

A $G'(H_2)$ value of 0.00756 molecules H_2/100 eV decay energy is derived from the experiment by Icenhour and Toth with a U_3O_8 sample (5.64 g) containing 2% water and spiked with 0.0249 g ^{244}Cm (ORNL/TM-2003/172, p. 7, Table 3.1). The mass of ^{244}Cm can be neglected, so the calculation of $G(H_2)$ for this sample is $e^-(H_2O) = 0.02 \times 0.5556 = 0.0111$; $e^-(mat) = 0.0111 + 0.98 \times 0.4082 = 0.4111$; $Gf = 0.0111 / 0.4111 = 0.0270$; and $G(H_2) = 0.00756 / 0.0270 = 0.280$ molecules H_2/100 eV absorbed by the water. Since the largest of the ORNL values (1.02) is used for the hydrogen generation calculations, the $G'(H_2)$ value for any other water content is the corresponding value of $Gf \times 1.02$.

To calculate Gf for $UO_2(NO_3)_2 \cdot XH_2O$, the two components are $UO_2(NO_3)_2$ and H_2O, where f_{H2O} is

$$f_{H2O} = X \times (2 + 16) / [235 + 2 \times 16 + 2 \times (14 + 3 \times 16) + X \times (2 + 16)],$$
$$= 1 / [1 + 391 / (X \times 18)],$$

$$e^-(mat) = f_{H2O} \times 0.5556 + f_{UN2O8} \times (92 + 8 \times 8 + 2 \times 7) / (391),$$
$$= f_{H2O} \times 0.5556 + f_{UN2O8} \times 0.4348,$$

f_{UN2O8} = the weight fraction of $UO_2(NO_3)_2 = 1 - f_{H2O}$.

The following example calculations are for U_3O_8 with 3% H_2O and $UO_2(NO_3)_2 \cdot XH_2O$ with X = 6 (f_{H2O} = 0.2164, Sect. 3.5.4.1). The $e^-(H_2O)$ and e^-(mat) values for the U_3O_8 are 0.0300 × 0.5556 = 0.0167 and 0.0167 + 0.9700 × 0.4082 = 0.4126, respectively. The resulting Gf and G'(H_2) values for the U_3O_8 are 0.0167 / 0.4126 = 0.0404 and 0.0404 × 1.02 = 0.0412, respectively. The corresponding values for $UO_2(NO_3)_2 \cdot 6H_2O$ are $e^-(H_2O)$ = 0.2164 × 0.5556 = 0.1202, e^-(mat) = 0.1202 + 0.7836 × 0.4348 = 0.4609, Gf = 0.1202 / 0.4609 = 0.2608, and G'(H_2) = 0.2608 × 1.02 = 0.2661.

The equation for the H_2 generation rate ($d(n_{H2})/dt$, mol H_2/y) is given in Sect. 3.5.4.6. The emitted radiation rate is 1.395×10^{21} eV/[GU Y] (1.395E+15 MeV/[gU y], Table 3.5.4.2). The uranium content of U_3O_8 with 3% H_2O is (1 − 0.0300) × 3 × 235 / (3 × 235 + 8 × 16) = 0.8209 gU/g and $UO_2(NO_3)_2 \cdot 6H_2O$ is 235 / (235 + 2 × 16 + 2 × [14 + 3 × 16] + 6 × (2 + 16) = 0.4709 gU/g. For 15,130 g of U_3O_8 with 3% H_2O, $d(n_{H2}) / dt = 15{,}130 \times 0.8209 \times 1.39 \times 10^{21} \times 0.0412 / (100 \times 6.022 \times 10^{23}) = 0.01185$ mol H_2/y. For 4750 g of $UO_2(NO_3)_2 \cdot 6H_2O$, $d(n_{H2}) / dt = 4750 \times 0.4709 \times 1.39 \times 10^{21} \times 0.2661 / (100 \times 6.022 \times 10^{23}) = 0.0137$ mol H_2/y.

3.5.4.8 Time to reach 5 mol %

The time at which the H_2 concentration in the void space of the package reaches 5 mol % depends on the H_2 generation rate and the initial amount of gas in the void space. This void space includes the internal void space within the convenience containers and the void space in the containment vessel outside the convenience containers. It is assumed that the convenience containers are open to the containment vessel and all the gases initially present, and subsequently generated, are mixed in this void space.

The initial amount of gas in the void space is given by

$$n_I = V_{VT} \times \rho_G,$$
$$V_{VT} = V_{BT} - Wt / \rho,$$

where

n_I = the initial amount of gas in the containment vessel void space, mol;
V_{VT} = the void volume of the loaded containment vessel, cm^3;
V_{BT} = the void volume of the containment vessel with empty convenience containers, 9417.0 cm^3 (574.66 $in.^3$) and 9,257.3 cm^3 (564.92 $in.^3$) for CVA 1 and CVA 7, respectively (Appendix 3.5.1, Table 1);
Wt = the total load weight (Wt_{UNX} or Wt_{OX}), g;
ρ = the density of the load material (ρ_{UNX} or ρ_{OX}).

Since each mole of H_2 generated is accompanied by 0.5 mol of O_2, the concentration of H_2 will reach 5 mol % when

$$(n_{H2GN} + n_{H2I}) / (1.5 \times n_{H2GN} + n_I) = 0.05 \text{ or } n_{H2GN} = 0.05405 \times n_I - 1.08108 \times n_{H2I},$$

where

n_{H2GN} = the amount of H_2 generated after the containment vessel is loaded, mol,
n_{H2I} = the initial amount of H_2 in the convenience containers when the containment vessel is loaded (= n_{H2B} or n_{H2C}), mol.

As an example, 15,130 g of U_3O_8 (ρ is 8.38 g/cm^3) in a CVA 1 configuration will result in a loaded void volume (V_{VT}) of 9417.0 − 15130 / 8.38 = 7611.5 cm^3. The initial amount of gas (n_I) is 7611.5 cm^3 × 4.087 × 10^{-5} mol/cm^3 = 0.31108 mol. The initial amount of H_2 in the convenience containers (n_{H2I}) is 4.5402E-05 mol (Sect. 3.5.4.2) so n_{H2GN} = 0.05405 × 0.31108 − 1.08108 × 4.54E-05 = 0.016765 mol.

3.5.4.9 Hydrogen buildup

The buildup of H_2 in the containment vessel can be expressed as

$$\frac{d(n_{H2GN})}{dt} = \frac{d(n_{H2})}{dt} - L_{MH2},$$

where

L_{MH2} = the permeation loss rate of H_2 through the main O-ring of the containment vessel, mol /y.

Parker O-Ring Handbook (Sect. 3.12.1, p. 3-21) gives the following expression for the permeation loss of H_2 through an O-ring:

L_{VH2} = $0.7 \times F \times D \times P \times Q \times (1 - S)^2$;
= the permeation loss rate of H_2 through the O-ring, std cm^3 H_2/s;

F = the permeability of hydrogen through the O-ring material (ethylene propylene, Table 3.10) at 38°C, 28.9E-08 std cm^3 H_2/(cm s bar) [*Parker O-Ring Handbook*, Table 3-24, p. 3-29];
D = the inside diameter of the O-ring, 5.359 in. (Drawing M2E801580A013, Appendix 1.3.7);
P = the pressure differential across the seal, psi;
S = the fraction of the O-ring cross-section reduced by squeezing the ring in the gland, 0.15 to 0.21 (Sect. 4.1.1), 0.21 conservatively selected;
Q = a factor depending on S (ring is lubricated, Table 3.10), 0.72 (*Parker O-Ring Handbook*, Fig. 3-11, p. 3-21);
L_{MH2} = L_{VH2} multiplied by (3600 s/h × 24 h/d × 365.25 d/y) and divided by 22,414 std cm^3/mol.

The pressure increase in the containment vessel is given by

P = $1.5 \times n_{H2GN} / n_I \times P_i$,
P_i = the initial pressure of the gas in the containment vessel, 14.7 psia.

If the initial pressure is equal to the ambient pressure (the usual situation), the pressure differential across the seal is equal to P.

If all of the above terms are combined, the expression for $d(n_{H2GN}) / dt$ becomes

$$\frac{d(n_{H2GN})}{dt} = \frac{d(n_{H2})}{dt} - \frac{k \times n_{H2GN}}{n_I},$$

$$\begin{aligned} k &= 0.7 \times F \times D \times 1.5 \times P_i \times Q \times (1 - S)^2 \times (3600 \times 24 \times 365.25) / 22414, \\ &= 0.01512 \text{ mol/y}. \end{aligned}$$

The solution to the above differential equation is

$$n_{H2GN} = [d(n_{H2}) / dt] \times n_I / k \times [1.0 - \exp(-k \times t / n_I)],$$

and the time when n_{H2GN} reaches $0.05405 \times n_I - 1.08108 \times n_{H2I}$ is

$$t = -\text{Ln}(1.0 - [0.05405 \times n_I - 1.08108 \times n_{H2I}] \times k / [d(n_{H2}) / dt \times n_I]) \times n_I / k.$$

As an example, the time for the 15,130 g of U_3O_8 is $-\text{Ln}(1.0 - 0.016765 \text{ mol} \times 0.01512 \text{ mol/y} / [0.01185 \text{ mol/y} \times 0.31108 \text{ mol}]) \times 0.31108 \text{ mol} / 0.01512 \text{ mol/y} = 1.465$ y.

As shown in Table 3.5.4.2, the bounding value of the decay energy (D_E) is 1.39×10^{15} MeV/(gU y). The energy per gram of material is the product of $D_E \times$ the fraction of uranium in the material. The fraction of uranium in UO_2 with $f_{H2O} = 0.03$ (3% water) is $(1 - 0.03) \times 235 / (235 + 2 \times 16) = 0.85375$ gU/g material. Similarly, the fractions in U_3O_8 and UO_3 are 0.82095 and 0.80548, respectively. The corresponding fraction in crystals is $235 / [235 + 2 \times 16 + 2 \times (14 + 3 \times 16) + X \times (2 + 16)] = 0.47094$ gU/g material for X = 6 $[UO_2(NO_3)_2 \cdot 6H_2O]$ and 0.52809 for X = 3 $[UO_2(NO_3)_2 \cdot 3H_2O]$. The decay energies are 1.19×10^{15} MeV/y g material for UO_2 with 3% H_2O, 1.15×10^{15} for U_3O_8, 1.12×10^{15} for UO_3, 6.57×10^{14} for $UO_2(NO_3)_2 \cdot 6H_2O$, and 7.37×10^{14} for $UO_2(NO_3)_2 \cdot 3H_2O$.

Table 3.5.4.4 summarizes the calculations for the time to reach 5 mol % H_2 in the void space of the containment vessel, as a function of the total weight of the material in the containers (Wt). The total amount of H_2 in the void space is the sum of the initial H_2 plus the added H_2 while the total gas in the void space is the sum of the initial gas plus 1.5 times the added H_2. The 1.5 factor accounts for the O_2 generated with the H_2. For 15.13 kg of U_3O_8 with 3% H_2O, the time to reach 5 mol % H_2 in the void space is 1.5 years or 18.2 months. At that time, the total amount of H_2 in the void space is 0.00005 + 0.01820 = 0.01825 mol while the total gas in the void space is 0.33777 + 1.5 × 0.01820 = 0.36507 mol.

Table 3.5.4.4. Summary of calculation results

Weight (kg)	Density (g/cm^3)	Void volume (cm^3)	Gas amounts (mol)			Water content		Material uranium content (gU/g)	Annual radiation rate [a]	Gf	G'(H_2) [b]	n_{H2} rate (mol/y)	Time to 5 % (y/mo)
			Initial total	Initial H_2	Added H_2	X	(wt %)						
U Oxides (UO_2) [CVA 1]													
15.13	10.97	8037.7	0.32850	0.00005	0.017700		3.0	0.85375	1.19E+15	0.04075	0.04156	0.01243	1.4717.6
U Oxides (U_3O_8) [CVA 1]													
15.13	8.38	7611.5	0.31108	0.00005	0.016765		3.0	0.82095	1.15E+15	0.04040	0.04120	0.01185	1.46/17.5
U Oxides (UO_3) [CVA 1]													
15.13	7.30	7344.3	0.30016	0.00004	0.016178		3.0	0.80548	1.12E+15	0.04023	0.04104	0.01158	1.44/17.3
$UO_2(NO_3)_2 \cdot XH_2O$ [CVA 7]													
4.75	2.81	7567.0	0.30926	0.00108	0.015548	6.0	21.64	0.47094	6.57E+14	0.26087	0.26609	0.01379	1.16/13.9
6.70	2.81	6873.0	0.28090	0.00085	0.014263	3.0	12.13	0.52809	7.37E+14	0.15000	0.15300	0.01254	1.17/14.0
9.17	2.81	5994.0	0.24497	0.00144	0.011686	6.0	21.64	0.47094	6.57E+14	0.26087	0.26609	0.02661	0.445/5.3
11.90	2.81	5022.5	0.20527	0.00088	0.010145	3.0	12.13	0.52809	7.37E+14	0.15000	0.15300	0.02227	0.463/5.5

[a] Units are MeV/(g y).
[b] Units are molecules H_2/100 eV.

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Appendix 3.5.5
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4. CONTAINMENT

Design analysis, full-scale testing, and similarity of the ES-3100 prototypes have been used to demonstrate that the ES-3100 package with highly enriched uranium (HEU) is in compliance with the applicable containment requirements of Title 10 Code of Federal Regulations, Part 71 (10 CFR 71). The containment requirements of 10 CFR 71.51 are shown in Table 4.1. A bounding load case has been established for the ES-3100 package, and it assumes that the maximum HEU content is 35.2 kg (Sect. 1.2.2.6) with a decay heat load of 5 W (Sect. 3.1.2). This decay heat load and the volumes established for the convenience cans, polyethylene, nylon or Teflon bagging, spacers, silicone rubber pads, and the containment vessel void volume are discussed in Sect. 3.1.2 and Appendix 3.5.1. Chapters 2 and 3 of this safety analysis report for packaging (SARP) also examine the effects of the lightest weight HEU content [2.77 kg (6.11 lb)]. Section 3.4.3 also examines the conservative effects of shipping no contents inside the containment vessel but including the maximum decay heat load for the proposed contents. The evaluations in Chapters 2, 3, and 4 have demonstrated that the ES-3100 shipping package with HEU content weight ranging from 0 kg (0 lb) to 35.2 kg (77.60 lb) meets the containment requirements specified in 10 CFR 71 for all conditions of transport. As shown in Chap. 1, some Thorium (^{232}Th) compounds or oxides mixed with uranium are proposed for transport. Shipping of ^{232}Th is bounded by the containment analyses using uranium due to the following: (1) the A_2 of ^{232}Th is unlimited; (2) the decay energy of ^{232}Th is less than all other uranium isotopes; and (3) the half-life of ^{232}Th is significantly longer than the uranium isotopes. A summary of the containment boundary design and fabrication acceptance basis is given in Table 4.2. No credit is taken for the ability of the various convenience cans to protect the HEU contents from being released.

The analysis documented in Appendix 4.5.1 was conducted to establish the upper limit for the total activity and the maximum number of A_2s proposed for transport in the ES-3100 package. The maximum activity [7.2554×10^{-1} TBq (19.6092 Ci)] of the contents occurs 10 years after initial fabrication. When the maximum activity-to-A_2 value (4.7528×10^{3}) is reached at ~70 years from material fabrication, the corresponding activity is 7.2456×10^{-1} TBq (19.5827 Ci). These values have been determined using a maximum of 35.2 kg of HEU with isotopic weight percents as shown in Table 4.3. By applying the maximum weight percents of isotopes ^{233}U, ^{234}U, ^{236}U and by incorporating the traces of ^{232}U and the transuranic isotopes, the maximum activity, minimum A_2 value, and the minimum leakage requirements were determined for the proposed contents and are summarized in Tables 4.4, 4.5, 4.6, and 4.8. Containment vessel design verification tests for NCT and HAC are shown in Tables 4.7 and 4.9, respectively. Table 4.6 summarizes the results of evaluating the International Atomic Energy Agency (IAEA) requirements for air transportation of fissile uranium in accordance with 10 CFR 71.51(a)(1). The ANSI N14.5 leaktight criterion achieved by compliance testing is substantially below the results shown in Table 4.6 for air transport. Therefore, the IAEA SSR-6 requirements of no loss or dispersal of radioactive contents from the containment system is satisfied. The mass and isotopic concentrations used for the proposed content do not take into consideration limits based on shielding and subcriticality.

Table 4.1. Containment requirements of transport for Type B packages

Condition	Allowable release rate [a]
Normal Conditions of Transport (NCT)	$R_N = 10^{-6}$ A_2 per hour = 2.78×10^{-10} A_2 per second
Hypothetical Accident Conditions (HAC)	$R_A = A_2$ in 1 week = 1.65×10^{-6} A_2 per second For ^{85}Kr, a value of 10 A_2 in 1 week is used

[a] From ANSI N14.5-1997, Sects. 5.4.1 and 5.4.2, and 10 CFR 71.51(a)(1) and (a)(2).

Table 4.2. Summary of the containment vessel design and fabrication acceptance basis

Weight (empty, nominal)	15.10 kg (33.29 lb)
Temperature at loading (air fill, average)	25°C (77°F)
Pressure at loading (air fill, average)	101.35 kPa (14.70 psia)
Hydrostatic pressure test	1034 ± 34 kPa (150 ± 5) gauge
Leakage rate testing [a]	
Acceptance leakage rate test, air (or equivalent)	
Containment boundary [b]	$L_T \leq 1 \times 10^{-7}$ ref-cm^3/s
Fabrication verification of O-ring seal [c]	$L_T \leq 1 \times 10^{-4}$ ref-cm^3/s
Preshipment, air [d]	$L_T \leq L_R$ or no detected leakage when tested to a sensitivity of 1×10^{-3} ref-cm^3/s

[a] L_T is the maximum allowable test leakage rate for a set of testing conditions.
[b] Acceptance leakage testing of the containment boundary includes fabrication, periodic (within 12 months of use), and maintenance testing. According to Subclause 2.1 of ANSI N14.5-1997, *leaktight* is defined as an air leakage rate of 1×10^{-7} ref-cm^3/s; under the same conditions, this air leakage rate is ~ equal to a helium leakage rate of 2×10^{-7} cm^3/s.
[c] Performed at initial fabrication on the fully assembled containment vessel with both O-rings installed to demonstrate the functionality of the leak-test port and sealing capability of the outer O-ring (Appendix 1.3.3).
[d] L_R as defined in ANSI N14.5-1997, Subclause 6.2, is the more restrictive reference air leakage rate based on the allowable leakage rate for both NCT and HAC.

Table 4.3. Isotopic mass and weight percent for the HEU contents

Nuclide	Weight percent [a]	Mass (g)
U-232	0.000004	0.001408
U-233	0.600000	211.200000
U-234	2.000000	704.000000
U-235	54.819996	19,296.638592
U-236	40.000000	14,080.000000
U-238	0.000000	0.000000
Transuranic	0.080000 [b]	28.160000
Np-237	2.500000	880.000000
Total	**100.000000**	**35,200.000000**

[a] Weight percent values of individual isotopes are those that generate the largest activity within the allowable ranges presented in Sect. 1.2.2.
[b] The transuranic weight percent of 0.080000 applies to ground transport only. The maximum transuranic weight percent in contents transported by air will be 0.004000.

Table 4.4. Activity, A_2 value, and number of A_2 proposed for transport

Year	Fast absorption			Medium absorption			Slow absorption		
	Activity (TBq)	A_2 (TBq)	Act / A_2	Activity (TBq)	A_2 (TBq)	Act / A_2	Activity (TBq)	A_2 (TBq)	Act / A_2
0	7.197E-01	1.5289E-04	4.707E+03	7.1974E-01	1.5253E-04	4.7185E+03	7.1974E-01	1.5148E-04	4.751E+03
5	7.251E-01	1.5399E-04	4.709E+03	7.2507E-01	1.5363E-04	4.7197E+03	7.2507E-01	1.5257E-04	4.752E+03
10	7.255E-01	1.5408E-04	4.709E+03	7.2554E-01	1.5372E-04	4.7199E+03	7.2554E-01	1.5267E-04	4.752E+03
20	7.254E-01	1.5404E-04	4.709E+03	7.2538E-01	1.5368E-04	4.7200E+03	7.2538E-01	1.5263E-04	4.752E+03
30	7.251E-01	1.5399E-04	4.709E+03	7.2514E-01	1.5363E-04	4.7200E+03	7.2514E-01	1.5258E-04	4.752E+03
40	7.249E-01	1.5394E-04	4.709E+03	7.2494E-01	1.5358E-04	4.7201E+03	7.2494E-01	1.5254E-04	4.753E+03
50	7.248E-01	1.5390E-04	4.709E+03	7.2478E-01	1.5355E-04	4.7202E+03	7.2478E-01	1.5250E-04	4.753E+03
60	7.247E-01	1.5387E-04	4.709E+03	7.2465E-01	1.5352E-04	4.7203E+03	7.2465E-01	1.5247E-04	4.753E+03
70	7.246E-01	1.5385E-04	4.710E+03	7.2456E-01	1.5349E-04	4.7206E+03	7.246E-01	1.5245E-04	4.7528E+03

Table 4.5. Regulatory leakage criteria for NCT

Verification activity	Fast absorption		Medium absorption		Slow absorption	
	$L_{RN\text{ - air}}$ (ref-cm^3/s)	$L_{RN\text{ - He}}$ (cm^3/s)	$L_{RN\text{ - air}}$ (ref-cm^3/s)	$L_{RN\text{ - He}}$ (cm^3/s)	$L_{RN\text{ - air}}$ (ref-cm^3/s)	$L_{RN\text{ - He}}$ (cm^3/s)
Design [a]	1.4151E-04	1.7416E-04	1.4119E-04	1.7378E-04	1.4025E-04	1.7269E-04

[a] The procedure used to calculate the above criteria is shown in Appendix 4.5.2. This data has been extracted from Table 1 in Appendix 4.5.2.

Table 4.6. 10 CFR 71.51(a)(1) leakage criteria for air transport in accordance with IAEA environmental conditions

Temperature	Slow absorption [a, b, c]	
	$L_{RN\text{ - air}}$ (ref-cm^3/s)	$L_{RN\text{ - He}}$ (cm^3/s)
Lower limit (-40°C)	1.7184E-04	2.0938E-04
Upper limit (64.44°C)	2.1611E-04	2.6031E-04

[a] The procedure used to calculate the above criteria is shown in Appendix 4.5.2.
[b] Slow absorption criteria has been shown to produce the lowest leakage criteria.
[c] The IAEA SSR-6 requirement is no loss or dispersal of radioactive contents from the containment system. This condition is satisfied based on the leaktight criterion achieved by compliance test units.

Table 4.7. Containment vessel verification tests criteria for NCT

Test type	Test values	Leakage test procedure
Design and compliance leakage testing		
Design verification of O-ring seal (air)	$L_T \leq 1.0 \times 10^{-4}$ ref-cm^3/s	See ORNL/NTRC-013
Design verification of containment vessel boundary (helium)	$L_T \leq 2.0 \times 10^{-7}$ cm^3/s	See ORNL/NTRC-013
Verification leakage testing		
Fabrication, periodic, and maintenance (helium)	$L_T \leq 2.0 \times 10^{-7}$ cm^3/s	Y51-01-B2-R-140 (Appendix 8.3.1) or equivalent
Fabrication verification of O-ring seal (air)	$L_T \leq 1.0 \times 10^{-4}$ ref-cm^3/s	Tested at initial fabrication in accordance with the supplier's approved procedure as required by Appendix 1.3.3
Preshipment (air)	$L_T \leq L_R$ or no detected leakage when tested to a sensitivity of 1×10^{-3} ref-cm^3/s	Y51-01-B2-R-074 (Appendix 7.5.2) or equivalent

The initial composition of the content contains several isotopes of uranium (Sect. 1.2.2). As a result of radioactive decay, the ingrowth of uranium daughter products occurs, and these concentrations of daughter products will vary with time. The uranium isotopes and daughter products are considered a mixture of radionuclides, and the method for determining the mixture's A_2 value in Section IV, Appendix A, 10 CFR 71 is applied. The A_2 value for the most conservative set of contents defined in Sect. 1.2.2 has been calculated in Appendix 4.5.1. Since the HEU can be in the form of oxides (U_3O_8-Al, UO_2-Mg, UO_2-ZrO_2, UO_2, UO_3, U_3O_8, UO_2-Th, or UO_2-ThO_2), uranyl nitrate crystals (UNX), metal or alloy, research reactor fuel elements and components, or compounds, the calculation of the mixture's A_2 used the various uranium isotopic A_2 values for fast, medium, and slow lung absorption criteria shown in Table A-1 of Appendix A of 10 CFR 71. As previously stated, ^{232}Th is bounded by the use of uranium isotopes and is subsequently neglected in further analyses.

The mass and material compositions analyzed in this section of the SARP are not limited by the combustible gas requirements stated in NUREG-1609, Sect. 4.5.2.3, which requires the applicant to demonstrate that any combustible gases generated in the package during a period of one year do not exceed 5% (by volume) of the free gas volume in any confined region of the package. No credit should be taken for getters, catalysts, or other recombination devices. The analysis conducted in Appendix 3.5.4 evaluates the different packaging arrangements for the generation of hydrogen gas due to the radiolysis of water vapor, free water, interstitial water, polyurethane bags, and polyurethane or Teflon bottles. By limiting the mass and the material distribution as shown in Appendix 3.5.4, the combustible gas concentration limit stated in NUREG-1609 is not exceeded. These limits are further shown in Tables 1.3 and 1.3a. Getters, catalysts, or other recombination devices are not employed in any of the containment vessel packaging arrangements. The analysis conducted in Appendix 3.5.1 predicts the maximum normal operating pressure (MNOP) inside the containment vessel for the various packaging arrangements and masses discussed previously. This appendix also includes the hydrogen gas generation predicted by Appendix 3.5.4.

4.1 DESCRIPTION OF THE CONTAINMENT SYSTEM

As shown in Table 4.4, the number of A_2s proposed for shipping exceeds 3000. In accordance with NUREG-1609, the containment vessel is a Category I vessel. Therefore, the containment vessel is designed (using nominal dimensions for each component), fabricated, and inspected in accordance with the American Society of Mechanical Engineers (ASME) *Boiler and Pressure Vessel Code*, Sect. III, Div. 1, Subsection NB and Sect. IX.

4.1.1 Containment Boundary

The containment boundary consists of the vessel's body, lid assembly, and inner O-ring (Sect. 1.2.1.5, Fig. 1.3). Only the inner O-ring is considered part of the boundary. The outer O-ring is provided to allow a post-assembly verification leak check. Two methods of fabrication may be used to fabricate the containment vessel body as shown on Drawing M2E801580A012 (Appendix 1.3.7). The first method uses a standard 5-in., schedule 40 stainless-steel pipe per ASME SA-312 Type TP304L, a machined flat-head bottom forging per ASME SA-182 Type F304L, and a machined top flange forging per ASME SA-182 Type F304L. The nominal outside diameter of the 5-in. schedule 40 pipe is machined to match the nominal wall thickness of 0.254 cm (0.100 in.). Each of these pieces is joined with full-penetration circumferential weld as shown on sheet 2 of Drawing M2E801580A012 (Appendix 1.3.7). The weld filler material conforms to Sect. II, Part C, of the *ASME Boiler and Pressure Vessel Code*. All full-penetration welds are dye penetrant and radiographically inspected in accordance with Sect. III, Div. 1, Subsection NB-5000, of the *ASME Boiler and Pressure Vessel Code*. The top flange is machined to match the schedule 40 stainless-steel 5-in. pipe, to provide two concentric half-dovetailed O-ring grooves in the flat face, to provide locations for two 18-8 stainless-steel dowel pins, and to provide the threaded portion for closure using the lid assembly. The second method of fabrication uses flow forming to create the complete body (flat bottom, cylindrical body, and flange) from a single forged billet or bar with final material properties in accordance with ASME SA-182 Type F304L. Final machining of the top flange area is identical to that of the welded forging method. The lid assembly, which completes the containment boundary structure, consists of a sealing lid, closure nut, and external retaining ring (Drawing M2E801580A014, Appendix 1.3.7). The containment vessel sealing lid (Drawing M2E801580A015, Appendix 1.3.7) is machined from Type 304 stainless-steel bar with final material properties in accordance with ASME SA-479. The containment vessel closure nut is machined from a Nitronic 60 stainless-steel bar with material properties in accordance with ASME SA-479. These two components are held together using an external retaining ring made from Type 302 stainless steel. A weld is used to seal around a plug that is inserted inside the hole used for machining the pathway for leak testing between the O-rings. Since this plug and weld are outside the containment boundary, the weld is not important to safety. However, it is important to operation because its sealing capability is needed to properly conduct the preshipment leak test. This weld is addressed in Paragraph 3.4 of the containment vessel equipment specification (JS-YMN3-801580-A001, Appendix 1.3.3). In this specification, the weld is inspected visually and using dye penetrant. The requirements of NB-5110 and NB-5350 of the *ASME Boiler and Pressure Vessel Code* also apply. The sealing lid is further machined to accept a ⅜-in.-16 swivel hoist ring bolt, to provide a leak-check port between the elastomeric O-rings, and notched along the perimeter to engage two dowel pins. The lid assembly, with the O-rings in place on the body, are joined together by torquing the closure nut and sealing lid assembly to 162.7 ± 6.78 N·m (120 ± 5 ft-lb). The sealing lid portion of the assembly is restrained from rotating during this torquing operation by the two dowel pins installed in the body flange. This torquing of the closure nut represents the positive fastening device used to satisfy the requirements of 10 CFR 71.43(c). The effectiveness of this closure system has been demonstrated by the NCT and HAC tests, which show that the complete containment system, including welds and O-ring seals, meet the leaktight criterion as defined in ANSI N14.5-1997 after the conclusion of the test series documented in ORNL/NTRC-013.

10 CFR 71.73(c) requires that the package containment vessel be immersed in 15 m (50 ft) of water, which is equivalent to an external pressure differential of 150 kPa (21.7 psi). The design analyses (DAC-M900000-0002) show that this vessel is conservatively rated for the 150 kPa (21.7 psi) external pressure differential requirement, as well as for an internal pressure differential of 1378.95 kPa (200 psig). A summary of the containment boundary design and acceptance basis is given in Table 4.2.

The ES-3100 package has no connections, fittings, valves, tapped holes, or other devices that penetrate the containment boundary; therefore, the package does not allow continuous venting during transport. The leak test port on the containment vessel lid accesses the annulus between the two O-rings. Since the outer O-ring is not considered to be part of the containment boundary, this leak test port does not penetrate the containment boundary. Therefore, the requirements of 10 CFR 71.43(e) and (h) are not applicable.

The containment vessel O-rings (Drawing M2E801580A013, Appendix 1.3.7) are manufactured from ethylene propylene diene monomer (EPDM) in accordance with Equipment Specification SPC M801580-0002 (Appendix 1.3.9).

The EPDM O-rings are rated for continuous service as a static face seal in the temperature range of −40 to 150°C (−40 to 302°F) [*Parker O-Ring Handbook*, Fig. 2-24]. Tests conducted by Los Alamos National Laboratory (LANL) on a similar compound used as a static face seal, are documented in *SAFKEG 2863B Tests for Verification of O-ring Performance* (TR 96/12/20). The material compound for the LANL tests was certified to ASTM D 2000 as M3BA610A14B13F17. The ES-3100 package O-rings are also certified to ASTM D 2000 as M3BA712A14B13F17. The class of material in the LANL test is identical except that the durometer and tensile strengths are somewhat less than those of the ES-3100 package. Each material was tested in accordance with ASTM D 2137 for brittleness at −40°C (−40°F) without failure. The leak test fixture, as reported in TR 96/12/20, provided a maximum compression of 25.7% in a static face seal configuration. The compression range provided by the flange and lid design of the ES-3100 package is 14.8 to 20.8% or 0.051 to 0.076 cm (0.020 to 0.030 in.) compression due to the half-dovetail design. Furthermore, *Parker O-Ring Handbook* states that the minimum squeeze for all seals, regardless of cross-section, should be ~0.018 cm (0.007 in.). Since the minimum compression is 0.051 cm (0.020 in.) and the flange and lid with the closure nut have nearly identical coefficient of thermal expansion, the sealing performance at −40°C (−40°F) should not be degraded. Therefore, the performance of the ES-3100 O-rings should be representative of those documented in TR 96/12/20. These tests demonstrated that the O-rings were leaktight over the temperature range of −40 to 205°C (−40 to 401°F), which is greater than the operating temperature range of −40 to 186.79°C (−40 to 368.23°F) of the ES-3100 containment vessel (Table 3.5). In addition to component testing, an ES-3100 full-scale test unit [Test Unit (TU)-2] was chilled to ≤ −40°C and later subjected to an NCT drop test and the entire HAC test battery. The containment vessel was leak tested and achieved “leaktight” status. Therefore, the continuous service temperature rating of the EPDM O-ring has been verified by testing.

4.1.2 Special Requirements for Plutonium

The HEU contents have only trace amounts of the transuranic isotopes. Therefore, the requirements in 10 CFR 71.63 and 71.74 are not applicable.

4.2 CONTAINMENT UNDER NORMAL CONDITIONS OF TRANSPORT

Title 10 CFR 71.51(a)(1) specifies that there shall be no loss or dispersal of radioactive contents as demonstrated to a sensitivity of 10^{-6} A_2 per hour, no significant increase in external radiation levels, and no substantial reduction in the effectiveness of the packaging. The initial composition of the HEU contains several isotopes of uranium and transuranic contributors (Table 4.3). As a result of radioactive

decay, uranium, transuranics, and daughter product isotopes are present in the HEU contents at varying concentrations depending on the length of decay time. The HEU, with its isotopes and daughter isotopes and contributions from unknown transuranic isotopes, qualifies as a mixture for A_2 determination (Appendix A of 10 CFR 71). The A_2 value and the maximum content activity-to-A_2 value ratio for this mixture have been calculated for several different decay times (Table 4.4). As calculated in Appendix 4.5.1, the A_2 value [1.5245×10^{-4} TBq (4.1203×10^{-3} Ci)] and the maximum content activity-to-A_2 ratio (4.7528×10^{3}) used to qualify this package occurs at ~70 years of decay. As previously stated, these values have been determined using a bounding case maximum of 35.2 kg of HEU with isotopic weight percent values as shown in Table 4.3. The specified composition is a very conservative upper bound achieved by using the maximum weight percent values for the higher specific activity isotopes (^{232}U, ^{233}U, ^{234}U, and ^{236}U), including contributions from other transuranics and ^{237}Np.

The maximum activity, minimum A_2, and minimum leakage requirements were determined for this worst case scenario and are presented in Tables 4.4 and 4.5. These masses and isotopic concentrations were used for the proposed contents without regard to limits established based on shielding and subcriticality considerations. The actual mass limits affirmed for this shipping package are established in Chap. 1 (Tables 1.3, 1.3a, and 1.3b). The analyses conducted in Appendix 4.5.2 assume that the total mass of uranium for each component is available for release as an aerosol (worst case). From experimental tests, the maximum aerosol density containing uranium particulate was reported in "Leakage of Radioactive Powders from Containers" (Curren and Bond) to be 9.0×10^{-6} g/cm^3. This aerosol density is used to calculate the total activity concentration in ANSI N14.5-1997, Sect. B.15, Examples 13, 27, and 29.

The containment criteria for the ES-3100 package will be leaktight (defined in paragraph 2.1 of ANSI N14.5-1997 as having a leakage rate $\leq 1 \times 10^{-7}$ ref-cm^3/s) during the prototype tests. This leaktight criterion satisfies the design verification requirement stipulated in paragraph 7.2.4 of ANSI N14.5-1997. The requirements of ANSI N14.5-1997 are used for the design and fabrication containment verification of the ES-3100 leakage rate testing.

The design, fabrication, maintenance, and periodic leakage rate limit is 1×10^{-7} ref-cm^3/s air (or equivalent). Preshipment leakage rate testing, which demonstrates correct assembly of the containment vessel, shall be performed to the acceptance criterion of either (1) a leakage rate of not more than the reference air leakage rate, L_R, or (2) no detected leakage when tested to a sensitivity of at least 10^{-3} ref-cm^3/s (ANSI N14.5-1997, Subclause 7.6.4). The preshipment, fabrication, and maintenance leakage rate tests are required to be conducted on each containment vessel in accordance with ANSI N14.5-1997 and are specified in Chapters 7 and 8. In addition to these leakage tests, Subclause 7.5.2 of ANSI N14.5-1997 states that the periodic leakage rate testing shall be conducted within 12 months prior to each shipment. Testing of the ES-3100 and EPDM O-rings, documented in RP 801580-0022, *ES-3100 Containment Vessel (CV) O-rings Life Extension Testing*, provides the justification to extend the periodic leakage rate testing frequency to 24 months. Therefore, the periodic leakage rate testing specified in Chapter 8 shall be conducted in accordance with ANSI N14.5-1997 except for the frequency. These leakage rates are not dependent on filters or mechanical cooling.

The complete design verification testing of the ES-3100 package for NCT was conducted on test unit TU-4. Since the containment vessel was assembled at ambient conditions, the pressure was nominally 101.35 kPa (14.70 psia) at 25°C (77°F). In accordance with 10 CFR 71.71(b), the initial pressure inside each containment vessel should be the maximum normal operating pressure (MNOP). As calculated in Appendix 3.5.1 and rounded up, the bounding case MNOP is 108.94 kPa (15.8 psig). The stresses at the MNOP are insignificant compared to the allowable stresses (Tables 2.21 and 2.21a). O-ring grooves are designed and fabricated in accordance with guidance from the *Parker O-Ring Handbook*. In accordance with Fig. 3-2 of the *Parker O-Ring Handbook*, the durometer of the O-ring, and the tolerance gap from the production drawings, the O-ring should be able to withstand ~800 psig

before anti-extrusion devices are required. Therefore, conducting a compliance test with the MNOP in the containment vessel will have little, if any, effect on the results.

Following the design verification testing of paragraphs 10 CFR 71.71(c)(5) through 71.71(c)(10) excluding 71.71(c)(8), TU-4 was subjected to the sequential testing of paragraphs 10 CFR 71.73(c)(1) through (c)(4). Upon removal of the containment vessel from the drum assembly, the cavity between the O-rings was leak checked. This unit recorded a leak rate between the O-rings of 2.4773×10^{-5} ref-cm^3/s (ORNL/NTRC-013).

Following the O-ring leak test, the entire containment boundary of TU-4 was helium leak tested to a value $\leq 2 \times 10^{-7}$ cm^3/s, thereby verifying a leak-tight boundary. The leak-test procedure followed to verify this criterion is documented in the ES-3100 test report (ORNL/NTRC-013). The maximum recorded helium leakage rate for this containment vessel was 2.0×10^{-7} cm^3/s after 20 min of testing. Visual inspection following the testing indicated that neither the vessel body, the O-rings, the seal areas, nor the vessel lid assembly were damaged during the tests. Pictures taken of the containment vessel top following testing showed that the closure nut had rotated a maximum of 0.15 cm (0.060 in.) from its original radial position obtained during assembly. Based on the pitch of the closure nut, this rotation translates into only 0.0013 cm (0.0005 in.) decompression of the O-rings. This compares to the original nominal compression of 0.064 cm (0.025 in.). Therefore, O-ring compression was maintained during compliance testing. Based on these results, the ES-3100 package meets and exceeds the containment criteria specified in 10 CFR 71.51 for NCT when used to ship the contents described in Sect. 1.2.2.

Following fabrication, the containment vessel undergoes hydrostatic pressure testing to 1034 kPa (150 psi) gauge. The hydrostatic test is conducted before the final leakage test. Following the hydrostatic pressure test, and prior to conducting the leakage test, the containment vessel and O-ring cavity must be thoroughly dried. Each vessel is then leak tested with helium to 2×10^{-7} cm^3/s. In accordance with *ASME Boiler and Pressure Vessel Code*, Sect. V, Subsection A, Article 10, Appendix IX, "Helium Mass Spectrometer Test—Hood Technique," a system response time must be established to determine the helium leak testing duration. The fabricators of this package used the *ASME Boiler and Pressure Vessel Code* approach and determined that the system response time for their setup of this containment vessel was ~15 s. To ensure that the leak detector steady-state (equilibrium) response is reached, the helium leak test duration was established at 2 min (8 × system response time). This test ensures the containment vessel's integrity (walls, welds, inner O-ring seal) as delivered for use in accordance with paragraph 6.3.2 of ANSI N14.5-1997.

Following placement of the HEU content inside the containment vessel and joining the body and lid assembly, the volume between the containment vessel's O-ring seals is typically evacuated and leak checked using the pressure rise air leak test prescribed in Sect. 7.1.2.1. The acceptance criterion for preshipment leakage rate testing shall be either (1) a leakage rate of not more than the reference air leakage rate, L_R, or (2) no detected leakage rate when tested to a sensitivity of at least 10^{-3} ref-cm^3/s. This ensures that each containment vessel has been properly assembled in accordance with paragraph 7.6.4 of ANSI N14.5-1997.

The design verification tests were conducted following compliance tests in accordance with 10 CFR 71.71 and 71.73. The effectiveness of this closure system has been demonstrated by the NCT and HAC tests, which show that the complete containment system, including welds and O-ring seals, meet the leaktight criterion as defined in ANSI N14.5-1997 after the conclusion of the test series documented in ORNL/NTRC-013.

4.3 CONTAINMENT UNDER HYPOTHETICAL ACCIDENT CONDITIONS

Requirements. A Type B package, in addition to satisfying the requirements of paragraphs 10 CFR 71.41 through 71.47, must be designed, constructed, and prepared for shipment so under the tests specified in Sect. 71.73 ("Hypothetical Accident Conditions"), there would be no escape of ^{85}Kr exceeding 10 A_2 in one week, no escape of other radioactive material exceeding a total amount A_2 in one week, and no external radiation dose rate exceeding 10 mSv/h (1 rem/h) at 1 m (40 in.) from the external surface of the package.

Analysis. Calculations have been conducted in Appendix 4.5.2 to determine the regulatory leakage criteria to satisfy the above requirements. The results are shown in Table 4.8. These analyses assume that the total mass of uranium for each component is available for release as an aerosol (worst case). From experimental tests, the maximum aerosol density containing uranium particulate was reported by Curren and Bond to be 9.0×10^{-6} g/cm^3. This aerosol density is used to calculate the total activity concentration in ANSI N14.5-1997, Sect. B.15, Examples 13, 27, and 29. Design leakage rate verification testing of the containment boundary (Table 4.9) was conducted on TU-1 through TU-6 and documented in the test report (ORNL/NTRC-013). Since each containment vessel was assembled at ambient conditions, the pressure was nominally 101.35 kPa (14.70 psi) at 25°C (77°F). In accordance with 10 CFR 71.73(b), for these tests, the initial pressure inside each containment vessel should be the maximum normal operating pressure. As shown in Tables 2.21 and 2.21a, the stresses at the maximum normal operating pressure are insignificant compared to the allowable stresses. Therefore, conducting compliance testing with nominal pressure in the containment vessel would have little, if any, effect on the results. During the structural and thermal tests conducted on the ES-3100 for HAC, the drum experienced plastic deformation, and the insulation and impact limiter material experienced some deterioration, as anticipated (Sect. 2.7). The containment vessels did not exhibit any signs of damage and passed post-test leak tests and the subsequent 10 CFR 71.73(c)(5)–specified 0.9-m (3-ft) water immersion tests except for TU-6. TU-6 was subjected to the test specified in 10 CFR 71.73(c)(6). After completion of this test, the containment vessel was removed and the lid was drilled and tapped for a helium leak-check port. The entire containment boundary was then helium leak checked and passed the leaktight criteria. Also, no visible water was seen inside the inner O-ring groove of TU-6 and no water was observed inside any of the other test units.

To verify the entire containment boundary to the leaktight criteria, the containment vessels of TU-1 through TU-5 were helium leak tested using the procedure shown in the test report (ORNL/NTRC-013). These test units had previously been subjected to the drop test stipulated in 10 CFR 71.71 (c)(6) and the sequential tests stipulated in 10 CFR 71.73 except for TU-4, which had been first subjected to the testing in accordance with 10 CFR 71.71. The maximum recorded helium leak rate for any of these containment vessels was 2.0×10^{-7} cm^3/s after 21 min of testing on TU-4 as documented in Sect. 5.2.2 of ORNL/NTRC-013. TU-2 and TU-5 displayed some unusual pulsing action during leak testing. The root cause of these oscillatory leak rates has not been determined. However, it is postulated that the seal around the machined port in the lid that is used for helium leak checking the test units was the cause of this unusual pattern. In accordance with the *ASME Boiler and Pressure Vessel Code*, Sect. V, Subsection A, Article 10, Appendix IX, "Helium Mass Spectrometer Test – Hood Technique," a system response time must be established to determine the helium leak testing duration. The fabricators of this package used this *ASME Boiler and Pressure Vessel Code* approach and determined that the system response time for their leak test setup with this containment vessel was ~15 s. To ensure that the leak detector steady-state (equilibrium) response is reached, the helium leak test duration was established at 2 min (8 × system response time). Since the helium leakage rates observed at NTRC (ORNL/NTRC-013), using a configuration similar to the fabricator's test arrangement, remained below the ANSI N14.5-1997 leak tight value for ~10 min, it was determined that the test duration was adequate and the units were leaktight. The peak amplitude changed after adding helium in a manner expected

for diffusion through the O-rings rather than a rise immediately following the addition of helium that would indicate a leak to the outside of the containment vessel. This is further discussed and graphically presented in Sect. 5.2.2 of ORNL/NTRC-013. These measured leakage rates verify that the containment vessels are leaktight in accordance with ANSI N14.5-1997. Therefore, the containment boundary of the ES-3100 package was maintained during the HAC testing.

The 35.2 kg of HEU content is unirradiated; therefore, only very small quantities of fission gas products will be produced from spontaneous fission and subcritical neutron induced fission. Fission gas products are produced in such small quantities that they have no measurable effect on the releasable content source term or containment vessel pressurization. Fission gas products will not be considered further in this SARP.

Table 4.8. Regulatory leakage criteria for HAC

Verification activity	Fast absorption		Medium absorption		Slow absorption	
	$L_{RA\text{ - air}}$ (ref-cm^3/s)	$L_{RA\text{ - He}}$ (cm^3/s)	$L_{RA\text{ - air}}$ (ref-cm^3/s)	$L_{RA\text{ - He}}$ (cm^3/s)	$L_{RA\text{ - air}}$ (ref-cm^3/s)	$L_{RA\text{ - He}}$ (cm^3/s)
Design [a]	1.5980E-01	1.5846E-01	1.5943E-01	1.5810E-01	1.5836E-01	1.5705E-01

[a] The procedure used to calculate the above criteria is shown in Appendix 4.5.2. This data has been extracted from Table 1 in Appendix 4.5.2.

Table 4.9. Containment vessel design verification tests for HAC

Test type	Test values	Leakage test procedure
Design and compliance leakage testing		
Design verification of O-ring seal (air)	$L_T \leq 1.0 \times 10^{-4}$ ref-cm^3/s	See ORNL/NTRC-013
Design verification of CV boundary (helium)	$L_T \leq 2.0 \times 10^{-7}$ cm^3/s	See ORNL/NTRC-013

4.4 LEAKAGE RATE TESTS FOR TYPE B PACKAGES

The maximum allowable release of radioactive material allowed by 10 CFR 71.51(a)(2) under HAC is A_2 in one week. Title 10 CFR 71.51(a)(2) also specifies that there be no escape of ^{85}Kr exceeding 10 A_2 in one week. ANSI N14.5-1997 specifies the leakage test methods and leakage rates that are accepted in NRC Regulatory Guide 7.4 as demonstrating that a package meets the 10 CFR 71.51(a)(2) requirements for containment. The containment criteria for the ES-3100 package will be leaktight, defined in ANSI N14.5 paragraph 2.1 as having a leakage rate $\leq 1 \times 10^{-7}$ ref-cm^3/s, during the prototype tests. This leaktight criterion satisfies the design verification requirement stipulated in paragraph 7.2.4 of ANSI N14.5-1997. With the exception of the periodic leakage rate testing frequency discussed below, the requirements of ANSI N14.5-1997 are used for all stages of containment demonstration for the ES-3100 leakage rate testing (i.e., design, fabrication, maintenance, periodic and preshipment). The design, fabrication, maintenance, and periodic leakage rate limit is 1×10^{-7} ref-cm^3/s air (or equivalent). Preshipment leakage rate testing, which demonstrates correct assembly of the containment vessel, shall be performed to the acceptance criterion of either (1) a leakage rate of not more than the reference air leakage rate, L_R, or (2) no detected leakage when tested to a sensitivity of at least 10^{-3} ref-cm^3/s (ANSI N14.5-1997, Subclause 7.6.4). The preshipment, fabrication, and maintenance leakage rate tests are required to be conducted on each containment vessel in accordance with ANSI N14.5-1997 and are specified in Chapters 7 and 8. In addition to these leakage tests, Subclause 7.5.2 of ANSI N14.5-1997 states that the periodic leakage rate testing shall be conducted within 12 months prior to each shipment. Testing of the ES-3100 and EPDM O-rings, documented in RP 801580-0022, provides the justification to extend the periodic leakage rate testing frequency to 24 months. Therefore, the periodic leakage rate testing specified in Chapter 8 shall be conducted in accordance with ANSI N14.5-1997 except for the frequency. These leakage rates are not dependent on filters or mechanical cooling.

The requirements of ANSI N14.5-1997 are used for all stages of containment verification for the ES-3100; the design (HAC test) leakage rate limit is 1×10^{-7} ref-cm^3/s (which is defined as leaktight in ANSI N14.5-1997). The packaging has been shown to maintain containment before and after prototype testing by leakage tests performed for containment verification to the requirements of ANSI N14.5-1997. TU-4's containment vessel was subjected to both the NCT and HAC tests. TU-1 through TU-5 were subjected to the free drop stipulated in 10 CFR 71.71(c)(7) and to the sequential HAC test stipulated in 10 CFR 71.73. Following these tests, each containment vessel was helium leak tested in accordance with the test plan. Again, the test results verified that the containment vessels were leaktight. Thus, there could be no release of radioactive materials from the containment vessels. These leakage rates are not dependent on filters or mechanical cooling. These measured leakage rates verify that the containment vessels are leaktight in accordance with ANSI N14.5-1997.

Therefore, the ES-3100 package meets the containment criteria as specified in 10 CFR 71.73 for HAC when shipping the proposed 35.2 kg of HEU in the containment vessel.

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4.5 APPENDIX

Appendix 4.5.1 Determination of A_2 for the ES-3100 Package with HEU Contents 4-15
Appendix 4.5.2 Calculation of the ES-3100 CV Regulatory Reference Air Leakage Rates 4-23
Appendix 4.5.3 Chapter 4 References 4-41

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Appendix 4.5.1
Determination of A_2 for the ES-3100 Package with HEU Contents

Introduction

The containment criteria for radioactive, fissile material packages are given in 10 CFR 71.51(a)(1) for Normal Conditions of Transport (NCT) [$\leq 10^{-6}$ A_2/h] and in 71.51(a)(2) for Hypothetical Accident Conditions (HAC) [$\leq A_2$ in a week]. The A_2 value for this mixture of radioisotopes must be determined to establish the content containment criteria and to determine the maximum release quantity that is allowed by the regulations. These values for a mixture of isotopes are determined by the methodology given in 10 CFR 71, Appendix A, "Determination of A_1 and A_2," Sect. IV. The results of these analyses are used to demonstrate compliance of the ES-3100 package with the containment requirements of 10 CFR 71.

Scope

The A_2 value of the highly enriched uranium (HEU) content to be shipped is evaluated based on the mass and weight percents of HEU shown in Table 1 and defined in Sect. 1.2.2. The weight percents shown in Table 1 are the ones that generate the largest activity within the allowable ranges presented in Sect. 1.2.2. Incorporating the new 10 CFR 71 A_2 values for the uranium isotopes, three different categories have been established based on the absorption rate of the uranium isotopes. The fast lung absorption, medium lung absorption, and slow lung absorption categories are addressed in subsequent sections. By applying the maximum weight percents of isotopes ^{232}U, ^{233}U, ^{234}U, ^{236}U and by incorporating the traces of ^{237}Np and the transuranic isotopes, the maximum activity, minimum A_2 value, and the minimum leakage requirements were determined for each category of absorption for the HEU contents. The mass and isotopic concentrations used for the proposed content do not take into consideration limits based on shielding and subcriticality.

Table 1. Isotopic mass and weight percent for the HEU contents [a]

Nuclide	Weight percent	Mass (g)
U-232	0.000004	0.001408
U-233	0.600000	211.200000
U-234	2.000000	704.000000
U-235	54.819996	19,296.638592
U-236	40.000000	14,080.000000
U-238	0.000000	0.000000
Transuranic	0.080000 [b]	28.160000
Np-237	2.500000	880.000000
Total	**100.000000**	**35,200.000000**

[a] Weight percents values of individual isotopes are those that generate the largest activity within the allowable ranges presented in Sect. 1.2.2.

[b] The transuranic weight percent of 0.080000 applies to ground transport only. The maximum transuranic weight percent in contents transported by air will be 0.004000.

According to 10 CFR 71, Appendix A, parent and daughter nuclides are considered to be a mixture of different nuclides than those of the parent nuclide. The radioactive decay of uranium [refer to

the decay chains presented by Dr. David C. Kocher, *Radioactive Decay Data Tables* (DOE/TIC-11026)] creates isotopes that will accumulate enough activity to exceed their respective criteria for limited quantities (49 CFR 173.425, Table 4, "Activity Limits for Limited Quantities, Instruments, and Articles") and for Type A quantities of radionuclides (10 CFR 71, Table A-1, "A_1 and A_2 Values for Radionuclides"). Furthermore, the A_2 value for the mixture will change over time as a result of radioactive decay. The analysis below shows that the A_2 value for this mixture reaches a minimum at initial fabrication, increases to the 10^{th} year, and declines through the 70^{th} year.

Analysis

Mass Tables. The mass and weight fractions for HEU isotopes used in the containment calculations are presented in Table 1. For conservatism, a small quantity of ^{232}U is assumed in this material at fabrication.

ORIGEN-S Results. The source terms of the isotopes in the mixtures were evaluated using the ORIGEN-S computer program (NUREG/CR-0200). The mass values for the parent and daughter products are presented in Table 2 for the time interval of 0–70 years. Contributions from the transuranics and ^{237}Np are held constant at each time interval during the 70-year evaluation.

The A_2 value of each mixture was calculated using the procedure shown in Tables 3, 4, and 5 for the above time intervals. The 70^{th} year of decay represents the smallest value of A_2 and the maximum activity-to-A_2 value ratio (the smallest maximum allowable leakage rate within the time interval examined). A summary of the content activity and the A_2 value of the various configurations for the above time interval is given in Table 6.

From Sect. 1.2.2, the activity and mass concentrations for the transuranics are 1.2×10^{7} Bq/gU and 800 µg/gU (ground transport only), respectively. Using a maximum uranium mass of 35.2 kg, the mass of transuranics is calculated to be 28.160 g and the activity is calculated to be 4.2240×10^{-1} TBq. Dividing this activity by the mass results in a specific activity of 1.5×10^{-2} TBq/g. In accordance with 10 CFR 71, Appendix A, Table A-3 for "contents with no relevant data," an A_2 value of 9.0×10^{-5} TBq is obtained.

Section 1.2.2 gives a maximum concentration for Np-237 of 0.025 g/gU. Using a maximum uranium mass of 35.2 kg, the mass of Np-237 is calculated to be 880 g. This value is used in Tables 3, 4, and 5 for the Np-237 contents.

Results

The containment criteria analysis indicates that the HEU contents must be shipped in a Type B material package since their activities are greater than the A_2 value. The smallest A_2 value of 1.5245×10^{-4} TBq (4.1203×10^{-3} Ci) in conjunction with the maximum activity-to-A_2 value ratio of 4,752.8 occurs after ~70 years of decay for the assumed maximum 35.2 kg of HEU.

Table 2. Mass values of parent and daughter products for 35.2 kg of HEU

Isotope	0 years	5 years	10 years	20 years	30 years	40 years	50 years	60 years	70 years
Pb-210	0.0000E+00	1.4150E-10	1.0912E-09	8.1664E-09	2.5555E-08	5.6672E-08	1.0349E-07	1.6896E-07	2.5274E-07
Pb-212	0.0000E+00	1.8163E-08	2.0275E-08	1.8867E-08	1.7037E-08	1.5488E-08	1.3996E-08	1.2672E-08	1.1475E-08
Bi-210	0.0000E+00	8.7296E-14	6.7302E-13	5.0054E-12	1.5770E-11	3.4918E-11	6.3923E-11	1.0419E-10	1.5558E-10
Bi-212	0.0000E+00	1.7178E-09	1.9149E-09	1.7882E-09	1.6192E-09	1.4643E-09	1.3277E-09	1.2024E-09	1.0884E-09
Po-210	0.0000E+00	2.4077E-12	1.8586E-11	1.3798E-10	4.3507E-10	9.6448E-10	1.7670E-09	2.8653E-09	4.2944E-09
Rn-222	0.0000E+00	1.4150E-12	5.6602E-12	2.2598E-11	5.0829E-11	9.0112E-11	1.4080E-10	2.0205E-10	2.7526E-10
Ra-223	0.0000E+00	6.5223E-12	2.4700E-11	8.9922E-11	1.8428E-10	2.9910E-10	4.3032E-10	5.7311E-10	7.2362E-10
Ra-224	0.0000E+00	1.5770E-07	1.7600E-07	1.6474E-07	1.4925E-07	1.3489E-07	1.2207E-07	1.1053E-07	1.0011E-07
Ra-225	0.0000E+00	2.1120E-08	4.5619E-08	9.1238E-08	1.3686E-07	1.8227E-07	2.2810E-07	2.7245E-07	3.1891E-07
Ra-226	0.0000E+00	2.2035E-07	8.8000E-07	3.5200E-06	7.8848E-06	1.4010E-05	2.1894E-05	3.1469E-05	4.2803E-05
Ra-228	0.0000E+00	2.0557E-13	6.8992E-13	2.0557E-12	3.6186E-12	5.2378E-12	6.8710E-12	8.5184E-12	1.0166E-11
Ac-225	0.0000E+00	1.6896E-08	3.0835E-08	6.1670E-08	9.2506E-08	1.2313E-07	1.5396E-07	1.8459E-07	2.1542E-07
Ac-227	0.0000E+00	4.6119E-09	1.7541E-08	6.3486E-08	1.3025E-07	2.1226E-07	3.0489E-07	4.0523E-07	5.1136E-07
Ac-228	0.0000E+00	2.5062E-17	8.4198E-17	2.5062E-16	4.4070E-16	6.3923E-16	8.3917E-16	1.0391E-15	1.2404E-15
Th-227	0.0000E+00	1.0710E-11	4.0716E-11	1.4762E-10	3.0296E-10	4.9206E-10	7.0819E-10	9.4168E-10	1.1906E-09
Th-228	0.0000E+00	3.0694E-05	3.4214E-05	3.1962E-05	2.9005E-05	2.6189E-05	2.3795E-05	2.1542E-05	1.9430E-05
Th-229	0.0000E+00	6.3360E-03	9.0394E-03	1.8058E-02	2.7034E-02	3.6115E-02	4.4986E-02	5.4067E-02	6.3149E-02
Th-230	0.0000E+00	9.7856E-03	1.9501E-02	3.9072E-02	5.8573E-02	7.8144E-02	9.7856E-02	1.1686E-01	1.3658E-01
Th-231	0.0000E+00	7.8537E-08	7.8537E-08	7.8537E-08	7.8537E-08	7.8537E-08	7.8537E-08	7.8537E-08	7.8537E-08
Th-232	0.0000E+00	2.0416E-03	4.0973E-03	8.1946E-03	1.2292E-02	1.6333E-02	2.0416E-02	2.4640E-02	2.8723E-02
Th-234	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00
Pa-231	0.0000E+00	9.3396E-05	1.8698E-04	3.7435E-04	5.6153E-04	7.4678E-04	9.3396E-04	1.1211E-03	1.3064E-03
Pa-233	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00
U-232	1.4080E-03	1.3376E-03	1.2742E-03	1.1546E-03	1.0447E-03	9.4618E-04	8.5747E-04	7.7581E-04	7.0259E-04
U-233	2.1120E+02	2.1119E+02	2.1119E+02	2.1118E+02	2.1117E+02	2.1116E+02	2.1116E+02	2.1115E+02	2.1114E+02
U-234	7.0400E+02	7.0399E+02	7.0398E+02	7.0396E+02	7.0394E+02	7.0392E+02	7.0390E+02	7.0388E+02	7.0386E+02
U-235	1.9297E+04	1.9297E+04	1.9297E+04	1.9297E+04	1.9297E+04	1.9297E+04	1.9297E+04	1.9297E+04	1.9297E+04
U-236	1.4080E+04	1.4080E+04	1.4080E+04	1.4080E+04	1.4080E+04	1.4080E+04	1.4080E+04	1.4080E+04	1.4080E+04
U-238	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00	0.0000E+00
Trans.	2.8160E+01	2.8160E+01	2.8160E+01	2.8160E+01	2.8160E+01	2.8160E+01	2.8160E+01	2.8160E+01	2.8160E+01
Np-237	8.8000E+02	8.8000E+02	8.8000E+02	8.8000E+02	8.8000E+02	8.8000E+02	8.8000E+02	8.8000E+02	8.8000E+02
Total	**3.5200E+04**	**3.5200E+04**	**3.5200E+04**	**3.5200E+04**	**3.5200E+04**	**3.5200E+04**	**3.5200E+04**	**3.5200E+04**	**3.5200E+04**

Table 3. A_2 value calculation for 35.2 kg HEU for fast absorption uranium at 70 years

Isotope	Mass at 70 years (g)	Specific activity (TBq/g)	Activity (TBq)	A_2 (TBq)	f(i) (TBq/TBq)	f(i) / A_2 (1/TBq)
Pb-210	2.5274E-07	2.8000E+00	7.0767E-07	5.0000E-02	9.7669E-07	1.9534E-05
Pb-212	1.1475E-08	5.1000E+04	5.8523E-04	2.0000E-01	8.0770E-04	4.0385E-03
Bi-210	1.5558E-10	4.6000E+03	7.1567E-07	6.0000E-01	9.8773E-07	1.6462E-06
Bi-212	1.0884E-09	5.4000E+05	5.8774E-04	6.0000E-01	8.1116E-04	1.3519E-03
Po-210	4.2944E-09	1.7000E+02	7.3005E-07	2.0000E-02	1.0076E-06	5.0379E-05
Rn-222	2.7526E-10	5.7000E+03	1.5690E-06	4.0000E-03	2.1654E-06	5.4136E-04
Ra-223	7.2362E-10	1.9000E+03	1.3749E-06	7.0000E-03	1.8975E-06	2.7108E-04
Ra-224	1.0011E-07	5.9000E+03	5.9065E-04	2.0000E-02	8.1518E-04	4.0759E-02
Ra-225	3.1891E-07	1.5000E+03	4.7837E-04	4.0000E-03	6.6022E-04	1.6505E-01
Ra-226	4.2803E-05	3.7000E-02	1.5837E-06	3.0000E-03	2.1858E-06	7.2859E-04
Ra-228	1.0166E-11	1.0000E+01	1.0166E-10	2.0000E-02	1.4031E-10	7.0153E-09
Ac-225	2.1542E-07	2.1000E+03	4.5238E-04	6.0000E-03	6.2435E-04	1.0406E-01
Ac-227	5.1136E-07	2.7000E+00	1.3807E-06	9.0000E-05	1.9055E-06	2.1173E-02
Ac-228	1.2404E-15	8.4000E+04	1.0419E-10	5.0000E-01	1.4380E-10	2.8761E-10
Th-227	1.1906E-09	1.1000E+03	1.3097E-06	5.0000E-03	1.8075E-06	3.6151E-04
Th-228	1.9430E-05	3.0000E+01	5.8290E-04	1.0000E-03	8.0449E-04	8.0449E-01
Th-229	6.3149E-02	7.9000E-03	4.9888E-04	5.0000E-04	6.8852E-04	1.3771E+00
Th-230	1.3658E-01	7.6000E-04	1.0380E-04	1.0000E-03	1.4326E-04	1.4326E-01
Th-231	7.8537E-08	2.0000E+04	1.5707E-03	2.0000E-02	2.1679E-03	1.0839E-01
Th-232	2.8723E-02	4.0000E-09	1.1489E-10	UNLIMITED	1.5857E-10	--
Pa-231	1.3064E-03	1.7000E-03	2.2209E-06	4.0000E-04	3.0651E-06	7.6628E-03
U-232	7.0259E-04	8.3000E-01	5.8315E-04	1.0000E-02	8.0483E-04	8.0483E-02
U-233	2.1114E+02	3.6000E-04	7.6010E-02	9.0000E-02	1.0491E-01	1.1656E+00
U-234	7.0386E+02	2.3000E-04	1.6189E-01	9.0000E-02	2.2343E-01	2.4825E+00
U-235	1.9297E+04	8.0000E-08	1.5438E-03	UNLIMITED	2.1306E-03	--
U-236	1.4080E+04	2.4000E-06	3.3792E-02	UNLIMITED	4.6638E-02	--
Transuranic	2.8160E+01	1.5000E-02	4.2240E-01	9.0000E-05	5.8298E-01	6.4775E+03
Np-237	8.8000E+02	2.6000E-05	2.2880E-02	2.0000E-03	3.1578E-02	1.5789E+01
Total Mass =	**3.5200E+04**	**∑ Act. =**	**7.2456E-01**		**∑ f(i) / A_2 =**	**6.4998E+03**

$$A_2 \text{ (mixture)} = \frac{1}{\sum f(i)/A_2} = \frac{1}{6.4998 \times 10^3 \text{ (1/TBq)}} = 1.5385 \times 10^{-4} \text{ TBq}$$

Table 4. A_2 value calculation for 35.2 kg HEU for medium absorption uranium at 70 years

Isotope	Mass at 70 years (g)	Specific activity (TBq/g)	Activity (TBq)	A_2 (TBq)	f(i) (TBq/TBq)	f(i) / A_2 (1/TBq)
Pb-210	2.5274E-07	2.8000E+00	7.0767E-07	5.0000E-02	9.7669E-07	1.9534E-05
Pb-212	1.1475E-08	5.1000E+04	5.8523E-04	2.0000E-01	8.0770E-04	4.0385E-03
Bi-210	1.5558E-10	4.6000E+03	7.1569E-07	6.0000E-01	9.8775E-07	1.6463E-06
Bi-212	1.0884E-09	5.4000E+05	5.8773E-04	6.0000E-01	8.1115E-04	1.3519E-03
Po-210	4.2944E-09	1.7000E+02	7.3005E-07	2.0000E-02	1.0076E-06	5.0379E-05
Rn-222	2.7526E-10	5.7000E+03	1.5690E-06	4.0000E-03	2.1655E-06	5.4137E-04
Ra-223	7.2362E-10	1.9000E+03	1.3749E-06	7.0000E-03	1.8975E-06	2.7108E-04
Ra-224	1.0011E-07	5.9000E+03	5.9064E-04	2.0000E-02	8.1517E-04	4.0759E-02
Ra-225	3.1891E-07	1.5000E+03	4.7837E-04	4.0000E-03	6.6022E-04	1.6505E-01
Ra-226	4.2803E-05	3.7000E-02	1.5837E-06	3.0000E-03	2.1858E-06	7.2859E-04
Ra-228	1.0166E-11	1.0000E+01	1.0166E-10	2.0000E-02	1.4030E-10	7.0151E-09
Ac-225	2.1542E-07	2.1000E+03	4.5239E-04	6.0000E-03	6.2437E-04	1.0406E-01
Ac-227	5.1136E-07	2.7000E+00	1.3807E-06	9.0000E-05	1.9055E-06	2.1173E-02
Ac-228	1.2404E-15	8.4000E+04	1.0420E-10	5.0000E-01	1.4381E-10	2.8762E-10
Th-227	1.1906E-09	1.1000E+03	1.3097E-06	5.0000E-03	1.8075E-06	3.6151E-04
Th-228	1.9430E-05	3.0000E+01	5.8291E-04	1.0000E-03	8.0451E-04	8.0451E-01
Th-229	6.3149E-02	7.9000E-03	4.9888E-04	5.0000E-04	6.8852E-04	1.3770E+00
Th-230	1.3658E-01	7.6000E-04	1.0380E-04	1.0000E-03	1.4326E-04	1.4326E-01
Th-231	7.8537E-08	2.0000E+04	1.5707E-03	2.0000E-02	2.1679E-03	1.0839E-01
Th-232	2.8723E-02	4.0000E-09	1.1489E-10	UNLIMITED	1.5857E-10	--
Pa-231	1.3064E-03	1.7000E-03	2.2209E-06	4.0000E-04	3.0651E-06	7.6628E-03
U-232	7.0259E-04	8.3000E-01	5.8315E-04	7.0000E-03	8.0484E-04	1.1498E-01
U-233	2.1114E+02	3.6000E-04	7.6009E-02	2.0000E-02	1.0490E-01	5.2452E+00
U-234	7.0386E+02	2.3000E-04	1.6189E-01	2.0000E-02	2.2343E-01	1.1172E+01
U-235	1.9297E+04	8.0000E-08	1.5437E-03	UNLIMITED	2.1306E-03	--
U-236	1.4080E+04	2.4000E-06	3.3792E-02	2.0000E-02	4.6638E-02	2.3319E+00
Transuranic	2.8160E+01	1.5000E-02	4.2240E-01	9.0000E-05	5.8298E-01	6.4775E+03
Np-237	8.8000E+02	2.6000E-05	2.2880E-02	2.0000E-03	3.1578E-02	1.5789E+01
Total Mass =	**3.5200E+04**	**∑ Act. =**	**7.2456E-01**		**∑ f(i) / A2 =**	**6.5149E+03**

$$A_2 \text{ (mixture)} = \frac{1}{\sum f(i)/A_2} = \frac{1}{6.5149 \times 10^3 \text{ (1/TBq)}} = 1.5349 \times 10^{-4} \text{ TBq}$$

Table 5. A_2 value calculation for 35.2 kg HEU for slow absorption uranium at 70 years

Isotope	Mass at 70 years (g)	Specific activity (TBq/g)	Activity (TBq)	A_2 (TBq)	f(i) (TBq/TBq)	f(i) / A_2 (1/TBq)
Pb-210	2.5274E-07	2.8000E+00	7.0766E-07	5.0000E-02	9.7668E-07	1.9534E-05
Pb-212	1.1475E-08	5.1000E+04	5.8524E-04	2.0000E-01	8.0771E-04	4.0386E-03
Bi-210	1.5558E-10	4.6000E+03	7.1569E-07	6.0000E-01	9.8775E-07	1.6463E-06
Bi-212	1.0884E-09	5.4000E+05	5.8773E-04	6.0000E-01	8.1115E-04	1.3519E-03
Po-210	4.2944E-09	1.7000E+02	7.3005E-07	2.0000E-02	1.0076E-06	5.0379E-05
Rn-222	2.7526E-10	5.7000E+03	1.5690E-06	4.0000E-03	2.1655E-06	5.4137E-04
Ra-223	7.2362E-10	1.9000E+03	1.3749E-06	7.0000E-03	1.8975E-06	2.7108E-04
Ra-224	1.0011E-07	5.9000E+03	5.9064E-04	2.0000E-02	8.1517E-04	4.0759E-02
Ra-225	3.1891E-07	1.5000E+03	4.7837E-04	4.0000E-03	6.6022E-04	1.6505E-01
Ra-226	4.2803E-05	3.7000E-02	1.5837E-06	3.0000E-03	2.1858E-06	7.2859E-04
Ra-228	1.0166E-11	1.0000E+01	1.0166E-10	2.0000E-02	1.4030E-10	7.0151E-09
Ac-225	2.1542E-07	2.1000E+03	4.5239E-04	6.0000E-03	6.2437E-04	1.0406E-01
Ac-227	5.1136E-07	2.7000E+00	1.3807E-06	9.0000E-05	1.9055E-06	2.1173E-02
Ac-228	1.2404E-15	8.4000E+04	1.0420E-10	5.0000E-01	1.4381E-10	2.8762E-10
Th-227	1.1906E-09	1.1000E+03	1.3097E-06	5.0000E-03	1.8075E-06	3.6151E-04
Th-228	1.9430E-05	3.0000E+01	5.8291E-04	1.0000E-03	8.0451E-04	8.0451E-01
Th-229	6.3149E-02	7.9000E-03	4.9888E-04	5.0000E-04	6.8852E-04	1.3770E+00
Th-230	1.3658E-01	7.6000E-04	1.0380E-04	1.0000E-03	1.4326E-04	1.4326E-01
Th-231	7.8537E-08	2.0000E+04	1.5707E-03	2.0000E-02	2.1679E-03	1.0839E-01
Th-232	2.8723E-02	4.0000E-09	1.1489E-10	UNLIMITED	1.5857E-10	--
Pa-231	1.3064E-03	1.7000E-03	2.2209E-06	4.0000E-04	3.0651E-06	7.6628E-03
U-232	7.0259E-04	8.3000E-01	5.8315E-04	1.0000E-03	8.0484E-04	8.0484E-01
U-233	2.1114E+02	3.6000E-04	7.6009E-02	6.0000E-03	1.0490E-01	1.7484E+01
U-234	7.0386E+02	2.3000E-04	1.6189E-01	6.0000E-03	2.2343E-01	3.7238E+01
U-235	1.9297E+04	8.0000E-08	1.5437E-03	UNLIMITED	2.1306E-03	--
U-236	1.4080E+04	2.4000E-06	3.3792E-02	6.0000E-03	4.6638E-02	7.7730E+00
Transuranic	2.8160E+01	1.5000E-02	4.2240E-01	9.0000E-05	5.8298E-01	6.4775E+03
Np-237	8.8000E+02	2.6000E-05	2.2880E-02	2.0000E-03	3.1578E-02	1.5789E+01
Total Mass =	**3.5200E+04**	**∑ Act. =**	**7.2456E-01**		**∑ f(i) / A_2 =**	**6.5594E+03**

$$A_2 \text{ (mixture)} = \frac{1}{\sum f(i)/A_2} = \frac{1}{6.5594 \times 10^3 \text{ (1/TBq)}} = 1.5245 \times 10^{-4} \text{ TBq}$$

Table 6. Activity, A_2 value, and activity-to-A_2 ratio for the enriched uranium contents

Year	Activity (TBq)	A_2-Mixture (TBq)			Activity/A_2		
		Fast	Medium	Slow	Fast	Medium	Slow
0	7.1974E-01	1.5289E-04	1.5253E-04	1.5148E-04	4707.57	4718.68	4751.39
5	7.2507E-01	1.5399E-04	1.5363E-04	1.5257E-04	4708.55	4719.59	4752.38
10	7.2554E-01	1.5408E-04	1.5372E-04	1.5267E-04	4708.85	4719.88	4752.34
20	7.2538E-01	1.5404E-04	1.5368E-04	1.5263E-04	4709.04	4720.07	4752.54
30	7.2514E-01	1.5399E-04	1.5363E-04	1.5258E-04	4709.01	4720.04	4752.52
40	7.2494E-01	1.5394E-04	1.5358E-04	1.5254E-04	4709.24	4720.28	4752.46
50	7.2478E-01	1.5390E-04	1.5355E-04	1.5250E-04	4709.42	4720.16	4752.66
60	7.2465E-01	1.5387E-04	1.5352E-04	1.5247E-04	4709.50	4720.23	4752.74
70	7.2456E-01 [a]	1.5385E-04	1.5349E-04	1.5245E-04 [a]	4709.52	4720.57	4752.77 [a]

[a] The A_2, total activity, and activity-to-A_2 ratio values used in Appendix 4.5.2.

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Appendix 4.5.2
Calculation of the ES-3100 CV Regulatory Reference Air Leakage Rates

Introduction

The ES-3100 leak-testing requirements of the containment boundary are based on the smallest maximum allowable leakage rate generated from the maximum uranium content defined in Table 4.3. Section 5 of ANSI N14.5-1997 defines the maximum allowable leakage rate based on the maximum allowable release rate. These leakage rates, L_N and L_A, are the maximum allowable O-ring seal leakage rates for Normal Conditions of Transport (NCT) and Hypothetical Accident Conditions (HAC). The worst-case maximum allowable leakage rates are used to calculate an equivalent leakage hole diameter following ANSI N14.5-1997, Appendix B, for each condition of transport. This leakage hole diameter is used to calculate a reference air and a helium leakage rate for leak testing. A bounding mass for the highly enriched uranium (HEU) content of 35.2 kg is used in this calculation to certify the ES-3100 package for shipment. The maximum allowable leakage rates are calculated using this maximum content mass in a much more dispersive form (oxide powder) at the highest calculated pressures and temperatures. This appendix shows the procedure used to calculate the leak criteria for the uranium constituents in the "slow lung absorption" group. Table 1 shows the results of using this procedure for fast, medium, and slow absorption uranium constituents as a function of decay time.

HEU Content

Calculate R_N and R_A: (Table 4.1)

The maximum allowable release rate is based on using A_2.

$A_2 = 1.5245 \times 10^{-4}$ TBq, (4.1203×10^{-3} Ci). [Table 6 (Appendix 4.5.1)]

The containment requirements for NCT and HAC are:

$R_N = A_2 \times 10^{-6}$ TBq/h,
$= A_2 \times 2.78 \times 10^{-10}$ TBq/s, [ANSI N14.5-1997 (Eq. 1)]
$= 1.5245 \times 10^{-4} \times 2.78 \times 10^{-10}$ TBq/s,
$= 4.2382 \times 10^{-14}$ TBq/s, (1.1455×10^{-12} Ci/s).

$R_A = A_2$ (TBq/week),
$= A_2 \times 1.65 \times 10^{-6}$ (TBq/s), [ANSI N14.5-1997 (Eq. 2)]
$= 1.5245 \times 10^{-4} \times 1.65 \times 10^{-6}$ TBq/s,
$= 2.5155 \times 10^{-10}$ TBq/s, (6.7986×10^{-9} Ci/s). (or limited to 10 A_2/week of ^{85}Kr)

Following ANSI N14.5-1997, the medium aerosol activity must be calculated to determine the leakage rates.

m = total nuclide mass in the package available for release (g),
TotA = total activity in the package available for release (TBq),
TSA = total specific activity in the package available for release (TBq/g).

Table 1. Regulatory leakage criteria for 35.2 kg of HEU

Years from fabrication		NCT		HAC	
		$L_{RN - air}$ (ref-cm^3/s)	$L_{RN - He}$ (cm^3/s)	$L_{RA - air}$ (ref-cm^3/s)	$L_{RA - He}$ (cm^3/s)
Fast absorption	0	1.4157E-04	1.7423E-04	1.5986E-01	1.5852E-01
	5	1.4154E-04	1.7419E-04	1.5982E-01	1.5848E-01
	10	1.4153E-04	1.7418E-04	1.5982E-01	1.5848E-01
	20	1.4153E-04	1.7418E-04	1.5982E-01	1.5847E-01
	30	1.4153E-04	1.7417E-04	1.5981E-01	1.5847E-01
	40	1.4152E-04	1.7417E-04	1.5981E-01	1.5847E-01
	50	1.4152E-04	1.7417E-04	1.5981E-01	1.5847E-01
	60	1.4152E-04	1.7416E-04	1.5980E-01	1.5846E-01
	70	1.4151E-04	1.7416E-04	1.5980E-01	1.5846E-01
Medium absorption	0	1.4125E-04	1.7385E-04	1.5949E-01	1.5816E-01
	5	1.4121E-04	1.7381E-04	1.5945E-01	1.5812E-01
	10	1.4121E-04	1.7380E-04	1.5945E-01	1.5812E-01
	20	1.4121E-04	1.7380E-04	1.5945E-01	1.5811E-01
	30	1.4120E-04	1.7380E-04	1.5944E-01	1.5811E-01
	40	1.4120E-04	1.7379E-04	1.5944E-01	1.5811E-01
	50	1.4120E-04	1.7379E-04	1.5944E-01	1.5811E-01
	60	1.4119E-04	1.7379E-04	1.5943E-01	1.5810E-01
	70	1.4119E-04	1.7378E-04	1.5943E-01	1.5810E-01
Slow absorption	0	1.4029E-04	1.7273E-04	1.5840E-01	1.5710E-01
	5	1.4026E-04	1.7270E-04	1.5837E-01	1.5706E-01
	10	1.4025E-04	1.7269E-04	1.5836E-01	1.5706E-01
	20	1.4025E-04	1.7269E-04	1.5840E-01	1.5710E-01
	30	1.4025E-04	1.7269E-04	1.5837E-01	1.5706E-01
	40	1.4025E-04	1.7269E-04	1.5836E-01	1.5706E-01
	50	1.4025E-04	1.7269E-04	1.5840E-01	1.5710E-01
	60	1.4025E-04	1.7269E-04	1.5837E-01	1.5706E-01
	70	1.4025E-04	1.7269E-04	1.5836E-01	1.5706E-01

For HEU content:

$$\begin{aligned} TSA &= TotA / m, \\ &= 7.2456 \times 10^{-1}\ (TBq) / 35{,}200\ (g), && \text{[Table 6 (Appendix 4.5.1)]} \\ &= 2.0584 \times 10^{-5}\ TBq/g, \\ \rho_P &= 9 \times 10^{-6}\ g/cm^3. && \text{(The maximum density of powder aerosols in the fill gas)} \end{aligned}$$

For any packaging arrangement:

$$\begin{aligned} C_N &= \text{activity per unit volume of medium that could escape from the containment system } (TBq/cm^3), \\ &= TSA \times \rho_P, \\ &= 2.0584 \times 10^{-5}\ (TBq/g) \times 9 \times 10^{-6}\ (g/cm^3), \\ &= 1.8526 \times 10^{-10}\ TBq/cm^3. \end{aligned}$$

Using Curren's maximum aerosol density, $C_A = C_N$:

$$\begin{aligned} C_A &= \text{activity per unit volume of exiting gas } (TBq/cm^3), && \text{(HAC)} \\ &= 1.8526 \times 10^{-10}\ TBq/cm^3. \end{aligned}$$

Section 6.1 of ANSI N14.5-1997 calculates L_N with (Eq. 3) and L_A with (Eq. 4). L_N and L_A are the maximum allowable leakage rates for the containment vessel fill gas aerosol during NCT and HAC, respectively.

$$\begin{aligned} L_N &= \text{maximum allowable leakage rate for the medium for NCT } (TBq/cm^3), \\ &= R_N / C_N, && \text{[ANSI N14.5-1997 (Eq. 3)]} \\ &= 4.2382 \times 10^{-14}\ (TBq/s) / 1.8526 \times 10^{-10}\ (TBq/cm^3), \\ &= 2.2878 \times 10^{-4}\ cm^3/s, \end{aligned}$$

$$\begin{aligned} L_A &= \text{maximum allowable leakage rate for the medium for HAC } (TBq/cm^3), \\ &= R_A / C_A, \\ &= 2.5155 \times 10^{-10}\ (TBq/s) / 1.8526 \times 10^{-10}\ (TBq/cm^3), \\ &= 1.3578\ cm^3/s. \end{aligned}$$

L_N and L_A correspond to the upstream volumetric leakage rate (L_u) at the upstream pressure (P_u) in the ANSI N14.5-1997 formulas for use later in this appendix. The reference air leakage rates $L_{R,N}$ and $L_{R,A}$ for NCT and HAC, based on the L_N and L_A, are then calculated using the maximum temperatures and pressure combinations from Table 7 in Appendix 3.5.1 (NCT) and from Table 7 in Appendix 3.5.2 (HAC) as the basis. For conservatism, the latter values have been rounded up to compensate for numerical tolerance issues. Therefore, the following analyses will use a pressure of 30.50 psia at a temperature of 194°F for the NCT evaluation and a pressure of 175.0 psia at a temperature of 334°F for the HAC evaluation.

Determination of the Leakage Test Procedure Requirements for the HEU Content

This calculation will examine the most conservative effects of a fully loaded containment vessel with an HEU mass of 35.2 kg. The smallest allowable leakage values are shown in Tables 4.5 and 4.8. The A_2 value and the maximum content activity-to-A_2 value ratio for this mixture were calculated for several different decay times (Table 6, Appendix 4.5.1). As calculated in Appendix 4.5.1, the A_2 value

and the maximum content activity-to-A_2 ratio used to qualify this package occur at ~70 years of decay and are 1.5245×10^{-4} TBq (4.1203×10^{-3} Ci) and 4,752.8 respectively. These values are used to determine the leakage test procedural requirements when packaging any convenience cans/contents arrangements in the ES-3100 package. The convenience cans/contents are sealed inside the containment vessel in an environmentally controlled area.

The following analysis determines the maximum allowable O-ring seal air reference leakage rate for both NCT and HAC. The ANSI N14.5-1997 recommended method using a straight circular tube to model the leakage path is applied. Using this "standard" leakage hole model permits the calculation of equivalent reference leakage rates from which leak-test requirements can be established. Viscosity data for air and helium used in the following analyses were obtained from curve fitting routines at specific temperatures based on viscosity data for air (*CRC Handbook of Chemistry and Physics*) and helium (NBS Technical Note 631).

L_N and L_A correspond to the upstream volumetric leakage rate (L_u) at the upstream pressure (P_u).

$$L_N = 2.2878 \times 10^{-4} \text{ cm}^3/\text{s},$$
$$L_A = 1.3578 \text{ cm}^3/\text{s}.$$

Find the maximum pressure and temperature in the containment vessel:

Converting the temperature to degrees Kelvin:

$$T = 273.15 + T\ (°C),$$
$$= 273.15 + 5 / 9\ (°F - 32)\ (K),$$

$$T_N = 273.15 + 5 / 9\ (194°F - 32)\ (K), \quad (T = 194°F)$$
$$= 363.15 \text{ K}, \quad (NCT)$$

$$T_A = 273.15 + 5 / 9\ (334°F - 32)\ (K), \quad (T = 334°F)$$
$$= 440.93 \text{ K}. \quad (HAC)$$

Converting the pressures from psia to atmospheres:

$$P_N = P\ (psia) / 14.696\ (psia/atm), \quad (\text{where P is the pressure in Sect. } 3.3.2)$$
$$= 30.5\ (psia) / 14.696\ (psia/atm), \quad (\text{rounded up for NCT})$$
$$= 2.0754 \text{ atm},$$

$$P_A = P\ (psia) / 14.696\ (psia/atm), \quad (\text{where P is the pressure in Sect. } 3.4.2)$$
$$= 175.0\ (psia) / 14.696\ (psia/atm), \quad (\text{rounded up for HAC})$$
$$= 11.9080 \text{ atm}.$$

NCT Leakage Hole Diameter for the HEU Content

The following calculations determine the leakage hole diameter that generates the maximum allowable leakage rate during NCT. To keep these calculations conservative, the maximum values for temperature and pressure were used as steady-state conditions for NCT.

Input data for NCT with air fill gas:

$L_N = 2.2878 \times 10^{-4}$ cm^3/s, (Maximum upstream leakage)
$P_u = 2.0754$ atm, (Upstream pressure = 30.5 psia)
$P_d = 0.2382$ atm, [Downstream pressure = 3.5 psia, per 10 CFR 71.71(3)]
$a = 0.3531$ cm, (Leak path length, 0.139-in. O-ring section diameter)
$T = 363.15$ K, (Fill gas temperature = 194°F)
$\mu = 0.02150$ cP, (Viscosity at temperature)
$M = 29$ g/g-mol. (Molecular weight of fill gas)

The average pressure is:

$$P_a = (P_u + P_d) / 2,$$
$$= (2.0754 + 0.2382) / 2,$$
$$= 1.1568 \text{ atm.} \quad \text{(Average pressure during NCT)}$$

According to ANSI N14.5-1997, the flow leakage hole diameter is unknown. Therefore, the mass-like leakage flow rate must be calculated to calculate the average leakage flow rate.

Q is the mass-like leakage for flow using the upstream leakage, L_u, and pressure, P_u:

$$Q = P_u L_u, \quad \text{(Eq. B1)}$$
$$L_u = L_N, \quad \text{(NCT leakage)}$$

$$Q = (2.0754)(\text{atm})\ (2.2878 \times 10^{-4})(\text{cm}^3/\text{s}),$$
$$= 4.7481 \times 10^{-4} \text{ atm-cm}^3/\text{s}, \quad \text{(NCT mass-like leakage rate)}$$

$$Q = P_a L_a, \quad \text{(Eq. B1)}$$

$$L_a = Q / P_a,$$
$$= 4.7481 \times 10^{-4} \text{ (atm-cm}^3/\text{s)} / (1.1568) \text{ (atm)},$$
$$= 4.1045 \times 10^{-4} \text{ cm}^3/\text{s}. \quad \text{(NCT average leakage rate)}$$

Solve equations B2–B4 from ANSI N14.5-1997:

$$L_a = (F_c + F_m)(P_u - P_d) \text{ cm}^3/\text{s}, \quad \text{(Eq. B2)}$$
$$= (F_c + F_m)(2.0754 - 0.2382),$$
$$= (1.8372)(F_c + F_m) \text{ cm}^3/\text{s},$$

$$F_c = (2.49 \times 10^6) D^4 / (a \mu) \text{ (cm}^3/\text{atm-s)}, \quad \text{(Eq. B3)}$$
$$= (2.49 \times 10^6) D^4 / [(0.3531)(0.02150)],$$
$$= (3.2795 \times 10^8) D^4 \text{ cm}^3/\text{atm-s},$$

$$F_m = (3.81 \times 10^3) D^3 (T / M)^{.5} / (a P_a) \text{ (cm}^3/\text{atm-s)}, \quad \text{(Eq. B4)}$$
$$= (3.81 \times 10^3) D^3 (363.15 / 29)^{.5} / [(0.3531)(1.1568)],$$
$$= (3.3012 \times 10^4) D^3 \text{ cm}^3/\text{atm-s}.$$

From the mass-like leakage calculation:

$L_a = 4.1045 \times 10^{-4}$ cm^3/s. (NCT average leakage rate)

Find the leakage hole diameter that sets:

$L_2 = L_a$.

Using the equations:

$L_2 = (1.8372)\ (F_c + F_m)$ cm^3/s,
$F_c = (3.2795 \times 10^8)\ D^4$ cm^3/atm-s,
$F_m = (3.3012 \times 10^4)\ D^3$ cm^3/atm-s.

To get a better guess on a new D, use:

$D = D_2\ (L_a / L_2)^{0.252}$.

Now a guess must be made for D_2 to solve Eq. B2 for NCT:

D_2 = 0.001 cm, and solve for $L_a = 4.1045 \times 10^{-4}$ cm^3/s. (NCT average leakage rate)

Diameter	F_c	F_m	L_2	L_a / L_2
1.0000E-03	3.2795E-04	3.3012E-05	6.6318E-04	0.61891
8.8612E-04	2.0220E-04	2.2969E-05	4.1368E-04	0.99218
8.8437E-04	2.0060E-04	2.2833E-05	4.1051E-04	0.99986
8.8433E-04	2.0058E-04	2.2831E-05	4.1045E-04	1.00000

The NCT leakage hole diameter for the HEU oxide content:

$D = 8.8433 \times 10^{-4}$ cm. (NCT diameter)

NCT Reference Air Leakage Rate for HEU Content

The leakage hole diameter found for the maximum allowable leakage rate for NCT will be used to determine the reference air leakage rate. O-ring seal leakage testing must ensure that no leakage is greater than the leakage generated by the hole diameter $D = 8.8433 \times 10^{-4}$ cm. Therefore, the NCT reference leakage flow rate ($L_{R, N}$) must be calculated to determine the allowable test leakage rate.

Input data for NCT reference air leakage rate:

$D = 8.8433 \times 10^{-4}$ cm, (From NCT)
$a = 0.3531$ cm, (Leak path length, 0.139-in. O-ring section diameter)
$P_u = 1.0$ atm, (Upstream pressure)
$P_d = 0.01$ atm, (Downstream pressure)
$T = 298$ K, (Fill gas temperature, 77°F)

$M = 29$ g/g-mol, (Molecular weight of air)

$\mu = 0.0185$ cP, (Viscosity of air at reference temperature)

Calculate P_a:

$$P_a = (P_u + P_d) / 2,$$
$$= (1.0 + 0.01) /2,$$
$$= 0.505 \text{ atm}, \quad \text{(NCT average pressure)}$$

$$F_c = (2.49 \times 10^6) D^4 / (a \mu) \text{ (cm}^3\text{/atm-s)}, \quad \text{(Eq. B3)}$$
$$= (2.49 \times 10^6) (8.8433 \times 10^{-4})^4 / [(0.3531) (0.0185)],$$
$$= (3.8122 \times 10^8) (8.8433 \times 10^{-4})^4,$$
$$= 2.3316 \times 10^{-4} \text{ cm}^3\text{/atm-s},$$

$$F_m = (3.81 \times 10^3) D^3 (T / M)^{.5} / (a P_a) \text{ (cm}^3\text{/atm-s)}, \quad \text{(Eq. B4)}$$
$$= (3.81 \times 10^3) (8.8433 \times 10^{-4})^3 (298 / 29)^{.5} / [(0.3531) (0.505)],$$
$$= (6.8501 \times 10^4) (8.8433 \times 10^{-4})^3,$$
$$= 4.7374 \times 10^{-5} \text{ cm}^3\text{/atm-s},$$

$$L_u = (F_c + F_m) (P_u - P_d) (P_a / P_u) \text{ (cm}^3\text{/s)}, \quad \text{(Eq. B5)}$$
$$= (2.3316 \times 10^{-4} + 4.7374 \times 10^{-5})(\text{cm}^3\text{/atm-s}) (1.0 - 0.01)(\text{atm}) (0.505 / 1.0),$$
$$= (2.8053 \times 10^{-4})(\text{cm}^3\text{/atm-s}) (0.49995)(\text{atm}),$$
$$= 1.4025 \times 10^{-4} \text{ cm}^3\text{/s}.$$

The reference air leakage rate as defined in ANSI N14.5-1997, Sect. B.3, is the upstream leakage in air.

$L_{RN,Air} = 1.4025 \times 10^{-4}$ ref-cm^3/s. (For HEU oxide content)

The same equations can be used to calculate an allowable leakage rate using helium for leak testing.

$M = 4$ g/g-mol, (Molecular weight of helium)

$\mu = 0.0198$ cP, (Viscosity of helium at temperature)

$$F_c = (2.49 \times 10^6) D^4 / (a \mu) \text{ (cm}^3\text{/atm-s)}, \quad \text{(Eq. B3)}$$
$$= (2.49 \times 10^6) (8.8433\times 10^{-4})^4 / [(0.3531) (0.0198)],$$
$$= (3.5619 \times 10^8) (8.8433 \times 10^{-4})^4,$$
$$= 2.1785 \times 10^{-4} \text{ cm}^3\text{/atm-s},$$

$$F_m = (3.81 \times 10^3) D^3 (T / M)^{.5} / (a P_a) \text{ (cm}^3\text{/atm-s)}, \quad \text{(Eq. B4)}$$
$$= (3.81 \times 10^3) (8.8433 \times 10^{-4})^3 (298 / 4)^{.5} / [(0.3531) (0.505)],$$
$$= (1.8444 \times 10^5) (8.8433 \times 10^{-4})^3,$$
$$= 1.2756 \times 10^{-4} \text{ cm}^3\text{/atm-s},$$

$$L_u = (F_c + F_m) (P_u - P_d) (P_a / P_u) \text{ (cm}^3\text{/s)}, \quad \text{(Eq. B5)}$$
$$= (2.1785 \times 10^{-4} + 1.2756 \times 10^{-4})(\text{cm}^3\text{/atm-s}) (1.0 - 0.01)(\text{atm}) (0.505 / 1.0),$$
$$= (3.4541 \times 10^{-4})(\text{cm}^3\text{/atm-s}) (0.49995)(\text{atm}),$$
$$= 1.7269 \times 10^{-4} \text{ cm}^3\text{/s}.$$

The allowable leakage rate using helium for leak testing is:

$L_{RN,\,He} = 1.7269 \times 10^{-4}$ cm^3/s. (NCT helium test value)

HAC Leakage Hole Diameter for HEU Content

The calculation of a maximum allowable leakage rate hole diameter is based on the temperature and pressure of the fill gas aerosol for HAC, assuming the content is in an oxide powder form. Keeping this calculation conservative, the maximum values for temperature and pressure were used as steady-state conditions for a week. The maximum values were generated during the 30-min burn test for HAC.

Input data for HAC:

$L_A = 1.3578$ cm^3/s, (Maximum exit leakage)
$P_u = 11.9080$ atm, (Upstream pressure = 175.0 psia)
$P_d = 1.0$ atm, (Downstream pressure)
$T = 440.93$ K, (Fill gas temperature = 334°F)
$\mu = 0.02479$ cP, (Viscosity of air at temperature)
$M = 29$ g/g-mol, (Molecular weight of air)
$a = 0.3531$ cm, (Leak path length, 0.139-in. O-ring section diameter)

$P_a = (P_u + P_d) / 2,$
$= (11.9080 + 1.0) / 2,$ (HAC average pressure)
$= 6.4540$ atm.

Q is the mass-like leakage for flow using the upstream leakage, L_u, and pressure, P_u:

$Q = P_u L_u,$ (Eq. B1)
$L_u = L_A.$ (HAC leakage)

$Q = (11.9080)(\text{atm})\ (1.3578)(\text{cm}^3/\text{s}),$
$= 16.1691$ atm-cm^3/s, (HAC mass-like leakage rate)

$Q = P_a L_a,$ (Eq. B1)

$L_a = Q / P_a,$
$= 16.1691$ (atm-cm^3/s) / (6.4540) (atm),
$= 2.5053$ cm^3/s. (HAC average leakage rate)

Solve equations B2–B4 from ANSI N14.5-1997:

$L_a = (F_c + F_m)\ (P_u - P_d)$ (cm^3/s), (Eq. B2)
$= (F_c + F_m)\ (11.9080 - 1.0),$
$= 10.9080\ (F_c + F_m)$ cm^3/s,

$F_c = (2.49 \times 10^6)\ D^4 / (a\ \mu)$ (cm^3/atm-s), (Eq. B3)
$= (2.49 \times 10^6)\ D^4 / [(0.3531)\ (0.02479)],$
$= (2.8435 \times 10^8)\ D^4$ cm^3/atm-s,

$$F_m = (3.81 \times 10^3)\, D^3\, (T / M)^{.5} / (a\, P_a)\ (cm^3/atm\text{-}s), \quad \text{(Eq. B4)}$$
$$= (3.81 \times 10^3)\, D^3\, (440.93 / 29)^{.5} / [(0.3531)\,(6.4540)],$$
$$= (6.5198 \times 10^3)\, D^3\ cm^3/atm\text{-}s.$$

From the mass-like leakage calculation:

$$L_a = 2.5053\ cm^3/s. \quad \text{(HAC average leakage rate)}$$

Find the leakage hole diameter that sets:

$$L_2 = L_a.$$

Using the equations:

$$L_2 = 10.9080\,(F_c + F_m)\ cm^3/s,$$
$$F_c = (2.8435 \times 10^8)\, D^4\ cm^3/atm\text{-}s,$$
$$F_m = (6.5198 \times 10^3)\, D^3\ cm^3/atm\text{-}s.$$

To get a better guess on a new D, use:

$$D = D_2\,(L_a / L_2)^{0.252}.$$

Now a guess must be made for D_2 to solve Eq. B2 for HAC:

D_2 = 0.01 (cm), and solve for $L_a = 2.5053\ (cm^3/s)$. (HAC average leakage rate)

Diameter	F_c	F_m	L_2	L_a / L_2
1.0000E-02	2.8453E+00	6.5198E-03	3.1108E+01	0.08054
5.3004E-03	2.2458E-01	9.7087E-04	2.4603E+00	1.01829
5.3247E-03	2.2872E-01	9.8426E-04	2.5056E+00	0.99987
5.3245E-03	2.2869E-01	9.8417E-04	2.5053E+00	1.00000

The HAC leakage hole diameter for the HEU oxide content is:

$$D = 5.3245 \times 10^{-3}\ cm. \quad \text{(HAC diameter)}$$

HAC Reference Air Leakage Rate for HEU Content

The leakage hole diameter found for the maximum allowable leakage rate for HAC will be used to determine the reference air leakage rate. O-ring seal leakage testing must assure that no leakage is greater than the leakage generated by the hole diameter $D = 5.3245 \times 10^{-3}$ cm. Therefore, the HAC reference air leakage rate ($L_{R,A}$) must be calculated to determine the acceptable test leakage rate for post-HAC leakage testing.

Input data for HAC reference air leakage rate:

$D = 5.3245 \times 10^{-3}$ cm, (From the HAC of transport)
$a = 0.3531$ cm, (Leak path length, 0.139-in. O-ring section diameter)
$P_u = 1.0$ atm, (Upstream pressure)
$P_d = 0.01$ atm, (Downstream pressure)
$T = 298$ K, (Fill gas temperature, 77°F)
$M = 29$ g/g-mol, (Molecular weight of air)
$\mu = 0.0185$ cP. (Viscosity at temperature)

Calculate P_a:

$$P_a = (P_u + P_d) / 2,$$
$$= 0.505 \text{ atm,} \quad \text{(HAC average pressure)}$$

$$F_c = (2.49 \times 10^6)\, D^4 / (a\, \mu) \text{ (cm}^3\text{/atm-s),} \quad \text{(Eq. B3)}$$
$$= (2.49 \times 10^6)\, (5.3245 \times 10^{-3})^4 / [(0.3531)\, (0.0185)],$$
$$= (3.8122 \times 10^8)\, (5.3245 \times 10^{-3})^4,$$
$$= 3.0641 \times 10^{-1} \text{ cm}^3\text{/atm-s,}$$

$$F_m = (3.81 \times 10^3)\, D^3\, (T / M)^{.5} / (a\, P_a) \text{ (cm}^3\text{/atm-s),} \quad \text{(Eq. B4)}$$
$$= (3.81 \times 10^3)\, (5.3245 \times 10^{-3})^3\, (298 / 29)^{.5} / [(0.3531)\, (0.505)],$$
$$= (6.8501 \times 10^4)\, (5.3245 \times 10^{-3})^3,$$
$$= 1.0340 \times 10^{-2} \text{ cm}^3\text{/atm-s,}$$

$$L_u = (F_c + F_m)\, (P_u - P_d)\, (P_a / P_u) \text{ (cm}^3\text{/s),} \quad \text{(Eq. B5)}$$
$$= (3.0641 \times 10^{-1} + 1.0340 \times 10^{-2}) \text{(cm}^3\text{/atm-s)}\, (1.0 - 0.01) \text{(atm)}\, (0.505 / 1.0),$$
$$= (3.1675 \times 10^{-1}) \text{(cm}^3\text{/atm-s)}\, (0.49995) \text{(atm)},$$
$$= 1.5836 \times 10^{-1} \text{ cm}^3\text{/s.}$$

The HAC reference air leakage rate as defined in ANSI N14.5-1997, Sect. B.3, is the upstream leakage in air.

$L_{RA,Air} = 1.5836 \times 10^{-1}$ ref-cm^3/s. (for HEU oxide content)

The same equations can be used to calculate an allowable leakage rate using helium for leak testing.

$M = 4$ g/g-mol, (Molecular weight of helium)
$\mu = 0.0198$ cP, (Viscosity of helium at temperature)

$$F_c = (2.49 \times 10^6)\, D^4 / (a\, \mu) \text{ (cm}^3\text{/atm-s),} \quad \text{(Eq. B3)}$$
$$= (2.49 \times 10^6)\, (5.3245 \times 10^{-3} \text{ cm})^4 / [(0.3531)\, (0.0198)],$$
$$= (3.5619 \times 10^8)\, (5.3245 \times 10^{-3} \text{ cm})^4,$$
$$= 2.8629 \times 10^{-1} \text{ cm}^3\text{/atm-s,}$$

$$F_m = (3.81 \times 10^3)\, D^3\, (T / M)^{0.5} / (a\, P_a)\ (cm^3/atm\text{-}s), \quad \text{(Eq. B4)}$$
$$= (3.81 \times 10^3)\, (5.3245 \times 10^{-3}\ cm)^3\, (298 / 4)^{.5} / [(0.3531)\, (0.505)],$$
$$= (1.8444 \times 10^5)\, (5.3245 \times 10^{-3}\ cm)^3,$$
$$= 2.7842 \times 10^{-2}\ cm^3/atm\text{-}s,$$

$$L_u = (F_c + F_m)\, (P_u - P_d)\, (P_a / P_u)\ (cm^3/s), \quad \text{(Eq. B5)}$$
$$= (2.8629 \times 10^{-1} + 2.7842 \times 10^{-2})(cm^3/atm\text{-}s)\, (1.0 - 0.01)(atm)\, (0.505 / 1.0),$$
$$= (3.1413 \times 10^{-1})(cm^3/atm\text{-}s)\, (0.49995)(atm),$$
$$= 1.5705 \times 10^{-1}\ cm^3/s.$$

The allowable leakage rate using helium for leak testing for HAC is:

$$L_{RA,\,He} = 1.5705 \times 10^{-1}\ cm^3/s. \quad \text{(HAC helium test value)}$$

Determination of the Leakage Test Procedure Requirements for the HEU Content Transported by Air

The IAEA SSR-6, para. 621, states: "Packages containing radioactive material, to be transported by air, shall be capable of withstanding, without loss or dispersal of radioactive contents from the containment system, an internal pressure that produces a pressure differential of not less than the maximum normal operating pressure plus 95 kPa." As shown in Table 2.20, the maximum normal operating pressure (MNOP) for CVA 1 or CVA 11 was predicted to be 31.943 kPa (4.633 psi) gauge [133.30 kPa (19.333 psi) absolute] for ground transportation. As shown in Appendix 3.5.1, Table 9, the maximum pressure differential for both containment vessel arrangements determined for air transport is the MNOP plus 95 kPa (13.78 psi) or 117.69 kPa (17.07 psi). The following calculations will examine the most conservative effects of a fully loaded containment vessel with an HEU mass of 35.2 kg and this pressure differential. The smallest allowable leakage values are shown in Table 4.6. The A_2 value and the maximum content activity-to-A_2 value ratio for this mixture were calculated for several different decay times (Table 6, Appendix 4.5.1). As calculated in Appendix 4.5.1, the A_2 value and the maximum content activity-to-A_2 ratio used to qualify this package occur at ~70 years of decay and are 1.5245×10^{-4} TBq (4.1203×10^{-3} Ci) and 4,752.8, respectively. These values are used to determine the leakage test procedural requirements when packaging any convenience cans/contents arrangements in the ES-3100 package. The convenience cans/contents are sealed inside the containment vessel in an environmentally controlled area.

The following analysis determines the maximum allowable O-ring seal air reference leakage rate for NCT during air transport. The ANSI N14.5-1997 recommended method using a straight circular tube to model the leakage path is applied. Using this "standard" leakage hole model permits the calculation of equivalent reference leakage rates from which leak-test requirements can be established. Viscosity data for air and helium used in the following analyses were obtained from curve fitting routines at specific temperatures based on viscosity data for air (*CRC Handbook of Chemistry and Physics*) and helium (NBS Technical Note 631). To also comply with 49 CFR 173.410(i)(2), the range of temperature evaluated will be from −40 to 55°C (ambient temperature). According to IAEA SSG-26, para. 621.3, the evaluation at an ambient temperature of 55°C does not consider insolation; however, self-heating of the package is taken into account. An analysis has been conducted, and results for these conditions are shown in Table 3.14. The maximum temperature predicted for the containment vessel was 64.44°C (147.99°F). This temperature will be used in the following analysis as the maximum gas temperature (T_{NL}).

L_N and L_A correspond to the upstream volumetric leakage rate (L_u) at the upstream pressure (P_u).

$$L_N = 2.2878 \times 10^{-4} \text{ cm}^3/\text{s},$$
$$L_A = 1.3578 \text{ cm}^3/\text{s}.$$

Find the maximum pressure and a temperature in the containment vessel from -40 to 55°C:

Converting the temperature to Kelvin:

$$T = 273.15 + T\ (°C),$$
$$= 273.15 + 5 / 9\ (°F - 32)\ (K),$$

$$T_{NL} = 273.15 + 5 / 9\ (-40°F - 32)\ (K), \quad [T = -40°F\ (-40°C)]$$
$$= 233.15 \text{ K}, \quad \text{(NCT low limit)}$$

$$T_{NH} = 273.15 + 5 / 9\ (147.99°F - 32)\ (K), \quad [T = 147.99°F\ (64.44°C)]$$
$$= 337.59 \text{ K}, \quad \text{(NCT high limit)}$$

Converting the pressures from psia to atmospheres:

$$P_N = P\ (\text{psia}) / 14.696\ (\text{psia/atm}), \quad [\text{where P is the pressure in Sect. 3.3.2 plus 13.78 psia (95 kPa)}]$$
$$= 17.07\ (\text{psia}) / 14.696\ (\text{psia/atm}), \quad \text{(rounded up for NCT)}$$
$$= 1.1615 \text{ atm},$$

NCT Leakage Hole Diameter for the HEU Content during Air Transport at the Lower Temperature Limit of IAEA SSG-26

The following calculations determine the leakage hole diameter that generates the maximum allowable leakage rate during NCT. To keep these calculations conservative, the maximum values for temperature and pressure were used as steady-state conditions for NCT as dictated for air transport.

Input data for NCT at the lower temperature limit with air fill gas:

$L_N = 2.2878 \times 10^{-4} \text{ cm}^3/\text{s}$, (Maximum upstream leakage)
$P_u = 1.1615 \text{ atm}$, (Upstream pressure = 17.07 psia)
$P_d = 0 \text{ atm}$, [Downstream pressure = 0 psia, per 10 CFR 71.71(3)]
$a = 0.3531 \text{ cm}$, (Leak path length, 0.139-in. O-ring section diameter)
$T = 233.15 \text{ K}$, (Fill gas temperature = −40°F)
$\mu = 0.01518 \text{ cP}$, (Viscosity at temperature)
$M = 29 \text{ g/g-mol}$. (Molecular weight of fill gas)

The average pressure is:

$$P_a = (P_u + P_d) / 2,$$
$$= (1.1615 + 0) / 2,$$
$$= 0.5808 \text{ atm}. \quad \text{(Average pressure during NCT)}$$

According to ANSI N14.5-1997, the flow leakage hole diameter is unknown. Therefore, the mass-like leakage flow rate must be calculated to calculate the average leakage flow rate.

Q is the mass-like leakage for flow using the upstream leakage, L_u, and pressure, P_u:

$$Q = P_u L_u, \quad \text{(Eq. B1)}$$
$$L_u = L_N, \quad \text{(NCT leakage)}$$

$$Q = (1.1615)(\text{atm})\ (2.2878 \times 10^{-4})(\text{cm}^3/\text{s}),$$
$$= 2.6573 \times 10^{-4}\ \text{atm-cm}^3/\text{s}, \quad \text{(NCT mass-like leakage rate)}$$

$$Q = P_a L_a, \quad \text{(Eq. B1)}$$

$$L_a = Q / P_a,$$
$$= 2.6573 \times 10^{-4}\ (\text{atm-cm}^3/\text{s}) / (0.5808)\ (\text{atm}),$$
$$= 4.5755 \times 10^{-4}\ \text{cm}^3/\text{s}. \quad \text{(NCT average leakage rate)}$$

Solve equations B2–B4 from ANSI N14.5-1997:

$$L_a = (F_c + F_m)\ (P_u - P_d)\ \text{cm}^3/\text{s}, \quad \text{(Eq. B2)}$$
$$= (F_c + F_m)\ (1.1615 - 0.0000),$$
$$= (1.16153.0641)\ (F_c + F_m)\ \text{cm}^3/\text{s},$$

$$F_c = (2.49 \times 10^6)\ D^4 / (a\ \mu)\ (\text{cm}^3/\text{atm-s}), \quad \text{(Eq. B3)}$$
$$= (2.49 \times 10^6)\ D^4 / [(0.3531)\ (0.01518)],$$
$$= (4.6459 \times 10^8)\ D^4\ \text{cm}^3/\text{atm-s},$$

$$F_m = (3.81 \times 10^3)\ D^3\ (T / M)^{.5} / (a\ P_a)\ (\text{cm}^3/\text{atm-s}), \quad \text{(Eq. B4)}$$
$$= (3.81 \times 10^3)\ D^3\ (233.15 / 29)^{.5} / [(0.3531)\ (0.5808)],$$
$$= (5.2685 \times 10^4)\ D^3\ \text{cm}^3/\text{atm-s}.$$

From the mass-like leakage calculation:

$$L_a = 4.5755 \times 10^{-4}\ \text{cm}^3/\text{s}. \quad \text{(NCT average leakage rate)}$$

Find the leakage hole diameter that sets:

$$L_2 = L_a.$$

Using the equations:

$$L_2 = (1.1615)\ (F_c + F_m)\ \text{cm}^3/\text{s},$$
$$F_c = (4.6459 \times 10^8)\ D^4\ \text{cm}^3/\text{atm-s},$$
$$F_m = (5.2685 \times 10^4)\ D^3\ \text{cm}^3/\text{atm-s}.$$

To get a better guess on a new D, use:

$$D = D_2\ (L_a / L_2)^{0.252}.$$

Now a guess must be made for D_2 to solve Eq. B2 for NCT:

D_2 = 0.001 cm, and solve for $L_a = 4.5755 \times 10^{-4}$ cm^3/s. (NCT average leakage rate)

Diameter	F_c	F_m	L_2	L_a / L_2
1.0000E-03	4.6459E-04	5.2685E-05	6.0083E-04	0.76153
9.3365E-04	3.5303E-04	4.2879E-05	4.5986E-04	0.99498
9.3247E-04	3.5124E-04	4.2716E-05	4.5759E-04	0.99990
9.3245E-04	3.5120E-04	4.2713E-05	4.5755E-04	1.00000

The NCT leakage hole diameter for the HEU oxide content:

$D = 9.3245 \times 10^{-4}$ cm. (NCT diameter)

NCT Reference Air Leakage Rate for HEU Content Transported by Air

The leakage hole diameter found for the maximum allowable leakage rate for NCT will be used to determine the reference air leakage rate. O-ring seal leakage testing must ensure that no leakage is greater than the leakage generated by the hole diameter $D = 9.3245 \times 10^{-4}$ cm. Therefore, the NCT reference leakage flow rate ($L_{R, N}$) must be calculated to determine the allowable test leakage rate.

Input data for NCT reference air leakage rate:

$D = 9.3245 \times 10^{-4}$ cm, (From NCT)
$a = 0.3531$ cm, (Leak path length, 0.139-in. O-ring section diameter)
$P_u = 1.0$ atm, (Upstream pressure)
$P_d = 0.01$ atm, (Downstream pressure)
$T = 298$ K, (Fill gas temperature, 77°F)
$M = 29$ g/g-mol, (Molecular weight of air)
$\mu = 0.0185$ cP, (Viscosity of air at reference temperature)

Calculate P_a:

$$P_a = (P_u + P_d) / 2,$$
$$= (1.0 + 0.01) /2,$$
$$= 0.505 \text{ atm,} \quad \text{(NCT average pressure)}$$

$$F_c = (2.49 \times 10^6) D^4 / (a \mu) \text{ (cm}^3\text{/atm-s),} \quad \text{(Eq. B3)}$$
$$= (2.49 \times 10^6) (9.3245 \times 10^{-4})^4 / [(0.3531) (0.0185)],$$
$$= (3.8122 \times 10^8) (9.3245 \times 10^{-4})^4,$$
$$= 2.8819 \times 10^{-4} \text{ cm}^3\text{/atm-s,}$$

$$F_m = (3.81 \times 10^3) D^3 (T / M)^{.5} / (a P_a) \text{ (cm}^3\text{/atm-s),} \quad \text{(Eq. B4)}$$
$$= (3.81 \times 10^3) (9.3245 \times 10^{-4})^3 (298 / 29)^{.5} / [(0.3531) (0.505)],$$
$$= (6.8501 \times 10^4) (9.3245 \times 10^{-4})^3,$$
$$= 5.5535 \times 10^{-5} \text{ cm}^3\text{/atm-s,}$$

$L_u = (F_c + F_m)(P_u - P_d)(P_a / P_u)$ (cm^3/s), (Eq. B5)
$= (2.8819 \times 10^{-4} + 5.5535 \times 10^{-5})$ (cm^3/atm-s) (1.0 − 0.01) (atm) (0.505 / 1.0),
$= (3.4372 \times 10^{-4})$ (cm^3/atm-s) (0.49995) (atm),
$= 1.7184 \times 10^{-4}\ 2 \times 10^{-5}$ cm^3/s.

The reference air leakage rate as defined in ANSI N14.5-1997, Sect. B.3, is the upstream leakage in air.

$L_{RN,Air} = 1.7184 \times 10^{-4}$ ref-cm^3/s. (For HEU oxide content)

The same equations can be used to calculate an allowable leakage rate using helium for leak testing.

$M = 4$ g/g-mol, (Molecular weight of helium)
$\mu = 0.0198$ cP, (Viscosity of helium at temperature)

$F_c = (2.49 \times 10^6)\ D^4 / (a\ \mu)$ (cm^3/atm-s), (Eq. B3)
$= (2.49 \times 10^6)\ (9.3245 \times 10^{-4})^4 / [(0.3531)\ (0.0198)]$,
$= (3.5619 \times 10^8)\ (9.3245 \times 10^{-4})^4$,
$= 2.6926 \times 10^{-4}$ cm^3/atm-s,

$F_m = (3.81 \times 10^3)\ D^3\ (T / M)^{.5} / (a\ P_a)$ (cm^3/atm-s), (Eq. B4)
$= (3.81 \times 10^3)\ (9.3245 \times 10^{-4})^3\ (298 / 4)^{.5} / [(0.3531)\ (0.505)]$,
$= (1.8444 \times 10^5)\ (9.3245 \times 10^{-4})^3$,
$= 1.4953 \times 10^{-4}$ cm^3/atm-s,

$L_u = (F_c + F_m)(P_u - P_d)(P_a / P_u)$ (cm^3/s), (Eq. B5)
$= (2.6926 \times 10^{-4} + 1.4953 \times 10^{-4})$ (cm^3/atm-s) (1.0 − 0.01) (atm) (0.505 / 1.0),
$= (4.1880 \times 10^{-4})$ (cm^3/atm-s) (0.49995) (atm),
$= 2.0938 \times 10^{-4}$ cm^3/s.

The allowable leakage rate using helium for leak testing is:

$L_{RN,\,He} = 2.0938 \times 10^{-4}$ cm^3/s.

NCT Leakage Hole Diameter for the HEU Content during Air Transport at the Upper Temperature Limit [147.99°F (64.44°C)] per IAEA SSG-26

The following calculations determine the leakage hole diameter that generates the maximum allowable leakage rate during NCT. To keep these calculations conservative, the maximum values for temperature and pressure were used as steady-state conditions for NCT.

Input data for NCT at the upper temperature limit with air fill gas:

$L_N = 2.2878 \times 10^{-4}$ cm^3/s, (Maximum upstream leakage)
$P_u = 1.1615$ atm, (Upstream pressure = 17.07 psia)
$P_d = 0$ atm, [Downstream pressure = 0 psia, per 10 CFR 71.71(3)]
$a = 0.3531$ cm, (Leak path length, 0.139-in. O-ring section diameter)
$T = 337.59$ K, [Fill gas temperature = 147.44°F (64.44°C)]
$\mu = 0.02036$ cP, (Viscosity at temperature)
$M = 29$ g/g-mol. (Molecular weight of fill gas)

The average pressure is:

$$P_a = (P_u + P_d) / 2,$$
$$= (1.1615 + 0.0000) / 2,$$
$$= 0.5808 \text{ atm.} \quad \text{(Average pressure during NCT)}$$

According to ANSI N14.5-1997, the flow leakage hole diameter is unknown. Therefore, the mass-like leakage flow rate must be calculated to calculate the average leakage flow rate.

Q is the mass-like leakage for flow using the upstream leakage, L_u, and pressure, P_u:

$$Q = P_u L_u, \quad \text{(Eq. B1)}$$
$$L_u = L_N, \quad \text{(NCT leakage)}$$

$$Q = (1.1615) \text{ (atm) } (2.2878 \times 10^{-4}) \text{ (cm}^3\text{/s)},$$
$$= 2.6573 \times 10^{-4} \text{ atm-cm}^3\text{/s}, \quad \text{(NCT mass-like leakage rate)}$$

$$Q = P_a L_a, \quad \text{(Eq. B1)}$$

$$L_a = Q / P_a,$$
$$= 2.6573 \times 10^{-4} \text{ (atm-cm}^3\text{/s) / (0.5808) (atm)},$$
$$= 4.5755 \times 10^{-4} \text{ cm}^3\text{/s}. \quad \text{(NCT average leakage rate)}$$

Solve Eqs. B2–B4 from ANSI N14.5-1997:

$$L_a = (F_c + F_m) (P_u - P_d) \text{ cm}^3\text{/s}, \quad \text{(Eq. B2)}$$
$$= (F_c + F_m) (1.1615 - 0),$$
$$= (1.1615) (F_c + F_m) \text{ cm}^3\text{/s},$$

$$F_c = (2.49 \times 10^6) D^4 / (a \mu) \text{ (cm}^3\text{/atm-s)}, \quad \text{(Eq. B3)}$$
$$= (2.49 \times 10^6) D^4 / [(0.3531) (0.02036)],$$
$$= (3.4642 \times 10^8) D^4 \text{ cm}^3\text{/atm-s},$$

$$F_m = (3.81 \times 10^3) D^3 (T / M)^{.5} / (a P_a) \text{ (cm}^3\text{/atm-s)}, \quad \text{(Eq. B4)}$$
$$= (3.81 \times 10^3) D^3 (337.59 / 29)^{.5} / [(0.3531) (0.5808)],$$
$$= (6.3397 \times 10^4) D^3 \text{ cm}^3\text{/atm-s}.$$

From the mass-like leakage calculation:

$$L_a = 4.5755 \times 10^{-4} \text{ cm}^3\text{/s}. \quad \text{(NCT average leakage rate)}$$

Find the leakage hole diameter that sets:

$$L_2 = L_a.$$

Using the equations:

$$L_2 = (1.1615) (F_c + F_m) \text{ cm}^3\text{/s},$$
$$F_c = (3.4642 \times 10^8) D^4 \text{ cm}^3\text{/atm-s},$$
$$F_m = (6.3397 \times 10^4) D^3 \text{ cm}^3\text{/atm-s}.$$

To get a better guess on a new D, use:

$$D = D_2 (L_a / L_2)^{0.252}.$$

Now a guess must be made for D_2 to solve Eq. B2 for NCT:

D_2 = 0.001 cm, and solve for $L_a = 4.5755 \times 10^{-4}$ cm^3/s. (NCT average leakage rate)

Diameter	F_c	F_m	L_2	L_a / L_2
1.0000E-03	3.4642E-04	6.3397E-05	4.7602E-04	0.96120
9.9008E-04	3.3287E-04	6.1528E-05	4.5811E-04	0.99877
9.8977E-04	3.3246E-04	6.1471E-05	4.5757E-04	0.99996
9.8976E-04	3.3245E-04	6.1469E-05	4.5755E-04	1.00000

The NCT leakage hole diameter for the HEU oxide content:

$D = 9.8976 \times 10^{-4}$ cm. (NCT diameter)

NCT Reference Air Leakage Rate for HEU Content Transported by Air

The leakage hole diameter found for the maximum allowable leakage rate for NCT will be used to determine the reference air leakage rate. O-ring seal leakage testing must ensure that no leakage is greater than the leakage generated by the hole diameter $D = 9.8976 \times 10^{-4}$ cm. Therefore, the NCT reference leakage flow rate ($L_{R, N}$) must be calculated to determine the allowable test leakage rate.

Input data for NCT reference air leakage rate:

$D = 9.8976 \times 10^{-4}$ cm, (From NCT)
$a = 0.3531$ cm, (Leak path length, 0.139-in. O-ring section diameter)
$P_u = 1.0$ atm, (Upstream pressure)
$P_d = 0.01$ atm, (Downstream pressure)
$T = 298$ K, (Fill gas temperature, 77°F)
$M = 29$ g/g-mol, (Molecular weight of air)
$\mu = 0.0185$ cP, (Viscosity of air at reference temperature)

Calculate P_a:

$$P_a = (P_u + P_d) / 2,$$
$$= (1.0 + 0.01) /2,$$
$$= 0.505 \text{ atm,} \quad \text{(NCT average pressure)}$$

$$F_c = (2.49 \times 10^6) D^4 / (a \mu) \text{ (cm}^3\text{/atm-s),} \quad \text{(Eq. B3)}$$
$$= (2.49 \times 10^6) (9.8976\times 10^{-4})^4 / [(0.3531) (0.0185)],$$
$$= (3.8122 \times 10^8) (9.8976\times 10^{-4})^4,$$
$$= 3.6585 \times 10^{-4} \text{ cm}^3\text{/atm-s,}$$

$$F_m = (3.81 \times 10^3)\, D^3\, (T / M)^{.5} / (a\, P_a)\ (cm^3/atm\text{-}s), \quad \text{(Eq. B4)}$$
$$= (3.81 \times 10^3)\, (9.8976 \times 10^{-4})^3\, (298 / 29)^{.5} / [(0.3531)\, (0.505)],$$
$$= (6.8501 \times 10^4)\, (9.8976 \times 10^{-4})^3,$$
$$= 6.6418 \times 10^{-5}\ cm^3/atm\text{-}s,$$

$$L_u = (F_c + F_m)\, (P_u - P_d)\, (P_a / P_u)\ (cm^3/s), \quad \text{(Eq. B5)}$$
$$= (3.6585 \times 10^{-4} + 6.6418 \times 10^{-5})\ (cm^3/atm\text{-}s)\ (1.0 - 0.01)\ (atm)\ (0.505 / 1.0),$$
$$= (4.3227 \times 10^{-4})\ (cm^3/atm\text{-}s)\ (0.49995)\ (atm),$$
$$= 2.1611 \times 10^{-4}\ cm^3/s.$$

The reference air leakage rate as defined in ANSI N14.5-1997, Sect. B.3, is the upstream leakage in air.

$$L_{RN,Air} = 2.1611 \times 10^{-4}\ ref\text{-}cm^3/s. \quad \text{(For HEU oxide content)}$$

The same equations can be used to calculate an allowable leakage rate using helium for leak testing.

$$M = 4\ g/g\text{-}mol, \quad \text{(Molecular weight of helium)}$$
$$\mu = 0.0198\ cP, \quad \text{(Viscosity of helium at temperature)}$$

$$F_c = (2.49 \times 10^6)\, D^4 / (a\, \mu)\ (cm^3/atm\text{-}s), \quad \text{(Eq. B3)}$$
$$= (2.49 \times 10^6)\, (9.8976 \times 10^{-4})^4 / [(0.3531)\, (0.0198)],$$
$$= (3.5619 \times 10^8)\, (9.8976 \times 10^{-4})^4,$$
$$= 3.4183 \times 10^{-4}\ cm^3/atm\text{-}s,$$

$$F_m = (3.81 \times 10^3)\, D^3\, (T / M)^{.5} / (a\, P_a)\ (cm^3/atm\text{-}s), \quad \text{(Eq. B4)}$$
$$= (3.81 \times 10^3)\, (9.8976 \times 10^{-4})^3\, (298 / 4)^{.5} / [(0.3531)\, (0.505)],$$
$$= (1.8444 \times 10^5)\, (9.8976 \times 10^{-4})^3,$$
$$= 1.7884 \times 10^{-4}\ cm^3/atm\text{-}s,$$

$$L_u = (F_c + F_m)\, (P_u - P_d)\, (P_a / P_u)\ (cm^3/s), \quad \text{(Eq. B5)}$$
$$= (3.4183 \times 10^{-4} + 1.7884 \times 10^{-4})\ (cm^3/atm\text{-}s)\ (1.0 - 0.01)\ (atm)\ (0.505 / 1.0),$$
$$= (5.2066 \times 10^{-4})\ (cm^3/atm\text{-}s)\ (0.49995)\ (atm),$$
$$= 2.6031 \times 10^{-4}\ cm^3/s.$$

The allowable leakage rate using helium for leak testing is:

$$L_{RN,\,He} = 2.6031 \times 10^{-4}\ cm^3/s.$$

The design verification tests were conducted following compliance tests in accordance with 10 CFR 71.71 and 71.73. The effectiveness of this closure system has been demonstrated by the NCT and HAC tests, which show that the complete containment system, including welds and O-ring seals, meet the leaktight criterion as defined in ANSI N14.5-1997 after the conclusion of the test series documented in ORNL/NTRC-013. This leaktight criterion is substantially below the above calculated results for air transport. Therefore, the requirements of 10 CFR Part 71.51(a)(1) are satisfied as well as the IAEA SSR-6 requirement of no loss or dispersal of radioactive contents from the containment system.

Appendix 4.5.3
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5. SHIELDING EVALUATION

This section describes the shielding evaluation performed for the shipment of up to 36 kg of highly enriched uranium (HEU) metal or 24 kg of HEU oxide powder in the ES-3100 shipping package. The objective of this evaluation is to demonstrate—for both normal conditions of transport (NCT) and hypothetical accident conditions (HAC)—compliance of this package with the performance requirements specified in Title 10, Part 71, of the Code of Federal Regulations (CFR) [10 CFR 71] and U.S. Department of Transportation (DOT) regulations for packaging and shipment of hazardous materials given in Title 49 CFR.

5.1 DESCRIPTION OF SHIELDING DESIGN

5.1.1 Design Features

The ES-3100 package for NCT consists of stainless-steel convenience cans loaded with HEU material, can spacer assemblies to support and position the convenience cans, the ES-3100 containment vessel (CV), and an insulation-filled drum as shown in Appendix 1.3.1. Calculations presented in Appendix 5.5.3 demonstrate from a shielding evaluation standpoint that there are minor statistical differences among the calculated dose rates for different source configurations using either the Kaolite or Packcrete impact-absorbing and thermal-insulating materials. Thus, the Kaolite shielding calculations in this chapter are considered to bound packages with Packcrete. None of the package materials are specifically designed for shielding gamma rays (photons), the primary contributor to external package dose rates for the specified source configurations. For NCT and HAC shielding calculations, the packing materials inside the CV are conservatively not modeled. It is assumed that the CV remains intact during HAC, but all the packaging materials external to the CV are removed. The geometry of the shielding analysis model is a conservative, cylindrical representation of the package.

Two sets of contents have been investigated for the shielding analysis. These are 36 kg of HEU metal and 24 kg of HEU oxide powder. The analyses of these models have been performed such that the results and conclusions cover other proposed contents in an equivalent or conservative manner. For the source calculation, the uranium is enriched at 92 wt % ^{235}U and is assumed to contain 0.6 wt % ^{233}U, 2.0 wt % ^{234}U, 1.0 wt % ^{236}U, 4.4 wt % ^{238}U, 2.5 wt % ^{237}Np, 40 parts per billion (ppb) ^{232}U, and 800 parts per million (ppm) weapons-grade plutonium to represent all other transuranic trace elements. The value of 800 ppm weapons-grade plutonium applies to ground transport only. Contents for air transport are limited to 40 ppm weapons-grade plutonium. There are two sources of the transuranic contamination in this HEU. First, much of this uranium originated from recycled material. Second, some uranium had plutonium components removed by machining or other processes, but left contamination. This contamination became mixed with the uranium as it was recast and used for other purposes.

5.1.2 Summary Table of Maximum Radiation Levels

The results of the shielding model evaluations, summarized in Tables 5.1 and 5.2, are the calculated dose rates at the locations indicated for the uranium metal and uranium oxide contents. These dose rates are based on the conservative assumption there is no packaging material except the content inside the CV. The side dose rates in Table 5.1 for the HEU metal content are maximized by assuming the content in the hemi-shell configuration. The top and bottom dose rates for the HEU metal content are maximized by assuming the content in the form of a cylinder at the top or at the bottom of the CV, respectively. For the HEU oxide content, the side drum surface photon dose rate presented in Table 5.2 is from the solid cylindrical configuration of 47.365 cm height and density of 4.0 g/cm^3. The 1 m from the side surface photon dose rates for the NCT and HAC are from the cylindrical shell configuration of 2.6275 cm inner radius, 6.35 cm outer radius, 76.2 cm height, and density of 3.0 g/cm^3. The neutron side dose rates are from the solid cylinder at the top of the CV configuration with a density of 10.96 g/cm^3. The top and bottom dose rates are from the cylinder type configuration with a density of 10.96 g/cm^3 at the top and bottom of the CV configurations, respectively. The uncertainty associated with the results is one standard deviation of the mean (i.e., one sigma uncertainty expressed as a percentage of the mean) calculated using the MCNP Monte Carlo code (LA-UR-03-1987). The shielding evaluation demonstrates the package with HEU metal or HEU oxide content meets all dose-rate limits as specified in 10 CFR 71.47(a) and 49 CFR 173.441(a) for NCT and 10 CFR 71.51(a)(2) for HAC, as shown by the dose rates in Tables 5.1 and 5.2 and the information in Sect. 5.3. The maximum radiation level at the package surface is measured when it is presented for transport. The maximum radiation level at 1 m from the external surface will also be measured to establish the transport index (TI) for the package. The calculated TI values are 6.2 and 5.1 for the HEU metal and HEU oxide contents, respectively. The measured dose rates are expected to be much lower than the calculated dose rates due to conservatism and bounding nature of the calculations. The measured radiation levels are evaluated against the allowable radiation levels prescribed in 10 CFR 71.47 and 49 CFR 173.441.

5.2 SOURCE SPECIFICATION

The principal source for the calculated dose rates is the decay of the radioactive isotopes. There is also neutron and photon production from spontaneous and neutron-induced fissions, secondary photon generation, and [alpha (α), n] reactions in trace element impurities. The isotopic content used in the shielding calculations is shown in Table 5.3. ^{237}Np and transuranic (2.58 wt % combined in Table 5.3) are conservatively added to the source term without increasing the content mass. A trace amount of ^{232}U (40 ppb), which significantly increases the dose rate, is also added to the source term. This composition was chosen to represent all proposed package contents described in Sect. 1.2.2. The uranium metal source is assumed to be the same as that for the oxides per unit HEU mass. Details of the source specifications and their use in the dose-rate calculations are provided in Appendix 5.5.1.

Table 5.1. Calculated external dose rates for the ES-3100 package with 36 kg of HEU metal contents

mSv/h (mrem/h) with ± one sigma uncertainty (%) [a, b]

	One millimeter from drum surface			One meter from surface [c]		
	Side	**Top**	**Bottom**	**Side**	**Top**	**Bottom**
			NCT			
Photon	0.9580 (95.80) ± 1.47%	0.2304 (23.04) ± 0.99%	0.8000 (80.00) ± 0.64%	0.06064 (6.064) ± 0.06%	0.00672 (0.672) ± 0.15%	0.01434 (1.434) ± 0.15%
Neutron [d]	0.0158 (1.58) ± 0.32%	0.0133 (1.33) ± 0.35%	0.0204 (2.04) ± 0.36%	0.00057 (0.057) ± 0.19%	0.00038 (0.038) ± 0.19%	0.00042 (0.042) ± 0.15%
Total	0.9738 (97.38) ± 1.45%	0.2437 (24.37) ± 0.94%	0.8204 (82.04) ± 0.62%	0.06121 (6.121) ± 0.06% [e]	0.00710 (0.710) ± 0.14%	0.01476 (1.476) ± 0.15%
Limit [f]	2 (200)	2 (200)	2 (200)	0.1 (10)	0.1 (10)	0.1 (10)
			HAC			
Photon	NA [g]	NA	NA	0.12906 (12.906) ± 0.04%	0.01008 (1.008) ± 0.13%	0.02044 (2.044) ± 0.30%
Neutron [d]	NA	NA	NA	0.00036 (0.036) ± 0.19%	0.00020 (0.020) ±0.03%	0.00022 (0.022) ± 0.03%
Total	NA	NA	NA	0.12942 (12.942) ± 0.04%	0.01028 (1.028) ± 0.13%	0.02066 (2.066) ± 0.30%
Limit [h]	NA	NA	NA	10 (1000)	10 (1000)	10 (1000)

[a] Side photon and neutron dose rates are from the cylindrical hemi-shell and solid cylinder at the top configurations, respectively. The top and bottom dose rates are from the cylinder-type configurations at the top and bottom of the CV, respectively.

[b] MCNP5 Monte Carlo code results (LA-UR-03-1987). The uncertainty associated with the results is one standard deviation of the mean (i.e., one sigma uncertainty expressed as a percentage of the mean) calculated using MCNP5.

[c] One meter from the drum for NCT and one meter from the CV for HAC.

[d] Includes secondary photon dose rate (<1% of neutron dose rates).

[e] The radiation shielding transport index is 6.2.

[f] Nonexclusive use radiation dose limit in accordance with 10 CFR 71.47(a) and 49 CFR 173.441(a).

[g] Not applicable.

[h] Radiation dose limit in accordance with 10 CFR 71.51(a)(2).

Table 5.2. Calculated external dose rates for the ES-3100 package with 24 kg of HEU oxide contents

mSv/h (mrem/h) with ± one sigma uncertainty (%) [a, b]

	One millimeter from drum surface			One meter from surface [c]		
	Side	**Top**	**Bottom**	**Side [c]**	**Top**	**Bottom**
			NCT			
Photon	0.7972 (79.72) ± 1.80%	0.2015 (20.15) ± 0.92%	0.7062 (70.62) ± 1.29%	0.05019 (5.019) ± 0.16%	0.00610 (0.610) ± 0.12 %	0.01319 (1.319) ± 0.09%
Neutron [d]	0.0015 (0.15) ± 0.46%	0.0011 (0.11) ± 0.91%	0.0022 (0.22) ± 0.31%	0.00005 (0.005) ± 0.04%	0.00003 (0.003) ± 0.05%	0.00005 (0.005) ± 0.04%
Total	0.7987 (79.87) ± 1.80%	0.2026 (20.26) ± 0.91%	0.7084 (70.84) ± 1.29%	0.05024 (5.024) ± 0.16% [e]	0.00613 (0.613) ± 0.12%	0.01324 (1.324) ± 0.09%
Limit [f]	2 (200)	2 (200)	2 (200)	0.1 (10)	0.1 (10)	0.1 (10)
			HAC			
Photon	NA [g]	NA	NA	0.10687 (10.687) ± 0.03%	0.00907 (0.907) ± 0.15%	0.01862 (1.862) ± 0.09%
Neutron [d]	NA	NA	NA	0.00004 (0.004) ± 0.01%	0.00003 (0.003) ± 0.02%	0.00004 (0.004) ± 0.02%
Total	NA	NA	NA	0.10691 (10.691) ± 0.03%	0.00910 (0.910) ± 0.15%	0.01866 (1.866) ± 0.09%
Limit [h]	NA	NA	NA	10 (1000)	10 (1000)	10 (1000)

[a] Side drum surface photon dose rate is from the solid cylindrical configuration (height = 47.365 cm and density = 4.0 g/cm^3 sitting at the bottom of the CV). The 1 m from the side surface photon dose rates for the NCT and HAC are from the cylindrical shell configuration (inner radius = 2.6275 cm, outer radius = 6.35 cm, height = 76.2 cm, and density 3.0 g/cm^3). The neutron side dose rates are from the solid cylinder (density = 10.96 g/cm^3) at the top of the CV configuration. The top and bottom photon and neutron dose rates are from the cylinder-type configurations (density = 10.96 g/cm^3) at the top and bottom of the CV, respectively.

[b] MCNP5 Monte Carlo code results (LA-UR-03-1987). The uncertainty associated with the results is one standard deviation of the mean (i.e., one sigma uncertainty expressed as a percentage of the mean) calculated using MCNP5.

[c] One meter from the drum for NCT and one meter from the CV for HAC.

[d] Includes secondary photon dose rate (<1% of neutron dose rates).

[e] The radiation shielding transport index is 5.1.

[f] Nonexclusive use radiation dose limit in accordance with 10 CFR 71.47(a) and 49 CFR 173.441(a).

[g] Not applicable.

[h] Radiation dose limit in accordance with 10 CFR 71.51(a)(2).

Table 5.3. Radioisotope composition for all ES-3100 package analysis source calculations with HEU content and other nuclides per HEU unit weight

Isotope	wt % [a]
^{232}U	0.000004
^{233}U	0.600000
^{234}U	2.000000
^{235}U	92.000000
^{236}U	1.000000
^{238}U	4.399996
^{237}Np	2.500000
Transuranic [b]	0.080000
Total	102.58

[a] ^{237}Np and transuranic are added to the uranium source composition without adding their weights in the source mass calculations.

[b] The transuranic contents are: 1.60×10^{-5} wt % ^{238}Pu, 7.41×10^{-2} wt % ^{239}Pu, 5.20×10^{-3} wt % ^{240}Pu, 4.48×10^{-4} wt % ^{241}Pu, 3.20×10^{-5} wt % ^{242}Pu, and 2.40×10^{-4} wt % ^{241}Am. ^{237}Np and transuranic are added to the uranium source composition without adding their weights.

5.2.1 Gamma Source

The photon source is calculated by the Standardized Computer Analysis for Licensing Evaluation (SCALE) module of ORIGEN-S (NUREG/CR-0200, Vol. II, Sect. F7) as a function of the 47 energy group photon spectrum and decay time. Additional information about ORIGEN-S methodology and input is available in Appendix 5.5.1. It is shown that the photon spectrum around 10.5 years decay time provides maximum photon dose rates, and the spectra are given in Table 5.4. Figure 5.1 shows the photon spectrum for ^{232}U and the total source composition including ^{232}U. In Table 5.4, the photon source for the 38th energy group (2.6 – 2.7 MeV) is 1.062×10^4 photons/s/g. Figure 5.1 shows that this photon source comes from ^{232}U and this phenomenon is a result of the ^{232}U daughter product (i.e., ^{208}Tl) decaying to ^{208}Pb. This 38th energy group photon source contributes most of the calculated photon dose rates presented in Tables 5.1 and 5.2. The photon spectrum computed by ORIGEN-S includes photons arising from X-rays, gamma-rays, internal bremsstrahlung, spontaneous fission gamma-rays, and gamma-ray accompanying (α, n) reactions.

Table 5.4. Photon source for 1 g of HEU for all contents

Group number	Energy range (MeV)	Source [a] (photons/s)
1	0.005–0.010	$8.515 \times 10^{+4}$
2	0.010–0.015	$1.700 \times 10^{+6}$
3	0.015–0.020	$7.313 \times 10^{+3}$
4	0.020–0.025	$3.595 \times 10^{+3}$
5	0.025–0.030	$1.230 \times 10^{+5}$
6	0.030–0.040	$5.112 \times 10^{+3}$
7	0.040–0.050	$6.605 \times 10^{+3}$
8	0.050–0.060	$2.147 \times 10^{+5}$
9	0.060–0.070	$1.779 \times 10^{+3}$
10	0.070–0.080	$1.941 \times 10^{+4}$
11	0.080–0.090	$1.085 \times 10^{+5}$
12	0.090–0.100	$2.244 \times 10^{+5}$
13	0.100–0.200	$1.328 \times 10^{+5}$
14	0.200–0.300	$5.245 \times 10^{+4}$
15	0.300–0.400	$2.819 \times 10^{+5}$
16	0.400–0.500	$1.556 \times 10^{+4}$
17	0.500–0.600	$1.225 \times 10^{+4}$
18	0.600–0.700	$1.485 \times 10^{+2}$
19	0.700–0.800	$2.705 \times 10^{+3}$
20	0.800–0.900	$1.802 \times 10^{+3}$
21	0.900–1.000	$4.068 \times 10^{+2}$
22	1.000–1.100	$2.527 \times 10^{+2}$
23	1.100–1.200	$2.157 \times 10^{+1}$
24	1.200–1.300	$2.105 \times 10^{+1}$
25	1.300–1.400	$2.990 \times 10^{+1}$
26	1.400–1.500	$1.300 \times 10^{+1}$
27	1.500–1.600	$1.386 \times 10^{+2}$
28	1.600–1.700	$4.719 \times 10^{+2}$
29	1.700–1.800	$5.522 \times 10^{+0}$
30	1.800–1.900	$2.999 \times 10^{+1}$
31	1.900–2.000	$4.918 \times 10^{+0}$
32	2.000–2.100	1.599×10^{-2}
33	2.100–2.200	1.308×10^{-2}
34	2.200–2.300	7.152×10^{-2}
35	2.300–2.400	5.321×10^{-4}
36	2.400–2.500	1.584×10^{-2}
37	2.500–2.600	6.552×10^{-5}
38	2.600–2.700	$1.062 \times 10^{+4}$
39	2.700–2.800	1.108×10^{-2}
40	2.800–2.900	1.917×10^{-4}
41	2.900–3.000	3.408×10^{-4}
42	3.000–3.500	6.039×10^{-1}
43	3.500–4.000	3.876×10^{-1}
44	4.000–5.000	2.959×10^{-3}
45	5.000–6.500	1.134×10^{-3}
46	6.500–8.000	2.131×10^{-4}
47	8.000–10.00	4.388×10^{-5}
Total		**$3.011 \times 10^{+6}$**

[a] ORIGEN-S code results at 10.5 years decay (NUREG/CR-0200).

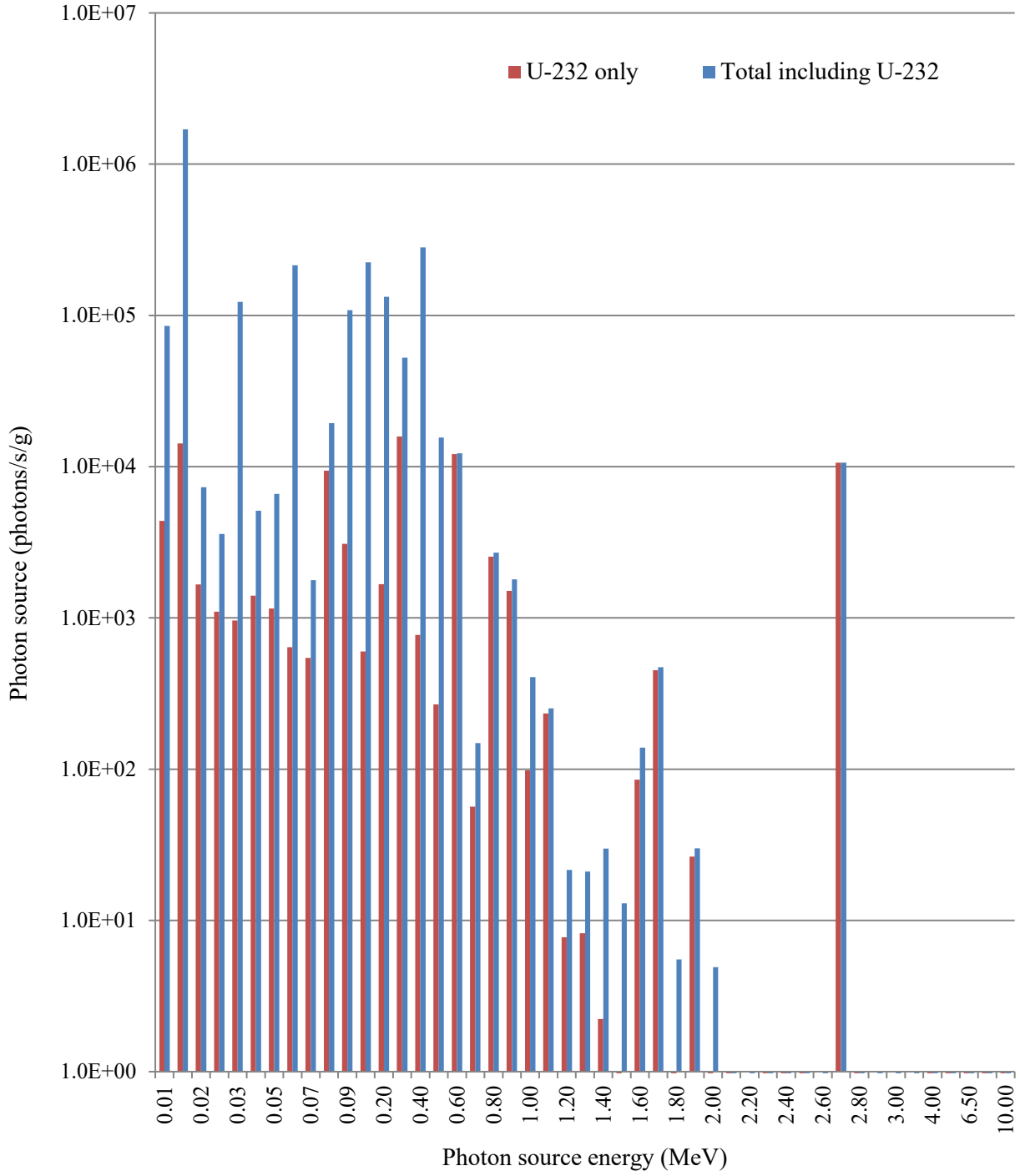


Fig. 5.1. Photon spectrum for ^{232}U only and HEU content including ^{232}U.

5.2.2 Neutron Source

The neutron source given in Table 5.5 is generated using ORIGEN-S as a function of the 27 energy group neutron spectrum and decay time. It is shown that the neutron spectrum around 50 years decay time provide maximum neutron dose rates. Figure 5.2 shows the neutron spectrum for different neutron source constituents. Figure 5.2 shows transuranic components contribute most of the neutron source spectrum, particularly at higher energy intervals. Neutron source from the spontaneous fission, (α, n), and delayed neutrons are included in Table 5.5 spectrum. Induced fission neutrons and secondary photons are included in the dose rate calculations. Oxygen was not included in the uranium oxide source calculation, but the neutron source includes (α, n) neutrons from the UO_2 default option in the ORIGEN-S code (NUREG/CR-0200, Vol. II, Sect. F7). The production of neutrons from subcritical multiplication is calculated as part of the shielding evaluation by using the default option (i.e., no NONU card in the MCNP input file). If the NONU card is not used, all cells are given their regular treatment of real fission. The neutrons are captured by the fissile and fissionable materials producing neutron-induced fissions.

Table 5.5. Neutron source for 1 g of HEU for all contents

Group number	Energy range (MeV)	Source [a] (neutrons/s)
1–17	$1.00 \times 10^{-11} – 5.83 \times 10^{-4}$	0 [b]
18	$5.83 \times 10^{-4} – 3.04 \times 10^{-3}$	7.034×10^{-6}
19	$3.04 \times 10^{-3} – 1.50 \times 10^{-2}$	8.280×10^{-5}
20	$1.50 \times 10^{-2} – 1.11 \times 10^{-1}$	1.790×10^{-3}
21	$1.11 \times 10^{-1} – 4.08 \times 10^{-1}$	8.973×10^{-3}
22	$4.08 \times 10^{-1} – 9.07 \times 10^{-1}$	1.572×10^{-2}
23	$9.07 \times 10^{-1} – 1.42 \times 10^{+0}$	2.205×10^{-2}
24	$1.42 \times 10^{+0} – 1.83 \times 10^{+0}$	2.510×10^{-2}
25	$1.83 \times 10^{+0} – 3.01 \times 10^{+0}$	1.042×10^{-1}
26	$3.01 \times 10^{+0} – 6.38 \times 10^{+0}$	3.430×10^{-2}
27	$6.38 \times 10^{+0} – 2.00 \times 10^{+1}$	7.260×10^{-4}
Total		**2.129×10^{-1}**

[a] ORIGEN-S code results at 50 years decay (NUREG/CR-0200).
[b] Source is assumed to be zero for Groups 1–17 because of their low contributions.

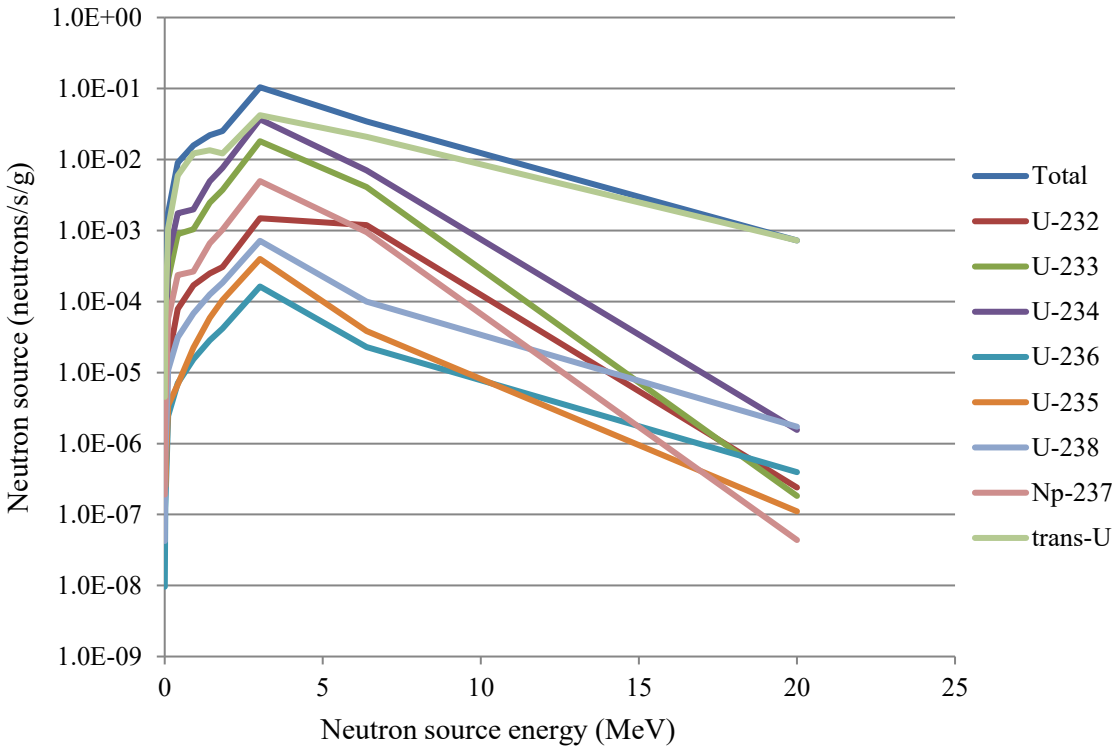


Fig. 5.2. Neutron spectrum for HEU source composition.

5.3 SHIELDING MODEL

The geometry of the shielding analysis model inside the CV is conservative because no packing materials besides the content are included in the model. The analyzed package contents are (a) 36 kg of HEU metal and (b) 24 kg of HEU oxide. The 36 kg of HEU metal analyzed are in the form of a solid cylinder, cylindrical shell, vertical plate, cylindrical hemi-shell, single solid rod, and cylindrical segment. The HEU metal in the form of a cylinder with the same radius as the CV is moved to the bottom and top of the CV for the maximum bottom and top dose rate configurations. The HEU metal in all configurations mentioned are analyzed for the maximum side dose rates. The 24 kg of HEU oxide powder analyzed are in cylindrical and cylindrical-shell forms of varying height and density. The material with maximum density in cylindrical shape and with the same radius as the CV is moved to the bottom and top of the CV for the maximum bottom and top dose rate configurations for the HEU oxide. The worst cases at the bottom, side, and top dose rates for the HEU metal and oxide are presented in Tables 5.1 and 5.2, and are assumed to bound any possible source configuration for the container.

Three-dimensional detailed geometric models are created to calculate the dose rates external to the ES-3100 shipping package when loaded with each of the configurations outlined in Sect. 5.3.1. Figure 5.3 presents the packaging without any content. The details of several sections of the packaging are shown in Figs. 5.4, 5.5, and 5.6. The shielding model of the ES-3100 package is represented in the MCNP Monte Carlo radiation transport code to perform the photon and neutron transport and dose rate calculations (LA-UR-03-1987) for these configurations. Dose rates are calculated in by converting the photon and neutron fluxes using the American National Standards Institute and American Nuclear Society conversion factors (ANSI/ANS-6.1.1).

5.3.1 Configuration of Source and Shielding

The photon and neutron sources from the radioactive contents described in the previous section and listed in Tables 5.4 and 5.5, are input to the MCNP code to calculate the ES-3100 external package dose rates given in Tables 5.1, 5.2, and 5.7.

The packaging component drawings are shown in Appendix 1.3.1. The package contents analyzed are (a) 36 kg of HEU metal and (b) 24 kg of HEU oxide. The analyses of these models have been performed in a manner covering all other proposed contents identified in Sect. 1.2.2 in an equivalent or conservative manner. Figure 5.7 shows the NCT and HAC calculation models in MCNP for cylinder type HEU metal source configuration. Figure 5.8 shows the NCT calculation model for UO_2 source configuration.

There are no radiation streaming paths from the source toward the package exterior. The models are analyzed for both photon and neutron sources, and for both NCT and HAC. Table 5.6 lists the locations of the external dose-rate detectors for the NCT and HAC models. For NCT, dose rates are calculated at detector locations that are identified by their distance from the external surface of the drum (1 mm and 1 m from the external surface of the drum). All components outside the CV are removed for HAC shielding models and the detector locations are modeled as if they were 1 m from the external surface of the CV. Additional information on the models is presented in Appendices 5.5.1 and 5.5.2.

The dose rates presented in Tables 5.1 and 5.2 should bound the dose rates for all proposed content loadings in the ES-3100. In some cases, it is not possible or practical to find an exact maximum dose rate geometric configuration due to the statistical uncertainty of the calculation method, variations in model radius vs. height, variable densities, source configuration, etc. The presence of 800-ppm transuranic trace elements has no effect on the photon dose rates. Although it has significant effects on the neutron dose rates, the neutron dose rates constitute only 2.0% or less of the total dose rates.

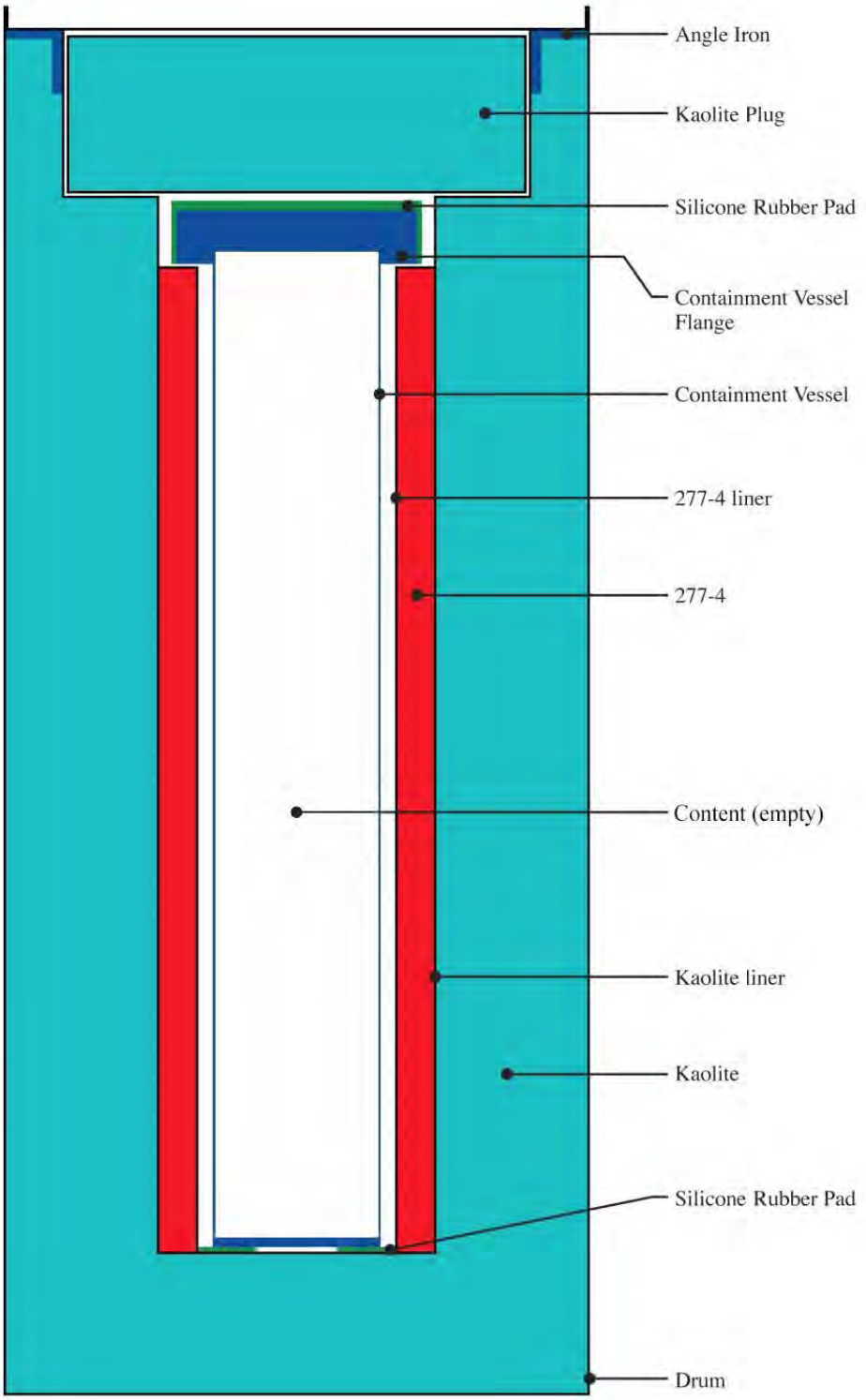
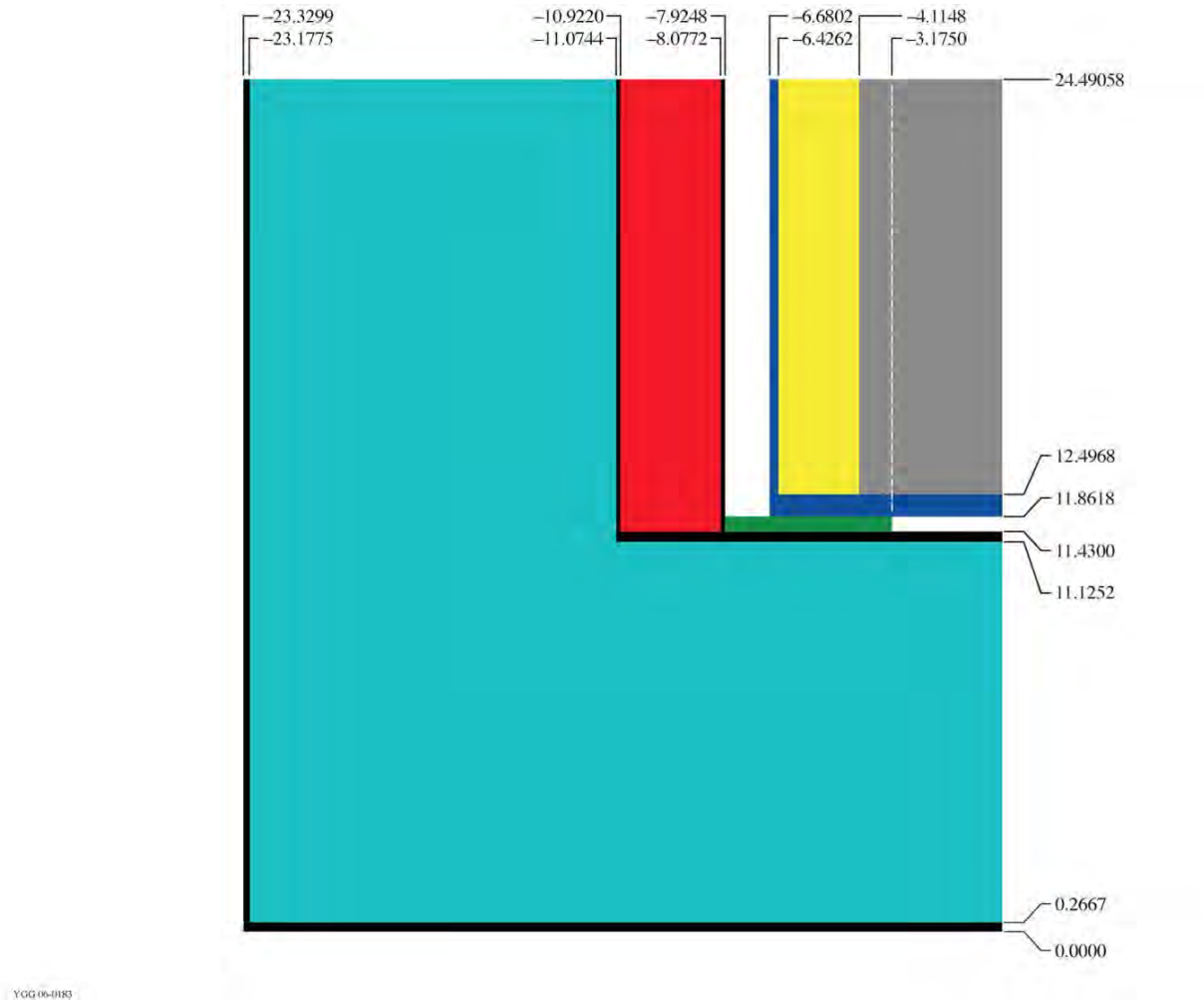
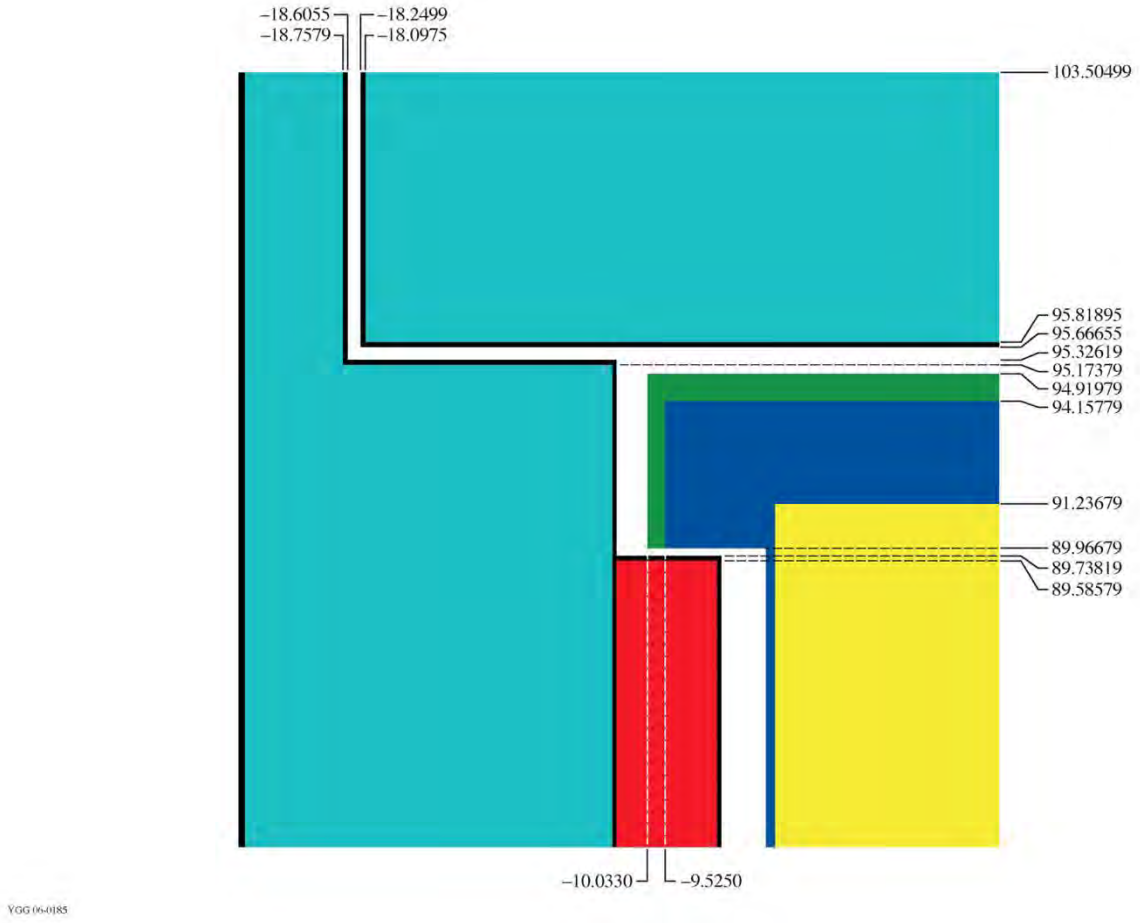


Fig. 5.3. ES-3100 packaging model.



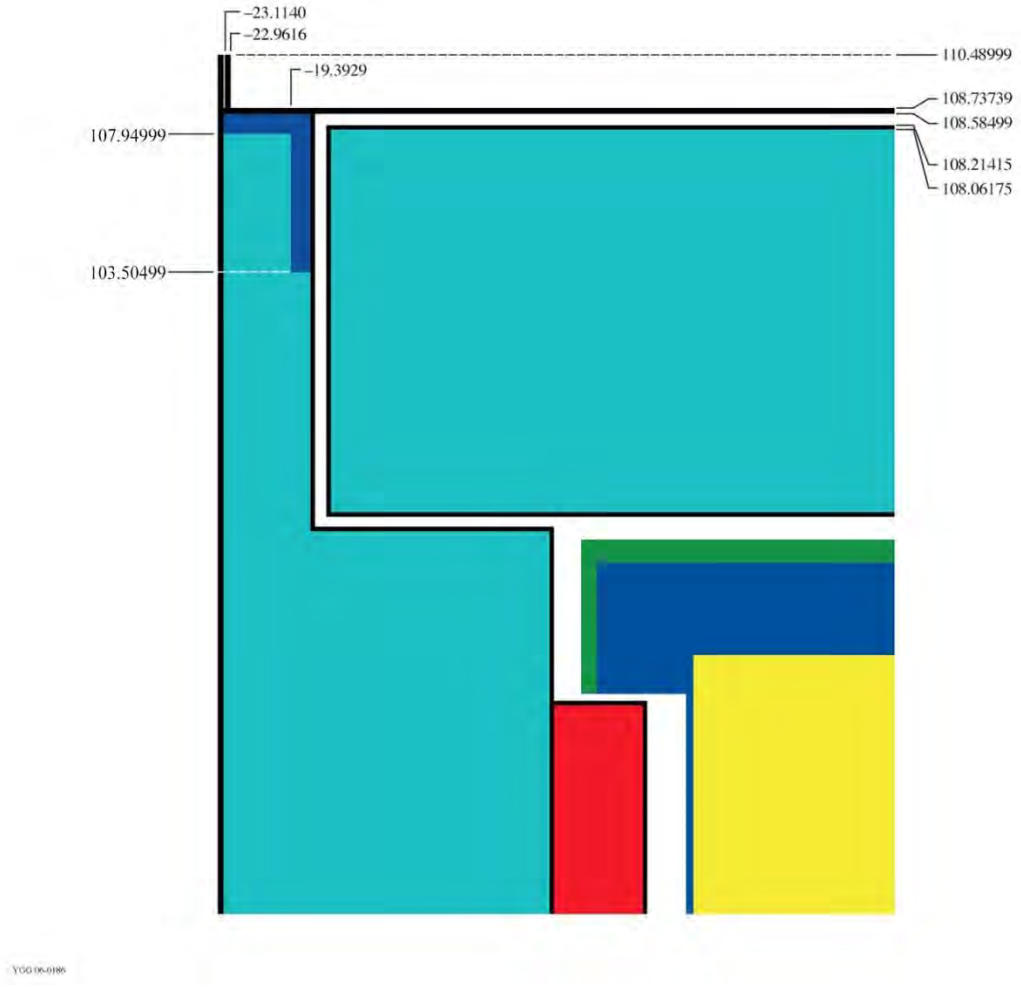
Note: Dimensions are in centimeters.

Fig. 5.4. R/Z section at the bottom of the ES-3100 package model.



Note: Dimensions are in centimeters.

Fig. 5.5. R/Z section near the top of the ES-3100 package model.



Note: Dimensions are in centimeters.

Fig. 5.6. R/Z section at the top of the ES-3100 package model.

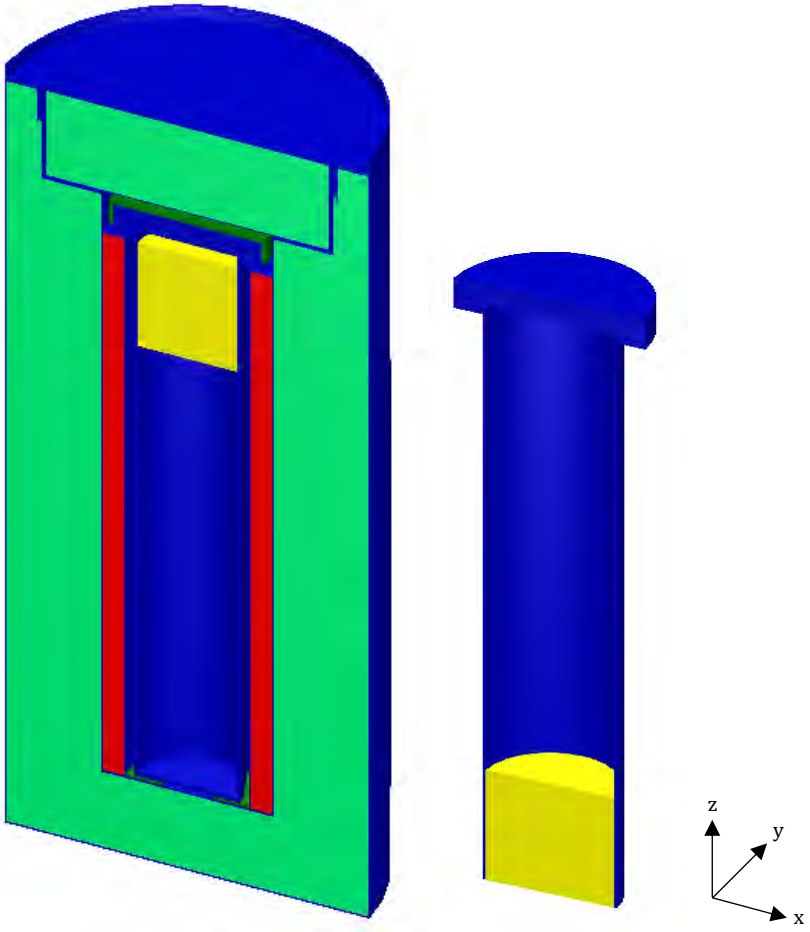


Fig. 5.7. Calculation model of the ES-3100 shipping package (x-z side section) for NCT with cylinder-type source configuration at the top of CV (left) and for HAC with cylinder type source configuration at the bottom of CV (right).

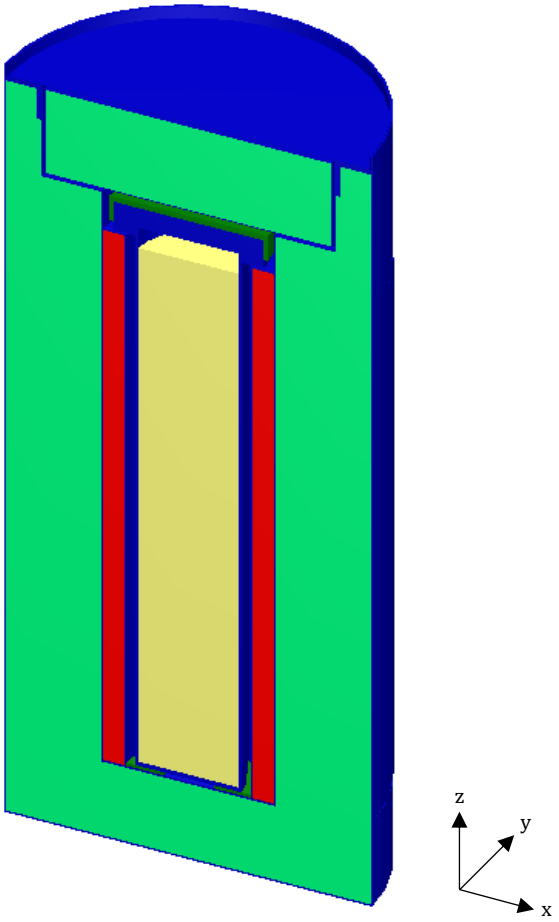


Fig. 5.8. Calculation model of the ES-3100 shipping package for NCT with UO_2 powder shown in yellow (x-z side section).

Table 5.6. Radiation detector locations

Description	Radius [a] (cm)	Position [b] (cm)
NCT detectors [c]		
1 mm from the drum side [d]	23.4299	variable
1 mm from the drum top	0.0000	108.83739
1 mm from the drum bottom	0.0000	-0.1
1 m from the drum side [d]	123.3299	variable
1 m from the drum top	0.0000	208.73739
1 m from the drum bottom	0.0000	-100.0
HAC detectors [c]		
1 m from the containment vessel (CV) side [d]	106.6802	variable
1 m from the CV top	0.0000	194.15779
1 m from the CV bottom	0.0000	-88.1382

[a] Radial distance from the centerline of the drum along x-axis. (Source is symmetrically placed on the +x-axis.)
[b] Distance from drum base for NCT detectors and from CV base for HAC detectors.
[c] Locations are relative to the drum for NCT and relative to the containment vessel for HAC.
[d] Surface side location is at the axial mid-point of the content height.

5.3.1.1 Photon model for 36-kg HEU metal content

The HEU metal content in the ES-3100 may be many small, irregularly shaped pieces, each placed at some arbitrary orientation inside the convenience cans. Several conservative, regular geometry models have been devised to cover these and other proposed loadings. The convenience cans and can spacers are omitted from the models and these assumptions are conservative.

Six geometric models inside the CV are analyzed to calculate the liming dose rates for HEU metal content. The geometric configurations are solid cylinder (Fig. 5.9), cylindrical hemi-shell (Fig. 5.10), cylindrical shell (Fig. 5.11), plate (Fig. 5.12), single rod (Fig. 5.13), and cylindrical segment (Fig. 5.14). The figures show the sectional views of these configurations. The 1 mm and 1 m from the drum side surface and 1 m from the CV side surface dose rates with uncertainty for these configurations are presented in Table 5.7. The cylindrical hemi-shell configuration produces the maximum NCT and HAC side photon dose rates, which are presented in Table 5.1. Brief descriptions of the six configurations are discussed below.

Solid cylinder configuration: A solid uranium metal cylinder of 6.35 cm radius and 15.1003 cm height is placed either at the top or at the bottom of the CV. The solid cylinder at the top configuration produces the maximum photon dose rates at the: (1) 1 mm and 1 m from the top surface for NCT and (2) 1 m from the top CV surface for HAC. This top configuration also produces the maximum neutron dose rates at the: (1) 1 mm and 1 m from the drum top and side surface for NCT and (2) 1 m from the CV top and side surface for HAC. The solid cylinder at the bottom configuration produces the maximum photon dose rates at the: (1) 1 mm and 1 m from the drum bottom surface for NCT and (2) 1 m from bottom CV surface for HAC. This bottom configuration also produces the maximum neutron dose rates at the: (1) 1 mm and 1 m from the drum bottom surface for NCT and (2) 1 m from CV bottom surface for HAC. These maximum dose rates are presented in Table 5.1. The side and top sections of the solid cylinder configuration are shown in Fig. 5.9.

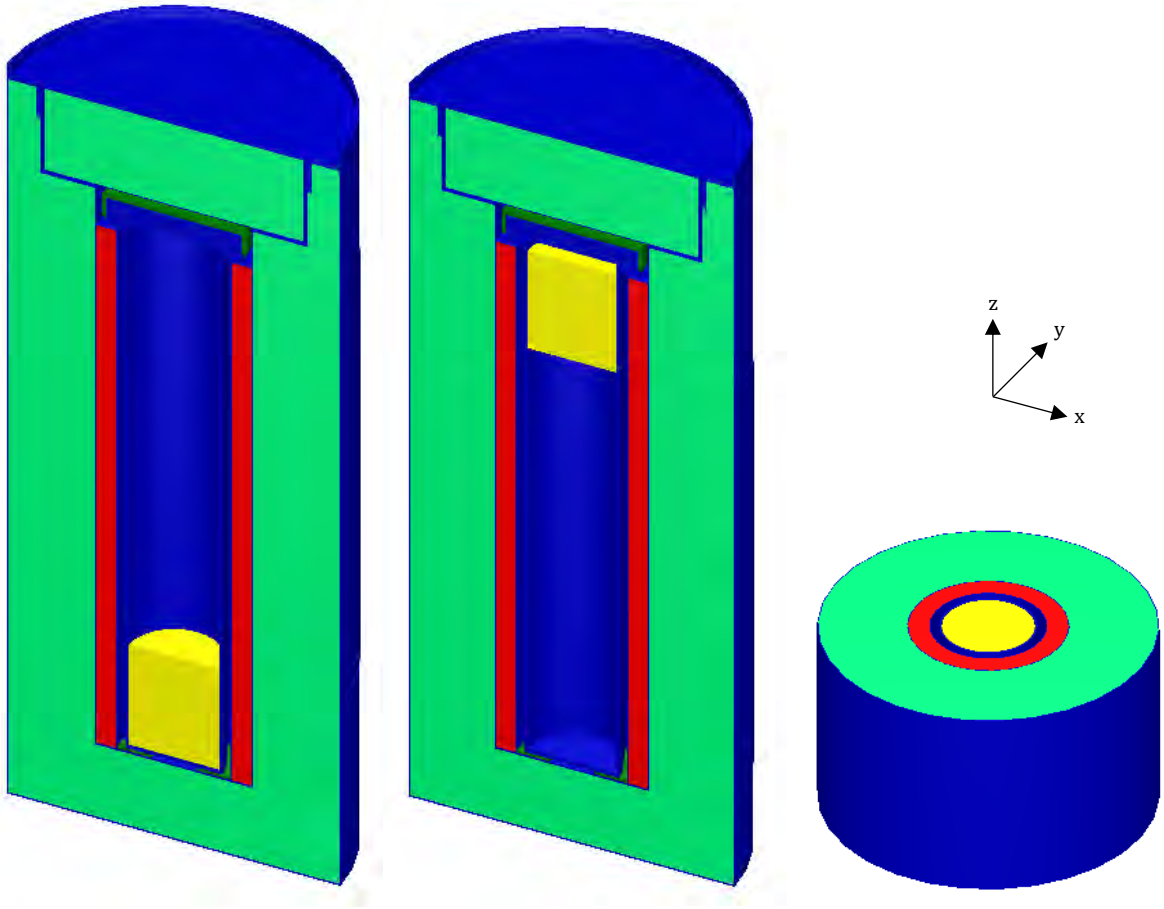


Fig. 5.9. Calculation model of the ES-3100 shipping package for NCT with cylinder type source configuration shown in yellow (x-z side and x-y top sections).

Cylindrical hemi-shell configuration: A cylindrical hemi-shell of 4.9337 cm inner radius, 6.35 cm outer radius, and 76.2 cm height with interior opening inward is placed inside the CV along +x axis. This configuration produces the maximum photon dose rates at the: (1) 1 mm and 1 m from the drum side for NCT, and (2) 1 m from the CV side surface for HAC. These dose rates are presented in Table 5.1. The side and top sections of the cylindrical hemi-shell calculation model are shown in Fig. 5.10.

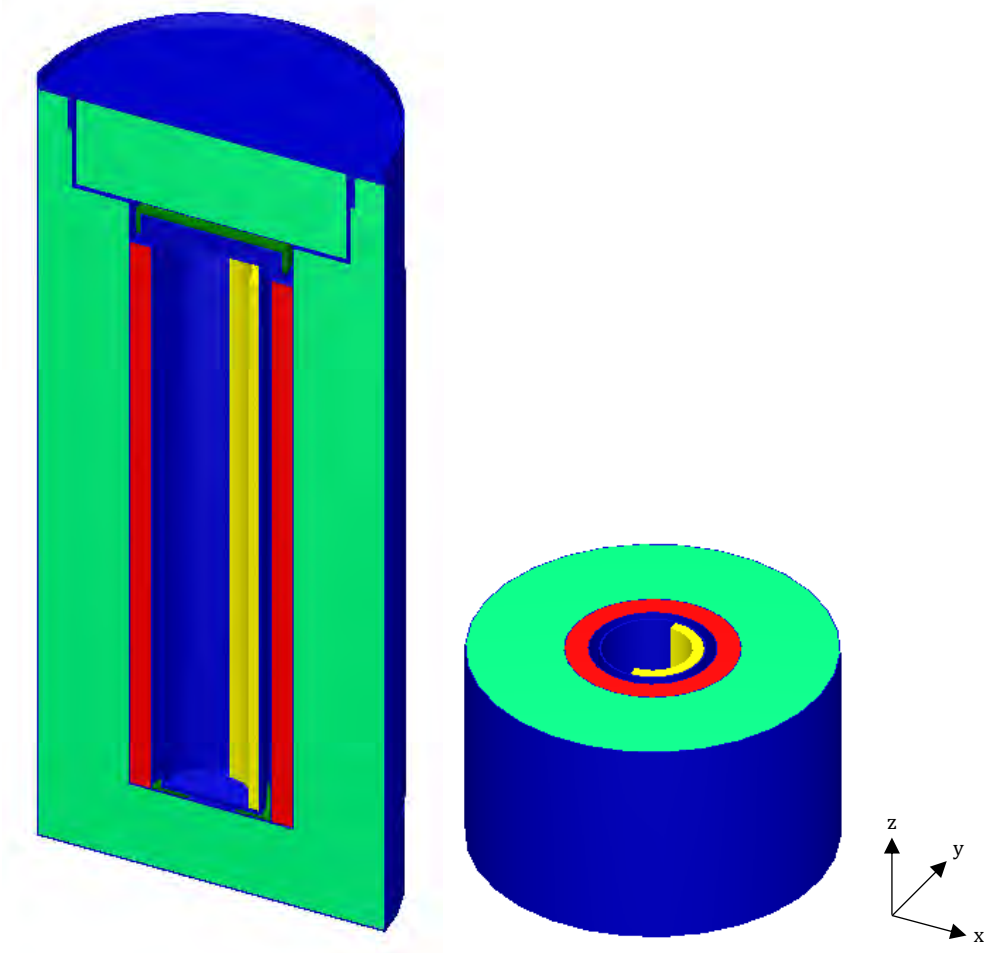


Fig. 5.10. Calculation model of the ES-3100 shipping package for NCT with cylindrical hemi-shell source configuration shown in yellow (x-z side and x-y top sections).

Cylindrical shell configuration: A cylindrical shell of variable inner radius and height with 6.35 cm outer radius is placed inside the CV for investigating side surface dose rates. The shell of 5.6861 cm inner radius and 76.2 cm height produces the maximum NCT dose rates at 1 mm and 1 m from the drum side surface and the HAC dose rates at 1 m from the CV surface for the cylindrical shell configuration. The side and top sections of the cylindrical shell calculation model are shown in Fig. 5.11.

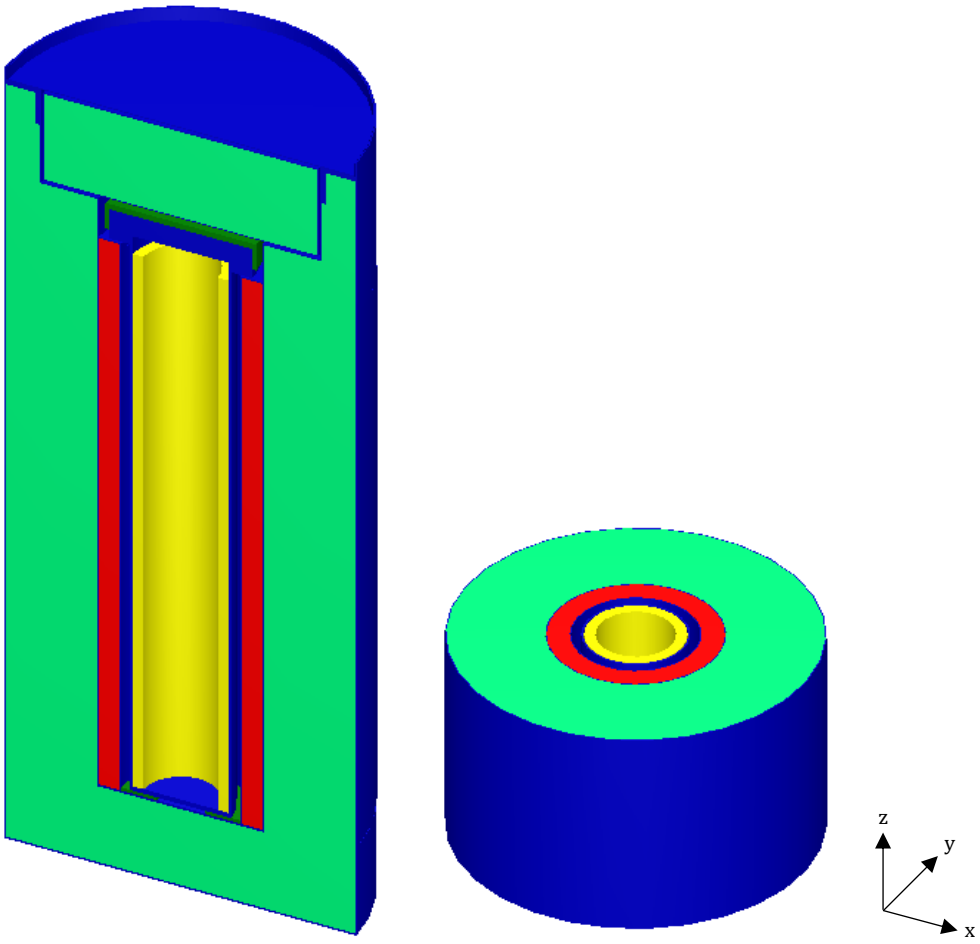


Fig. 5.11. Calculation model of the ES-3100 shipping package for NCT with cylindrical shell source configuration shown in yellow (x-z side and x-y top sections).

Rectangular plate configuration: A rectangular plate of 1.9829 cm width, 12.66 cm length, and 76.2 cm height is placed along the centerline on the y-axis. The NCT 1 mm and 1 m from the drum side surface, and the HAC 1 m from the CV side surface dose rates are calculated and presented in Table 5.7. The side and top sections of the plate calculation model are shown in Fig. 5.12.

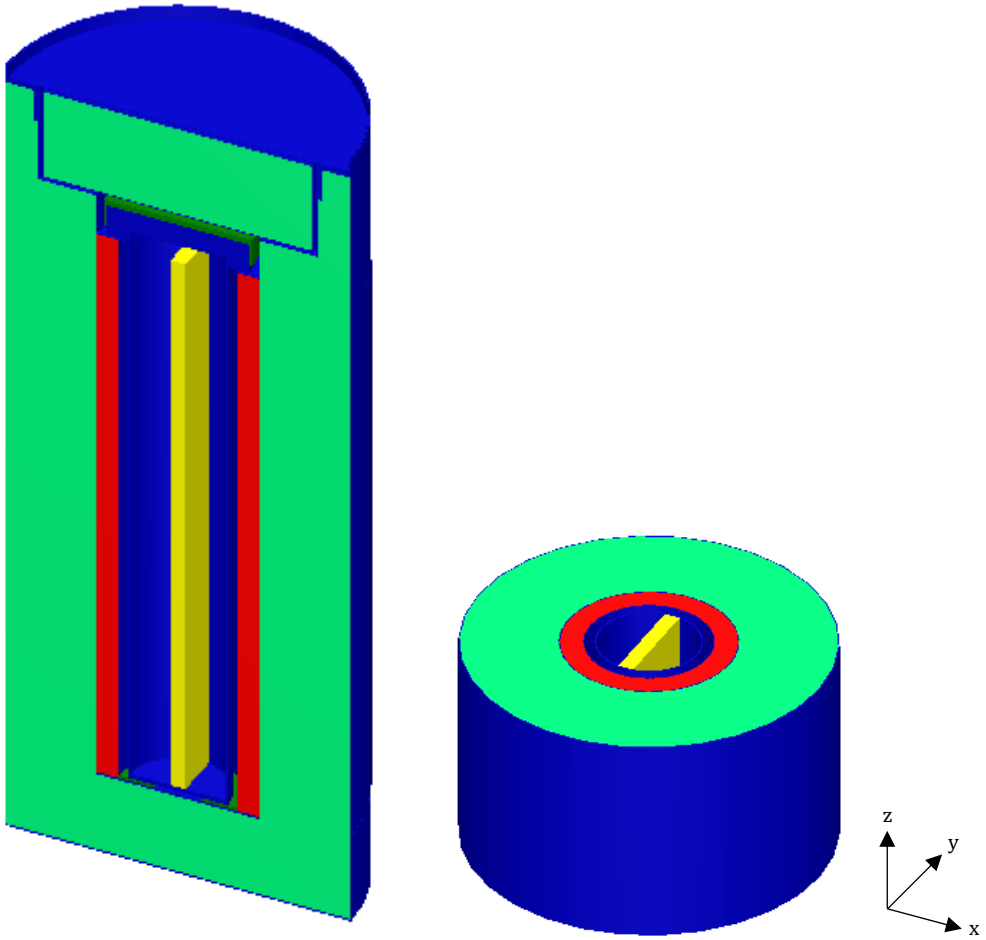


Fig. 5.12. Calculation model of the ES-3100 shipping package for NCT with plate type source configuration shown in yellow (x-z side and x-y top section).

Cylindrical rod configuration: A cylindrical rod of 2.82675 cm radius and 76.2 cm length is placed along x-axis close to the CV. The NCT 1 mm and 1 m from the drum side surface, and the HAC 1 m from the CV side surface dose rates are presented in Table 5.7. The side and top sections of the cylindrical rod calculation model are shown in Fig. 5.13.

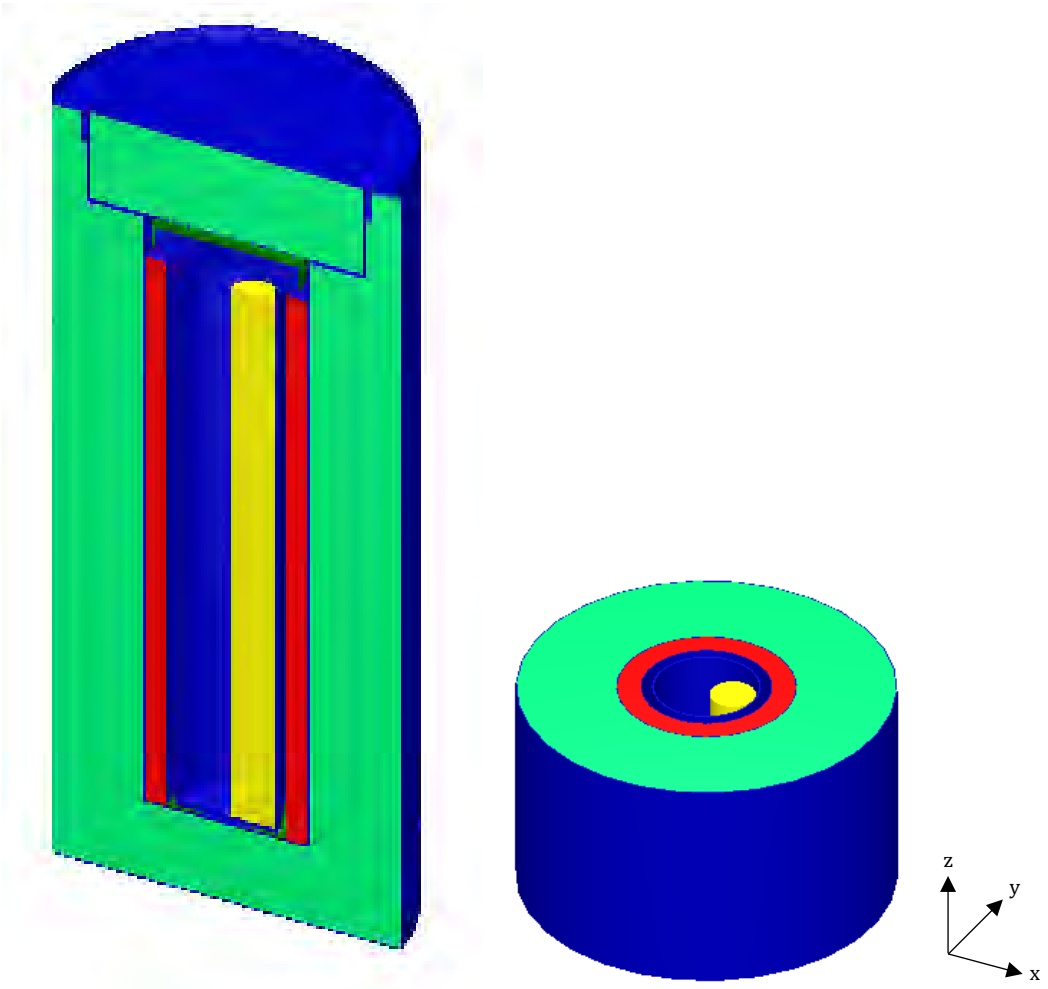


Fig. 5.13. Calculation model of the ES-3100 shipping package for NCT with single rod source configuration shown in yellow (x-z side and x-y top sections).

Cylindrical segment configuration: A cylindrical segment of 6.35 cm radius and 76.2 cm height, which is 3.1442 cm off from the center, is placed along x-axis close to the CV. The NCT 1 mm and 1 m from the drum side surface, and the HAC 1 m from the CV side surface dose rates are presented in Table 5.7. The side and top sections of the cylindrical segment calculation model are shown in Fig. 5.14.

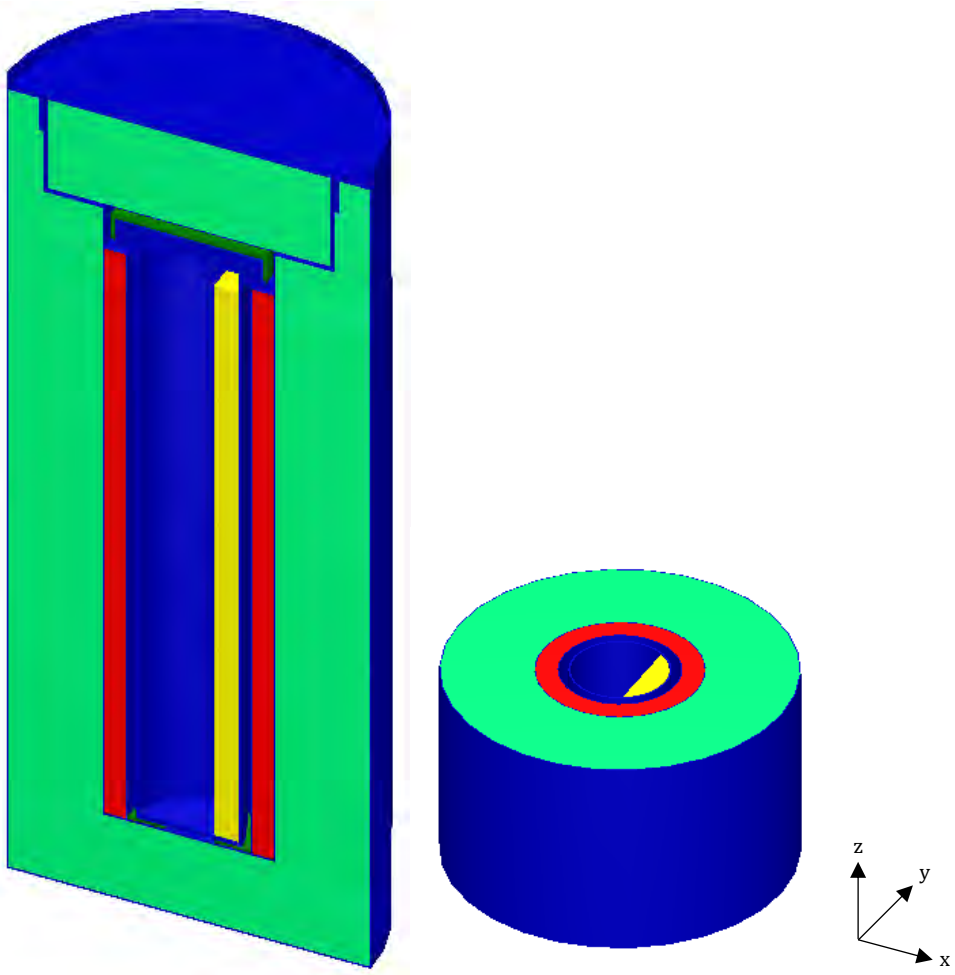


Fig. 5.14. Calculation model of the ES-3100 shipping package for NCT with cylindrical segment source configuration shown in yellow (x-z side and x-y top sections).

Table 5.7. Side dose rates for different HEU metal source configurations

Configuration	Description	Dose rates (mrem/h) with ± one sigma uncertainty (%) [a]		
1 mm from the drum side surface				
NCT	**Dimension (cm) [b]**	**NCT photon**	**NCT neutron [c]**	**NCT photon and neutron**
Solid cylinder at the top of CV	Radius = 6.35 Height = 15.1003	49.6250 ± 0.66%	1.5787 ± 0.32%	51.2038 ± 0.64%
Solid cylinder at the bottom of CV	Radius = 6.35 Height = 15.1003	51.4160 ± 0.77%	1.1937 ± 0.27%	52.6097 ± 0.75%
Cylindrical hemi-shell	IR = 4.9337 OR = 6.35	95.8000 ± 1.47%	0.1335 ± 0.38%	95.9335 ± 1.47%
Cylindrical shell	IR = 5.6861 OR = 6.35	93.4120 ± 2.02%	0.1039 ± 1.07%	93.5159 ± 2.02%
Rectangular plate	Width = 1.9829 Length = 12.66	91.6170 ± 1.50%	0.1214 ± 0.58%	91.7384 ± 1.50%
Cylindrical rod	Radius = 2.82675	58.7820 ± 0.46%	0.1629 ± 0.51%	58.9449 ± 0.46%
Cylindrical segment	Depth = 3.20548	94.3050 ± 1.19%	0.1757 ± 1.74%	94.4807 ± 1.19%
1 m from the drum side surface				
NCT	**Dimension (cm) [b]**	**NCT photon**	**NCT neutron [c]**	**NCT photon and neutron**
Solid cylinder at the top of CV	Radius = 6.35 Height = 15.1003	1.5469 ± 0.10%	0.0510 ± 0.19%	1.5979 ± 0.10%
Solid cylinder at the bottom of CV	Radius = 6.35 Height = 15.1003	1.6255 ± 0.10%	0.0383 ± 0.15%	1.6638 ± 0.10%
Cylindrical hemi-shell	IR = 4.9337 OR = 6.35	6.0639 ± 0.06%	0.0073 ± 0.02%	6.0712 ± 0.06%
Cylindrical shell	IR = 5.6861 OR = 6.35	6.0067 ± 0.05%	0.0060 ± 0.05%	6.0127 ± 0.05%
Rectangular plate	Width = 1.9829 Length = 12.66	5.8423 ± 0.05%	0.0071 ± 0.05%	5.8494 ± 0.05%
Cylindrical rod	Radius = 2.82675	3.5115 ± 0.07%	0.0086 ± 0.05%	3.5201 ± 0.07%
Cylindrical segment	Depth = 3.20548	5.5070 ± 0.05%	0.0089 ± 0.05%	5.5159 ± 0.05%
1 m from the CV side surface				
HAC	**Dimension (cm) [b]**	**HAC photon**	**HAC neutron [c]**	**HAC photon and neutron**
Solid cylinder at the top of CV	Radius = 6.35 Height = 15.1003	3.0745 ± 0.09%	0.0362 ± 0.15%	3.1107 ± 0.09%
Solid cylinder at the bottom of CV	Radius = 6.35 Height = 15.1003	3.1979 ± 0.09%	0.0311 ± 0.15%	3.2290 ± 0.09%
Cylindrical hemi-shell	IR = 4.9337 OR = 6.35	12.9060 ± 0.04%	0.0106 ± 0.01%	12.9166 ± 0.04%
Cylindrical shell	IR = 5.6861 OR = 6.35	12.5430 ± 0.06%	0.0362 ± 0.10%	12.5792 ± 0.06%
Rectangular plate	Width = 1.9829 Length = 12.66	12.5420 ± 0.06%	0.0107 ± 0.01%	12.5527 ± 0.06%
Cylindrical rod	Radius = 2.82675	7.0261 ± 0.09%	0.0120 ± 0.01%	7.0381 ± 0.09%
Cylindrical segment	Depth = 3.20548	11.8800 ± 0.20%	0.0130 ± 0.01%	11.8930 ± 0.20%

[a] MCNP5 Monte Carlo code results (LA-UR-03-1987). The uncertainty associated with the results is one standard deviation of the mean (i.e., one sigma uncertainty expressed as a percentage of the mean) calculated using MCNP5.
[b] Height is 76.2 cm for all configurations except solid cylinders at the top or bottom of CV.
[c] Includes secondary photon.

Table 5.7 shows the cylindrical hemi-shell configuration produces the maximum NCT and HAC side dose rates. The variations in dose rates described here are due to the variations in source-detector point geometry and the self-absorption of photons in the source material. Figures 5.15, 5.16, and 5.17 show photon dose rate and the associated absolute uncertainty contours for the cylindrical hemi-shell source configuration. The photon dose contours for the cylinder source configurations at the top and bottom of the cylinder are shown in Figs. 5.18 and 5.19. The photon dose rate contours for the rectangular plate source configuration in the x-z and y-z planes are shown in Figs. 5.20 and 5.21. The calculated dose rates for 36-kg HEU metal or 24-kg HEU oxide content defined in Table 5.3 are not close to the regulatory limits.

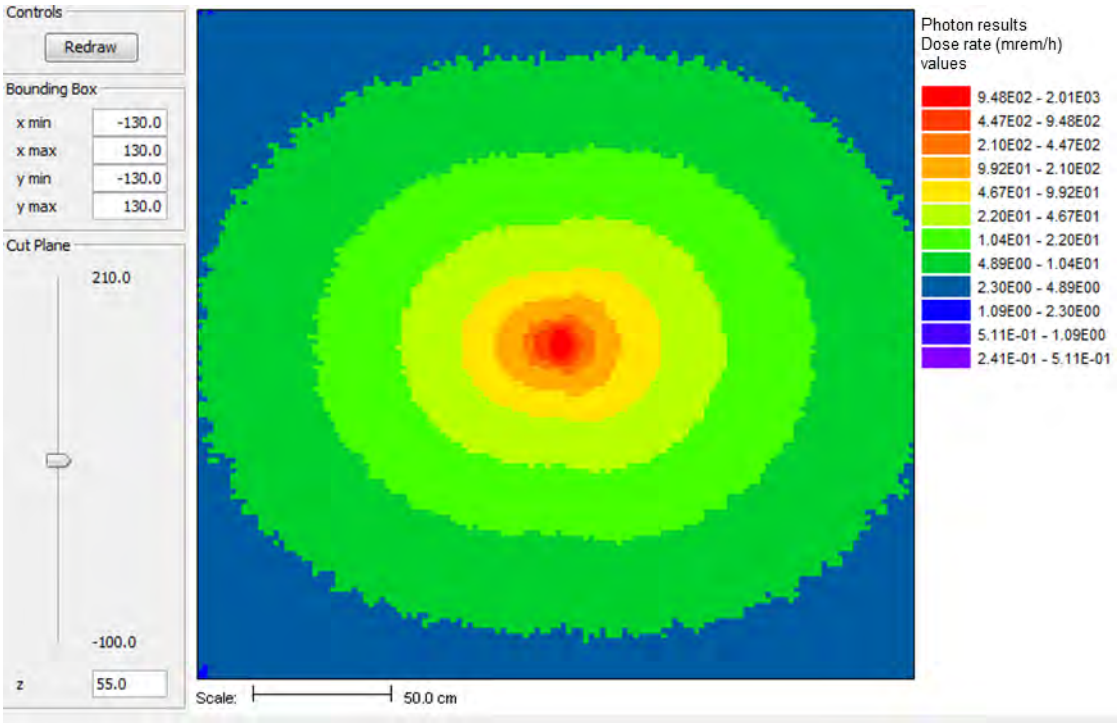


Fig. 5.15. Photon dose rate contours for the cylindrical hemi-shell configuration (x-y plane).

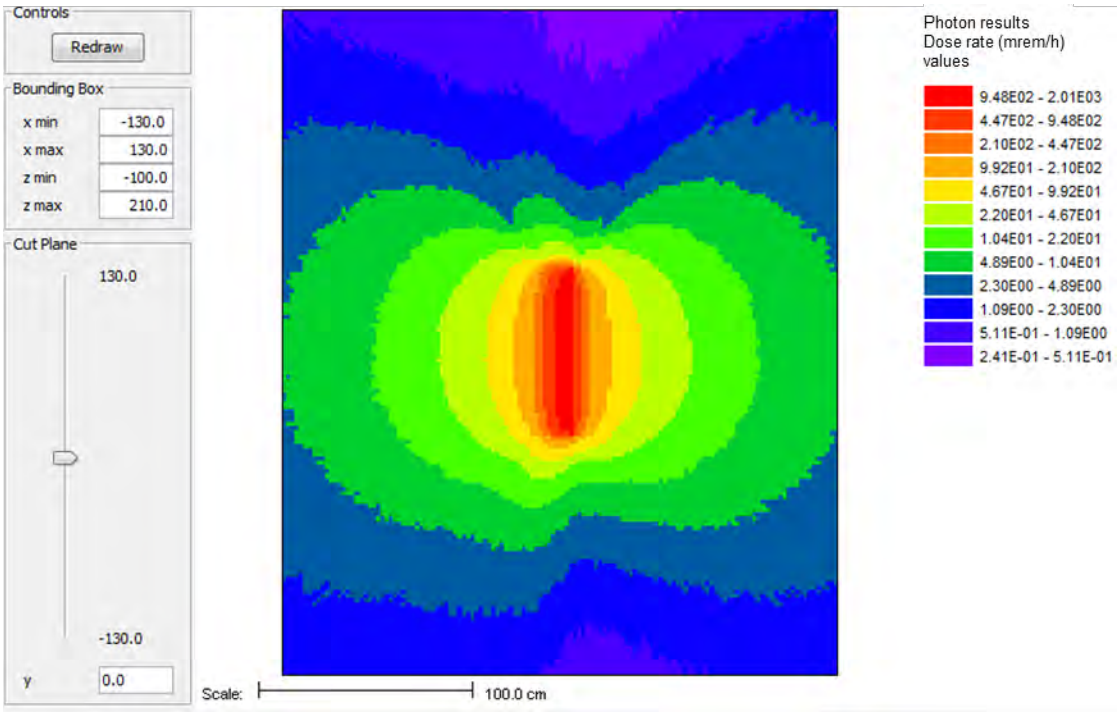


Fig. 5.16. Photon dose rate contours for the cylindrical hemi-shell configuration (x-z plane).

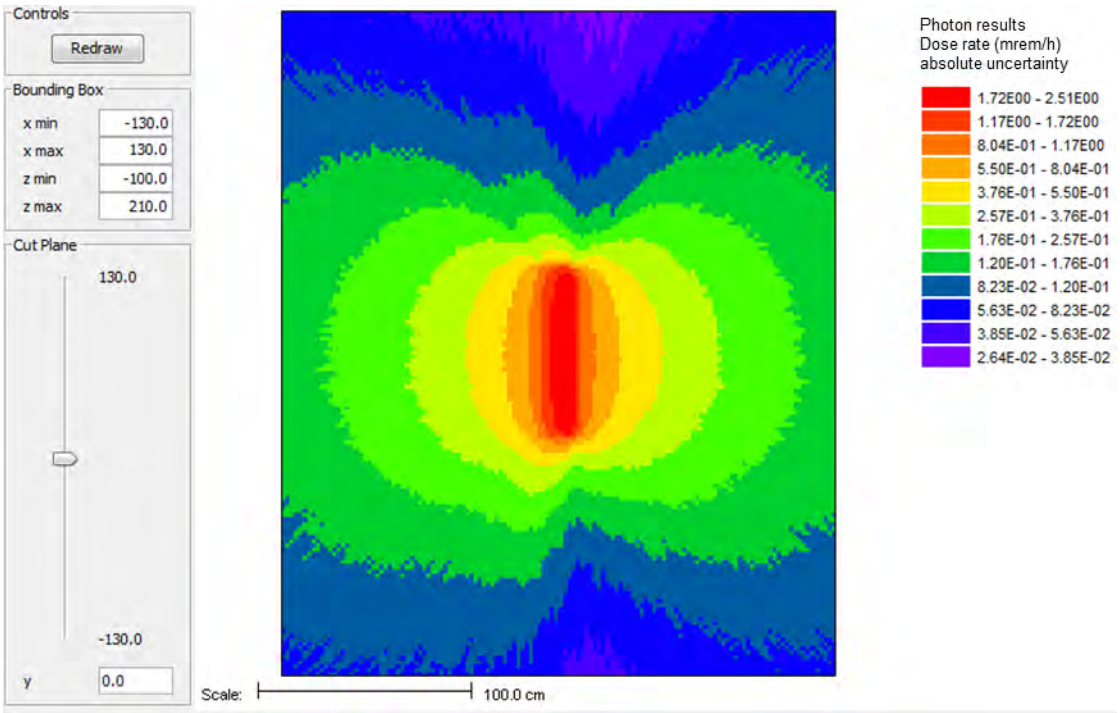


Fig. 5.17. Photon dose rate absolute uncertainty contours for the cylindrical hemi-shell configuration (x-z plane).

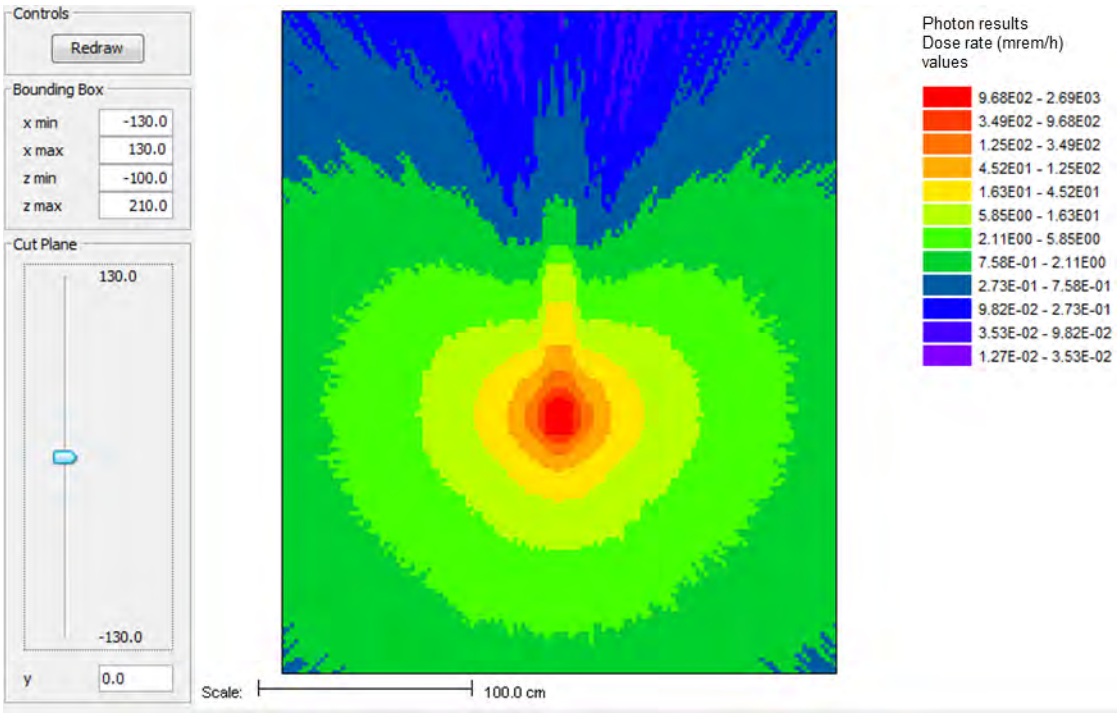


Fig. 5.18. Photon dose rate contours for the cylinder at the bottom of CV configuration (x-z plane).

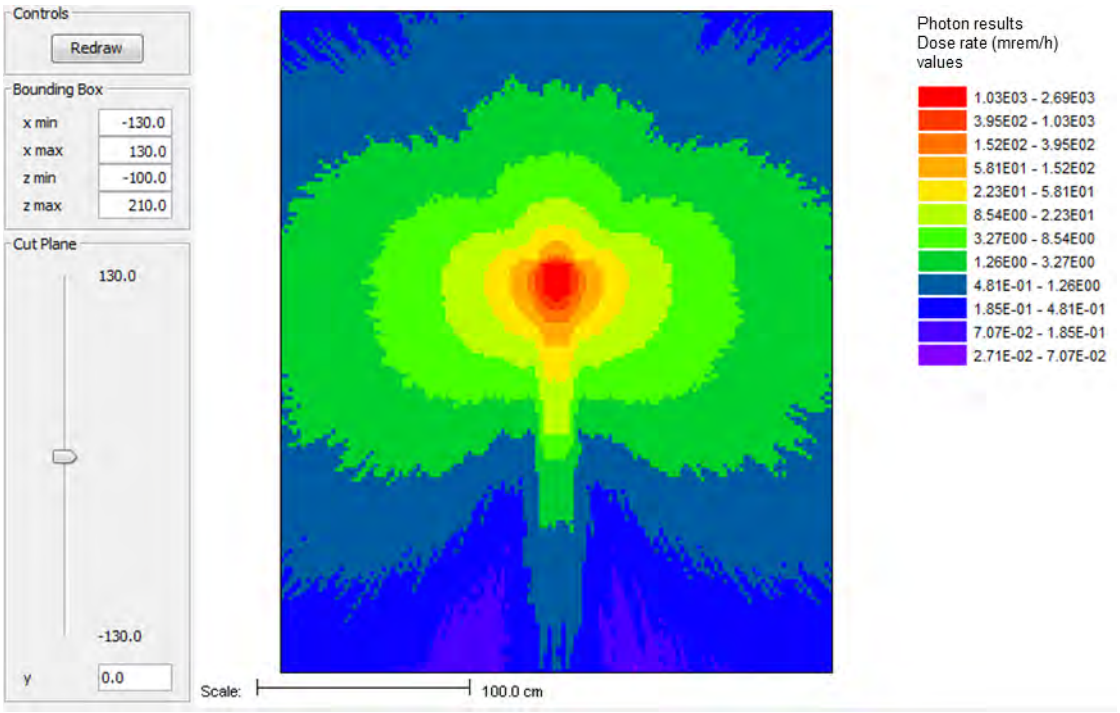


Fig. 5.19. Photon dose rate contours for the cylinder at the top of CV configuration (x-z plane).

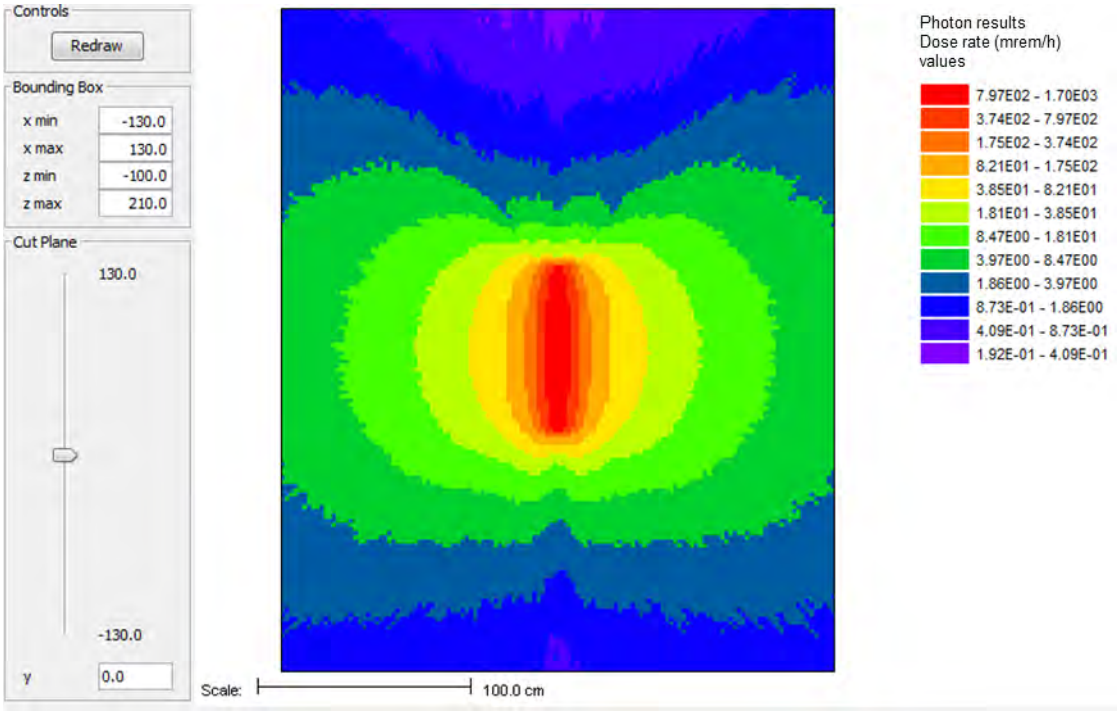


Fig. 5.20. Photon dose rate contours for the plate configuration (x-z plane).

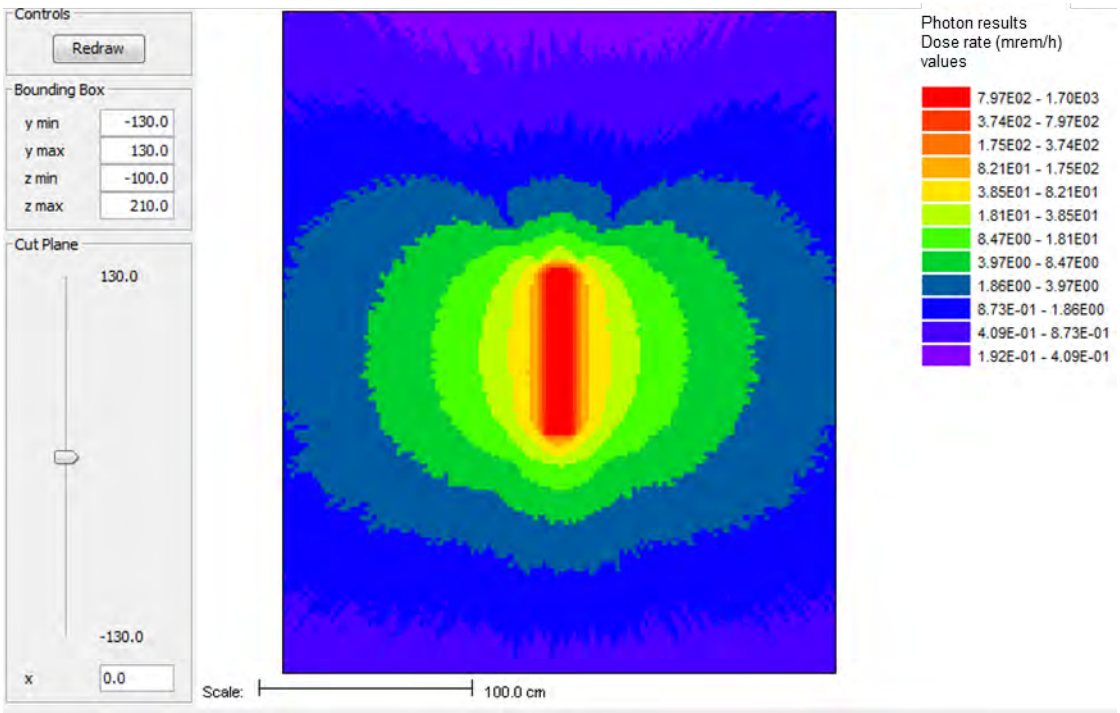


Fig. 5.21. Photon dose rate contours for the plate configuration (y-z plane).

5.3.1.2 Neutron model for 36-kg HEU metal content

For the NCT and HAC neutron top and bottom dose rate calculations for the 36-kg HEU contents, it was assumed all the uranium was a solid cylinder (i.e., radius = 6.35 cm, height = 15.1003 cm, and density = 18.82 g/cm^3) at the bottom or at the top of the CV. These configurations produce the maximum neutron top and bottom dose rates for both NCT and HAC. The results are presented in Table 5.1. The NCT and HAC neutron side dose rates are calculated for six different geometric configurations: solid cylinder (Fig. 5.9), cylindrical hemi-shell (Fig. 5.10), cylindrical shell (Fig. 5.11), plate (Fig. 5.12), single rod (Fig. 5.13), and cylindrical segment (Fig. 5.14). The side neutron dose rates for these configurations are presented in Table 5.7. The neutron dose rate and the associated absolute uncertainty contours for the cylindrical hemi-shell source configuration are shown in Figs. 5.22 and 5.23. The combined neutron and photon side dose rates for these configurations are also presented in Table 5.7. The combined side dose rates for NCT and HAC are the highest for the cylindrical hemi-shell configuration and is presented in Table 5.1.

5.3.1.3 Photon model for 24-kg HEU oxide content

The photon dose rate calculation model was developed to apply to 24 kg of HEU oxide content for all three common uranium oxides (i.e., UO_2, UO_3, and U_3O_8). The theoretical densities for these oxides are 10.96 g/cm^3, 7.29 g/cm^3, and 8.30 g/cm^3, respectively. In the package loading models, the convenience can locations are completely filled with oxide powder, and the actual densities, always less than theoretical values, will be the oxide mass divided by the model can volume. The dose rate model excludes the convenience cans, and it is represented by a solid cylinder of oxide resting on the CV interior base. The cylinder radius is 6.35 cm, and the height is variable. The density is adjusted for each calculation to preserve the 24-kg oxide mass. The HEU mass is 21.126 kg for UO_2, the largest uranium mass of the three oxides for 24 kg of HEU oxide. For side dose rate calculations, cylindrical shell with varying shell thickness and height with different UO_2 density from 2.5 to 10.96 g/cm^3 while maintaining the oxide mass of 24 kg have also been analyzed. Different configurations are analyzed to get the maximum dose rates that are presented in Table 5.2. The dose rates presented in Table 5.2 will also bound the dose rates from lower density oxides (i.e., <2.5 g/cm^3) and the oxide mass will be lower than 24 kg due to volumetric limitations inside the CV.

The photon NCT side dose rate is for a UO_2 cylinder of 47.365 cm height and 4.0 g/cm^3 density. The 1-m side NCT and side HAC photon dose rates are from the cylindrical shell configuration of 2.6275 cm inner radius, 6.35 cm outer radius, 76.2 cm height, and density of 3.0 g/cm^3. The top and bottom NCT and HAC photon dose rates are from the UO_2 solid cylinder configuration of density 10.96 g/cm^3 at the top and bottom of the CV, respectively. Figure 5.24 shows the photon dose-rate contours for the UO_2 cylinder of 75.785 cm height, 6.35 cm radius, and 2.5 g/cm^3 density.

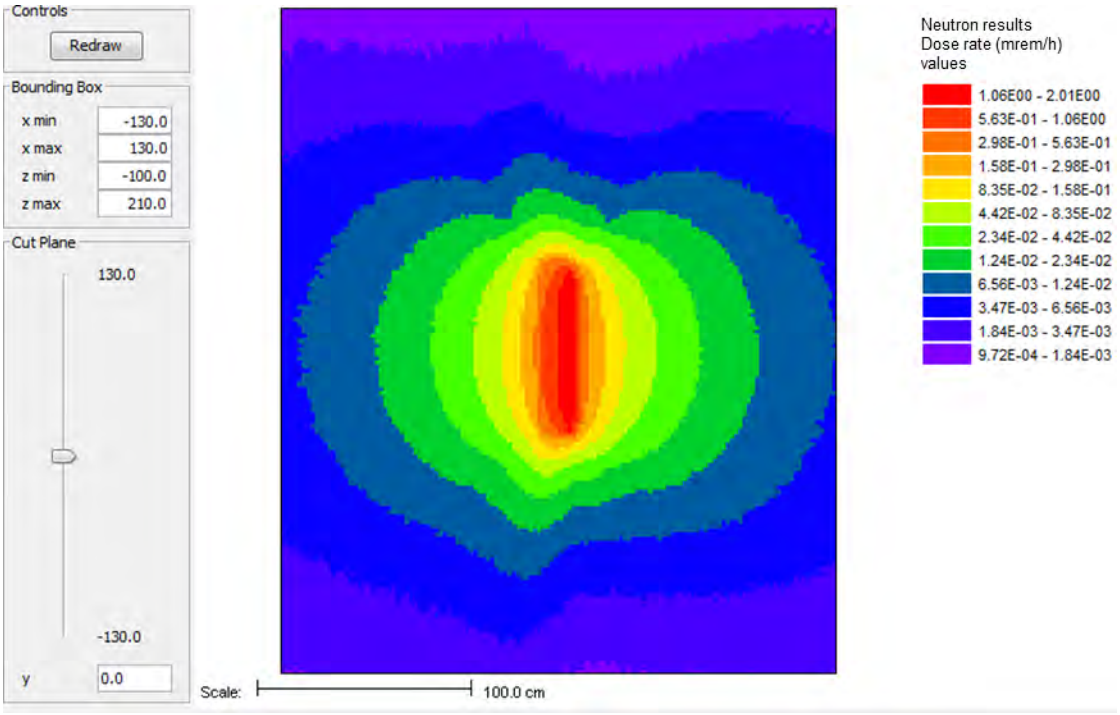


Fig. 5.22. Neutron dose rate contours for the cylindrical hemi-shell configuration (x-z plane).

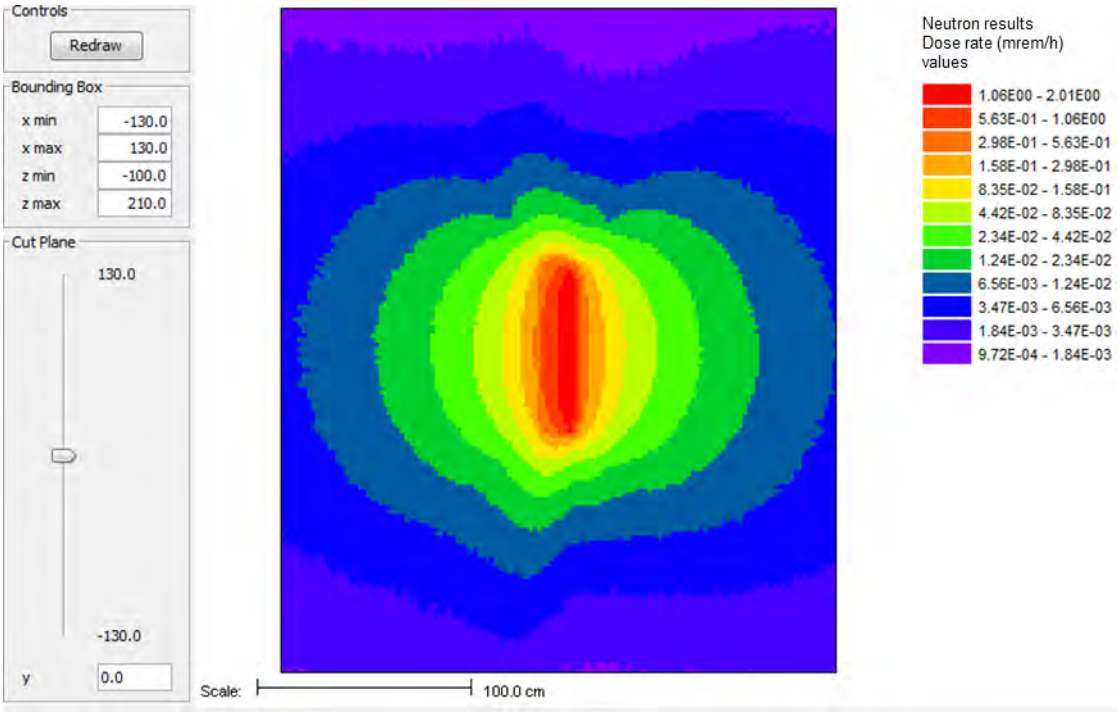


Fig. 5.23. Neutron dose rate absolute uncertainty contours for the cylindrical hemi-shell configuration (x-z plane).

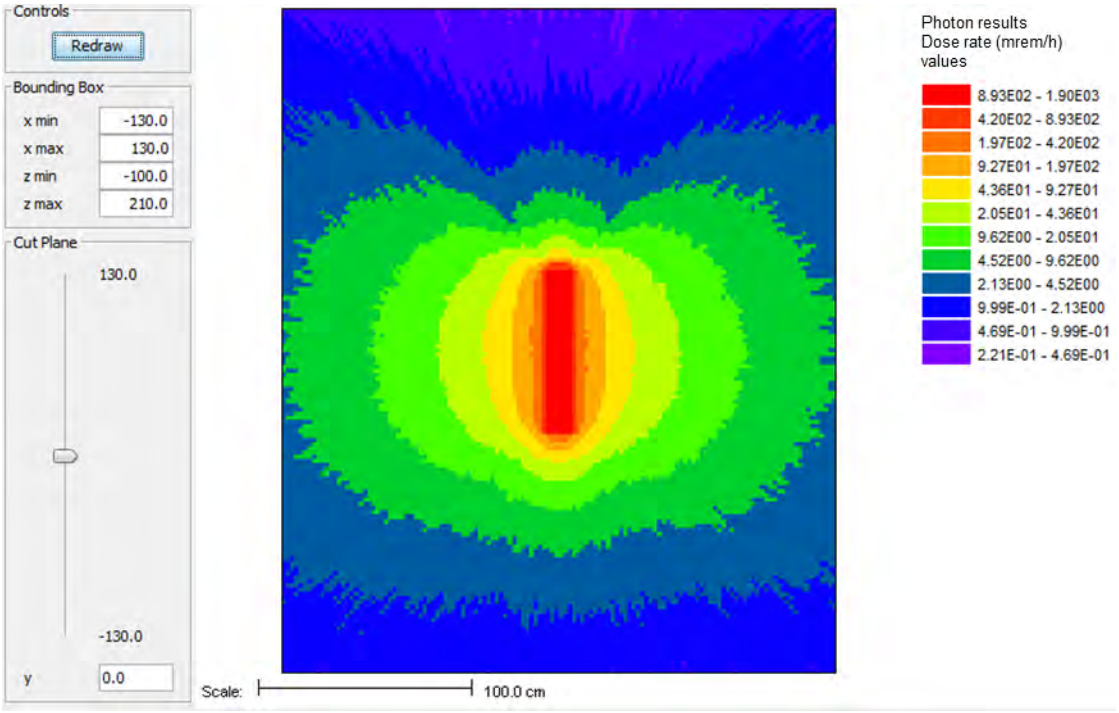


Fig. 5.24. Photon dose rate contours for the UO_2 cylindrical powder configuration of 75.785 cm height and 6.35 cm radius (x-z plane).

5.3.1.4 Neutron model for 24-kg HEU oxide content

The neutron model for the calculated dose rate is a solid cylinder of UO_2 of 6.35 cm radius either at the bottom or at the top of the CV. The density of UO_2 used in the model is 10.96 g/cm^3 and the height is 17.286 cm. The top and bottom NCT and HAC neutron dose rates are calculated by placing the UO_2 cylinder at the top and bottom of the CV, respectively. The side NCT and HAC neutron dose rates are from the UO_2 solid cylinder of density at the top of the CV. The oxide mass in a cylindrical shape is the only analyzed configuration for neutron dose rate contribution since the uranium oxides are in powder form and the contribution of neutron dose rate is <1% of the combined (photon and neutron) dose rate.

5.3.1.5 Containment vessel O-rings dose rate

The dose rate at the location of the CV O-rings is calculated for HEU metal case with cylindrical type fuel configuration at the top of the CV. Figure 5.25 shows the location of the O-rings. The radial and height locations of the point detector calculation point are 6.8 cm and 91.20 cm, respectively. The calculated photon dose rate is 483.92 mrem/h, and the neutron and secondary photon dose rate combined is 16.33 mrem/h. The calculated combined dose rate with 3σ uncertainty at the O-ring is 506.5 mrem/h. Using a 1-rad/rem conversion factor, which is applied to the photon dose rate and conservatively applied to the relatively low neutron dose rate, the maximum total calculated dose rate at the O-ring location is ~0.5 rad/h. The O-ring location dose rate for the HEU metal case bounds that for the HEU oxide case.

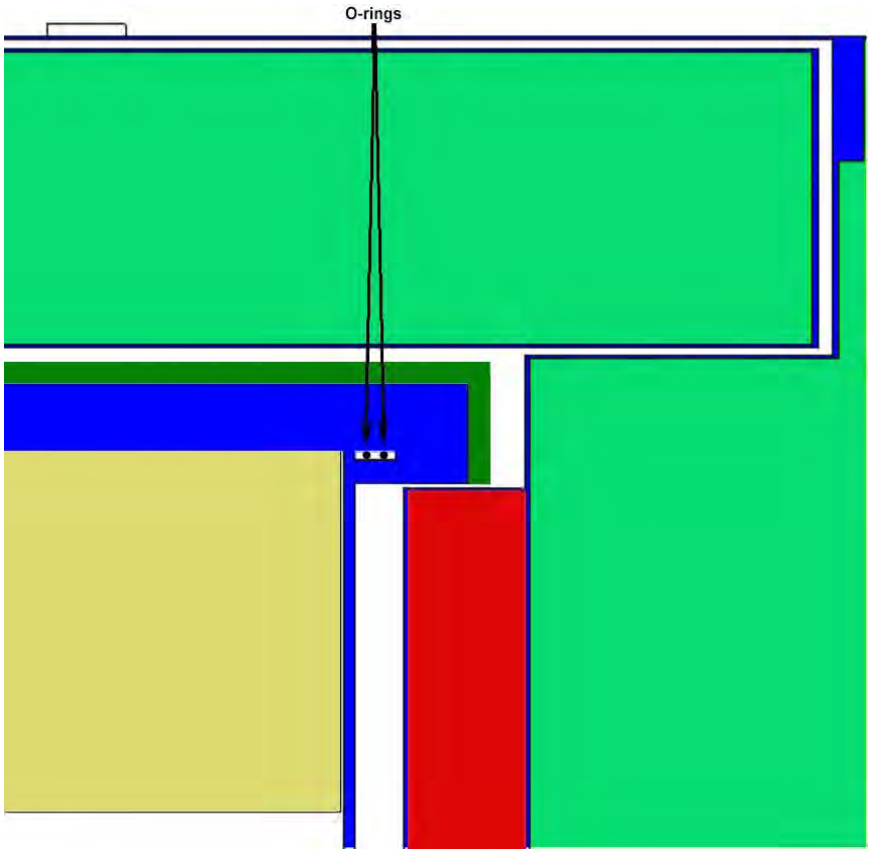


Fig. 5.25. Calculation model of the ES-3100 shipping package for NCT with cylinder type configuration at the top of CV for dose rate calculations at O-rings (x-z side section).

5.3.1.6 Effects of impurities

The content may contain radioactive and nonradioactive material as impurities. The presence of ^{232}U, ^{233}U, ^{234}U, ^{236}U, ^{237}Np, and plutonium contents is conservatively included in the source-term calculations (Table 5.3). The nonradioactive impurities, if any are present, do not affect the photon source term. The neutron dose rate is negligible in comparison to the total dose rate presented in Tables 5.1 and 5.2. Therefore, it can be concluded that the presence of nonradioactive impurities does not significantly affect the total dose rates presented in Tables 5.1 and 5.2.

5.3.1.7 Conservative features of the packaging model

Several conservative features are included in the model. All dimensions and densities of the packaging materials are modeled as equal to or less than specified or nominal values. The content is modeled conservatively to calculate the side, top, and bottom dose rates (Sect. 5.3.1). All packaging materials inside the CV are neglected. The convenience cans, can spacers, content wrappings, covers, supports, etc., are omitted. The CV model, therefore, contains HEU material content only. For HEU oxide cases, all contents are modeled as cylinders or cylindrical shells with the base resting on the lower CV surface with a maximum specified radius of 6.35 cm (the maximum allowable convenience can diameter is 5 in.) and with a height, inner radius (if any), and density adjusted for each specific model to preserve the content mass. In this conservative manner, it is possible to cover all specified combinations of can loadings and can and spacer placements with a minimum number of calculations. The geometric configuration of some of the cases investigated represents a situation where the maximum

possible mass loading for a convenience can would be exceeded if the cans had been included in the model. The calculated dose rates from the models used, however, will always exceed those from a model where the geometry is expanded so the can mass loadings are not exceeded and the internal CV hardware is included.

5.3.2 Material Properties

The material properties for the ES-3100 package shielding models are shown in Table 5.8. Kaolite and Packcrete are impact-absorbing and thermal-insulating materials and Cat 277-4 is a neutron-attenuating material used in the ES-3100 package. Additional information on these materials can be found in Chapters 1, 2, and 6.

Table 5.8. Shielding model material specifications for the ES-3100 package with HEU content

Material	Density (g/cm^3)	Constituent	Weight percent
Uranium metal	18.82	^{235}U	95.0000
		^{238}U	5.0000
UO_2	10.960 [a]	^{16}O	11.9800
		^{235}U	83.6200
		^{238}U	4.4000
Stainless steel	7.92	C	0.0800
		^{28}Si	0.9187
		^{29}Si	0.0483
		^{30}Si	0.0330
		^{31}P	0.0450
		^{50}Cr	0.7930
		^{52}Cr	15.9029
		^{53}Cr	1.8380
		^{54}Cr	0.4661
		^{55}Mn	2.0000
		^{54}Fe	3.8602
		^{56}Fe	62.8377
		^{57}Fe	1.4772
		^{58}Fe	0.2000
		^{58}Ni	6.3838
		^{60}Ni	2.5437
		^{61}Ni	0.1124
		^{62}Ni	0.3643
		^{64}Ni	0.0958

Table 5.8. Shielding model material specifications for the ES-3100 package with HEU content

Material	Density (g/cm^3)	Constituent	Weight percent
Silicone rubber	1.20	^{1}H	8.1573
		C	32.3767
		^{16}O	21.5196
		^{17}O and ^{18}O	0.0586
		^{28}Si	34.8061
		^{29}Si	1.8314
		^{30}Si	1.2503
Cat 277-4	1.4586	^{1}H	2.8475
		^{10}B	0.6591
		^{11}B	2.9726
		C	1.3609
		^{14}N	0.0100
		^{16}O	53.2515
		^{17}O and ^{18}O	0.1450
		^{23}Na	0.0833
		^{24}Mg	0.1867
		^{25}Mg	0.0246
		^{26}Mg	0.0282
		^{27}Al	27.6937
		^{28}Si	1.6075
		^{29}Si	0.0846
		^{30}Si	0.0577
		^{32}S	0.2071
		^{33}S	0.0017
		^{34}S	0.0098
		^{36}S	0.00002
		^{40}Ca	8.1125
		^{42}Ca	0.0569
		^{43}Ca	0.0121
		^{44}Ca	0.1920
		^{46}Ca	0.0004
		^{48}Ca	0.0188
		^{54}Fe	0.0212
		^{56}Fe	0.3453
		^{57}Fe	0.0081
		^{58}Fe	0.0011

Table 5.8. Shielding model material specifications for the ES-3100 package with HEU content

Material	Density (g/cm^3)	Constituent	Weight percent
Kaolite [b]	0.321	^{16}O	40.9231
		^{17}O and ^{18}O	0.1114
		^{23}Na	1.4837
		^{24}Mg	6.1579
		^{25}Mg	0.8121
		^{26}Mg	0.9298
		^{27}Al	5.0808
		^{28}Si	15.7696
		^{29}Si	0.8292
		^{30}Si	0.5661
		^{40}Ca	21.2086
		^{42}Ca	0.1490
		^{43}Ca	0.0318
		^{44}Ca	0.5031
		^{46}Ca	0.0010
		^{48}Ca	0.0491
		^{54}Fe	0.2646
		^{56}Fe	4.3066
		^{57}Fe	0.1012
		^{58}Fe	0.0137
Air	0.001225	^{14}N	75.50
		^{16}O	23.20
		^{40}Ar	1.30

[a] The uranium oxide density varies with the geometric model volume to preserve the 24-kg mass.
[b] Comparative analyses for Kaolite and Packcrete are provided in Appendix 5.5.3.

5.4 SHIELDING EVALUATION

5.4.1 Methods

Two computer programs were used in the shielding evaluation: ORIGEN-S and MCNP5. Both are stand-alone codes. Brief descriptions of the programs are presented below.

1. ORIGEN-S (NUREG/CR-0200, Vol. II, Sect. F7) is a general depletion and decay code. Given an initial isotopic distribution, materials are decayed to provide time-dependent, energy-grouped photon and neutron sources.

2. MCNP5 (LA-UR-03-1987) is a general-purpose Monte Carlo transport code that treats multidimensional neutron, photon, and coupled problems. MCNP5 and the cross section library used for the materials in this analysis are based on Evaluated Nuclear Data Files VII cross sections for neutrons and MCPLIB04 for photons.

A Type 5 point detector tally was used for calculating the photon and neutron dose rates for NCT and HAC. These dose rates are reported in Tables 5.1, 5.2, and 5.7. Type 4 tally dose rates (segmented volume detectors) for neutrons and photons are also calculated from tally cells, each of 1 cm height, arranged around the package surface and at 1 m from the external surface of the drum for NCT and HAC side doses for symmetrical source distribution cases. Volume detectors are also used at the top and bottom surfaces and at 1m from the external top and bottom surfaces for symmetrical source distribution cases. The volume detector tallies are used only to compare the Type 5 point detector tally dose rates.

5.4.2 Input and Output Data

Sample input files are shown in Appendices 5.5.1 and 5.5.2. The limiting output dose rates are shown in Tables 5.1 and 5.2. Point detectors are used for all dose-rate calculations. A large number of particle histories were used to assemble reliable statistics. The results are judged to be acceptable from the tally fluctuation chart, and the relative error (fractional standard deviation) is lower than the criterion (0.05 for point detectors).

5.4.3 Flux-to-Dose-Rate Conversion

Dose rates were calculated at the detector locations by converting the calculated photon and neutron fluxes using the ANSI/ANS conversion factors (ANSI/ANS-6.1.1). These factors for the energy groups used in the shielding evaluation are shown in Tables 5.9 and 5.10.

5.4.4 External Radiation Levels

The calculated maximum side, top, and bottom external dose rates for the HEU metal and oxide contents are presented in Tables 5.1 and 5.2, respectively. The dose rates were calculated by the computer code MCNP. Comparison of dose rates calculated at the detector locations to the requirements of 10 CFR 71 demonstrates compliance of the package. The calculated total dose rates are well within the NCT limits of 200 mrem/h and 10 mrem/h on the drum surface and 1 m from the drum surface, respectively. Calculated HAC dose rates at 1 m from the CV surface are well within the limit of 1000 mrem/h. The shielding analyses were done in a conservative manner applicable to all proposed ES-3100 package contents listed in Sect. 1.2.2. The MCNP calculated dose rates for the HEU metal contents were compared against the Monaco (ORNL/TM-2005/39) calculated dose rates in a journal paper (Paul 2019) and were found to be in general agreement.

In addition to the required external package dose rate calculations, auxiliary calculations were performed to give an upper bound estimate for the dose rate at the location of the CV O-rings. The maximum calculated combined dose rate with 3σ uncertainty at the O-ring was 506.5 mrem/h. Using a 1-rad/rem conversion factor, which was applied to the photon dose rate and conservatively applied to the relatively low neutron dose rate, the maximum total calculated dose rate at the O-ring location was ~0.5 rad/h. The O-ring location dose rate for the HEU metal case bounds that for the HEU oxide case.

Table 5.9. ANSI/ANS-1977 photon flux-to-dose-rate conversion factors

Energy (MeV)	Factor (rem/h)/(photons/s/cm^2)
0.01	3.96×10^{-6}
0.03	5.82×10^{-7}
0.05	2.90×10^{-7}
0.07	2.58×10^{-7}
0.10	2.83×10^{-7}
0.15	3.79×10^{-7}
0.20	5.01×10^{-7}
0.25	6.31×10^{-7}
0.30	7.59×10^{-7}
0.35	8.78×10^{-7}
0.40	9.85×10^{-7}
0.45	1.08×10^{-6}
0.50	1.17×10^{-6}
0.55	1.27×10^{-6}
0.60	1.36×10^{-6}
0.65	1.44×10^{-6}
0.70	1.52×10^{-6}
0.80	1.68×10^{-6}
1.00	1.98×10^{-6}
1.40	2.51×10^{-6}
1.80	2.99×10^{-6}
2.20	3.42×10^{-6}
2.60	3.82×10^{-6}
2.80	4.01×10^{-6}
3.25	4.41×10^{-6}
3.75	4.83×10^{-6}
4.25	5.23×10^{-6}
4.75	5.60×10^{-6}
5.00	5.80×10^{-6}
5.25	6.01×10^{-6}
5.75	6.37×10^{-6}
6.25	6.74×10^{-6}
6.75	7.11×10^{-6}
7.50	7.66×10^{-6}
9.00	8.77×10^{-6}
11.00	1.03×10^{-5}
13.00	1.18×10^{-5}
15.00	1.33×10^{-5}

Table 5.10. ANSI/ANS-1977 neutron flux-to-dose-rate conversion factors

Energy (MeV)	Factor (rem/h)/(neutrons/s/cm^2)
2.5×10^{-8}	3.67×10^{-6}
1.0×10^{-7}	3.67×10^{-6}
1.0×10^{-6}	4.46×10^{-6}
1.0×10^{-5}	4.54×10^{-6}
1.0×10^{-4}	4.18×10^{-6}
1.0×10^{-3}	3.76×10^{-6}
1.0×10^{-2}	3.56×10^{-6}
1.0×10^{-1}	2.17×10^{-5}
5.0×10^{-1}	9.26×10^{-5}
1.0	1.32×10^{-4}
2.5	1.25×10^{-4}
5.0	1.56×10^{-4}
7.0	1.47×10^{-4}
10.0	1.47×10^{-4}
14.0	2.08×10^{-4}
20.0	2.27×10^{-4}

5.5 APPENDIX

Appendix 5.5.1 Origen-S Input Data 5-41
Appendix 5.5.2 MCNP Input Data.....5-43
Appendix 5.5.3 Comparative NCT Dose Rates for Kaolite and Packcrete.....5-109
Appendix 5.5.4 Chapter 5 References 5-117

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Appendix 5.5.1
Origen-S Input Data

The ORIGEN-S (NUREG/CR-0200) input file used for the Table 5.1 and 5.2 calculated dose rates is provided. The input file in Appendix 5.5.1.1 is for the source term based on the radionuclides in Table 5.3. The concentration of each isotope is based on 1 g of highly enriched uranium (HEU). This is a conservative assumption because the uranium mass is not compensated (reduced) due to the addition of the radionuclide impurity masses of ^{237}Np and Pu. This file has generated the photon and neutron spectrum in Tables 5.4 and 5.5, respectively, which are used to calculate the HEU metal and oxide results in Tables 5.1 and 5.2.

5.5.1.1 Source generation file for radionuclides only

```
#origen
'
'  source term for ES-3100 HEU (This revision - same source term was used
'  in older version)
'  This revision used 47 group photon spectrum instead of 18 group used
'  in earlier version - this is the only difference
'  assumed 95 wt% U-235 and 5 wt% U-238 and also used
'  used U-232, U-233, U-234, U-236, Np-237, and Transuranic U in
'  1 gm basis - source term calculations
'
0$$ 6 13 a8 26 e
1$$ 1 t
master photon
'
'   used 47 energy groups for photons (a33 item) specified in 83** card
'   used 27 default neutron energy groups
'   units of concentration in gm (a16 item)
'
3$$ 21 0 1 -88 6 a16 2 a33 47
'
'   used UO2 medium composition for the alpha-n (conservative assumption
'   for Uranium metal case)
'
54$$ a11 0 e
4** a4 1-70 t
35$$ 0 t
'
'   no of nuclides or elements used as initial condition (a13)
'   time interval in years in card 60
'   input card for both title and basis
'
56$$ 0 10 a13 13 5 3 a17 2 e
'
'   time subtracted from first time period in card 60
'
57** 0 e t
input source concentration in grams
 basis 1 gm U-metal
60** 7  10  10.5  12  15  20  30  40  50  60
'
'    print options specified here from Table F7.6.1
'
65$$ a4 1 a7 1 a10 1 a13 1 a25 1 a28 1 a31 1 a34 1 a46 1 a49 1 a52 1 e
'
'    source term nuclide or element
```

```
'
73$$ 922320      922330       922340
     922350      922360       922380     932370     942380
     942390      942400       942410     942420     952410
'
'    nuclide or element concentration
'
74** 4.0000-08  6.0000-03    2.0000-02
     0.9200000  1.0000-02    0.04399996  0.0250000  1.6000-07
     7.4100-04  5.2000-05    4.4800-06   3.2000-07  2.4000-06
'
'    library kind (used 2 for actinide library)
'
75$$ 2 2 2 2 2 2 2 2 2 2 2 2 2
81$$ 2 0 26 1 e
82$$ 2 2 2 2 2 2 2 2 2 2
'
'    gamma energy group structure (user specified here)
'
83** 10.0+6 8.0+6 6.5+6 5.0+6 4.0+6 3.5+6 3.0+6 2.9+6 2.8+6 2.7+6
      2.6+6 2.5+6 2.4+6 2.3+6 2.2+6 2.1+6 2.0+6 1.9+6 1.8+6 1.7+6
      1.6+6 1.5+6 1.4+6 1.3+6 1.2+6 1.1+6 1.0+6 0.9+6 0.8+6 0.7+6
      0.6+6 0.5+6 0.4+6 0.3+6 0.2+6 0.1+6 .09+6 .08+6 .07+6 .06+6
      .05+6 .04+6 .03+6 .025+6 .020+6 .015+6 .010+6  .005+6 t
56$$ f0 t
end
```

Appendix 5.5.2
MCNP Input Data

Included here are some of the input files used for the dose rate calculations that provide results listed in Tables 5.1 and 5.2. For the normal conditions of transport (NCT) cases, the detectors are set at 1 mm and 1 m from the drum side, top, and bottom surfaces. For the hypothetical accident conditions (HAC) cases, all cells and surfaces external to the containment vessel (CV) are eliminated, and the detectors are set at 1 m from the external surface of the CV. For photon dose-rate calculations for both NCT and HAC cases, the 47 energy group photon spectrum in Table 5.4 are used. For neutron and secondary photon dose-rate calculations for both NCT and HAC cases, the 18–27 energy group neutron spectra in Table 5.5 are used. The contribution of low energy spectra (Groups 1-17) to the neutron dose rate is neglected because the contribution to the dose rate from these groups is minimal. The secondary photon dose rates are less than 1% of the neutron dose rates and the contribution from the secondary photon dose rates are shown as part of the neutron dose rates in Tables 5.1 and 5.2.

Representative input files used for the dose rates calculations are listed below.

Section **Description**

5.5.2.1 NCT for 36-kg uranium metal photon side dose-rate calculations (cylindrical hemi-shell configuration source moved towards x-axis in CV) 5-45
5.5.2.2 NCT for 36-kg uranium metal photon top dose-rate calculations (cylinder configuration source moved to the top of CV) 5-56
5.5.2.3 NCT for 36-kg uranium metal neutron and secondary photon top and side dose-rate calculations (cylinder configuration source moved to the top of CV) 5-68
5.5.2.4 HAC for 36-kg uranium metal neutron and secondary photon side dose-rate calculations (cylindrical hemi-shell configuration source moved towards x-axis in CV) 5-82
5.5.2.5 NCT for 24-kg uranium oxide photon side dose-rate calculations (cylinder configuration source) 5-95

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5.5.2.1 NCT for 36-kg uranium metal photon side dose-rate calculations (cylindrical hemi-shell configuration source moved towards x-axis in CV)

```
photon_hemishell.inp - ES-3100: 2015 HEU detailed model (primary photons)
c                 U-metal case (76.2 cm ht cylindrical hemishell
c                 density = 18.82 g/cc; IR=4.9337 cm; OR=6.35 cm)
c    configuration
c    (side dose rate calculations)
c    source in cylindrical hemishell form sitting at the bottom of CV for
c    side dose rate calculations for 2015 calculation Revision
c
c    mcnp geometry model (CV and outside) is identical to criticality model
c    (KENO Model).
c    47 energy groups are used for the photon spectrum.  In the older version,
c    18 energy groups were used.
c    surface detectors are placed 0.1 cm and 100 cm way from the surfaces
c    and detectors are placed on the side, top, and bottom.
c    point detectors are used for dose rate calculations (used for results).
c    segmented volume detectors are used for side dose rate calculations (for checking).
c    volume detectors are used to check bottom and top dose rate calculations.
c    ANSI/ANS-6.1.1-1977 Dose conversion factors are used,
c    multiplied by 1000 to convert from rem to mrem
c
c   mode p - (primary  photons)
c
c    --------------
c     Cell Cards
c    --------------
c
    1     0             -1 401      imp:n,p=1 $ inner void
    2     1   -18.82    -2 1 401    imp:n,p=1 $ source shell
c
c   drum bottom - at 0.0 cm level (height - 0.2667 cm)
c
   51     2   -7.92     -51      imp:n,p=1 $ drum bottom
c
c   bottom kaolite - at 0.2667 cm level (height - 10.8585 cm)
c
   61     4   -0.321    -61      imp:n,p=1 $ bottom kaolite
   62     2   -7.92     -62 61   imp:n,p=1 $ bottom kaolite+drum
c
c   bottom inner liner - at 11.1252 cm level (height - 0.3048 cm)
c
   71     2   -7.92     -71      imp:n,p=1 $ bottom liner
   72     4   -0.321    -72 71   imp:n,p=1 $ bottom liner+kaolite
   73     2   -7.92     -73 72   imp:n,p=1 $ bottom liner+kaolite+drum
c
c   bottom rubber pad - at 11.4300 cm level (height - 0.4318 cm)
c
   81     0             -81      imp:n,p=1 $ void
   82     3   -1.2      -82 81   imp:n,p=1 $ void+pad
   83     2   -7.92     -83 82   imp:n,p=1 $ void+pad+liner
   84     5   -1.4586   -84 83   imp:n,p=1 $ void+pad+liner+277-4
   85     2   -7.92     -85 84   imp:n,p=1 $ void+pad+liner+277-4+liner
   86     4   -0.321    -86 85   imp:n,p=1 $ void+pad+liner+277-4+liner+kaolite
   87     2   -7.92     -87 86   imp:n,p=1 $ void+pad+liner+277-4+liner+kaolite+drum
c
c   CV bottom (section 1) - at 11.8618 cm level (height - 0.6350 cm)
c
   91     2   -7.92     -91      imp:n,p=1 $ cv bottom
   92     0             -92 91   imp:n,p=1 $ cv bottom+void
```

```
   93     2   -7.92     -93 92   imp:n,p=1 $ cv bottom+void+liner
   94     5   -1.4586   -94 93   imp:n,p=1 $ cv bottom+void+liner+277-4
   95     2   -7.92     -95 94   imp:n,p=1 $ cv bottom+void+liner+277-4+liner
   96     4   -0.321    -96 95   imp:n,p=1 $ cv bottom+void+liner+277-4+liner+kaolite
   97     2   -7.92     -97 96   imp:n,p=1 $ cv bottom+void+liner+277-4+liner+kaolite+drum
c
c   CV (section 2) at 12.4968 cm level (height - 77.08899 cm)
c
  101     0             -101 #1 #2  imp:n,p=1 $ cv void
  102     2   -7.92     -102 101  imp:n,p=1 $ cv void+ss
  103     0             -103 102  imp:n,p=1 $ cv void+ss+void
  104     2   -7.92     -104 103  imp:n,p=1 $ cv void+ss+void+liner
  105     5   -1.4586   -105 104  imp:n,p=1 $ cv void+ss+void+liner+277-4
  106     2   -7.92     -106 105  imp:n,p=1 $ cv void+ss+void+liner+277-4+liner
  107     4   -0.321    -107 106  imp:n,p=1 $ cv void+ss+void+liner+277-4+liner+kaolite
  108     2   -7.92     -108 107  imp:n,p=1 $ cv void+ss+void+liner+277-4+liner+kaolite+drum
  109     0             -109 108  imp:n,p=1 $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1
  110     0             -110 109  imp:n,p=1 $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp
  111     0             -111 110  imp:n,p=1 $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp+dt2
c
c   CV (section 3) at 89.5857 cm level (height - 0.1524 cm)
c   (ss liner top of sillicone rubber)
c
c 111     0             -111      imp:n,p=1 $ cv void (to be filled by content can)
  112     0             -112      imp:n,p=1 $ cv void
  113     2   -7.92     -113 112  imp:n,p=1 $ cv void+ss
  114     0             -114 113  imp:n,p=1 $ cv void+ss+void
  115     2   -7.92     -115 114  imp:n,p=1 $ cv void+ss+void+liner
  116     4   -0.321    -116 115  imp:n,p=1 $ cv void+ss+void+liner+kaolite
  117     2   -7.92     -117 116  imp:n,p=1 $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 4) at 89.73819 cm level (height - 0.2286 cm)
c   (gap between Cat 277-4 & CV top section)
c
  122     0             -122      imp:n,p=1 $ cv void
  123     2   -7.92     -123 122  imp:n,p=1 $ cv void+ss
  124     0             -124 123  imp:n,p=1 $ cv void+ss+void
  125     2   -7.92     -125 124  imp:n,p=1 $ cv void+ss+void+liner
  126     4   -0.321    -126 125  imp:n,p=1 $ cv void+ss+void+liner+kaolite
  127     2   -7.92     -127 126  imp:n,p=1 $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 6) at 89.96679 cm level (height - 1.27 cm)
c   (lower section of CV flange)
c
  132     0             -132      imp:n,p=1 $ cv void
  133     2   -7.92     -133 132  imp:n,p=1 $ cv void+ss
  134     3   -1.20     -134 133  imp:n,p=1 $ cv void+ss+rubber
  135     0             -135 134  imp:n,p=1 $ cv void+ss+rubber+void
  136     2   -7.92     -136 135  imp:n,p=1 $ cv void+ss+rubber+void+liner
  137     4   -0.321    -137 136  imp:n,p=1 $ cv void+ss+rubber+void+liner+kaolite
  138     2   -7.92     -138 137  imp:n,p=1 $ cv +void+ss+rubber+void+liner+kaolite+drum
c
c   CV (section 7) at 91.23679 cm level (height - 2.921 cm)
c   (middle section of CV flange)
c
  141     2   -7.92     -141      imp:n,p=1 $ ss
  142     3   -1.20     -142 141  imp:n,p=1 $ ss+rubber
  143     0             -143 142  imp:n,p=1 $ ss+rubber+void
```

```
  144     2   -7.92     -144 143  imp:n,p=1 $ ss+rubber+void+liner
  145     4   -0.321    -145 144  imp:n,p=1 $ ss+rubber+void+liner+kaolite
  146     2   -7.92     -146 145  imp:n,p=1 $ ss+rubber+void+liner+kaolite+drum
c
c   CV (section 8) at 94.15779 cm level (height - 0.762 cm)
c   (top section of CV flange)
c
  151     3   -1.20     -151      imp:n,p=1 $ rubber
  152     0             -152 151  imp:n,p=1 $ rubber+void
  153     2   -7.92     -153 152  imp:n,p=1 $ rubber+void+liner
  154     4   -0.321    -154 153  imp:n,p=1 $ rubber+void+liner+kaolite
  155     2   -7.92     -155 154  imp:n,p=1 $ rubber+void+liner+kaolite+drum
c
c   Top of CV (section 1) at 94.91979 cm level (height - 0.254 cm)
c
  161     0             -161      imp:n,p=1 $ void
  162     2   -7.92     -162 161  imp:n,p=1 $ void+liner
  163     4   -0.321    -163 162  imp:n,p=1 $ void+liner+kaolite
  164     2   -7.92     -164 163  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Top of CV (section 2) at 95.17379 cm level (height - 0.1524 cm)
c
  171     0             -171      imp:n,p=1 $ void
  172     2   -7.92     -172 171  imp:n,p=1 $ void+liner
  173     4   -0.321    -173 172  imp:n,p=1 $ void+liner+kaolite
  174     2   -7.92     -174 173  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Top of CV (section 3) at 95.32619 cm level (height - 0.34036 cm)
c
  181     0             -181      imp:n,p=1 $ void
  182     2   -7.92     -182 181  imp:n,p=1 $ void+liner
  183     4   -0.321    -183 182  imp:n,p=1 $ void+liner+kaolite
  184     2   -7.92     -184 183  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Kaolite plug bottom ss  at 95.66655 cm level (height - 0.1524 cm)
c
  191     2   -7.92     -191      imp:n,p=1 $ ss (liner)
  192     0             -192 191  imp:n,p=1 $ ss+void
  193     2   -7.92     -193 192  imp:n,p=1 $ ss+void+liner
  194     4   -0.321    -194 193  imp:n,p=1 $ ss+void+liner+kaolite
  195     2   -7.92     -195 194  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Kaolite top plug bottom section  at 95.81895 cm level (height - 7.68604 cm)
c
  201     4   -0.321    -201      imp:n,p=1 $ kaolite
  202     2   -7.92     -202 201  imp:n,p=1 $ kaolite+liner
  203     0             -203 202  imp:n,p=1 $ kaolite+liner+void
  204     2   -7.92     -204 203  imp:n,p=1 $ kaolite+liner+void+liner
  205     4   -0.321    -205 204  imp:n,p=1 $ kaolite+liner+void+liner+kaolite
  206     2   -7.92     -206 205  imp:n,p=1 $ kaolite+liner+void+liner+kaolite+drum
c
c   Kaolite top plug (iron angle bottom section) at 103.50499 cm level (height - 4.4450 cm)
c
  211     4   -0.321    -211      imp:n,p=1 $ kaolite
  212     2   -7.92     -212 211  imp:n,p=1 $ kaolite+liner
  213     0             -213 212  imp:n,p=1 $ kaolite+liner+void
  214     2   -7.92     -214 213  imp:n,p=1 $ kaolite+liner+void+liner
  215     2   -7.92     -215 214  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle
  216     4   -0.321    -216 215  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle+kaolite
  217     2   -7.92     -217 216  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle+kaolite+drum
c
```

```
c   Kaolite top plug (iron angle top section) at 107.94999 cm level (height - 0.1118 cm)
c
  221     4   -0.321    -221      imp:n,p=1 $ kaolite
  222     2   -7.92     -222 221  imp:n,p=1 $ kaolite+liner
  223     0             -223 222  imp:n,p=1 $ kaolite+liner+void
  224     2   -7.92     -224 223  imp:n,p=1 $ kaolite+liner+void+liner
  225     2   -7.92     -225 224  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle
  226     2   -7.92     -226 225  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle+drum
c
c   Kaolite top plug (iron angle top section) at 108.06175 cm level (height - 0.1524 cm)
c
  231     2   -7.92     -231      imp:n,p=1 $ liner
  232     0             -232 231  imp:n,p=1 $ liner+void
  233     2   -7.92     -233 232  imp:n,p=1 $ liner+void+liner
  234     2   -7.92     -234 233  imp:n,p=1 $ liner+void+liner+iron-angle
  235     2   -7.92     -235 234  imp:n,p=1 $ liner+void+liner+iron-angle+drum
c
c   Gap above Kaolite top plug at 108.21415 cm level (height - 0.37084 cm)
c
  241     0             -241      imp:n,p=1 $ liner+void
  242     2   -7.92     -242 241  imp:n,p=1 $ liner+void+liner
  243     2   -7.92     -243 242  imp:n,p=1 $ liner+void+liner+iron-angle
  244     2   -7.92     -244 243  imp:n,p=1 $ liner+void+liner+iron-angle+drum
c
c   Top ss lid at 108.58499 cm level (height - 0.1524 cm)
c
  251     2   -7.92     -251      imp:n,p=1 $ ss lid
  252     0             -252 251  imp:n,p=1 $ ss lid+void
  253     2   -7.92     -253 252  imp:n,p=1 $ ss lid+void+drum
c
c   Top ss lid at 108.73739 cm level (height - 1.7526 cm)
c
  261     0             -261 #502      imp:n,p=1 $ void
  262     2   -7.92     -262 261  imp:n,p=1 $ void+ss lid
  263     0             -263 262  imp:n,p=1 $ void+ss lid+void
  264     2   -7.92     -264 263  imp:n,p=1 $ void+ss lid+void+drum
c
c   Put volume source for top and bottom detectors
c
  501     0             -501      imp:n,p=1 $ bottom surface detector
  502     0             -502      imp:n,p=1 $ top surface detector
  551     0             -551      imp:n,p=1 $ 1 m from bottom surface - detector
  552     0             -552      imp:n,p=1 $ 1 m from top surface - detector
c
  998     0             -999      51 62 73 87 97 111 117 127 138 146 155
                                  164 174 184 195 206 217 226 235 244 253
                                  264 501 502 551 552
                                  imp:n,p=1 $ inside boundary
  999     0              999      imp:n,p=0 $ outside world

c    ------------------
c    Surface Cards
c    ------------------
c
    1  rcc  0.0 0.0 12.4968   0.0 0.0  76.20   4.9337  $ inner radius cylindrical hemishell
source
    2  rcc  0.0 0.0 12.4968   0.0 0.0  76.20   6.35    $ outer radius cylindrical hemishell
source
c
c   drum bottom - at 0.0 cm level (height - 0.2667 cm)
c
```

```
   51  rcc  0.0 0.0  0.0     0.0 0.0 0.2667   23.3299  $ drum bottom
c
c   bottom kaolite - at 0.2667 cm level (height - 10.8585 cm)
c
   61  rcc  0.0 0.0  0.2667  0.0 0.0 10.8585  23.1775  $ bottom kaolite
   62  rcc  0.0 0.0  0.2667  0.0 0.0 10.8585  23.3299  $ bottom kaolite+drum
c
c   bottom inner liner - at 11.1252 cm level (height - 0.3048 cm)
c
   71  rcc  0.0 0.0 11.1252  0.0 0.0  0.3048  11.0744  $ bottom liner
   72  rcc  0.0 0.0 11.1252  0.0 0.0  0.3048  23.1775  $ bottom liner+kaolite
   73  rcc  0.0 0.0 11.1252  0.0 0.0  0.3048  23.3299  $ bottom liner+kaolite+drum
c
c   bottom rubber pad - at 11.4300 cm level (height - 0.4318 cm)
c
   81  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318    3.1750  $ void
   82  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318    7.9248  $ void+pad
   83  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318    8.0772  $ void+pad+liner
   84  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   10.9220  $ void+pad+liner+277-4
   85  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   11.0744  $ void+pad+liner+277-4+liner
   86  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   23.1775  $ void+pad+liner+277-4+liner+kaolite
   87  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   23.3299  $
void+pad+liner+277-4+liner+kaolite+drum
c
c   CV bottom (section 1) - at 11.8618 cm level (height - 0.6350 cm)
c
   91  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350    6.6802  $ cv bottom
   92  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350    7.9248  $ cv bottom+void
   93  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350    8.0772  $ cv bottom+void+liner
   94  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   10.9220  $ cv bottom+void+liner+277-4
   95  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   11.0744  $ cv bottom+void+liner+277-4+liner
   96  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   23.1775  $ cv
bottom+void+liner+277-4+liner+kaolite
   97  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   23.3299  $ cv
bottom+void+liner+277-4+liner+kaolite+drum
c
c   CV (section 2) at 12.4968 cm level (height - 77.08899 cm)
c
  101  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  6.4262  $ cv void
  102  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  6.6802  $ cv void+ss
  103  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  7.9248  $ cv void+ss+void
  104  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  8.0772  $ cv void+ss+void+liner
  105  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 10.9220  $ cv void+ss+void+liner+277-4
  106  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 11.0744  $ cv void+ss+void+liner+277-4+liner
  107  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 23.1775  $ cv
void+ss+void+liner+277-4+liner+kaolite
  108  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 23.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum
  109  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 24.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1
  110  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 123.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp
  111  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 124.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp+dt2
c
c   CV (section 3) at 89.58579 cm level (height - 0.1524 cm)
c   (ss liner top of sillicone rubber)
c
  112  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524  6.4262  $ cv void
  113  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524  6.6802  $ cv void+ss
  114  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524  7.9248  $ cv void+ss+void
```

```
  115  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524 11.0744  $ cv void+ss+void+liner
  116  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524 23.1775  $ cv void+ss+void+liner+kaolite
  117  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524 23.3299  $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 5) at 89.73819 cm level (height - 0.2286 cm)
c   (gap between Cat 277-4 & CV top section)
c
  122  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286  6.4262  $ cv void
  123  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286  6.6802  $ cv void+ss
  124  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 10.9220  $ cv void+ss+void
  125  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 11.0744  $ cv void+ss+void+liner
  126  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 23.1775  $ cv void+ss+void+liner+kaolite
  127  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 23.3299  $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 6) at 89.96679 cm level (height - 1.27 cm)
c   (lower section of CV flange)
c
  132  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700  6.4262  $ cv void
  133  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700  9.5250  $ cv void+ss
  134  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 10.0330  $ cv void+ss+rubber
  135  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 10.9220  $ cv void+ss+rubber+void
  136  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 11.0744  $ cv void+ss+rubber+void+liner
  137  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 23.1775  $ cv void+ss+rubber+void+liner+kaolite
  138  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 23.3299  $ cv
void+ss+rubber+void+liner+kaolite+drum
c
c   CV (section 7) at 91.23679 cm level (height - 2.921 cm)
c   (lower section of CV flange)
c
  141  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210  9.5250  $ ss
  142  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 10.0330  $ ss+rubber
  143  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 10.9220  $ ss+rubber+void
  144  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 11.0744  $ ss+rubber+void+liner
  145  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 23.1775  $ ss+rubber+void+liner+kaolite
  146  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 23.3299  $ ss+rubber+void+liner+kaolite+drum
c
c   CV (section 8) at 94.15779 cm level (height - 0.762 cm)
c   (top section of CV flange)
c
  151  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 10.0330  $ rubber
  152  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 10.9220  $ rubber+void
  153  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 11.0744  $ rubber+void+liner
  154  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 23.1775  $ rubber+void+liner+kaolite
  155  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 23.3299  $ rubber+void+liner+kaolite+drum
c
c   Top of CV (section 1) at 94.91979 cm level (height - 0.254 cm)
c
  161  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 10.9220  $ void
  162  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 11.0744  $ void+liner
  163  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 23.1775  $ void+liner+kaolite
  164  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 23.3299  $ void+liner+kaolite+drum
c
c   Top of CV (section 2) at 95.17379 cm level (height - 0.1524 cm)
c
  171  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 10.9220  $ void
  172  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 18.7579  $ void+liner
  173  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 23.1775  $ void+liner+kaolite
  174  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 23.3299  $ void+liner+kaolite+drum
c
c   Top of CV (section 3) at 95.32619 cm level (height - 0.34036 cm)
c
```

```
  181  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 18.6055  $ void
  182  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 18.7579  $ void+liner
  183  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 23.1775  $ void+liner+kaolite
  184  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 23.3299  $ void+liner+kaolite+drum
c
c   Kaolite plug bottom ss  at 95.66655 cm level (height - 0.1524 cm)
c
  191  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 18.2499   $ ss (liner)
  192  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 18.6055   $ ss+void
  193  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 18.7579   $ ss+void+liner
  194  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 23.1775   $ ss+void+liner+kaolite
  195  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 23.3299   $ ss+void+liner+kaolite+drum
c
c   Kaolite top plug bottom section  at 95.81895 cm level (height - 7.68604 cm)
c
  201  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.0975  $ kaolite
  202  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.2499  $ kaolite +liner
  203  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.6055  $ kaolite+liner+void
  204  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.7579  $ kaolite+liner+void+liner
  205  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 23.1775  $ kaolite+liner+void+liner+kaolite
  206  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 23.3299  $
kaolite+liner+void+liner+kaolite+drum
c
c   Kaolite top plug (iron angle bottom section) at 103.50499 cm level (height - 4.4450 cm)
c
  211  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.0975  $ kaolite
  212  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.2499  $ kaolite +liner
  213  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.6055  $ kaolite+liner+void
  214  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.7579  $ kaolite+liner+void+liner
  215  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  19.3929  $ kaolite+liner+void+liner+iron-angle
  216  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  23.1775  $
kaolite+liner+void+liner+iron-angle+kaolite
  217  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  23.3299  $
kaolite+liner+void+liner+iron-angle+kaolite+drum
c
c   Kaolite top plug (iron angle top section) at 107.94999 cm level (height - 0.1118 cm)
c
  221  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.0975  $ kaolite
  222  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.2499  $ kaolite +liner
  223  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.6055  $ kaolite+liner+void
  224  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.7579  $ kaolite+liner+void+liner
  225  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  23.1775  $ kaolite+liner+void+liner+iron-angle
  226  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  23.3299  $
kaolite+liner+void+liner+iron-angle+drum
c
c   Kaolite top plug (iron angle top section) at 108.06175 cm level (height - 0.1524 cm)
c
  231  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  18.2499  $ ss liner
  232  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  18.6055  $ ss liner+void
  233  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  18.7579  $ ss liner+void+liner
  234  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  23.1775  $ ss liner+void+liner+iron-angle
  235  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  23.3299  $ ss liner+void+liner+iron-angle+drum
c
c   Gap above Kaolite top plug at 108.21415 cm level (height - 0.37084 cm)
c
  241  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  18.6055  $ void
  242  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  18.7579  $ void+liner
  243  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  23.1775  $ void+liner+iron-angle
  244  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  23.3299  $ void+liner+iron-angle+drum
c
c   Top ss lid at 108.58499 cm level (height - 0.1524 cm)
```

```
c
  251  rcc 0.0 0.0 108.58499  0.0 0.0  0.1524  23.1140  $ ss lid
  252  rcc 0.0 0.0 108.58499  0.0 0.0  0.1524  23.1775  $ ss lid+void
  253  rcc 0.0 0.0 108.58499  0.0 0.0  0.1524  23.3299  $ ss lid+void+drum
c
c   Top ss lid at 108.73739 cm level (height - 1.7526 cm)
c
  261  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  22.9616  $ void
  262  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  23.1140  $ void+ss lid
  263  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  23.1775  $ void+ss lid+void
  264  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  23.3299  $ void+ss lid+void+drum
c
c   Segmented side volume detectors
c
  301  pz 13
  302  pz 14
  303  pz 15
  304  pz 16
  305  pz 17
  306  pz 18
  307  pz 19
  308  pz 20
  309  pz 21
  310  pz 22
  311  pz 23
  312  pz 24
  313  pz 25
  314  pz 26
  315  pz 27
  316  pz 28
  317  pz 29
  318  pz 30
  319  pz 31
  320  pz 32
  321  pz 33
  322  pz 34
  323  pz 35
  324  pz 36
  325  pz 37
  326  pz 38
  327  pz 39
  328  pz 40
  329  pz 41
  330  pz 42
  331  pz 43
  332  pz 44
  333  pz 45
  334  pz 46
  335  pz 47
  336  pz 48
  337  pz 49
  338  pz 50
  339  pz 51
  340  pz 52
  341  pz 53
  342  pz 54
  343  pz 55
  344  pz 56
  345  pz 57
  346  pz 58
  347  pz 59
```

```
  348  pz 60
  349  pz 61
  350  pz 62
  351  pz 63
  352  pz 64
  353  pz 65
  354  pz 66
  355  pz 67
  356  pz 68
  357  pz 69
  358  pz 70
  359  pz 71
  360  pz 72
  361  pz 73
  362  pz 74
  363  pz 75
  364  pz 76
  365  pz 77
  366  pz 78
  367  pz 79
  368  pz 80
  369  pz 81
  370  pz 82
  371  pz 83
  372  pz 84
  373  pz 85
  374  pz 86
  375  pz 87
  376  pz 88
  377  pz 89
c
c   plane perpendicular to x-axis
c
  401  px 0
c
c   Put volume source for top and bottom detectors
c
  501  rcc 0.0 0.0 -0.5  0.0 0.0  0.5  1.0          $ bottom surface vol detector
  502  rcc 0.0 0.0 108.73739  0.0 0.0  0.5  1.0     $ top surface vol detector
  551  rcc 0.0 0.0 -100.5  0.0 0.0  0.5  1.0        $ 1 m from bottom surface - vol detector
  552  rcc 0.0 0.0 208.73739  0.0 0.0  0.5  1.0     $ 1 m from top surface - vol detector
c
  999  sph  0.0 0.0  0.000  999.0                          $ boundary
c

c    ----------------------
c    Data Cards
c    ----------------------
mode  p
c
c      uranium metal (18.82 g/cc)
c
m1    92235.70c  -0.9500    $ U-235           95.0000  wt%
      92238.70c  -0.0500    $ U-238            5.0000  wt%
c
c      ss 304 (7.92 g/cc)
c
m2     6000.70c  -0.00080    $ Carbon(C)        0.0800  wt%
      14028.70c  -0.00919    $ Silicon(Si-28)   0.9187  wt%
      14029.70c  -0.00048    $ Si-29            0.0483  wt%
      14030.70c  -0.00033    $ Si-30            0.0330  wt%
```

```
      15031.70c  -0.00045    $ Phosphorus(P)    0.0450  wt%
      24050.70c  -0.00793    $ Cromium (Cr-50)  0.7930  wt%
      24052.70c  -0.15903    $ Cr-52           15.9029  wt%
      24053.70c  -0.01838    $ Cr-53            1.8380  wt%
      24054.70c  -0.00466    $ Cr-54            0.4661  wt%
      25055.70c  -0.02000    $ Manganese (Mn)   2.0000  wt%
      26054.70c  -0.03860    $ Iron (Fe-54)     3.8602  wt%
      26056.70c  -0.62838    $ Fe-56           62.8377  wt%
      26057.70c  -0.01477    $ Fe-57            1.4772  wt%
      26058.70c  -0.00200    $ Fe-58            0.2000  wt%
      28058.70c  -0.06384    $ Nickel (Ni-58)   6.3838  wt%
      28060.70c  -0.02544    $ Ni-60            2.5437  wt%
      28061.70c  -0.00112    $ Ni-61            0.1124  wt%
      28062.70c  -0.00364    $ Ni-62            0.3643  wt%
      28064.70c  -0.00096    $ Ni-64            0.0958  wt%
c
c      rubber foam (1.20 g/cc)
c
m3     1001.70c  -0.08157    $ Hydrogen (H)     8.1573 wt%
       6000.70c  -0.32377    $ Carbon (C)      32.3767 wt%
       8016.70c  -0.21520    $ Oxygen (O-16)   21.5196 wt%
       8017.70c  -0.00059    $ O-17 & O-18      0.0586 wt%
      14028.70c  -0.34806    $ Silicon(Si-28)  34.8061 wt%
      14029.70c  -0.01831    $ Si-29            1.8314 wt%
      14030.70c  -0.01250    $ Si-30            1.2503 wt%
c
c      kaolite (0.321 g/cc)
c
m4     8016.70c -0.4092    $ Oxygen (O-16)   40.9231 wt%
       8017.70c -0.0011    $ Oxygen (17&18)   0.1114 wt%
      11023.70c -0.0148    $ Sodium (Na)      1.4837 wt%
      12024.70c -0.0786    $ Magnesium (Mg-24)6.1579 wt%
      12025.70c -0.0081    $ Mg-25            0.8121 wt%
      12026.70c -0.0093    $ Mg-26            0.9298 wt%
      13027.70c -0.0508    $ Al               5.0808 wt%
      14028.70c -0.1576    $ Silicon (Si-28) 15.7596 wt%
      14029.70c -0.0083    $ Si-29            0.8292 wt%
      14030.70c -0.0057    $ Si-30            0.5661 wt%
      20040.70c -0.2121    $ Calcium (Ca-40  21.2086 wt%
      20042.70c -0.0015    $ Ca-42            0.1490 wt%
      20043.70c -0.0003    $ Ca-43            0.0318 wt%
      20044.70c -0.0050    $ Ca-44            0.5031 wt%
      20046.70c -0.00001   $ Ca-46            0.0010 wt%
      20048.70c -0.0005    $ Ca-48            0.0491 wt%
      22046.70c -0.0006    $ Titanium (Ti-46) 0.0570 wt%
      22047.70c -0.0005    $ Ti-47            0.0525 wt%
      22048.70c -0.0053    $ Ti-48            0.5311 wt%
      22049.70c -0.0004    $ Ti-49            0.0398 wt%
      22050.70c -0.0004    $ Ti-50            0.0407 wt%
      26054.70c -0.0026    $ Iron (Fe-54)     0.2646 wt%
      26056.70c -0.0431    $ Fe-56            4.3066 wt%
      26057.70c -0.0010    $ Fe-57            0.1012 wt%
      26058.70c -0.0001    $ Fe-58            0.0137 wt%
c
c      Cat 277-4 (1.4586 g/cc)
c
m5     1001.70c -0.0285    $ Hydrogen         2.8475 wt%
       5010.70c -0.0066    $ Boron (B-10)     0.6591 wt%
       5011.70c -0.0297    $ Boron (B-11)     2.9726 wt%
       6000.70c -0.0136    $ Carbon (C)       1.3609 wt%
       7014.70c -0.0001    $ Nitrogen (N)     0.0100 wt%
```

```
        8016.70c -0.5325    $ Oxygen (O-16)   53.2515 wt%
        8017.70c -0.0015    $ Oxygen (17&18)   0.1450 wt%
       11023.70c -0.0008    $ Sodium (Na)      0.0833 wt%
       12024.70c -0.0019    $ Magnesium (Mg-24)0.1867 wt%
       12025.70c -0.0002    $ Mg-25            0.0246 wt%
       12026.70c -0.0003    $ Mg-26            0.0282 wt%
       13027.70c -0.2769    $ Al              27.6937 wt%
       14028.70c -0.0161    $ Silicon (Si-28)  1.6075 wt%
       14029.70c -0.0008    $ Si-29            0.0846 wt%
       14030.70c -0.0006    $ Si-30            0.0577 wt%
       16032.70c -0.0021    $ Sulfur (S-32)    0.2071 wt%
       16033.70c -0.00002   $ S-33             0.0017 wt%
       16034.70c -0.0001    $ S-34             0.0098 wt%
       16036.70c -0.0000002 $ S-36             0.00002 wt%
       20040.70c -0.0811    $ Calcium (Ca-40)  8.1125 wt%
       20042.70c -0.0006    $ Ca-42            0.0569 wt%
       20043.70c -0.0001    $ Ca-43            0.0121 wt%
       20044.70c -0.0019    $ Ca-44            0.1920 wt%
       20046.70c -0.000004  $ Ca-46            0.0004 wt%
       20048.70c -0.0002    $ Ca-48            0.0188 wt%
       26054.70c -0.0002    $ Iron (Fe-54)     0.0212 wt%
       26056.70c -0.0035    $ Fe-56            0.3453 wt%
       26057.70c -0.00008   $ Fe-57            0.0081 wt%
       26058.70c -0.00001   $ Fe-58            0.0011 wt%
c
c       air (1.225e-3 g/cc)
c
m6      7014.70c  -0.755   $ Nitrogen (N-14) 75.5000 wt%
        8016.70c  -0.232   $ Oxygen (O-16)   23.2000 wt%
       18000.70c  -0.013   $ Argon (Ar-40)    1.3000 wt%
c
c      uranium metal (10.960 g/cc - variable)
c
m7     8016.70c  -0.1198    $ O               11.9800  wt%
      92235.70c  -0.8362    $ U-235           83.6200  wt%
      92238.70c  -0.0440    $ U-238            4.4000  wt%
c
c    source in ES-3100 - cylindrical hemishell at the bottom of CV
c                        (H = 76.2 cm; IR = 4.9337 cm; OR = 6.35 cm)
c
c   photon source - 3.011e+06 photons/sec/gm basis
c   material used - 36 kg U-mass
c   dose conversion factor (mrem/hr)/(photons/cm2-s) used
c   source term, wgt = 3.011e+06 * 36.0e+03  = 1.08396e+11
c
sdef cell=2 pos=0 0 12.4968 rad=d1 ext=d2  erg=d3 axs=0 0 1 wgt=1.08396e+11
c
c  source position
c
si1    4.9337   6.35         $ radial
sp1    -21       1
si2    0.0     76.20         $ axial
sp2     0        1
c
c  ORIGEN photon spectrum
c
si3     5.00e-03     1.00e-02    1.50e-02     2.00e-02    2.50e-02     3.00e-02
        4.00e-02     5.00e-02    6.00e-02     7.00e-02    8.00e-02     9.00e-02
        1.00e-01     2.00e-01    3.00e-01     4.00e-01    5.00e-01     6.00e-01
        7.00e-01     8.00e-01    9.00e-01     1.00e+00    1.10e+00     1.20e+00
        1.30e+00     1.40e+00    1.50e+00     1.60e+00    1.70e+00     1.80e+00
```

```
        1.90e+00     2.00e+00    2.10e+00     2.20e+00    2.30e+00     2.40e+00
        2.50e+00     2.60e+00    2.70e+00     2.80e+00    2.90e+00     3.00e+00
        3.50e+00     4.00e+00    5.00e+00     6.50e+00    8.00e+00    10.00e+00
sp3     0.0          8.515e+04   1.700e+06    7.313e+03   3.595e+03    1.230e+05
        5.112e+03    6.605e+03   2.147e+05    1.779e+03   1.941e+04    1.085e+05
        2.244e+05    1.328e+05   5.245e+04    2.819e+05   1.556e+04    1.225e+04
        1.485e+02    2.705e+03   1.802e+03    4.068e+02   2.527e+02    2.157e+01
        2.105e+01    2.990e+01   1.300e+01    1.386e+02   4.719e+02    5.522e+00
        2.999e+01    4.918e+00   1.599e-02    1.308e-02   7.152e-02    5.321e-04
        1.584e-02    6.552e-05   1.062e+04    1.108e-02   1.917e-04    3.408e-04
        6.039e-01    3.876e-01   2.959e-03    1.134e-03   2.131e-04    4.388e-05
c
fq0 f s d
c
c  point detectors for primary photons
c
f5:p    23.4299  0.0     50.5968   0.0     $ side surface - detector
f15:p    0.0     0.0    108.83739  0.0     $ top surface - detector
f25:p    0.0     0.0     -0.1      0.0     $ bottom surface - detector
f35:p  123.3299  0.0     50.5968   0.0     $ 1m from side surface - detector
f45:p    0.0     0.0    208.73739  0.0     $ 1m from top surface - detector
f55:p    0.0     0.0   -100.0      0.0     $ 1m from bottom surface - detector
c
c ANSI/ANS-6.1.1-1977 photon flux to dose rate conversion factor
c                                  (mrem/hr)/(photons/cm2-s)
c
de0         0.01      0.03      0.05      0.07       0.1      0.15      0.20
            0.25      0.30      0.35      0.40       0.45     0.50      0.55
            0.60      0.65      0.70      0.8        1.0      1.4       1.8
            2.2       2.6       2.8       3.25       3.75     4.25      4.75
            5.00      5.25      5.75      6.25       6.75     7.50      9.0
           11.0      13.0      15.0
c
df0      3.96e-3   5.82e-4   2.90e-4   2.58e-4   2.83e-4   3.79e-4   5.01e-4
         6.31e-4   7.59e-4   8.78e-4   9.85e-4   1.08e-3   1.17e-3   1.27e-3
         1.36e-3   1.44e-3   1.52e-3   1.68e-3   1.98e-3   2.51e-3   2.99e-3
         3.42e-3   3.82e-3   4.01e-3   4.41e-3   4.83e-3   5.23e-3   5.60e-3
         5.80e-3   6.01e-3   6.37e-3   6.74e-3   7.11e-3   7.66e-3   8.77e-3
         1.03e-2   1.18e-2   1.33e-2
c
prdmp  j  50000000 0 10
ctme 3000
```

5.5.2.2 NCT for 36-kg uranium metal photon top dose-rate calculations (cylinder configuration source moved to the top of CV)

```
photon_top.inp - ES-3100: 2015 HEU detailed mmodel (primary photons)
c
c    NCT configuration
c    (top dose rate calculations)
c    source in cylindrical form sitting at the top of CV for
c    top dose rate calculations for 2015 Revision
c
c    mcnp geometry model (CV and outside) is identical to criticality model
c    (KENO Model).
c    47 energy groups are used for the photon spectrum.  In the older version,
c    18 energy groups were used.
c    surface detectors are placed 0.1 cm and 100 cm way from the surfaces
c    and detectors are placed on the side, top, and bottom.
c    point detectors are used for dose rate calculations (used for results).
c    segmented volume detectors are used for side dose rate calculations (for checking).
```

```
c    volume detectors are used to check bottom and top dose rate calculations.
c    ANSI/ANS-6.1.1-1977 Dose conversion factors are used,
c    multiplied by 1000 to convert from rem to mrem
c
c   mode p - (primary  photons)
c
c    --------------
c     Cell Cards
c    --------------
c
    1     1   -18.82    -1       imp:n,p=1 $ source cylinder
c
c   drum bottom - at 0.0 cm level (height - 0.2667 cm)
c
   51     2   -7.92     -51      imp:n,p=1 $ drum bottom
c
c   bottom kaolite - at 0.2667 cm level (height - 10.8585 cm)
c
   61     4   -0.321    -61      imp:n,p=1 $ bottom kaolite
   62     2   -7.92     -62 61   imp:n,p=1 $ bottom kaolite+drum
c
c   bottom inner liner - at 11.1252 cm level (height - 0.3048 cm)
c
   71     2   -7.92     -71      imp:n,p=1 $ bottom liner
   72     4   -0.321    -72 71   imp:n,p=1 $ bottom liner+kaolite
   73     2   -7.92     -73 72   imp:n,p=1 $ bottom liner+kaolite+drum
c
c   bottom rubber pad - at 11.4300 cm level (height - 0.4318 cm)
c
   81     0             -81      imp:n,p=1 $ void
   82     3   -1.2      -82 81   imp:n,p=1 $ void+pad
   83     2   -7.92     -83 82   imp:n,p=1 $ void+pad+liner
   84     5   -1.4586   -84 83   imp:n,p=1 $ void+pad+liner+277-4
   85     2   -7.92     -85 84   imp:n,p=1 $ void+pad+liner+277-4+liner
   86     4   -0.321    -86 85   imp:n,p=1 $ void+pad+liner+277-4+liner+kaolite
   87     2   -7.92     -87 86   imp:n,p=1 $ void+pad+liner+277-4+liner+kaolite+drum
c
c   CV bottom (section 1) - at 11.8618 cm level (height - 0.6350 cm)
c
   91     2   -7.92     -91      imp:n,p=1 $ cv bottom
   92     0             -92 91   imp:n,p=1 $ cv bottom+void
   93     2   -7.92     -93 92   imp:n,p=1 $ cv bottom+void+liner
   94     5   -1.4586   -94 93   imp:n,p=1 $ cv bottom+void+liner+277-4
   95     2   -7.92     -95 94   imp:n,p=1 $ cv bottom+void+liner+277-4+liner
   96     4   -0.321    -96 95   imp:n,p=1 $ cv bottom+void+liner+277-4+liner+kaolite
   97     2   -7.92     -97 96   imp:n,p=1 $ cv bottom+void+liner+277-4+liner+kaolite+drum
c
c   CV (section 2) at 12.4968 cm level (height - 77.08899 cm)
c
  101     0             -101 #1   imp:n,p=1 $ cv void
  102     2   -7.92     -102 101  imp:n,p=1 $ cv void+ss
  103     0             -103 102  imp:n,p=1 $ cv void+ss+void
  104     2   -7.92     -104 103  imp:n,p=1 $ cv void+ss+void+liner
  105     5   -1.4586   -105 104  imp:n,p=1 $ cv void+ss+void+liner+277-4
  106     2   -7.92     -106 105  imp:n,p=1 $ cv void+ss+void+liner+277-4+liner
  107     4   -0.321    -107 106  imp:n,p=1 $ cv void+ss+void+liner+277-4+liner+kaolite
  108     2   -7.92     -108 107  imp:n,p=1 $ cv void+ss+void+liner+277-4+liner+kaolite+drum
  109     0             -109 108  imp:n,p=1 $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1
  110     0             -110 109  imp:n,p=1 $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp
```

```
  111     0             -111 110  imp:n,p=1 $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp+dt2
c
c   CV (section 3) at 89.5857 cm level (height - 0.1524 cm)
c   (ss liner top of sillicone rubber)
c
  112     0             -112 #1   imp:n,p=1 $ cv void
  113     2   -7.92     -113 112  imp:n,p=1 $ cv void+ss
  114     0             -114 113  imp:n,p=1 $ cv void+ss+void
  115     2   -7.92     -115 114  imp:n,p=1 $ cv void+ss+void+liner
  116     4   -0.321    -116 115  imp:n,p=1 $ cv void+ss+void+liner+kaolite
  117     2   -7.92     -117 116  imp:n,p=1 $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 4) at 89.73819 cm level (height - 0.2286 cm)
c   (gap between Cat 277-4 & CV top section)
c
  122     0             -122 #1   imp:n,p=1 $ cv void
  123     2   -7.92     -123 122  imp:n,p=1 $ cv void+ss
  124     0             -124 123  imp:n,p=1 $ cv void+ss+void
  125     2   -7.92     -125 124  imp:n,p=1 $ cv void+ss+void+liner
  126     4   -0.321    -126 125  imp:n,p=1 $ cv void+ss+void+liner+kaolite
  127     2   -7.92     -127 126  imp:n,p=1 $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 6) at 89.96679 cm level (height - 1.27 cm)
c   (lower section of CV flange)
c
  132     0             -132 #1   imp:n,p=1 $ cv void
  133     2   -7.92     -133 132  imp:n,p=1 $ cv void+ss
  134     3   -1.20     -134 133  imp:n,p=1 $ cv void+ss+rubber
  135     0             -135 134  imp:n,p=1 $ cv void+ss+rubber+void
  136     2   -7.92     -136 135  imp:n,p=1 $ cv void+ss+rubber+void+liner
  137     4   -0.321    -137 136  imp:n,p=1 $ cv void+ss+rubber+void+liner+kaolite
  138     2   -7.92     -138 137  imp:n,p=1 $ cv +void+ss+rubber+void+liner+kaolite+drum
c
c   CV (section 7) at 91.23679 cm level (height - 2.921 cm)
c   (middle section of CV flange)
c
  141     2   -7.92     -141 #1   imp:n,p=1 $ ss
  142     3   -1.20     -142 141  imp:n,p=1 $ ss+rubber
  143     0             -143 142  imp:n,p=1 $ ss+rubber+void
  144     2   -7.92     -144 143  imp:n,p=1 $ ss+rubber+void+liner
  145     4   -0.321    -145 144  imp:n,p=1 $ ss+rubber+void+liner+kaolite
  146     2   -7.92     -146 145  imp:n,p=1 $ ss+rubber+void+liner+kaolite+drum
c
c   CV (section 8) at 94.15779 cm level (height - 0.762 cm)
c   (top section of CV flange)
c
  151     3   -1.20     -151      imp:n,p=1 $ rubber
  152     0             -152 151  imp:n,p=1 $ rubber+void
  153     2   -7.92     -153 152  imp:n,p=1 $ rubber+void+liner
  154     4   -0.321    -154 153  imp:n,p=1 $ rubber+void+liner+kaolite
  155     2   -7.92     -155 154  imp:n,p=1 $ rubber+void+liner+kaolite+drum
c
c   Top of CV (section 1) at 94.91979 cm level (height - 0.254 cm)
c
  161     0             -161      imp:n,p=1 $ void
  162     2   -7.92     -162 161  imp:n,p=1 $ void+liner
  163     4   -0.321    -163 162  imp:n,p=1 $ void+liner+kaolite
  164     2   -7.92     -164 163  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Top of CV (section 2) at 95.17379 cm level (height - 0.1524 cm)
```

```
c
  171     0             -171      imp:n,p=1 $ void
  172     2   -7.92     -172 171  imp:n,p=1 $ void+liner
  173     4   -0.321    -173 172  imp:n,p=1 $ void+liner+kaolite
  174     2   -7.92     -174 173  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Top of CV (section 3) at 95.32619 cm level (height - 0.34036 cm)
c
  181     0             -181      imp:n,p=1 $ void
  182     2   -7.92     -182 181  imp:n,p=1 $ void+liner
  183     4   -0.321    -183 182  imp:n,p=1 $ void+liner+kaolite
  184     2   -7.92     -184 183  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Kaolite plug bottom ss  at 95.66655 cm level (height - 0.1524 cm)
c
  191     2   -7.92     -191      imp:n,p=1 $ ss (liner)
  192     0             -192 191  imp:n,p=1 $ ss+void
  193     2   -7.92     -193 192  imp:n,p=1 $ ss+void+liner
  194     4   -0.321    -194 193  imp:n,p=1 $ ss+void+liner+kaolite
  195     2   -7.92     -195 194  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Kaolite top plug bottom section  at 95.81895 cm level (height - 7.68604 cm)
c
  201     4   -0.321    -201      imp:n,p=1 $ kaolite
  202     2   -7.92     -202 201  imp:n,p=1 $ kaolite+liner
  203     0             -203 202  imp:n,p=1 $ kaolite+liner+void
  204     2   -7.92     -204 203  imp:n,p=1 $ kaolite+liner+void+liner
  205     4   -0.321    -205 204  imp:n,p=1 $ kaolite+liner+void+liner+kaolite
  206     2   -7.92     -206 205  imp:n,p=1 $ kaolite+liner+void+liner+kaolite+drum
c
c   Kaolite top plug (iron angle bottom section) at 103.50499 cm level (height - 4.4450 cm)
c
  211     4   -0.321    -211      imp:n,p=1 $ kaolite
  212     2   -7.92     -212 211  imp:n,p=1 $ kaolite+liner
  213     0             -213 212  imp:n,p=1 $ kaolite+liner+void
  214     2   -7.92     -214 213  imp:n,p=1 $ kaolite+liner+void+liner
  215     2   -7.92     -215 214  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle
  216     4   -0.321    -216 215  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle+kaolite
  217     2   -7.92     -217 216  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle+kaolite+drum
c
c   Kaolite top plug (iron angle top section) at 107.94999 cm level (height - 0.1118 cm)
c
  221     4   -0.321    -221      imp:n,p=1 $ kaolite
  222     2   -7.92     -222 221  imp:n,p=1 $ kaolite+liner
  223     0             -223 222  imp:n,p=1 $ kaolite+liner+void
  224     2   -7.92     -224 223  imp:n,p=1 $ kaolite+liner+void+liner
  225     2   -7.92     -225 224  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle
  226     2   -7.92     -226 225  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle+drum
c
c   Kaolite top plug (iron angle top section) at 108.06175 cm level (height - 0.1524 cm)
c
  231     2   -7.92     -231      imp:n,p=1 $ liner
  232     0             -232 231  imp:n,p=1 $ liner+void
  233     2   -7.92     -233 232  imp:n,p=1 $ liner+void+liner
  234     2   -7.92     -234 233  imp:n,p=1 $ liner+void+liner+iron-angle
  235     2   -7.92     -235 234  imp:n,p=1 $ liner+void+liner+iron-angle+drum
c
c   Gap above Kaolite top plug at 108.21415 cm level (height - 0.37084 cm)
c
  241     0             -241      imp:n,p=1 $ liner+void
  242     2   -7.92     -242 241  imp:n,p=1 $ liner+void+liner
```

```
  243     2   -7.92     -243 242  imp:n,p=1 $ liner+void+liner+iron-angle
  244     2   -7.92     -244 243  imp:n,p=1 $ liner+void+liner+iron-angle+drum
c
c   Top ss lid at 108.58499 cm level (height - 0.1524 cm)
c
  251     2   -7.92     -251      imp:n,p=1 $ ss lid
  252     0             -252 251  imp:n,p=1 $ ss lid+void
  253     2   -7.92     -253 252  imp:n,p=1 $ ss lid+void+drum
c
c   Top ss lid at 108.73739 cm level (height - 1.7526 cm)
c
  261     0             -261 #502      imp:n,p=1 $ void
  262     2   -7.92     -262 261  imp:n,p=1 $ void+ss lid
  263     0             -263 262  imp:n,p=1 $ void+ss lid+void
  264     2   -7.92     -264 263  imp:n,p=1 $ void+ss lid+void+drum
c
c   Put volume source for top and bottom detectors
c
  501     0             -501      imp:n,p=1 $ bottom surface detector
  502     0             -502      imp:n,p=1 $ top surface detector
  551     0             -551      imp:n,p=1 $ 1 m from bottom surface - detector
  552     0             -552      imp:n,p=1 $ 1 m from top surface - detector
c
  998     0             -999      51 62 73 87 97 111 117 127 138 146 155
                                  164 174 184 195 206 217 226 235 244 253
                                  264 501 502 551 552
                                  imp:n,p=1 $ inside boundary
  999     0              999      imp:n,p=0 $ outside world

c    ------------------
c    Surface Cards
c    ------------------
c
    1  rcc  0.0 0.0 76.13649   0.0 0.0  15.1003  6.35 $ cylinder source at top of cv
c
c   drum bottom - at 0.0 cm level (height - 0.2667 cm)
c
   51  rcc  0.0 0.0  0.0     0.0 0.0 0.2667   23.3299  $ drum bottom
c
c   bottom kaolite - at 0.2667 cm level (height - 10.8585 cm)
c
   61  rcc  0.0 0.0  0.2667  0.0 0.0 10.8585  23.1775  $ bottom kaolite
   62  rcc  0.0 0.0  0.2667  0.0 0.0 10.8585  23.3299  $ bottom kaolite+drum
c
c   bottom inner liner - at 11.1252 cm level (height - 0.3048 cm)
c
   71  rcc  0.0 0.0 11.1252  0.0 0.0  0.3048  11.0744  $ bottom liner
   72  rcc  0.0 0.0 11.1252  0.0 0.0  0.3048  23.1775  $ bottom liner+kaolite
   73  rcc  0.0 0.0 11.1252  0.0 0.0  0.3048  23.3299  $ bottom liner+kaolite+drum
c
c   bottom rubber pad - at 11.4300 cm level (height - 0.4318 cm)
c
   81  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318    3.1750  $ void
   82  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318    7.9248  $ void+pad
   83  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318    8.0772  $ void+pad+liner
   84  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   10.9220  $ void+pad+liner+277-4
   85  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   11.0744  $ void+pad+liner+277-4+liner
   86  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   23.1775  $ void+pad+liner+277-4+liner+kaolite
   87  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   23.3299  $
void+pad+liner+277-4+liner+kaolite+drum
c
```

```
c   CV bottom (section 1) - at 11.8618 cm level (height - 0.6350 cm)
c
   91  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350    6.6802  $ cv bottom
   92  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350    7.9248  $ cv bottom+void
   93  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350    8.0772  $ cv bottom+void+liner
   94  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   10.9220  $ cv bottom+void+liner+277-4
   95  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   11.0744  $ cv bottom+void+liner+277-4+liner
   96  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   23.1775  $ cv
bottom+void+liner+277-4+liner+kaolite
   97  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   23.3299  $ cv
bottom+void+liner+277-4+liner+kaolite+drum
c
c   CV (section 2) at 12.4968 cm level (height - 77.08899 cm)
c
  101  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  6.4262  $ cv void
  102  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  6.6802  $ cv void+ss
  103  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  7.9248  $ cv void+ss+void
  104  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  8.0772  $ cv void+ss+void+liner
  105  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 10.9220  $ cv void+ss+void+liner+277-4
  106  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 11.0744  $ cv void+ss+void+liner+277-4+liner
  107  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 23.1775  $ cv
void+ss+void+liner+277-4+liner+kaolite
  108  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 23.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum
  109  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 24.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1
  110  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 123.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp
  111  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 124.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp+dt2
c
c   CV (section 3) at 89.58579 cm level (height - 0.1524 cm)
c   (ss liner top of sillicone rubber)
c
  112  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524  6.4262  $ cv void
  113  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524  6.6802  $ cv void+ss
  114  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524  7.9248  $ cv void+ss+void
  115  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524 11.0744  $ cv void+ss+void+liner
  116  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524 23.1775  $ cv void+ss+void+liner+kaolite
  117  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524 23.3299  $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 5) at 89.73819 cm level (height - 0.2286 cm)
c   (gap between Cat 277-4 & CV top section)
c
  122  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286  6.4262  $ cv void
  123  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286  6.6802  $ cv void+ss
  124  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 10.9220  $ cv void+ss+void
  125  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 11.0744  $ cv void+ss+void+liner
  126  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 23.1775  $ cv void+ss+void+liner+kaolite
  127  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 23.3299  $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 6) at 89.96679 cm level (height - 1.27 cm)
c   (lower section of CV flange)
c
  132  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700  6.4262  $ cv void
  133  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700  9.5250  $ cv void+ss
  134  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 10.0330  $ cv void+ss+rubber
  135  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 10.9220  $ cv void+ss+rubber+void
  136  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 11.0744  $ cv void+ss+rubber+void+liner
  137  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 23.1775  $ cv void+ss+rubber+void+liner+kaolite
```

```
  138  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 23.3299  $ cv
void+ss+rubber+void+liner+kaolite+drum
c
c   CV (section 7) at 91.23679 cm level (height - 2.921 cm)
c   (lower section of CV flange)
c
  141  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210  9.5250  $ ss
  142  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 10.0330  $ ss+rubber
  143  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 10.9220  $ ss+rubber+void
  144  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 11.0744  $ ss+rubber+void+liner
  145  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 23.1775  $ ss+rubber+void+liner+kaolite
  146  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 23.3299  $ ss+rubber+void+liner+kaolite+drum
c
c   CV (section 8) at 94.15779 cm level (height - 0.762 cm)
c   (top section of CV flange)
c
  151  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 10.0330  $ rubber
  152  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 10.9220  $ rubber+void
  153  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 11.0744  $ rubber+void+liner
  154  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 23.1775  $ rubber+void+liner+kaolite
  155  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 23.3299  $ rubber+void+liner+kaolite+drum
c
c   Top of CV (section 1) at 94.91979 cm level (height - 0.254 cm)
c
  161  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 10.9220  $ void
  162  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 11.0744  $ void+liner
  163  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 23.1775  $ void+liner+kaolite
  164  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 23.3299  $ void+liner+kaolite+drum
c
c   Top of CV (section 2) at 95.17379 cm level (height - 0.1524 cm)
c
  171  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 10.9220  $ void
  172  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 18.7579  $ void+liner
  173  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 23.1775  $ void+liner+kaolite
  174  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 23.3299  $ void+liner+kaolite+drum
c
c   Top of CV (section 3) at 95.32619 cm level (height - 0.34036 cm)
c
  181  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 18.6055  $ void
  182  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 18.7579  $ void+liner
  183  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 23.1775  $ void+liner+kaolite
  184  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 23.3299  $ void+liner+kaolite+drum
c
c   Kaolite plug bottom ss  at 95.66655 cm level (height - 0.1524 cm)
c
  191  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 18.2499   $ ss (liner)
  192  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 18.6055   $ ss+void
  193  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 18.7579   $ ss+void+liner
  194  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 23.1775   $ ss+void+liner+kaolite
  195  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 23.3299   $ ss+void+liner+kaolite+drum
c
c   Kaolite top plug bottom section  at 95.81895 cm level (height - 7.68604 cm)
c
  201  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.0975  $ kaolite
  202  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.2499  $ kaolite +liner
  203  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.6055  $ kaolite+liner+void
  204  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.7579  $ kaolite+liner+void+liner
  205  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 23.1775  $ kaolite+liner+void+liner+kaolite
  206  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 23.3299  $
kaolite+liner+void+liner+kaolite+drum
c
```

```
c   Kaolite top plug (iron angle bottom section) at 103.50499 cm level (height - 4.4450 cm)
c
  211  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.0975  $ kaolite
  212  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.2499  $ kaolite +liner
  213  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.6055  $ kaolite+liner+void
  214  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.7579  $ kaolite+liner+void+liner
  215  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  19.3929  $ kaolite+liner+void+liner+iron-angle
  216  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  23.1775  $
kaolite+liner+void+liner+iron-angle+kaolite
  217  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  23.3299  $
kaolite+liner+void+liner+iron-angle+kaolite+drum
c
c   Kaolite top plug (iron angle top section) at 107.94999 cm level (height - 0.1118 cm)
c
  221  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.0975  $ kaolite
  222  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.2499  $ kaolite +liner
  223  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.6055  $ kaolite+liner+void
  224  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.7579  $ kaolite+liner+void+liner
  225  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  23.1775  $ kaolite+liner+void+liner+iron-angle
  226  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  23.3299  $
kaolite+liner+void+liner+iron-angle+drum
c
c   Kaolite top plug (iron angle top section) at 108.06175 cm level (height - 0.1524 cm)
c
  231  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  18.2499  $ ss liner
  232  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  18.6055  $ ss liner+void
  233  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  18.7579  $ ss liner+void+liner
  234  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  23.1775  $ ss liner+void+liner+iron-angle
  235  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  23.3299  $ ss liner+void+liner+iron-angle+drum
c
c   Gap above Kaolite top plug at 108.21415 cm level (height - 0.37084 cm)
c
  241  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  18.6055  $ void
  242  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  18.7579  $ void+liner
  243  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  23.1775  $ void+liner+iron-angle
  244  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  23.3299  $ void+liner+iron-angle+drum
c
c   Top ss lid at 108.58499 cm level (height - 0.1524 cm)
c
  251  rcc 0.0 0.0 108.58499  0.0 0.0  0.1524  23.1140  $ ss lid
  252  rcc 0.0 0.0 108.58499  0.0 0.0  0.1524  23.1775  $ ss lid+void
  253  rcc 0.0 0.0 108.58499  0.0 0.0  0.1524  23.3299  $ ss lid+void+drum
c
c   Top ss lid at 108.73739 cm level (height - 1.7526 cm)
c
  261  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  22.9616  $ void
  262  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  23.1140  $ void+ss lid
  263  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  23.1775  $ void+ss lid+void
  264  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  23.3299  $ void+ss lid+void+drum
c
c   Segmented side volume detectors
c
  301  pz 13
  302  pz 14
  303  pz 15
  304  pz 16
  305  pz 17
  306  pz 18
  307  pz 19
  308  pz 20
  309  pz 21
```

```
310  pz 22
311  pz 23
312  pz 24
313  pz 25
314  pz 26
315  pz 27
316  pz 28
317  pz 29
318  pz 30
319  pz 31
320  pz 32
321  pz 33
322  pz 34
323  pz 35
324  pz 36
325  pz 37
326  pz 38
327  pz 39
328  pz 40
329  pz 41
330  pz 42
331  pz 43
332  pz 44
333  pz 45
334  pz 46
335  pz 47
336  pz 48
337  pz 49
338  pz 50
339  pz 51
340  pz 52
341  pz 53
342  pz 54
343  pz 55
344  pz 56
345  pz 57
346  pz 58
347  pz 59
348  pz 60
349  pz 61
350  pz 62
351  pz 63
352  pz 64
353  pz 65
354  pz 66
355  pz 67
356  pz 68
357  pz 69
358  pz 70
359  pz 71
360  pz 72
361  pz 73
362  pz 74
363  pz 75
364  pz 76
365  pz 77
366  pz 78
367  pz 79
368  pz 80
369  pz 81
370  pz 82
```

```
  371  pz 83
  372  pz 84
  373  pz 85
  374  pz 86
  375  pz 87
  376  pz 88
  377  pz 89
c
c   Put volume source for top and bottom detectors
c
  501  rcc 0.0 0.0 -0.5  0.0 0.0  0.5  1.0          $ bottom surface vol detector
  502  rcc 0.0 0.0 108.73739  0.0 0.0  0.5  1.0     $ top surface vol detector
  551  rcc 0.0 0.0 -100.5  0.0 0.0  0.5  1.0        $ 1 m from bottom surface - vol detector
  552  rcc 0.0 0.0 208.73739  0.0 0.0  0.5  1.0     $ 1 m from top surface - vol detector
c
  999  sph  0.0 0.0  0.000  999.0                         $ boundary
c

c    ----------------------
c    Data Cards
c    ----------------------
mode  p
c
c      uranium metal (18.82 g/cc)
c
m1    92235.70c  -0.9500    $ U-235           95.0000  wt%
      92238.70c  -0.0500    $ U-238            5.0000  wt%
c
c      ss 304 (7.92 g/cc)
c
m2     6000.70c  -0.00080    $ Carbon(C)        0.0800  wt%
      14028.70c  -0.00919    $ Silicon(Si-28)   0.9187  wt%
      14029.70c  -0.00048    $ Si-29            0.0483  wt%
      14030.70c  -0.00033    $ Si-30            0.0330  wt%
      15031.70c  -0.00045    $ Phosphorus(P)    0.0450  wt%
      24050.70c  -0.00793    $ Cromium (Cr-50)  0.7930  wt%
      24052.70c  -0.15903    $ Cr-52           15.9029  wt%
      24053.70c  -0.01838    $ Cr-53            1.8380  wt%
      24054.70c  -0.00466    $ Cr-54            0.4661  wt%
      25055.70c  -0.02000    $ Manganese (Mn)   2.0000  wt%
      26054.70c  -0.03860    $ Iron (Fe-54)     3.8602  wt%
      26056.70c  -0.62838    $ Fe-56           62.8377  wt%
      26057.70c  -0.01477    $ Fe-57            1.4772  wt%
      26058.70c  -0.00200    $ Fe-58            0.2000  wt%
      28058.70c  -0.06384    $ Nickel (Ni-58)   6.3838  wt%
      28060.70c  -0.02544    $ Ni-60            2.5437  wt%
      28061.70c  -0.00112    $ Ni-61            0.1124  wt%
      28062.70c  -0.00364    $ Ni-62            0.3643  wt%
      28064.70c  -0.00096    $ Ni-64            0.0958  wt%
c
c      rubber foam (1.20 g/cc)
c
m3     1001.70c  -0.08157    $ Hydrogen (H)     8.1573 wt%
       6000.70c  -0.32377    $ Carbon (C)      32.3767 wt%
       8016.70c  -0.21520    $ Oxygen (O-16)   21.5196 wt%
       8017.70c  -0.00059    $ O-17 & O-18      0.0586 wt%
      14028.70c  -0.34806    $ Silicon(Si-28)  34.8061 wt%
      14029.70c  -0.01831    $ Si-29            1.8314 wt%
      14030.70c  -0.01250    $ Si-30            1.2503 wt%
c
c      kaolite (0.321 g/cc)
```

```
c
m4     8016.70c -0.4092    $ Oxygen (O-16)   40.9231 wt%
       8017.70c -0.0011    $ Oxygen (17&18)   0.1114 wt%
      11023.70c -0.0148    $ Sodium (Na)      1.4837 wt%
      12024.70c -0.0616    $ Magnesium (Mg-24)6.1579 wt%
      12025.70c -0.0081    $ Mg-25            0.8121 wt%
      12026.70c -0.0093    $ Mg-26            0.9298 wt%
      13027.70c -0.0508    $ Al               5.0808 wt%
      14028.70c -0.1576    $ Silicon (Si-28) 15.7596 wt%
      14029.70c -0.0083    $ Si-29            0.8292 wt%
      14030.70c -0.0057    $ Si-30            0.5661 wt%
      20040.70c -0.2121    $ Calcium (Ca-40) 21.2086 wt%
      20042.70c -0.0015    $ Ca-42            0.1490 wt%
      20043.70c -0.0003    $ Ca-43            0.0318 wt%
      20044.70c -0.0050    $ Ca-44            0.5031 wt%
      20046.70c -0.00001   $ Ca-46            0.0010 wt%
      20048.70c -0.0005    $ Ca-48            0.0491 wt%
      22046.70c -0.0006    $ Titanium (Ti-46) 0.0570 wt%
      22047.70c -0.0005    $ Ti-47            0.0525 wt%
      22048.70c -0.0053    $ Ti-48            0.5311 wt%
      22049.70c -0.0004    $ Ti-49            0.0398 wt%
      22050.70c -0.0004    $ Ti-50            0.0407 wt%
      26054.70c -0.0026    $ Iron (Fe-54)     0.2646 wt%
      26056.70c -0.0431    $ Fe-56            4.3066 wt%
      26057.70c -0.0010    $ Fe-57            0.1012 wt%
      26058.70c -0.0001    $ Fe-58            0.0137 wt%
c
c      Cat 277-4 (1.4586 g/cc)
c
m5     1001.70c -0.0285    $ Hydrogen         2.8475 wt%
       5010.70c -0.0066    $ Boron (B-10)     0.6591 wt%
       5011.70c -0.0297    $ Boron (B-11)     2.9726 wt%
       6000.70c -0.0136    $ Carbon (C)       1.3609 wt%
       7014.70c -0.0001    $ Nitrogen (N)     0.0100 wt%
       8016.70c -0.5325    $ Oxygen (O-16)   53.2515 wt%
       8017.70c -0.0015    $ Oxygen (17&18)   0.1450 wt%
      11023.70c -0.0008    $ Sodium (Na)      0.0833 wt%
      12024.70c -0.0019    $ Magnesium (Mg-24)0.1867 wt%
      12025.70c -0.0002    $ Mg-25            0.0246 wt%
      12026.70c -0.0003    $ Mg-26            0.0282 wt%
      13027.70c -0.2769    $ Al              27.6937 wt%
      14028.70c -0.0161    $ Silicon (Si-28)  1.6075 wt%
      14029.70c -0.0008    $ Si-29            0.0846 wt%
      14030.70c -0.0006    $ Si-30            0.0577 wt%
      16032.70c -0.0021    $ Sulfur (S-32)    0.2071 wt%
      16033.70c -0.00002   $ S-33             0.0017 wt%
      16034.70c -0.0001    $ S-34             0.0098 wt%
      16036.70c -0.0000002 $ S-36             0.00002 wt%
      20040.70c -0.0811    $ Calcium (Ca-40)  8.1125 wt%
      20042.70c -0.0006    $ Ca-42            0.0569 wt%
      20043.70c -0.0001    $ Ca-43            0.0121 wt%
      20044.70c -0.0019    $ Ca-44            0.1920 wt%
      20046.70c -0.000004  $ Ca-46            0.0004 wt%
      20048.70c -0.0002    $ Ca-48            0.0188 wt%
      26054.70c -0.0002    $ Iron (Fe-54)     0.0212 wt%
      26056.70c -0.0035    $ Fe-56            0.3453 wt%
      26057.70c -0.00008   $ Fe-57            0.0081 wt%
      26058.70c -0.00001   $ Fe-58            0.0011 wt%
c
c       air (1.225e-3 g/cc)
c
```

```
m6      7014.70c  -0.755   $ Nitrogen (N-14) 75.5000 wt%
        8016.70c  -0.232   $ Oxygen (O-16)   23.2000 wt%
       18000.70c  -0.013   $ Argon (Ar-40)    1.3000 wt%
c
c    source in ES-3100 - cylindrical shape at the top of CV
c                        (H = 15.1003 cm; R = 6.35 cm)
c
c   photon source - 3.011e+06 photons/sec/gm basis
c   material used - 36 kg HEU
c   dose conversion factor (mrem/hr)/(photons/cm2-s) used
c   source term, wgt = 3.011e+06 * 36.0e+03  = 1.0840e+11
c
sdef pos=0 0 76.13649 rad=d1 ext=d2  erg=d3 axs=0 0 1 wgt=1.0840e+11
c
c  source position
c
si1    0.0      6.35         $ radial
sp1    -21       1
si2    0.0     15.1003       $ axial
sp2     0        1
c
c  ORIGEN photon spectrum
c
si3     5.00e-03     1.00e-02    1.50e-02     2.00e-02    2.50e-02     3.00e-02
        4.00e-02     5.00e-02    6.00e-02     7.00e-02    8.00e-02     9.00e-02
        1.00e-01     2.00e-01    3.00e-01     4.00e-01    5.00e-01     6.00e-01
        7.00e-01     8.00e-01    9.00e-01     1.00e+00    1.10e+00     1.20e+00
        1.30e+00     1.40e+00    1.50e+00     1.60e+00    1.70e+00     1.80e+00
        1.90e+00     2.00e+00    2.10e+00     2.20e+00    2.30e+00     2.40e+00
        2.50e+00     2.60e+00    2.70e+00     2.80e+00    2.90e+00     3.00e+00
        3.50e+00     4.00e+00    5.00e+00     6.50e+00    8.00e+00    10.00e+00
sp3     0.0          8.515e+04   1.700e+06    7.313e+03   3.595e+03    1.230e+05
        5.112e+03    6.605e+03   2.147e+05    1.779e+03   1.941e+04    1.085e+05
        2.244e+05    1.328e+05   5.245e+04    2.819e+05   1.556e+04    1.225e+04
        1.485e+02    2.705e+03   1.802e+03    4.068e+02   2.527e+02    2.157e+01
        2.105e+01    2.990e+01   1.300e+01    1.386e+02   4.719e+02    5.522e+00
        2.999e+01    4.918e+00   1.599e-02    1.308e-02   7.152e-02    5.321e-04
        1.584e-02    6.552e-05   1.062e+04    1.108e-02   1.917e-04    3.408e-04
        6.039e-01    3.876e-01   2.959e-03    1.134e-03   2.131e-04    4.388e-05
c
fq0 f s d
c
c  volume detector at the bottom surface of the drum
c
f4:p 501             $ bottom surface volume detector
f14:p 502            $ top surface volume detector
f24:p 551            $ 1 m from bottom surface  - volume detector
f34:p 552            $ 1 m from top surface  - volume detector
c
c  segmented volume detectors for primary photons
c
c  side surface
c
f114:p 109
fs114  -301 -302 -303 -304 -305 -306 -307 -308 -309 -310
       -311 -312 -313 -314 -315 -316 -317 -318 -319 -320
       -321 -322 -323 -324 -325 -326 -327 -328 -329 -330
       -331 -332 -333 -334 -335 -336 -337 -338 -339 -340
       -341 -342 -343 -344 -345 -346 -347 -348 -349 -350
       -351 -352 -353 -354 -355 -356 -357 -358 -359 -360
       -361 -362 -363 -364 -365 -366 -367 -368 -369 -370
```

```
       -371 -372 -373 -374 -375 -376 -377
c
c  1 m from side surface
c
f134:p  111
fs134  -301 -302 -303 -304 -305 -306 -307 -308 -309 -310
       -311 -312 -313 -314 -315 -316 -317 -318 -319 -320
       -321 -322 -323 -324 -325 -326 -327 -328 -329 -330
       -331 -332 -333 -334 -335 -336 -337 -338 -339 -340
       -341 -342 -343 -344 -345 -346 -347 -348 -349 -350
       -351 -352 -353 -354 -355 -356 -357 -358 -359 -360
       -361 -362 -363 -364 -365 -366 -367 -368 -369 -370
       -371 -372 -373 -374 -375 -376 -377
c
c  point detectors for primary photons
c
f5:p    23.4299  0.0     83.68664  0.0     $ side surface - detector
f15:p    0.0     0.0    108.83739  0.0     $ top surface - detector
f25:p    0.0     0.0     -0.1      0.0     $ bottom surface - detector
f35:p  123.3299  0.0     83.68664  0.0     $ 1m from side surface - detector
f45:p    0.0     0.0    208.73739  0.0     $ 1m from top surface - detector
f55:p    0.0     0.0   -100.0      0.0     $ 1m from bottom surface - detector
c
c ANSI/ANS-6.1.1-1977 photon flux to dose rate conversion factor
c                                  (mrem/hr)/(photons/cm2-s)
c
de0         0.01      0.03      0.05      0.07       0.1      0.15      0.20
            0.25      0.30      0.35      0.40       0.45     0.50      0.55
            0.60      0.65      0.70      0.8        1.0      1.4       1.8
            2.2       2.6       2.8       3.25       3.75     4.25      4.75
            5.00      5.25      5.75      6.25       6.75     7.50      9.0
           11.0      13.0      15.0
c
df0      3.96e-3   5.82e-4   2.90e-4   2.58e-4   2.83e-4   3.79e-4   5.01e-4
         6.31e-4   7.59e-4   8.78e-4   9.85e-4   1.08e-3   1.17e-3   1.27e-3
         1.36e-3   1.44e-3   1.52e-3   1.68e-3   1.98e-3   2.51e-3   2.99e-3
         3.42e-3   3.82e-3   4.01e-3   4.41e-3   4.83e-3   5.23e-3   5.60e-3
         5.80e-3   6.01e-3   6.37e-3   6.74e-3   7.11e-3   7.66e-3   8.77e-3
         1.03e-2   1.18e-2   1.33e-2
c
prdmp  j  10000000 0 10
ctme 5000
```

5.5.2.3 NCT for 36-kg uranium metal neutron and secondary photon top and side dose-rate calculations (cylinder configuration source moved to the top of CV)

```
neutron_top.inp - ES-3100: 2015 HEU model (neutrons and secondary photons)
c
c    NCT configuration
c    (top dose rate calculations)
c    source in cylindrical form sitting at the top of CV for
c    top dose rate calculations for 2015 calculation Revision
c
c    mcnp geometry model (CV and outside) is identical to criticality model
c    (KENO Model).
c    47 energy groups are used for the photon spectrum.  In the older version,
c    18 energy groups were used.
c    surface detectors are placed 0.1 cm and 100 cm way from the surfaces
c    and detectors are placed on the side, top, and bottom.
c    point detectors are used for dose rate calculations (used for results).
c    segmented volume detectors are used for side dose rate calculations (for checking).
```

```
c    volume detectors are used to check bottom and top dose rate calculations.
c    ANSI/ANS-6.1.1-1977 Dose conversion factors are used,
c    multiplied by 1000 to convert from rem to mrem
c
c   mode n p - (neutrons and secondary photons)
c
c    --------------
c     Cell Cards
c    --------------
c
    1     1   -18.82    -1       imp:n,p=1 $ source cylinder
c
c   drum bottom - at 0.0 cm level (height - 0.2667 cm)
c
   51     2   -7.92     -51      imp:n,p=1 $ drum bottom
c
c   bottom kaolite - at 0.2667 cm level (height - 10.8585 cm)
c
   61     4   -0.321    -61      imp:n,p=1 $ bottom kaolite
   62     2   -7.92     -62 61   imp:n,p=1 $ bottom kaolite+drum
c
c   bottom inner liner - at 11.1252 cm level (height - 0.3048 cm)
c
   71     2   -7.92     -71      imp:n,p=1 $ bottom liner
   72     4   -0.321    -72 71   imp:n,p=1 $ bottom liner+kaolite
   73     2   -7.92     -73 72   imp:n,p=1 $ bottom liner+kaolite+drum
c
c   bottom rubber pad - at 11.4300 cm level (height - 0.4318 cm)
c
   81     0             -81      imp:n,p=1 $ void
   82     3   -1.2      -82 81   imp:n,p=1 $ void+pad
   83     2   -7.92     -83 82   imp:n,p=1 $ void+pad+liner
   84     5   -1.4586   -84 83   imp:n,p=1 $ void+pad+liner+277-4
   85     2   -7.92     -85 84   imp:n,p=1 $ void+pad+liner+277-4+liner
   86     4   -0.321    -86 85   imp:n,p=1 $ void+pad+liner+277-4+liner+kaolite
   87     2   -7.92     -87 86   imp:n,p=1 $ void+pad+liner+277-4+liner+kaolite+drum
c
c   CV bottom (section 1) - at 11.8618 cm level (height - 0.6350 cm)
c
   91     2   -7.92     -91      imp:n,p=1 $ cv bottom
   92     0             -92 91   imp:n,p=1 $ cv bottom+void
   93     2   -7.92     -93 92   imp:n,p=1 $ cv bottom+void+liner
   94     5   -1.4586   -94 93   imp:n,p=1 $ cv bottom+void+liner+277-4
   95     2   -7.92     -95 94   imp:n,p=1 $ cv bottom+void+liner+277-4+liner
   96     4   -0.321    -96 95   imp:n,p=1 $ cv bottom+void+liner+277-4+liner+kaolite
   97     2   -7.92     -97 96   imp:n,p=1 $ cv bottom+void+liner+277-4+liner+kaolite+drum
c
c   CV (section 2) at 12.4968 cm level (height - 77.08899 cm)
c
  101     0             -101 #1   imp:n,p=1 $ cv void
  102     2   -7.92     -102 101  imp:n,p=1 $ cv void+ss
  103     0             -103 102  imp:n,p=1 $ cv void+ss+void
  104     2   -7.92     -104 103  imp:n,p=1 $ cv void+ss+void+liner
  105     5   -1.4586   -105 104  imp:n,p=1 $ cv void+ss+void+liner+277-4
  106     2   -7.92     -106 105  imp:n,p=1 $ cv void+ss+void+liner+277-4+liner
  107     4   -0.321    -107 106  imp:n,p=1 $ cv void+ss+void+liner+277-4+liner+kaolite
  108     2   -7.92     -108 107  imp:n,p=1 $ cv void+ss+void+liner+277-4+liner+kaolite+drum
  109     0             -109 108  imp:n,p=1 $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1
  110     0             -110 109  imp:n,p=1 $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp
```

```
  111     0             -111 110  imp:n,p=1 $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp+dt2
c
c   CV (section 3) at 89.5857 cm level (height - 0.1524 cm)
c   (ss liner top of sillicone rubber)
c
  112     0             -112 #1   imp:n,p=1 $ cv void
  113     2   -7.92     -113 112  imp:n,p=1 $ cv void+ss
  114     0             -114 113  imp:n,p=1 $ cv void+ss+void
  115     2   -7.92     -115 114  imp:n,p=1 $ cv void+ss+void+liner
  116     4   -0.321    -116 115  imp:n,p=1 $ cv void+ss+void+liner+kaolite
  117     2   -7.92     -117 116  imp:n,p=1 $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 4) at 89.73819 cm level (height - 0.2286 cm)
c   (gap between Cat 277-4 & CV top section)
c
  122     0             -122 #1   imp:n,p=1 $ cv void
  123     2   -7.92     -123 122  imp:n,p=1 $ cv void+ss
  124     0             -124 123  imp:n,p=1 $ cv void+ss+void
  125     2   -7.92     -125 124  imp:n,p=1 $ cv void+ss+void+liner
  126     4   -0.321    -126 125  imp:n,p=1 $ cv void+ss+void+liner+kaolite
  127     2   -7.92     -127 126  imp:n,p=1 $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 6) at 89.96679 cm level (height - 1.27 cm)
c   (lower section of CV flange)
c
  132     0             -132 #1   imp:n,p=1 $ cv void
  133     2   -7.92     -133 132  imp:n,p=1 $ cv void+ss
  134     3   -1.20     -134 133  imp:n,p=1 $ cv void+ss+rubber
  135     0             -135 134  imp:n,p=1 $ cv void+ss+rubber+void
  136     2   -7.92     -136 135  imp:n,p=1 $ cv void+ss+rubber+void+liner
  137     4   -0.321    -137 136  imp:n,p=1 $ cv void+ss+rubber+void+liner+kaolite
  138     2   -7.92     -138 137  imp:n,p=1 $ cv +void+ss+rubber+void+liner+kaolite+drum
c
c   CV (section 7) at 91.23679 cm level (height - 2.921 cm)
c   (middle section of CV flange)
c
  141     2   -7.92     -141 #1   imp:n,p=1 $ ss
  142     3   -1.20     -142 141  imp:n,p=1 $ ss+rubber
  143     0             -143 142  imp:n,p=1 $ ss+rubber+void
  144     2   -7.92     -144 143  imp:n,p=1 $ ss+rubber+void+liner
  145     4   -0.321    -145 144  imp:n,p=1 $ ss+rubber+void+liner+kaolite
  146     2   -7.92     -146 145  imp:n,p=1 $ ss+rubber+void+liner+kaolite+drum
c
c   CV (section 8) at 94.15779 cm level (height - 0.762 cm)
c   (top section of CV flange)
c
  151     3   -1.20     -151      imp:n,p=1 $ rubber
  152     0             -152 151  imp:n,p=1 $ rubber+void
  153     2   -7.92     -153 152  imp:n,p=1 $ rubber+void+liner
  154     4   -0.321    -154 153  imp:n,p=1 $ rubber+void+liner+kaolite
  155     2   -7.92     -155 154  imp:n,p=1 $ rubber+void+liner+kaolite+drum
c
c   Top of CV (section 1) at 94.91979 cm level (height - 0.254 cm)
c
  161     0             -161      imp:n,p=1 $ void
  162     2   -7.92     -162 161  imp:n,p=1 $ void+liner
  163     4   -0.321    -163 162  imp:n,p=1 $ void+liner+kaolite
  164     2   -7.92     -164 163  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Top of CV (section 2) at 95.17379 cm level (height - 0.1524 cm)
```

```
c
  171     0             -171      imp:n,p=1 $ void
  172     2   -7.92     -172 171  imp:n,p=1 $ void+liner
  173     4   -0.321    -173 172  imp:n,p=1 $ void+liner+kaolite
  174     2   -7.92     -174 173  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Top of CV (section 3) at 95.32619 cm level (height - 0.34036 cm)
c
  181     0             -181      imp:n,p=1 $ void
  182     2   -7.92     -182 181  imp:n,p=1 $ void+liner
  183     4   -0.321    -183 182  imp:n,p=1 $ void+liner+kaolite
  184     2   -7.92     -184 183  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Kaolite plug bottom ss  at 95.66655 cm level (height - 0.1524 cm)
c
  191     2   -7.92     -191      imp:n,p=1 $ ss (liner)
  192     0             -192 191  imp:n,p=1 $ ss+void
  193     2   -7.92     -193 192  imp:n,p=1 $ ss+void+liner
  194     4   -0.321    -194 193  imp:n,p=1 $ ss+void+liner+kaolite
  195     2   -7.92     -195 194  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Kaolite top plug bottom section  at 95.81895 cm level (height - 7.68604 cm)
c
  201     4   -0.321    -201      imp:n,p=1 $ kaolite
  202     2   -7.92     -202 201  imp:n,p=1 $ kaolite+liner
  203     0             -203 202  imp:n,p=1 $ kaolite+liner+void
  204     2   -7.92     -204 203  imp:n,p=1 $ kaolite+liner+void+liner
  205     4   -0.321    -205 204  imp:n,p=1 $ kaolite+liner+void+liner+kaolite
  206     2   -7.92     -206 205  imp:n,p=1 $ kaolite+liner+void+liner+kaolite+drum
c
c   Kaolite top plug (iron angle bottom section) at 103.50499 cm level (height - 4.4450 cm)
c
  211     4   -0.321    -211      imp:n,p=1 $ kaolite
  212     2   -7.92     -212 211  imp:n,p=1 $ kaolite+liner
  213     0             -213 212  imp:n,p=1 $ kaolite+liner+void
  214     2   -7.92     -214 213  imp:n,p=1 $ kaolite+liner+void+liner
  215     2   -7.92     -215 214  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle
  216     4   -0.321    -216 215  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle+kaolite
  217     2   -7.92     -217 216  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle+kaolite+drum
c
c   Kaolite top plug (iron angle top section) at 107.94999 cm level (height - 0.1118 cm)
c
  221     4   -0.321    -221      imp:n,p=1 $ kaolite
  222     2   -7.92     -222 221  imp:n,p=1 $ kaolite+liner
  223     0             -223 222  imp:n,p=1 $ kaolite+liner+void
  224     2   -7.92     -224 223  imp:n,p=1 $ kaolite+liner+void+liner
  225     2   -7.92     -225 224  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle
  226     2   -7.92     -226 225  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle+drum
c
c   Kaolite top plug (iron angle top section) at 108.06175 cm level (height - 0.1524 cm)
c
  231     2   -7.92     -231      imp:n,p=1 $ liner
  232     0             -232 231  imp:n,p=1 $ liner+void
  233     2   -7.92     -233 232  imp:n,p=1 $ liner+void+liner
  234     2   -7.92     -234 233  imp:n,p=1 $ liner+void+liner+iron-angle
  235     2   -7.92     -235 234  imp:n,p=1 $ liner+void+liner+iron-angle+drum
c
c   Gap above Kaolite top plug at 108.21415 cm level (height - 0.37084 cm)
c
  241     0             -241      imp:n,p=1 $ liner+void
  242     2   -7.92     -242 241  imp:n,p=1 $ liner+void+liner
```

```
  243     2   -7.92     -243 242  imp:n,p=1 $ liner+void+liner+iron-angle
  244     2   -7.92     -244 243  imp:n,p=1 $ liner+void+liner+iron-angle+drum
c
c   Top ss lid at 108.58499 cm level (height - 0.1524 cm)
c
  251     2   -7.92     -251      imp:n,p=1 $ ss lid
  252     0             -252 251  imp:n,p=1 $ ss lid+void
  253     2   -7.92     -253 252  imp:n,p=1 $ ss lid+void+drum
c
c   Top ss lid at 108.73739 cm level (height - 1.7526 cm)
c
  261     0             -261 #502      imp:n,p=1 $ void
  262     2   -7.92     -262 261  imp:n,p=1 $ void+ss lid
  263     0             -263 262  imp:n,p=1 $ void+ss lid+void
  264     2   -7.92     -264 263  imp:n,p=1 $ void+ss lid+void+drum
c
c   Put volume source for top and bottom detectors
c
  501     0             -501      imp:n,p=1 $ bottom surface detector
  502     0             -502      imp:n,p=1 $ top surface detector
  551     0             -551      imp:n,p=1 $ 1 m from bottom surface - detector
  552     0             -552      imp:n,p=1 $ 1 m from top surface - detector
c
  998     0             -999      51 62 73 87 97 111 117 127 138 146 155
                                  164 174 184 195 206 217 226 235 244 253
                                  264 501 502 551 552
                                  imp:n,p=1 $ inside boundary
  999     0              999      imp:n,p=0 $ outside world

c    ------------------
c    Surface Cards
c    ------------------
c
    1  rcc  0.0 0.0 76.13649   0.0 0.0  15.1003  6.35 $ cylinder source top of cv
c
c   drum bottom - at 0.0 cm level (height - 0.2667 cm)
c
   51  rcc  0.0 0.0  0.0     0.0 0.0 0.2667   23.3299  $ drum bottom
c
c   bottom kaolite - at 0.2667 cm level (height - 10.8585 cm)
c
   61  rcc  0.0 0.0  0.2667  0.0 0.0 10.8585  23.1775  $ bottom kaolite
   62  rcc  0.0 0.0  0.2667  0.0 0.0 10.8585  23.3299  $ bottom kaolite+drum
c
c   bottom inner liner - at 11.1252 cm level (height - 0.3048 cm)
c
   71  rcc  0.0 0.0 11.1252  0.0 0.0  0.3048  11.0744  $ bottom liner
   72  rcc  0.0 0.0 11.1252  0.0 0.0  0.3048  23.1775  $ bottom liner+kaolite
   73  rcc  0.0 0.0 11.1252  0.0 0.0  0.3048  23.3299  $ bottom liner+kaolite+drum
c
c   bottom rubber pad - at 11.4300 cm level (height - 0.4318 cm)
c
   81  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318    3.1750  $ void
   82  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318    7.9248  $ void+pad
   83  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318    8.0772  $ void+pad+liner
   84  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   10.9220  $ void+pad+liner+277-4
   85  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   11.0744  $ void+pad+liner+277-4+liner
   86  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   23.1775  $ void+pad+liner+277-4+liner+kaolite
   87  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   23.3299  $
void+pad+liner+277-4+liner+kaolite+drum
c
```

```
c   CV bottom (section 1) - at 11.8618 cm level (height - 0.6350 cm)
c
   91  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350    6.6802  $ cv bottom
   92  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350    7.9248  $ cv bottom+void
   93  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350    8.0772  $ cv bottom+void+liner
   94  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   10.9220  $ cv bottom+void+liner+277-4
   95  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   11.0744  $ cv bottom+void+liner+277-4+liner
   96  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   23.1775  $ cv
bottom+void+liner+277-4+liner+kaolite
   97  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   23.3299  $ cv
bottom+void+liner+277-4+liner+kaolite+drum
c
c   CV (section 2) at 12.4968 cm level (height - 77.08899 cm)
c
  101  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  6.4262  $ cv void
  102  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  6.6802  $ cv void+ss
  103  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  7.9248  $ cv void+ss+void
  104  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  8.0772  $ cv void+ss+void+liner
  105  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 10.9220  $ cv void+ss+void+liner+277-4
  106  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 11.0744  $ cv void+ss+void+liner+277-4+liner
  107  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 23.1775  $ cv
void+ss+void+liner+277-4+liner+kaolite
  108  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 23.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum
  109  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 24.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1
  110  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 123.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp
  111  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 124.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp+dt2
c
c   CV (section 3) at 89.58579 cm level (height - 0.1524 cm)
c   (ss liner top of sillicone rubber)
c
  112  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524  6.4262  $ cv void
  113  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524  6.6802  $ cv void+ss
  114  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524  7.9248  $ cv void+ss+void
  115  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524 11.0744  $ cv void+ss+void+liner
  116  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524 23.1775  $ cv void+ss+void+liner+kaolite
  117  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524 23.3299  $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 5) at 89.73819 cm level (height - 0.2286 cm)
c   (gap between Cat 277-4 & CV top section)
c
  122  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286  6.4262  $ cv void
  123  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286  6.6802  $ cv void+ss
  124  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 10.9220  $ cv void+ss+void
  125  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 11.0744  $ cv void+ss+void+liner
  126  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 23.1775  $ cv void+ss+void+liner+kaolite
  127  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 23.3299  $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 6) at 89.96679 cm level (height - 1.27 cm)
c   (lower section of CV flange)
c
  132  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700  6.4262  $ cv void
  133  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700  9.5250  $ cv void+ss
  134  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 10.0330  $ cv void+ss+rubber
  135  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 10.9220  $ cv void+ss+rubber+void
  136  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 11.0744  $ cv void+ss+rubber+void+liner
  137  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 23.1775  $ cv void+ss+rubber+void+liner+kaolite
```

```
  138  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 23.3299  $ cv
void+ss+rubber+void+liner+kaolite+drum
c
c   CV (section 7) at 91.23679 cm level (height - 2.921 cm)
c   (lower section of CV flange)
c
  141  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210  9.5250  $ ss
  142  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 10.0330  $ ss+rubber
  143  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 10.9220  $ ss+rubber+void
  144  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 11.0744  $ ss+rubber+void+liner
  145  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 23.1775  $ ss+rubber+void+liner+kaolite
  146  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 23.3299  $ ss+rubber+void+liner+kaolite+drum
c
c   CV (section 8) at 94.15779 cm level (height - 0.762 cm)
c   (top section of CV flange)
c
  151  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 10.0330  $ rubber
  152  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 10.9220  $ rubber+void
  153  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 11.0744  $ rubber+void+liner
  154  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 23.1775  $ rubber+void+liner+kaolite
  155  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 23.3299  $ rubber+void+liner+kaolite+drum
c
c   Top of CV (section 1) at 94.91979 cm level (height - 0.254 cm)
c
  161  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 10.9220  $ void
  162  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 11.0744  $ void+liner
  163  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 23.1775  $ void+liner+kaolite
  164  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 23.3299  $ void+liner+kaolite+drum
c
c   Top of CV (section 2) at 95.17379 cm level (height - 0.1524 cm)
c
  171  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 10.9220  $ void
  172  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 18.7579  $ void+liner
  173  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 23.1775  $ void+liner+kaolite
  174  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 23.3299  $ void+liner+kaolite+drum
c
c   Top of CV (section 3) at 95.32619 cm level (height - 0.34036 cm)
c
  181  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 18.6055  $ void
  182  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 18.7579  $ void+liner
  183  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 23.1775  $ void+liner+kaolite
  184  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 23.3299  $ void+liner+kaolite+drum
c
c   Kaolite plug bottom ss  at 95.66655 cm level (height - 0.1524 cm)
c
  191  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 18.2499   $ ss (liner)
  192  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 18.6055   $ ss+void
  193  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 18.7579   $ ss+void+liner
  194  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 23.1775   $ ss+void+liner+kaolite
  195  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 23.3299   $ ss+void+liner+kaolite+drum
c
c   Kaolite top plug bottom section  at 95.81895 cm level (height - 7.68604 cm)
c
  201  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.0975  $ kaolite
  202  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.2499  $ kaolite +liner
  203  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.6055  $ kaolite+liner+void
  204  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.7579  $ kaolite+liner+void+liner
  205  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 23.1775  $ kaolite+liner+void+liner+kaolite
  206  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 23.3299  $
kaolite+liner+void+liner+kaolite+drum
c
```

```
c   Kaolite top plug (iron angle bottom section) at 103.50499 cm level (height - 4.4450 cm)
c
  211  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.0975  $ kaolite
  212  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.2499  $ kaolite +liner
  213  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.6055  $ kaolite+liner+void
  214  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.7579  $ kaolite+liner+void+liner
  215  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  19.3929  $ kaolite+liner+void+liner+iron-angle
  216  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  23.1775  $
kaolite+liner+void+liner+iron-angle+kaolite
  217  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  23.3299  $
kaolite+liner+void+liner+iron-angle+kaolite+drum
c
c   Kaolite top plug (iron angle top section) at 107.94999 cm level (height - 0.1118 cm)
c
  221  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.0975  $ kaolite
  222  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.2499  $ kaolite +liner
  223  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.6055  $ kaolite+liner+void
  224  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.7579  $ kaolite+liner+void+liner
  225  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  23.1775  $ kaolite+liner+void+liner+iron-angle
  226  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  23.3299  $
kaolite+liner+void+liner+iron-angle+drum
c
c   Kaolite top plug (iron angle top section) at 108.06175 cm level (height - 0.1524 cm)
c
  231  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  18.2499  $ ss liner
  232  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  18.6055  $ ss liner+void
  233  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  18.7579  $ ss liner+void+liner
  234  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  23.1775  $ ss liner+void+liner+iron-angle
  235  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  23.3299  $ ss liner+void+liner+iron-angle+drum
c
c   Gap above Kaolite top plug at 108.21415 cm level (height - 0.37084 cm)
c
  241  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  18.6055  $ void
  242  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  18.7579  $ void+liner
  243  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  23.1775  $ void+liner+iron-angle
  244  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  23.3299  $ void+liner+iron-angle+drum
c
c   Top ss lid at 108.58499 cm level (height - 0.1524 cm)
c
  251  rcc 0.0 0.0 108.58499  0.0 0.0  0.1524  23.1140  $ ss lid
  252  rcc 0.0 0.0 108.58499  0.0 0.0  0.1524  23.1775  $ ss lid+void
  253  rcc 0.0 0.0 108.58499  0.0 0.0  0.1524  23.3299  $ ss lid+void+drum
c
c   Top ss lid at 108.73739 cm level (height - 1.7526 cm)
c
  261  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  22.9616  $ void
  262  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  23.1140  $ void+ss lid
  263  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  23.1775  $ void+ss lid+void
  264  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  23.3299  $ void+ss lid+void+drum
c
c   Segmented side volume detectors
c
  301  pz 13
  302  pz 14
  303  pz 15
  304  pz 16
  305  pz 17
  306  pz 18
  307  pz 19
  308  pz 20
  309  pz 21
```

```
310  pz 22
311  pz 23
312  pz 24
313  pz 25
314  pz 26
315  pz 27
316  pz 28
317  pz 29
318  pz 30
319  pz 31
320  pz 32
321  pz 33
322  pz 34
323  pz 35
324  pz 36
325  pz 37
326  pz 38
327  pz 39
328  pz 40
329  pz 41
330  pz 42
331  pz 43
332  pz 44
333  pz 45
334  pz 46
335  pz 47
336  pz 48
337  pz 49
338  pz 50
339  pz 51
340  pz 52
341  pz 53
342  pz 54
343  pz 55
344  pz 56
345  pz 57
346  pz 58
347  pz 59
348  pz 60
349  pz 61
350  pz 62
351  pz 63
352  pz 64
353  pz 65
354  pz 66
355  pz 67
356  pz 68
357  pz 69
358  pz 70
359  pz 71
360  pz 72
361  pz 73
362  pz 74
363  pz 75
364  pz 76
365  pz 77
366  pz 78
367  pz 79
368  pz 80
369  pz 81
370  pz 82
```

```
  371  pz 83
  372  pz 84
  373  pz 85
  374  pz 86
  375  pz 87
  376  pz 88
  377  pz 89
c
c   Put volume source for top and bottom detectors
c
  501  rcc 0.0 0.0 -0.5  0.0 0.0  0.5  1.0          $ bottom surface vol detector
  502  rcc 0.0 0.0 108.73739  0.0 0.0  0.5  1.0     $ top surface vol detector
  551  rcc 0.0 0.0 -100.5  0.0 0.0  0.5  1.0        $ 1 m from bottom surface - vol detector
  552  rcc 0.0 0.0 208.73739  0.0 0.0  0.5  1.0     $ 1 m from top surface - vol detector
c
  999  sph  0.0 0.0  0.000  999.0                         $ boundary
c

c    ----------------------
c    Data Cards
c    ----------------------
mode  n p
c
c      uranium metal (18.82 g/cc)
c
m1    92235.70c  -0.9500    $ U-235           95.0000  wt%
      92238.70c  -0.0500    $ U-238            5.0000  wt%
c
c      ss 304 (7.92 g/cc)
c
m2     6000.70c  -0.00080    $ Carbon(C)        0.0800  wt%
      14028.70c  -0.00919    $ Silicon(Si-28)   0.9187  wt%
      14029.70c  -0.00048    $ Si-29            0.0483  wt%
      14030.70c  -0.00033    $ Si-30            0.0330  wt%
      15031.70c  -0.00045    $ Phosphorus(P)    0.0450  wt%
      24050.70c  -0.00793    $ Cromium (Cr-50)  0.7930  wt%
      24052.70c  -0.15903    $ Cr-52           15.9029  wt%
      24053.70c  -0.01838    $ Cr-53            1.8380  wt%
      24054.70c  -0.00466    $ Cr-54            0.4661  wt%
      25055.70c  -0.02000    $ Manganese (Mn)   2.0000  wt%
      26054.70c  -0.03860    $ Iron (Fe-54)     3.8602  wt%
      26056.70c  -0.62838    $ Fe-56           62.8377  wt%
      26057.70c  -0.01477    $ Fe-57            1.4772  wt%
      26058.70c  -0.00200    $ Fe-58            0.2000  wt%
      28058.70c  -0.06384    $ Nickel (Ni-58)   6.3838  wt%
      28060.70c  -0.02544    $ Ni-60            2.5437  wt%
      28061.70c  -0.00112    $ Ni-61            0.1124  wt%
      28062.70c  -0.00364    $ Ni-62            0.3643  wt%
      28064.70c  -0.00096    $ Ni-64            0.0958  wt%
c
c      rubber foam (1.20 g/cc)
c
m3     1001.70c  -0.08157    $ Hydrogen (H)     8.1573 wt%
       6000.70c  -0.32377    $ Carbon (C)      32.3767 wt%
       8016.70c  -0.21520    $ Oxygen (O-16)   21.5196 wt%
       8017.70c  -0.00059    $ O-17 & O-18      0.0586 wt%
      14028.70c  -0.34806    $ Silicon(Si-28)  34.8061 wt%
      14029.70c  -0.01831    $ Si-29            1.8314 wt%
      14030.70c  -0.01250    $ Si-30            1.2503 wt%
c
c      kaolite (0.321 g/cc)
```

```
c
m4     8016.70c -0.4092    $ Oxygen (O-16)   40.9231 wt%
       8017.70c -0.0011    $ Oxygen (17&18)   0.1114 wt%
      11023.70c -0.0148    $ Sodium (Na)      1.4837 wt%
      12024.70c -0.0616    $ Magnesium (Mg-24)6.1579 wt%
      12025.70c -0.0081    $ Mg-25            0.8121 wt%
      12026.70c -0.0093    $ Mg-26            0.9298 wt%
      13027.70c -0.0508    $ Al               5.0808 wt%
      14028.70c -0.1576    $ Silicon (Si-28) 15.7596 wt%
      14029.70c -0.0083    $ Si-29            0.8292 wt%
      14030.70c -0.0057    $ Si-30            0.5661 wt%
      20040.70c -0.2121    $ Calcium (Ca-40) 21.2086 wt%
      20042.70c -0.0015    $ Ca-42            0.1490 wt%
      20043.70c -0.0003    $ Ca-43            0.0318 wt%
      20044.70c -0.0050    $ Ca-44            0.5031 wt%
      20046.70c -0.00001   $ Ca-46            0.0010 wt%
      20048.70c -0.0005    $ Ca-48            0.0491 wt%
      22046.70c -0.0006    $ Titanium (Ti-46) 0.0570 wt%
      22047.70c -0.0005    $ Ti-47            0.0525 wt%
      22048.70c -0.0053    $ Ti-48            0.5311 wt%
      22049.70c -0.0004    $ Ti-49            0.0398 wt%
      22050.70c -0.0004    $ Ti-50            0.0407 wt%
      26054.70c -0.0026    $ Iron (Fe-54)     0.2646 wt%
      26056.70c -0.0431    $ Fe-56            4.3066 wt%
      26057.70c -0.0010    $ Fe-57            0.1012 wt%
      26058.70c -0.0001    $ Fe-58            0.0137 wt%
c
c      Cat 277-4 (1.4586 g/cc)
c
m5     1001.70c -0.0285    $ Hydrogen         2.8475 wt%
       5010.70c -0.0066    $ Boron (B-10)     0.6591 wt%
       5011.70c -0.0297    $ Boron (B-11)     2.9726 wt%
       6000.70c -0.0136    $ Carbon (C)       1.3609 wt%
       7014.70c -0.0001    $ Nitrogen (N)     0.0100 wt%
       8016.70c -0.5325    $ Oxygen (O-16)   53.2515 wt%
       8017.70c -0.0015    $ Oxygen (17&18)   0.1450 wt%
      11023.70c -0.0008    $ Sodium (Na)      0.0833 wt%
      12024.70c -0.0019    $ Magnesium (Mg-24)0.1867 wt%
      12025.70c -0.0002    $ Mg-25            0.0246 wt%
      12026.70c -0.0003    $ Mg-26            0.0282 wt%
      13027.70c -0.2769    $ Al              27.6937 wt%
      14028.70c -0.0161    $ Silicon (Si-28)  1.6075 wt%
      14029.70c -0.0008    $ Si-29            0.0846 wt%
      14030.70c -0.0006    $ Si-30            0.0577 wt%
      16032.70c -0.0021    $ Sulfur (S-32)    0.2071 wt%
      16033.70c -0.00002   $ S-33             0.0017 wt%
      16034.70c -0.0001    $ S-34             0.0098 wt%
      16036.70c -0.0000002 $ S-36             0.00002 wt%
      20040.70c -0.0811    $ Calcium (Ca-40)  8.1125 wt%
      20042.70c -0.0006    $ Ca-42            0.0569 wt%
      20043.70c -0.0001    $ Ca-43            0.0121 wt%
      20044.70c -0.0019    $ Ca-44            0.1920 wt%
      20046.70c -0.000004  $ Ca-46            0.0004 wt%
      20048.70c -0.0002    $ Ca-48            0.0188 wt%
      26054.70c -0.0002    $ Iron (Fe-54)     0.0212 wt%
      26056.70c -0.0035    $ Fe-56            0.3453 wt%
      26057.70c -0.00008   $ Fe-57            0.0081 wt%
      26058.70c -0.00001   $ Fe-58            0.0011 wt%
c
c       air (1.225e-3 g/cc)
c
```

```
m6      7014.70c  -0.755   $ Nitrogen (N-14) 75.5000 wt%
        8016.70c  -0.232   $ Oxygen (O-16)   23.2000 wt%
       18000.70c  -0.013   $ Argon (Ar-40)    1.3000 wt%
c
c    source in ES-3100 - cylindrical shape at the top of CV
c                        (H = 15.1003 cm; R = 6.35 cm)
c
c   neutron source - 2.129e-01 neutrons/sec/gm basis
c   material used - 36 kg HEU
c   dose conversion factor (mrem/hr)/(neutrons/cm2-s) used
c   source term, wgt = 2.129e-01 * 36.0e+03  = 7.6644e+03
c
sdef pos=0 0 76.13649 rad=d1 ext=d2  erg=d3 axs=0 0 1 wgt=7.6644e+03
c
c  source position
c
si1    0.0      6.35         $ radial
sp1    -21       1
si2    0.0     15.1003       $ axial
sp2     0        1
c
c  ORIGEN neutron spectrum
c
si3     5.83e-04     3.04e-03    1.50e-02     1.11e-01    4.08e-01
        9.07e-01     1.42e+00    1.83e+00     3.01e+00    6.38e+00    20.00e+00
c
sp3     0.0          7.034e-06   8.280e-05    1.790e-03   8.973e-03
        1.572e-02    2.205e-02   2.510e-02    1.042e-01   3.430e-02    7.260e-04
c
fq0 f s d
c
c  volume detector for neutron at the bottom surface of the drum
c
f4:n 501             $ bottom surface volume detector
f14:n 502            $ top surface volume detector
f24:n 551            $ 1 m from bottom surface  - volume detector
f34:n 552            $ 1 m from top surface  - volume detector
c
c  segmented volume detectors for neutrons
c
c  side surface
c
f114:n 109
fs114  -301 -302 -303 -304 -305 -306 -307 -308 -309 -310
       -311 -312 -313 -314 -315 -316 -317 -318 -319 -320
       -321 -322 -323 -324 -325 -326 -327 -328 -329 -330
       -331 -332 -333 -334 -335 -336 -337 -338 -339 -340
       -341 -342 -343 -344 -345 -346 -347 -348 -349 -350
       -351 -352 -353 -354 -355 -356 -357 -358 -359 -360
       -361 -362 -363 -364 -365 -366 -367 -368 -369 -370
       -371 -372 -373 -374 -375 -376 -377
c
c  1 m from side surface
c
f134:n  111
fs134  -301 -302 -303 -304 -305 -306 -307 -308 -309 -310
       -311 -312 -313 -314 -315 -316 -317 -318 -319 -320
       -321 -322 -323 -324 -325 -326 -327 -328 -329 -330
       -331 -332 -333 -334 -335 -336 -337 -338 -339 -340
       -341 -342 -343 -344 -345 -346 -347 -348 -349 -350
       -351 -352 -353 -354 -355 -356 -357 -358 -359 -360
```

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       -361 -362 -363 -364 -365 -366 -367 -368 -369 -370
       -371 -372 -373 -374 -375 -376 -377
c
c  point detectors for neutrons
c
f5:n    23.4299  0.0     83.68664  0.0     $ side surface - detector
f15:n    0.0     0.0    108.83739  0.0     $ top surface - detector
f25:n    0.0     0.0     -0.1      0.0     $ bottom surface - detector
f35:n  123.3299  0.0     83.68664  0.0     $ 1m from side surface - detector
f45:n    0.0     0.0    208.73739  0.0     $ 1m from top surface - detector
f55:n    0.0     0.0   -100.0      0.0     $ 1m from bottom surface - detector
c
c ANSI/ANS-6.1.1-1977 neutron flux to dose rate conversion factor
c                                  (mrem/hr)/(neutrons/cm2-s)
c
de0      2.5e-08   1.0e-07   1.0e-06   1.0e-05   1.0e-04   1.0e-3    1.0e-02
         1.0e-01   5.0e-01   1.0       2.5       5.0       7.0       10.0
         14.0      20.0
c
df0      3.67e-03  3.67e-03  4.46e-03  4.54e-03  4.18e-03  3.76e-03  3.56e-03
         2.17e-02  9.26e-02  1.32e-01  1.25e-01  1.56e-01  1.47e-01  1.47e-01
         2.08e-01  2.27e-01
c
c  point detectors for secondary photons
c
f505:p   23.4299  0.0     83.68664  0.0     $ side surface - detector
f515:p    0.0     0.0    108.83739  0.0     $ top surface - detector
f525:p    0.0     0.0     -0.1      0.0     $ bottom surface - detector
f535:p  123.3299  0.0     83.68664  0.0     $ 1m from side surface - detector
f545:p    0.0     0.0    208.73739  0.0     $ 1m from top surface - detector
f555:p    0.0     0.0   -100.0      0.0     $ 1m from bottom surface - detector
c
c ANSI/ANS-6.1.1-1977 photon flux to dose rate conversion factor
c                                  (mrem/hr)/(photons/cm2-s)
c
de505       0.01      0.03      0.05      0.07       0.1      0.15      0.20
            0.25      0.30      0.35      0.40       0.45     0.50      0.55
            0.60      0.65      0.70      0.8        1.0      1.4       1.8
            2.2       2.6       2.8       3.25       3.75     4.25      4.75
            5.00      5.25      5.75      6.25       6.75     7.50      9.0
           11.0      13.0      15.0
c
df505    3.96e-3   5.82e-4   2.90e-4   2.58e-4   2.83e-4   3.79e-4   5.01e-4
         6.31e-4   7.59e-4   8.78e-4   9.85e-4   1.08e-3   1.17e-3   1.27e-3
         1.36e-3   1.44e-3   1.52e-3   1.68e-3   1.98e-3   2.51e-3   2.99e-3
         3.42e-3   3.82e-3   4.01e-3   4.41e-3   4.83e-3   5.23e-3   5.60e-3
         5.80e-3   6.01e-3   6.37e-3   6.74e-3   7.11e-3   7.66e-3   8.77e-3
         1.03e-2   1.18e-2   1.33e-2
c
de515       0.01      0.03      0.05      0.07       0.1      0.15      0.20
            0.25      0.30      0.35      0.40       0.45     0.50      0.55
            0.60      0.65      0.70      0.8        1.0      1.4       1.8
            2.2       2.6       2.8       3.25       3.75     4.25      4.75
            5.00      5.25      5.75      6.25       6.75     7.50      9.0
           11.0      13.0      15.0
c
df515    3.96e-3   5.82e-4   2.90e-4   2.58e-4   2.83e-4   3.79e-4   5.01e-4
         6.31e-4   7.59e-4   8.78e-4   9.85e-4   1.08e-3   1.17e-3   1.27e-3
         1.36e-3   1.44e-3   1.52e-3   1.68e-3   1.98e-3   2.51e-3   2.99e-3
         3.42e-3   3.82e-3   4.01e-3   4.41e-3   4.83e-3   5.23e-3   5.60e-3
         5.80e-3   6.01e-3   6.37e-3   6.74e-3   7.11e-3   7.66e-3   8.77e-3
```

```
         1.03e-2   1.18e-2   1.33e-2
c
de525       0.01      0.03      0.05      0.07       0.1      0.15      0.20
            0.25      0.30      0.35      0.40      0.45      0.50      0.55
            0.60      0.65      0.70       0.8       1.0       1.4       1.8
             2.2       2.6       2.8      3.25      3.75      4.25      4.75
            5.00      5.25      5.75      6.25      6.75      7.50       9.0
            11.0      13.0      15.0
c
df525    3.96e-3   5.82e-4   2.90e-4   2.58e-4   2.83e-4   3.79e-4   5.01e-4
         6.31e-4   7.59e-4   8.78e-4   9.85e-4   1.08e-3   1.17e-3   1.27e-3
         1.36e-3   1.44e-3   1.52e-3   1.68e-3   1.98e-3   2.51e-3   2.99e-3
         3.42e-3   3.82e-3   4.01e-3   4.41e-3   4.83e-3   5.23e-3   5.60e-3
         5.80e-3   6.01e-3   6.37e-3   6.74e-3   7.11e-3   7.66e-3   8.77e-3
         1.03e-2   1.18e-2   1.33e-2
c
de535       0.01      0.03      0.05      0.07       0.1      0.15      0.20
            0.25      0.30      0.35      0.40      0.45      0.50      0.55
            0.60      0.65      0.70       0.8       1.0       1.4       1.8
             2.2       2.6       2.8      3.25      3.75      4.25      4.75
            5.00      5.25      5.75      6.25      6.75      7.50       9.0
            11.0      13.0      15.0
c
df535    3.96e-3   5.82e-4   2.90e-4   2.58e-4   2.83e-4   3.79e-4   5.01e-4
         6.31e-4   7.59e-4   8.78e-4   9.85e-4   1.08e-3   1.17e-3   1.27e-3
         1.36e-3   1.44e-3   1.52e-3   1.68e-3   1.98e-3   2.51e-3   2.99e-3
         3.42e-3   3.82e-3   4.01e-3   4.41e-3   4.83e-3   5.23e-3   5.60e-3
         5.80e-3   6.01e-3   6.37e-3   6.74e-3   7.11e-3   7.66e-3   8.77e-3
         1.03e-2   1.18e-2   1.33e-2
c
de545       0.01      0.03      0.05      0.07       0.1      0.15      0.20
            0.25      0.30      0.35      0.40      0.45      0.50      0.55
            0.60      0.65      0.70       0.8       1.0       1.4       1.8
             2.2       2.6       2.8      3.25      3.75      4.25      4.75
            5.00      5.25      5.75      6.25      6.75      7.50       9.0
            11.0      13.0      15.0
c
df545    3.96e-3   5.82e-4   2.90e-4   2.58e-4   2.83e-4   3.79e-4   5.01e-4
         6.31e-4   7.59e-4   8.78e-4   9.85e-4   1.08e-3   1.17e-3   1.27e-3
         1.36e-3   1.44e-3   1.52e-3   1.68e-3   1.98e-3   2.51e-3   2.99e-3
         3.42e-3   3.82e-3   4.01e-3   4.41e-3   4.83e-3   5.23e-3   5.60e-3
         5.80e-3   6.01e-3   6.37e-3   6.74e-3   7.11e-3   7.66e-3   8.77e-3
         1.03e-2   1.18e-2   1.33e-2
c
de555       0.01      0.03      0.05      0.07       0.1      0.15      0.20
            0.25      0.30      0.35      0.40      0.45      0.50      0.55
            0.60      0.65      0.70       0.8       1.0       1.4       1.8
             2.2       2.6       2.8      3.25      3.75      4.25      4.75
            5.00      5.25      5.75      6.25      6.75      7.50       9.0
            11.0      13.0      15.0
c
df555    3.96e-3   5.82e-4   2.90e-4   2.58e-4   2.83e-4   3.79e-4   5.01e-4
         6.31e-4   7.59e-4   8.78e-4   9.85e-4   1.08e-3   1.17e-3   1.27e-3
         1.36e-3   1.44e-3   1.52e-3   1.68e-3   1.98e-3   2.51e-3   2.99e-3
         3.42e-3   3.82e-3   4.01e-3   4.41e-3   4.83e-3   5.23e-3   5.60e-3
         5.80e-3   6.01e-3   6.37e-3   6.74e-3   7.11e-3   7.66e-3   8.77e-3
         1.03e-2   1.18e-2   1.33e-2
c
prdmp  j  10000000 0 10
ctme 2000
```

5.5.2.4 HAC for 36-kg uranium metal neutron and secondary photon side dose-rate calculations (cylindrical hemi-shell configuration source moved towards x-axis in CV)

```
neutron_hemishell.inp - ES-3100: 2015 HEU detailed model
c                 (neutrons & sec photons)
c                 U-metal case (76.2 cm ht cylindrical hemishell
c                 density = 18.82 g/cc; IR=4.9337 cm; OR=6.35 cm)
c    configuration
c    (side dose rate calculations)
c    source in cylindrical hemishell form sitting at the bottom of CV for
c    side dose rate calculations for 2015 Revision
c
c    mcnp geometry model (CV and outside) is identical to criticality model
c    (KENO Model).
c    47 energy groups are used for the photon spectrum.  In the older version,
c    18 energy groups were used.
c    surface detectors are placed 0.1 cm and 100 cm way from the surfaces
c    and detectors are placed on the side, top, and bottom.
c    point detectors are used for dose rate calculations (used for results).
c    segmented volume detectors are used for side dose rate calculations (for checking).
c    volume detectors are used to check bottom and top dose rate calculations.
c    ANSI/ANS-6.1.1-1977 Dose conversion factors are used,
c    multiplied by 1000 to convert from rem to mrem
c
c   mode n p - (neutrons and secondary photons)
c
c    --------------
c     Cell Cards
c    --------------
c
    1     0             -1 401      imp:n,p=1 $ inner void
    2     1   -18.82    -2 1 401    imp:n,p=1 $ source shell
c
c   drum bottom - at 0.0 cm level (height - 0.2667 cm)
c
   51     2   -7.92     -51      imp:n,p=1 $ drum bottom
c
c   bottom kaolite - at 0.2667 cm level (height - 10.8585 cm)
c
   61     4   -0.321    -61      imp:n,p=1 $ bottom kaolite
   62     2   -7.92     -62 61   imp:n,p=1 $ bottom kaolite+drum
c
c   bottom inner liner - at 11.1252 cm level (height - 0.3048 cm)
c
   71     2   -7.92     -71      imp:n,p=1 $ bottom liner
   72     4   -0.321    -72 71   imp:n,p=1 $ bottom liner+kaolite
   73     2   -7.92     -73 72   imp:n,p=1 $ bottom liner+kaolite+drum
c
c   bottom rubber pad - at 11.4300 cm level (height - 0.4318 cm)
c
   81     0             -81      imp:n,p=1 $ void
   82     3   -1.2      -82 81   imp:n,p=1 $ void+pad
   83     2   -7.92     -83 82   imp:n,p=1 $ void+pad+liner
   84     5   -1.4586   -84 83   imp:n,p=1 $ void+pad+liner+277-4
   85     2   -7.92     -85 84   imp:n,p=1 $ void+pad+liner+277-4+liner
   86     4   -0.321    -86 85   imp:n,p=1 $ void+pad+liner+277-4+liner+kaolite
   87     2   -7.92     -87 86   imp:n,p=1 $ void+pad+liner+277-4+liner+kaolite+drum
c
c   CV bottom (section 1) - at 11.8618 cm level (height - 0.6350 cm)
c
   91     2   -7.92     -91      imp:n,p=1 $ cv bottom
```

```
   92     0             -92 91   imp:n,p=1 $ cv bottom+void
   93     2   -7.92     -93 92   imp:n,p=1 $ cv bottom+void+liner
   94     5   -1.4586   -94 93   imp:n,p=1 $ cv bottom+void+liner+277-4
   95     2   -7.92     -95 94   imp:n,p=1 $ cv bottom+void+liner+277-4+liner
   96     4   -0.321    -96 95   imp:n,p=1 $ cv bottom+void+liner+277-4+liner+kaolite
   97     2   -7.92     -97 96   imp:n,p=1 $ cv bottom+void+liner+277-4+liner+kaolite+drum
c
c   CV (section 2) at 12.4968 cm level (height - 77.08899 cm)
c
  101     0             -101 #1 #2  imp:n,p=1 $ cv void
  102     2   -7.92     -102 101  imp:n,p=1 $ cv void+ss
  103     0             -103 102  imp:n,p=1 $ cv void+ss+void
  104     2   -7.92     -104 103  imp:n,p=1 $ cv void+ss+void+liner
  105     5   -1.4586   -105 104  imp:n,p=1 $ cv void+ss+void+liner+277-4
  106     2   -7.92     -106 105  imp:n,p=1 $ cv void+ss+void+liner+277-4+liner
  107     4   -0.321    -107 106  imp:n,p=1 $ cv void+ss+void+liner+277-4+liner+kaolite
  108     2   -7.92     -108 107  imp:n,p=1 $ cv void+ss+void+liner+277-4+liner+kaolite+drum
  109     0             -109 108  imp:n,p=1 $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1
  110     0             -110 109  imp:n,p=1 $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp
  111     0             -111 110  imp:n,p=1 $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp+dt2
c
c   CV (section 3) at 89.5857 cm level (height - 0.1524 cm)
c   (ss liner top of sillicone rubber)
c
c 111     0             -111      imp:n,p=1 $ cv void (to be filled by content can)
  112     0             -112      imp:n,p=1 $ cv void
  113     2   -7.92     -113 112  imp:n,p=1 $ cv void+ss
  114     0             -114 113  imp:n,p=1 $ cv void+ss+void
  115     2   -7.92     -115 114  imp:n,p=1 $ cv void+ss+void+liner
  116     4   -0.321    -116 115  imp:n,p=1 $ cv void+ss+void+liner+kaolite
  117     2   -7.92     -117 116  imp:n,p=1 $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 4) at 89.73819 cm level (height - 0.2286 cm)
c   (gap between Cat 277-4 & CV top section)
c
  122     0             -122      imp:n,p=1 $ cv void
  123     2   -7.92     -123 122  imp:n,p=1 $ cv void+ss
  124     0             -124 123  imp:n,p=1 $ cv void+ss+void
  125     2   -7.92     -125 124  imp:n,p=1 $ cv void+ss+void+liner
  126     4   -0.321    -126 125  imp:n,p=1 $ cv void+ss+void+liner+kaolite
  127     2   -7.92     -127 126  imp:n,p=1 $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 6) at 89.96679 cm level (height - 1.27 cm)
c   (lower section of CV flange)
c
  132     0             -132      imp:n,p=1 $ cv void
  133     2   -7.92     -133 132  imp:n,p=1 $ cv void+ss
  134     3   -1.20     -134 133  imp:n,p=1 $ cv void+ss+rubber
  135     0             -135 134  imp:n,p=1 $ cv void+ss+rubber+void
  136     2   -7.92     -136 135  imp:n,p=1 $ cv void+ss+rubber+void+liner
  137     4   -0.321    -137 136  imp:n,p=1 $ cv void+ss+rubber+void+liner+kaolite
  138     2   -7.92     -138 137  imp:n,p=1 $ cv +void+ss+rubber+void+liner+kaolite+drum
c
c   CV (section 7) at 91.23679 cm level (height - 2.921 cm)
c   (middle section of CV flange)
c
  141     2   -7.92     -141      imp:n,p=1 $ ss
  142     3   -1.20     -142 141  imp:n,p=1 $ ss+rubber
```

```
  143     0             -143 142  imp:n,p=1 $ ss+rubber+void
  144     2   -7.92     -144 143  imp:n,p=1 $ ss+rubber+void+liner
  145     4   -0.321    -145 144  imp:n,p=1 $ ss+rubber+void+liner+kaolite
  146     2   -7.92     -146 145  imp:n,p=1 $ ss+rubber+void+liner+kaolite+drum
c
c   CV (section 8) at 94.15779 cm level (height - 0.762 cm)
c   (top section of CV flange)
c
  151     3   -1.20     -151      imp:n,p=1 $ rubber
  152     0             -152 151  imp:n,p=1 $ rubber+void
  153     2   -7.92     -153 152  imp:n,p=1 $ rubber+void+liner
  154     4   -0.321    -154 153  imp:n,p=1 $ rubber+void+liner+kaolite
  155     2   -7.92     -155 154  imp:n,p=1 $ rubber+void+liner+kaolite+drum
c
c   Top of CV (section 1) at 94.91979 cm level (height - 0.254 cm)
c
  161     0             -161      imp:n,p=1 $ void
  162     2   -7.92     -162 161  imp:n,p=1 $ void+liner
  163     4   -0.321    -163 162  imp:n,p=1 $ void+liner+kaolite
  164     2   -7.92     -164 163  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Top of CV (section 2) at 95.17379 cm level (height - 0.1524 cm)
c
  171     0             -171      imp:n,p=1 $ void
  172     2   -7.92     -172 171  imp:n,p=1 $ void+liner
  173     4   -0.321    -173 172  imp:n,p=1 $ void+liner+kaolite
  174     2   -7.92     -174 173  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Top of CV (section 3) at 95.32619 cm level (height - 0.34036 cm)
c
  181     0             -181      imp:n,p=1 $ void
  182     2   -7.92     -182 181  imp:n,p=1 $ void+liner
  183     4   -0.321    -183 182  imp:n,p=1 $ void+liner+kaolite
  184     2   -7.92     -184 183  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Kaolite plug bottom ss  at 95.66655 cm level (height - 0.1524 cm)
c
  191     2   -7.92     -191      imp:n,p=1 $ ss (liner)
  192     0             -192 191  imp:n,p=1 $ ss+void
  193     2   -7.92     -193 192  imp:n,p=1 $ ss+void+liner
  194     4   -0.321    -194 193  imp:n,p=1 $ ss+void+liner+kaolite
  195     2   -7.92     -195 194  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Kaolite top plug bottom section  at 95.81895 cm level (height - 7.68604 cm)
c
  201     4   -0.321    -201      imp:n,p=1 $ kaolite
  202     2   -7.92     -202 201  imp:n,p=1 $ kaolite+liner
  203     0             -203 202  imp:n,p=1 $ kaolite+liner+void
  204     2   -7.92     -204 203  imp:n,p=1 $ kaolite+liner+void+liner
  205     4   -0.321    -205 204  imp:n,p=1 $ kaolite+liner+void+liner+kaolite
  206     2   -7.92     -206 205  imp:n,p=1 $ kaolite+liner+void+liner+kaolite+drum
c
c   Kaolite top plug (iron angle bottom section) at 103.50499 cm level (height - 4.4450 cm)
c
  211     4   -0.321    -211      imp:n,p=1 $ kaolite
  212     2   -7.92     -212 211  imp:n,p=1 $ kaolite+liner
  213     0             -213 212  imp:n,p=1 $ kaolite+liner+void
  214     2   -7.92     -214 213  imp:n,p=1 $ kaolite+liner+void+liner
  215     2   -7.92     -215 214  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle
  216     4   -0.321    -216 215  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle+kaolite
  217     2   -7.92     -217 216  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle+kaolite+drum
```

```
c
c   Kaolite top plug (iron angle top section) at 107.94999 cm level (height - 0.1118 cm)
c
  221     4   -0.321    -221      imp:n,p=1 $ kaolite
  222     2   -7.92     -222 221  imp:n,p=1 $ kaolite+liner
  223     0             -223 222  imp:n,p=1 $ kaolite+liner+void
  224     2   -7.92     -224 223  imp:n,p=1 $ kaolite+liner+void+liner
  225     2   -7.92     -225 224  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle
  226     2   -7.92     -226 225  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle+drum
c
c   Kaolite top plug (iron angle top section) at 108.06175 cm level (height - 0.1524 cm)
c
  231     2   -7.92     -231      imp:n,p=1 $ liner
  232     0             -232 231  imp:n,p=1 $ liner+void
  233     2   -7.92     -233 232  imp:n,p=1 $ liner+void+liner
  234     2   -7.92     -234 233  imp:n,p=1 $ liner+void+liner+iron-angle
  235     2   -7.92     -235 234  imp:n,p=1 $ liner+void+liner+iron-angle+drum
c
c   Gap above Kaolite top plug at 108.21415 cm level (height - 0.37084 cm)
c
  241     0             -241      imp:n,p=1 $ liner+void
  242     2   -7.92     -242 241  imp:n,p=1 $ liner+void+liner
  243     2   -7.92     -243 242  imp:n,p=1 $ liner+void+liner+iron-angle
  244     2   -7.92     -244 243  imp:n,p=1 $ liner+void+liner+iron-angle+drum
c
c   Top ss lid at 108.58499 cm level (height - 0.1524 cm)
c
  251     2   -7.92     -251      imp:n,p=1 $ ss lid
  252     0             -252 251  imp:n,p=1 $ ss lid+void
  253     2   -7.92     -253 252  imp:n,p=1 $ ss lid+void+drum
c
c   Top ss lid at 108.73739 cm level (height - 1.7526 cm)
c
  261     0             -261 #502      imp:n,p=1 $ void
  262     2   -7.92     -262 261  imp:n,p=1 $ void+ss lid
  263     0             -263 262  imp:n,p=1 $ void+ss lid+void
  264     2   -7.92     -264 263  imp:n,p=1 $ void+ss lid+void+drum
c
c   Put volume source for top and bottom detectors
c
  501     0             -501      imp:n,p=1 $ bottom surface detector
  502     0             -502      imp:n,p=1 $ top surface detector
  551     0             -551      imp:n,p=1 $ 1 m from bottom surface - detector
  552     0             -552      imp:n,p=1 $ 1 m from top surface - detector
c
  998     0             -999      51 62 73 87 97 111 117 127 138 146 155
                                  164 174 184 195 206 217 226 235 244 253
                                  264 501 502 551 552
                                  imp:n,p=1 $ inside boundary
  999     0              999      imp:n,p=0 $ outside world

c    ------------------
c    Surface Cards
c    ------------------
c
    1  rcc  0.0 0.0 12.4968   0.0 0.0  76.20   4.9337  $ inner radius cylindrical shell source
    2  rcc  0.0 0.0 12.4968   0.0 0.0  76.20   6.35    $ outer radius cylindrical shell source
c
c   drum bottom - at 0.0 cm level (height - 0.2667 cm)
c
   51  rcc  0.0 0.0  0.0     0.0 0.0 0.2667   23.3299  $ drum bottom
```

```
c
c   bottom kaolite - at 0.2667 cm level (height - 10.8585 cm)
c
   61  rcc  0.0 0.0  0.2667  0.0 0.0 10.8585  23.1775  $ bottom kaolite
   62  rcc  0.0 0.0  0.2667  0.0 0.0 10.8585  23.3299  $ bottom kaolite+drum
c
c   bottom inner liner - at 11.1252 cm level (height - 0.3048 cm)
c
   71  rcc  0.0 0.0 11.1252  0.0 0.0  0.3048  11.0744  $ bottom liner
   72  rcc  0.0 0.0 11.1252  0.0 0.0  0.3048  23.1775  $ bottom liner+kaolite
   73  rcc  0.0 0.0 11.1252  0.0 0.0  0.3048  23.3299  $ bottom liner+kaolite+drum
c
c   bottom rubber pad - at 11.4300 cm level (height - 0.4318 cm)
c
   81  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318    3.1750  $ void
   82  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318    7.9248  $ void+pad
   83  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318    8.0772  $ void+pad+liner
   84  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   10.9220  $ void+pad+liner+277-4
   85  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   11.0744  $ void+pad+liner+277-4+liner
   86  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   23.1775  $ void+pad+liner+277-4+liner+kaolite
   87  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   23.3299  $
void+pad+liner+277-4+liner+kaolite+drum
c
c   CV bottom (section 1) - at 11.8618 cm level (height - 0.6350 cm)
c
   91  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350    6.6802  $ cv bottom
   92  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350    7.9248  $ cv bottom+void
   93  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350    8.0772  $ cv bottom+void+liner
   94  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   10.9220  $ cv bottom+void+liner+277-4
   95  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   11.0744  $ cv bottom+void+liner+277-4+liner
   96  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   23.1775  $ cv
bottom+void+liner+277-4+liner+kaolite
   97  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   23.3299  $ cv
bottom+void+liner+277-4+liner+kaolite+drum
c
c   CV (section 2) at 12.4968 cm level (height - 77.08899 cm)
c
  101  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  6.4262  $ cv void
  102  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  6.6802  $ cv void+ss
  103  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  7.9248  $ cv void+ss+void
  104  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  8.0772  $ cv void+ss+void+liner
  105  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 10.9220  $ cv void+ss+void+liner+277-4
  106  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 11.0744  $ cv void+ss+void+liner+277-4+liner
  107  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 23.1775  $ cv
void+ss+void+liner+277-4+liner+kaolite
  108  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 23.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum
  109  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 24.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1
  110  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 123.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp
  111  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 124.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp+dt2
c
c   CV (section 3) at 89.58579 cm level (height - 0.1524 cm)
c   (ss liner top of sillicone rubber)
c
  112  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524  6.4262  $ cv void
  113  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524  6.6802  $ cv void+ss
  114  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524  7.9248  $ cv void+ss+void
  115  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524 11.0744  $ cv void+ss+void+liner
```

```
  116  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524 23.1775  $ cv void+ss+void+liner+kaolite
  117  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524 23.3299  $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 5) at 89.73819 cm level (height - 0.2286 cm)
c   (gap between Cat 277-4 & CV top section)
c
  122  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286  6.4262  $ cv void
  123  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286  6.6802  $ cv void+ss
  124  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 10.9220  $ cv void+ss+void
  125  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 11.0744  $ cv void+ss+void+liner
  126  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 23.1775  $ cv void+ss+void+liner+kaolite
  127  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 23.3299  $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 6) at 89.96679 cm level (height - 1.27 cm)
c   (lower section of CV flange)
c
  132  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700  6.4262  $ cv void
  133  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700  9.5250  $ cv void+ss
  134  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 10.0330  $ cv void+ss+rubber
  135  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 10.9220  $ cv void+ss+rubber+void
  136  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 11.0744  $ cv void+ss+rubber+void+liner
  137  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 23.1775  $ cv void+ss+rubber+void+liner+kaolite
  138  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 23.3299  $ cv
void+ss+rubber+void+liner+kaolite+drum
c
c   CV (section 7) at 91.23679 cm level (height - 2.921 cm)
c   (lower section of CV flange)
c
  141  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210  9.5250  $ ss
  142  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 10.0330  $ ss+rubber
  143  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 10.9220  $ ss+rubber+void
  144  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 11.0744  $ ss+rubber+void+liner
  145  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 23.1775  $ ss+rubber+void+liner+kaolite
  146  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 23.3299  $ ss+rubber+void+liner+kaolite+drum
c
c   CV (section 8) at 94.15779 cm level (height - 0.762 cm)
c   (top section of CV flange)
c
  151  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 10.0330  $ rubber
  152  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 10.9220  $ rubber+void
  153  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 11.0744  $ rubber+void+liner
  154  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 23.1775  $ rubber+void+liner+kaolite
  155  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 23.3299  $ rubber+void+liner+kaolite+drum
c
c   Top of CV (section 1) at 94.91979 cm level (height - 0.254 cm)
c
  161  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 10.9220  $ void
  162  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 11.0744  $ void+liner
  163  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 23.1775  $ void+liner+kaolite
  164  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 23.3299  $ void+liner+kaolite+drum
c
c   Top of CV (section 2) at 95.17379 cm level (height - 0.1524 cm)
c
  171  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 10.9220  $ void
  172  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 18.7579  $ void+liner
  173  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 23.1775  $ void+liner+kaolite
  174  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 23.3299  $ void+liner+kaolite+drum
c
c   Top of CV (section 3) at 95.32619 cm level (height - 0.34036 cm)
c
  181  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 18.6055  $ void
```

```
  182  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 18.7579  $ void+liner
  183  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 23.1775  $ void+liner+kaolite
  184  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 23.3299  $ void+liner+kaolite+drum
c
c   Kaolite plug bottom ss  at 95.66655 cm level (height - 0.1524 cm)
c
  191  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 18.2499   $ ss (liner)
  192  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 18.6055   $ ss+void
  193  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 18.7579   $ ss+void+liner
  194  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 23.1775   $ ss+void+liner+kaolite
  195  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 23.3299   $ ss+void+liner+kaolite+drum
c
c   Kaolite top plug bottom section  at 95.81895 cm level (height - 7.68604 cm)
c
  201  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.0975  $ kaolite
  202  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.2499  $ kaolite +liner
  203  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.6055  $ kaolite+liner+void
  204  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.7579  $ kaolite+liner+void+liner
  205  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 23.1775  $ kaolite+liner+void+liner+kaolite
  206  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 23.3299  $
kaolite+liner+void+liner+kaolite+drum
c
c   Kaolite top plug (iron angle bottom section) at 103.50499 cm level (height - 4.4450 cm)
c
  211  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.0975  $ kaolite
  212  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.2499  $ kaolite +liner
  213  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.6055  $ kaolite+liner+void
  214  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.7579  $ kaolite+liner+void+liner
  215  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  19.3929  $ kaolite+liner+void+liner+iron-angle
  216  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  23.1775  $
kaolite+liner+void+liner+iron-angle+kaolite
  217  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  23.3299  $
kaolite+liner+void+liner+iron-angle+kaolite+drum
c
c   Kaolite top plug (iron angle top section) at 107.94999 cm level (height - 0.1118 cm)
c
  221  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.0975  $ kaolite
  222  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.2499  $ kaolite +liner
  223  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.6055  $ kaolite+liner+void
  224  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.7579  $ kaolite+liner+void+liner
  225  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  23.1775  $ kaolite+liner+void+liner+iron-angle
  226  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  23.3299  $
kaolite+liner+void+liner+iron-angle+drum
c
c   Kaolite top plug (iron angle top section) at 108.06175 cm level (height - 0.1524 cm)
c
  231  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  18.2499  $ ss liner
  232  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  18.6055  $ ss liner+void
  233  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  18.7579  $ ss liner+void+liner
  234  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  23.1775  $ ss liner+void+liner+iron-angle
  235  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  23.3299  $ ss liner+void+liner+iron-angle+drum
c
c   Gap above Kaolite top plug at 108.21415 cm level (height - 0.37084 cm)
c
  241  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  18.6055  $ void
  242  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  18.7579  $ void+liner
  243  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  23.1775  $ void+liner+iron-angle
  244  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  23.3299  $ void+liner+iron-angle+drum
c
c   Top ss lid at 108.58499 cm level (height - 0.1524 cm)
c
```

```
  251  rcc 0.0 0.0 108.58499  0.0 0.0  0.1524  23.1140  $ ss lid
  252  rcc 0.0 0.0 108.58499  0.0 0.0  0.1524  23.1775  $ ss lid+void
  253  rcc 0.0 0.0 108.58499  0.0 0.0  0.1524  23.3299  $ ss lid+void+drum
c
c   Top ss lid at 108.73739 cm level (height - 1.7526 cm)
c
  261  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  22.9616  $ void
  262  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  23.1140  $ void+ss lid
  263  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  23.1775  $ void+ss lid+void
  264  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  23.3299  $ void+ss lid+void+drum
c
c   Segmented side volume detectors
c
  301  pz 13
  302  pz 14
  303  pz 15
  304  pz 16
  305  pz 17
  306  pz 18
  307  pz 19
  308  pz 20
  309  pz 21
  310  pz 22
  311  pz 23
  312  pz 24
  313  pz 25
  314  pz 26
  315  pz 27
  316  pz 28
  317  pz 29
  318  pz 30
  319  pz 31
  320  pz 32
  321  pz 33
  322  pz 34
  323  pz 35
  324  pz 36
  325  pz 37
  326  pz 38
  327  pz 39
  328  pz 40
  329  pz 41
  330  pz 42
  331  pz 43
  332  pz 44
  333  pz 45
  334  pz 46
  335  pz 47
  336  pz 48
  337  pz 49
  338  pz 50
  339  pz 51
  340  pz 52
  341  pz 53
  342  pz 54
  343  pz 55
  344  pz 56
  345  pz 57
  346  pz 58
  347  pz 59
  348  pz 60
```

```
  349  pz 61
  350  pz 62
  351  pz 63
  352  pz 64
  353  pz 65
  354  pz 66
  355  pz 67
  356  pz 68
  357  pz 69
  358  pz 70
  359  pz 71
  360  pz 72
  361  pz 73
  362  pz 74
  363  pz 75
  364  pz 76
  365  pz 77
  366  pz 78
  367  pz 79
  368  pz 80
  369  pz 81
  370  pz 82
  371  pz 83
  372  pz 84
  373  pz 85
  374  pz 86
  375  pz 87
  376  pz 88
  377  pz 89
c
c   plane perpendicular to x-axis
c
  401  px 0
c
c   Put volume source for top and bottom detectors
c
  501  rcc 0.0 0.0 -0.5  0.0 0.0  0.5  1.0          $ bottom surface vol detector
  502  rcc 0.0 0.0 108.73739  0.0 0.0  0.5  1.0     $ top surface vol detector
  551  rcc 0.0 0.0 -100.5  0.0 0.0  0.5  1.0        $ 1 m from bottom surface - vol detector
  552  rcc 0.0 0.0 208.73739  0.0 0.0  0.5  1.0     $ 1 m from top surface - vol detector
c
  999  sph  0.0 0.0  0.000  999.0                          $ boundary
c

c    ----------------------
c    Data Cards
c    ----------------------
mode  n p
c
c      uranium metal (18.82 g/cc)
c
m1    92235.70c  -0.9500    $ U-235           95.0000  wt%
      92238.70c  -0.0500    $ U-238            5.0000  wt%
c
c      ss 304 (7.92 g/cc)
c
m2     6000.70c  -0.00080    $ Carbon(C)        0.0800  wt%
      14028.70c  -0.00919    $ Silicon(Si-28)   0.9187  wt%
      14029.70c  -0.00048    $ Si-29            0.0483  wt%
      14030.70c  -0.00033    $ Si-30            0.0330  wt%
      15031.70c  -0.00045    $ Phosphorus(P)    0.0450  wt%
```

```
      24050.70c  -0.00793    $ Cromium (Cr-50)  0.7930  wt%
      24052.70c  -0.15903    $ Cr-52           15.9029  wt%
      24053.70c  -0.01838    $ Cr-53            1.8380  wt%
      24054.70c  -0.00466    $ Cr-54            0.4661  wt%
      25055.70c  -0.02000    $ Manganese (Mn)   2.0000  wt%
      26054.70c  -0.03860    $ Iron (Fe-54)     3.8602  wt%
      26056.70c  -0.62838    $ Fe-56           62.8377  wt%
      26057.70c  -0.01477    $ Fe-57            1.4772  wt%
      26058.70c  -0.00200    $ Fe-58            0.2000  wt%
      28058.70c  -0.06384    $ Nickel (Ni-58)   6.3838  wt%
      28060.70c  -0.02544    $ Ni-60            2.5437  wt%
      28061.70c  -0.00112    $ Ni-61            0.1124  wt%
      28062.70c  -0.00364    $ Ni-62            0.3643  wt%
      28064.70c  -0.00096    $ Ni-64            0.0958  wt%
c
c      rubber foam (1.20 g/cc)
c
m3     1001.70c  -0.08157    $ Hydrogen (H)     8.1573 wt%
       6000.70c  -0.32377    $ Carbon (C)      32.3767 wt%
       8016.70c  -0.21520    $ Oxygen (O-16)   21.5196 wt%
       8017.70c  -0.00059    $ O-17 & O-18      0.0586 wt%
      14028.70c  -0.34806    $ Silicon(Si-28)  34.8061 wt%
      14029.70c  -0.01831    $ Si-29            1.8314 wt%
      14030.70c  -0.01250    $ Si-30            1.2503 wt%
c
c      kaolite (0.321 g/cc)
c
m4     8016.70c -0.4092    $ Oxygen (O-16)   40.9231 wt%
       8017.70c -0.0011    $ Oxygen (17&18)   0.1114 wt%
      11023.70c -0.0148    $ Sodium (Na)      1.4837 wt%
      12024.70c -0.0786    $ Magnesium (Mg-24)6.1579 wt%
      12025.70c -0.0081    $ Mg-25            0.8121 wt%
      12026.70c -0.0093    $ Mg-26            0.9298 wt%
      13027.70c -0.0508    $ Al               5.0808 wt%
      14028.70c -0.1576    $ Silicon (Si-28) 15.7596 wt%
      14029.70c -0.0083    $ Si-29            0.8292 wt%
      14030.70c -0.0057    $ Si-30            0.5661 wt%
      20040.70c -0.2121    $ Calcium (Ca-40) 21.2086 wt%
      20042.70c -0.0015    $ Ca-42            0.1490 wt%
      20043.70c -0.0003    $ Ca-43            0.0318 wt%
      20044.70c -0.0050    $ Ca-44            0.5031 wt%
      20046.70c -0.00001   $ Ca-46            0.0010 wt%
      20048.70c -0.0005    $ Ca-48            0.0491 wt%
      22046.70c -0.0006    $ Titanium (Ti-46) 0.0570 wt%
      22047.70c -0.0005    $ Ti-47            0.0525 wt%
      22048.70c -0.0053    $ Ti-48            0.5311 wt%
      22049.70c -0.0004    $ Ti-49            0.0398 wt%
      22050.70c -0.0004    $ Ti-50            0.0407 wt%
      26054.70c -0.0026    $ Iron (Fe-54)     0.2646 wt%
      26056.70c -0.0431    $ Fe-56            4.3066 wt%
      26057.70c -0.0010    $ Fe-57            0.1012 wt%
      26058.70c -0.0001    $ Fe-58            0.0137 wt%
c
c      Cat 277-4 (1.4586 g/cc)
c
m5     1001.70c -0.0285    $ Hydrogen         2.8475 wt%
       5010.70c -0.0066    $ Boron (B-10)     0.6591 wt%
       5011.70c -0.0297    $ Boron (B-11)     2.9726 wt%
       6000.70c -0.0136    $ Carbon (C)       1.3609 wt%
       7014.70c -0.0001    $ Nitrogen (N)     0.0100 wt%
       8016.70c -0.5325    $ Oxygen (O-16)   53.2515 wt%
```

```
       8017.70c -0.0015    $ Oxygen (17&18)   0.1450 wt%
      11023.70c -0.0008    $ Sodium (Na)      0.0833 wt%
      12024.70c -0.0019    $ Magnesium (Mg-24)0.1867 wt%
      12025.70c -0.0002    $ Mg-25            0.0246 wt%
      12026.70c -0.0003    $ Mg-26            0.0282 wt%
      13027.70c -0.2769    $ Al              27.6937 wt%
      14028.70c -0.0161    $ Silicon (Si-28)  1.6075 wt%
      14029.70c -0.0008    $ Si-29            0.0846 wt%
      14030.70c -0.0006    $ Si-30            0.0577 wt%
      16032.70c -0.0021    $ Sulfur (S-32)    0.2071 wt%
      16033.70c -0.00002   $ S-33             0.0017 wt%
      16034.70c -0.0001    $ S-34             0.0098 wt%
      16036.70c -0.0000002 $ S-36             0.00002 wt%
      20040.70c -0.0811    $ Calcium (Ca-40)  8.1125 wt%
      20042.70c -0.0006    $ Ca-42            0.0569 wt%
      20043.70c -0.0001    $ Ca-43            0.0121 wt%
      20044.70c -0.0019    $ Ca-44            0.1920 wt%
      20046.70c -0.000004  $ Ca-46            0.0004 wt%
      20048.70c -0.0002    $ Ca-48            0.0188 wt%
      26054.70c -0.0002    $ Iron (Fe-54)     0.0212 wt%
      26056.70c -0.0035    $ Fe-56            0.3453 wt%
      26057.70c -0.00008   $ Fe-57            0.0081 wt%
      26058.70c -0.00001   $ Fe-58            0.0011 wt%
c
c       air (1.225e-3 g/cc)
c
m6      7014.70c  -0.755   $ Nitrogen (N-14) 75.5000 wt%
        8016.70c  -0.232   $ Oxygen (O-16)   23.2000 wt%
       18000.70c  -0.013   $ Argon (Ar-40)    1.3000 wt%
c
c      uranium metal (10.960 g/cc - variable)
c
m7     8016.70c  -0.1198    $ O               11.9800  wt%
      92235.70c  -0.8362    $ U-235           83.6200  wt%
      92238.70c  -0.0440    $ U-238            4.4000  wt%
c
c    source in ES-3100 - cylindrical hemishell at the bottom of CV
c                        (H = 76.2 cm; IR = 4.9337 cm; OR = 6.35 cm)
c
c   neutron source - 2.129e-01 neutron/sec/gm basis
c   material used - 36 kg HEU
c   dose conversion factor (mrem/hr)/(neutrons/cm2-s) used
c   source term, wgt = 2.129e-01 * 36.0e+03  = 7.6644e+03
c
sdef cell=2 pos=0 0 12.4968 rad=d1 ext=d2  erg=d3 axs=0 0 1 wgt=7.6644e+03
c
c  source position
c
si1    4.9337   6.35         $ radial
sp1    -21       1
si2    0.0     76.20         $ axial
sp2     0        1
c
c  ORIGEN neutron spectrum
c
si3     5.83e-04     3.04e-03    1.50e-02     1.11e-01    4.08e-01
        9.07e-01     1.42e+00    1.83e+00     3.01e+00    6.38e+00    20.00e+00
c
sp3     0.0          7.034e-06   8.280e-05    1.790e-03   8.973e-03
        1.572e-02    2.205e-02   2.510e-02    1.042e-01   3.430e-02    7.260e-04
c
```

```
fq0 f s d
c
c  point detectors for neutrons
c
f5:n    23.4299  0.0     50.5968   0.0     $ side surface - detector
f15:n    0.0     0.0    108.83739  0.0     $ top surface - detector
f25:n    0.0     0.0     -0.1      0.0     $ bottom surface - detector
f35:n  123.3299  0.0     50.5968   0.0     $ 1m from side surface - detector
f45:n    0.0     0.0    208.73739  0.0     $ 1m from top surface - detector
f55:n    0.0     0.0   -100.0      0.0     $ 1m from bottom surface - detector
c
c ANSI/ANS-6.1.1-1977 neutron flux to dose rate conversion factor
c                                  (mrem/hr)/(neutrons/cm2-s)
c
de0      2.5e-08   1.0e-07   1.0e-06   1.0e-05   1.0e-04   1.0e-3    1.0e-02
         1.0e-01   5.0e-01   1.0       2.5       5.0       7.0       10.0
         14.0      20.0
c
df0      3.67e-03  3.67e-03  4.46e-03  4.54e-03  4.18e-03  3.76e-03  3.56e-03
         2.17e-02  9.26e-02  1.32e-01  1.25e-01  1.56e-01  1.47e-01  1.47e-01
         2.08e-01  2.27e-01
c
c  point detectors for secondary photons
c
f505:p   23.4299  0.0     50.5968   0.0     $ side surface - detector
f515:p    0.0     0.0    108.83739  0.0     $ top surface - detector
f525:p    0.0     0.0     -0.1      0.0     $ bottom surface - detector
f535:p  123.3299  0.0     50.5968   0.0     $ 1m from side surface - detector
f545:p    0.0     0.0    208.73739  0.0     $ 1m from top surface - detector
f555:p    0.0     0.0   -100.0      0.0     $ 1m from bottom surface - detector
c
c ANSI/ANS-6.1.1-1977 photon flux to dose rate conversion factor
c                                  (mrem/hr)/(photons/cm2-s)
c
de505       0.01      0.03      0.05      0.07       0.1      0.15      0.20
            0.25      0.30      0.35      0.40       0.45     0.50      0.55
            0.60      0.65      0.70      0.8        1.0      1.4       1.8
            2.2       2.6       2.8       3.25       3.75     4.25      4.75
            5.00      5.25      5.75      6.25       6.75     7.50      9.0
           11.0      13.0      15.0
c
df505    3.96e-3   5.82e-4   2.90e-4   2.58e-4   2.83e-4   3.79e-4   5.01e-4
         6.31e-4   7.59e-4   8.78e-4   9.85e-4   1.08e-3   1.17e-3   1.27e-3
         1.36e-3   1.44e-3   1.52e-3   1.68e-3   1.98e-3   2.51e-3   2.99e-3
         3.42e-3   3.82e-3   4.01e-3   4.41e-3   4.83e-3   5.23e-3   5.60e-3
         5.80e-3   6.01e-3   6.37e-3   6.74e-3   7.11e-3   7.66e-3   8.77e-3
         1.03e-2   1.18e-2   1.33e-2
c
de515       0.01      0.03      0.05      0.07       0.1      0.15      0.20
            0.25      0.30      0.35      0.40       0.45     0.50      0.55
            0.60      0.65      0.70      0.8        1.0      1.4       1.8
            2.2       2.6       2.8       3.25       3.75     4.25      4.75
            5.00      5.25      5.75      6.25       6.75     7.50      9.0
           11.0      13.0      15.0
c
df515    3.96e-3   5.82e-4   2.90e-4   2.58e-4   2.83e-4   3.79e-4   5.01e-4
         6.31e-4   7.59e-4   8.78e-4   9.85e-4   1.08e-3   1.17e-3   1.27e-3
         1.36e-3   1.44e-3   1.52e-3   1.68e-3   1.98e-3   2.51e-3   2.99e-3
         3.42e-3   3.82e-3   4.01e-3   4.41e-3   4.83e-3   5.23e-3   5.60e-3
         5.80e-3   6.01e-3   6.37e-3   6.74e-3   7.11e-3   7.66e-3   8.77e-3
         1.03e-2   1.18e-2   1.33e-2
```

```
c
de525       0.01      0.03      0.05      0.07       0.1      0.15      0.20
            0.25      0.30      0.35      0.40       0.45     0.50      0.55
            0.60      0.65      0.70      0.8        1.0      1.4       1.8
            2.2       2.6       2.8       3.25       3.75     4.25      4.75
            5.00      5.25      5.75      6.25       6.75     7.50      9.0
           11.0      13.0      15.0
c
df525    3.96e-3   5.82e-4   2.90e-4   2.58e-4   2.83e-4   3.79e-4   5.01e-4
         6.31e-4   7.59e-4   8.78e-4   9.85e-4   1.08e-3   1.17e-3   1.27e-3
         1.36e-3   1.44e-3   1.52e-3   1.68e-3   1.98e-3   2.51e-3   2.99e-3
         3.42e-3   3.82e-3   4.01e-3   4.41e-3   4.83e-3   5.23e-3   5.60e-3
         5.80e-3   6.01e-3   6.37e-3   6.74e-3   7.11e-3   7.66e-3   8.77e-3
         1.03e-2   1.18e-2   1.33e-2
c
de535       0.01      0.03      0.05      0.07       0.1      0.15      0.20
            0.25      0.30      0.35      0.40       0.45     0.50      0.55
            0.60      0.65      0.70      0.8        1.0      1.4       1.8
            2.2       2.6       2.8       3.25       3.75     4.25      4.75
            5.00      5.25      5.75      6.25       6.75     7.50      9.0
           11.0      13.0      15.0
c
df535    3.96e-3   5.82e-4   2.90e-4   2.58e-4   2.83e-4   3.79e-4   5.01e-4
         6.31e-4   7.59e-4   8.78e-4   9.85e-4   1.08e-3   1.17e-3   1.27e-3
         1.36e-3   1.44e-3   1.52e-3   1.68e-3   1.98e-3   2.51e-3   2.99e-3
         3.42e-3   3.82e-3   4.01e-3   4.41e-3   4.83e-3   5.23e-3   5.60e-3
         5.80e-3   6.01e-3   6.37e-3   6.74e-3   7.11e-3   7.66e-3   8.77e-3
         1.03e-2   1.18e-2   1.33e-2
c
de545       0.01      0.03      0.05      0.07       0.1      0.15      0.20
            0.25      0.30      0.35      0.40       0.45     0.50      0.55
            0.60      0.65      0.70      0.8        1.0      1.4       1.8
            2.2       2.6       2.8       3.25       3.75     4.25      4.75
            5.00      5.25      5.75      6.25       6.75     7.50      9.0
           11.0      13.0      15.0
c
df545    3.96e-3   5.82e-4   2.90e-4   2.58e-4   2.83e-4   3.79e-4   5.01e-4
         6.31e-4   7.59e-4   8.78e-4   9.85e-4   1.08e-3   1.17e-3   1.27e-3
         1.36e-3   1.44e-3   1.52e-3   1.68e-3   1.98e-3   2.51e-3   2.99e-3
         3.42e-3   3.82e-3   4.01e-3   4.41e-3   4.83e-3   5.23e-3   5.60e-3
         5.80e-3   6.01e-3   6.37e-3   6.74e-3   7.11e-3   7.66e-3   8.77e-3
         1.03e-2   1.18e-2   1.33e-2
c
de555       0.01      0.03      0.05      0.07       0.1      0.15      0.20
            0.25      0.30      0.35      0.40       0.45     0.50      0.55
            0.60      0.65      0.70      0.8        1.0      1.4       1.8
            2.2       2.6       2.8       3.25       3.75     4.25      4.75
            5.00      5.25      5.75      6.25       6.75     7.50      9.0
           11.0      13.0      15.0
c
df555    3.96e-3   5.82e-4   2.90e-4   2.58e-4   2.83e-4   3.79e-4   5.01e-4
         6.31e-4   7.59e-4   8.78e-4   9.85e-4   1.08e-3   1.17e-3   1.27e-3
         1.36e-3   1.44e-3   1.52e-3   1.68e-3   1.98e-3   2.51e-3   2.99e-3
         3.42e-3   3.82e-3   4.01e-3   4.41e-3   4.83e-3   5.23e-3   5.60e-3
         5.80e-3   6.01e-3   6.37e-3   6.74e-3   7.11e-3   7.66e-3   8.77e-3
         1.03e-2   1.18e-2   1.33e-2
c
prdmp  j  10000000 0 10
ctme 2000
```

5.5.2.5 NCT for 24-kg uranium oxide photon side dose-rate calculations (cylinder configuration source)

```
photon_side8.inp- ES-3100: 2015 HEU detailed model (primary photons)
c                 UO2 case (47.365 cm ht cylindrical
c                 density = 4.0 g/cc; OR=6.35 cm)
c    configuration
c    (bottom dose rate calculations)
c    source in cylindricalshell form sitting at the bottom of CV for
c    side dose rate calculations for 2015 Revision
c
c    mcnp geometry model (CV and outside) is identical to criticality model
c    (KENO Model).
c    47 energy groups are used for the photon spectrum.  In the older version,
c    18 energy groups were used.
c    surface detectors are placed 0.1 cm and 100 cm way from the surfaces
c    and detectors are placed on the side, top, and bottom.
c    point detectors are used for dose rate calculations (used for results).
c    segmented volume detectors are used for side dose rate calculations (for checking).
c    volume detectors are used to check bottom and top dose rate calculations.
c    ANSI/ANS-6.1.1-1977 Dose conversion factors are used,
c    multiplied by 1000 to convert from rem to mrem
c
c    segmented volume detectors are placed
c
c   mode p - (primary  photons)
c
c    --------------
c     Cell Cards
c    --------------
c
    1     7   -4.0      -1       imp:n,p=1 $ source shell
c
c   drum bottom - at 0.0 cm level (height - 0.2667 cm)
c
   51     2   -7.92     -51      imp:n,p=1 $ drum bottom
c
c   bottom kaolite - at 0.2667 cm level (height - 10.8585 cm)
c
   61     4   -0.321    -61      imp:n,p=1 $ bottom kaolite
   62     2   -7.92     -62 61   imp:n,p=1 $ bottom kaolite+drum
c
c   bottom inner liner - at 11.1252 cm level (height - 0.3048 cm)
c
   71     2   -7.92     -71      imp:n,p=1 $ bottom liner
   72     4   -0.321    -72 71   imp:n,p=1 $ bottom liner+kaolite
   73     2   -7.92     -73 72   imp:n,p=1 $ bottom liner+kaolite+drum
c
c   bottom rubber pad - at 11.4300 cm level (height - 0.4318 cm)
c
   81     0             -81      imp:n,p=1 $ void
   82     3   -1.2      -82 81   imp:n,p=1 $ void+pad
   83     2   -7.92     -83 82   imp:n,p=1 $ void+pad+liner
   84     5   -1.4586   -84 83   imp:n,p=1 $ void+pad+liner+277-4
   85     2   -7.92     -85 84   imp:n,p=1 $ void+pad+liner+277-4+liner
   86     4   -0.321    -86 85   imp:n,p=1 $ void+pad+liner+277-4+liner+kaolite
   87     2   -7.92     -87 86   imp:n,p=1 $ void+pad+liner+277-4+liner+kaolite+drum
c
c   CV bottom (section 1) - at 11.8618 cm level (height - 0.6350 cm)
c
   91     2   -7.92     -91      imp:n,p=1 $ cv bottom
```

```
   92     0             -92 91   imp:n,p=1 $ cv bottom+void
   93     2   -7.92     -93 92   imp:n,p=1 $ cv bottom+void+liner
   94     5   -1.4586   -94 93   imp:n,p=1 $ cv bottom+void+liner+277-4
   95     2   -7.92     -95 94   imp:n,p=1 $ cv bottom+void+liner+277-4+liner
   96     4   -0.321    -96 95   imp:n,p=1 $ cv bottom+void+liner+277-4+liner+kaolite
   97     2   -7.92     -97 96   imp:n,p=1 $ cv bottom+void+liner+277-4+liner+kaolite+drum
c
c   CV (section 2) at 12.4968 cm level (height - 77.08899 cm)
c
  101     0             -101 #1   imp:n,p=1 $ cv void
  102     2   -7.92     -102 101  imp:n,p=1 $ cv void+ss
  103     0             -103 102  imp:n,p=1 $ cv void+ss+void
  104     2   -7.92     -104 103  imp:n,p=1 $ cv void+ss+void+liner
  105     5   -1.4586   -105 104  imp:n,p=1 $ cv void+ss+void+liner+277-4
  106     2   -7.92     -106 105  imp:n,p=1 $ cv void+ss+void+liner+277-4+liner
  107     4   -0.321    -107 106  imp:n,p=1 $ cv void+ss+void+liner+277-4+liner+kaolite
  108     2   -7.92     -108 107  imp:n,p=1 $ cv void+ss+void+liner+277-4+liner+kaolite+drum
  109     0             -109 108  imp:n,p=1 $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1
  110     0             -110 109  imp:n,p=1 $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp
  111     0             -111 110  imp:n,p=1 $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp+dt2
c
c   CV (section 3) at 89.5857 cm level (height - 0.1524 cm)
c   (ss liner top of sillicone rubber)
c
c 111     0             -111      imp:n,p=1 $ cv void (to be filled by content can)
  112     0             -112      imp:n,p=1 $ cv void
  113     2   -7.92     -113 112  imp:n,p=1 $ cv void+ss
  114     0             -114 113  imp:n,p=1 $ cv void+ss+void
  115     2   -7.92     -115 114  imp:n,p=1 $ cv void+ss+void+liner
  116     4   -0.321    -116 115  imp:n,p=1 $ cv void+ss+void+liner+kaolite
  117     2   -7.92     -117 116  imp:n,p=1 $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 4) at 89.73819 cm level (height - 0.2286 cm)
c   (gap between Cat 277-4 & CV top section)
c
  122     0             -122      imp:n,p=1 $ cv void
  123     2   -7.92     -123 122  imp:n,p=1 $ cv void+ss
  124     0             -124 123  imp:n,p=1 $ cv void+ss+void
  125     2   -7.92     -125 124  imp:n,p=1 $ cv void+ss+void+liner
  126     4   -0.321    -126 125  imp:n,p=1 $ cv void+ss+void+liner+kaolite
  127     2   -7.92     -127 126  imp:n,p=1 $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 6) at 89.96679 cm level (height - 1.27 cm)
c   (lower section of CV flange)
c
  132     0             -132      imp:n,p=1 $ cv void
  133     2   -7.92     -133 132  imp:n,p=1 $ cv void+ss
  134     3   -1.20     -134 133  imp:n,p=1 $ cv void+ss+rubber
  135     0             -135 134  imp:n,p=1 $ cv void+ss+rubber+void
  136     2   -7.92     -136 135  imp:n,p=1 $ cv void+ss+rubber+void+liner
  137     4   -0.321    -137 136  imp:n,p=1 $ cv void+ss+rubber+void+liner+kaolite
  138     2   -7.92     -138 137  imp:n,p=1 $ cv +void+ss+rubber+void+liner+kaolite+drum
c
c   CV (section 7) at 91.23679 cm level (height - 2.921 cm)
c   (middle section of CV flange)
c
  141     2   -7.92     -141      imp:n,p=1 $ ss
  142     3   -1.20     -142 141  imp:n,p=1 $ ss+rubber
```

```
  143     0             -143 142  imp:n,p=1 $ ss+rubber+void
  144     2   -7.92     -144 143  imp:n,p=1 $ ss+rubber+void+liner
  145     4   -0.321    -145 144  imp:n,p=1 $ ss+rubber+void+liner+kaolite
  146     2   -7.92     -146 145  imp:n,p=1 $ ss+rubber+void+liner+kaolite+drum
c
c   CV (section 8) at 94.15779 cm level (height - 0.762 cm)
c   (top section of CV flange)
c
  151     3   -1.20     -151      imp:n,p=1 $ rubber
  152     0             -152 151  imp:n,p=1 $ rubber+void
  153     2   -7.92     -153 152  imp:n,p=1 $ rubber+void+liner
  154     4   -0.321    -154 153  imp:n,p=1 $ rubber+void+liner+kaolite
  155     2   -7.92     -155 154  imp:n,p=1 $ rubber+void+liner+kaolite+drum
c
c   Top of CV (section 1) at 94.91979 cm level (height - 0.254 cm)
c
  161     0             -161      imp:n,p=1 $ void
  162     2   -7.92     -162 161  imp:n,p=1 $ void+liner
  163     4   -0.321    -163 162  imp:n,p=1 $ void+liner+kaolite
  164     2   -7.92     -164 163  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Top of CV (section 2) at 95.17379 cm level (height - 0.1524 cm)
c
  171     0             -171      imp:n,p=1 $ void
  172     2   -7.92     -172 171  imp:n,p=1 $ void+liner
  173     4   -0.321    -173 172  imp:n,p=1 $ void+liner+kaolite
  174     2   -7.92     -174 173  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Top of CV (section 3) at 95.32619 cm level (height - 0.34036 cm)
c
  181     0             -181      imp:n,p=1 $ void
  182     2   -7.92     -182 181  imp:n,p=1 $ void+liner
  183     4   -0.321    -183 182  imp:n,p=1 $ void+liner+kaolite
  184     2   -7.92     -184 183  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Kaolite plug bottom ss  at 95.66655 cm level (height - 0.1524 cm)
c
  191     2   -7.92     -191      imp:n,p=1 $ ss (liner)
  192     0             -192 191  imp:n,p=1 $ ss+void
  193     2   -7.92     -193 192  imp:n,p=1 $ ss+void+liner
  194     4   -0.321    -194 193  imp:n,p=1 $ ss+void+liner+kaolite
  195     2   -7.92     -195 194  imp:n,p=1 $ void+liner+kaolite+drum
c
c   Kaolite top plug bottom section  at 95.81895 cm level (height - 7.68604 cm)
c
  201     4   -0.321    -201      imp:n,p=1 $ kaolite
  202     2   -7.92     -202 201  imp:n,p=1 $ kaolite+liner
  203     0             -203 202  imp:n,p=1 $ kaolite+liner+void
  204     2   -7.92     -204 203  imp:n,p=1 $ kaolite+liner+void+liner
  205     4   -0.321    -205 204  imp:n,p=1 $ kaolite+liner+void+liner+kaolite
  206     2   -7.92     -206 205  imp:n,p=1 $ kaolite+liner+void+liner+kaolite+drum
c
c   Kaolite top plug (iron angle bottom section) at 103.50499 cm level (height - 4.4450 cm)
c
  211     4   -0.321    -211      imp:n,p=1 $ kaolite
  212     2   -7.92     -212 211  imp:n,p=1 $ kaolite+liner
  213     0             -213 212  imp:n,p=1 $ kaolite+liner+void
  214     2   -7.92     -214 213  imp:n,p=1 $ kaolite+liner+void+liner
  215     2   -7.92     -215 214  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle
  216     4   -0.321    -216 215  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle+kaolite
  217     2   -7.92     -217 216  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle+kaolite+drum
```

```
c
c   Kaolite top plug (iron angle top section) at 107.94999 cm level (height - 0.1118 cm)
c
  221     4   -0.321    -221      imp:n,p=1 $ kaolite
  222     2   -7.92     -222 221  imp:n,p=1 $ kaolite+liner
  223     0             -223 222  imp:n,p=1 $ kaolite+liner+void
  224     2   -7.92     -224 223  imp:n,p=1 $ kaolite+liner+void+liner
  225     2   -7.92     -225 224  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle
  226     2   -7.92     -226 225  imp:n,p=1 $ kaolite+liner+void+liner+iron-angle+drum
c
c   Kaolite top plug (iron angle top section) at 108.06175 cm level (height - 0.1524 cm)
c
  231     2   -7.92     -231      imp:n,p=1 $ liner
  232     0             -232 231  imp:n,p=1 $ liner+void
  233     2   -7.92     -233 232  imp:n,p=1 $ liner+void+liner
  234     2   -7.92     -234 233  imp:n,p=1 $ liner+void+liner+iron-angle
  235     2   -7.92     -235 234  imp:n,p=1 $ liner+void+liner+iron-angle+drum
c
c   Gap above Kaolite top plug at 108.21415 cm level (height - 0.37084 cm)
c
  241     0             -241      imp:n,p=1 $ liner+void
  242     2   -7.92     -242 241  imp:n,p=1 $ liner+void+liner
  243     2   -7.92     -243 242  imp:n,p=1 $ liner+void+liner+iron-angle
  244     2   -7.92     -244 243  imp:n,p=1 $ liner+void+liner+iron-angle+drum
c
c   Top ss lid at 108.58499 cm level (height - 0.1524 cm)
c
  251     2   -7.92     -251      imp:n,p=1 $ ss lid
  252     0             -252 251  imp:n,p=1 $ ss lid+void
  253     2   -7.92     -253 252  imp:n,p=1 $ ss lid+void+drum
c
c   Top ss lid at 108.73739 cm level (height - 1.7526 cm)
c
  261     0             -261 #502      imp:n,p=1 $ void
  262     2   -7.92     -262 261  imp:n,p=1 $ void+ss lid
  263     0             -263 262  imp:n,p=1 $ void+ss lid+void
  264     2   -7.92     -264 263  imp:n,p=1 $ void+ss lid+void+drum
c
c   Put volume source for top and bottom detectors
c
  501     0             -501      imp:n,p=1 $ bottom surface detector
  502     0             -502      imp:n,p=1 $ top surface detector
  551     0             -551      imp:n,p=1 $ 1 m from bottom surface - detector
  552     0             -552      imp:n,p=1 $ 1 m from top surface - detector
c
  998     0             -999      51 62 73 87 97 111 117 127 138 146 155
                                  164 174 184 195 206 217 226 235 244 253
                                  264 501 502 551 552
                                  imp:n,p=1 $ inside boundary
  999     0              999      imp:n,p=0 $ outside world

c    ------------------
c    Surface Cards
c    ------------------
c
    1  rcc  0.0 0.0 12.4968   0.0 0.0  47.365   6.35    $ outer radius cylindrical shell
source
c
c   drum bottom - at 0.0 cm level (height - 0.2667 cm)
c
   51  rcc  0.0 0.0  0.0     0.0 0.0 0.2667   23.3299  $ drum bottom
```

```
c
c   bottom kaolite - at 0.2667 cm level (height - 10.8585 cm)
c
   61  rcc  0.0 0.0  0.2667  0.0 0.0 10.8585  23.1775  $ bottom kaolite
   62  rcc  0.0 0.0  0.2667  0.0 0.0 10.8585  23.3299  $ bottom kaolite+drum
c
c   bottom inner liner - at 11.1252 cm level (height - 0.3048 cm)
c
   71  rcc  0.0 0.0 11.1252  0.0 0.0  0.3048  11.0744  $ bottom liner
   72  rcc  0.0 0.0 11.1252  0.0 0.0  0.3048  23.1775  $ bottom liner+kaolite
   73  rcc  0.0 0.0 11.1252  0.0 0.0  0.3048  23.3299  $ bottom liner+kaolite+drum
c
c   bottom rubber pad - at 11.4300 cm level (height - 0.4318 cm)
c
   81  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318    3.1750  $ void
   82  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318    7.9248  $ void+pad
   83  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318    8.0772  $ void+pad+liner
   84  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   10.9220  $ void+pad+liner+277-4
   85  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   11.0744  $ void+pad+liner+277-4+liner
   86  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   23.1775  $ void+pad+liner+277-4+liner+kaolite
   87  rcc  0.0 0.0 11.4300  0.0 0.0 0.4318   23.3299  $
void+pad+liner+277-4+liner+kaolite+drum
c
c   CV bottom (section 1) - at 11.8618 cm level (height - 0.6350 cm)
c
   91  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350    6.6802  $ cv bottom
   92  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350    7.9248  $ cv bottom+void
   93  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350    8.0772  $ cv bottom+void+liner
   94  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   10.9220  $ cv bottom+void+liner+277-4
   95  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   11.0744  $ cv bottom+void+liner+277-4+liner
   96  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   23.1775  $ cv
bottom+void+liner+277-4+liner+kaolite
   97  rcc  0.0 0.0 11.8618  0.0 0.0 0.6350   23.3299  $ cv
bottom+void+liner+277-4+liner+kaolite+drum
c
c   CV (section 2) at 12.4968 cm level (height - 77.08899 cm)
c
  101  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  6.4262  $ cv void
  102  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  6.6802  $ cv void+ss
  103  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  7.9248  $ cv void+ss+void
  104  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899  8.0772  $ cv void+ss+void+liner
  105  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 10.9220  $ cv void+ss+void+liner+277-4
  106  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 11.0744  $ cv void+ss+void+liner+277-4+liner
  107  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 23.1775  $ cv
void+ss+void+liner+277-4+liner+kaolite
  108  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 23.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum
  109  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 24.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1
  110  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 123.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp
  111  rcc  0.0 0.0 12.4968  0.0 0.0 77.08899 124.3299  $ cv
void+ss+void+liner+277-4+liner+kaolite+drum+dt1+sp+dt2
c
c   CV (section 3) at 89.58579 cm level (height - 0.1524 cm)
c   (ss liner top of sillicone rubber)
c
  112  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524  6.4262  $ cv void
  113  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524  6.6802  $ cv void+ss
  114  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524  7.9248  $ cv void+ss+void
  115  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524 11.0744  $ cv void+ss+void+liner
```

```
  116  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524 23.1775  $ cv void+ss+void+liner+kaolite
  117  rcc  0.0 0.0 89.58579  0.0 0.0  0.1524 23.3299  $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 5) at 89.73819 cm level (height - 0.2286 cm)
c   (gap between Cat 277-4 & CV top section)
c
  122  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286  6.4262  $ cv void
  123  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286  6.6802  $ cv void+ss
  124  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 10.9220  $ cv void+ss+void
  125  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 11.0744  $ cv void+ss+void+liner
  126  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 23.1775  $ cv void+ss+void+liner+kaolite
  127  rcc  0.0 0.0 89.73819  0.0 0.0  0.2286 23.3299  $ cv void+ss+void+liner+kaolite+drum
c
c   CV (section 6) at 89.96679 cm level (height - 1.27 cm)
c   (lower section of CV flange)
c
  132  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700  6.4262  $ cv void
  133  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700  9.5250  $ cv void+ss
  134  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 10.0330  $ cv void+ss+rubber
  135  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 10.9220  $ cv void+ss+rubber+void
  136  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 11.0744  $ cv void+ss+rubber+void+liner
  137  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 23.1775  $ cv void+ss+rubber+void+liner+kaolite
  138  rcc  0.0 0.0 89.96679  0.0 0.0  1.2700 23.3299  $ cv
void+ss+rubber+void+liner+kaolite+drum
c
c   CV (section 7) at 91.23679 cm level (height - 2.921 cm)
c   (lower section of CV flange)
c
  141  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210  9.5250  $ ss
  142  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 10.0330  $ ss+rubber
  143  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 10.9220  $ ss+rubber+void
  144  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 11.0744  $ ss+rubber+void+liner
  145  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 23.1775  $ ss+rubber+void+liner+kaolite
  146  rcc  0.0 0.0 91.23679  0.0 0.0  2.9210 23.3299  $ ss+rubber+void+liner+kaolite+drum
c
c   CV (section 8) at 94.15779 cm level (height - 0.762 cm)
c   (top section of CV flange)
c
  151  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 10.0330  $ rubber
  152  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 10.9220  $ rubber+void
  153  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 11.0744  $ rubber+void+liner
  154  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 23.1775  $ rubber+void+liner+kaolite
  155  rcc  0.0 0.0 94.15779  0.0 0.0  0.7620 23.3299  $ rubber+void+liner+kaolite+drum
c
c   Top of CV (section 1) at 94.91979 cm level (height - 0.254 cm)
c
  161  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 10.9220  $ void
  162  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 11.0744  $ void+liner
  163  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 23.1775  $ void+liner+kaolite
  164  rcc  0.0 0.0 94.91979  0.0 0.0  0.2540 23.3299  $ void+liner+kaolite+drum
c
c   Top of CV (section 2) at 95.17379 cm level (height - 0.1524 cm)
c
  171  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 10.9220  $ void
  172  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 18.7579  $ void+liner
  173  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 23.1775  $ void+liner+kaolite
  174  rcc  0.0 0.0 95.17379  0.0 0.0  0.1524 23.3299  $ void+liner+kaolite+drum
c
c   Top of CV (section 3) at 95.32619 cm level (height - 0.34036 cm)
c
  181  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 18.6055  $ void
```

```
  182  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 18.7579  $ void+liner
  183  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 23.1775  $ void+liner+kaolite
  184  rcc  0.0 0.0 95.32619  0.0 0.0  0.34036 23.3299  $ void+liner+kaolite+drum
c
c   Kaolite plug bottom ss  at 95.66655 cm level (height - 0.1524 cm)
c
  191  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 18.2499   $ ss (liner)
  192  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 18.6055   $ ss+void
  193  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 18.7579   $ ss+void+liner
  194  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 23.1775   $ ss+void+liner+kaolite
  195  rcc  0.0 0.0 95.66655  0.0 0.0  0.1524 23.3299   $ ss+void+liner+kaolite+drum
c
c   Kaolite top plug bottom section  at 95.81895 cm level (height - 7.68604 cm)
c
  201  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.0975  $ kaolite
  202  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.2499  $ kaolite +liner
  203  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.6055  $ kaolite+liner+void
  204  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 18.7579  $ kaolite+liner+void+liner
  205  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 23.1775  $ kaolite+liner+void+liner+kaolite
  206  rcc  0.0 0.0 95.81895  0.0 0.0  7.68604 23.3299  $
kaolite+liner+void+liner+kaolite+drum
c
c   Kaolite top plug (iron angle bottom section) at 103.50499 cm level (height - 4.4450 cm)
c
  211  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.0975  $ kaolite
  212  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.2499  $ kaolite +liner
  213  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.6055  $ kaolite+liner+void
  214  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  18.7579  $ kaolite+liner+void+liner
  215  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  19.3929  $ kaolite+liner+void+liner+iron-angle
  216  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  23.1775  $
kaolite+liner+void+liner+iron-angle+kaolite
  217  rcc 0.0 0.0 103.50499  0.0 0.0  4.4450  23.3299  $
kaolite+liner+void+liner+iron-angle+kaolite+drum
c
c   Kaolite top plug (iron angle top section) at 107.94999 cm level (height - 0.1118 cm)
c
  221  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.0975  $ kaolite
  222  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.2499  $ kaolite +liner
  223  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.6055  $ kaolite+liner+void
  224  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  18.7579  $ kaolite+liner+void+liner
  225  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  23.1775  $ kaolite+liner+void+liner+iron-angle
  226  rcc 0.0 0.0 107.94999  0.0 0.0  0.11176  23.3299  $
kaolite+liner+void+liner+iron-angle+drum
c
c   Kaolite top plug (iron angle top section) at 108.06175 cm level (height - 0.1524 cm)
c
  231  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  18.2499  $ ss liner
  232  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  18.6055  $ ss liner+void
  233  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  18.7579  $ ss liner+void+liner
  234  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  23.1775  $ ss liner+void+liner+iron-angle
  235  rcc 0.0 0.0 108.06175  0.0 0.0  0.1524  23.3299  $ ss liner+void+liner+iron-angle+drum
c
c   Gap above Kaolite top plug at 108.21415 cm level (height - 0.37084 cm)
c
  241  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  18.6055  $ void
  242  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  18.7579  $ void+liner
  243  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  23.1775  $ void+liner+iron-angle
  244  rcc 0.0 0.0 108.21415  0.0 0.0  0.37084  23.3299  $ void+liner+iron-angle+drum
c
c   Top ss lid at 108.58499 cm level (height - 0.1524 cm)
c
```

```
  251  rcc 0.0 0.0 108.58499  0.0 0.0  0.1524  23.1140  $ ss lid
  252  rcc 0.0 0.0 108.58499  0.0 0.0  0.1524  23.1775  $ ss lid+void
  253  rcc 0.0 0.0 108.58499  0.0 0.0  0.1524  23.3299  $ ss lid+void+drum
c
c   Top ss lid at 108.73739 cm level (height - 1.7526 cm)
c
  261  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  22.9616  $ void
  262  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  23.1140  $ void+ss lid
  263  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  23.1775  $ void+ss lid+void
  264  rcc 0.0 0.0 108.73739  0.0 0.0  1.7526  23.3299  $ void+ss lid+void+drum
c
c   Segmented side volume detectors
c
  301  pz 13
  302  pz 14
  303  pz 15
  304  pz 16
  305  pz 17
  306  pz 18
  307  pz 19
  308  pz 20
  309  pz 21
  310  pz 22
  311  pz 23
  312  pz 24
  313  pz 25
  314  pz 26
  315  pz 27
  316  pz 28
  317  pz 29
  318  pz 30
  319  pz 31
  320  pz 32
  321  pz 33
  322  pz 34
  323  pz 35
  324  pz 36
  325  pz 37
  326  pz 38
  327  pz 39
  328  pz 40
  329  pz 41
  330  pz 42
  331  pz 43
  332  pz 44
  333  pz 45
  334  pz 46
  335  pz 47
  336  pz 48
  337  pz 49
  338  pz 50
  339  pz 51
  340  pz 52
  341  pz 53
  342  pz 54
  343  pz 55
  344  pz 56
  345  pz 57
  346  pz 58
  347  pz 59
  348  pz 60
```

```
  349  pz 61
  350  pz 62
  351  pz 63
  352  pz 64
  353  pz 65
  354  pz 66
  355  pz 67
  356  pz 68
  357  pz 69
  358  pz 70
  359  pz 71
  360  pz 72
  361  pz 73
  362  pz 74
  363  pz 75
  364  pz 76
  365  pz 77
  366  pz 78
  367  pz 79
  368  pz 80
  369  pz 81
  370  pz 82
  371  pz 83
  372  pz 84
  373  pz 85
  374  pz 86
  375  pz 87
  376  pz 88
  377  pz 89
c
c   Put volume source for top and bottom detectors
c
  501  rcc 0.0 0.0 -0.5  0.0 0.0  0.5  1.0          $ bottom surface vol detector
  502  rcc 0.0 0.0 108.73739  0.0 0.0  0.5  1.0     $ top surface vol detector
  551  rcc 0.0 0.0 -100.5  0.0 0.0  0.5  1.0        $ 1 m from bottom surface - vol detector
  552  rcc 0.0 0.0 208.73739  0.0 0.0  0.5  1.0     $ 1 m from top surface - vol detector
c
  999  sph  0.0 0.0  0.000  999.0                          $ boundary
c

c    ----------------------
c    Data Cards
c    ----------------------
mode  p
c
c      uranium metal (18.82 g/cc)
c
m1    92235.70c  -0.9500    $ U-235           95.0000  wt%
      92238.70c  -0.0500    $ U-238            5.0000  wt%
c
c      ss 304 (7.92 g/cc)
c
m2     6000.70c  -0.00080    $ Carbon(C)        0.0800  wt%
      14028.70c  -0.00919    $ Silicon(Si-28)   0.9187  wt%
      14029.70c  -0.00048    $ Si-29            0.0483  wt%
      14030.70c  -0.00033    $ Si-30            0.0330  wt%
      15031.70c  -0.00045    $ Phosphorus(P)    0.0450  wt%
      24050.70c  -0.00793    $ Cromium (Cr-50)  0.7930  wt%
      24052.70c  -0.15903    $ Cr-52           15.9029  wt%
      24053.70c  -0.01838    $ Cr-53            1.8380  wt%
      24054.70c  -0.00466    $ Cr-54            0.4661  wt%
```

```
      25055.70c  -0.02000    $ Manganese (Mn)   2.0000  wt%
      26054.70c  -0.03860    $ Iron (Fe-54)     3.8602  wt%
      26056.70c  -0.62838    $ Fe-56           62.8377  wt%
      26057.70c  -0.01477    $ Fe-57            1.4772  wt%
      26058.70c  -0.00200    $ Fe-58            0.2000  wt%
      28058.70c  -0.06384    $ Nickel (Ni-58)   6.3838  wt%
      28060.70c  -0.02544    $ Ni-60            2.5437  wt%
      28061.70c  -0.00112    $ Ni-61            0.1124  wt%
      28062.70c  -0.00364    $ Ni-62            0.3643  wt%
      28064.70c  -0.00096    $ Ni-64            0.0958  wt%
c
c      rubber foam (1.20 g/cc)
c
m3     1001.70c  -0.08157    $ Hydrogen (H)     8.1573 wt%
       6000.70c  -0.32377    $ Carbon (C)      32.3767 wt%
       8016.70c  -0.21520    $ Oxygen (O-16)   21.5196 wt%
       8017.70c  -0.00059    $ O-17 & O-18      0.0586 wt%
      14028.70c  -0.34806    $ Silicon(Si-28)  34.8061 wt%
      14029.70c  -0.01831    $ Si-29            1.8314 wt%
      14030.70c  -0.01250    $ Si-30            1.2503 wt%
c
c      kaolite (0.321 g/cc)
c
m4     8016.70c -0.4092    $ Oxygen (O-16)   40.9231 wt%
       8017.70c -0.0011    $ Oxygen (17&18)   0.1114 wt%
      11023.70c -0.0148    $ Sodium (Na)      1.4837 wt%
      12024.70c -0.0786    $ Magnesium (Mg-24)6.1579 wt%
      12025.70c -0.0081    $ Mg-25            0.8121 wt%
      12026.70c -0.0093    $ Mg-26            0.9298 wt%
      13027.70c -0.0508    $ Al               5.0808 wt%
      14028.70c -0.1576    $ Silicon (Si-28) 15.7596 wt%
      14029.70c -0.0083    $ Si-29            0.8292 wt%
      14030.70c -0.0057    $ Si-30            0.5661 wt%
      20040.70c -0.2121    $ Calcium (Ca-40) 21.2086 wt%
      20042.70c -0.0015    $ Ca-42            0.1490 wt%
      20043.70c -0.0003    $ Ca-43            0.0318 wt%
      20044.70c -0.0050    $ Ca-44            0.5031 wt%
      20046.70c -0.00001   $ Ca-46            0.0010 wt%
      20048.70c -0.0005    $ Ca-48            0.0491 wt%
      22046.70c -0.0006    $ Titanium (Ti-46) 0.0570 wt%
      22047.70c -0.0005    $ Ti-47            0.0525 wt%
      22048.70c -0.0053    $ Ti-48            0.5311 wt%
      22049.70c -0.0004    $ Ti-49            0.0398 wt%
      22050.70c -0.0004    $ Ti-50            0.0407 wt%
      26054.70c -0.0026    $ Iron (Fe-54)     0.2646 wt%
      26056.70c -0.0431    $ Fe-56            4.3066 wt%
      26057.70c -0.0010    $ Fe-57            0.1012 wt%
      26058.70c -0.0001    $ Fe-58            0.0137 wt%
c
c      Cat 277-4 (1.4586 g/cc)
c
m5     1001.70c -0.0285    $ Hydrogen         2.8475 wt%
       5010.70c -0.0066    $ Boron (B-10)     0.6591 wt%
       5011.70c -0.0297    $ Boron (B-11)     2.9726 wt%
       6000.70c -0.0136    $ Carbon (C)       1.3609 wt%
       7014.70c -0.0001    $ Nitrogen (N)     0.0100 wt%
       8016.70c -0.5325    $ Oxygen (O-16)   53.2515 wt%
       8017.70c -0.0015    $ Oxygen (17&18)   0.1450 wt%
      11023.70c -0.0008    $ Sodium (Na)      0.0833 wt%
      12024.70c -0.0019    $ Magnesium (Mg-24)0.1867 wt%
      12025.70c -0.0002    $ Mg-25            0.0246 wt%
```

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      12026.70c -0.0003    $ Mg-26            0.0282 wt%
      13027.70c -0.2769    $ Al              27.6937 wt%
      14028.70c -0.0161    $ Silicon (Si-28)  1.6075 wt%
      14029.70c -0.0008    $ Si-29            0.0846 wt%
      14030.70c -0.0006    $ Si-30            0.0577 wt%
      16032.70c -0.0021    $ Sulfur (S-32)    0.2071 wt%
      16033.70c -0.00002   $ S-33             0.0017 wt%
      16034.70c -0.0001    $ S-34             0.0098 wt%
      16036.70c -0.0000002 $ S-36             0.00002 wt%
      20040.70c -0.0811    $ Calcium (Ca-40)  8.1125 wt%
      20042.70c -0.0006    $ Ca-42            0.0569 wt%
      20043.70c -0.0001    $ Ca-43            0.0121 wt%
      20044.70c -0.0019    $ Ca-44            0.1920 wt%
      20046.70c -0.000004  $ Ca-46            0.0004 wt%
      20048.70c -0.0002    $ Ca-48            0.0188 wt%
      26054.70c -0.0002    $ Iron (Fe-54)     0.0212 wt%
      26056.70c -0.0035    $ Fe-56            0.3453 wt%
      26057.70c -0.00008   $ Fe-57            0.0081 wt%
      26058.70c -0.00001   $ Fe-58            0.0011 wt%
c
c       air (1.225e-3 g/cc)
c
m6      7014.70c  -0.755   $ Nitrogen (N-14) 75.5000 wt%
        8016.70c  -0.232   $ Oxygen (O-16)   23.2000 wt%
       18000.70c  -0.013   $ Argon (Ar-40)    1.3000 wt%
c
c      uranium oxide (10.960 g/cc - variable)
c
m7     8016.70c  -0.1198    $ O               11.9800  wt%
      92235.70c  -0.8362    $ U-235           83.6200  wt%
      92238.70c  -0.0440    $ U-238            4.4000  wt%
c
c    source in ES-3100 - cylindrical at the bottom of CV
c                        (H = 63.153 cm; R = 6.35 cm)
c
c   photon source - 3.011e+06 photons/sec/gm basis
c   material used - 24 kg UO2 (21.126 kg U-mass)
c   dose conversion factor (mrem/hr)/(photons/cm2-s) used
c   source term, wgt = 3.011e+06 * 21.126e+03  = 6.361039e+10
c
sdef pos=0 0 12.4968 rad=d1 ext=d2  erg=d3 axs=0 0 1 wgt=6.361039e+10
c
c  source position
c
si1    0.00     6.35         $ radial
sp1    -21       1
si2    0.0     47.365        $ axial
sp2     0        1
c
c  ORIGEN photon spectrum
c
si3     5.00e-03     1.00e-02    1.50e-02     2.00e-02    2.50e-02     3.00e-02
        4.00e-02     5.00e-02    6.00e-02     7.00e-02    8.00e-02     9.00e-02
        1.00e-01     2.00e-01    3.00e-01     4.00e-01    5.00e-01     6.00e-01
        7.00e-01     8.00e-01    9.00e-01     1.00e+00    1.10e+00     1.20e+00
        1.30e+00     1.40e+00    1.50e+00     1.60e+00    1.70e+00     1.80e+00
        1.90e+00     2.00e+00    2.10e+00     2.20e+00    2.30e+00     2.40e+00
        2.50e+00     2.60e+00    2.70e+00     2.80e+00    2.90e+00     3.00e+00
        3.50e+00     4.00e+00    5.00e+00     6.50e+00    8.00e+00    10.00e+00
sp3     0.0          8.515e+04   1.700e+06    7.313e+03   3.595e+03    1.230e+05
        5.112e+03    6.605e+03   2.147e+05    1.779e+03   1.941e+04    1.085e+05
```

```
        2.244e+05    1.328e+05   5.245e+04    2.819e+05   1.556e+04    1.225e+04
        1.485e+02    2.705e+03   1.802e+03    4.068e+02   2.527e+02    2.157e+01
        2.105e+01    2.990e+01   1.300e+01    1.386e+02   4.719e+02    5.522e+00
        2.999e+01    4.918e+00   1.599e-02    1.308e-02   7.152e-02    5.321e-04
        1.584e-02    6.552e-05   1.062e+04    1.108e-02   1.917e-04    3.408e-04
        6.039e-01    3.876e-01   2.959e-03    1.134e-03   2.131e-04    4.388e-05
c
c  volume detector at the bottom surface of the drum
c
f4:p  501            $ bottom surface volume detector
f14:p 502            $ top surface volume detector
f24:p 551            $ 1 m from bottom surface  - volume detector
f34:p 552            $ 1 m from top surface  - volume detector
c
c  segmented volume detectors for primary photons
c  (13 cm through 99 cm)
c
c  side surface
c
f114:p 109
fs114  -301 -302 -303 -304 -305 -306 -307 -308 -309 -310
       -311 -312 -313 -314 -315 -316 -317 -318 -319 -320
       -321 -322 -323 -324 -325 -326 -327 -328 -329 -330
       -331 -332 -333 -334 -335 -336 -337 -338 -339 -340
       -341 -342 -343 -344 -345 -346 -347 -348 -349 -350
       -351 -352 -353 -354 -355 -356 -357 -358 -359 -360
       -361 -362 -363 -364 -365 -366 -367 -368 -369 -370
       -371 -372 -373 -374 -375 -376 -377
c
c  1 m from side surface
c
f134:p  111
fs134  -301 -302 -303 -304 -305 -306 -307 -308 -309 -310
       -311 -312 -313 -314 -315 -316 -317 -318 -319 -320
       -321 -322 -323 -324 -325 -326 -327 -328 -329 -330
       -331 -332 -333 -334 -335 -336 -337 -338 -339 -340
       -341 -342 -343 -344 -345 -346 -347 -348 -349 -350
       -351 -352 -353 -354 -355 -356 -357 -358 -359 -360
       -361 -362 -363 -364 -365 -366 -367 -368 -369 -370
       -371 -372 -373 -374 -375 -376 -377
c
fq0 f s d
c
c  point detectors for primary photons
c
f5:p    23.4299  0.0     36.1793   0.0     $ side surface - detector
f15:p    0.0     0.0    108.83739  0.0     $ top surface - detector
f25:p    0.0     0.0     -0.1      0.0     $ bottom surface - detector
f35:p  123.3299  0.0     36.1793   0.0     $ 1m from side surface - detector
f45:p    0.0     0.0    208.73739  0.0     $ 1m from top surface - detector
f55:p    0.0     0.0   -100.0      0.0     $ 1m from bottom surface - detector
c
c ANSI/ANS-6.1.1-1977 photon flux to dose rate conversion factor
c                                  (mrem/hr)/(photons/cm2-s)
c
de0         0.01      0.03      0.05      0.07       0.1      0.15      0.20
            0.25      0.30      0.35      0.40       0.45     0.50      0.55
            0.60      0.65      0.70      0.8        1.0      1.4       1.8
            2.2       2.6       2.8       3.25       3.75     4.25      4.75
            5.00      5.25      5.75      6.25       6.75     7.50      9.0
           11.0      13.0      15.0
```

```
c
df0      3.96e-3   5.82e-4   2.90e-4   2.58e-4   2.83e-4   3.79e-4   5.01e-4
         6.31e-4   7.59e-4   8.78e-4   9.85e-4   1.08e-3   1.17e-3   1.27e-3
         1.36e-3   1.44e-3   1.52e-3   1.68e-3   1.98e-3   2.51e-3   2.99e-3
         3.42e-3   3.82e-3   4.01e-3   4.41e-3   4.83e-3   5.23e-3   5.60e-3
         5.80e-3   6.01e-3   6.37e-3   6.74e-3   7.11e-3   7.66e-3   8.77e-3
         1.03e-2   1.18e-2   1.33e-2
c
prdmp  j  50000000 0 10
ctme 1000
```

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Appendix 5.5.3
Comparative NCT Dose Rates for Kaolite and Packcrete

The material properties of the impact-limiting and thermal-insulating materials, Kaolite and Packcrete, used in the ES-3100 shielding models for the comparative dose rate calculations are shown in Table 5.5.3.1. In this comparative study, Packcrete with a density of 0.31076 g/cm^3 (19.4 lb/ft^3) [Table1, RP 802282-0002 000 02] is used for dose rate calculations instead of Kaolite with a density of 0.321 g/cm^3. The properties of the other packaging materials remain invariant in the dose rate calculations. Dose rates are calculated at 1 mm and 1 m from the side, top, and bottom surfaces for the 36 kg solid cylinder at the top of the CV, bottom of the CV, cylindrical hemi-shell, cylindrical shell, rectangular plate, cylindrical rod, and cylindrical segment configurations. The same source configurations are used in Table 5.7 for side dose rates for the various highly enriched uranium metal source configurations. In addition, dose rates are also compared for the 24 kg UO_2 powder source configuration. The calculated dose rates are presented in Tables 5.5.3.2–5.5.3.7. There are minor statistical differences among the calculated dose rates for different source configurations using either Kaolite or Packcrete as the impact-limiting and thermal-insulating material. Therefore, it can be concluded that the shielding evaluation for the ES-3100 package with Kaolite validates the use of the ES-3100 package with Packcrete as the impact-limiting and thermal-insulating material.

Table 5.5.3.1. Shielding model Kaolite and Packcrete material specifications

Material	Density (g/cm^3)	Constituent	Weight percent
Kaolite	0.321	^{16}O	40.9231
		^{17}O and ^{18}O	0.1114
		^{23}Na	1.4837
		^{24}Mg	6.1579
		^{25}Mg	0.8121
		^{26}Mg	0.9298
		^{27}Al	5.0808
		^{28}Si	15.7596
		^{29}Si	0.8292
		^{30}Si	0.5661
		^{40}Ca	21.2086
		^{42}Ca	0.1490
		^{43}Ca	0.0318
		^{44}Ca	0.5031
		^{46}Ca	0.0010
		^{48}Ca	0.0491
		^{46}Ti	0.0570
		^{47}Ti	0.0525
		^{48}Ti	0.5311
		^{49}Ti	0.0398
		^{50}Ti	0.0407
		^{54}Fe	0.2646
		^{56}Fe	4.3066
		^{57}Fe	0.1012
		^{58}Fe	0.0137

Table 5.5.3.1. Shielding model Kaolite and Packcrete material specifications

Material	Density (g/cm^3)	Constituent	Weight percent
Packcrete [a]	0.31076	^{1}H	1.3584
		^{16}O	44.8207
		^{17}O and ^{18}O	0.1219
		^{23}Na	0.0668
		^{24}Mg	3.6430
		^{25}Mg	0.4804
		^{26}Mg	0.5501
		^{27}Al	4.2128
		^{28}Si	10.9501
		^{29}Si	0.5761
		^{30}Si	0.3933
		^{32}S	0.8231
		^{33}S	0.0067
		^{34}S	0.0391
		^{36}S	0.0001
		^{39}K	1.5276
		^{40}K	0.0002
		^{41}K	0.1159
		^{40}Ca	24.4215
		^{42}Ca	0.1652
		^{43}Ca	0.0353
		^{44}Ca	0.5579
		^{46}Ca	0.0011
		^{48}Ca	0.0546
		^{46}Ti	0.0451
		^{47}Ti	0.0420
		^{48}Ti	0.4205
		^{49}Ti	0.0315
		^{50}Ti	0.0308
		^{54}Fe	0.2444
		^{56}Fe	3.9788
		^{57}Fe	0.0935
		^{58}Fe	0.0127
		^{138}Ba	0.1791

[a] Composition representative for Sample ID 3621411 in Table 1 of RP 802282-0002.

Table 5.5.3.2. Dose rates 1 mm from package side surface using Kaolite and Packcrete for NCT

Configuration	Dimension [a] (cm)	Kaolite			Packcrete			Difference between Packcrete and Kaolite
		Photon	Neutron [b]	Photon and neutron	Photon	Neutron [b]	Photon and neutron	Photon and neutron
		Dose rates (mrem/h) ± 1σ uncertainty (%) [c]						(%)
Solid cylinder at the top of CV	Radius = 6.35 Height = 15.1003	49.6250 ± 0.66%	1.5786 ± 0.32%	51.2036 ± 0.64%	49.8840 ± 0.67%	1.5088 ± 0.38%	51.3928 ± 0.65%	0.37%
Solid cylinder at the bottom of CV	Radius = 6.35 Height = 15.1003	51.4160 ± 0.77%	1.1937 ± 0.27%	52.6097 ± 0.75%	51.2100 ± 0.69%	1.1371 ± 0.29%	52.3471 ± 0.68%	−0.50%
Cylindrical hemi-shell	IR = 4.9337 OR = 6.35	95.8000 ± 1.47%	0.1335 ± 0.38%	95.9335 ± 1.47%	95.1360 ± 0.44%	0.1269 ± 0.34%	95.2629 ± 0.44%	−0.70%
Cylindrical shell	IR = 5.6861 OR = 6.35	93.4120 ± 2.02%	0.1039 ± 1.07%	93.5159 ± 2.02%	91.6510 ± 0.48%	0.0964 ± 0.66%	91.7474 ± 0.48%	−1.89%
Rectangular plate	Width = 1.9829 Length = 12.66	91.6170 ± 1.50%	0.1214 ± 0.58%	91.7384 ± 1.50%	91.4830 ± 1.49%	0.1161 ± 0.72%	91.5991 ± 1.49%	−0.15%
Cylindrical rod	Radius = 2.82675	58.7820 ± 0.46%	0.1626 ± 1.18%	58.9446 ± 0.46%	59.2640 ± 0.57%	0.1534 ± 0.66%	59.4174 ± 0.57%	0.80%
Cylindrical segment	Depth = 3.20548	94.3050 ± 1.19%	0.1757 ± 1.74%	94.4807 ± 1.19%	93.5370 ± 0.66%	0.1636 ± 0.72%	93.7006 ± 0.66%	−0.83%
UO_2 powder	Radius = 6.35 Height = 75.785	77.2340 ± 0.80%	0.0556 ± 0.47%	77.2896 ± 0.80%	77.7050 ± 0.96%	0.0526 ± 0.41%	77.7576 ± 0.96%	0.61%

[a] Height is 76.2 cm for all configurations except solid cylinders at the top or bottom of CV and UO_2 powder configurations.
[b] Includes secondary photons.
[c] MCNP5 Monte Carlo code results (LA-UR-03-1987). The uncertainty associated with the results is one standard deviation of the mean (i.e., 1σ uncertainty expressed as a percentage of the mean) calculated using MCNP5.

Table 5.5.3.3. Dose rates 1 mm from package top surface using Kaolite and Packcrete for NCT

Configuration	Dimension [a] (cm)	Kaolite			Packcrete			Difference between Packcrete and Kaolite
		Photon	Neutron [b]	Photon and neutron	Photon	Neutron [b]	Photon and neutron	Photon and neutron
		Dose rates (mrem/h) ± 1σ uncertainty (%) [c]						(%)
Solid cylinder at the top of CV	Radius = 6.35 Height = 15.1003	23.0400 ± 0.99%	1.3255 ± 0.35%	24.3655 ± 0.94%	23.2320 ± 1.10%	1.2481 ± 0.37%	24.4801 ± 1.04%	0.47%
Solid cylinder at the bottom of CV	Radius = 6.35 Height = 15.1003	1.1715 ± 2.19%	0.0454 ± 0.56%	1.2169 ± 2.11%	1.1703 ± 2.15%	0.0446 ± 1.26%	1.2149 ± 2.07%	−0.17%
Cylindrical hemi-shell	IR = 4.9337 OR = 6.35	9.3716 ± 0.71%	0.0339 ± 0.55%	9.4055 ± 0.71%	9.3618 ± 0.67%	0.0316 ± 0.48%	9.3934 ± 0.67%	−0.13%
Cylindrical shell	IR = 5.6861 OR = 6.35	16.5070 ± 2.01%	0.0363 ± 1.43%	16.5433 ± 2.01%	16.5990 ± 2.01%	0.0355 ± 3.27%	16.6345 ± 2.01%	0.55%
Rectangular plate	Width = 1.9829 Length = 12.66	5.9658 ± 1.28%	0.0295 ± 3.14%	5.9953 ± 1.27%	5.9502 ± 1.19%	0.0270 ± 1.63%	5.9772 ± 1.18%	−0.30%
Cylindrical rod	Radius = 2.82675	5.1016 ± 2.84%	0.0321 ± 1.35%	5.1337 ± 2.82%	5.1410 ± 2.51%	0.0297 ± 1.17%	5.1707 ± 2.50%	0.72%
Cylindrical segment	Depth = 3.20548	6.7257 ± 1.78%	0.0322 ± 1.06%	6.7579 ± 1.77%	6.7967 ± 1.96%	0.0309 ± 1.55%	6.8276 ± 1.95%	1.03%
UO_2 powder	Radius = 6.35 Height = 75.785	11.1210 ± 0.91%	0.0172 ± 0.58%	11.1382 ± 0.91%	11.1160 ± 0.80%	0.0165 ± 0.67%	11.1325 ± 0.80%	−0.05%

[a] Height is 76.2 cm for all configurations except solid cylinders at the top or bottom of CV and UO_2 powder configurations.
[b] Includes secondary photons.
[c] MCNP5 Monte Carlo code results (LA-UR-03-1987). The uncertainty associated with the results is one standard deviation of the mean (i.e., 1σ uncertainty expressed as a percentage of the mean) calculated using MCNP5.

Table 5.5.3.4. Dose rates 1 mm from package bottom surface using Kaolite and Packcrete for NCT

Configuration	Dimension [a] (cm)	Kaolite			Packcrete			Difference between Packcrete and Kaolite
		Photon	Neutron [b]	Photon and neutron	Photon	Neutron [b]	Photon and neutron	Photon and neutron
		Dose rates (mrem/h) ± 1σ uncertainty (%) [c]						(%)
Solid cylinder at the top of CV	Radius = 6.35 Height = 15.1003	3.1424 ± 3.87%	0.1191 ± 0.94%	3.2615 ± 3.73%	3.0867 ± 1.90%	0.1132 ± 0.76%	3.1999 ± 1.83%	−1.89%
Solid cylinder at the bottom of CV	Radius = 6.35 Height = 15.1003	80.0030 ± 0.64%	2.0354 ± 0.36%	82.0384 ± 0.62%	79.7770 ± 0.62%	1.9515 ± 0.32%	81.7285 ± 0.61%	−0.38%
Cylindrical hemi-shell	IR = 4.9337 OR = 6.35	41.1910 ± 0.8%	0.0817 ± 0.43%	41.2727 ± 0.80%	41.0830 ± 0.67%	0.0788 ± 0.51%	41.1618 ± 0.67%	−0.27%
Cylindrical shell	IR = 5.6861 OR = 6.35	71.1790 ± 0.88%	0.0881 ± 0.86%	71.2671 ± 0.88%	71.2960 ± 0.87%	0.0864 ± 1.15%	71.3824 ± 0.87%	0.16%
Rectangular plate	Width = 1.9829 Length = 12.66	24.3270 ± 1.21%	0.0623 ± 1.62%	24.3893 ± 1.21%	24.1660 ± 0.92%	0.0592 ± 1.66%	24.2252 ± 0.92%	−0.67%
Cylindrical rod	Radius = 2.82675	20.4820 ± 1.15%	0.0716 ± 0.91%	20.5536 ± 1.15%	20.5770 ± 1.27%	0.0684 ± 1.00%	20.6454 ± 1.27%	0.45%
Cylindrical segment	Depth = 3.20548	28.6270 ± 1.41%	0.0764 ± 1.20%	28.7034 ± 1.41%	28.5520 ± 1.37%	0.0748 ± 2.12%	28.6268 ± 1.37%	−0.27%
UO_2 powder	Radius = 6.35 Height =75.785	51.5560 ± 1.52%	0.0417 ± 0.53%	51.5977 ± 1.52%	51.8220 ± 1.55%	0.0400 ± 0.45%	51.8620 ± 1.55%	0.51%

[a] Height is 76.2 cm for all configurations except solid cylinders at the top or bottom of CV and UO_2 powder configurations.
[b] Includes secondary photons.
[c] MCNP5 Monte Carlo code results (LA-UR-03-1987). The uncertainty associated with the results is one standard deviation of the mean (i.e., 1σ uncertainty expressed as a percentage of the mean) calculated using MCNP5.

Table 5.5.3.5. Dose rates 1 m from package side surface using Kaolite and Packcrete for NCT

Configuration	Dimension [a] (cm)	Kaolite			Packcrete			Difference between Packcrete and Kaolite
		Photon	Neutron [b]	Photon and neutron	Photon	Neutron [b]	Photon and neutron	Photon and neutron
		Dose rates (mrem/h) ± 1σ uncertainty (%) [c]						(%)
Solid cylinder at the top of CV	Radius = 6.35 Height = 15.1003	1.5469 ± 0.10%	0.0510 ± 0.19%	1.5979 ± 0.10%	1.5494 ± 0.09%	0.0483 ± 0.19%	1.5977 ± 0.09%	−0.01%
Solid cylinder at the bottom of CV	Radius = 6.35 Height = 15.1003	1.6255 ± 0.10%	0.0383 ± 0.15%	1.6638 ± 0.10%	1.6276 ± 0.10%	0.0364 ± 0.15%	1.6640 ± 0.10%	0.01%
Cylindrical hemi-shell	IR = 4.9337 OR = 6.35	6.0639 ± 0.06%	0.0073 ± 0.02%	6.0712 ± 0.06%	6.0766 ± 0.06%	0.0070 ± 0.02%	6.0836 ± 0.06%	0.20%
Cylindrical shell	IR = 5.6861 OR = 6.35	6.0067 ± 0.05%	0.0060 ± 0.05%	6.0127 ± 0.05%	6.0163 ± 0.05%	0.0057 ± 0.05%	6.0220 ± 0.05%	0.16%
Rectangular plate	Width = 1.9829 Length = 12.66	5.8423 ± 0.05%	0.0071 ± 0.05%	5.8494 ± 0.05%	5.8541 ± 0.05%	0.0068 ± 0.05%	5.8609 ± 0.05%	0.20%
Cylindrical rod	Radius = 2.82675	3.5115 ± 0.07%	0.0086 ± 0.05%	3.5201 ± 0.07%	3.5187 ± 0.07%	0.0082 ± 0.06%	3.5269 ± 0.07%	0.19%
Cylindrical segment	Depth = 3.20548	5.5070 ± 0.05%	0.0089 ± 0.05%	5.5159 ± 0.05%	5.5184 ± 0.05%	0.0084 ± 0.05%	5.5268 ± 0.05%	0.20%
UO_2 powder	Radius = 6.35 Height =75.785	4.9800 ± 0.06%	0.0032 ± 0.02%	4.9832 ± 0.06%	4.9910 ± 0.06%	0.0031 ± 0.02%	4.9941 ± 0.06%	0.22%

[a] Height is 76.2 cm for all configurations except solid cylinders at the top or bottom of CV and UO_2 powder configurations.
[b] Includes secondary photons.
[c] MCNP5 Monte Carlo code results (LA-UR-03-1987). The uncertainty associated with the results is one standard deviation of the mean (i.e., 1σ uncertainty expressed as a percentage of the mean) calculated using MCNP5.

Table 5.5.3.6. Dose rates 1 m from package top surface using Kaolite and Packcrete for NCT

Configuration	Dimension [a] (cm)	Kaolite			Packcrete			Difference between Packcrete and Kaolite
		Photon	Neutron [b]	Photon and neutron	Photon	Neutron [b]	Photon and neutron	Photon and neutron
		Dose rates (mrem/h) ± 1σ uncertainty (%) [c]						(%)
Solid cylinder at the top of CV	Radius = 6.35 Height = 15.1003	0.6720 ± 0.15%	0.0381 ± 0.19%	0.7101 ± 0.14%	0.6733 ± 0.15%	0.0360 ± 0.19%	0.7093 ± 0.14%	−0.12%
Solid cylinder at the bottom of CV	Radius = 6.35 Height = 15.1003	0.1665 ± 0.18 %	0.0051 ± 0.15%	0.1716 ± 0.17%	0.1671 ± 0.18%	0.0045 ± 0.16%	0.1716 ± 0.18%	0.05%
Cylindrical hemi-shell	IR = 4.9337 OR = 6.35	0.3821 ± 0.43%	0.0013 ± 0.04%	0.3834 ± 0.43%	0.3830 ± 0.44%	0.0012 ± 0.04%	0.3842 ± 0.44%	0.20%
Cylindrical shell	IR = 5.6861 OR = 6.35	0.5660 ± 0.24%	0.0013 ± 0.10%	0.5673 ± 0.24%	0.5674 ± 0.30%	0.0012 ± 0.10%	0.5686 ± 0.30%	0.23%
Rectangular plate	Width = 1.9829 Length = 12.66	0.3089 ± 0.36%	0.0012 ± 0.11%	0.3101 ± 0.36%	0.3087 ± 0.34%	0.0011 ± 0.12%	0.3098 ± 0.34%	−0.09%
Cylindrical rod	Radius = 2.82675	0.2268 ± 0.15%	0.0013 ± 0.11%	0.2281 ± 0.15%	0.2271 ± 0.15%	0.0012± 0.12%	0.2283 ± 0.15%	0.09%
Cylindrical segment	Depth = 3.20548	0.2853 ± 0.2%	0.0013 ± 0.11%	0.2866 ± 0.20%	0.2852 ± 0.14%	0.0012 ± 0.12%	0.2864 ± 0.14%	−0.05%
UO_2 powder	Radius = 6.35 Height =75.785	0.5285 ± 0.22%	0.0008 ± 0.04%	0.5293 ± 0.22%	0.5290 ± 0.22%	0.0007 ± 0.04%	0.5297 ± 0.22%	0.09%

[a] Height is 76.2 cm for all configurations except solid cylinders at the top or bottom of CV and UO_2 powder configurations.
[b] Includes secondary photons.
[c] MCNP5 Monte Carlo code results (LA-UR-03-1987). The uncertainty associated with the results is one standard deviation of the mean (i.e., 1σ uncertainty expressed as a percentage of the mean) calculated using MCNP5.

Table 5.5.3.7. Dose rates 1 m from package bottom surface using Kaolite and Packcrete for NCT

Configuration	Dimension [a] (cm)	Kaolite			Packcrete			Difference between Packcrete and Kaolite
		Photon	Neutron [b]	Photon and neutron	Photon	Neutron [b]	Photon and neutron	Photon and neutron
		Dose rates (mrem/h) ± 1σ uncertainty (%) [c]						(%)
Solid cylinder at the top of CV	Radius = 6.35 Height = 15.1003	0.4135 ± 0.28%	0.0132 ± 0.19%	0.4267 ± 0.27%	0.4153 ± 0.28%	0.0121 ± 0.19%	0.4274 ± 0.27%	0.15%
Solid cylinder at the bottom of CV	Radius = 6.35 Height = 15.1003	1.4337 ± 0.15%	0.0416 ± 0.15%	1.4753 ± 0.15%	1.4358± 0.15%	0.0400 ± 0.15%	1.4758 ± 0.15%	0.03%
Cylindrical hemi-shell	IR = 4.9337 OR = 6.35	0.8479 ± 0.13%	0.0019 ± 0.03%	0.8498 ± 0.13%	0.8477 ± 0.13%	0.0018 ± 0.03%	0.8495 ± 0.13%	−0.03%
Cylindrical shell	IR = 5.6861 OR = 6.35	1.2700 ± 0.07%	0.0021 ± 0.08%	1.2721 ± 0.07%	1.2699 ± 0.07%	0.0020 ± 0.08%	1.2719 ± 0.07%	−0.02%
Rectangular plate	Width = 1.9829 Length = 12.66	0.6639 ± 0.13%	0.0018 ± 0.09%	0.6657 ± 0.13%	0.6641 ± 0.13%	0.0017 ± 0.10%	0.6658 ± 0.13%	0.02%
Cylindrical rod	Radius = 2.82675	0.4966 ± 0.1%	0.0020 ± 0.10%	0.4986 ± 0.10%	0.4970 ± 0.10%	0.0019 ± 0.10%	0.4989 ± 0.10%	0.07%
Cylindrical segment	Depth = 3.20548	0.6320 ± 0.09%	0.0020 ± 0.09%	0.6340 ± 0.09%	0.6319 ± 0.11%	0.0019 ± 0.10%	0.6338 ± 0.11%	−0.02%
UO_2 powder	Radius = 6.35 Height =75.785	1.2676 ± 0.10%	0.0013 ± 0.03%	1.2689 ± 0.10%	1.2690 ± 0.09%	0.0012 ± 0.03%	1.2702 ± 0.09%	0.11%

[a] Height is 76.2 cm for all configurations except solid cylinders at the top or bottom of CV and UO_2 powder configurations.
[b] Includes secondary photons.
[c] MCNP5 Monte Carlo code results (LA-UR-03-1987). The uncertainty associated with the results is one standard deviation of the mean (i.e., 1σ uncertainty expressed as a percentage of the mean) calculated using MCNP5.

Appendix 5.5.4
Chapter 5 References

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6. CRITICALITY EVALUATION

This chapter describes the criticality safety evaluation of the Y-12 National Security Complex (Y-12) Model ES-3100 package with solid highly enriched uranium (HEU) metal or alloys (specific information for alloys are addressed in Sects. 6.2.1, 6.2.4, 6.3.2, 6.4, 6.4.1, and 6.6.1), or HEU oxide, or highly enriched uranyl nitrate crystals (UNX). HEU metal or alloy may be in the form of solid shapes (cylinders, bars, buttons, billets, slugs, unirradiated TRIGA fuel), broken metal, turnings, fines, powder, or content of an unspecified geometric shape and characterized as broken metal. Distinguished from TRIGA contents, the research reactor related contents covered under this criticality evaluation are fuel elements or fuel components, broken metal, U alloys, or oxides.

A variety of similar materials from various reactor programs were added under a subsequent revision of the criticality safety evaluation (Appendix 6.9.8). These additional contents include bare, clad or canned uranium metal alloy or oxide in various shapes as pellets, rods, plates, bundled components and fuel assemblies. Compounds of uranium include uranium tetrafluoride, uranyl fluoride, uranium carbide, and uranium nitride. The physical form of these uranium compounds is described as powder, beads, and ash. Both content moisture and content uniformity are not defined. The criticality evaluation has been updated as discussed in Appendices 6.9.9, 6.9.10, and 6.9.11.

Physical testing of Type-B fissile material packages for surface transportation conducted in accordance with the physical testing requirements of 10 CFR 71 is limited to the ES-3100 packaging and non-fissile dummy contents. Consequently, analytic methods are used to demonstrate compliance of the ES-3100 package with the applicable performance requirements in 10 CFR 71. The specific requirements investigated for compliance in this evaluation are contained in 10 CFR 71.55, "General Requirements of all Fissile Material Packages," and 10 CFR 71.59, "Standards for Arrays of Fissile Material Packages." Physical testing of Type-B fissile material packages transported by air is not conducted for the ES-3100. Analytic methods are also used to demonstrate compliance of the ES-3100 package with the requirements of 10 CFR 71.55(f). This is accomplished by demonstrating compliance of the package with the more stringent requirements of the International Atomic Energy Agency (IAEA) for situations where the conditions of the fissile material package following the tests cannot be demonstrated (IAEA SSG-26, Para. 683.2).

6.1 DESCRIPTION OF THE CRITICALITY DESIGN

6.1.1 Design Features

The principal design feature of interest in the criticality evaluation of the Model ES-3100 package is the containment/outer drum system (Drawing M2E801580A031, Appendix 1.3.7). The ES-3100 package uses a single containment system (Drawing M2E801580A011, Appendix 1.3.7) to contain the HEU contents. The containment is a high-integrity, watertight, post-load leak-testable, stainless-steel vessel (Fig. 1.3). The outer drum system (Drawing M2E801580A001, Appendix 1.3.7) is a recessed, double-compartment body with a removable top for insertion and removal of the containment vessel (CV). The body weldment liner outer cavity and the top plug weldment contain Kaolite 1600 (Kaolite), a thermal insulation material that protects the CV from thermal absorption, shock and impact. The body weldment liner inner cavity contains a neutron poison, "277-4," which serves as a strong neutron absorber. Other chapters of this report (Chaps. 2, 3, and 4) demonstrate the integrity of the ES-3100 package [i.e., that this single CV remains intact and watertight under the Normal Conditions of Transport (NCT) and Hypothetical Accident Conditions (HAC)].

Typical shipping configurations inside the ES-3100 containment vessel are illustrated in Fig. 1.4. The 277-4 canned spacers will only be used for contents shipped in metal convenience cans. Three 4.25-in.-diam × 10.0-in.-tall or six 4.25-in.-diam × 4.88-in.-tall convenience cans separated by can pads may be placed inside the 31-in.-tall cavity of the ES-3100 containment vessel (Fig. 1.4). Other can arrangements fit inside the containment vessel, such as three 4.25-in.-diam × 8.75-in.-tall or five 4.25-in.-diam × 4.88-in.-tall convenience cans. Both of these can arrangements include can pads and 277-4 canned spacers with overall dimensions of 4.25-in. diam × 1.82-in. height (Drawing M2E801580A043, Appendix 1.3.7). Nickel alloy cans are ~3-in. diam × 4.75-in. tall. Up to three Teflon bottles (4.69-in. diam × 9.4-in. tall) or three polyethylene bottles (4.94-in. diam × 8.7-in. tall) will fit inside the containment vessel; however, 277-4 canned spacers are not used with these configurations. If closed convenience cans with an outer diameter >4.25 in. are used, at least 43 $in.^3$ of free or void volume must exist inside the containment vessel to allow for gas expansion and offgassing of material at temperatures associated with NCT or HAC.

A modified convenience can may be used to package the TRIGA and research reactor related contents that do not fit inside these containers. A 17.5-in.- or 30-in.-tall convenience can is constructed from two 4.25-in.-diam × 8.75-in.-tall or three 10-in. cans brazed together. The research reactor fuel elements and fuel components that cannot be packaged in these convenience cans due to their overall dimensions will be bundled together and protected on each end with an open-ended convenience can having an outer diameter ≤ 5 in. Solid form HEU contents (i.e., spheres, cylinders, bars, slugs, etc.) that will not fit in a 4.25-in. convenience can may be bagged only with no convenience can required around the content. For contents that are bagged only, stainless-steel metal scrubbers may be placed on the top and bottom of this assembly inside the CV. For these bagged contents, the void volume requirement stated in Sect. 1.2.2.8, *Loading restrictions*, Item 8 must still be satisfied.

Credit is not taken in this criticality analysis for fissile material spacing provided by the presence of the convenience cans or bottles inside the CV. These containers are not manufactured to the American Society of Mechanical Engineers *Boiler and Pressure Vessel Code*, Sect. III, Subsection NG, or better.

6.1.2 Codes and Standards

Testing conducted in accordance with the physical testing requirements of 10 CFR 71 demonstrated that water leakage into the containment is not a credible event under the NCT and HAC. As directed, credit for the high-integrity, watertight containment is not taken in this criticality evaluation per discussions held at public meetings at the U.S. Nuclear Regulatory Commission (Docket 71-9315).

Liquid HEU is not being shipped in the ES-3100. With the exception of UNX crystals, the other uranium contents being shipped are not soluble in water and do not form solutions. The hypothetical occurrence of uranyl nitrate solution is evaluated as a consequence of evaluating the presence of water inside the CV. Thus, uranyl nitrate solution is evaluated even though it is not shipped as an approved package content in the ES-3100.

10 CFR 71.55(b) requires the evaluation of water leakage into the CV or leakage of liquid contents out of the CV and other conditions that produce maximum reactivity in the single package. For solid uranium contents, water leakage conditions are simulated by flooding all regions outside and inside of the CV, including the sealed convenience cans. For liquid uranium "contents," water leakage conditions are simulated by flooding all regions outside the CV except the CV well. The uranyl nitrate (UN) solution resides inside both the CV well and the CV, including the Teflon bottles. Per 10 CFR 71.55(b), a flooded CV under full water reflection is also evaluated. Under such leakage conditions, the calculated neutron multiplication factor ($k_{eff} + 2\sigma$) for the ES-3100 package with HEU contents is lower than the upper subcritical limit (USL) for a subcritical system. Water inleakage into the CV or liquid content leakage out of the CV will not produce a criticality in the CV of a disassembled

package or an assembled single package. Therefore, the Model ES-3100 shipping package complies with all of the requirements of 10 CFR 71.55(b) and (d).

While the loss of containment is deemed incredible by merit of the results of the physical tests performed under 10 CFR 71.71 and 10 CFR 71.73, credit for the high-integrity, watertight containment is not taken in the single package analysis [10 CFR 71.55(d) and (e)]. Only partial credit is taken in the package array analysis (10 CFR 71.59). In both the single package and package array analyses, the CV is flooded with water. This fictitious "evaluation" water provides moderation to such an extent as to cause maximum reactivity of the content consistent with the chemical and physical form of the material present. While UN crystals are soluble in water, leakage of UN solution out of the CV for undamaged packages under 10 CFR 71.59 (a)(1) or damaged packages under 10 CFR 71.59 (a)(2) is not considered credible during NCT or HAC based on results for tests specified in 10 CFR 71.71 and 10 CFR 71.73. Because credit for the high-integrity, watertight containment is not fully taken in the criticality evaluation, the fissile mass loading limits are very conservative.

The NCT tests under 10 CFR 71.71 and the HAC tests under 10 CFR 71.73 demonstrate that containment is not breached. Nevertheless, CV flooding is assumed in the criticality calculations performed for the derivation of fissile material loading limits. The 7.1–10.1 kg quantities of evaluation water in both the NCT and HAC criticality calculations are not actually present in the CV. Simulation of this condition in the criticality calculations produces fissile material content that is more reactive than actual.

The 7.1–10.1 kg quantity of evaluation water does not necessarily bound reasonable amounts of hydrogenous packing material present inside the CV when the fissile material is in particulate form (primarily HEU oxides and UNX crystals) or must be evaluated as particulate matter (broken metal). Packing materials include can pads; polyethylene, nylon, and Teflon bags; vinyl tape; and polyethylene or Teflon bottles, if used. An administrative criticality control is used to restrict the amount of hydrogenous packing material normally present inside the CV (Item 7 in Sect. 6.2.4).

Under NCT and HAC, three parameters that affect criticality and may vary during transport of the Model ES-3100 package are the number of packages transported, the amount of water present in the package, and the volatile (organic material) contents of the package. The number of packages transported is limited by the criticality safety index (CSI) established by this criticality evaluation. Both the amount of water present in the package and the volatile (organic material) contents of the package are parameters for the following reasons. First, volatile materials can be driven off at the high temperatures of HAC. Second, the inherent water content of the Kaolite in NCT and the water absorption by the Kaolite in HAC are unknowns. These parameters determine a variety of competing effects that govern the fission process, including, but not limited to, mass, moderation, absorption, and reflection. To ensure that all effects are adequately included in this criticality evaluation, the range of these parameters is evaluated.

It is possible for accidents to be significantly more severe in the air transport mode than in the surface transport mode. Thus, the performance requirements for packages designed to be transported by air are more stringent. These requirements address separate aspects of the accident assessment and apply only to the criticality evaluation of an individual package under isolation (IAEA SSG-26). For a fissile material package designed to be transported by air, 10 CFR 71.55(f) requires that the criticality evaluation demonstrate that the package be subcritical assuming reflection by 20 cm (7.9 in.) of water but no water inleakage when subjected to the sequential application of the HAC free drop and crush tests of 10 CFR 71.73(c)(1 and 2) and the modified puncture and thermal tests of 10 CFR 71.55(f)(1)(iii and iv). 10 CFR 71.55(f)(2) requires the criticality evaluation demonstrate that the package be subcritical, assuming reflection by 20 cm (7.9 in.) of water but no water inleakage, when subjected to an impact on an unyielding surface of 90 m/s normal to the surface.

The ES-3100 package was not subjected to physical testing of Type-C fissile material packages transported by air as specified in IAEA SSR-6, Para. 683. Instead, analytic methods are used to demonstrate compliance of the ES-3100 package with the requirements of 10 CFR 71.55(f). This is accomplished by demonstrating compliance of the package with the more stringent requirements imposed by the IAEA for situations where the conditions of the fissile material package following the tests cannot be demonstrated (IAEA SSG-26, Para. 683.2). Paragraph 683.2 of IAEA SSG-26 states that worst-case assumptions regarding the geometric arrangement of the package and contents should be made in the criticality evaluation taking into account all moderating and structural components of the packaging. The assumptions should be in conformity with the potential worst-case effects of the mechanical and thermal tests, and all package orientations should be considered for the analysis. Subcriticality must be demonstrated after due consideration of such aspects as the efficiency of the moderator, loss of neutron absorbers, rearrangement of packaging components and contents, geometry changes, and temperature effects. Given that the requirements of 10 CFR 71.55(f) mirror the IAEA requirements of SSR-6, Para. 683, for Type B(U) fissile material packages, this approach is considered an acceptable one.

6.1.3 Summary of the Criticality Evaluation

The following criticality evaluation shows that the Model ES-3100 package with designated content satisfies the requirements of 10 CFR 71.55 and 71.59 for surface transport, and of 10 CFR 71.55(f) for air transport. Designated contents are **solid** HEU metal or alloy of specified shape (cylinders, bars, buttons, billets, slugs, and unirradiated TRIGA fuel), broken metal, turnings, fines, or powder; **solid** HEU metal or alloy of unspecified geometric shape and characterized as broken metal; HEU product or skull oxides; or UNX crystals. HEU skull oxides are distinguished from product oxides (UO_2, U_3O_8, or UO_3) as being a residue of graphite and oxidized uranium (U_3O_8) recovered in the casting process. The criticality evaluation of these contents is addressed in the main subsections of this chapter. The criticality evaluation of the contents not covered under the initial evaluation is addressed in Appendices 6.9.8, 6.9.9, and 6.9.11 as explained therein.

Tables 6.1a–6.1f pertain to surface-only modes of transportation. The column headings across the tables identify content and 277-4 canned spacer configurations. The tables are organized into groups of rows, which identify the defining calculations for addressing the performance requirements of 10 CFR 71.55(b), 71.55(d), 71.55(e), or 71.59 (see "Conditions" column). The defining calculations are also discussed in Sects. 6.4, 6.5, or 6.6, as appropriate. The KENO V.a input listings for the calculations are provided in Appendix 6.9.7. The rows within the groups cite the specific requirements stated in the CFR paragraphs and provide details regarding how these conditions are addressed or treated in the defining calculations for each content and 277-4 canned spacer configuration listed in a table column. Results of the criticality evaluation are summarized in Tables 6.1a and 6.1b for **solid** HEU metal in the form of specified shape (cylinders, bars, buttons, billets, and slugs); Table 6.1c for HEU broken metal or **solid** HEU metal of unspecified geometric shape and characterized as broken metal; Table 6.1d for HEU metal in the form of turnings, fines, or powder; Table 6.1e for HEU product and skull oxide; and Table 6.1f for UNX crystals and unirradiated TRIGA reactor fuel elements. In some cases, studies were performed to determine which is more reactive — no polyethylene or 500 g of polyethylene. The most reactive cases of these evaluations are cited in Tables 6.1a–6.1f.

Table 6.1a. Summary of criticality evaluation for solid HEU metal cylinders and bars

Conditions	Cylinders (d ≤ 3.24 in.) no can spacers	Cylinders (d ≤ 3.24 in.) with can spacers	Square bars (l,w ≤ 2.29 in.) no can spacers	Cylinders (3.24 < d ≤ 4.25 in.) no can spacers	Cylinders (3.24 < d ≤ 4.25 in.) with can spacers
General requirements for each fissile package (§71.55)					
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited that it would be subcritical if water were to leak into the containment system, . . . so that under the following conditions, maximum reactivity of the fissile material would be attained:" (Paragraph "b")	$k_{eff} + 2\sigma \leq 0.9228$ cvcrcyt11_21_1	$k_{eff} + 2\sigma \leq 0.8866$ cvcrcyt11_36_2	$k_{eff} + 2\sigma \leq 0.8787$ cvcrsqt11_36_1	$k_{eff} + 2\sigma \leq 0.9215$ cvcrcyct11_17_1	$k_{eff} + 2\sigma \leq 0.9202$ cvcrcyct11_32_2
(1) the most reactive credible configuration consistent with the chemical and physical form of the material,	3 stacked cylinders (d = 3.24 in.) 1 cylinder per convenience can, no can spacers, 21,000-g ^{235}U	3 stacked cylinders (d = 3.24 in.) 1 cylinder per convenience can, with can spacers, 36,000-g ^{235}U	3 stacked bars (l,w = 2.29 in.) 1 bar per convenience can, no can spacers, 36,000-g ^{235}U	3 stacked cylinders (d = 4.25 in.) 1 cylinder per convenience can, no can spacers, 17,000-g ^{235}U	3 stacked cylinders (d = 4.25 in.) 1 cylinder per convenience can, with can spacers, 32,000-g ^{235}U
(2) moderation by water to the most reactive credible extent,	Flooding of the CV	Same	Same	Same	Same
(3) close full reflection of the containment system by water on all sides, or such greater reflection of the containment system as may be provided by the surrounding material of the packaging.	30.48-cm H_2O surrounding the CV	Same	Same	Same	Same

Table 6.1a. Summary of criticality evaluation for solid HEU metal cylinders and bars

Conditions	Cylinders ($d \leq 3.24$ in.) no can spacers	Cylinders ($d \leq 3.24$ in.) with can spacers	Square bars ($l,w \leq 2.29$ in.) no can spacers	Cylinders ($3.24 < d \leq 4.25$ in.) no can spacers	Cylinders ($3.24 < d \leq 4.25$ in.) with can spacers
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited under the tests specified in §71.71 (Normal Conditions of Transport) . . ." (Paragraph "d")					
(1) the contents would be subcritical,	$k_{eff} + 2\sigma \leq 0.9035$ ncsrcyt11_21_1_15	$k_{eff} + 2\sigma \leq 0.8731$ ncsrcyt11_36_2_15	$k_{eff} + 2\sigma \leq 0.8652$ ncsrsqt11_36_1_15	$k_{eff} + 2\sigma \leq 0.8941$ ncsrcyct11_17_1_15	$k_{eff} + 2\sigma \leq 0.8946$ ncsrcyct11_32_2_15
(2) the geometric form of the package contents would not be substantially altered,	3 stacked cylinders (d = 3.24 in.) 1 cylinder per convenience can, no can spacers, 21,000-g ^{235}U	3 stacked cylinders (d = 3.24 in.) 1 cylinder per convenience can, with can spacers, 36,000-g ^{235}U	3 stacked bars (l,w = 2.29 in.) 1 bar per convenience can, no can spacers, 36,000-g ^{235}U	3 stacked cylinders (d = 4.25 in.) 1 cylinder per convenience can, no can spacers, 17,000-g ^{235}U	3 stacked cylinders (d = 4.25 in.) 1 cylinder per convenience can, with can spacers, 32,000-g ^{235}U
(3) there would be no leakage of water into the containment system unless, in the evaluation of undamaged packages under §71.59(a)(1), it has been assumed that moderation is present to such an extent as to cause maximum reactivity consistent with the chemical and physical form of the material,	Moderation is present to such an extent as to cause maximum reactivity	Same	Same	Same	Same
(4) there will be no substantial reduction in the effectiveness of the packaging	30.48-cm H_2O surrounding the drum (d=18.37 in., h=43.5 in.)	Same	Same	Same	Same

Table 6.1a. Summary of criticality evaluation for solid HEU metal cylinders and bars

Conditions	Cylinders (d ≤ 3.24 in.) no can spacers	Cylinders (d ≤ 3.24 in.) with can spacers	Square bars (l,w ≤ 2.29 in.) no can spacers	Cylinders (3.24 < d ≤ 4.25 in.) no can spacers	Cylinders (3.24 < d ≤ 4.25 in.) with can spacers
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited that under the tests specified in §71.73 (Hypothetical Accident Conditions) the package would be subcritical. For this determination, it must be assumed that:" (Paragraph "e")	$k_{eff} + 2\sigma \leq 0.9044$ hcsrcyt12_21_1_15	$k_{eff} + 2\sigma \leq 0.8734$ hcsrcyt12_36_2_15	$k_{eff} + 2\sigma \leq 0.8642$ hcsrsqt12_36_1_15	$k_{eff} + 2\sigma \leq 0.8979$ hcsrcyct12_17_1_15	$k_{eff} + 2\sigma \leq 0.8977$ hcsrcyct12_32_2_15
(1) the fissile material is in the most reactive credible configuration consistent with the chemical and physical form of the contents,	3 stacked cylinders (d = 3.24 in.) 1 cylinder per convenience can, no can spacers, 21,000-g ^{235}U	3 stacked cylinders (d = 3.24 in.) 1 cylinder per convenience can, with can spacers, 36,000-g ^{235}U	3 stacked bars (l,w = 2.29 in.) 1 bar per convenience can, no can spacers, 36,000-g ^{235}U	3 stacked cylinders (d = 4.25 in.) 1 cylinder per convenience can, no can spacers, 17,000-g ^{235}U	3 stacked cylinders (d = 4.25 in.) 1 cylinder per convenience can, with can spacers, 32,000-g ^{235}U
(2) water moderation occurs to the most reactive credible extent consistent with the chemical and physical form of content,	Flooding of the package	Same	Same	Same	Same
(3) there is full reflection by water on all sides, as close as is consistent with the damage condition of the package.	30.48-cm H_2O surrounding the reduced diameter drum (d=17.20 in., h=43.5 in.)	Same	Same	Same	Same

Table 6.1a. Summary of criticality evaluation for solid HEU metal cylinders and bars

Conditions	Cylinders ($d \leq 3.24$ in.) no can spacers	Cylinders ($d \leq 3.24$ in.) with can spacers	Square bars ($l,w \leq 2.29$ in.) no can spacers	Cylinders ($3.24 < d \leq 4.25$ in.) no can spacers	Cylinders ($3.24 < d \leq 4.25$ in.) with can spacers
Standards for arrays of fissile material packages (§71.59)					
" . . . the designer of a fissile material package shall derive a number "N" based on all the following conditions being satisfied, assuming packages are stacked together in any arrangement and with close reflection on all sides of the stack by water:" (Paragraph "a")					
Transport index based on nuclear criticality control, CSI = 0.0	**Load-limited to 18,000-g ^{235}U, no can spacers**	**Load-limited to 30,000-g ^{235}U, can spacers**	**Load-limited to 30,000-g ^{235}U, no can spacers**	**Load-limited to 15,000-g ^{235}U, no can spacers**	**Load-limited to 25,000-g ^{235}U, can spacers**
(1) five times "N" undamaged packages with nothing between the packages would be subcritical,	$k_{eff} + 2\sigma \leq 0.92517$ nciacyt11_18_1_3	$k_{eff} + 2\sigma \leq 0.92111$ nciacyt11_30_2_3	$k_{eff} + 2\sigma \leq 0.92517$ nciasqt11_30_1_3	$k_{eff} + 2\sigma \leq 0.90754$ nciacyct11p_15_1_3	$k_{eff} + 2\sigma \leq 0.91455$ nciacyct11_25_2_3
(2) two times "N" damaged packages, if each package were subject to the tests specified in §71.73 (Hypothetical Accident Conditions) would be subcritical with optimum interspersed hydrogenous moderation,	$k_{eff} + 2\sigma \leq 0.92554$ hciacyt12_18_1_3	$k_{eff} + 2\sigma \leq 0.92152$ hciacyt12_30_2_3	$k_{eff} + 2\sigma \leq 0.92351$ hciasqt12_30_1_3	$k_{eff} + 2\sigma \leq 0.90793$ hciacyct12p_15_1_3	$k_{eff} + 2\sigma \leq 0.91428$ hciacyct12_25_2_3
(3) the value of "N" not <0.5.	$N(1,2) = \infty$	Same	Same	Same	Same
Transport index based on nuclear criticality control, CSI = 0.0			**Load-limited to 36,000-g ^{235}U, can spacers**		
(1) five times "N" undamaged packages			$k_{eff} + 2\sigma \leq 0.89604$ nciasqt11p_36_2_3		
(2) two times "N" damaged packages, ...			$k_{eff} + 2\sigma \leq 0.89632$ hciasqt12p_36_2_3		
(3) the value of "N"			$N(1,2) = \infty$		

Table 6.1b. Summary of criticality evaluation for solid HEU metal slugs

Conditions	Slugs, no can spacers enr. ≤ 100% ≤ 18,277-g ^{235}U	Slugs with can spacers 80% < enr. ≤ 100% < 36,555-g ^{235}U	Slugs with can spacers enr. ≤ 80% < 36,555-g ^{235}U
General requirements for each fissile package (§71.55)			
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited that it would be subcritical if water were to leak into the containment system, . . . so that under the following conditions, maximum reactivity of the fissile material would be attained:" (Paragraph "b")	$k_{eff} + 2\sigma \leq 0.92161$ cvcr5st11p_1_1	$k_{eff} + 2\sigma \leq 0.90706$ cvcr5st11p_2_2	
(1) the most reactive credible configuration consistent with the chemical and physical form of the material,	Cluster of 5 slugs (d = 1.5625 in., h = 2.0625 in.) per convenience can, no can spacers, 18,277-g ^{235}U	Cluster of 10 slugs stacked 2 high per convenience can, can spacers, 36,555-g ^{235}U	
(2) moderation by water to the most reactive credible extent,	Flooding of the CV	Same	
(3) close full reflection of the containment system by water on all sides, or such greater reflection of the containment system as may be provided by the surrounding material of the packaging.	30.48-cm H_2O surrounding the CV	Same	
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited under the tests specified in §71.71 (Normal Conditions of Transport) . . ." (Paragraph "d")			
(1) the contents would be subcritical,	$k_{eff} + 2\sigma \leq 0.88475$ ncsr5st11p_1_1_15	$k_{eff} + 2\sigma \leq 0.8781$ ncsr5st11_2_2_15	
(2) the geometric form of the package contents would not be substantially altered,	Cluster of 5 slugs (d = 1.5625 in., h = 2.0625 in.) per convenience can, no can spacers, 18,277-g ^{235}U	Cluster of 10 slugs stacked 2 high per convenience can, can spacers, 36,555-g ^{235}U	
(3) there would be no leakage of water into the containment system unless, in the evaluation of undamaged packages under §71.59(a)(1), it has been assumed that moderation is present to such an extent as to cause maximum reactivity consistent with the chemical and physical form of the material,	Moderation is present to such an extent as to cause maximum reactivity	Same	
(4) there will be no substantial reduction in the effectiveness of the packaging	30.48-cm H_2O surrounding the drum (d=18.37 in., h=43.5 in.)	Same	

Table 6.1b. Summary of criticality evaluation for solid HEU metal slugs

Conditions	Slugs, no can spacers enr. ≤ 100% ≤ 18,277-g ^{235}U	Slugs with can spacers 80% < enr. ≤ 100% < 36,555-g ^{235}U	Slugs with can spacers enr. ≤ 80% < 36,555-g ^{235}U
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited that under the tests specified in §71.73 (Hypothetical Accident Conditions) the package would be subcritical. For this determination, it must be assumed that:" (Paragraph "e")	$k_{eff} + 2\sigma \leq 0.88795$ hcsr5est12_1_1_15	$k_{eff} + 2\sigma \leq 0.88195$ hcsr5est12_2_2_15	
(1) the fissile material is in the most reactive credible configuration consistent with the chemical and physical form of the contents,	Cluster of 5 slugs (d = 1.5625 in., h = 2.0625 in.) per convenience can, no can spacers, 18,277-g ^{235}U	Cluster of 10 slugs stacked 2 high per convenience can, can spacers, 36,555-g ^{235}U	
(2) water moderation occurs to the most reactive credible extent consistent with the chemical and physical form of content,	Flooding of the package	Same	
(3) there is full reflection by water on all sides, as close as is consistent with the damage condition of the package.	30.48-cm H_2O surrounding the reduced diameter drum (d=17.20 in., h=43.5 in.)	Same	

Table 6.1b. Summary of criticality evaluation for solid HEU metal slugs

Conditions	Slugs, no can spacers enr. ≤ 100% ≤ 18,277-g ^{235}U	Slugs with can spacers 80% < enr. ≤ 100% < 36,555-g ^{235}U	Slugs with can spacers enr. ≤ 80% < 36,555-g ^{235}U
Standards for arrays of fissile material packages (§71.59)			
" . . . the designer of a fissile material package shall derive a number "N" based on all the following conditions being satisfied, assuming packages are stacked together in any arrangement and with close reflection on all sides of the stack by water: " (Paragraph "a")			
Transport index based on nuclear criticality control, CSI = 0.0	**Load-limited to enr. ≤ 95%, 17,374-g ^{235}U, no can spacers**	**Load-limited to 80% < enr. ≤ 95% 24,324-g ^{235}U, can spacers**	**Load-limited to enr. ≤ 80%, 29,318-g ^{235}U, can spacers**
(1) five times "N" undamaged packages with nothing between the packages would be subcritical,	$k_{eff} + 2\sigma \leq 0.91797$ ncia5st11p_1_1_7_3	$k_{eff} + 2\sigma \leq 0.89635$ ncia70st11p_2_7_3	$k_{eff} + 2\sigma \leq 0.91056$ ncia5est11_2_2_5_3
(2) two times "N" damaged packages, if each package were subject to the tests specified in §71.73 (Hypothetical Accident Conditions) would be subcritical with optimum interspersed hydrogenous moderation,	$k_{eff} + 2\sigma \leq 0.91907$ hcia5est12p_1_1_7_3	$k_{eff} + 2\sigma \leq 0.89599$ hcia70st12_2_7_3	$k_{eff} + 2\sigma \leq 0.91066$ hcia5est12_2_2_5_3
(3) the value of "N" not <0.5.	N(1,2) = ∞	Same	Same
Transport index based on nuclear criticality control, CSI = 0.4	**Load-limited to enr. ≤ 95%, 17,374-g ^{235}U, no can spacers**	**Load-limited to 80% < enr. ≤ 95% 34,749-g ^{235}U, can spacers**	**Load-limited to enr. ≤ 80%, 29,318-g ^{235}U, can spacers**
(1) five times "N" undamaged packages	Bounded by CSI=0	$k_{eff} + 2\sigma \leq 0.92455$ ncf15est11p_2_2_7_3	$k_{eff} + 2\sigma \leq 0.87006$ ncf15est11p_2_2_5_3
(2) two times "N" damaged packages, ...	Bounded by CSI=0	$k_{eff} + 2\sigma \leq 0.91240$ hcf25est12p_2_2_7_3	$k_{eff} + 2\sigma \leq 0.85831$ hcf25est12_2_2_5_3
(3) the value of "N"	N(1,2) = 202/162	Same	Same

Table 6.1c. Summary of criticality evaluation for HEU broken metal or solid HEU metal of unspecified geometric shape and characterized as broken metal

Conditions	95% < enr. ≤ 100% ≤ 22,400-g ^{235}U	90% < enr. ≤95% ≤ 23,370-g ^{235}U	80% < enr. ≤90% ≤ 27,990-g ^{235}U	70% < enr. ≤80% ≤ 28,800-g ^{235}U	60% < enr. ≤70% ≤ 25,200-g ^{235}U	enr. ≤60% ≤ 36,000-g U
General requirements for each fissile package (§71.55)						
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited that it would be subcritical if water were to leak into the containment system, . . . so that under the following conditions, maximum reactivity of the fissile material would be attained:" (Paragraph "b")	$k_{eff} + 2\sigma \leq 0.93380$ cvr3lhap_9_1_6_15	$k_{eff} + 2\sigma \leq 0.93678$ cvr3lhap_18_1_5_15	$k_{eff} + 2\sigma \leq 0.93258$ cvr3lhap_28_1_4_15	$k_{eff} + 2\sigma \leq 0.90434$ cvr3lhap_34_1_3_15	$k_{eff} + 2\sigma \leq 0.87555$ cvr3lhap_34_1_2_15	$k_{eff} + 2\sigma \leq 0.84316$ cvr3lhap_34_1_1_15
(1) the most reactive credible configuration consistent with the chemical and physical form of the material,	A mixture of HEU metal and water is homogenized over the internal volume of an assumed content lattice, one per can location. The square footprint of the content lattice is circumscribed by the inner wall of the CV. The amount of water in the flooded CV is calculated on the basis that the convenience can steel is replaced with water. Can pads and spacers not used. See Appendix 6.9.3, Sect. 6.9.3.1, for justification of the content model.					
(2) moderation by water to the most reactive credible extent,	Flooding of the CV					
(3) close full reflection of the containment system by water on all sides, or such greater reflection of the containment system as may be provided by the surrounding material of the packaging.	30.48-cm H_2O surrounding the CV					

Table 6.1c. Summary of criticality evaluation for HEU broken metal or solid HEU metal of unspecified geometric shape and characterized as broken metal

Conditions	95% < enr. ≤ 100% ≤ 22,400-g ^{235}U	90% < enr. ≤95% ≤ 23,370-g ^{235}U	80% < enr. ≤90% ≤ 27,990-g ^{235}U	70% < enr. ≤80% ≤ 28,800-g ^{235}U	60% < enr. ≤70% ≤ 25,200-g ^{235}U	enr. ≤60% ≤ 36,000-g U
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited under the tests specified in §71.71 (Normal Conditions of Transport) . . ." (Paragraph "d")						
(1) the contents would be subcritical,	$k_{eff} + 2\sigma \leq 0.89242$ ncsrbmt11p_8_6_15					
(2) the geometric form of the package contents would not be substantially altered,	A mixture of HEU metal and water is homogenized over the internal volume of the CV. The amount of water in the flooded CV is calculated on the basis that the convenience can steel is replaced with water. Can pads and spacers not used.					
(3) there would be no leakage of water into the containment system unless, in the evaluation of undamaged packages under §71.59(a)(1), it has been assumed that moderation is present to such an extent as to cause maximum reactivity consistent with the chemical and physical form of the material,	Moderation is present to such an extent as to cause maximum reactivity					
(4) there will be no substantial reduction in the effectiveness of the packaging	30.48-cm H_2O surrounding the drum (d = 18.37 in., h = 43.5 in.)					

Table 6.1c. Summary of criticality evaluation for HEU broken metal or solid HEU metal of unspecified geometric shape and characterized as broken metal

Conditions	95% < enr. ≤ 100% ≤ 22,400-g ^{235}U	90% < enr. ≤95% ≤ 23,370-g ^{235}U	80% < enr. ≤90% ≤ 27,990-g ^{235}U	70% < enr. ≤80% ≤ 28,800-g ^{235}U	60% < enr. ≤70% ≤ 25,200-g ^{235}U	enr. ≤60% ≤ 36,000-g U
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited that under the tests specified in §71.73 (Hypothetical Accident Conditions) the package would be subcritical. For this determination, it must be assumed that:" (Paragraph "e")	$k_{eff} + 2\sigma \leq 0.89382$ hcsrbmt12p_8_6_15					
(1) the fissile material is in the most reactive credible configuration consistent with the chemical and physical form of the contents,	A mixture of HEU metal and water is homogenized over the internal volume of the CV. The amount of water in the flooded CV is calculated on the basis that the convenience can steel is replaced with water. Can pads and spacers not used.					
(2) water moderation occurs to the most reactive credible extent consistent with the chemical and physical form of content,	Flooding of the package					
(3) there is full reflection by water on all sides, as close as is consistent with the damage condition of the package.	30.48-cm H_2O surrounding the reduced diameter drum (d = 17.20 in., h = 43.5 in.)					

Table 6.1c. Summary of criticality evaluation for HEU broken metal or solid HEU metal of unspecified geometric shape and characterized as broken metal

Conditions	95% < enr. ≤ 100% ≤ 22,400-g ^{235}U	90% < enr. ≤95% ≤ 23,370-g ^{235}U	80% < enr. ≤90% ≤ 27,990-g ^{235}U	70% < enr. ≤80% ≤ 28,800-g ^{235}U	60% < enr. ≤70% ≤ 25,200-g ^{235}U	enr. ≤60% ≤ 36,000-g U
Standards for arrays of fissile material packages (§71.59)						
" . . . the designer of a fissile material package shall derive a number "N" based on all the following conditions being satisfied, assuming packages are stacked together in any arrangement and with close reflection on all sides of the stack by water: " (Paragraph "a")						
Transport index based on nuclear criticality control, CSI = 0.0	**Load-limited to 2,600-g ^{235}U, no can spacers**	**Load-limited to 2,755-g ^{235}U, no can spacers**	**Load-limited to 2,880-g U, no can spacers**	**Load-limited to 3,200-g ^{235}U, no can spacers**	**Load-limited to 3,570-g ^{235}U, no can spacers**	**Load-limited to 7,200-g U, no can spacers**
(1) five times "N" undamaged packages with nothing between the packages would be subcritical,	$k_{eff} + 2\sigma \leq 0.93426$ nciabmt11p_5_1_6_3	$k_{eff} + 2\sigma \leq 0.93464$ nciabmt11p_8_1_5_3	$k_{eff} + 2\sigma \leq 0.93549$ nciabmt11p_11_1_4_3	$k_{eff} + 2\sigma \leq 0.93490$ nciabmt11p_18_1_3_3	$k_{eff} + 2\sigma \leq 0.93377$ nciabmt11p_27_1_2_3	$k_{eff} + 2\sigma \leq 0.93629$ nciabmt11p_39_1_1_3
(2) two times "N" damaged packages, if each package were subject to the tests specified in §71.73 (Hypothetical Accident Conditions) would be subcritical with optimum interspersed hydrogenous moderation,	$k_{eff} + 2\sigma \leq 0.93447$ hciabmt12p_5_1_6_3	$k_{eff} + 2\sigma \leq 0.93569$ hciabmt12p_8_1_5_3	$k_{eff} + 2\sigma \leq 0.93594$ hciabmt12p_11_1_4_3	$k_{eff} + 2\sigma \leq 0.93612$ hciabmt12p_18_1_3_3	$k_{eff} + 2\sigma \leq 0.93602$ hciabmt12p_27_1_2_3	$k_{eff} + 2\sigma \leq 0.93648$ hciabmt12p_39_1_1_3
(3) the value of "N" cannot be <0.5.	$N(1,2) = \infty$	Same	Same	Same	Same	Same

Table 6.1c. Summary of criticality evaluation for HEU broken metal or solid HEU metal of unspecified geometric shape and characterized as broken metal

Conditions	95% < enr. ≤ 100% ≤ 22,400-g ^{235}U	90% < enr. ≤95% ≤ 23,370-g ^{235}U	80% < enr. ≤90% ≤ 27,990-g ^{235}U	70% < enr. ≤80% ≤ 28,800-g ^{235}U	60% < enr. ≤70% ≤ 25,200-g ^{235}U	enr. ≤60% ≤ 36,000-g U
Transport index based on nuclear criticality control, CSI = 0.0	**Load-limited to 3,600-g ^{235}U, can spacers**	**Load-limited to 3,895-g ^{235}U, can spacers**	**Load-limited to 4,140-g ^{235}U, can spacers**	**Load-limited to 4,880-g ^{235}U, can spacers**	**Load-limited to 6,580-g ^{235}U, can spacers**	**Load-limited to 14,100-g U, can spacers**
(1) five times "N" undamaged packages . . .	$k_{eff} + 2\sigma \leq 0.93567$ nciabmt11p_14_2_6_3	$k_{eff} + 2\sigma \leq 0.93564$ nciabmt11p_19_2_5_3	$k_{eff} + 2\sigma \leq 0.93233$ nciabmt11p_22_2_4_3	$k_{eff} + 2\sigma \leq 0.93233$ nciabmt11p_32_2_3_3	$k_{eff} + 2\sigma \leq 0.93317$ nciabmt11p_45_2_2_3	$k_{eff} + 2\sigma \leq 0.93368$ nciabmt11p_52_2_1_3
(2) two times "N" damaged packages, ...	$k_{eff} + 2\sigma \leq 0.93571$ hciabmt12p_14_2_6_3	$k_{eff} + 2\sigma \leq 0.93650$ hciabmt12p_19_2_5_3	$k_{eff} + 2\sigma \leq 0.93554$ hciabmt12p_22_2_4_3	$k_{eff} + 2\sigma \leq 0.93573$ hciabmt12p_32_2_3_3	$k_{eff} + 2\sigma \leq 0.93438$ hciabmt12p_45_2_2_3	$k_{eff} + 2\sigma \leq 0.93502$ hciabmt12p_52_2_1_3
(3) the value of "N" . . .	N(1,2) = ∞	Same	Same	Same	Same	Same
Transport index based on nuclear criticality control, CSI = 0.4	**Load-limited to 4,000-g ^{235}U, no can spacers**	**Load-limited to 4,370-g ^{235}U, no can spacers**	**Load-limited to 4,860-g U, no can spacers**	**Load-limited to 5,840-g ^{235}U, no can spacers**	**Load-limited to 7,350-g ^{235}U, no can spacers**	**Load-limited to 17,300-g U, no can spacers**
(1) five times "N" undamaged packages	$k_{eff} + 2\sigma \leq 0.93658$ ncf1bmt11p_5_1_6_3	$k_{eff} + 2\sigma \leq 0.93648$ ncf1bmt11p_9_1_5_3	$k_{eff} + 2\sigma \leq 0.93577$ ncf1bmt11p_15_1_4_3	$k_{eff} + 2\sigma \leq 0.93386$ ncf1bmt11p_24_1_3_3	$k_{eff} + 2\sigma \leq 0.93497$ ncf1bmt11p_35_1_2_3	$k_{eff} + 2\sigma \leq 0.93467$ ncf1bmt11p_50_1_1_3
(2) two times "N" damaged packages, ...	$k_{eff} + 2\sigma \leq 0.91151$ hcf2bmt12p_5_1_6_3	$k_{eff} + 2\sigma \leq 0.91150$ hcf2bmt12p_9_1_5_3	$k_{eff} + 2\sigma \leq 0.91130$ hcf2bmt12p_15_1_4_3	$k_{eff} + 2\sigma \leq 0.91363$ hcf2bmt12p_24_1_3_3	$k_{eff} + 2\sigma \leq 0.90985$ hcf2bmt12p_35_1_2_3	$k_{eff} + 2\sigma \leq 0.91110$ hcf2bmt12p_50_1_1_3
(3) the value of "N" . . .	N(1,2) = 202/162	Same	Same	Same	Same	Same
Transport index based on nuclear criticality control, CSI = 0.4	**Load-limited to 5,900-g ^{235}U, can spacers**	**Load-limited to 6,935-g ^{235}U, can spacers**	**Load-limited to 8,460-g ^{235}U, can spacers**	**Load-limited to 11,040-g ^{235}U, can spacers**	**Load-limited to 15,260-g ^{235}U, can spacers**	**Load-limited to 32,900-g U, can spacers**
(1) five times "N" undamaged packages	$k_{eff} + 2\sigma \leq 0.93398$ ncf1bmt11p_19_2_6_3	$k_{eff} + 2\sigma \leq 0.93571$ ncf1bmt11p_24_2_5_3	$k_{eff} + 2\sigma \leq 0.93283$ ncf1bmt11p_30_2_4_3	$k_{eff} + 2\sigma \leq 0.93378$ ncf1bmt11p_42_2_3_3	$k_{eff} + 2\sigma \leq 0.93475$ ncf1bmt11p_57_2_2_3	$k_{eff} + 2\sigma \leq 0.93323$ ncf1bmt11p_68_2_1_3
(2) two times "N" damaged packages, ...	$k_{eff} + 2\sigma \leq 0.91360$ hcf2bmt12p_19_2_6_3	$k_{eff} + 2\sigma \leq 0.91397$ hcf2bmt12p_24_2_5_3	$k_{eff} + 2\sigma \leq 0.91180$ hcf2bmt12p_30_2_4_3	$k_{eff} + 2\sigma \leq 0.91234$ hcf2bmt12p_42_2_3_3	$k_{eff} + 2\sigma \leq 0.91237$ hcf2bmt12p_57_2_2_3	$k_{eff} + 2\sigma \leq 0.90853$ hcf2bmt12p_68_2_1_3
(3) the value of "N"	N(1,2) = 202/162	Same	Same	Same	Same	Same

Table 6.1c. Summary of criticality evaluation for HEU broken metal or solid HEU metal of unspecified geometric shape and characterized as broken metal

Conditions	95% < enr. ≤ 100% ≤ 22,400-g ^{235}U	90% < enr. ≤95% ≤ 23,370-g ^{235}U	80% < enr. ≤90% ≤ 27,990-g ^{235}U	70% < enr. ≤80% ≤ 28,800-g ^{235}U	60% < enr. ≤70% ≤ 25,200-g ^{235}U	enr. ≤60% ≤ 36,000-g U
Transport index based on nuclear criticality control, CSI = 0.8	**Load-limited to 6,200-g ^{235}U, no can spacers**	**Load-limited to 7,315-g ^{235}U, no can spacers**	**Load-limited to 8,550-g U, no can spacers**	**Load-limited to 11,360-g ^{235}U, no can spacers**	**Load-limited to 15,260-g ^{235}U, no can spacers**	**Load-limited to 34,500-g U, no can spacers**
(1) five times "N" undamaged packages	$k_{eff} + 2\sigma \leq 0.93492$ ncf2bmt11p_4_1_6_3	$k_{eff} + 2\sigma \leq 0.93505$ ncf2bmt11p_9_1_5_3	$k_{eff} + 2\sigma \leq 0.93445$ ncf2bmt11p_15_1_4_3	$k_{eff} + 2\sigma \leq 0.93347$ ncf2bmt11p_31_1_3_3	$k_{eff} + 2\sigma \leq 0.93234$ ncf2bmt11p_48_1_2_3	$k_{eff} + 2\sigma \leq 0.93276$ ncf2bmt11p_66_1_1_3
(2) two times "N" damaged packages, ...	$k_{eff} + 2\sigma \leq 0.91488$ hcf3bmt12p_4_1_6_3	$k_{eff} + 2\sigma \leq 0.91487$ hcf3bmt12p_9_1_5_3	$k_{eff} + 2\sigma \leq 0.91437$ hcf3bmt12p_15_1_4_3	$k_{eff} + 2\sigma \leq 0.91306$ hcf3bmt12p_31_1_3_3	$k_{eff} + 2\sigma \leq 0.91462$ hcf3bmt12p_48_1_2_3	$k_{eff} + 2\sigma \leq 0.91386$ hcf3bmt12p_66_1_1_3
(3) the value of "N"	N(1,2) = 64/73	Same	Same	Same	Same	Same
Transport index based on nuclear criticality control, CSI = 0.8	**Load-limited to 10,500-g ^{235}U, can spacers**	**Load-limited to 12,825-g ^{235}U, can spacers**	**Load-limited to 15,660-g ^{235}U, can spacers**	**Load-limited to 20,480-g ^{235}U, can spacers**	**Load-limited to 24,780-g ^{235}U, can spacers**	**Load-limited to 36,000-g U, can spacers**
(1) five times "N" undamaged packages	$k_{eff} + 2\sigma \leq 0.93516$ ncf2bmt11p_20_2_6_3	$k_{eff} + 2\sigma \leq 0.93403$ ncf2bmt11p_27_2_5_3	$k_{eff} + 2\sigma \leq 0.93510$ ncf2bmt11p_40_2_4_3	$k_{eff} + 2\sigma \leq 0.93513$ ncf2bmt11p_56_2_3_3	$k_{eff} + 2\sigma \leq 0.93364$ ncf2bmt11p_71_2_2_3	$k_{eff} + 2\sigma \leq 0.90587$ ncf2bmt11p_73_2_1_3
(2) two times "N" damaged packages, ...	$k_{eff} + 2\sigma \leq 0.91652$ hcf3bmt12p_20_2_6_3	$k_{eff} + 2\sigma \leq 0.91657$ hcf3bmt12p_27_2_5_3	$k_{eff} + 2\sigma \leq 0.91232$ hcf3bmt12p_40_2_4_3	$k_{eff} + 2\sigma \leq 0.91591$ hcf3bmt12p_56_2_3_3	$k_{eff} + 2\sigma \leq 0.91397$ hcf3bmt12p_71_2_2_3	$k_{eff} + 2\sigma \leq 0.88617$ hcf3bmt12p_73_2_1_3
(3) the value of "N"	N(1,2) = 64/73	Same	Same	Same	Same	Same
Transport index based on nuclear criticality control, CSI = 2.0 [a]	**Load-limited to 10,700-g ^{235}U, no can spacers**	**Load-limited to 13,300-g ^{235}U, no can spacers**	**Load-limited to 16,110-g ^{235}U, no can spacers**	**Load-limited to 20,320-g ^{235}U, no can spacers**	**Load-limited to 25,200-g ^{235}U, no can spacers**	**Load-limited to 36,000-g U, no can spacers**
(1) five times "N" undamaged packages	$k_{eff} + 2\sigma \leq 0.93491$ ncf3bmt11p_5_1_6_3	$k_{eff} + 2\sigma \leq 0.93456$ ncf3bmt11p_13_1_5_3	$k_{eff} + 2\sigma \leq 0.93457$ ncf3bmt11p_24_1_4_3	$k_{eff} + 2\sigma \leq 0.93309$ ncf3bmt11p_39_1_3_3	$k_{eff} + 2\sigma \leq 0.93503$ ncf3bmt11p_58_1_2_3	$k_{eff} + 2\sigma \leq 0.90727$ ncf3bmt11p_58_1_1_3
(2) two times "N" damaged packages, ...	$k_{eff} + 2\sigma \leq 0.89810$ hcf4bmt12p_5_1_6_3	$k_{eff} + 2\sigma \leq 0.89542$ hcf4bmt12p_13_1_5_3	$k_{eff} + 2\sigma \leq 0.89754$ hcf4bmt12p_24_1_4_3	$k_{eff} + 2\sigma \leq 0.89489$ hcf4bmt12p_39_1_3_3	$k_{eff} + 2\sigma \leq 0.89793$ hcf4bmt12p_58_1_2_3	$k_{eff} + 2\sigma \leq 0.87098$ hcf4bmt12p_58_1_1_3
(3) the value of "N"	N(1,2) = 29/25	Same	Same	Same	Same	Same

Table 6.1c. Summary of criticality evaluation for HEU broken metal or solid HEU metal of unspecified geometric shape and characterized as broken metal

Conditions	95% < enr. ≤ 100% ≤ 22,400-g ^{235}U	90% < enr. ≤95% ≤ 23,370-g ^{235}U	80% < enr. ≤90% ≤ 27,990-g ^{235}U	70% < enr. ≤80% ≤ 28,800-g ^{235}U	60% < enr. ≤70% ≤ 25,200-g ^{235}U	enr. ≤60% ≤ 36,000-g U
Transport index based on nuclear criticality control, CSI = 2.0 [a]	**Load-limited to 17,500-g ^{235}U, can spacers**	**Load-limited to 21,280-g ^{235}U, can spacers**	**Load-limited to 24,750-g ^{235}U, can spacers**	**Load-limited to 28,800-g ^{235}U, can spacers**	**25,200-g ^{235}U, can spacers**	**36,000-g U, can spacers**
(1) five times "N" undamaged packages	$k_{eff} + 2\sigma \leq 0.93345$ ncf3bmt11p_20_2_6_3	$k_{eff} + 2\sigma \leq 0.93485$ ncf3bmt11p_32_2_5_3	$k_{eff} + 2\sigma \leq 0.93409$ ncf3bmt11p_45_2_4_3	$k_{eff} + 2\sigma \leq 0.93335$ ncf3bmt11p_58_2_3_3	$k_{eff} + 2\sigma \leq 0.90603$ ncf3bmt11p_58_2_2_3	$k_{eff} + 2\sigma \leq 0.87803$ ncf3bmt11p_58_2_1_3
(2) two times "N" damaged packages, ...	$k_{eff} + 2\sigma \leq 0.89836$ hcf4bmt12p_20_2_6_3	$k_{eff} + 2\sigma \leq 0.89964$ hcf4bmt12p_32_2_5_3	$k_{eff} + 2\sigma \leq 0.89932$ hcf4bmt12p_45_2_4_3	$k_{eff} + 2\sigma \leq 0.89601$ hcf4bmt12p_58_2_3_3	$k_{eff} + 2\sigma \leq 0.86840$ hcf4bmt12p_58_2_2_3	$k_{eff} + 2\sigma \leq 0.84175$ hcf4bmt12p_58_2_1_3
(3) the value of "N"	N(1,2) = 29/25	Same	Same	Same	Same	Same
Transport index based on nuclear criticality control, CSI = 3.2 [b]	**Load-limited to 19,100-g ^{235}U, no can spacers**	**Load-limited to 23,560-g ^{235}U, no can spacers**	**Load-limited to 26,100-g ^{235}U, no can spacers**	**Load-limited to 28,800-g ^{235}U, no can spacers**	**25,200-g ^{235}U, no can spacers**	**36,000-g U, no can spacers**
(1) five times "N" undamaged packages	$k_{eff} + 2\sigma \leq 0.93479$ nctf5bmt11p_5_1_6_3	$k_{eff} + 2\sigma \leq 0.93508$ nctf5bmt11p_14_1_5_3	$k_{eff} + 2\sigma \leq 0.93367$ nctf5bmt11p_27_1_4_3	$k_{eff} + 2\sigma \leq 0.92826$ nctf5bmt11p_42_1_3_3	$k_{eff} + 2\sigma \leq 0.90345$ nctf5bmt11p_42_1_2_3	$k_{eff} + 2\sigma \leq 0.87716$ nctf5bmt11p_42_1_1_3
(2) two times "N" damaged packages, ...	$k_{eff} + 2\sigma \leq 0.91484$ hctf5bmt12p_5_1_6_3	$k_{eff} + 2\sigma \leq 0.91688$ hctf5bmt12p_14_1_5_3	$k_{eff} + 2\sigma \leq 0.91496$ hctf5bmt12p_27_1_4_3	$k_{eff} + 2\sigma \leq 0.90875$ hctf5bmt12p_42_1_3_3	$k_{eff} + 2\sigma \leq 0.88319$ hctf5bmt12p_42_1_2_3	$k_{eff} + 2\sigma \leq 0.85772$ hctf5bmt12p_42_1_1_3
(3) the value of "N"	N(1,2) = 16/24	Same	Same	Same	Same	Same
Transport index based on nuclear criticality control, CSI = 3.2 [b]	**Load-limited to 27,400-g ^{235}U, can spacers**	**Load-limited to 30,970-g ^{235}U, can spacers**	**32,400-g ^{235}U, can spacers**	**28,800-g ^{235}U, can spacers**	**25,200-g ^{235}U, can spacers**	**36,000-g U, can spacers**
(1) five times "N" undamaged packages	$k_{eff} + 2\sigma \leq 0.93442$ nctf5bmt11p_21_2_6_3	$k_{eff} + 2\sigma \leq 0.93259$ nctf5bmt11p_34_2_5_3	$k_{eff} + 2\sigma \leq 0.92896$ nctf5bmt11p_42_2_4_3	$k_{eff} + 2\sigma \leq 0.90190$ nctf5bmt11p_42_2_3_3	$k_{eff} + 2\sigma \leq 0.87405$ nctf5bmt11p_42_2_2_3	$k_{eff} + 2\sigma \leq 0.84681$ nctf5bmt11p_42_2_1_3
(2) two times "N" damaged packages, ...	$k_{eff} + 2\sigma \leq 0.91551$ hctf5bmt12p_21_2_6_3	$k_{eff} + 2\sigma \leq 0.91466$ hctf5bmt12p_34_2_5_3	$k_{eff} + 2\sigma \leq 0.90893$ hctf5bmt12p_42_2_4_3	$k_{eff} + 2\sigma \leq 0.88123$ hctf5bmt12p_42_2_3_3	$k_{eff} + 2\sigma \leq 0.85663$ hctf5bmt12p_42_2_2_3	$k_{eff} + 2\sigma \leq 0.82886$ hctf5bmt12p_42_2_1_3
(3) the value of "N"	N(1,2) = 16/24	Same	Same	Same	Same	Same

[a] Neutron multiplication factors and "N" are shown for an NCT array size of 7×7×3 and an HAC array size of 5×5×2; both arrays are nearly cubic arrangements. An HAC array size is not available for CSI=1.8; therefore, CSI for NCT at 1.8 is rounded up to 2.0 as shown.

[b] Neutron multiplication factors and "N" are shown for an NCT array size of 27×3 and an HAC array size of 16×3; where packages in the planar dimension are in explicit triangular-pitch arrangement and stacked three high in the vertical direction. An NCT array size of 81 packages gives a CSI value of 3.12 (50 / 16), while an HAC array size of 48 packages gives a CSI value of 2.08 (50 / 24). The specified CSI value of 3.2 is the larger of the two numbers rounded up to the nearest tenth decimal place as shown.

Table 6.1d. Summary of criticality evaluation for HEU metal turnings, fines, or powder

Conditions	95% < enr. ≤ 100% ≤ 10,500-g ^{235}U	90% < enr. ≤ 95% ≤ 15,295-g ^{235}U	80% < enr. ≤ 90% ≤ 19,800-g ^{235}U	70% < enr. ≤ 80% ≤ 26,400-g ^{235}U	60% < enr. ≤ 70% ≤ 25,200-g ^{235}U	enr. ≤ 60% ≤ 36,000-g U
General requirements for each fissile package (§71.55)						
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited that it would be subcritical if water were to leak into the containment system, . . . so that under the following conditions, maximum reactivity of the fissile material would be attained:" (Paragraph "b")	$k_{eff} + 2\sigma \leq 0.93366$ cvr3chap_5_1_6_15	$k_{eff} + 2\sigma \leq 0.93416$ cvr3chap_14_1_5_15	$k_{eff} + 2\sigma \leq 0.93466$ cvr3chap_23_1_4_15	$k_{eff} + 2\sigma \leq 0.93489$ cvr3chap_34_1_3_15	$k_{eff} + 2\sigma \leq 0.92010$ cvr3chap_38_1_2_15	$k_{eff} + 2\sigma \leq 0.90368$ cvr3chap_38_1_1_15
(1) the most reactive credible configuration consistent with the chemical and physical form of the material,	A mixture of water and HEU metal as turnings, fines, or powder is homogenized over the internal volume of the CV. The amount of water in the flooded CV is calculated on the basis that the convenience can steel is replaced with water. Can pads and spacers not used. See Appendix 6.9.3, Sect. 6.9.3.1, for justification of the content model.					
(2) moderation by water to the most reactive credible extent,	Flooding of the CV					
(3) close full reflection of the containment system by water on all sides, or such greater reflection of the containment system as may be provided by the surrounding material of the packaging.	30.48-cm H_2O surrounding the CV					

Table 6.1d. Summary of criticality evaluation for HEU metal turnings, fines, or powder

Conditions	95% < enr. ≤ 100% ≤ 10,500-g ^{235}U	90% < enr. ≤ 95% ≤ 15,295-g ^{235}U	80% < enr. ≤ 90% ≤ 19,800-g ^{235}U	70% < enr. ≤ 80% ≤ 26,400-g ^{235}U	60% < enr. ≤ 70% ≤ 25,200-g ^{235}U	enr. ≤ 60% ≤ 36,000-g U
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited under the tests specified in §71.71 (Normal Conditions of Transport) . . ." (Paragraph "d")						
(1) the contents would be subcritical,	$k_{eff} + 2\sigma \leq 0.89242$ ncsrbmt11p_8_6_15					
(2) the geometric form of the package contents would not be substantially altered,	A mixture of HEU metal and water is homogenized over the internal volume of the CV. The amount of water in the flooded CV is calculated on the basis that the convenience can steel is replaced with water. Can pads and spacers not used.					
(3) there would be no leakage of water into the containment system unless, in the evaluation of undamaged packages under §71.59(a)(1), it has been assumed that moderation is present to such an extent as to cause maximum reactivity consistent with the chemical and physical form of the material,	Moderation is present to such an extent as to cause maximum reactivity					
(4) there will be no substantial reduction in the effectiveness of the packaging	30.48-cm H_2O surrounding the drum (d = 18.37 in., h = 43.5 in.)					

Table 6.1d. Summary of criticality evaluation for HEU metal turnings, fines, or powder

Conditions	95% < enr. ≤ 100% ≤ 10,500-g ^{235}U	90% < enr. ≤ 95% ≤ 15,295-g ^{235}U	80% < enr. ≤ 90% ≤ 19,800-g ^{235}U	70% < enr. ≤ 80% ≤ 26,400-g ^{235}U	60% < enr. ≤ 70% ≤ 25,200-g ^{235}U	enr. ≤ 60% ≤ 36,000-g U
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited that under the tests specified in §71.73 (Hypothetical Accident Conditions) the package would be subcritical. For this determination, it must be assumed that:" (Paragraph "e")	$k_{eff} + 2\sigma \leq 0.89382$ hcsrbmt12p_8_6_15					
(1) the fissile material is in the most reactive credible configuration consistent with the chemical and physical form of the contents,	A mixture of HEU metal and water is homogenized over the internal volume of the CV. The amount of water in the flooded CV is calculated on the basis that the convenience can steel is replaced with water. Can pads and spacers not used.					
(2) water moderation occurs to the most reactive credible extent consistent with the chemical and physical form of content,	Flooding of the package					
(3) there is full reflection by water on all sides, as close as is consistent with the damage condition of the package.	30.48-cm H_2O surrounding the reduced diameter drum (d = 17.20 in., h = 43.5 in.)					

Table 6.1d. Summary of criticality evaluation for HEU metal turnings, fines, or powder

Conditions	95% < enr. ≤ 100% ≤ 10,500-g ^{235}U	90% < enr. ≤ 95% ≤ 15,295-g ^{235}U	80% < enr. ≤ 90% ≤ 19,800-g ^{235}U	70% < enr. ≤ 80% ≤ 26,400-g ^{235}U	60% < enr. ≤ 70% ≤ 25,200-g ^{235}U	enr. ≤ 60% ≤ 36,000-g U
Standards for arrays of fissile material packages (§71.59)						
" . . . the designer of a fissile material package shall derive a number "N" based on all the following conditions being satisfied, assuming packages are stacked together in any arrangement and with close reflection on all sides of the stack by water: " (Paragraph "a")						
Transport index based on nuclear criticality control, CSI = 0.0	**Load-limited to 2,600-g ^{235}U, no can spacers**	**Load-limited to 2,755-g ^{235}U, no can spacers**	**Load-limited to 2,880-g U, no can spacers**	**Load-limited to 3,200-g ^{235}U, no can spacers**	**Load-limited to 3,570-g ^{235}U, no can spacers**	**Load-limited to 7,200-g U, no can spacers**
(1) five times "N" undamaged packages with nothing between the packages would be subcritical,	$k_{eff} + 2\sigma \leq 0.93426$ nciabmt11p_5_1_6_3	$k_{eff} + 2\sigma \leq 0.93464$ nciabmt11p_8_1_5_3	$k_{eff} + 2\sigma \leq 0.93549$ nciabmt11p_11_1_4_3	$k_{eff} + 2\sigma \leq 0.93490$ nciabmt11p_18_1_3_3	$k_{eff} + 2\sigma \leq 0.93377$ nciabmt11p_27_1_2_3	$k_{eff} + 2\sigma \leq 0.93629$ nciabmt11p_39_1_1_3
(2) two times "N" damaged packages, if each package were subject to the tests specified in §71.73 (Hypothetical Accident Conditions) would be subcritical with optimum interspersed hydrogenous moderation,	$k_{eff} + 2\sigma \leq 0.93447$ hciabmt12p_5_1_6_3	$k_{eff} + 2\sigma \leq 0.93569$ hciabmt12p_8_1_5_3	$k_{eff} + 2\sigma \leq 0.93594$ hciabmt12p_11_1_4_3	$k_{eff} + 2\sigma \leq 0.93612$ hciabmt12p_18_1_3_3	$k_{eff} + 2\sigma \leq 0.93602$ hciabmt12p_27_1_2_3	$k_{eff} + 2\sigma \leq 0.93648$ hciabmt12p_39_1_1_3
(3) the value of "N" cannot be <0.5.	N(1,2) = ∞	Same	Same	Same	Same	Same

Table 6.1d. Summary of criticality evaluation for HEU metal turnings, fines, or powder

Conditions	95% < enr. ≤ 100% ≤ 10,500-g ^{235}U	90% < enr. ≤ 95% ≤ 15,295-g ^{235}U	80% < enr. ≤ 90% ≤ 19,800-g ^{235}U	70% < enr. ≤ 80% ≤ 26,400-g ^{235}U	60% < enr. ≤ 70% ≤ 25,200-g ^{235}U	enr. ≤ 60% ≤ 36,000-g U
Transport index based on nuclear criticality control, CSI = 0.4	**Load-limited to 4,000-g ^{235}U, no can spacers**	**Load-limited to 4,370-g ^{235}U, no can spacers**	**Load-limited to 4,860-g U, no can spacers**	**Load-limited to 5,840-g ^{235}U, no can spacers**	**Load-limited to 7,350-g ^{235}U, no can spacers**	**Load-limited to 17,300-g U, no can spacers**
(1) five times "N" undamaged packages	$k_{eff} + 2\sigma \leq 0.93658$ ncf1bmt11p_5_1_6_3	$k_{eff} + 2\sigma \leq 0.93648$ ncf1bmt11p_9_1_5_3	$k_{eff} + 2\sigma \leq 0.93572$ ncf1bmt11p_15_1_4_3	$k_{eff} + 2\sigma \leq 0.93386$ ncf1bmt11p_24_1_3_3	$k_{eff} + 2\sigma \leq 0.93497$ ncf1bmt11p_35_1_2_3	$k_{eff} + 2\sigma \leq 0.93467$ ncf1bmt11p_50_1_1_3
(2) two times "N" damaged packages, ...	$k_{eff} + 2\sigma \leq 0.91151$ hcf2bmt12p_5_1_6_3	$k_{eff} + 2\sigma \leq 0.91150$ hcf2bmt12p_9_1_5_3	$k_{eff} + 2\sigma \leq 0.91130$ hcf2bmt12p_15_1_4_3	$k_{eff} + 2\sigma \leq 0.91363$ hcf2bmt12p_24_1_3_3	$k_{eff} + 2\sigma \leq 0.90985$ hcf2bmt12p_35_1_2_3	$k_{eff} + 2\sigma \leq 0.91110$ hcf2bmt12p_50_1_1_3
(3) the value of "N" . . .	N(1,2) = 202/162	Same	Same	Same	Same	Same
Transport index based on nuclear criticality control, CSI = 0.8	**Load-limited to 6,200-g ^{235}U, no can spacers**	**Load-limited to 7,315-g ^{235}U, no can spacers**	**Load-limited to 8,550-g U, no can spacers**	**Load-limited to 11,360-g ^{235}U, no can spacers**	**Load-limited to 15,260-g ^{235}U, no can spacers**	**Load-limited to 34,500-g U, no can spacers**
(1) five times "N" undamaged packages	$k_{eff} + 2\sigma \leq 0.93492$ ncf2bmt11p_4_1_6_3	$k_{eff} + 2\sigma \leq 0.93505$ ncf2bmt11p_9_1_5_3	$k_{eff} + 2\sigma \leq 0.93445$ ncf2bmt11p_15_1_4_3	$k_{eff} + 2\sigma \leq 0.93347$ ncf2bmt11p_31_1_3_3	$k_{eff} + 2\sigma \leq 0.93234$ ncf2bmt11p_48_1_2_3	$k_{eff} + 2\sigma \leq 0.93276$ ncf2bmt11p_66_1_1_3
(2) two times "N" damaged packages, ...	$k_{eff} + 2\sigma \leq 0.91488$ hcf3bmt12p_4_1_6_3	$k_{eff} + 2\sigma \leq 0.91487$ hcf3bmt12p_9_1_5_3	$k_{eff} + 2\sigma \leq 0.91437$ hcf3bmt12p_15_1_4_3	$k_{eff} + 2\sigma \leq 0.91306$ hcf3bmt12p_31_1_3_3	$k_{eff} + 2\sigma \leq 0.91462$ hcf3bmt12p_48_1_2_3	$k_{eff} + 2\sigma \leq 0.91386$ hcf3bmt12p_66_1_1_3
(3) the value of "N"	N(1,2) = 64/73	Same	Same	Same	Same	Same
Transport index based on nuclear criticality control, CSI = 2.0 [a]	**Load-limited to 10,700-g ^{235}U, no can spacers**	**Load-limited to 13,300-g ^{235}U, no can spacers**	**Load-limited to 16,110-g ^{235}U, no can spacers**	**Load-limited to 20,320-g ^{235}U, no can spacers**	**Load-limited to 25,200-g ^{235}U, no can spacers**	**Load-limited to 36,000-g U, no can spacers**
(1) five times "N" undamaged packages	$k_{eff} + 2\sigma \leq 0.93491$ ncf3bmt11p_5_1_6_3	$k_{eff} + 2\sigma \leq 0.93456$ ncf3bmt11p_13_1_5_3	$k_{eff} + 2\sigma \leq 0.93457$ ncf3bmt11p_24_1_4_3	$k_{eff} + 2\sigma \leq 0.93309$ ncf3bmt11p_39_1_3_3	$k_{eff} + 2\sigma \leq 0.93503$ ncf3bmt11p_58_1_2_3	$k_{eff} + 2\sigma \leq 0.90727$ ncf3bmt11p_58_1_1_3
(2) two times "N" damaged packages, ...	$k_{eff} + 2\sigma \leq 0.89810$ hcf4bmt12p_5_1_6_3	$k_{eff} + 2\sigma \leq 0.89542$ hcf4bmt12p_13_1_5_3	$k_{eff} + 2\sigma \leq 0.89754$ hcf4bmt12p_24_1_4_3	$k_{eff} + 2\sigma \leq 0.89489$ hcf4bmt12p_39_1_3_3	$k_{eff} + 2\sigma \leq 0.89793$ hcf4bmt12p_58_1_2_3	$k_{eff} + 2\sigma \leq 0.87098$ hcf4bmt12p_58_1_1_3
(3) the value of "N"	N(1,2) = 29/25	Same	Same	Same	Same	Same

Table 6.1d. Summary of criticality evaluation for HEU metal turnings, fines, or powder

Conditions	95% < enr. ≤ 100% ≤ 10,500-g ^{235}U	90% < enr. ≤ 95% ≤ 15,295-g ^{235}U	80% < enr. ≤ 90% ≤ 19,800-g ^{235}U	70% < enr. ≤ 80% ≤ 26,400-g ^{235}U	60% < enr. ≤ 70% ≤ 25,200-g ^{235}U	enr. ≤ 60% ≤ 36,000-g U
Transport index based on nuclear criticality control, CSI = 3.2 [b]	**Load-limited to 19,100-g ^{235}U, no can spacers**	**Load-limited to 23,560-g ^{235}U, no can spacers**	**Load-limited to 26,100-g ^{235}U, no can spacers**	**Load-limited to 28,800-g ^{235}U, no can spacers**	**25,200-g ^{235}U, no can spacers**	**36,000-g U, no can spacers**
(1) five times "N" undamaged packages	$k_{eff} + 2\sigma \leq 0.93479$ nctf5bmt11p_5_1_6_3	$k_{eff} + 2\sigma \leq 0.93508$ nctf5bmt11p_14_1_5_3	$k_{eff} + 2\sigma \leq 0.93367$ nctf5bmt11p_27_1_4_3	$k_{eff} + 2\sigma \leq 0.92826$ nctf5bmt11p_42_1_3_3	$k_{eff} + 2\sigma \leq 0.90345$ nctf5bmt11p_42_1_2_3	$k_{eff} + 2\sigma \leq 0.87716$ nctf5bmt11p_42_1_1_3
(2) two times "N" damaged packages, ...	$k_{eff} + 2\sigma \leq 0.91484$ hctf5bmt12p_5_1_6_3	$k_{eff} + 2\sigma \leq 0.91688$ hctf5bmt12p_14_1_5_3	$k_{eff} + 2\sigma \leq 0.91496$ hctf5bmt12p_27_1_4_3	$k_{eff} + 2\sigma \leq 0.90875$ hctf5bmt12p_42_1_3_3	$k_{eff} + 2\sigma \leq 0.88319$ hctf5bmt12p_42_1_2_3	$k_{eff} + 2\sigma \leq 0.85772$ hctf5bmt12p_42_1_1_3
(3) the value of "N"	N(1,2) = 16/24	Same	Same	Same	Same	Same

[a] Neutron multiplication factors and "N" are shown for an NCT array size of 7×7×3 and an HAC array size of 5×5×2; both arrays are nearly cubic arrangements. An HAC array size is not available for CSI=1.8; therefore, CSI for NCT at 1.8 is rounded up to 2.0 as shown.

[b] Neutron multiplication factors and "N" are shown for an NCT array size of 27×3 and an HAC array size of 16×3; where packages in the planar dimension are in explicit triangular-pitch arrangement and stacked three high in the vertical direction. An NCT array size of 81 packages gives a CSI value of 3.12 (50 / 16), while an HAC array size of 48 packages gives a CSI value of 2.08 (50 / 24). The specified CSI value of 3.2 is the larger of the two numbers rounded up to the nearest tenth decimal place as shown.

Table 6.1e. Summary of criticality evaluation for HEU product oxide

Conditions	HEU product oxide 2.0-6.54 g/cm^3 ≤ 21,125-g ^{235}U	HEU product oxide ≥ 1.75 g/cm^3 ≤ 14,083-g ^{235}U	HEU product oxide ≥ 1.5 g/cm^3 ≤ 12,323-g ^{235}U	HEU product oxide ≥ 1.25 g/cm^3 ≤ 10,562-g ^{235}U
General requirements for each fissile package (§71.55)				
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited that it would be subcritical if water were to leak into the containment system, . . . so that under the following conditions, maximum reactivity of the fissile material would be attained:" (Paragraph "b")	$k_{eff} + 2\sigma \leq 0.9143$ cvcrpdoxt11_1_3_24_15	$k_{eff} + 2\sigma \leq 0.9196$ cvcrldoxt11_1_20_15	$k_{eff} + 2\sigma \leq 0.9154$ cvcrldoxt11_2_18_15	$k_{eff} + 2\sigma \leq 0.9208$ cvcrldoxt11_3_16_15
(1) the most reactive credible configuration consistent with the chemical and physical form of the material,	HEU oxide at the bulk density is assumed dispersed in the CV, where the oxide fills the CV to a height determined by the oxide mass. The oxide is saturated with water. Water fills the void region above the oxide content, but this amount of water is reduced by an amount equivalent to the volume occupied by can spacers. The can pads, spacer can, and convenience can steel are replaced by water. See Sect. 6.9.3.1 for justification of the content model.			
(2) moderation by water to the most reactive credible extent,	Flooding of the CV			
(3) close full reflection of the containment system by water on all sides, or such greater reflection of the containment system as may be provided by the surrounding material of the packaging.	30.48-cm H_2O surrounding the CV			
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited under the tests specified in §71.71 (Normal Conditions of Transport) . . ." (Paragraph "d")				
(1) the contents would be subcritical,	$k_{eff} + 2\sigma \leq 0.8166$ ncsrpdoxt11_1_3_24	$k_{eff} + 2\sigma \leq 0.8123$ ncsrldoxt11_1_20	$k_{eff} + 2\sigma \leq 0.8110$ ncsrldoxt11_2_28	$k_{eff} + 2\sigma \leq 0.8092$ ncsrldoxt11_3_16
(2) the geometric form of the package contents would not be substantially altered,	HEU oxide at the bulk density is assumed dispersed in the CV, where the oxide fills the CV to a height determined by the oxide mass. The oxide is saturated with water. Water fills the void region above the oxide content, but this amount of water is reduced by an amount equivalent to the volume occupied by can spacers. The can pads, spacer can, and convenience can steel are replaced by water.			

Table 6.1e. Summary of criticality evaluation for HEU product oxide

Conditions	HEU product oxide 2.0-6.54 g/cm^3 ≤ 21,125-g ^{235}U	HEU product oxide ≥ 1.75 g/cm^3 ≤ 14,083-g ^{235}U	HEU product oxide ≥ 1.5 g/cm^3 ≤ 12,323-g ^{235}U	HEU product oxide ≥ 1.25 g/cm^3 ≤ 10,562-g ^{235}U
(3) there would be no leakage of water into the containment system unless, in the evaluation of undamaged packages under §71.59(a)(1), it has been assumed that moderation is present to such an extent as to cause maximum reactivity consistent with the chemical and physical form of the material,	Moderation is present to such an extent as to cause maximum reactivity			
(4) there will be no substantial reduction in the effectiveness of the packaging	30.48-cm H_2O surrounding the drum (d = 18.37 in., h = 43.5 in.)			
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited that under the tests specified in §71.73 (Hypothetical Accident Conditions) the package would be subcritical. For this determination, it must be assumed that:" (Paragraph "e")	$k_{eff} + 2\sigma \leq 0.8187$ hcsrpdoxt12_1_3_24	$k_{eff} + 2\sigma \leq 0.8132$ hcsrldoxt12_1_20	$k_{eff} + 2\sigma \leq 0.8098$ hcsrldoxt12_2_18	$k_{eff} + 2\sigma \leq 0.8117$ hcsrldoxt12_3_16
(1) the fissile material is in the most reactive credible configuration consistent with the chemical and physical form of the contents,	HEU oxide at the bulk density is assumed dispersed in the CV, where the oxide fills the CV to a height determined by the oxide mass. The oxide is saturated with water. Water fills the void region above the oxide content, but this amount of water is reduced by an amount equivalent to the volume occupied by can spacers. The can pads, spacer can, and convenience can steel are replaced by water.			
(2) water moderation occurs to the most reactive credible extent consistent with the chemical and physical form of content,	Flooding of the package			
(3) there is full reflection by water on all sides, as close as is consistent with the damage condition of the package.	30.48-cm H_2O surrounding the reduced diameter drum (d = 17.20 in., h = 43.5 in.)			

Table 6.1e. Summary of criticality evaluation for HEU product oxide

Conditions	HEU product oxide 2.0-6.54 g/cm^3 ≤ 21,125-g ^{235}U	HEU product oxide ≥ 1.75 g/cm^3 ≤ 14,083-g ^{235}U	HEU product oxide ≥ 1.5 g/cm^3 ≤ 12,323-g ^{235}U	HEU product oxide ≥ 1.25 g/cm^3 ≤ 10,562-g ^{235}U
Standards for arrays of fissile material packages (§71.59)				
" . . . the designer of a fissile material package shall derive a number "N" based on all the following conditions being satisfied, assuming packages are stacked together in any arrangement and with close reflection on all sides of the stack by water: " (Paragraph "a")				
Transport index based on nuclear criticality control, CSI = 0.0	**Load-limited to 9,682-g ^{235}U, [b] no can spacers**	**Load-limited to 9,400-g ^{235}U, no can spacers**	**Load-limited to 8,300-g ^{235}U, no can spacers**	**Load-limited to 7,200-g ^{235}U, no can spacers**
(1) five times "N" undamaged packages with nothing between the packages would be subcritical,	$k_{eff} + 2\sigma \leq 0.9201$ nciapdoxt11_1_1_11_3	$k_{eff} + 2\sigma \leq 0.9344$ ncialdoxt11_1_19_1	$k_{eff} + 2\sigma \leq 0.9339$ ncialdoxt11_2_16_3	$k_{eff} + 2\sigma \leq 0.9344$ ncialdoxt11_3_12_2
(2) two times "N" damaged packages, if each package were subject to the tests specified in §71.73 (Hypothetical Accident Conditions) would be subcritical with optimum interspersed hydrogenous moderation,	$k_{eff} + 2\sigma \leq 0.9247$ hciapdoxt12_1_1_11_3	$k_{eff} + 2\sigma \leq 0.9350$ hcialdoxt12_1_19_2	$k_{eff} + 2\sigma \leq 0.9350$ hcialdoxt12_1_19_2	$k_{eff} + 2\sigma \leq 0.9350$ hcialdoxt12_1_19_2
(3) the value of "N" cannot be <0.5.	$N(1,2) = \infty$	Same	Same	Same

[a] See Appendix 6.9.11 for removal of the carbon limit.

[b] For HEU product oxides with a bulk density ranging from ≥ 2.0 g/cm^3 to 6.54 g/cm^3 at a CSI of 0.4, the maximum ^{235}U per ES-3100 package is 12,323 g as discussed in Appendix 6.9.9.

Table 6.1e. Summary of criticality evaluation for HEU product and skull oxide

Conditions	HEU product oxide ≥ 1.75 g/cm^3 ≤ 14,083-g ^{235}U	HEU product oxide ≥ 1.5 g/cm^3 ≤ 12,323-g ^{235}U	HEU product oxide ≥ 1.25 g/cm^3 ≤ 10,562-g ^{235}U
General requirements for each fissile package (§71.55)			
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited that it would be subcritical if water were to leak into the containment system, . . . so that under the following conditions, maximum reactivity of the fissile material would be attained:" (Paragraph "b")	$k_{eff} + 2\sigma \leq 0.9111$ cvcrldoxt11_4_13_15	$k_{eff} + 2\sigma \leq 0.9060$ cvcrldoxt11_5_11_15	$k_{eff} + 2\sigma \leq 0.8943$ cvcrldoxt11_6_8_15
(4) the most reactive credible configuration consistent with the chemical and physical form of the material,	HEU oxide at the bulk density is assumed dispersed in the CV, where the oxide fills the CV to a height determined by the oxide mass. The oxide is saturated with water. Water fills the void region above the oxide content, but this amount of water is reduced by an amount equivalent to the volume occupied by can spacers. The can pads, spacer can, and convenience can steel are replaced by water. See Sect. 6.9.3.1 for justification of the content model.		
(5) moderation by water to the most reactive credible extent,	Flooding of the CV		
(6) close full reflection of the containment system by water on all sides, or such greater reflection of the containment system as may be provided by the surrounding material of the packaging.	30.48-cm H_2O surrounding the CV		
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited under the tests specified in §71.71 (Normal Conditions of Transport) . . ." (Paragraph "d")			
(7) the contents would be subcritical,	$k_{eff} + 2\sigma \leq 0.8052$ ncsrldoxt11_4_13	$k_{eff} + 2\sigma \leq 0.7984$ ncsrldoxt11_5_11	$k_{eff} + 2\sigma \leq 0.7871$ ncsrldoxt11_6_8
(8) the geometric form of the package contents would not be substantially altered,	HEU oxide at the bulk density is assumed dispersed in the CV, where the oxide fills the CV to a height determined by the oxide mass. The oxide is saturated with water. Water fills the void region above the oxide content, but this amount of water is reduced by an amount equivalent to the volume occupied by can spacers. The can pads, spacer can, and convenience can steel are replaced by water.		

Table 6.1e. Summary of criticality evaluation for HEU product and skull oxide

Conditions	HEU product oxide ≥ 1.75 g/cm^3 ≤ 14,083-g ^{235}U	HEU product oxide ≥ 1.5 g/cm^3 ≤ 12,323-g ^{235}U	HEU product oxide ≥ 1.25 g/cm^3 ≤ 10,562-g ^{235}U
(9) there would be no leakage of water into the containment system unless, in the evaluation of undamaged packages under §71.59(a)(1), it has been assumed that moderation is present to such an extent as to cause maximum reactivity consistent with the chemical and physical form of the material,	Moderation is present to such an extent as to cause maximum reactivity		
(10) there will be no substantial reduction in the effectiveness of the packaging	30.48-cm H_2O surrounding the drum (d = 18.37 in., h = 43.5 in.)		
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited that under the tests specified in §71.73 (Hypothetical Accident Conditions) the package would be subcritical. For this determination, it must be assumed that:" (Paragraph "e")	$k_{eff} + 2\sigma \leq 0.8063$ hcsrldoxt12_4_13	$k_{eff} + 2\sigma \leq 0.7997$ hcsrldoxt12_5_11	$k_{eff} + 2\sigma \leq 0.7890$ hcsrldoxt12_6_8
(11) the fissile material is in the most reactive credible configuration consistent with the chemical and physical form of the contents,	HEU oxide at the bulk density is assumed dispersed in the CV, where the oxide fills the CV to a height determined by the oxide mass. The oxide is saturated with water. Water fills the void region above the oxide content, but this amount of water is reduced by an amount equivalent to the volume occupied by can spacers. The can pads, spacer can, and convenience can steel are replaced by water.		
(12) water moderation occurs to the most reactive credible extent consistent with the chemical and physical form of content,	Flooding of the package		
(13) there is full reflection by water on all sides, as close as is consistent with the damage condition of the package.	30.48-cm H_2O surrounding the reduced diameter drum (d = 17.20 in., h = 43.5 in.)		

Table 6.1e. Summary of criticality evaluation for HEU product and skull oxide

Conditions	HEU product oxide ≥ 1.75 g/cm^3 ≤ 14,083-g ^{235}U	HEU product oxide ≥ 1.5 g/cm^3 ≤ 12,323-g ^{235}U	HEU product oxide ≥ 1.25 g/cm^3 ≤ 10,562-g ^{235}U
Standards for arrays of fissile material packages (§71.59)			
" . . . the designer of a fissile material package shall derive a number "N" based on all the following conditions being satisfied, assuming packages are stacked together in any arrangement and with close reflection on all sides of the stack by water: " (Paragraph "a")			
Transport index based on nuclear criticality control, CSI = 0.0	**Load-limited to 9,400-g ^{235}U, no can spacers**	**Load-limited to 8,300-g ^{235}U, no can spacers**	**Load-limited to 7,200-g ^{235}U, no can spacers**
(14) five times "N" undamaged packages with nothing between the packages would be subcritical,	$k_{eff} + 2\sigma \leq 0.9326$ ncialdoxt11_4_9_1	$k_{eff} + 2\sigma \leq 0.9332$ ncialdoxt11_5_5_2	$k_{eff} + 2\sigma \leq 0.9271$ ncialdoxt11_6_1_2
(15) two times "N" damaged packages, if each package were subject to the tests specified in §71.73 (Hypothetical Accident Conditions) would be subcritical with optimum interspersed hydrogenous moderation,	$k_{eff} + 2\sigma \leq 0.9327$ hcialdoxt12_4_9_1	$k_{eff} + 2\sigma \leq 0.9318$ hcialdoxt12_5_5_2	$k_{eff} + 2\sigma \leq 0.9260$ hcialdoxt12_6_1_1
(16) the value of "N" cannot be <0.5.	N(1,2) = ∞	Same	Same

Table 6.1f. Summary of criticality evaluation for UNX crystals and unirradiated TRIGA reactor fuel elements

Conditions	UNX crystals ≤ 11,303-g ^{235}U	Unirradiated TRIGA fuel elements ≤ 921-g ^{235}U
General requirements for each fissile package (§71.55)		
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited that it would be subcritical if water were to leak into the containment system, . . . so that under the following conditions, maximum reactivity of the fissile material would be attained:" (Paragraph "b")	$k_{eff} + 2\sigma \leq 0.8630$ cvcrpunhct11_10_15	$k_{eff} + 2\sigma \leq 0.53709$ cvcrtrigap_1_15
(1) the most reactive credible configuration consistent with the chemical and physical form of the material,	UNX crystals are homogenized with water over the internal volume of the CV consistent with the high solubility properties of UNX. Can spacers are not used. Hydrogenous packing material represented by 500 g.	Three 5-in tall sectioned pieces of $UZrH_x$ from a cylindrical TRIGA fuel element per convenience can. Sectioned pieces arranged in triangular pitch. No can spacers. Convenience can steel replaced by water.
(2) moderation by water to the most reactive credible extent,	Flooding of the CV	Same
(3) close full reflection of the containment system by water on all sides, or such greater reflection of the containment system as may be provided by the surrounding material of the packaging.	30.48-cm H_2O surrounding the CV	Same

Table 6.1f. Summary of criticality evaluation for UNX crystals and unirradiated TRIGA reactor fuel elements

Conditions	UNX crystals ≤ 11,303-g ^{235}U	Unirradiated TRIGA fuel elements ≤ 921-g ^{235}U
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited under the tests specified in §71.71 (Normal Conditions of Transport) . . ." (Paragraph "d")		
(1) the contents would be subcritical,	$k_{eff} + 2\sigma \leq 0.7526$ ncsrpunhct11_8_15	$k_{eff} + 2\sigma \leq 0.50588$ ncsrtrigap_1_15_15
(2) the geometric form of the package contents would not be substantially altered,	UNX crystals are homogenized with water over the internal volume of the CV consistent with the high solubility properties of UNX. Can spacers are not used. Hydrogenous packing material represented by 500 g.	Three 5-in tall sectioned pieces of UZrHx from a cylindrical TRIGA fuel element per convenience can. Sectioned pieces arranged in triangular pitch. No can spacers. Convenience can steel replaced by water.
(3) there would be no leakage of water into the containment system unless, in the evaluation of undamaged packages under §71.59(a)(1), it has been assumed that moderation is present to such an extent as to cause maximum reactivity consistent with the chemical and physical form of the material,	Moderation is present to such an extent as to cause maximum reactivity	Same
(4) there will be no substantial reduction in the effectiveness of the packaging	30.48-cm H_2O surrounding the drum (d = 18.37 in., h = 43.5 in.)	Same

Table 6.1f. Summary of criticality evaluation for UNX crystals and unirradiated TRIGA reactor fuel elements

Conditions	UNX crystals ≤ 11,303-g ^{235}U	Unirradiated TRIGA fuel elements ≤ 921-g ^{235}U
"A package used for shipment of fissile material must be so designed and constructed and its contents so limited that under the tests specified in §71.73 (Hypothetical Accident Conditions) the package would be subcritical. For this determination, it must be assumed that:" (Paragraph "e")	$k_{eff} + 2\sigma \leq 0.8144$ icsrpunhct12_15_15	$k_{eff} + 2\sigma \leq 0.50689$ hcsrtrigap_1_15_15
(1) the fissile material is in the most reactive credible configuration consistent with the chemical and physical form of the contents,	UNX crystals are homogenized with water over the internal volume of the CV consistent with the high solubility properties of UNX. Can spacers are not used. Hydrogenous packing material represented by 500 g.	Three 5-in tall sectioned pieces of UZrHx from a cylindrical TRIGA fuel element per convenience can. Sectioned pieces arranged in triangular pitch. No can spacers. Convenience can steel replaced by water.
(2) water moderation occurs to the most reactive credible extent consistent with the chemical and physical form of content,	Flooding of the package	Same
(3) there is full reflection by water on all sides, as close as is consistent with the damage condition of the package.	30.48-cm H_2O surrounding the reduced diameter drum (d = 17.20 in., h = 43.5 in.)	Same

Table 6.1f. Summary of criticality evaluation for UNX crystals and unirradiated TRIGA reactor fuel elements

Conditions	UNX crystals ≤ 11,303-g ^{235}U	Unirradiated TRIGA fuel elements ≤ 921-g ^{235}U
Standards for arrays of fissile material packages (§71.59)		
" . . . the designer of a fissile material package shall derive a number "N" based on all the following conditions being satisfied, assuming packages are stacked together in any arrangement and with close reflection on all sides of the stack by water: " (Paragraph "a")		
Transport index based on nuclear criticality control, CSI = 0.0	**Load-limited to 3297-g ^{235}U, no can spacers**	**No can spacers**
(1) five times "N" undamaged packages with nothing between the packages would be subcritical,	$k_{eff} + 2\sigma \leq 0.9199$ nciapunhct11_7_3	$k_{eff} + 2\sigma \leq 0.54642$ nciatriga_1_15_3
(2) two times "N" damaged packages, if each package were subject to the tests specified in §71.73 (Hypothetical Accident Conditions) would be subcritical with optimum interspersed hydrogenous moderation,	$k_{eff} + 2\sigma \leq 0.9180$ hciapunhct12_7_3	$k_{eff} + 2\sigma \leq 0.53740$ hciatrigap_1_15_3
(3) the value of "N" cannot be <0.5.	N(1,2) = ∞	Same
Transport index based on nuclear criticality control, CSI = 0.0	**Can spacers**	**Can spacers**
(1) five times "N" undamaged packages	Not applicable	$k_{eff} + 2\sigma \leq 0.45280$ nciatrigap_2_15_3
(2) two times "N" damaged packages, ...	Not applicable	$k_{eff} + 2\sigma \leq 0.45337$ hciatrigap_2_15_3
(3) the value of "N"	Not applicable	N(1,2) = ∞

Table 6.1f. Summary of criticality evaluation for UNX crystals and unirradiated TRIGA reactor fuel elements

Conditions	UNX crystals ≤ 11,303-g ^{235}U	Unirradiated TRIGA fuel elements ≤ 921-g ^{235}U
Transport index based on nuclear criticality control, CSI = 0.4	**Load-limited to 11,303-g ^{235}U, no can spacers**	**No can spacers**
(1) five times "N" undamaged packages	$k_{eff} + 2\sigma \leq 0.8730$ ncf1punhct11_24_3	Bounded by CSI=0
(2) two times "N" damaged packages, ...	$k_{eff} + 2\sigma \leq 0.8423$ hcf2punhct12_24_3	Bounded by CSI=0
(3) the value of "N"	N(1,2) = 202/162	Same
Transport index based on nuclear criticality control, CSI = 0.4	**Can spacers**	**Can spacers**
(1) five times "N" undamaged packages	Not applicable	Bounded by CSI=0
(2) two times "N" damaged packages, ...	Not applicable	Bounded by CSI=0
(3) the value of "N"	Not applicable	N(1,2) = 202/162

The evaluation limits for solid HEU metal shapes are listed in the column headings appearing to the right of the "Conditions" column of Table 6.1a. Limits expressed in terms of the diameter for a cylinder and the length-width of the geometric cross section for a square bar are established by the size of the convenience can opening through which these contents are inserted. Potential fissile (^{235}U) mass loading limits for these contents are given in the information blocks where a description of the content appears for the fissile material "in the most reactive credible configuration."

The fissile (^{235}U) or uranium masses listed in the column headings of Tables 6.1b–6.1f indicate evaluation limits for the associated content configurations. In the case of slugs (Table 6.1b), the ^{235}U evaluation limits represent the fissile content contained in the slugs with maximum tolerances applied. In the case of broken metal (Table 6.1c), the ^{235}U evaluation limits represent the maximum amount of ^{235}U adequately subcritical in a flooded, reflected CV as conservatively applied over the indicated range of enrichment. For HEU enrichments ≤ 60%, the 35.32-kg package limit on the amount of HEU to be shipped in an ES-3100 becomes the evaluation limit. Relative to the broken metal limits specified in Table 6.1c, the ^{235}U evaluation limit permissible for HEU metal in the form of turnings, fines, or powder is reduced at the higher enrichments (Table 6.1d). For HEU oxide and UNX crystals (Tables 6.1e and 6.1f), the ^{235}U evaluation limits correspond to the 24-kg package limit on the amount of HEU oxide or UNX crystals to be shipped. For HEU skull oxide (Table 6.1e), the ^{235}U evaluation limit represents a maximum derived from the evaluation of an inventory at Y-12. For unirradiated TRIGA reactor fuel elements (Table 6.1f), the ^{235}U evaluation limit represents a maximum for the fuel manufacturer's product line.

The NCT and HAC array analyses [10 CFR 71.59(a)(1) and (a)(2)] may reveal reductions in the potential loading limits for content and 277-4 canned spacer configurations initially identified in the single package calculations [10 CFR 71.55(b), (d), and (e)] of Tables 6.1a–6.1f. This occurs in order to achieve fissile material loadings which are at or below the subcritical safety limit. These reduced loading limits are identified as "**load-limited to**" values in the "CSI" rows.

Table 6.2a summarizes the fissile loading limits derived from Tables 6.1a–6.1f for surface-only transport mode. In establishing compliance with the fissile loading limit indicated in Table 6.2a for uranium alloys of aluminum, molybdenum, zirconium, stainless steel, titanium, tungsten, niobium, silicon, or vanadium, the content mass of ^{235}U includes the mass of the non-uranium alloy constituents. The fissile loading limits pertaining to the air-transport mode summarized in Table 6.2b are derived from the air-transport analysis addressed in Sect. 6.7. Packages transported by air involve both surface and air modes of transportation. The loading limit for packages under mixed-mode transportation is taken as the most restrictive limit for either mode (surface or air transport).

The "no water inleakage" condition of 10 CFR 71.55(f)(1) and (f)(2) signifies that the hydrogenous material present in the package during air transport is limited to the amount present in the package when it is loaded on the aircraft for transport. The dry-baked Kaolite in the drum body weldment and drum top plug consists of vermiculite-cement constituents and 2,204.7 g of bound water. Potential sources of additional hydrogen moderator are the hydrogenous packing materials present inside the CV, moisture inside the CV well, and the moisture inside the Kaolite region of the package.

For establishing the loading limits for air transport, the total **free** water in wet Kaolite was conservatively evaluated up to 15 lb (6,803.8 g). Based on this evaluation, **free** water must be limited to 12 lb (5,443.1 g) for maintaining the required margin of subcriticality when shipping under the air transport loading limits specified in Table 6.2b. This requirement is specific to the Kaolite region of the ES-3100 package for two reasons. First, the hydrogenous packing material inside the CV is limited to 500 g per the air transport evaluation. Second, the use of a drum covering and administrative controls (Sects. 7 and 7.1.3.1) will ensure dryness of the CV well. Package operational controls and acceptance limits (Chaps. 7 and 8) will ensure that a package to be used for air transport is qualified.

Table 6.2a. HEU fissile material mass loading limits (with case name) for surface-only modes of transportation

Solid HEU metal of specified geometric shape [a]						
Transport index based on nuclear criticality control	**Cylinders (d ≤ 3.24 in.)**	**Cylinders (3.24 in. < d ≤ 4.25 in.)**	**Bars**	**Slugs [b] enr. ≤ 95%**	**Slugs [c] 80% < enr. ≤ 95%**	**Slugs [c] enr. ≤ 80%**
No can spacers						
CSI = 0.0	18,000-g ^{235}U nciacyt11_18_1_3	15,000-g ^{235}U nciacyct11_15_1_3	30,000-g ^{235}U hciasqt12_30_1_3	17,374-g ^{235}U ncia5st11_1_1_7_3	–	–
With can spacers						
CSI = 0.0	30,000-g ^{235}U nciacyt11_30_2_3	25,000-g ^{235}U nciacyct11p_25_2_3	36,000-g ^{235}U nciasqt11_36_2_3	–	24,324-g ^{235}U hcia70st12_2_7_3	29,318-g ^{235}U hcia5est12_2_2_5_3
CSI = 0.4	–	–	–	–	34,749-g ^{235}U [c] ncf15est11_2_2_7_3	29,318-g ^{235}U ncf15est11_2_2_5_3

HEU broken metal or solid HEU metal of unspecified geometric shape and characterized as broken metal [a, e, f, g]						
Transport index based on nuclear criticality control	**95% < enr. ≤ 100%**	**90% < enr. ≤95%**	**80% < enr. ≤90%**	**70% < enr. ≤80%**	**60% < enr. ≤70%**	**Enr. ≤60%**
No can spacers						
CSI = 0.0	2,600-g ^{235}U hciabmt12_5_1_6_3	2,755-g ^{235}U hciabmt12_8_1_5_3	2,880-g ^{235}U hciabmt12_11_1_4_3	3,200-g ^{235}U hciabmt12_18_1_3_3	3,570-g ^{235}U hciabmt12_27_1_2_3	7,200-g U hciabmt12_39_1_1_3
CSI = 0.4	4,000-g ^{235}U ncf1bmt11_5_1_6_3	4,370-g ^{235}U ncf1bmt11_9_1_5_3	4,860-g ^{235}U ncf1bmt11_15_1_4_3	5,840-g ^{235}U ncf1bmt11_24_1_3_3	7,350-g ^{235}U ncf1bmt11_35_1_2_3	17,300-g U ncf1bmt11_50_1_1_3
CSI = 0.8	6,200-g ^{235}U ncf2bmt11_4_1_6_3	7,315-g ^{235}U ncf2bmt11_9_1_5_3	8,550-g ^{235}U ncf2bmt11_15_1_4_3	11,360-g ^{235}U ncf2bmt11_31_1_3_3	15,260-g ^{235}U ncf2bmt11_48_1_2_3	34,500-g U ncf2bmt11_66_1_1_3
CSI = 2.0	10,700-g ^{235}U ncf3bmt11_5_1_6_3	13,300-g ^{235}U ncf3bmt11_13_1_5_3	16,110-g ^{235}U ncf3bmt11_24_1_4_3	20,320-g ^{235}U ncf3bmt11_39_1_3_3	25,200-g ^{235}U ncf3bmt11_58_1_2_3	36,000-g U ncf3bmt11_58_1_1_3
CSI = 3.2	19,100-g ^{235}U ncf5bmt11_5_1_6_3	23,560-g ^{235}U[d] ncf5bmt11_14_1_5_3	26,100-g ^{235}U ncf5bmt11_27_1_4_3	28,800-g ^{235}U ncf5bmt11_42_1_3_3	25,200-g ^{235}U ncf5bmt11_42_1_2_3	36,000-g U ncf5bmt11_42_1_1_3

Table 6.2a. HEU fissile material mass loading limits (with case name) for surface-only modes of transportation

Transport index based on nuclear criticality control	95% < enr. ≤ 100%	90% < enr. ≤95%	80% < enr. ≤90%	70% < enr. ≤80%	60% < enr. ≤70%	Enr. ≤60%
With can spacers						
CSI = 0.0	3,600-g ^{235}U hciabmt12_14_2_6_3	3,800-g ^{235}U hciabmt12_18_2_5_3	4,140-g ^{235}U hciabmt12_22_2_4_3	4,880-g ^{235}U hciabmt12_32_2_3_3	6.580-g ^{235}U hciabmt12_45_2_2_3	14,100-g U hciabmt12_55_2_1_3
CSI = 0.4	5,900-g ^{235}U ncf1bmt11_19_2_6_3	6,395-g ^{235}U ncf1bmt11_24_2_5_3	8,460-g ^{235}U ncf1bmt11_30_2_4_3	11,040-g ^{235}U ncf1bmt11_42_2_3_3	15,260-g ^{235}U ncf1bmt11_57_2_2_3	32,900-g U ncf1bmt11_68_2_1_3
CSI = 0.8	10,500-g ^{235}U ncf2bmt11_20_2_6_3	12,825-g ^{235}U ncf2bmt11_28_2_5_3	15,660-g ^{235}U ncf2bmt11_40_2_4_3	20,480-g ^{235}U ncf2bmt11_56_2_3_3	24,780-g ^{235}U ncf2bmt11_71_2_2_3	36,000-g U ncf2bmt11_73_2_1_3
CSI = 2.0	17,500-g ^{235}U ncf3bmt11_20_2_6_3	21,280-g ^{235}U ncf3bmt11_32_2_5_3	24,750-g ^{235}U ncf3bmt11_45_2_4_3	28,800-g ^{235}U ncf3bmt11_58_2_3_3	25,200-g ^{235}U ncf3bmt11_58_2_2_3	36,000-g U ncf3bmt11_58_2_1_3
CSI = 3.2	27,400-g ^{235}U[e] ncf5bmt11_22_2_6_3	30,970-g ^{235}U[g] ncf5bmt11_34_2_5_3	32,400-g ^{235}U[k] ncf5bmt11_42_2_4_3	28,800-g ^{235}U ncf5bmt11_42_2_3_3	25,200-g ^{235}U ncf5bmt11_42_2_2_3	36,000-g U ncf5bmt11_42_2_1_3
HEU metal turnings, fines, or powder [a, e, g]						
Transport index based on nuclear criticality control	**95% < enr. ≤ 100%**	**90% < enr. ≤95%**	**80% < enr. ≤90%**	**70% < enr. ≤80%**	**60% < enr. ≤70%**	**Enr. ≤60%**
No can spacers						
CSI = 0.0	2,600-g ^{235}U hciabmt12_5_1_6_3	2,755-g ^{235}U hciabmt12_8_1_5_3	2,880-g ^{235}U hciabmt12_11_1_4_3	3,200-g ^{235}U hciabmt12_18_1_3_3	3,570-g ^{235}U hciabmt12_27_1_2_3	7,200-g U hciabmt12_39_1_1_3
CSI = 0.4	4,000-g ^{235}U ncf1bmt11_5_1_6_3	4,370-g ^{235}U ncf1bmt11_9_1_5_3	4,860-g ^{235}U ncf1bmt11_15_1_4_3	5,840-g ^{235}U ncf1bmt11_24_1_3_3	7,350-g ^{235}U ncf1bmt11_35_1_2_3	17,300-g U ncf1bmt11_50_1_1_3
CSI = 0.8	6,200-g ^{235}U ncf2bmt11_4_1_6_3	7,315-g ^{235}U ncf2bmt11_9_1_5_3	8,550-g ^{235}U ncf2bmt11_15_1_4_3	11,360-g ^{235}U ncf2bmt11_31_1_3_3	15,260-g ^{235}U ncf2bmt11_48_1_2_3	34,500-g U ncf2bmt11_66_1_1_3
CSI = 2.0	10,700-g ^{235}U[l] ncf3bmt11_5_1_6_3	13,300-g ^{235}U ncf3bmt11_13_1_5_3	16,110-g ^{235}U ncf3bmt11_24_1_4_3	20,320-g ^{235}U ncf3bmt11_39_1_3_3	25,200-g ^{235}U ncf3bmt11_58_1_2_3	36,000-g U ncf3bmt11_58_1_1_3
CSI = 3.2	19,100-g ^{235}U[m] ncf5bmt11_5_1_6_3	23,560-g ^{235}U[n] ncf5bmt11_14_1_5_3	26,100-g ^{235}U[o] ncf5bmt11_27_1_4_3	28,800-g ^{235}U[p] ncf5bmt11_42_1_3_3	25,200-g ^{235}U ncf5bmt11_42_1_2_3	36,000-g U ncf5bmt11_42_1_1_3

Table 6.2a. HEU fissile material mass loading limits (with case name) for surface-only modes of transportation

HEU oxide, UNX crystals, and unirradiated TRIGA fuel elements					
Transport index based on nuclear criticality control	**HEU product oxide, no can spacers**	**HEU skull oxide, no can spacers**	**UNX crystals, no can spacers**	**Unirradiated TRIGA fuel elements, no can spacers [h]**	
				20% enr.	**70% enr.**
CSI = 0.0	9,682-g ^{235}U hciapdoxt12_1_1_11_3	15,673-g ^{235}U and 921-g C [i] nciask_9_15	3,297-g ^{235}U nciapunhct11_7_3	921-g ^{235}U nciatrigap_1_15_3	408-g ^{235}U nciatriga70p_1_15_3
CSI = 0.4	12,323-g ^{235}U [j] 5ncf1pdoxt11_1_1_14_3	–	11,303-g ^{235}U ncf1punhct11_24_3	–	–

[a] Uranium alloys (uranium with aluminum, thorium, molybdenum, zirconium, stainless steel, titanium, tungsten, niobium, silicon, or vanadium) may be loaded to the appropriate mass limit as discussed in Appendix 6.9.11.

[b] When can spacers **are not** used, the mass limit = 17,374-g ^{235}U.

[c] When can spacers are used, a greater fissile mass limit is permissible based on enrichment. For CSI=0 and enrichments >80 wt %, the fissile mass must be reduced below the volumetric limit. For CSI=0.4, fissile mass is volumetrically limited by the size of the slugs. Note that within a fixed volume, the HEU mass increases slightly with decreasing enrichment.

[d] Case ncf5bmt11p_14_1_5_3 (with a mass of 23.560 kg ^{235}U) establishes the CSI value of 3.2. The more restrictive mass of 23.370 kg ^{235}U is from Case **cvr3lhap_18_1_5_15** (Table 6.1c).

[e] Case ncf5bmt11p_22_2_6_3 (with a mass of 27.400 kg ^{235}U) establishes the CSI value of 3.2. The more restrictive mass of 22.400 kg ^{235}U is from Case cvr3lhap_9_1_6_15 (Table 6.1c).

[f] Samples and small quantities (≤ 50 g) of HEU metal or alloy turnings, fines, or powder can be shipped under the parent form mass limits (e.g., broken metal, reactor fuel, etc.).

[g] Case ncf5bmt11p_34_2_5_3 (with a mass of 30.970 kg ^{235}U) establishes the CSI value of 3.2. The more restrictive mass of 23.370 kg ^{235}U is from Case cvr3lhap_18_1_5_15 (Table 6.1c).

[h] For ground transport, TRIGA reactor fuel element content will be limited to three fuel sections ("meats") per loaded convenience can and up to three loaded cans per package. The TRIGA fuel content may also be configured as clad fuel rods, each rod derived from a single TRIGA fuel element. A ~15-in.-long rod consists of the three fuel pellets and an exterior sheath of clad, where protruding clad at each end has been crimped in. Clad fuel rods will be packed into convenience cans, with a maximum of three fuel rods per loaded convenience can and one loaded can per containment vessel.

[i] Removal of the carbon limit (i.e., 921-g C) is addressed in Appendix 6.9.11.

[j] See Appendix 6.9.9.

[k] Case ncf5bmt11p_42_2_4_3 (with a mass of 32.400 kg ^{235}U) establishes the CSI value of 3.2. The more restrictive mass of 27.990 kg ^{235}U is from Case cvr3lhap_28_1_4_15 (Table 6.1c).

[l] Case ncf4bmt11p_5_1_6_3 (with a mass of 10.700 kg ^{235}U) establishes the CSI value of 2.0. The more restrictive mass of 10.500 kg ^{235}U is from Case cvr3chap_5_1_6_15 (Table 6.1d).

[m] Case nctf5bmt11p_5_1_6_3 (with a mass of 19.100 kg ^{235}U) establishes the CSI value of 3.2. The more restrictive mass of 10.500 kg ^{235}U is from Case cvr3chap_6_1_6_15 (Table 6.1d).

[n] Case nctf5bmt11p_14_1_5_3 (with a mass of 23.560 kg ^{235}U) establishes the CSI value of 3.2. The more restrictive mass of 15.295 kg ^{235}U is from Case cvr3lhap_14_1_5_15 (Table 6.1d).

[o] Case nctf5bmt11p_27_1_4_3 (with a mass of 26.100 kg ^{235}U) establishes the CSI value of 3.2. The more restrictive mass of 19.800 kg ^{235}U is from Case cvr3lhap_23_1_4_15 (Table 6.1d).

[p] Case nctf5bmt11p_42_1_3_3 (with a mass of 28.800 kg ^{235}U) establishes the CSI value of 3.2. The more restrictive mass of 26.400 kg ^{235}U is from Case cvr3lhap_34_1_3_15 (Table 6.1d).

Table 6.2b. HEU fissile material mass loading limits for air mode of transportation [a]

Solid HEU metal or alloy, unirradiated TRIGA fuel elements [b]					
Cylinders (3.24 ≤ d ≤ 4.25 in.)	**Bars**	**Slugs**	**Broken metal, unspecified geometric shape and characterized as broken metal, turnings, fines, or powder [c]**	**Unirradiated TRIGA [d]**	
				20% enr.	**70% enr.**
7,000-g ^{235}U	7,000-g ^{235}U	7,000-g ^{235}U	7,000-g ^{235}U	921-g ^{235}U	408-g ^{235}U

HEU oxide [e]				
Bulk density (g/cm^3)	**HEU oxide (^{235}U kg)**	**HEU oxide /Th oxide (^{235}U kg)**	**HEU oxide /Zr oxide (^{235}U kg)**	**HEU oxide /Th (^{235}U kg)**
≥ 1.0 g/cm^3, < 1.5 g/cm^3	2.15	1.14	0.70	1.18
≥ 1.5 g/cm^3, < 2.0 g/cm^3	2.77	1.58	0.83	1.71
≥ 2.0 g/cm^3, < 3.0 g/cm^3	3.38	2.46	1.49	2.55
≥ 3.0 g/cm^3, < 4.0 g/cm^3	4.75	4.48	3.12	4.66
≥ 4.0 g/cm^3, < 5.0 g/cm^3	6.02	6.02	6.02	6.02
≥ 5.0 g/cm^3, ≤ 6.54 g/cm^3	7.57	7.57	7.57	7.57

Uranium compounds								
Bulk density (g/cm^3)	**UF_4**	**UO_2F_2**	**UC**	**UN**	**U_3Si_2 (40% enr.)**	**U_3Si_2 (60% enr.)**	**U_3Si (40% enr.)**	**U_3Si (60% enr.)**
≥ 2.0 g/cm^3, ≤ 6.54 g/cm^3	24.0 kg UF_4 18.13 kg ^{235}U	3.0 kg UO_2F_2 2.06 kg ^{235}U	2.0 kg UC 1.81 kg ^{235}U	2.0 kg UN 2.06 kg ^{235}U	8.5 kg U_3Si_2 3.15 kg ^{235}U	6.5 kg U_3Si_2 3.61 kg ^{235}U	8.5 kg U_3Si 3.27 kg ^{235}U	6.5 kg U_3Si 3.75 kg ^{235}U

[a] The loading limit for mixed mode transportation is taken as the most restrictive limit for either the surface or the air mode of transportation, Tables 6.2a or 6.2b.

[b] For air transport, TRIGA reactor fuel element content will be limited to fuel sections or clad fuel rods as described for surface-only modes of transportation in footnote "c" of Table 6.2a and the fissile mass limit specified herein, whichever is more limiting.

[c] Research reactor related contents of uranium metal or U-Al alloy are packaged for air transport under these specified limits.

[d] Research reactor related contents of U_3O_8-Al, UO_2, or UO_2-Mg are packaged for air transport under limits specified for unirradiated TRIGA fuel elements. Per package limits for these items are a maximum of 921-g ^{235}U at enrichments not exceeding 20 wt % and a maximum of 408-g ^{235}U for content enrichments greater than 20 wt %.

[e] Appendix 6.9.10 details air transport evaluation of HEU oxide and compounds.

Research reactor fuel elements or fuel components are composed of U-Al, U_3O_8-Al, UO_2, or UO_2-Mg. Related materials are broken uranium metal, U-Al alloy, or oxides of U_3O_8, U_3O_8-Al, or UO_2-Mg. With the exception of the oxide and compounds, research reactor related contents are packaged for air transport under limits specified in Table 6.2b for HEU broken metal, solid HEU metal of unspecified geometric shape and characterized as broken metal, turnings, fines, or powder. The oxide and compounds are packaged for air transport under limits specified in Table 6.2b for unirradiated TRIGA fuel elements. Per package limits for these items are a maximum of 921-g ^{235}U at enrichments not exceeding 20 wt % and a maximum of 408-g ^{235}U for content enrichments greater than 20 wt %.

Table 6.9.8.1-2 (Appendix 6.9.8) summarizes the fissile material load limits for the contents not covered in Table 6.2a. The loading limits from Tables 6.2a and 6.9.8.1-2 are consolidated in Tables 1.3 and 1.3a.

The criticality evaluation demonstrates that the ES-3100 packaging with the HEU content satisfies the requirements for single packages and for arrays of fissile material packages when the packages are load-limited as specified in Tables 6.2a, 6.2b, and 6.9.8.1-2 (reproduced in Tables 1.3, 1.3a, and 1.3b) under the conditions identified in Sect. 6.2.4.

6.1.4 Criticality Safety Index

A CSI is assigned to the Model ES-3100 package on the basis of an adequate margin of subcriticality for the single package and arrays of packages for both NCT and HAC. Values for the CSI given in Tables 6.2a and 6.2b are based on the uranium and the ^{235}U mass of the content and on the presence of 277-4 canned spacers as defined in Sect. 6.2.2.

The CSI is determined from bounding calculations using KENO V.a models of the CV, the single package, and arrays of packages (NUREG/CR-0200, Rev. 6). It is a dimensionless number used to limit the number of packages in a conveyance for nuclear criticality safety control. The CSI is the larger of the CSI values for NCT and for HAC. For NCT, the CSI is equal to 50 divided by the allowable number of packages "N" that can be shipped, where the allowable number of packages is one-fifth of the maximum array size that is calculated to be subcritical. For HAC, the CSI is equal to 50 divided by the allowable number of packages "N" that can be shipped, where the allowable number of packages is one-half of the maximum array size that is calculated to be subcritical. The CSI is a calculated number rounded up to the nearest first decimal.

The array sizes examined in this evaluation are infinite, 13×13×6, 9×9×4, 7×7×3, 5×5×2, explicit triangular pitch (ETP) 27×3 for NCT, ETP 16×3 for HAC, and the degenerate single unit. For NCT, the "N" and corresponding CSI values for arrays determined to be adequately subcritical are as follows: N = ∞, CSI = 0; N = 202, CSI = 0.3; N = 64, CSI = 0.8; N = 29, CSI = 1.8; N = 10, CSI = 5.0; and N = 16, CSI = 3.2. For HAC, the "N" and corresponding CSI values for arrays determined to be adequately subcritical are as follows: N = ∞, CSI = 0; N = 507, CSI = 0.1; N =162, CSI = 0.4; N = 73, CSI = 0.7; N = 25, CSI = 2.0; and N = 24, CSI = 2.1. Absent an exact correspondence of CSI values for the NCT and HAC, the following arrays results were selected for rounded CSI values as indicated in Tables 6.1a–6.1f:

- infinite arrays evaluated for both NCT and HAC [designated as "(1,2)"], where N(1,2) = for a CSI = 0;
- 13×13×6 evaluated for NCT and 9×9×4 evaluated for HAC where N(1,2) = (202,162) for a CSI = 0.4;
- 9×9×4 evaluated for NCT and 7×7×3 evaluated for HAC where N(1,2) = (64,73) for a CSI = 0.8;

- 7×7×3 evaluated for NCT and 5×5×2 evaluated for HAC where N(1,2) = (29,25) for a CSI = 2.0; and
- 27×3 evaluated for NCT and 16×3 evaluated for HAC where N(1,2) = (16,24) for a CSI = 3.2.

6.2 PACKAGE CONTENTS

The **package content** is defined as the HEU fissile material, bottles, convenience cans, canned spacers, can pads, and the associated packing materials (polyethylene, nylon, and Teflon bags; pads; tape; etc.) inside the ES-3100 CV.

6.2.1 Fissile Material Contents

The per-package HEU mass loadings considered in the criticality evaluation range from 1000 to 36,000 g for uranium metal and from 1000 to 24,000 g for uranium oxide and UNX crystals. The HEU mass may include nonradioactive contaminants and trace elements or materials in the HEU.

The bounding types of HEU content evaluated in this criticality analysis are 4.25-in.- and 3.24-in.-diam cylinders; 2.29-in.-square bars; 1.5-in.-diam × 2-in.-tall slugs; cubes ranging from 0.25 to 1 in. on a side; broken metal pieces of unspecified geometric shapes; skull oxide; uranium oxide; UNX crystals; and unirradiated TRIGA reactor fuel elements.

The terms “broken metal” and “turnings, fines, or powder” are used to describe an HEU content without restrictions on shape or size other than a minimum size limit (spontaneous ignition), a maximum mass limit (criticality control), a minimum enrichment (the lower limit for HEU at 19 wt % ^{235}U in uranium), and the capacity limits of the convenience cans. The content geometry envelope encompasses regular, uniform shapes and sizes as well as irregular shapes and sizes. Broken metal pieces are distinguished from turnings, fines, or powder as having a surface-area-to-mass ratio of not greater than 1 cm^2/g or must not pass through a 3/8-in. mesh sieve (or equivalent size-grading method). By this definition, turnings, fines, or powder are packed in cans that are sealed and the cans’ atmosphere is inerted for pyrophoric considerations.

HEU in the form of oxide with residual metallic particles is referred to as Clinkers and Screenings. This material results from metal casting operations where uranium metal is melted in a graphite crucible. After the metal is poured into casting molds, the crucibles are cleaned of residual material. The residual are bits of scrap metal and oxide debris. This residual material is passed through a sieve, where finer oxide passes through the sieve and is considered to be skull oxide. The material that does not pass through the sieve is considered to be Clinkers and Screenings. This material is predominantly oxide, but often will have small particles of metal. From a criticality safety standpoint, the HEU metal or alloy turnings, fines, and powders model is more conservative than the HEU oxide model, and thus Clinkers and Screenings will be conservatively loaded under the mass loading limits for HEU metal or alloy turnings, fines, and powders.

The density of HEU metal ranges from 18.811 to 19.003 g/cm^3 for HEU metal, corresponding to enrichments ranging from 100 to 19 wt % ^{235}U. Theoretical (crystalline) densities for HEU oxide are 10.96 g/cm^3, 8.30 g/cm^3, and 7.29 g/cm^3 for UO_2, U_3O_8, and UO_3, respectively. However, bulk densities of product oxide are typically on the order of 2.0 to 6.54 g/cm^3. With increased moderation of fissile mass possible at these lower densities, only “less-than-theoretical” mass loadings would actually be achieved. Skull oxides are a mixture of U_3O_8 and graphite, having densities on the order of 2.44 g/cm^3 for poured material and 2.78 g/cm^3 for tamped (packed) material. Combined water saturation and crystallization of the HEU oxide is not expected in the HAC because UO_2 is non-hygroscopic, and

both UO_3 and U_3O_8 are only mildly hygroscopic. The density of UNX crystals varies depending on the degree of hydration. The most reactive form of UNX crystals considered for shipment in the ES-3100 is $UO_2(NO_3)\cdot xH_2O$ with 6 molecules of hydration, having a density of 2.79 g/cm3. UNX crystals are highly soluble in nitric acid and mildly soluble in water. Dissolution of UNX crystals in water is assumed in this criticality evaluation. The content geometry envelope encompasses both regular, uniform clumps and densities, and irregular clumps and densities.

The ~40 stock items of TRIGA fuel are cataloged as one of the four basic types: a standard element, an instrumented element, a fuel follower control rod, or a cluster assembly. The active region of TRIGA element consists of three 5-in long sections "fuel meats" of uranium zirconium hydride ($UZrH_x$). The "x" in $UZrH_x$ equals 1.6 in all cases except for two stock items where x = equals 1.0 and the fissile content is < 40-g ^{235}U. The clad thickness is ~0.02 in. for a TRIGA fuel element with stainless steel cladding and ~0.03 in. for an element with aluminum cladding.

Solid form TRIGA fuel is either 20 or 70 wt % enriched in ^{235}U and has specific dimensional characteristics for its designed function. For the 20 wt % enriched TRIGA elements, the active fuel diameters are 1.44 in., 1.41 in., 1.40 in., 1.37 in., 1.34 in., or 1.31 in. The uranium weight fractions are 45 wt %, 30 wt %, 20 wt %, 12 wt %, and 8.5 wt %. The TRIGA element with a maximum fissile content of 307-g ^{235}U in 1,560-g U is 45 wt % U in $UZrH_x$ and has a computed density of ~8.6 g/cm^3 (Appendix 6.9.3.1). For the 70 wt % enriched TRIGA fuel, the active fuel diameter is 1.44 in. in the standard element and instrumented element, and 1.31 in. in the fuel follower control rod. Both the standard element and instrumented elements contain ~136-g ^{235}U in 194-g U, while the fuel follower control rod contains ~113-g ^{235}U in 162-g U. The 70 wt % enriched TRIGA fuel is 8.5 wt % U in $UZrH_x$ and has a computed density of ~5.7 g/cm^3 (Appendix 6.9.3.1).

In preparation for shipment in the ES-3100, the unirradiated TRIGA fuel elements may be disassembled and the fuel sections removed from the thin-wall cladding. The TRIGA fuel may also be configured as clad fuel rods. Each clad fuel rod will be derived from a single TRIGA fuel element by removal of the stainless steel or aluminum clad beyond the plenum adjacent to the axial ends of the active fuel section. Each ~15-in.-long rod consists of the 3 fuel pellets and an exterior sheath of clad, where the protruding clad at each end has been crimped in.

The 0.02-in.-thick sheath of stainless steel clad adds ~179 g to the mass of the active fuel for the standard element or instrumented element with 1.48 in. overall diameter, and ~163 g to active fuel mass for the fuel follower control rod with 1.35 in. overall diameter. Allowance for 0.5 in. of residual stainless steel crimped on each end of the clad fuel rod adds ~11 to 12 g stainless steel to these amounts. Likewise, the 0.03-in.-thick sheath of aluminum clad adds ~90 g to the mass of the active fuel for the 1.47-in.-diam standard element or instrumented element. Allowance for 0.5 in. of residual aluminum crimped on each end of the clad fuel rod adds ~6 g aluminum.

Research reactor fuel elements or fuel components are composed of U-Al, U_3O_8-Al, UO_2, UO_2-Zr, UO_2-ZrO_2, or UO_2-Mg. Related materials include broken uranium metal, U-Al alloy, or oxides (UO_2, UO_3, U_3O_8, U_3O_8-Al, UO_2-ZrO_2, or UO_2-Mg). These items contain small quantities of fissile uranium typically ranging from 4.2-g ^{235}U to 2000-g ^{235}U. The maximum enrichment is ~93%. Components are of various solid shapes (rods, square bars, plates, or tubes).

HEU oxide fuel coated with carbon is allowed with no additional limits or controls as presented in Appendix 6.9.11. Since the CV was conservatively modeled as fully flooded, adding carbon results in a less reactive system because any carbon added would displace water, which is a much better moderator.

Skull oxides, uranium alloys of aluminum, molybdenum, or zirconium and unirradiated TRIGA reactor fuel elements are evaluated where composition data is for material in the as-manufactured condition. A maximum enrichment of 100 wt % is used for HEU metal, oxide and UNX crystals in the criticality calculations strictly for the purpose of maximizing reactivity, even though HEU enrichment ranges from 19 to 97.7 wt % ^{235}U. Although mass loading limits for oxide and crystals are based on 100% enrichment, the actual enrichment is expected to be less than the stated maximum, with the remainder of the uranium being primarily ^{238}U. The HEU mass may also include nonradioactive contaminants and trace elements or materials in the HEU.

No intact weapon part or component will be shipped in this package. Weapon parts or components that have been reduced to "broken metal pieces" or processed into HEU oxide and meet the additional content requirements identified in Sect. 6.2.4 may be shipped in this package.

6.2.2 Convenience Cans, Teflon and Polyethylene Bottles, and 277-4 Canned Spacers

HEU fissile material to be shipped in the ES-3100 package will be placed in stainless steel, tin-plated carbon steel, aluminum, or nickel alloy convenience cans, polyethylene or Teflon bottles, or polyethylene bagging. Can lids may be welded, press fit, slip lid, or crimp seal types; bottle lids are screw cap type. Convenience cans and bottles are used to hold the HEU for shipment in the ES-3100 package and to assure that the inside of the CV does not become contaminated with HEU under NCT. The HEU metal or oxide content may be wrapped or bagged in polyethylene, and the convenience cans may also be wrapped in polyethylene to further reduce the possibility of radioactive contamination of the packaging. Nylon straps may be used for handling the nickel alloy cans. Masses of the convenience cans and packing materials are in addition to the fissile material mass.

Three 4.25-in.-diam × 10.0-in.-tall or six 4.25-in.-diam × 4.88-in.-tall convenience cans, separated by can pads, may be placed inside the 31-in.-tall cavity of the ES-3100 CV (Fig. 1.4). The convenience cans may have press-fit or crimp-seal lids. The size of solid content placed inside a convenience can is physically limited by both the can opening and the usable height of the convenience can. Other can arrangements fit inside the CV, such as three 4.25-in.-diam × 8.75-in.-tall convenience cans or five 4.25-in.-diam × 4.88-in.-tall convenience cans. Both of these can arrangements include can pads and 277-4 canned spacers. Nickel alloy cans to be used exclusively for HEU oxide content are ~3-in. diam × 4.75-in. tall. Three Teflon bottles (4.69-in. diam × 9.4-in. tall) or three polyethylene bottles (4.94-in. diam × 8.76-in. tall) fit inside the CV; however, 277-4 canned spacers are not used with these configurations.

A modified convenience can may be used to package the TRIGA and research reactor fuel element and fuel components that do not fit inside these containers. A 17.5 in. or 30 in.-tall convenience can is constructed from two 4.25-in.-diam × 8.75-in.-tall or three 10-in. cans brazed together. The research reactor fuel elements and fuel components that cannot be packaged in these convenience cans due to their overall dimensions will be bundled together and protected on each end with an open-ended convenience can having an outer diameter ≤ 5 in.

The can pad and 277-4 canned spacer have overall dimensions of 4.25-in. diam × 1.82-in. height (Drawing M2E801580A043, Appendix 1.3.7). A stainless-steel spacer can with a lid has a usable cavity with dimensions of 4.13-in. diam × 1.37-in. height, which nominally allows for ~510 g of neutron poison material. If closed convenience cans with an outer diameter >4.25 in. are used, at least 43 $in.^3$ of free or void volume must exist inside the CV to allow for gas expansion and offgassing of material at temperatures associated with NCT or HAC.

6.2.3 Packing Materials

Polyethylene, nylon, or Teflon bags may be used for contamination control to hold the HEU material that is packed into a convenience can. Realistically, the number of bags used to bag content and wrap a convenience can would be six bags at most. Given that each bag weighs ~28 g, this results in a maximum of ~510 g of bagging per ES-3100 package. Possible additional sources of hydrogenous material inside the CV include can pads and vinyl tape. Nylon ($C_{12}H_{22}N_2O_2$) and Teflon (C_2F_4) have a lower hydrogen density than water and polyethylene and are bounded by the polyethylene evaluations.

Polyethylene bottles (~85 g) may be used to pack HEU oxide; however, polyethylene bags are not used for packing HEU oxide. While polyethylene bags may be used to bag the 85 g polyethylene bottles, the amount of hydrogenous packing material inside the CV is limited to an equivalent 500 g polyethylene. Non-metallic containers such as polyethylene or Teflon (~303 g) may be used to pack UNX crystals. Likewise, polyethylene bags are not used for packing the UNX crystals and the amount of hydrogenous packing material inside the CV is limited to an equivalent 500 g polyethylene.

Normally, the H/X ratio inside the CV is specified as an administrative control used to restrict both the amount of hydrogenous packing material normally used inside the CV and other sources of moisture present in the fissile content. The total amount of hydrogen inside the CV is used in the determination of package H/X ratio (i.e., the ratio of the number of hydrogen atoms "H" to the number of fissile atoms "X," where the hydrogen atoms are those of the content, including absorbed moisture and of the packing material both inside and outside of the convenience cans). However, CV flooding is assumed in calculations performed for the derivation of fissile material loading limits. This simulated condition produces fissile material content that is more reactive than actual.

The 7.1–10.1 kg quantity of evaluation water required in both the NCT and HAC criticality calculations bounds reasonable amounts of hydrogenous packing material present inside the ES-3100 CV for solid HEU metal content (cylinders, bars, buttons, slugs, unirradiated TRIGA fuel, and research-related fuel components fissile material). The hydrogenous packing material encompasses the solid fissile material but is not interspersed within it.

However, the 7.1–10.1 kg quantity of evaluation water does not necessarily bound reasonable amounts of hydrogenous packing material present inside the CV when the fissile material is in particulate form (primarily HEU oxides and UNX crystals) or must be evaluated in particulate form (broken metal). An administrative criticality control is used to restrict the amount of hydrogenous packing material normally present inside the CV (see Sect. 6.2.4, Item 7).

6.2.4 Package Content Loading Restrictions

Loading restrictions based upon the results of the criticality safety calculations presented in Sects. 6.4 and 6.5 are as follows:

1. HEU fissile material to be shipped in the ES-3100 package must be placed in stainless steel, tin-plated carbon steel, aluminum, or nickel alloy convenience cans, polyethylene or Teflon bottles, or polyethylene bagging. Enriched uranium oxide in the form of UO_2-Mg will be shipped in glass bottles inside a metal convenience can. Any closure is allowed on the convenience can.

2. The content shall not exceed the "per package" fissile material mass loading limits specified in Tables 6.2a and 6.2b, and 277-4 canned spacers shall be used as indicated for criticality control. Research reactor related contents of uranium metal or U-Al alloy may be packaged for air transport under limits specified in Table 6.2b for HEU broken metal, solid HEU metal of unspecified geometric

shape and characterized as broken metal, turnings, fines, or powder. Research reactor fuel elements and components may be packaged for air transport under limits specified in Table 6.2b for unirradiated TRIGA fuel elements. Per package limits for these items are a maximum of 921-g ^{235}U for content at enrichments not exceeding 20 wt % and a maximum of 408-g ^{235}U for content enrichments greater than 20 wt %.

3. Where 277-4 canned spacers are required, not greater than one-third of the permissible package content for that category indicated in Tables 6.2a or 6.2b shall be loaded in any vacancy between or adjacent to canned spacers inside the CV. The content mass loading may be further restricted based on structural, mechanical, and practical considerations (see Chaps. 1 and 2).

4. As shown in Fig. 1.4, the ES-3100 package may carry up to six loaded convenience cans. In situations where the plan for loading the CV calls for the use of empty convenience cans to fill the CV, empty cans and/or stainless-steel scrubbers may be used to fill the void space in the CV. If empty cans are shipped, a minimum 0.32-cm (0.125-in.)-diam hole must be placed through the lid to prevent over-pressurization of the can in the event of a thermal accident. These empty cans may be placed above or below the loaded cans.

5. The presence of uranium isotopes is limited on a weight-percent basis as follows: $^{232}U \leq 40$ ppb U, $^{233}U \leq 0.6$ wt % U, $^{234}U \leq 2.0$ wt % U, $^{235}U \leq 100.0$ wt % U, and $^{236}U \leq 40.0$ wt % U.

6. With the exception of slug content, unirradiated TRIGA reactor fuel element content, and research reactor related content, solid HEU metal or alloy content of specified geometric shape shall be one item per loaded convenience can. HEU metal or alloy content not covered by the specified geometric shapes (cylinder, bar, button, billet, slug, or unirradiated TRIGA fuel element contents) will be in either the "HEU broken metal or solid HEU metal of unspecified geometric shape and characterized as broken metal" category or in the "HEU metal turnings, fines, or powder" category, and so limited (Table 6.2a). Broken metal is distinguished from turnings, fines, or powder as having a surface-area-to-mass ratio of not greater than 1 cm^2/g or must not pass through a 3/8-in. mesh sieve (or equivalent size-grading method).

7. The package content is defined as the HEU fissile material, bottles, the convenience cans, the can spacers, and the associated packing materials (polyethylene, nylon, or Teflon bags; pads; tape; etc.) inside the ES-3100 CV. The amount of hydrogenous packing material inside the CV shall not exceed an equivalent mass of 500 g polyethylene.

8. The mass of unidentified constituents of an HEU fissile material to be loaded into the ES-3100 will be counted against the fissile mass loading limit. The HEU fissile material will not contain unevaluated moderating materials.

9. Allowable HEU oxide bulk densities are 0.5–6.54 g/cm^3 for ground transport and 1.0–6.54 g/cm^3 for air transport.

10. For air transport, the total free water permitted in the ES-3100 packaging is limited to 12 lb (5,443.1 g).

6.3 GENERAL CONSIDERATIONS

The ES-3100 packaging configuration is shown on Drawing M2E801580A031 (Appendix 1.3.7). KENO V.a modeling of this configuration with the maximum allowable contents (Sect. 6.2) for a variety of array sizes and array conditions yields bounding calculations that determine the package's CSI (Tables 6.1a–6.1f). Can spacers are used as indicated in Table 6.2a and 6.2b for the purpose of reducing neutronic interaction between the contents of the package, aiding in maintaining the $k_{eff} + 2\sigma$ below the USL for the ES-3100 package. Key input listings are provided in Appendix 6.9.7.

The HEU content of a package is in one of the following forms: solid metal or alloy of a specified geometric shape; broken metal; turnings, fines, or powder; solid metal or alloy of unspecified geometric shape and characterized as broken metal; uranium or skull oxide; UNX crystals; or unirradiated TRIGA reactor fuel elements. The bounding types of HEU content evaluated in this criticality analysis are: 4.25-in.- and 3.24-in.-diam cylinders; 2.29-in.-square bars; 1.5-in.-diam × 2-in.-tall slugs; cubes ranging from 0.25 to 1 in. on a side; broken metal pieces of unspecified geometric shapes; product and skull oxide; Uranyl nitrate hexahydrate (UNH) crystals; and unirradiated TRIGA reactor fuel elements. UNH has a chemical formula of $UO_2(NO_3)_2 \cdot 6H_2O$. This most reactive form is used as the bounding composition for UNX crystals in the criticality evaluation. TRIGA fuel elements are 1.44-in.-diam × 15-in.-tall cylinders of $UZrH_x$ containing <310-g ^{235}U. Fuel elements are sectioned into three equal length pieces. Calculations demonstrate that these contents are bounded by 3.24-in.-diam HEU metal cylinders. Evaluation of the 3.93-in.-diam × 9.5-in.-tall U-Al cylinders is covered under the evaluation of the 4.25-in.-diam HEU metal cylinders. The evaluation of the U-Mo content is covered under the assessment of HEU contents at 95 wt % enrichment.

HEU metal shapes are distributed in an optimum arrangement in the flooded CV. For the single package and the array calculations, the HEU broken metal is modeled as a homogeneous mixture of uranium metal and water filling the interior of a flooded CV. This representation bounds the heterogeneous configuration of metal pieces interspersed with hydrogenous packing material inside of wrapped convenience cans (Appendix 6.9.3., Sect. 6.9.3.1). Water soluble UNH crystalline content is modeled as a homogeneous mixture of UN and water filling the interior of the CV.

No credit is taken for the fissile material spacing, neutron absorption, or free volume reduction provided by the presence of can pads, spacer can steel, and convenience cans inside the CV. Water is substituted for polyethylene bagging which may be in use as packing material for both the content placed inside the convenience can and the cans themselves. Pads of steel turnings rolled up into a disk-like shape may also be present in the ES-3100 package for use as cushioning and for reducing the free volume inside the convenience cans. This steel packing material acts as a neutron absorber and is excluded from the calculation model.

Criticality calculations are performed for the CV under full water reflection whereby the water content inside the CV is varied from dry to fully flooded conditions. These calculations demonstrate that the fully flooded condition is most reactive. The CV is flooded in the single-unit calculation model and the infinite and finite array calculation models for both the NCT and HAC evaluations.

The KENO V.a models discussed in the following sections are the single-unit calculation model (Sect. 6.3.1.1), the infinite and finite array calculation models (Sect. 6.3.1.2), the HAC calculation models (Sect. 6.3.1.3), and the air transport models (Sect. 6.3.1.4). The single-unit calculation model is evaluated with a vacuum boundary condition and with full water reflection. The finite array calculation model is evaluated in arrays consisting of packages stacked in 13×13×6, 9×9×4, 7×7×3, 5×5×2, ETP 27×3 and ETP 16×3 arrangements with full water reflection at the array boundary. The ETP arrangements are used specifically for defining smaller array configurations with a high CSI value.

The geometry of the ES-3100 package is depicted in Drawing M2E801580A001 (Appendix 1.3.7). Calculation models of this geometry for evaluating NCT and HAC must be constructed for the single-unit, infinite array and finite arrays within the constraints and capabilities of KENO V.a. As shown in the drawing, the ES-3100 geometry is complex. Given KENO V.a's constraints and capabilities, two methods may be used to evaluate these complex geometries: simplify the geometries with conservative approximations or construct accurate geometries from simple components. Both methods yield valid results; however, the latter method is chosen for this analysis in order to maximize accuracy and to eliminate unnecessary conservatism.

6.3.1 Model Configuration

A detailed ES-3100 geometry model is accurately constructed using many simple geometric shapes. The selection of these components is governed by two of KENO V.a's geometry constraints: geometry regions must be composed of uniform and homogeneous materials and exterior regions must completely enclose interior regions. It is apparent from Drawing M2E801580A001 (Appendix 1.3.7) that these constraints could not be simultaneously applied to the entire ES-3100 package. However, these constraints could be applied to vertical segments of the package. Segments (i.e., simple components) are defined by starting at the bottom of the package and defining geometry regions radially outward until the drum surface is reached. A vertical segment is extended upward to the point where the KENO V.a constraints are violated. This vertical position is the termination point of a segment (i.e., the interface with the adjacent segment above it). The vertical segments are constructed accordingly, ignoring the minor variations in the ES-3100 geometry (i.e., radii of curvature, beveled edges, nuts and bolts). The KENO V.a geometry model for the ES-3100 is then assembled from the vertical segments. The resulting calculation model geometry includes the HEU content, 277-4 canned spacers, the CV, the stainless-steel liner, the inner-liner cavity filled with 277-4, the outer-liner cavity filled with Kaolite, the Kaolite top plug and steel shell, the silicon rubber spacers, and the stainless-steel drum.

6.3.1.1 Single-unit packaging calculation model

The single-unit packaging calculation model is comprised of the geometry model, material compositions, and boundary conditions. Figures 6.1–6.5 depict section views of the geometry model used to evaluate a single ES-3100 package. Excluding minor variations in the ES-3100 geometry (i.e., radii of curvature, beveled edges, nuts and bolts), the single-unit packaging calculation model is an accurate representation of the ES-3100 geometry.

Figure 6.1 depicts a vertical section view of an ES-3100 package with the content of three loaded convenience cans and 277-4 can spacers inside the CV. The fissile material contents shown are HEU cylinders, but convenience cans are not modeled. As illustrated in Fig. 6.1, credit is not taken for fissile material spacing provided by convenience cans inside the CV. Appendix 6.9.1 provides wire-frame schematic and isometric diagrams depicting other fissile material contents considered in this criticality calculation.

Figures 6.2–6.5 depict vertical section views at various elevations in the package. The dimensions and the material specifications of any element of the ES-3100 single-unit packaging model may be obtained directly from the KENO V.a input listings in Appendix 6.9.7. The vertical segments (KENO V.a geometry unit numbers) are denoted in parenthesis to the right of the dimensions. The dimensions are given in units of centimeters. Material specification data for the single-unit packaging calculation model are provided in Sect. 6.3.2.

The single-unit calculation model is evaluated as both a bare system (i.e., with a vacuum boundary condition) and as a reflected system with 30.48 cm (1 ft) of water surrounding the package for effectively infinite water reflection.

10 CFR 71.55(b) requires evaluation of water leakage into the containment system disregarding any performance capability demonstrated by physical testing per 10 CFR 71.71 and 71.73. In conjunction, 10 CFR 71.55(b)(3) also requires evaluation of the efficiency of the packaging as an external reflector to the CV. The test case is defined as a flooded package. All regions within the water-reflected, single-unit packaging calculation model are flooded with water. The reference case is defined as a water-reflected flooded CV. This calculation model is a modification of the water-reflected, single-unit packaging calculation model where all regions of the packaging external to the CV are replaced with full density water.

6.3.1.2 Infinite and finite array packaging calculation models

Array packaging calculation models like the single-unit packaging calculation model are comprised of geometry, material compositions, and boundary conditions. Figures 6.6–6.10 depict section views of the geometry model used to evaluate an array of ES-3100 packages. The array geometry model incorporates a 7.0% reduction in the inside diameter of the ES-3100 drum. This reduction of the drum's inside diameter produces an array density equivalent to drums in a tightly packed, triangular pitch configuration (O'Dell). Since all array calculations in this evaluation use a square pitch package configuration, using the 7.0% reduction in diameter of uniform-shaped packages avoids the use of a nonconservative lattice arrangement in the array analysis.

As seen in Drawings M2E801580A002 and M2E801580A003 (Appendix 1.3.7), a 7.0% reduction of the inside diameter of the ES-3100 drum affects the masses of the drum, the modified 2 × 2 × ¼ in. angle (angle iron), and the Kaolite refractory material. Also, a 7.0% reduction in diameter affects the mass of interstitial water between the ES-3100 packages of a tightly packed array. To maintain the correct mass of these materials in the NCT array packaging calculation model, the drum's outside dimensions, the density of the steel in the angle iron, the density of Kaolite, and the density of interstitial water are modified. Excluding modifications required to simulate a triangular pitch and minor variations in the ES-3100 geometry (i.e., radii of curvature, beveled edges, nuts and bolts), the array geometry model is an accurate model of the ES-3100 geometry.

In the NCT array packaging calculation model, the drum outside diameter is 43.444550 cm (17.104154 in.) [21.722275-cm radius used as the input value], and the drum inside diameter is 43.11015 cm (16.972500 in.) [21.555075-cm radius]. This inside diameter corresponds to 93% of the inside diameter of the ES-3100 drum. The thicknesses of the drum wall, the drum bottom flat cover, and the drum lid are uniformly increased in order to maintain the region volume and to conserve drum mass, while the stainless steel density and volume fraction remain unchanged in the KENO V.a input specification. However, the region volume for the drum steel in the NCT array packaging calculation model is not equal to the volume in the single-unit packaging calculation model due to internal round-off in KENO V.a. Therefore, the volume fraction is changed from 1.0 to 0.99981 in the NCT array packaging calculation model for normalization of the drum mass.

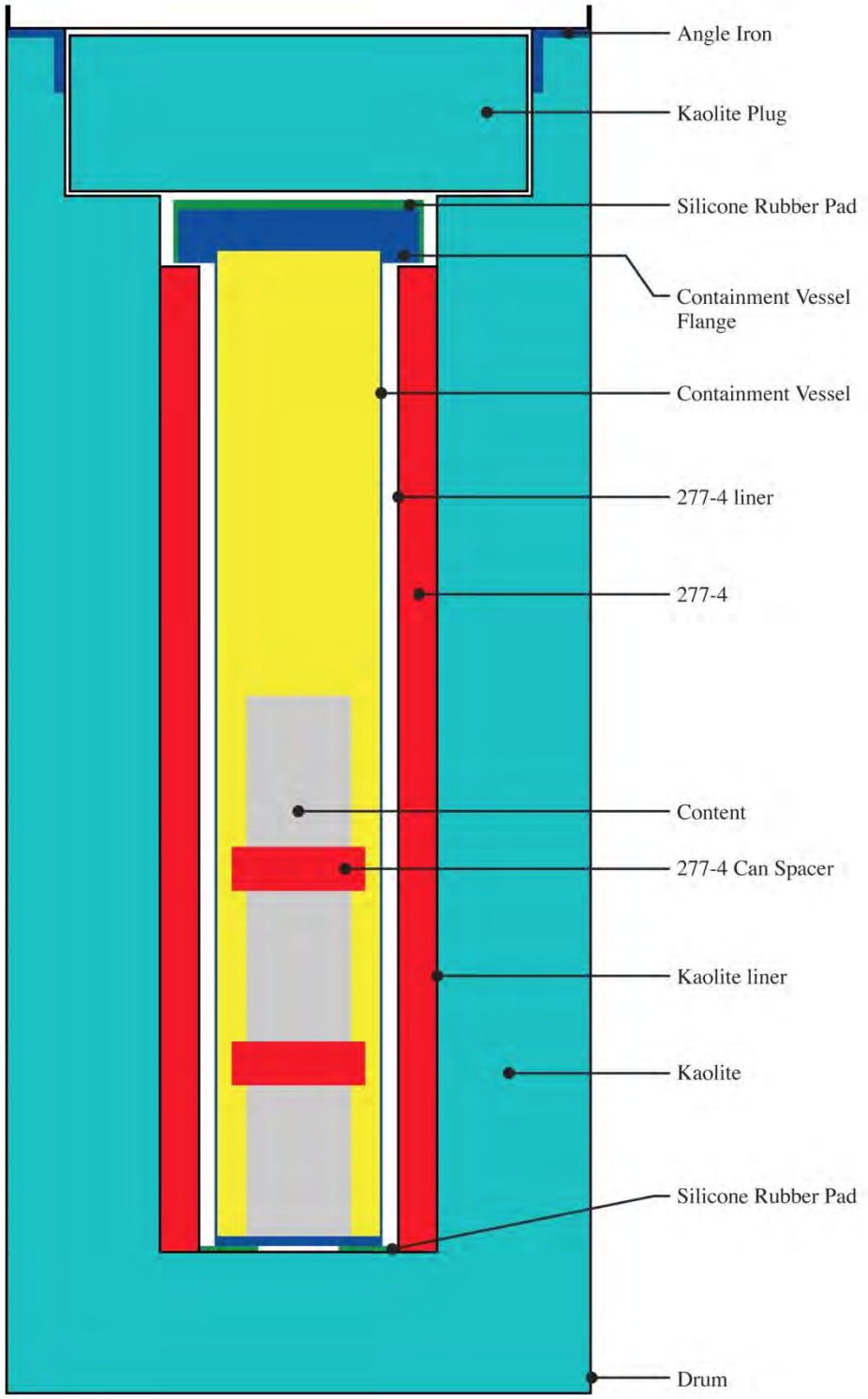
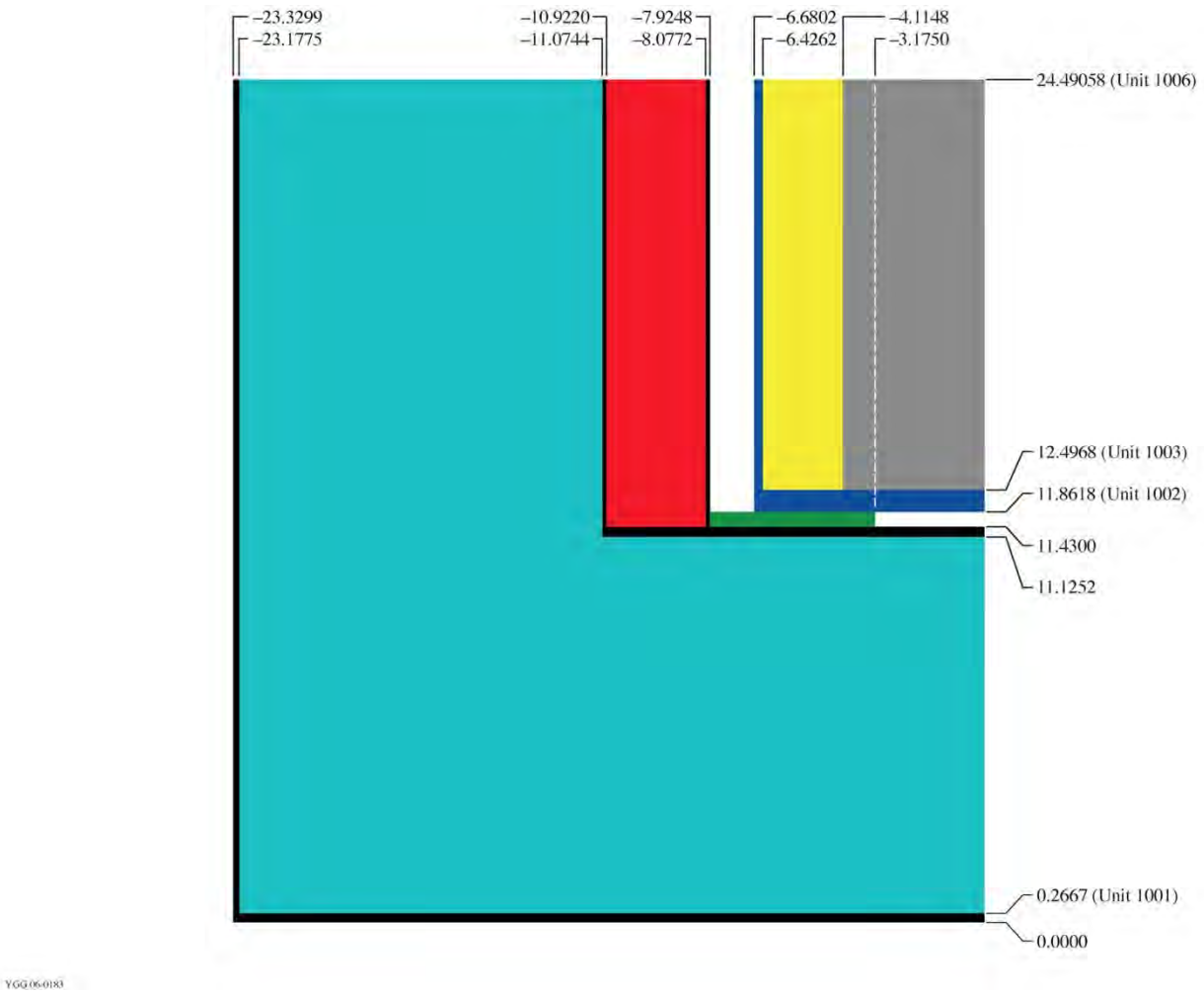
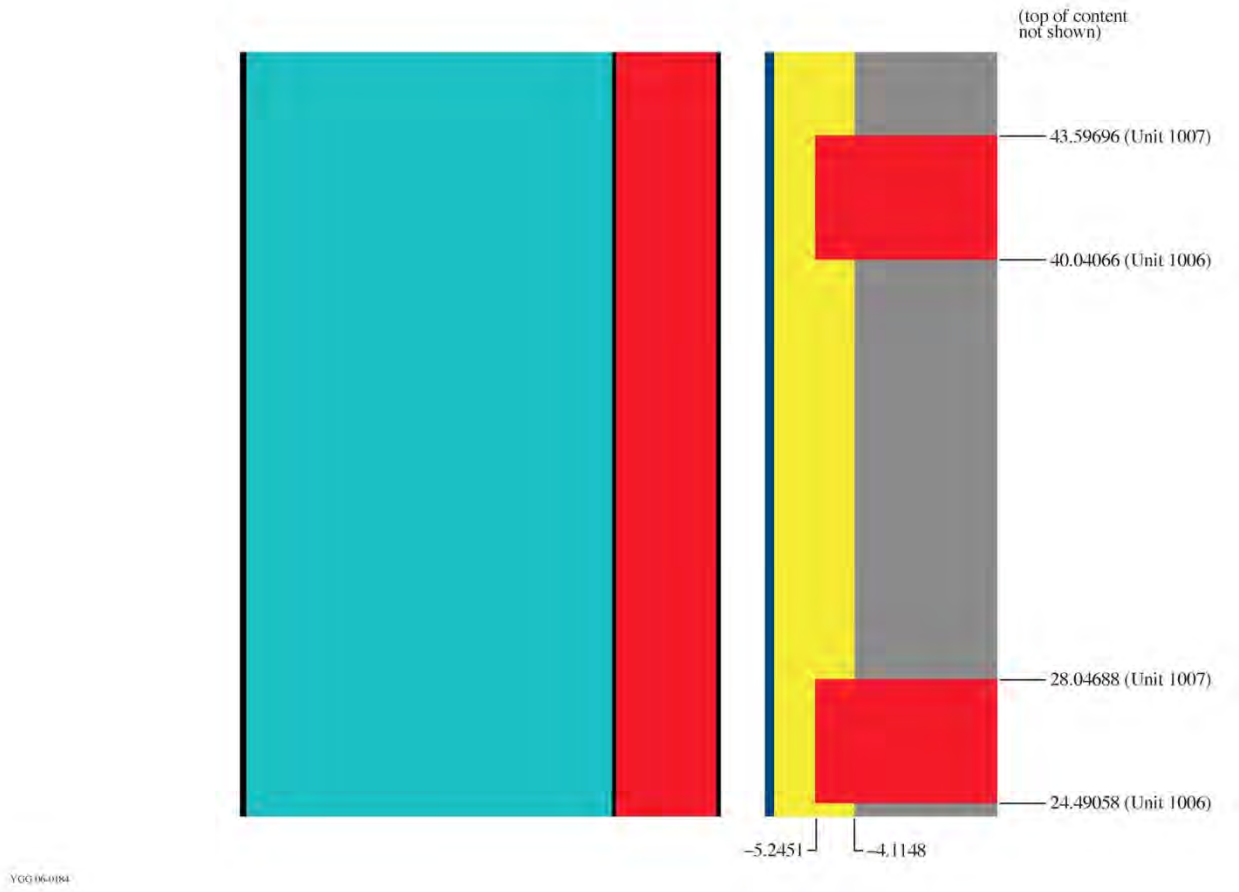


Fig. 6.1. R/Z section view of ES-3100 single-unit packaging model.



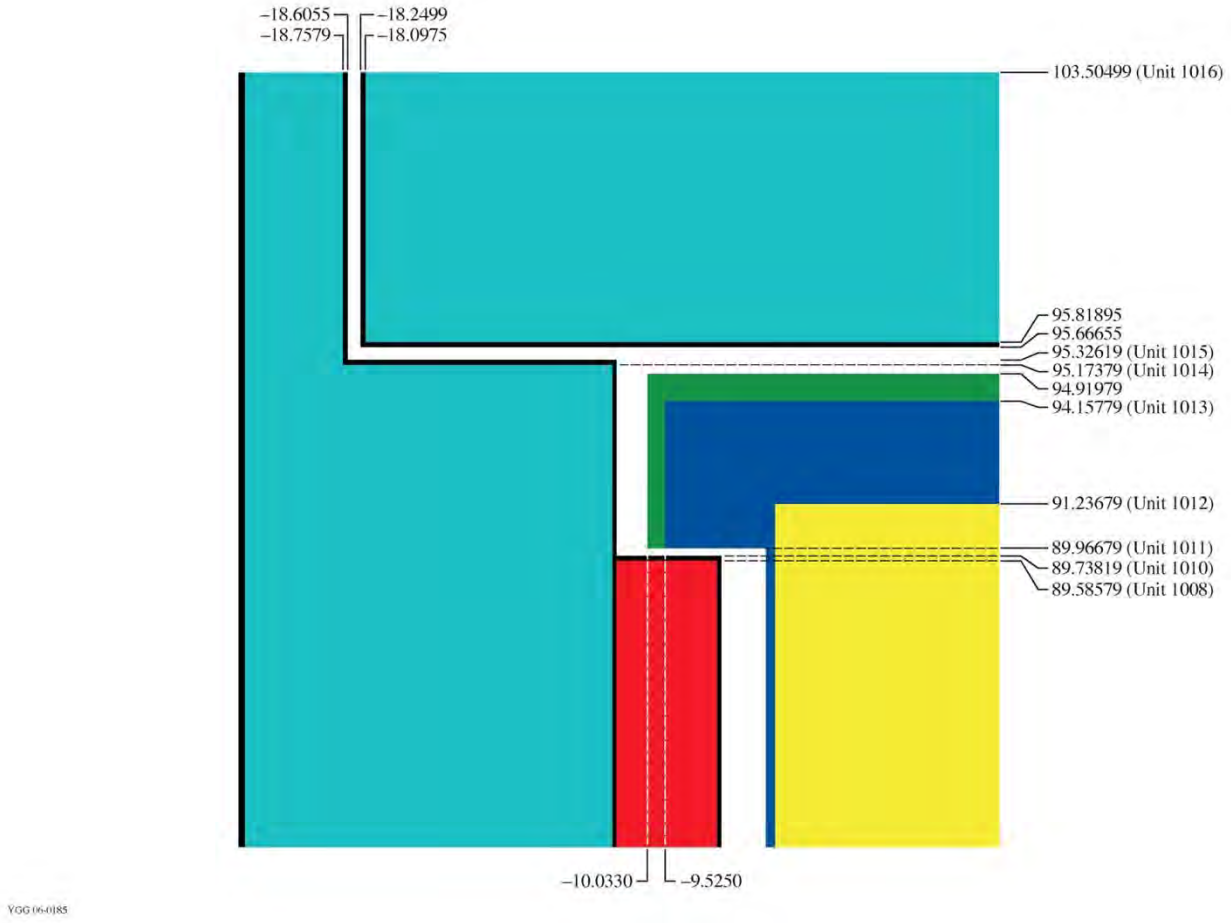
Note: Dimensions are in centimeters.

Fig. 6.2. R/Z section view at bottom of ES-3100 single-unit packaging showing KENO V.a geometry units 1001–1003, and 1006 (partial).



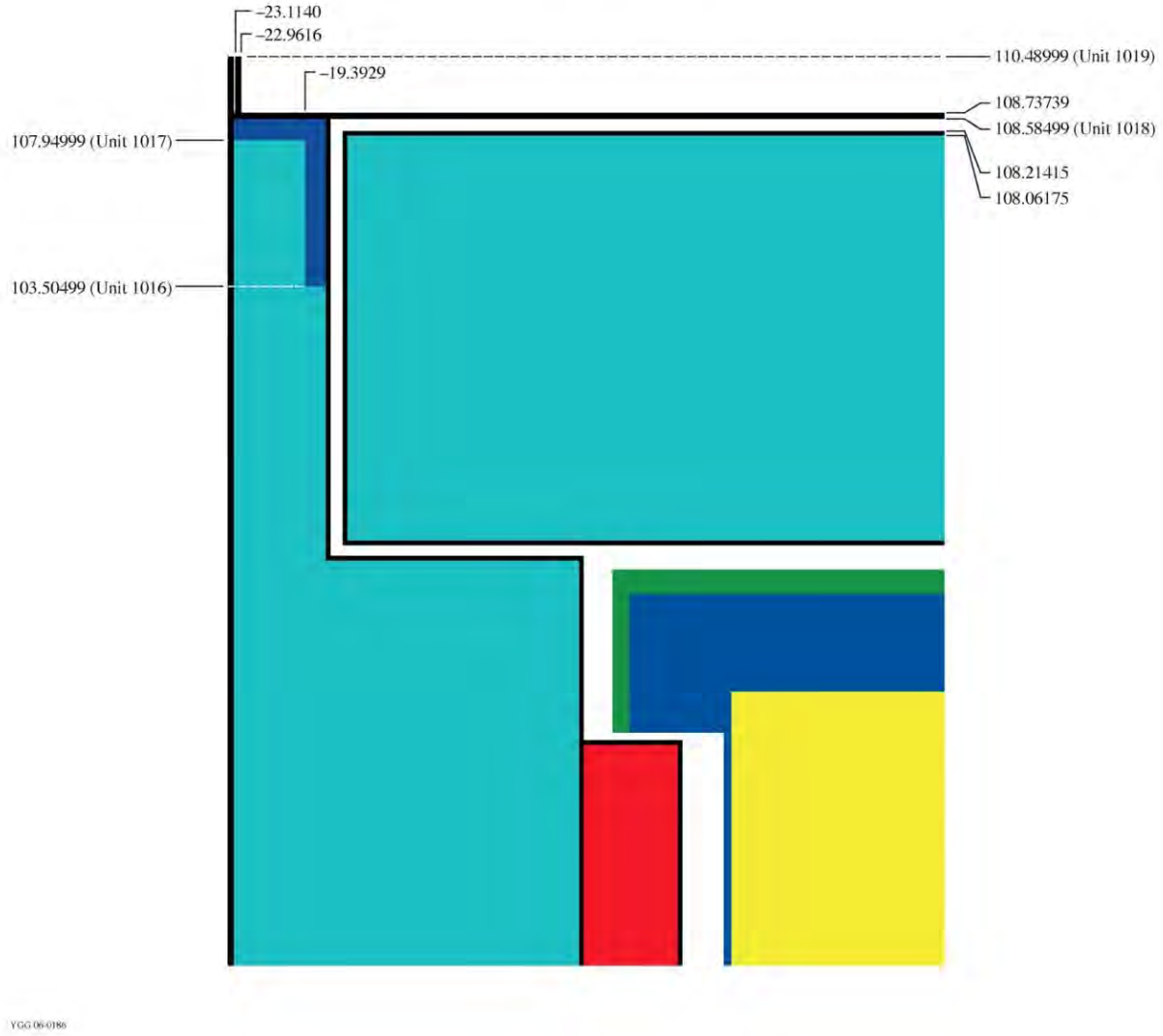
Note: Dimensions are in centimeters.

Fig. 6.3. R/Z section view at center of the ES-3100 single-unit packaging showing KENO V.a geometry units 1006 (partial), 1007, and 1008 (partial).



Note: Dimensions are in centimeters.

Fig. 6.4. R/Z section view of near top of the ES-3100 single-unit packaging showing KENO V.a geometry units 1008 (partial) and 1010–1016.



Note: Dimensions are in centimeters.

Fig. 6.5. R/Z section view at the top of the ES-3100 single-unit packaging showing KENO V.a geometry units 1016–1019.

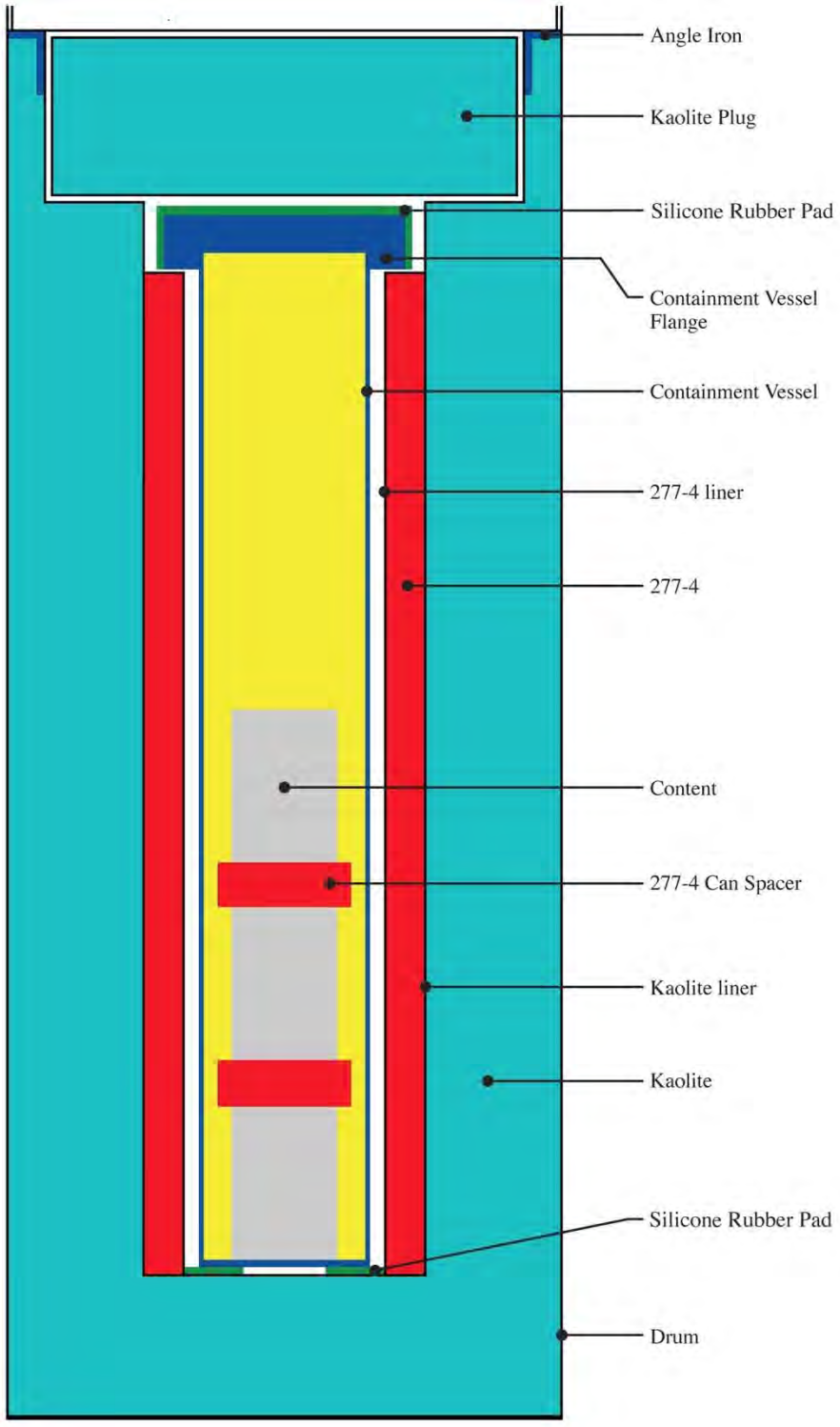
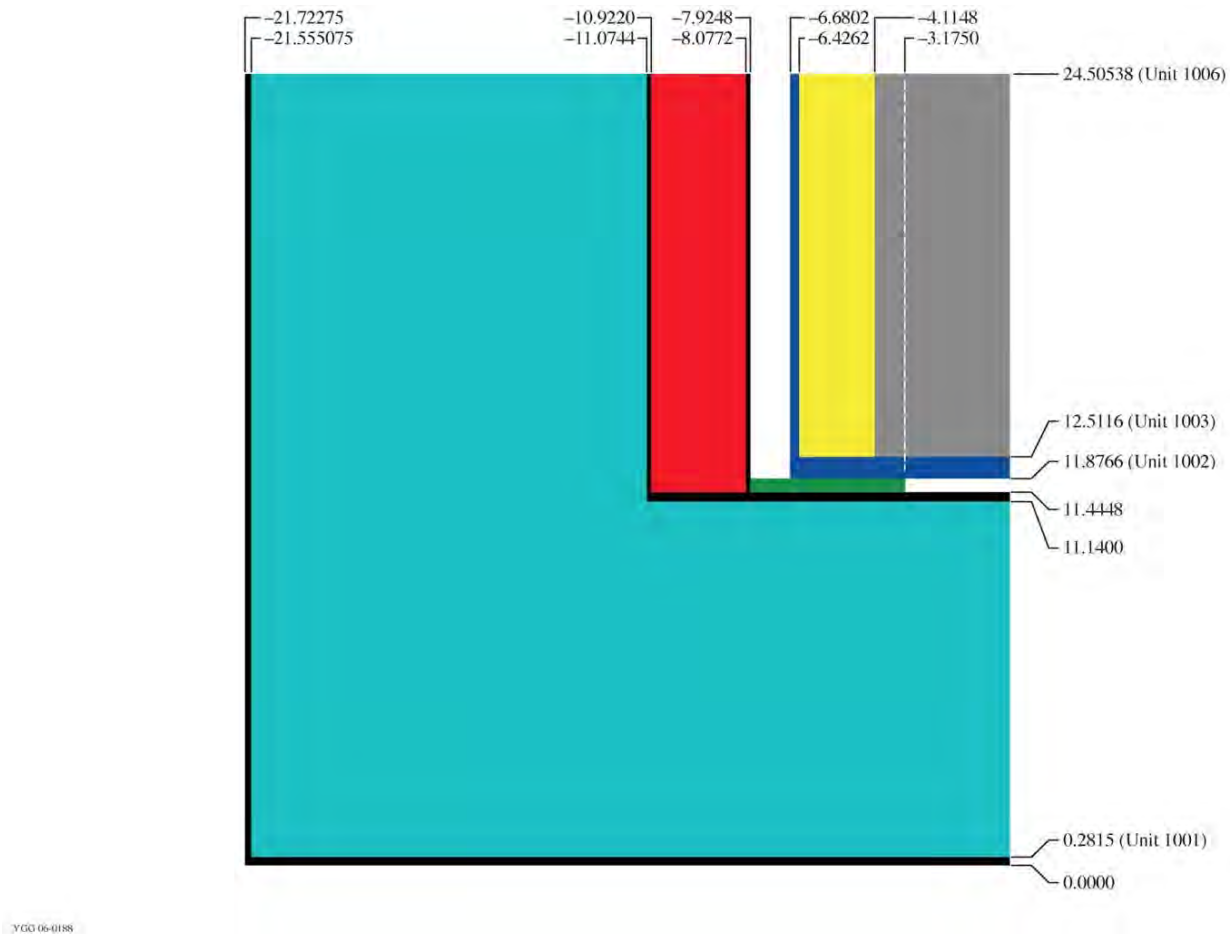
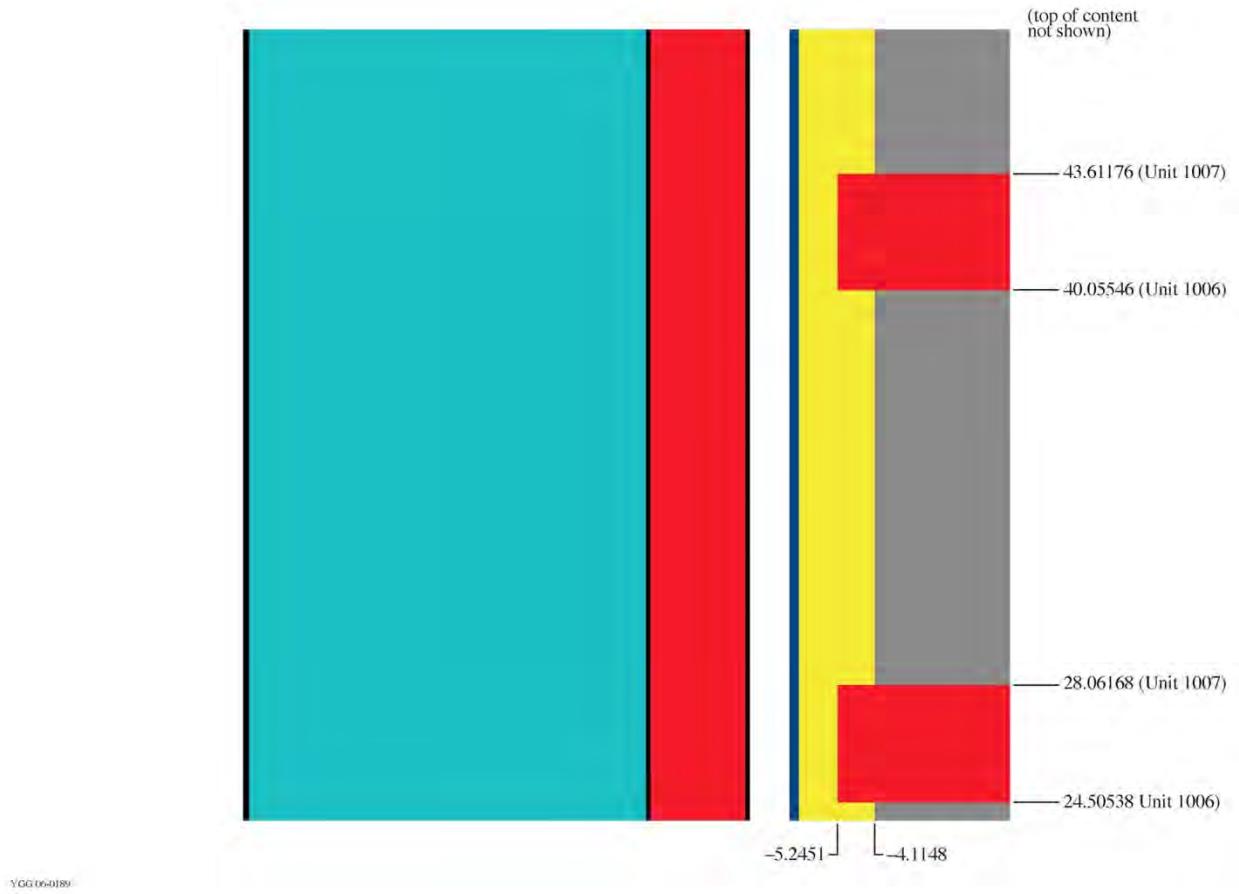


Fig. 6.6. R/Z section view of ES-3100 array packaging model with a 7% reduction in the drum's inner diameter.



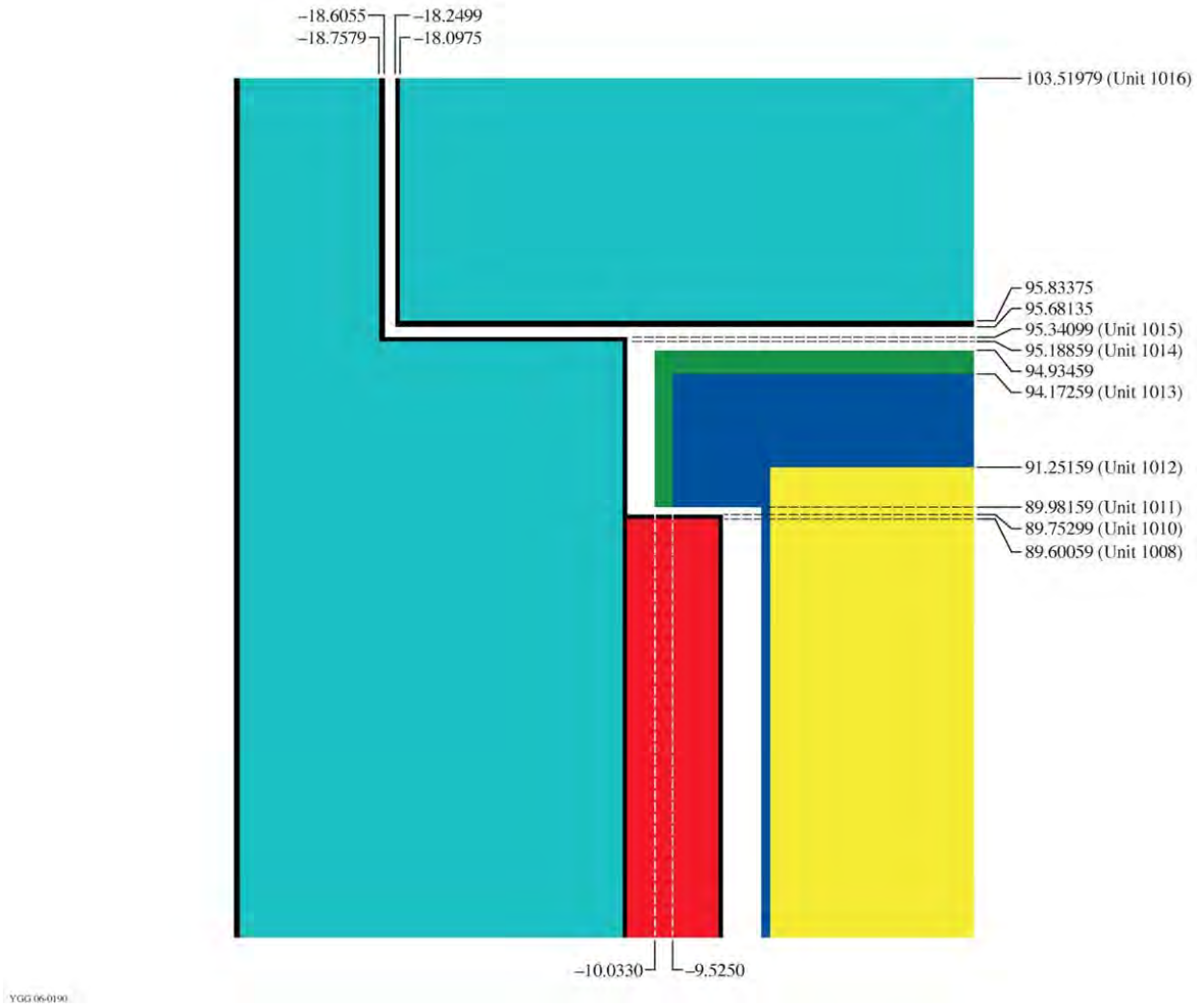
Note: Dimensions are in centimeters.

Fig. 6.7. R/Z section view at the bottom of the ES-3100 array packaging showing KENO V.a geometry units 1001–1003, and 1006 (partial).



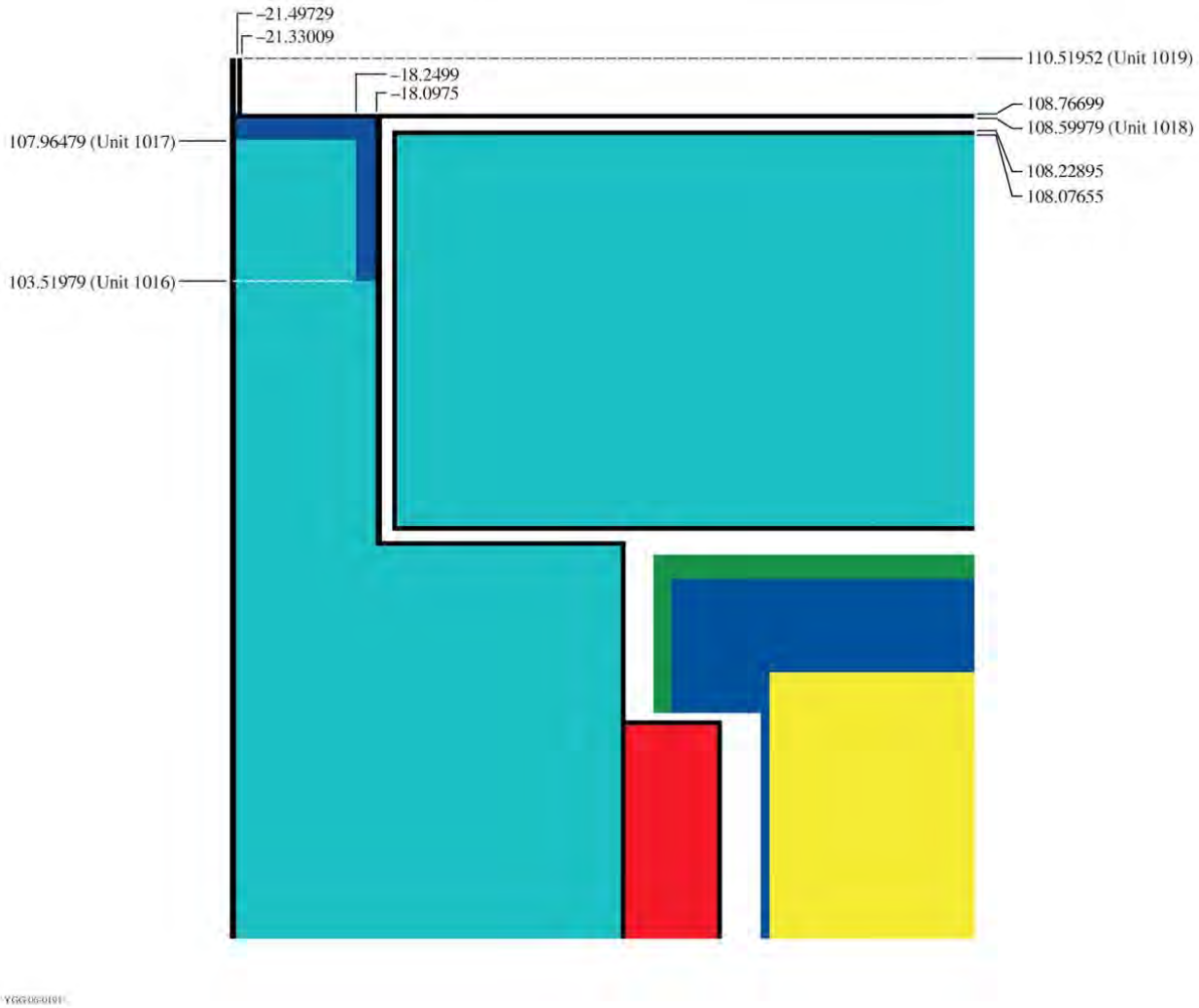
Note: Dimensions are in centimeters.

Fig. 6.8. R/Z section view at the center of the ES-3100 array packaging showing KENO V.a geometry units 1006 (partial), 1007, and 1008 (partial).



Note: Dimensions are in centimeters.

Fig. 6.9. R/Z section view of near top of the ES-3100 array packaging showing KENO V.a geometry units 1008 (partial) and 1010–1016.



Note: Dimensions are in centimeters.

Fig. 6.10. R/Z section view at the top of the ES-3100 array packaging showing KENO V.a geometry units 1016–1019.

The angle iron outside diameter is identical to the drum inside diameter. To maintain mass, the angle iron steel, the liner outer-cavity Kaolite, and interstitial water densities are modified by factors of 1.25705, 1.22252, and 1.16235, respectively. Excluding the modifications to drum and angle iron dimensions, the dimensions of any element of the ES-3100 array geometry model may be obtained directly from Appendix 6.9.7. Material specification data from the array calculation models are provided in Sect. 6.3.2.

O'Dell and Schlesser equate modeling triangular arrays with square pitch arrays, provided that the outer dimension of the array is reduced by a factor of 0.9306 and that the mass of materials is maintained. The actual reduction factors (ratio of the reduced radii to the single unit radii) for the Kaolite of the body weldment and for the angle iron is slightly <0.9306. Given that the array packages are closer than required by O'Dell and Schlesser, the array models are conservative with respect to their reduced radii.

The finite array calculation model is evaluated with arrays of packages stacked in 13×13×6, 9×9×4, 7×7×3, and 5×5×2 arrangements where the arrays are surrounded with 30 cm (~1 ft) of water as a boundary condition representative of full water reflection. These arrays are nearly cubic in shape for optimum reactivity of the array, thus eliminating the need for placing limitations on array configurations in terms of stack height, width, and depth.

The KENO V.a users manual (NUREG/CR-0200, Rev. 6) describes the input statements for an ETP model of cylinders in a close-pack array. This technique is adapted for modeling the ES-3100 in small compact array configurations. The ETP geometry model is much more complicated than the reduced-diameter approximation model described previously, but it yields smaller package configurations with correspondingly higher CSI values than the 7×7×3 and 5×5×2 package arrangements. Use of the ETP geometry specification allows for constructing compact package arrangements of 27×3 (27 packages in the horizontal plane stacked 3 packages high) and 16×3 packages.

6.3.1.3 Calculation models for damaged packages

Chapters 2, 3, and 4 of this report address the overall integrity of the Model ES-3100 package in tests for NCT and HAC (ORNL/NTRC-013). From a dimensional viewpoint, the only physical changes of interest for criticality safety occurred as a result of the 9-m (30-ft) drop test, the crush test, and the 1-m (40-in.) puncture test. There was significant crushing of the drum rim at the point of impact from the 9-m (30-ft) drop test and an indentation on the drum side from the 1-m (40-in.) puncture test. Even though significant crushing of the drum mid-section and bottom occurs, the effective center-to-center spacing of the contents actually increases under HAC. Selective rearrangement of alternating packages would be required to achieve a more compact array; however, this event is not credible.

The deformation of the outer diameters of the drum as predicted by finite element analysis is presented in Table 6.3. These diameters measured along the 90–270° and 0–180° axes are specified at five node points located along the vertical axis of an upright package. These node points are designated in a downward direction from the top of the drum as "UR," "MUR," "MR," "MLR," and "LR." Equivalent circular diameters for representing the deformed drum in the calculation models for the HAC study (Appendix 6.9.2) are based on the assumption that the drum cross section at each deformation point is ellipsoidal.

Table 6.3. Deformation of 18.37-in.-diam ES-3100 drum projected by finite element analysis Case "3100 RUN1HL Lower Bound Kaolite May 2004"

Deformation point	FEA node	Diameter at 90° (in.)	Diameter at 180° (in.)	Equivalent circular diameter (in.)
UR	098194	20.02	15.60	17.67
MUR	100238	20.74	15.07	17.68
MR	101589	20.74	14.18	17.15
MLR	103012	22.00	13.44	17.20
LR	105786	20.92	12.92	16.44

The package water content in the void spaces external to the CV and the interstitial spaces between drums is varied in the calculation model, while maintaining the Kaolite in the dry condition. At a low moisture content where neutronic interaction between packages of an array is greatest, there is no statistically significant difference in the calculated neutron multiplication factor for package models based on the "MR," "MLR," and "LR" node points. At high moisture content where a statistically significant difference in the calculated neutron multiplication factor occurs, the packages of an array are nearly isolated. The slight increase in k_{eff} at the smaller diameters is not numerically significant. A calculation model based on the "MLR" node point is used to represent HAC.

As concluded in Sect. 6.9.2.3, the criticality analysis of an array of HAC packages based on the "MLR" package model (diameter = 17.20 in.) in rectangular pitch bounds the analysis of damaged packages (diameter = 17.26 in.) in close-pack array configurations. Considering both the irregular shape of the deformed drums and the fact that overall (maximum) dimensions rather than a mean or minimum dimension for a damaged package would establish array spacing—this assumption is a reasonable one, and the model is conservative.

A reduced-diameter version of the "MLR" package model used for modeling a close-pack array configuration of HAC packages is not created. Instead, "MLR," the single-unit packaging model, is evaluated in a rectangular-pitch array configuration using appropriate boundary conditions. Consequently, the dimensions of the HAC array packaging calculation model do not differ from those of the HAC single-unit packaging calculation model. Therefore, the region volume of the drum and the atomic densities for the elemental constituents for the drum stainless steel are the same in both of the HAC calculation models.

The neutron poison, Kaolite refractory material, and stainless-steel components of the ES-3100 package were not significantly damaged during thermal testing. The principal material change of consequence that occurred during the thermal test was the loss of volatile material (Sect. 2.7.4). No loss of volatile material other than steam from the Kaolite was experienced during prototype testing of the Model ES-3100 package.

Physical damage is significant in terms of criticality safety when the amount of volatile hydrogenous material available for interstitial moderation is reduced. Conversely, the package could be saturated with water during water immersion conditions. Both possibilities affect only the amount of interstitial moderation. The representation of the changes to material composition from temperature extremes and water intrusion is addressed in Sect. 6.3.2.

In the case of broken metal content, the ETP geometry specification using the "MLR" package model (diameter = 17.20 in.) produces a 16×3 package configuration having a correspondingly higher CSI value than a 5×5×2 package arrangement. This allows for a greater fissile payload.

6.3.1.4 Calculation models for catastrophically-damaged packages (air-transport)

It is possible for accidents to be substantially more severe in the air transport mode than in the surface transport mode. Thus, the performance requirements for packages designed to be transported by air are more stringent. U.S. Nuclear Regulatory Commission (NRC) Regulatory Guide 7.9 states that the criticality evaluation should evaluate a single package under the expanded accident conditions specific in 10 CFR 71.55(f).

For a fissile material package designed to be transported by air, 10 CFR 71.55(f)(1) requires the criticality evaluation demonstrate that the package be subcritical, assuming reflection by 20 cm (7.9 in.) of water but no water inleakage, when subjected to the sequential application of the HAC free drop and crush tests of 10 CFR 71.73(c)(1 and 2) and the modified puncture and thermal tests of 10 CFR 71.55(f)(1)(iii and iv). 10 CFR 71.55(f)(2) requires the criticality evaluation demonstrate that the package be subcritical, assuming reflection by 20 cm (7.9 in.) of water but no water inleakage, when subjected to an impact on an unyielding surface of 90 m/s normal to the surface.

The "no water inleakage" condition of 10 CFR 71.55(f)(1) and (f)(2) signifies that the hydrogenous material present in the package during air transport is limited to the amount present in the package when it is loaded on the aircraft for transport. Potential sources of hydrogen moderator are the hydrogenous packing materials present inside the CV, moisture inside the CV well, and the moisture inside the Kaolite region of the package. The use of hydrogenous packing material is limited to 500 g. Both the use of a drum covering and administrative controls (Sects. 7 and 7.1.3.1) will ensure dryness of the CV well. Thus, the focus is on the Kaolite region of the ES-3100 package. The silicon rubber pads are not used in these calculations. The 53,420 g of dry-baked Kaolite in the drum body weldment and drum top plug consists of 51,214.9 g of vermiculite-cement constituents and 2,204.7 g of bound water. For establishing the loading limits for air transport, the total **free** water in wet Kaolite was conservatively evaluated up to 15 lb (6,803.8 g).

Physical testing of Type-B fissile material packages transported by air was not conducted for the ES-3100. In lieu of testing, criticality calculations are performed using calculation models that conform to the basic requirements of 10 CFR 71.55(f) regarding both the absence of water inleakage and reflection of the package by 20 cm of water. In addition, the air-transport calculation models incorporate features exhibiting the worst-case assumptions made regarding the geometric arrangement of the packaging and package contents. No credit is taken for the geometric form of the package content. Spherical geometry is used to represent the ultimate configuration of the ES-3100 package which undergoes catastrophic destruction.

The criticality analysis for air transport does not credit the ES-3100 for maintaining the geometry configuration of the packaged content. Fissile material is configured spherical in shape for optimization of neutron multiplication. Also, the criticality analysis does not credit the ES-3100 packaging for structural integrity of the containment and the confinement. The reactivity "enhancing" materials of the packaging may be interspersed with the fissile material content. However, selective removal of the neutron-absorbing material of the package (i.e., Kaolite and stainless steel) accompanied by retention of the moderating constituents of the neutron-absorbing material (i.e., bound water in the Kaolite) is not a credible condition. Moreover, a calculation model where the fissile material is homogenized with moderating material is only an appropriate representation when the fissile material content being shipped consists of numerous solid pieces uranium ("broken metal"), metal turnings, fines, powder, oxide, or crystals. Homogenization of fissile material with moderating material is not performed with exclusive preference given to specific constituents of the moderating material.

A set of six calculation models are constructed in order to determine the worst case or most reactive configuration with consideration given to the efficiency of moderators, loss of neutron

absorbers, rearrangement of packaging components and contents, geometry changes, and temperature effects. The fissile material component is dry in each case.

Model 1 (Fig. 6.11) represents the fissile material content configured into a spherical core with a 20.0-cm thick water reflector. All ES-3100 packaging material (Kaolite, stainless steel, 277-4 neutron poison, etc.) is excluded from Model 1. The fissile material content considered in the calculation model consists of a specific material form: solid HEU metal (7–10 kg ^{235}U); TRIGA fuel (10 kg $UZrH_x$ having 921-g ^{235}U); or broken HEU metal (≤ 7 kg ^{235}U). The presence of hydrogenous packing material inside the CV is also addressed in this calculation model. Five hundred grams of polyethylene is used to represent a maximum amount of hydrogenous packing material in the ES-3100. For 7 kg ^{235}U HEU homogenized with 500 g of polyethylene, the radius of the core is 6.0238 cm. The parametric variation of both the ^{235}U mass and the enrichment in Model 1 is used to establish a reference point for the evaluation neutron reflection and absorption effects on k_{eff} provided by the stainless steel and Kaolite packaging materials, addressed separately in Models 2 and 3. Case names for Model 1 are designated with the prefix "atdmr" for the HEU solid and broken metal contents. Case names for TRIGA fuel at 19.7 and 70% enrichments are designated with the prefixes "atdzr" and "atdzr70," respectively.

Model 2 (Fig. 6.12) represents a spherical core of Model 1 blanketed by a variable-thickness shell of stainless steel, and a 20.0 cm thick water reflector external to the shell. The shell at maximum thickness corresponds to the 66,133 g stainless steel of the CV and the liner and drum assembly. For 7 kg ^{235}U HEU metal homogenized with 500 g of polyethylene, the radius of the core is 6.0238 cm, while the outer radius of the stainless steel shell is 13.0198 cm. Case names for Model 2 are designated with the prefix "atdmsr" for HEU solid and broken metal content. Case names for TRIGA fuel are designated "atdzsr" and "atdzsr70."

Model 3 (Fig. 6.13) is configured the same as Model 2 with the exception that instead of stainless steel, the variable-thickness shell is composed of wet Kaolite. Maximum shell thickness corresponds to 60,223.4 g of wet Kaolite (53,419.6 g of dry-baked Kaolite plus 6,803.8 g of free water). For 7 kg ^{235}U HEU metal homogenized with 500 g of polyethylene, the radius of the core is 6.0238 cm, while the outer radius of the shell is 31.0802 cm. Case names for Model 3 are designated with the prefix "atdm15kr" for HEU solid and broken metal content. Case names for TRIGA fuel are designated "atdz15kr" and "atdz15kr70." The parametric variation of shell thickness in Models 2 and 3 is performed for the purpose of evaluating the effect on k_{eff} of neutron reflection and absorption provided by each packaging material.

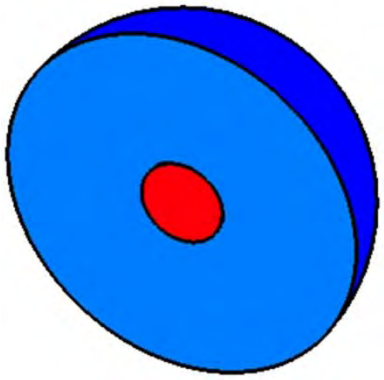


Fig. 6.11. Model 1.
7 kg ^{235}U (red) reflected by 20 cm of water (blue).

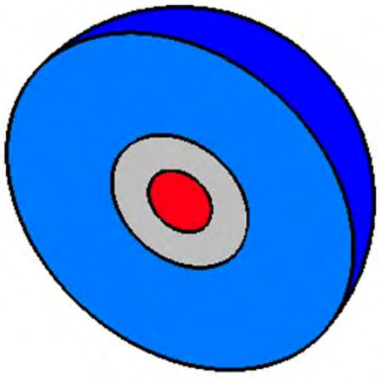


Fig. 6.12. Model 2.
7 kg ^{235}U (red) blanketed by a stainless-steel shell (gray), reflected by 20 cm of water (blue).

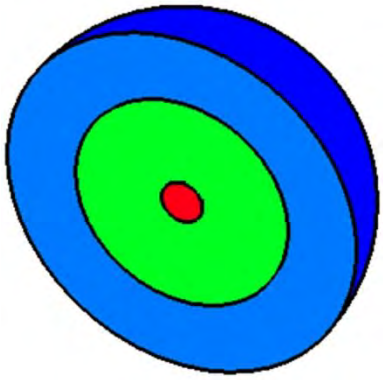


Fig. 6.13. Model 3.
7 kg ^{235}U (red) blanketed by a wet-Kaolite shell (green), reflected by 20 cm of water (blue).

Models 1–3 are applicable for establishing loading limits for air transport packages having a single piece or several pieces of solid HEU metal where the integrity of the content is demonstrated based on package tests or dynamic impact simulations per Type-C test criteria. Otherwise, the criticality evaluation of additional accident models is required for those situations where: (1) data is not available or is inadequate for discounting fragmentation of the fissile content in the air transport accident, or (2) the fissile material is in a physical form (crystals, oxide, or multiple pieces of solids) having the potential to blend with the other material of the package in the air transport accident.

Model 4 (Fig. 6.14) depicts a spherical core of broken metal homogenized with wet Kaolite and hydrogenous packing materials inside the CV represented by 500 g of polyethylene. A 20-cm thick water reflector blankets the spherical core. All other ES-3100 packaging material (stainless steel, 277-4 neutron poison, etc.) is excluded from Model 4. For 7 kg of HEU (7 kg of ^{235}U), the radius of the homogenized core is 31.0803 cm with the amount of water in Kaolite ranging from 2,204.7 g in baked-dry Kaolite to 9,008.6 g in wet Kaolite. Model 4 also applies to TRIGA fuel content. Case names for Model 4 are designated with the prefix "athmp15kr" for the HEU solid and broken metal contents. Case names for TRIGA fuel at 19.7 and 70% enrichments are designated with the prefixes "athzp15kr" and "athzp15kr70," respectively.

Model 5 (Fig. 6.15) is an extension of Model 3 applied to the case of TRIGA fuel and broken metal contents. Excess water from wet Kaolite is homogenized with the fissile material in the core. For 7 kg of HEU where 7 kg of ^{235}U is homogenized with 500 g of polyethylene and 0 g of free water from wet Kaolite, the radius of the spherical core is 6.0238 cm. The exterior Kaolite shell containing 9,008.5 g of water and the 51,214.9 g of vermiculite-cement constituents, has an outer radius of 31.0802 cm. At the extreme condition where the entire 6,803.8 g of water from wet Kaolite is homogenized with the core, the radius of the spherical core is 12.2667 cm. The exterior shell of dry Kaolite, containing 2204.72 g of bound water and 51,214.35 g of vermiculite cement constituents, has an outer radius of 31.6319 cm. Case names for Model 5 are designated with the prefix "athmpw15kr" for the HEU solid and broken metal contents. Case names for TRIGA fuel at 19.7 and 70% enrichments are designated with the prefixes "athzpw15kr" and "athzpw15kr70", respectively.

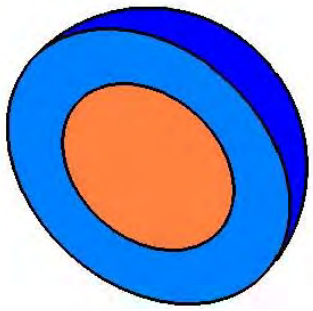


Fig. 6.14. Model 4.
Homogenized sphere of 7 kg ^{235}U, polyethylene, and wet-Kaolite (orange), reflected by 20 cm of water (blue).

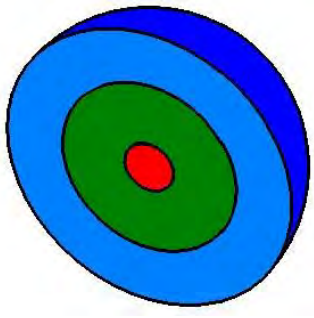


Fig. 6.15. Model 5.
Homogenized sphere of 7 kg ^{235}U, polyethylene, and excess moisture from wet-Kaolite (red), blanketed by Kaolite shell (green), reflected by 20 cm of water (blue).

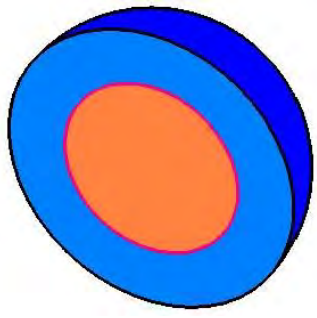


Fig. 6.16. Model 6.
Homogenized sphere of 3.5 kg ^{235}U, polyethylene, and wet-Kaolite (orange); blanketed by shell of 3.5 kg ^{235}U, reflected by 20 cm of water (blue).

Model 6 (Fig. 6.16) is configured similarly to Model 4 with the exception that only a partial amount of broken metal resides in the homogenized core. The remainder of the fissile material is modeled as a shell external to the spherical core and internal to the 20.0 cm thick water reflector. The amount of fissile material in the homogenized core is varied in 500 g increments from the full amount of Model 5 minus 500 g to a minimum amount of 500 g HEU. In the case of 7 kg of broken metal where 3.5 kg of ^{235}U is homogenized with 500 g of polyethylene and wet Kaolite, the radius of the core is 31.0649 cm, while the outer radius of the exterior 3.5 kg shell of ^{235}U is 31.0804 cm. The same dimensions apply in the case of 7.0 kg of broken metal where 3.5 kg of ^{235}U is homogenized with 500 g of polyethylene and dry Kaolite. In the case where 0.5 kg of ^{235}U is homogenized with 500 g of polyethylene and wet Kaolite, the radius of core is 31.0518 cm, while the outer radius of the exterior 6.5 kg shell of ^{235}U is 31.0804 cm. In the case where 6.5 kg of ^{235}U is homogenized with 500 g of polyethylene and wet Kaolite, the radius of core is 31.0781 cm, while the outer radius of the exterior 0.5 kg shell of ^{235}U is 31.0804 cm. Case names for Model 6 are designated with the prefix "athmpw15kmr" for the HEU solid and broken metal contents. Case names for TRIGA fuel at 19.7 and 70% enrichments are designated with the prefixes "athzpw15kmr" and "athzpw15kmr70," respectively. Model 6 addresses potential redistribution of fissile material consisting of multiple pieces, specifically the broken metal content. The parametric variation of shell thickness in Model 6 is performed for the purpose of evaluating the effect on k_{eff} of moderation efficiency of the core and enhanced neutron multiplication of the shell.

Models 1–6 are applicable to air transport of the ES-3100 package given that the physical integrity of the fissile content following the air transport accident cannot be established, or that the physical form of fissile material content may be multiple solid pieces, turnings, fines, powder, or oxide.

6.3.2 Material Properties

Criticality calculation models include the definition of material compositions in the geometry model for both NCT and HAC. The materials which affect nuclear criticality safety and may be present in the ES-3100 package during these conditions are fissile material content (HEU metal, aluminum, molybdenum, and zirconium alloys of uranium, HEU product or skull oxide, UNX crystals, or $UZrH_x$), stainless steel, 277-4 neutron poison, Kaolite, silicon rubber, Teflon or polyethylene, and various amounts of water. Other materials are present in the package (e.g., tin-coated steel convenience cans, nylon bagging, rubber O-rings, and trace impurities). However, these other materials are not present in amounts that will significantly affect the reactivity of the package. Detailed discussion of the package content and packaging materials is contained in Appendix 6.9.3. Specific topics are summarized in this section as required to support the discussion of the criticality calculations presented in Sects. 6.4–6.6.

Cat 277-4 neutron poison is designed to maximize the hydrogen content necessary for thermalizing fast neutrons for capture in the boron constituent. Cat 277-4 is a formulation of the vendor's Cat 277-0, a boron carbide additive, and water. This mixture is cast and dried. "Loss on drying" (LOD) tests are used to measure the amount of water in the as manufactured 277-4 casting. The as-manufactured neutron poison material at 100 lb/ft^3 and 31.8% LOD has a hydrogen concentration of 3.56 wt % and a natural boron concentration of 4.359 wt % (DAC-PKG-801624-A001, Table 5).

The testing of 277-4 reveals that the material will dehydrate at elevated temperatures. Test specimens were dried at 250°F for 168 hours to reach the NCT state, and weight measurements were taken. These specimens were subsequently heated to 320°F for 4 hours to reach the HAC state, and weight measurements were again taken. The compositions of 277-4 at NCT and HAC states were derived by adjustment of the formulation specification for measured losses taking into account the statistical variations in the data. Conservation of mass for non-volatiles was observed in the derivation of material specifications based upon testing. Given that hydrogen presence is key to the effectiveness of the neutron

poison, conservative material specifications were derived for minimum hydrogen content and minimum material density.

The NCT material specification for 277-4 at minimum density (95.39 lb/ft^3) and minimum hydrogen (25.15% LOD) is given in Table 11 of DAC-PKG-801624-A001. The average density of 277-4 in the ES-3100 package used for NCT calculations in KENO V.a is 1.52797 g/cm^3; the boron constituent is 7.31015E-2 g/cm^3; the residual base is 1.07070 g/cm^3; and the water component is 3.84169E-01 g/cm^3 (Appendix 6.9.3, Table 6.9.3.3-2). The HAC material specification at minimum density (95.32 lb/ft^3) and minimum hydrogen (25.09% LOD) is given in Table 12 of DAC-PKG-801624-A001. The average density of 277-4 used for HAC calculations in KENO V.a is 1.52680 g/cm^3; the boron constituent is 7.31015E-2 g/cm^3; the residual base is 1.07071 g/cm^3; and the water component is 3.82995E-1 g/cm^3 (Appendix 6.9.3, Table 6.9.3.3-3).

A set of 20 canned spacer assemblies as-manufactured has an average weight of 591.55 g. On average, the weight of an empty can with a lid is 86.05 g, and the 277-4 is 505.5 g. On the basis of volumetric measurements, the neutron poison is ~10.075 oz or 297.95 cm^3. The resultant 277-4 density is 1.6966 g/cm^3. The corresponding minimum mass is 473.84 g (given that the 277-4 material inside the spacer can is ≥4.07-in. diam and 1.31-in. thickness). Based on model dimensions of 4.13-in. diam × 1.37-in. height and use of composition data from Table 11 of DAC-PKG-801624-A001 (as-manufactured material at minimum density and hydrogen), the mass of neutron poison in the calculation model of the canned spacer is conservatively modeled as 457.15 g.

The density of 277-4 in the liner inner cavity is further reduced by a factor of 0.966893 because the actual volume of neutron poison is 12,831.4 cm^3 in the package, but 13,270.8 cm^3 is used in the calculation model. Also, guidance in Sect. 6.5.3.2 of NUREG-1609 requires that 75% of elemental boron be used in the material specification. Consequently, the minimum weight of 277-4 in the liner inner cavity of the calculation models is 19.37 kg (42.71 lb) for NCT and 19.36 kg (42.67 lb) for HAC, determined from the input density and the volume of the 277-4 region calculated by KENO V.a.

Kaolite is a lightweight, low thermal conductivity, refractory material that is used in the ES-3100 package between the drum and the inner liner. Kaolite is formed by mixing a dry constituent powder with water, pouring the mixture into a casting form, and curing and baking the cast. For NCT, the average density of Kaolite in the Model ES-3100 package is 0.34438 g/cm^3, and the residual water is 0.01493 g/cm^3 (Appendix 6.9.3, Sect. 6.9.3.4). The nominal weights of Kaolite in the liner outer cavity and in the top plug as determined from the input density and the region volumes calculated by KENO V.a are 49.04 kg (108.1 lb) and 4.37 kg (9.63 lb), respectively.

Kaolite is a nonvolatile refractory material, not significantly damaged by thermal excursions associated with HAC. It is assumed that upon immersion, a cured and dried casting will absorb a quantity of water equal to that required during preparation. This assumption is valid because the casting is fully saturated with water prior to curing and baking, and the casting does not change volume significantly during baking. The maximum water content of Kaolite refractory material is the water content of manufacture (1.5 g water per gram dry Kaolite) equivalent to a density of 0.51655 g/cm^3. For the single package, water saturation in the Kaolite region maximizes the effect of self-reflection in the surrounding package. This condition is assumed in the NCT single package calculations. For an array of packages, neutronic interaction between packages is maximized when the minimum amount of water is present in the Kaolite, which occurs in the as-manufactured condition. A volume fraction of 1.0 in the material specification corresponds to the water-saturated condition, while a volume fraction of 0.0289 corresponds to the dry condition.

ES-3100 drum body assemblies and top plugs may be fabricated with Packcrete or Kaolite. Packcrete is a fireproof, lightweight, impact limiting, thermal insulating, cast refractory material. Packcrete is similar to Kaolite in chemical composition, density, and water composition. From a criticality safety standpoint, this material is functionally equivalent to Kaolite, and ES-3100 calculations using Kaolite will bound Packcrete. Comparison calculations of Packcrete vs Kaolite may be found in Appendix 6.9.3.5.

The fissile material content packed into the CV is ordinarily dry. Given that a flooded CV is assumed for both NCT and HAC, the concurrent condition where the water-saturated Kaolite is baked dry beyond the as-manufactured condition, while the CV remains flooded is considered not credible. Therefore, the as-manufactured condition is assumed for the Kaolite water content in the HAC array analysis.

As stated in Sect. 6.3.1.2, the drum thicknesses of the NCT single-unit packaging model is increased for producing the NCT array packaging calculation model. The intent is to maintain the drum region volume thereby conserving drum mass. However, the both the region volume of the drum and the atomic densities for the elemental constituents of stainless steel in the resulting NCT array packaging calculation model are not identical to corresponding values for the single-unit packaging calculation model. This is due to internal round-off in KENO V.a. (Even though the volume fraction is changed from 1.0 to 0.99981 in the KENO V.a input specification of the NCT array packaging calculation model for normalization of the drum's region volume, the atomic densities still differ by 0.019% due to round-off.)

The material compositions for the NCT array calculation models are identical to compositions for the NCT single-unit calculation models except as noted in Table 6.4. In the NCT array calculation model, the adjusted model densities for the Kaolite in the body weldment liner inner cavity (Mix. No. 12), the stainless steel of the angle iron (Mix. No. 18), and the drum steel (Mix. No. 19) compensate for the dimensional changes of the reduced-diameter model (93% ID of drum). A difference between the NCT specifications for Kaolite (Mix. Nos. 12 and 13) in the array and the single-unit models occurs in the water component. The dry state is represented in the array model for maximizing neutronic interaction between packages of an array, while the flooded state is represented in the single-unit model for maximizing reflection.

The material compositions for the HAC single-unit calculation model are identical to those for the NCT single-unit calculation models except as noted in Table 6.4. The adjusted model densities for 277-4 neutron poison in both the canned spacers (Mix. No. 2) and the inner-liner cavity (Mix. No. 11) represent the HAC discussed earlier in this section. In the HAC single-unit calculation model, the adjusted model densities for the Kaolite in the body weldment liner inner cavity (Mix. No. 12), the stainless steel of the angle iron (Mix. No. 18), and the drum steel (Mix. No. 19) correspond to dimensional changes resulting from damage. While the atomic densities for the HAC model differ from those for the NCT model, the component masses do not change because mass is conserved.

Table 6.4. Material compositions used in the ES-3100 calculation models

Material	Mix. No.	Theoretical density input parameter (g/cm^3) [a]	Volume fraction	Constituent	Atomic weight	Weight fraction
Fissile material contents						
Uranium (solid metal)	1	18.81109	1.0	^{235}U	235.0441	1.00
				^{238}U	238.0510	0.00
Uranium (solid metal)	1	18.82298	1.0	^{235}U	235.0441	0.95
				^{238}U	238.0510	0.05
Uranium (solid metal)	1	18.83488	1.0	^{235}U	235.0441	0.90
				^{238}U	238.0510	0.10
Uranium (solid metal)	1	18.85873	1.0	^{235}U	235.0441	0.80
				^{238}U	238.0510	0.20
Uranium (solid metal)	1	18.88264	1.0	^{235}U	235.0441	0.70
				^{238}U	238.0510	0.30
Uranium (solid metal)	1	18.90661	1.0	^{235}U	235.0441	0.60
				^{238}U	238.0510	0.40
Uranium (solid metal)	1	18.95474	1.0	^{235}U	235.0441	0.40
				^{238}U	238.0510	0.60
Uranium (solid metal)	1	19.00554	1.0	^{235}U	235.0441	0.19
				^{238}U	238.0510	0.81
Uranium oxide (UO_2)	1	6.94256	1.0	H	1.0077	0.6490
				O	15.9904	16.4340
				^{235}U	235.0441	82.9170
Uranium oxide (U_3O_8)	1	6.75167	1.0	H	1.0077	0.3510
				O	15.9904	17.6620
				^{235}U	235.0441	81.9870
Uranium oxide (UO_3)	1	6.64270	1.0	H	1.0077	0.1730
				O	15.9904	18.0650
				^{235}U	235.0441	81.7620
Skull oxide (UO_3+graphite)	1	3.34850	1.0	H	1.0077	1.9000
				C	12.0001	11.9173
				O	15.9904	25.9923
				^{235}U	235.0441	56.0976
				^{238}U	238.0510	4.0929
UNH crystals (24000.0 g) [$UO_2(NO_3)_2$+$6H_2O$]	1	2.50804	1.0	H	1.0077	2.9770
				N	14.0033	5.2570
				O	15.9904	47.6480
				^{235}U	235.0441	44.1180
UNH crystals (9000.0 g) [$UO_2(NO_3)_2$+$6H_2O$]	1	1.56439	1.0	H	1.0077	6.2525
				N	14.0033	3.1604
				O	15.9904	64.0630
				^{235}U	235.0441	26.5240

Table 6.4. Material compositions used in the ES-3100 calculation models

Material	Mix. No.	Theoretical density input parameter (g/cm^3) [a]	Volume fraction	Constituent	Atomic weight	Weight fraction
UNH crystals	1	1.50149	1.0	H	1.0077	6.6172
(8000.0 g)				N	14.0033	2.9270
$[UO_2(NO_3)_2+6H_2O]$				O	15.9904	65.8907
				^{235}U	235.0441	24.5651
UNH crystals	1	1.06111	1.0	H	1.0077	10.3811
(1000.1 g)				N	14.0033	0.5178
$[UO_2(NO_3)_2+6H_2O]$				O	15.9904	84.7556
				^{235}U	235.0441	4.3455
~20% enriched UZrH	1	8.65974	1.0	H	1.0078	0.9554
(3466.7 g)				Zr	91.2196	54.0447
				^{235}U	235.0441	8.8558
				^{238}U	238.0510	36.1441
~70% enriched UZrH	1	5.70132	1.0	H	1.0078	1.5894
(2282.4 g)				Zr	91.2196	89.9107
				^{235}U	235.0441	5.9588
				^{238}U	238.0510	2.5413
~20% enr. U_3O_8-Al	1	3.52015	1.0	O	15.9904	5.2477
(12254.7 g)				Al	26.9818	65.5398
				^{235}U	235.0441	5.8425
				^{238}U	238.0510	23.3700
~70% enr. U_3O_8-Al	1	3.52095	1.0	O	15.9904	5.2800
(1995.7 g)				Al	26.9818	65.5141
				^{235}U	235.0441	20.4441
				^{238}U	238.0510	8.7618
~93% enr. U_3O_8-Al	1	3.52132	1.0	O	15.9904	5.2950
(1505.0 g)				Al	26.9818	65.5022
				^{235}U	235.0441	27.2170
				^{238}U	238.0510	1.9858
~9.9% enr. UO_2-Mg	1	3.95984	1.0	O	15.9904	6.4032
in Al clad				Mg	24.3048	7.6175
(15231.1 g)				Al	26.9818	38.3916
				^{235}U	235.0441	4.7062
				^{238}U	238.0510	42.8815
20% enr. UO_2-Mg	1	3.96017	1.0	O	15.9904	6.4110
in Al clad				Mg	24.3048	7.6169
(7523.6 g)				Al	26.9818	38.3885
				^{235}U	235.0441	9.5167
				^{238}U	238.0510	38.0670

Table 6.4. Material compositions used in the ES-3100 calculation models

Material	Mix. No.	Theoretical density input parameter (g/cm^3) [a]	Volume fraction	Constituent	Atomic weight	Weight fraction
~93% enr. UO_2-Mg	1	3.96254	1.0	O	15.9904	6.4670
in Al clad				Mg	24.3048	7.6123
(1472.1 g)				Al	26.9818	38.3655
				^{235}U	235.0441	44.3215
				^{238}U	238.0510	3.2338
Single-unit calculation models (NCT)						
277-4	2	1.50970	1.0	H	1.0077	2.84745
canned spacer				^{10}B	10.0130	0.65907
Table 11 data: [b]				^{11}B	11.0096	2.97264
as-manufactured,				C	12.0001	1.36094
minimum density and				N	14.0033	0.01000
hydrogen				O	15.9904	53.39650
				Na	22.9895	0.08326
				Mg	24.3048	0.23957
				Al	26.9818	27.69370
				Si	28.0853	1.74979
				S	32.0634	0.21865
				Ca	40.0803	8.39267
				Fe	55.8447	0.37575
Water-flooded containment vessel (CV)	3	0.9982	1.0	H	1.0077	11.1909
				O	15.9904	88.8091
SS304	8	7.9400	1.0	C	12.0001	0.0800
CV body				Si	28.0853	1.0000
16.60 lb				P	30.9741	0.0450
but 15.74 lb used				Cr	51.9957	19.0000
				Mn	54.9379	2.0000
				Fe	55.8447	68.3750
				Ni	58.6872	9.5000
SS304	9	7.9400	0.97267	C	12.0001	0.0800
CV lower flange				Si	28.0853	1.0000
used 3.36 lb				P	30.9741	0.0450
				Cr	51.9957	19.0000
				Mn	54.9379	2.0000
				Fe	55.8447	68.3750
				Ni	58.6872	9.5000

Table 6.4. Material compositions used in the ES-3100 calculation models

Material	Mix. No.	Theoretical density input parameter (g/cm^3) [a]	Volume fraction	Constituent	Atomic weight	Weight fraction
SS304	10	7.9400	0.94348	C	12.0001	0.0800
CV upper flange				Si	28.0853	1.0000
used 13.75 lb				P	30.9741	0.0450
				Cr	51.9957	19.0000
				Mn	54.9379	2.0000
				Fe	55.8447	68.3750
				Ni	58.6872	9.5000
277-4	11	1.45971	1.0	H	1.0077	2.84746
filling CV				^{10}B	10.0130	0.65907
inner-liner cavity				^{11}B	11.0096	2.97265
Table 11 data: [b]				C	12.0001	1.36094
as-manufactured,				N	14.0033	0.01000
minimum density and				O	15.9904	53.39660
hydrogen				Na	22.9895	0.08326
				Mg	24.3048	0.23957
				Al	26.9818	27.69360
				Si	28.0853	1.74979
				S	32.0634	0.21865
				Ca	40.0803	8.39266
				Fe	55.8447	0.37575
Kaolite	12	(body weldment)				
Al_2O_3		0.34864	0.096	Al	26.9818	52.9390
				O	15.9904	47.0610
SiO_2		0.34864	0.367	Si	28.0853	46.7570
				O	15.9904	53.2430
Fe_2O_3		0.34864	0.067	Fe	55.8447	69.9540
				O	15.9904	30.0460
TiO_2		0.34864	0.012	Ti	47.8793	59.9530
				O	15.9904	40.0470
CaO		0.34864	0.307	Ca	40.0803	71.4810
				O	15.9904	28.5180
MgO		0.34864	0.131	Mg	24.3048	60.3170
				O	15.9904	39.6830
Na_2O		0.34864	0.020	Na	22.9895	74.1960
				O	15.9904	25.8040
Total O		—	—	—	15.9904	—
Water	12	0.52294	1.0	H	1.0077	11.1909
				O	15.9904	88.8091

Table 6.4. Material compositions used in the ES-3100 calculation models

Material	Mix. No.	Theoretical density input parameter (g/cm^3) [a]	Volume fraction	Constituent	Atomic weight	Weight fraction
Kaolite	13	(top plug)				
Al_2O_3		0.33241	0.096	Al	26.9818	52.9390
				O	15.9904	47.0610
SiO_2		0.33241	0.367	Si	28.0853	46.7570
				O	15.9904	53.2430
Fe_2O_3		0.33241	0.067	Fe	55.8447	69.9540
				O	15.9904	30.0460
TiO_2		0.33241	0.012	Ti	47.8793	59.9530
				O	15.9904	40.0470
CaO		0.33241	0.307	Ca	40.0803	71.4810
				O	15.9904	28.5180
MgO		0.33241	0.131	Mg	24.3048	60.3170
				O	15.9904	39.6830
Na_2O		0.33241	0.020	Na	22.9895	74.1960
				O	15.9904	25.8040
Total O		—	—	—	15.9904	—
Water	13	0.49860	1.0	H	1.0077	11.1909
				O	15.9904	88.8091
Silicon rubber pads	14	1.21791	1.0	H	1.0077	8.1562
				C	12.0001	32.3774
				O	15.9904	21.5782
				Si	28.0853	37.8882
Water—CV well	15	0.9982	variable	H	1.0077	11.1909
				O	15.9904	88.8091
SS304 liner	16	7.94	1.0	C	12.0001	0.0800
				Si	28.0853	1.0000
				P	30.9741	0.0450
				Cr	51.9957	19.0000
				Mn	54.9379	2.0000
				Fe	55.8447	68.3750
				Ni	58.6872	9.5000
SS304 plug cover used 9.907 lb	17	7.94	1.06388	C	12.0001	0.0800
				Si	28.0853	1.0000
				P	30.9741	0.0450
				Cr	51.9957	19.0000
				Mn	54.9379	2.0000
				Fe	55.8447	68.3750
				Ni	58.6872	9.5000

Table 6.4. Material compositions used in the ES-3100 calculation models

Material	Mix. No.	Theoretical density input parameter (g/cm^3) [a]	Volume fraction	Constituent	Atomic weight	Weight fraction
SS304 angle iron	18	7.94	1.0	C	12.0001	0.0800
				Si	28.0853	1.0000
				P	30.9741	0.0450
				Cr	51.9957	19.0000
				Mn	54.9379	2.0000
				Fe	55.8447	68.3750
				Ni	58.6872	9.5000
SS304 steel drum	19	7.94	1.0	C	12.0001	0.0800
				Si	28.0853	1.0000
				P	30.9741	0.0450
				Cr	51.9957	19.0000
				Mn	54.9379	2.0000
				Fe	55.8447	68.3750
				Ni	58.6872	9.5000
Water—interstitial	20	0.9982	variable	H	1.0077	11.1909
				O	15.9904	88.8091
Water—reflector	21	0.9982	1.0	H	1.0077	11.1909
				O	15.9904	88.8091
Array calculation models (NCT) same as single-unit calculation models NCT except as follows:						
Kaolite	12	(body weldment)				
Al_2O_3		0.42622	0.096	Al	26.9818	52.9390
				O	15.9904	47.0610
SiO_2		0.42622	0.367	Si	28.0853	46.7570
				O	15.9904	53.2430
Fe_2O_3		0.42622	0.067	Fe	55.8447	69.9540
				O	15.9904	30.0460
TiO_2		0.42622	0.012	Ti	47.8793	59.9530
				O	15.9904	40.0470
CaO		0.42622	0.307	Ca	40.0803	71.4810
				O	15.9904	28.5180
MgO		0.42622	0.131	Mg	24.3048	60.3170
				O	15.9904	39.6830
Na_2O		0.42622	0.020	Na	22.9895	74.1960
				O	15.9904	25.8040
Total O		—	—	—	15.9904	—
Water	12	0.63931	0.0287	H	1.0077	11.1909
				O	15.9904	88.8091

Table 6.4. Material compositions used in the ES-3100 calculation models

Material	Mix. No.	Theoretical density input parameter (g/cm^3) [a]	Volume fraction	Constituent	Atomic weight	Weight fraction
Kaolite	13	(top plug)				
Al_2O_3		0.33241	0.096	Al	26.9818	52.9390
				O	15.9904	47.0610
SiO_2		0.33241	0.367	Si	28.0853	46.7570
				O	15.9904	53.2430
Fe_2O_3		0.33241	0.067	Fe	55.8447	69.9540
				O	15.9904	30.0460
TiO_2		0.33241	0.012	Ti	47.8793	59.9530
				O	15.9904	40.0470
CaO		0.33241	0.307	Ca	40.0803	71.4810
				O	15.9904	28.5180
MgO		0.33241	0.131	Mg	24.3048	60.3170
				O	15.9904	39.6830
Na_2O		0.33241	0.020	Na	22.9895	74.1960
				O	15.9904	25.8040
Total O		—	—	—	15.9904	—
Water	13	0.49860	0.0287	H	1.0077	11.1909
				O	15.9904	88.8091
SS304 angle iron	18	7.94	1.25705	C	12.0001	0.0800
				Si	28.0853	1.0000
				P	30.9741	0.0450
				Cr	51.9957	19.0000
				Mn	54.9379	2.0000
				Fe	55.8447	68.3750
				Ni	58.6872	9.5000
SS304 steel drum	19	7.94	0.99981	C	12.0001	0.0800
				Si	28.0853	1.0000
				P	30.9741	0.0450
				Cr	51.9957	19.0000
				Mn	54.9379	2.0000
				Fe	55.8447	68.3750
				Ni	58.6872	9.5000
Water—reflector	21	1.16235	1.0	H	1.0077	11.1909
				O	15.9904	88.8091

Table 6.4. Material compositions used in the ES-3100 calculation models

Material	Mix. No.	Theoretical density input parameter (g/cm^3) [a]	Volume fraction	Constituent	Atomic weight	Weight fraction
Single-unit calculation models (HAC) same as single-unit calculation models NCT except as follows:						
277-4	2	1.50853	1.0	H	1.0077	2.84094
canned spacer				^{10}B	10.0130	0.65958
Table 12 data: [b]				^{11}B	11.0096	2.97494
as-manufactured,				C	12.0001	1.36193
minimum density and				N	14.0033	0.01001
hydrogen				O	15.9904	53.36920
				Na	22.9895	0.08333
				Mg	24.3048	0.23976
				Al	26.9818	27.71520
				Si	28.0853	1.75109
				S	32.0634	0.21882
				Ca	40.0803	8.39916
				Fe	55.8447	0.37604
277-4	11	1.45858	1.0	H	1.0077	2.84097
filling CV				^{10}B	10.0130	0.65959
inner-liner cavity				^{11}B	11.0096	2.97496
Table 12 data: [b]				C	12.0001	1.36193
as-manufactured,				N	14.0033	0.01001
minimum density and				O	15.9904	53.36930
hydrogen				Na	22.9895	0.08333
				Mg	24.3048	0.23976
				Al	26.9818	27.71510
				Si	28.0853	1.75109
				S	32.0634	0.21882
				Ca	40.0803	8.39913
				Fe	55.8447	0.37604
Kaolite	12	(body weldment)				
Al_2O_3		0.41898	0.096	Al	26.9818	52.9390
				O	15.9904	47.0610
SiO_2		0.41898	0.367	Si	28.0853	46.7570
				O	15.9904	53.2430
Fe_2O_3		0.41898	0.067	Fe	55.8447	69.9540
				O	15.9904	30.0460
TiO_2		0.41898	0.012	Ti	47.8793	59.9530
				O	15.9904	40.0470
CaO		0.41898	0.307	Ca	40.0803	71.4810
				O	15.9904	28.5180
MgO		0.41898	0.131	Mg	24.3048	60.3170
				O	15.9904	39.6830

Table 6.4. Material compositions used in the ES-3100 calculation models

Material	Mix. No.	Theoretical density input parameter (g/cm^3) [a]	Volume fraction	Constituent	Atomic weight	Weight fraction
Na_2O		0.41898	0.020	Na	22.9895	74.1960
				O	15.9904	25.8040
Total O		—	—	—	15.9904	—
Water	12	0.62843	1.0	H	1.0077	11.1909
				O	15.9904	88.8091
SS304 angle iron	18	7.94	1.23239	C	12.0001	0.0800
				Si	28.0853	1.0000
				P	30.9741	0.0450
				Cr	51.9957	19.0000
				Mn	54.9379	2.0000
				Fe	55.8447	68.3750
				Ni	58.6872	9.5000
SS304 steel drum	19	7.94	1.08401	C	12.0001	0.0800
				Si	28.0853	1.0000
				P	30.9741	0.0450
				Cr	51.9957	19.0000
				Mn	54.9379	2.0000
				Fe	55.8447	68.3750
				Ni	58.6872	9.5000
Array calculation models (HAC) same as single-unit calculation models HAC except as follows:						
Kaolite	12	(body weldment)				
Al_2O_3		0.41898	0.096	Al	26.9818	52.9390
				O	15.9904	47.0610
SiO_2		0.41898	0.367	Si	28.0853	46.7570
				O	15.9904	53.2430
Fe_2O_3		0.41898	0.067	Fe	55.8447	69.9540
				O	15.9904	30.0460
TiO_2		0.41898	0.012	Ti	47.8793	59.9530
				O	15.9904	40.0470
CaO		0.41898	0.307	Ca	40.0803	71.4810
				O	15.9904	28.5180
MgO		0.41898	0.131	Mg	24.3048	60.3170
				O	15.9904	39.6830
Na_2O		0.41898	0.020	Na	22.9895	74.1960
				O	15.9904	25.8040
Total O		—	—	—	15.9904	—
Water	12	0.62843	0.287	H	1.0077	11.1909
				O	15.9904	88.8091

Table 6.4. Material compositions used in the ES-3100 calculation models

Material	Mix. No.	Theoretical density input parameter (g/cm^3) [a]	Volume fraction	Constituent	Atomic weight	Weight fraction
Kaolite	13	(top plug)				
Al_2O_3		0.33241	0.096	Al	26.9818	52.9390
				O	15.9904	47.0610
SiO_2		0.33241	0.367	Si	28.0853	46.7570
				O	15.9904	53.2430
Fe_2O_3		0.33241	0.067	Fe	55.8447	69.9540
				O	15.9904	30.0460
TiO_2		0.33241	0.012	Ti	47.8793	59.9530
				O	15.9904	40.0470
CaO		0.33241	0.307	Ca	40.0803	71.4810
				O	15.9904	28.5180
MgO		0.33241	0.131	Mg	24.3048	60.3170
				O	15.9904	39.6830
Na_2O		0.33241	0.020	Na	22.9895	74.1960
				O	15.9904	25.8040
Total O		—	—	—	15.9904	—
Water	13	0.49860	0.0287	H	1.0077	11.1909
				O	15.9904	88.8091
Water—reflector	21	1.16235	1.0	H	1.0077	11.1909
				O	15.9904	88.8091

[a] The theoretical density input parameter is specified for each material such that the required (or desired) mass of material is represented in the KENO V.a calculation model. The mass of material is computed by KENO V.a as the product of the theoretical density input parameter times the volume fraction times the volume of the geometry region in which the material resides in the calculation model.

[b] DAC-PKG-801624-A001.

The material compositions for the HAC array calculation model are identical to those for the NCT single-unit calculation models except as noted in Table 6.4. Also, the dimensions of the HAC array packaging calculation model do not differ from those of the HAC single-unit packaging calculation model. Therefore, both the region volumes and the atomic densities for the elemental constituents for Kaolite in the body weldment liner inner cavity are the same in both of the HAC calculation models. A difference between the HAC specifications for Kaolite (Mix. Nos. 12 and 13) in the array and the single-unit models occurs in the water component. The dry state is represented in the array model for maximizing neutronic interaction between packages of an array, while the flooded state is represented in the single-unit model for maximizing reflection.

The material composition used in the calculation model for the CV, the drum liner, and the drum is Type 304 stainless steel at a density of 7.94 g/cm^3. The density and composition of the Type 304 stainless steel for the drum is taken from the Standard Composition Library of the Standardized Computer Analysis for Licensing Evaluation (SCALE) code system. The nominal weights of these components, as determined by input density and volume calculated by KENO V.a, are 14.9 kg (32.85 lb) for the CV, 15.67 kg (34.55 lb) for the drum liner, and 25.44 kg (56.1 lb) for the drum.

Both the type and amount of hydrogenous packaging material used for packing the content in the CV is unknown. Polyethylene with a density of 0.92 g/cm^3 and a molecular formula of CH_2 has the greatest hydrogen density of potential packing materials. Although polyethylene bags are generally used in packing for contamination control, the exact mass of the polyethylene bags used is unknown. Multiple bags may be used to package the contents and to enclose the convenience cans, or bags may be omitted altogether. Realistically, the number of polyethylene bags used to bag the contents and wrap a convenience can would be six bags at most. Given that each bag weighs ~28 g, this results in a maximum of ~510 g of polyethylene per ES-3100 package. For consistency with other sections of this document, a maximum of 500 g of polyethylene per ES-3100 is used in the criticality evaluation. Possible additional sources of hydrogenous material inside the CV include can pads, vinyl tape, and polyethylene (~85 g) or Teflon (~303 g) bottles.

For the criticality calculations, the sources of hydrogen contained in packing materials are not distinguished from other sources of hydrogen inherent in the fissile material content. Therefore, packing material mass is defined as all sources of hydrogenous packing materials inside the CV plus the actual moisture in the content as constituent (the bonded hydrogen in UNX crystals or impurities in the oxide). Given content moisture is not to exceed 6 wt %, the amount of hydrogenous material inside the CV is not expected to exceed 2,400 g.

Containment vessel flooding is assumed in calculations performed for the derivation of fissile material loading limits. Even though both the NCT tests under 10 CFR 71.71 and the HAC tests under 10 CFR 71.73 demonstrate that containment is not breached, this simulated condition produces package configurations in the criticality calculations that are more reactive than the actual package configurations. The 7.1–10.1 kg quantities of evaluation water required in both the NCT and HAC criticality calculations bound reasonable amounts of hydrogenous material and inherent moisture of fissile material (primarily HEU oxides) present inside the CV (2,400 g).

HAC alter only the amount of volatile hydrogenous material contained in the package external to the CV (Sect. 2.7.3). High temperatures may reduce the hydrogenous material content of the Kaolite. Conversely, water intrusion may increase the hydrogenous material content in the package. Thus, the package's range of possible volatile hydrogenous material content varies from none, caused by high temperatures, to the maximum possible value caused by water intrusion.

Table 6.4 lists the material, density, atomic or isotopic constituent, and atomic or isotopic weight percent as basic data for materials used in the single-unit packaging and array calculation models in this criticality safety evaluation for NCT and HAC, respectively. Appendix 6.9.3 provides the rationale, justification, or both for using the basic data for computing atomic densities listed in Table 6.4.

6.3.3 Computer Codes and Cross-Section Libraries

The Criticality Safety Analysis Sequences within the SCALE modular code system provide automated, problem-dependent, cross-section processing followed by calculation of the neutron multiplication factor (k_{eff}) for the system being modeled (NUREG/CR-0200, Rev. 6). Initiated by "=csas25" appearing on the first line in the user input, the CSAS module runs the CSAS25 control sequence. The cross-section processing functional modules BONAMI (NUREG/CR-0200, Rev. 6) and NITAWL-II (NUREG/CR-0200, Rev. 6) are activated, providing resonance-corrected cross sections to the multigroup Monte Carlo functional module, KENO V.a (NUREG/CR-0200, Rev. 6). Using the processed cross sections, KENO V.a calculates the k_{eff} of three-dimensional system models. The geometric modeling capabilities available in KENO V.a, coupled with the automated cross-section processing, allow complex, three-dimensional systems to be easily analyzed.

The CSAS25 control sequence and the 238-group ENDF/B-V cross-section library in SCALE are used for all calculations. The control sequence, functional modules, and cross-section library are summarized in the following paragraphs.

The CSAS25 control sequence reads user-specified input data, which include the required cross-section library, specifications for mixtures, information for resonance processing of nuclides (size, geometry, and temperature), and a detailed geometry model for KENO V.a. Physical and neutronic information not specified but required by the functional modules (such as theoretical density, molecular weights, and average resonance region background cross sections) is supplied by the Standard Composition Library or calculated by the Materials Information Processor. The Standard Composition Library (NUREG/CR-0200, Rev. 6) consists of a standard composition directory and table, an isotopic distribution directory and table, and a nuclide information table. The Materials Information Processor (NUREG/CR-0200, Rev. 6) checks the input data pertaining to cross-section preparation and prepares binary input files for the applicable functional modules BONAMI and NITAWL-II.

The standardized automated procedures process SCALE cross sections using the Bondarenko method (via BONAMI) and the Nordheim integral method (via NITAWL-II) to provide a resonance-corrected cross-section library based on the physical characteristics of the problem being analyzed.

BONAMI performs resonance shielding through the application of the Bondarenko shielding factor method. BONAMI reads the master format library and applies the Bondarenko correction to all nuclides that have Bondarenko data. BONAMI produces a Bondarenko-corrected master format library which is read by NITAWL-II.

NITAWL-II applies the Nordheim Integral Treatment to perform neutron cross-section processing in the resonance energy range for nuclides that have ENDF/B resonance parameter data. This technique involves the numerical integration of ENDF/B resonance parameters using a calculated flux distribution, which is based on the calculated collision density across each resonance and subsequent weighing of the reaction cross section to the desired broad group structure. In the CSAS sequence, NITAWL-II assembles the group-to-group transfer arrays from the elastic and inelastic scattering components and performs other tasks to produce a problem-dependent, working cross-section library which can be used by KENO.

KENO V.a, a multigroup Monte Carlo computer code, is used to determine k_{eff} for multidimensional systems. The basic geometrical bodies allowed in KENO V.a for defining models are cuboids, spheres, cylinders, hemispheres, and hemicylinders. KENO V.a has the following major characteristics:

- enhanced geometry package that allows arrays to be defined and positioned throughout the model;
- P_n scattering treatment;
- extended use of differential albedo reflection;
- printer plots for checking the input model;
- energy-dependent data supergrouping;
- restart capability; and
- origin specifications for cuboids, spheres, cylinders, hemicylinders, and hemispheres.

The 238-group ENDF/B-V master cross-section library in SCALE is activated in the CSAS25 control sequence by specifying 238GROUPNDF5 (238GR) as the cross-section library name. The 238-GROUP ENDF/B-V [neutron cross-section] library is a general-purpose criticality analysis library and the most complete library available in SCALE 4.4a. The library contains data for all nuclides (more than 300) available in ENDF/B-V processed by the AMPX-77 systems. It also contains data for ENDF/B-VI evaluations of ^{14}N, ^{15}N, ^{16}O, ^{154}Eu, and ^{155}Eu. The library has 148 fast groups and 90 thermal groups (below 3 eV). Most resonance nuclides in the 238 group have resonance data (to be processed by NITAWL-II in the resolved resonance range) and Bondarenko factors (to be processed by BONAMI) for the unresolved range. The 238-group library contains resolved resonance data for s-wave, p-wave, and d-wave resonances **R** = 0, **R** = 1, and **R** = 2, respectively. These data can have a significant effect on results for under-moderated, intermediate-energy problems. Resonance structures in several light-to-intermediate mass "nonresonance" ENDF nuclides (i.e., ^{7}Li, ^{19}F, ^{27}Al, ^{28}Si) are accounted for using Bondarenko shielding factors. These structures can also be important in intermediate energy problems.

All nuclides in the 238-group library use the same weighting spectrum, consisting of:

- Maxwellian spectrum (peak at 300 K) from 10^{-5} to 0.125 eV,
- a 1/E spectrum from 0.125 eV to 67.4 keV,
- a fission spectrum (effective temperature at 1.273 MeV) from 67.4 keV to 10 MeV, and
- a 1/E spectrum from 10 to 20 MeV.

The k_{eff} values for each KENO V.a case are based on 500,000 neutron histories produced by running for 215 generations with 2,500 neutrons per generation and truncating the first 15 generations of data. The convergence of the KENO V.a calculation is related to trends in the average calculated k_{eff}. In general, the KENO V.a output table of k_{eff} by Generation Skipped is reviewed for trends. If no trends are observed, the calculation is accepted, and the reported value of k_{eff} is the one with the most neutron histories. Usually there is no statistically significant difference between this result and the one with the smallest standard deviation.

No manual cross-section adjustment is performed for the criticality safety evaluation. The cross-section processing is performed automatically in the CSAS25 code sequence making use of the available cross-section treatment options, as appropriate.

The CSAS control module, the associated functional modules, cross sections, and databases used in this evaluation reside in the verified configuration control area designated **/vcc/scale4.4a** on a Hewlett Packard Series 9000 J Class workstation at the Y-12 Safety Analysis Engineering (SAE) organization in Oak Ridge, Tennessee. The detailed input and computer output for the criticality safety evaluation of the ES-3100 shipping container with HEU reside in a configuration control area **/archive/ylf717_Rv2** on the workstation. Input listings of the key cases indicated in Tables 6.1a–6.1f are provided in Appendix 6.9.7.

For low density uranium oxides, KENO V.a calculations are performed using CSAS5 in SCALE 6.1.1 on the Microway Parallel Linux Cluster ENGHPC01 at the Y-12 National Security Complex, Oak Ridge, Tennessee.

More recent calculations for broken metal, turning, fines, powders, poly wrapped reactor fuel, annular cylinders, U_3Si_2-Al and U_3Si compounds, compounds by air, thorium oxide mixed with uranium oxide in fuel pellets and bulk oxide, zircalloy oxide mixed with uranium oxide, thorium mixed with uraniuim oxide, were performed using the Monte Carlo CSAS5 and 238-group ENDF/B-VII (V7-238 gr) cross-section library of SCALE 6.1.3, executed on a Microway Parallel Linux Cluster ENGHPC.

Several CSAS control modules are contained in SCALE 6.1.1 and SCALE 6.1.3 The CSAS control modules are designed to analyze systems containing fissile material and calculate the neutron multiplication factor (k_{eff}) of the system. This validation is only applicable to the CSAS5 control module that uses the KENO V.a functional module. Prior to entering the KENO V.a functional module, the CSAS5 control module calls a series of utility modules and other functional modules to process the cross-section data. This validation used the 238-group ENDF/B-VII cross-section library. This is a multigroup library containing 238 distinct neutron energy groups based on the ENDF/B-VII library. The CSAS5 control module executes several functional modules to process the cross-section data used in KENO V.a. These programs are:

- WORKER: This functional module interfaces between the AMPX master library contained in the SCALE code package and the AMPX working library used in KENO V.a.
- BONAMI: This functional module processes the unresolved resonance data contained in the master library and places it in the working library.
- PMC: This functional module uses point-wise continuous cross-section data to solve a one dimensional equivalent problem producing a flux profile used for processing cross-section data.
- CENTRM: This functional module uses the flux profile calculated in PMC to collapse point-wise continuous cross-section data into the appropriate group structure producing a working library used in KENO V.a.
- KENO V.a: This functional module performs the three dimensional Monte Carlo calculation using the cross-section library provided by the WORKER module.

The V7-238 gr cross-section library used to perform criticality calculations is a multigroup library containing 238 discrete neutron energy groups processed from the ENDF/B-VII continuous energy cross-section data.

The CSAS5 control module, the associated functional modules, the cross-section library, and databases used in this evaluation reside in the verified configuration control area designated **/vcc/scale6** on ENGHPC. The computer input and output files for the criticality safety evaluation of the ES-3100 package also reside in a configuration control area **/wa9/archive/RP-801940-A001R3** on ENGHPC.

6.3.4 Demonstration of Maximum Reactivity

Liquid HEU is not being shipped in the ES-3100. Only the uranyl nitrate crystal content being shipped in the ES-3100 is soluble in water. The hypothetical occurrence of uranyl nitrate solution is evaluated as a consequence of evaluating the presence of water inside the CV.

As stated in Sect. 6.1.2, 10 CFR 71.55(b) requires the evaluation of water leakage into the CV or leakage of liquid contents out of the CV and other conditions that produce maximum reactivity in the single package. For solid uranium contents, water leakage conditions are simulated by flooding all regions outside and inside of the CV, including the sealed convenience cans. For liquid uranium "contents", water leakage conditions are simulated by flooding all regions outside the CV except the CV well. Uranyl nitrate solution resides inside both the CV, including the Teflon bottles, and the well external to the CV. According to the 10 CFR 71.55(b) requirement, a flooded CV under full water reflection is also evaluated.

While the loss of containment is deemed incredible by merit of the results of the physical tests performed under 10 CFR 71.71 and 10 CFR 71.73, credit for the high-integrity, watertight containment is not taken in the single package analysis [10 CFR 71.55(d) and (e)]. Only partial credit is taken in the package array analysis (10 CFR 71.59). In both the single package and package array analyses, the CV is flooded with water. This fictitious "evaluation" water provides moderation to such an extent as to cause maximum reactivity of the content consistent with the chemical and physical form of the material present. Uranyl nitrate crystals are soluble in water. In both the evaluation of undamaged packages under 10 CFR 71.59(a)(1) and damaged packages under 10 CFR 71.59(a)(2), the leakage out of the CV of content moderated to such an extent as to cause maximum reactivity consistent with the physical and chemical form of material is not considered credible during NCT or HAC, based on results for tests specified in 10 CFR 71.71 and 10 CFR 71.73.

Contents are generally dry, and only small quantities of hydrogenous packing materials are used. However, credit for the high-integrity, watertight containment is not taken in this criticality evaluation (Docket 71-9315). Fissile material loading is restricted such that if a CV were flooded, it would be adequately subcritical under full water reflection. But instead of loading limits being established in accordance with conditions of confinement and containment as demonstrated under the NCT and HAC tests, these single-unit fissile material loading limits are severely reduced on the basis of the array calculations where all of the CVs of the packages in an array are assumed to be flooded, but each packaging is dry. This has the effect of maximizing both the neutron source and neutronic interaction between packages. Because credit for the high-integrity, watertight containment is not fully taken in this criticality evaluation, the fissile material mass loading limits developed as a result are very conservative.

Section 6.3.1 provides dimensional data for content and package models, and Sect. 6.3.2 provides material composition data used in the calculation models. Appendix 6.9.3 provides justification for the composition data used in the evaluation. These sections and this appendix describe how the packaging dimensions and materials are optimized to produce a conservative model by reducing neutron-absorbing materials and maximizing the reactivity of the fissile material content through the inclusion of water in the CV.

As described in Sect. 6.3.1.1, a geometry region is defined by dimensions and the type of material contained therein. The amount of material within a region is quantified in terms of the density, material volume fraction, and the volume of the region (Sect. 6.3.2). The term "water fraction" means the fraction of the maximum specific gravity of water possible for any geometry region in the ES-3100 package. Therefore, the water content is the fraction of the maximum specific gravity of water possible in a material in the ES-3100 package when flooded.

The maximum value for the void regions (spaces external to the CV) is 1.0 for both single-unit and array geometries. For the geometry regions containing Kaolite, the maximum values are 0.51655 for the single unit and 0.63931 for the array. For the geometry regions containing 277-4, the maximum value is 0.6942 for both the single-unit and array geometries. The same single-unit values are used in the array calculation models because the 277-4–bearing regions do not require adjustment for the close-pack approximation (Sect. 6.3.1.2).

In general, boundary condition specifications are not required in KENO V.a, so calculation models analyzed using KENO V.a require no special boundary conditions. However, in this evaluation, the infinite array cases use a single package with a reduced radius modeled with specular reflection on all faces of a surrounding cuboid. The energies and angular dependence of the neutrons are treated such that an infinite system with no neutron leakage is simulated.

For simplicity, the NCT and HAC sets of calculations were performed for selected ES-3100 array sizes by varying the water content of the ES-3100 package external to the CV from zero to its maximum

value. This technique bounds all NCT and HAC; however, only the relevant calculation results are used in determination of the CSI for criticality purposes.

Although four decimal places are shown for k_{eff} values in result tables, the actual accuracy of the code, for a particular calculation, may be on the order of ± 0.02–0.03 based on the spread in results for benchmark calculations (Y/DD-896/R1 and Y/DD-972R1). Also, the standard deviation of the mean for a particular calculation is on the order of 0.001 for benchmark cases and somewhat higher for the package calculations. Therefore, numerical values are considered physically meaningful or significant to the third decimal place. The primary reason for reporting four (or five) decimal places for a calculation result is to confirm that the result reported actually originated from a given output file. A value of 0.925 is the USL used for this safety analysis report for packaging (Sect. 6.8.3).

6.4 SINGLE PACKAGE EVALUATION

The HEU content of a package is in one of the following forms: metal of a specified geometric shape; metal of an unspecified shape and characterized as broken metal; uranium oxide; or UNX crystals. The bounding types of HEU content evaluated in this criticality analysis are 3.24-in. and 4.25-in.-diam cylinders; 2.29-in.-square bars; 1.5-in.-diam × 2-in.-tall slugs; cubes ranging from 0.25 to 1 in. on a side; broken metal; metal turnings, fines, or powder; solid HEU metal of unspecified geometric shape and characterized as broken metal; product oxide; skull oxide; UNH crystals; and unirradiated TRIGA reactor fuel elements.

Dimensions for bounding calculation models of a TRIGA fuel section are 1.44 in. in diameter × 5 in. tall. The 20% enrichment fuel contains more fissile mass than the 70% enrichment fuel on account of a higher uranium weight fraction and associated material density. A 20 wt % enriched TRIGA fuel element with 45 wt % U contains ≤ 307-g ^{235}U; whereas, a 70 wt % enriched TRIGA fuel with 8.5 wt % U contains ≤ 136-g ^{235}U. The physical parameters which characterize the TRIGA fuel are enrichment, uranium weight fraction, and the fuel diameter (Appendix 6.9.3.1). These parameters are addressed in this section demonstrating that the calculation models are bounding in the criticality evaluation.

Alloys of uranium may include aluminum, molybdenum, or zirconium. Uranium-aluminum (U-Al) alloy is typically 70 to 95 wt % aluminum. Uranium-molybdenum (U-Mo) alloys are typically 1.5 to 12 wt % molybdenum. U-Mo alloys may be plated with, clad with, or contain traces of aluminum, gold, stainless steel, nickel, and/or chromium. The enrichment of U-Al, U-Mo, and U-Zr alloys range from 92.65 to 93.21 wt % ^{235}U.

6.4.1 Solid HEU Metal of Specified Geometric Shapes

For bare and reflected single packages with HEU metal content, the neutron multiplication factor increases as a function of the ^{235}U mass and the moisture fraction of the package external to the CV (MOIFR). For example, consider the ES-3100 package loaded with three convenience cans for a total of 36,000-g ^{235}U. Each press-fit lid type can contains a single 3.24-in.-diam, 12,000-g cylinder of ^{235}U. The $k_{eff} + 2\sigma$ values in the bare package increase from 0.911 to 0.955 with increasing moisture fraction of the package external to the CV (MOIFR), Cases **ncsbcyt11_36_1_1** through **ncsbcyt11_36_1_15** (Appendix 6.9.6, Table 6.9.6-2). The $k_{eff} + 2\sigma$ values increase from 0.918 to 0.955 with increasing MOIFR in the water-reflected package, Cases **ncsrcyt11_36_1_1** through **ncsrcyt11_36_1_15** (Appendix 6.9.6, Table 6.9.6-2). The addition of water to the package reduces the neutron leakage fraction (NLF), thereby increasing k_{eff}. Water reflection external to a flooded package is inconsequential to package reactivity as a comparison of results for Cases **ncsbcyt11_36_1_15** and **ncsrcyt11_36_1_15** indicates.

In this series of calculations using the ES-3100 package model with NCT geometry (Cases **ncsrcyt11_36_1_1** through **ncsrcyt11_36_1_15)**, the MOIFR is varied uniformly over the package model with the exception of the neutron poison of the body weldment liner inner cavity and the flooded CV. The single-unit case with a MOIFR = 1.0 pertains specifically to the flooded drum under conditions specified in 10 CFR 71.55(b). This pseudo-HAC condition is more reactive than either the true NCT where both the CV and Kaolite are dry [10 CFR 71.55(d)] or this evaluation for NCT where the CV is flooded and the Kaolite is dry (in the as-manufactured condition, MOIFR ~ 0.0289). At MOIFR = 1.0, external water reflection of the package is inconsequential to package reactivity. Moisture in the Kaolite and in the recesses of the package acts as a close reflector that decreases neutron leakage away from the package.

The single-unit case with a MOIFR = 1E-20 pertains specifically to a package under pseudo-HAC where both the Kaolite and the recesses of the package do not contain **any** water or bound hydrogen. This configuration is less reactive than the cases for Kaolite in the as-manufactured condition or water-saturated Kaolite because water in the Kaolite will provide some neutron moderation and reflection of neutrons back into the content.

Single package reactivity changes slightly between the bare and reflected conditions, while NLF changes considerably over the range of water fractions. This behavior illustrates the dependence of package reactivity on internal conditions of the package. Bare packages with low MOIFR values manifest low reactivity (k_{eff} = 0.911) and high neutron leakage (NLF = 0.47). These parameters indicate that fast neutrons scattered in the packaging do not slow down significantly but escape the package. Consequently, neutron interaction between these packages when they are configured into an array is high. Bare packages with MOIFR values >1E-2 manifest increasing k_{eff} values (from 0.911 to 0.955) and reduced NLF values (from 0.47 to 0.18). The increase in k_{eff} occurs due to water present in the regions of the package external to the content which reflects neutrons back into the HEU content that would otherwise escape the package.

A series of calculations are performed using the calculation model of a water-reflected CV loaded with 3.24-in.–diam cylinders. The three cylinders are aligned as depicted in Fig. 6.9.1-1 (Appendix 6.9.1) but in very close proximity due to the omission of can spacers. A parametric variation of water density from zero to 1.0 sp gr inside the CV is performed for establishing moderation by water to the most credible extent. The calculated $k_{eff} + 2\sigma$ values for Cases **cvcrcyt11_36_1_1** through **cvcrcyt11_36_1_15** (Appendix 6.9.6, Table 6.9.6-1) increase monotonically from 0.907 to 0.974 with increasing moisture fraction inside the CV (MOCFR). Maximum reactivity of the fissile material occurs in the flooded CV.

10 CFR 71.55(b)(3) requires evaluation of the efficiency of the packaging as an external reflector to the CV. Comparison of the calculated $k_{eff} + 2\sigma$ value for Case **cvcrcyt11_36_1_15** to the value for Case **ncsrcyt11_36_1_15** reveals that the flooded CV under full water reflection is a more reactive configuration than the CV inside a flooded ES-3100 packaging. The ES-3100 package is not as efficient a reflector as full water reflection provided to the flooded CV. For this reason, calculation results for the flooded CV rather than a flooded package are reported in Tables 6.1a (and Tables 6.1b–6.1f) for the evaluation of 10 CFR 71.55(b) requirements.

Examination of the results for Cases **cvcrcyt11_36_1** through **cvcrcyt11_18_1** indicates that an adequately subcritical loading is achieved when the mass loading is limited to 21,000-g ^{235}U (Case **cvcrcyt11_21_1**). Case **cvcrcyt11_36_2** reveals that the 277-4 canned spacers are adequate for mass loading >18,000-g ^{235}U but ≤ 36,000-g ^{235}U. These potential fissile (^{235}U) mass loading limits derived through the evaluation of 10 CFR 71.55(b) are listed in Table 6.1a in the information block where a description of the content appears for fissile material, “the most reactive credible configuration consistent with the chemical and physical form of the content.” The finalized mass loading limit is derived at the conclusion of the array analysis for these content configurations.

The NCT tests under 10 CFR 71.71 and the HAC tests under 10 CFR 71.73 demonstrate that containment is not breached. Nevertheless, CV flooding is assumed in the criticality calculations performed for the derivation of fissile material loading limits. The 7.1–10.1 kg quantities of evaluation water in both the NCT and HAC criticality calculations are not actually present in the CV. Simulation of this condition in the criticality calculations produces fissile material content that is more reactive than actual. The evaluation water required in both the NCT and HAC criticality calculations bounds reasonable amounts of hydrogenous material present inside the CV for solid HEU shapes.

Consider Case **cvcrcyt11_21_1** as the reference case where the calculated $k_{eff} + 2\sigma = 0.923$ (Table 6.9.6-1). The fissile material content is 21,000 g HEU metal at 100% enrichment and a density of 18.81109 g/cm^3. Three HEU cylinders (3.24-in. diam and 2.75425-in. tall) are stacked end-to-end starting at 0.0005 cm above the bottom of the CV. The stack height is 20.98987 cm where each cylinder is separated by a 0.0001-cm–thick 277-4 canned spacer and 0.0012 cm of moderating material. Effectively, this configuration does not have 277-4 canned spacers, and no polyethylene is used in this calculation model. The water-filled cavity above the content is 57.74963 cm in height. As the input listing for Case **cvcrcyt11_21_1** (Appendix 6.9.7) indicates, ~9083 g of **evaluation** water fills the flooded CV and the calculated H/X ratio is ~11.29. The calculated H/X ratio for the HEU content wrapped in 500 g polyethylene (hydrogenous packing material) inside a dry CV is ~0.80.

Case **cvcrpcyt11_21_1** is the same as reference Case **cvcrcyt11_21_1,** except that 500-g polyethylene wraps three HEU cylinders with a uniform thickness of 0.54956 cm. The three wrapped HEU cylinders are stacked end-to-end starting at 0.0005 cm above the bottom of the CV. Each wrapped cylinder is separated by a 0.0001-cm–thick 277-4 canned spacer and 0.0012 cm of moderating material resulting in a stack height of 24.28733 cm. The water-filled cavity above the content is 57.74963 cm in height. At a density of 0.9200 g/cm^3, 500 g polyethylene adds 543.47826 cm^3 to the volume of the content and reduces the free volume of the CV by an equal amount. As indicated in the case title card, 8540.1 g of **evaluation** water fills the flooded CV. The 500 g polyethylene increases the overall H/X ratio inside the flooded CV to 11.41. The calculated $k_{eff} + 2\sigma$ is 0.908 for this configuration (Table 6.9.6-1). While polyethylene having a greater hydrogen density than water is a slightly better moderating material than water, the presence of polyethylene in the calculation model provides separation between the fissile material resulting in a slight reduction in the calculated $k_{eff} + 2\sigma$ value. Case **cvdcrpcyt11_21_1** is the same as Case **cvcrpcyt11_21_1**, except that the CV is dry. The calculated $k_{eff} + 2\sigma$ is 0.847 for Case **cvdcrpcyt11_21_1** (Table 6.9.6-1). The calculated $k_{eff} + 2\sigma$ value of 0.923 for reference Case **cvcrcyt11_21_1** without polyethylene is greater than the values for Cases **cvcrpcyt11_21_1** and **cvdcrpcyt11_21_1** with polyethylene. In the case of solid HEU shapes, the 7.1–10.1 kg quantities of evaluation water required in both the NCT and HAC criticality calculations bound reasonable amounts of hydrogenous material present inside the CV.

Because convenience cans are not credited for providing configuration control in the CV, it is possible for the fissile material to be spaced farther apart than shown in Fig. 6.9.1-1. A series of cases was run to evaluate the axial spacing of content inside the CV. As shown in Table 6.9.6-3b, the separation distances between adjacent cylinders range from 0.0 to 8.75 in. (12.225 cm). Zero separation occurs when the base surfaces of adjacent cylinders are flush with the 277-4 canned spacer between them. Figure 6.9.1-1b depicts a section view of the CV with 3.24-in.-diam cylinders at 4.826 and 0.254 cm separation. The calculated $k_{eff}+2\sigma$ values for Cases **ncsrcyat11_1_2_15** through **ncsrcyat11_12_2_15** (Table 6.9.6-3c) decrease with increasing separation distance. Loading configurations where solid HEU of specified geometric shape is axially positioned in contact with the can spacers are the most reactive ones.

Additional CV cases were performed to exam the effect that 500 g of polyethylene will have on HEU metal cylinders and bars. The original cases previously found in Table 6.1a were rerun using SCALE 6.1.3, with updated cross-sections and more particles. These cases were also modified by adding 500 g of polyethylene. The results of these cases are found in Table 6.5.

Table 6.5. Reflected CV model, HEU metal cylinders and bars, with and without 500 g polyethylene, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff} + 2\sigma$
cvcrcyt11_21_1	21 kg ^{235}U, 3.24 in.-diam cylinder, no spacers or polyethylene	0.92680	0.00056	0.92792
cvcrcyt11p_21_1	21 kg ^{235}U, 3.24in.-diam cylinder, no spacers, 500 g polyethylene	0.91355	0.00071	0.91497
cvcrcyt11_36_2	36 kg ^{235}U, 3.24 in.-diam cylinder, with spacers and no polyethylene	0.88803	0.00064	0.88931
cvcrcyt11p_36_2	36 kg ^{235}U, 3.24 in.-diam cylinder, with spacers and 500 g polyethylene	0.88486	0.00062	0.88610
cvcrsqt11_36_1	36 kg ^{235}U, 2.29 in. l,w bars, no spacers or polyethylene	0.88228	0.00060	0.88348
cvcrsqt11p_36_1	36 kg ^{235}U, 2.29 in. l,w bars, no spacers, 500 g polyethylene	0.87699	0.00064	0.87827
cvcrcyct11_17_1	17 kg ^{235}U, 4.25 in.-diam cylinder, no spacers or polyethylene	0.92476	0.00067	0.92610
cvcrcyct11p_17_1	17 kg ^{235}U, 4.25 in.-diam cylinder, no spacers, 500 g polyethylene	0.92373	0.00064	0.92501
cvcrcyct11_32_2	32 kg ^{235}U, 4.25 in.-diam cylinder, with spacers and no polyethylene	0.92141	0.00062	0.92265
cvcrcyct11p_32_2	32 kg ^{235}U, 4.25 in.-diam cylinder, with spacers and 500 g polyethylene	0.90981	0.00062	0.91105

From the results of the CV cases for HEU metal cylinders and bars, modeling 500 g of polyethylene surrounding the HEU metal is slightly less reactive than no polyethylene.

Case **hcsrcyt12_36_1_15** (Appendix 6.9.6, Table 6.9.6-3) represents the HAC model of the damaged ES-3100 package, where the outer dimensions of the package are reduced accordingly and the entire package is flooded with the exception of the neutron poison of the body weldment liner inner cavity. The CV well is flooded with water, and the Kaolite contains maximum water content. This single-unit case with a MOIFR = 1.0 pertains specifically to the flooded drum under conditions specified in 10 CFR 71.55(e). The $k_{eff} + 2\sigma = 0.955$ for this HAC. The changes in both the outer dimensions of the package and the compositions of the Kaolite and 277-4 due to HAC result in an ~0.002 change in the neutron multiplication factor.

Repeated for 4.25-in.-diam cylinders (Appendix 6.9.6, Tables 6.9.6-6 and 6.9.6-7); 2.29-in.-square bars (Tables 6.9.6-4 and 6.9.6-5); and 1.5-in.-diam × 2-in.-tall slugs (Tables 6.9.6-8 and 6.9.6-9), this type of analysis for the 3.24-in.-diam cylinders demonstrates that single packages with restricted fissile material (^{235}U) loading remain subcritical over the entire range of water content or MOIFR. HEU metal or alloy content not covered by the specified geometric shapes (cylinder, square bar, or slug contents) will be in the HEU broken metal category, and so limited.

Additional cases were performed to exam the effect that 500 g of polyethylene will have on HEU metal cylinders and bars for single packages. The original cases previously found in Table 6.1a were rerun using SCALE 6.1.3, with updated cross-sections and more particles. These cases were also modified by adding 500 g of polyethylene. The results of these cases are found in Tables 6.6 and 6.7.

Table 6.6. Reflected NCT single package model, HEU metal cylinders and bars, with and without 500 g polyethylene, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff} + 2\sigma$
ncsrcyt11_21_1_15	21 kg ^{235}U, 3.24 in.-diam cylinder, no spacers or polyethylene	0.90427	0.00067	0.90561
ncsrcyt11p_21_1_15	21 kg ^{235}U, 3.24 in.-diam cylinder, no spacers, 500 g polyethylene	0.89441	0.00060	0.89561
ncsrcyt11_36_2_15	36 kg ^{235}U, 3.24 in.-diam cylinder, with spacers and no polyethylene	0.87298	0.00060	0.87418
ncscrcyt11p_36_2_15	36 kg ^{235}U, 3.24 in.-diam cylinder, with spacers and 500 g polyethylene	0.86916	0.00062	0.87040
ncsrsqt11_36_1_15	36 kg ^{235}U, 2.29 in. l,w bars, no spacers or polyethylene	0.86298	0.00064	0.86426
ncsrsqt11p_36_1_15	36 kg ^{235}U, 2.29 in. l,w bars, no spacers, 500 g polyethylene	0.86007	0.00061	0.86129
ncsrcyct11_17_1_15	17 kg ^{235}U, 4.25 in.-diam cylinder, no spacers or polyethylene	0.89551	0.00079	0.89709
ncsrcyct11p_17_1_15	17 kg ^{235}U, 4.25 in.-diam cylinder, no spacers, 500 g polyethylene	0.89536	0.00075	0.89686
ncsrcyct11_32_2_15	32 kg ^{235}U, 4.25 in.-diam cylinder, with spacers and no polyethylene	0.89586	0.00062	0.89710
ncsrcyct11p_32_2_15	32 kg ^{235}U, 4.25 in.-diam cylinder, with spacers and 500 g polyethylene	0.88573	0.00059	0.88691

Table 6.7. Reflected HAC single package model, HEU metal cylinders and bars, with and without 500 g polyethylene, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff} + 2\sigma$
hcsrcyt12_21_1_15	21 kg ^{235}U, 3.24 in.-diam cylinder, no spacers or polyethylene	0.90663	0.00056	0.90775
hsrcyt12p_21_1_15	21 kg ^{235}U, 3.24 in.-diam cylinder, no spacers, 500 g polyethylene	0.89464	0.00057	0.89578
hcsrcyt12_36_2_15	36 kg ^{235}U, 3.24 in.-diam cylinder, with spacers and no polyethylene	0.87412	0.00061	0.87534
hcscrcyt12p_36_2_15	36 kg ^{235}U, 3.24 in.-diam cylinder, with spacers and 500 g polyethylene	0.86907	0.00067	0.87041
hcsrsqt12_36_1_15	36 kg ^{235}U, 2.29 in. l,w bars, no spacers or polyethylene	0.86427	0.00065	0.86557
hcsrsqt12p_36_1_15	36 kg ^{235}U, 2.29 in. l,w bars, no spacers, 500 g polyethylene	0.86011	0.00058	0.86127
hcsrcyct12_17_1_15	17 kg ^{235}U, 4.25 in.-diam cylinder, no spacers or polyethylene	0.89820	0.00069	0.89958
hcsrcyct12p_17_1_15	17 kg ^{235}U, 4.25 in.-diam cylinder, no spacers, 500 g polyethylene	0.89598	0.00061	0.89720
hcsrcyct12_32_2_15	32 kg ^{235}U, 4.25 in.-diam cylinder, with spacers and no polyethylene	0.89778	0.00061	0.89900
hcsrcyct12p_32_2_15	32 kg ^{235}U, 4.25 in.-diam cylinder, with spacers and 500 g polyethylene	0.88811	0.00063	0.88937

From the results of the single package cases for HEU metal cylinders and bars, modeling 500 g of polyethylene surrounding the HEU metal cylinders and bars is slightly less reactive than no polyethylene.

The examination of two types of annular cylinders, one per ES-3100 CV, is also evaluated. Cylinder C is a uranium-molybdenum alloy (U-Mo) with ≤ 95 wt % uranium and ≤ 93.5% ^{235}U enrichment. The Cylinder C length is ≤ 3.30 in. with an inner diameter of ≥ 1.5 in., an outer diameter of ≤ 4.35 in., and a mass of ≤ 13.5 kg. Cylinder D is also a U-Mo alloy with ≤ 95 wt % uranium and ≤ 93.5% ^{235}U enrichment. The length of Cylinder D is ≤ 5.80 in. with an inner diameter of ≥ 1.35 in., an outer diameter of ≤ 3.86 in., and a mass of ≤ 16.5 kg. Each cylinder may be wrapped in a polyethylene bag limited to ≤ 500 g. The USL for these calculations is 0.93520.

For the CV cases (Appendix 6.9.6, Table 6.9.6-1a), the CV is modeled fully flooded and reflected on all sides by 30.48 cm of water, and each cylinder is modeled at the bottom of the CV. Case **cycrcylc** for Cylinder C has a calculated $k_{eff} \pm 2\sigma$ value of 0.83037 (k_{eff} = 0.82909, σ = 0.00064), while Case **cycrcyld** for Cylinder D has a calculated $k_{eff} \pm 2\sigma$ value of 0.84469 (k_{eff} = 0.84347, σ = 0.00061). Additional cases were run with the cylinder modeled vertically centered in the CV. Case **cycrcylcc** for Cylinder C has a calculated $k_{eff} \pm 2\sigma$ value of 0.83645 (k_{eff} = 0.83511, σ = 0.00067), while Case **cycrcyldc** for Cylinder D has a calculated $k_{eff} \pm 2\sigma$ value of 0.84558 (k_{eff} = 0.84400, σ = 0.00059).

For the NCT cases with a single package (Appendix 6.9.6, Table 6.9.6-2a), the CV is modeled fully flooded and the single package is modeled reflected on all sides by 30.48 cm of water. Each cylinder is modeled at the bottom of the CV. Case **ncsrcylc11** for Cylinder C has a calculated $k_{eff} \pm 2\sigma$ value of 0.80262 (k_{eff} = 0.80138, σ = 0.00062), while Case **ncsrcyld11** for Cylinder D has a calculated

k_{eff} ± 2σ value of 0.81544 (k_{eff} = 0.81420, σ = 0.00062). Additional cases were run with the cylinder modeled vertically centered in the CV. Case **ncsrcylcc11** for Cylinder C has a calculated k_{eff} ± 2σ value of 0.80887 (k_{eff} = 0.80765, σ = 0.00061), while Case **ncsrcyldc11** for Cylinder D has a calculated k_{eff} ± 2σ value is 0.81940 (k_{eff} = 0.81812, σ = 0.00064).

For the HAC cases with a single ES-3100 package (Appendix 6.9.6, Table 6.9.6-2a), the CV is modeled fully flooded and the single damaged package is modeled reflected on all sides by 30.48 cm of water. Each cylinder is modeled at the bottom of the CV. Case **hcsrcylc12** for Cylinder C has a calculated k_{eff} ± 2σ value of 0.80262 (k_{eff} = 0.80138, σ = 0.00062), while Case **hcsrcyld12** for Cylinder D has a calculated k_{eff} ± 2σ value of 0.81544 (k_{eff} = 0.81420, σ = 0.00062). Additional cases were run with the cylinder modeled vertically centered in the CV. Case **hcsrcylcc12** for Cylinder C has a calculated k_{eff} ± 2σ value of 0.81042 (k_{eff} = 0.80930, σ = 0.00056), while Case **hcsrcyldc12** for Cylinder D has a calculated k_{eff} ± 2σ value of 0.81938 (k_{eff} = 0.81814, σ = 0.00062).

Calculations were also performed to exam the effect of aluminum shielding to Cylinder D (Appendix 6.9.6, Table 6.9.6-2a). Reactivity decreases as the amount of aluminum shielding is added. This is due to the fact that the CV is flooded, and in order to add aluminum cladding, water must be removed to conserve volume. Thus, aluminum cladding is not controlled for Cylinder D.

All Cylinder C and D cases were shown to be below the USL of 0.9352, with the models in which the cylinders are centered vertically inside the CV being the most reactive.

Each TRIGA fuel element for shipment in the ES-3100 is to be disassembled. The active fuel consisting of three 5-in.-tall cylinders of $UZrH_{1.6}$ is to be packed into a metal-type convenience can (Sect. 6.2.1). The use of three loaded convenience cans in the ES-3100 is assumed in the criticality calculation models for ground transport. However, credit is only taken for vertical spacing provided by canned spacers when present. For configurations where canned spacers are not used, the TRIGA content is assumed stacked end-to-end. The three cylinders of the active fuel are modeled in triangular-pitch configuration within the radial boundary of the convenience can(s). The pitch used in the criticality calculation models for the NCT and HAC ground transport is 4.9809 cm (1.96 in.).

As shown in Table 6.9.6-19b, a set of parametric cases were run where the triangular pitch for the fuel content is varied from 1.44 in. (fuel sections touching) to 2.413 in. (fuel sections at maximum separation and touching the inner boundary of the convenience can). As shown in Fig. 6.17, the calculated k_{eff} + 2σ values increase slightly from 0.48 to an asymptotic value of ~ 0.53 at a pitch of 2.121 in. or a foci of 3.1106 cm (Table 6.9.6-19b). The foci of 2.8757 cm. for the TRIGA fuel sections used in the criticality calculation models, corresponds to a 1.96-in. pitch. The calculated k_{eff} + 2σ value is 0.527 for Case **cvcrtriga_1_15** (Table 6.9.6-19a) indicating that the configuration is in the range of optimum moderation. Moreover, the calculated k_{eff} + 2σ value is substantially below the USL. The foci is the distance perpendicular from the CV's vertical axis to the center of each fuel section. The value is obtained from the computer input listing on the comment line for geometry unit 1006 which reads: " -2.875700 minus-y location lower cylinder."

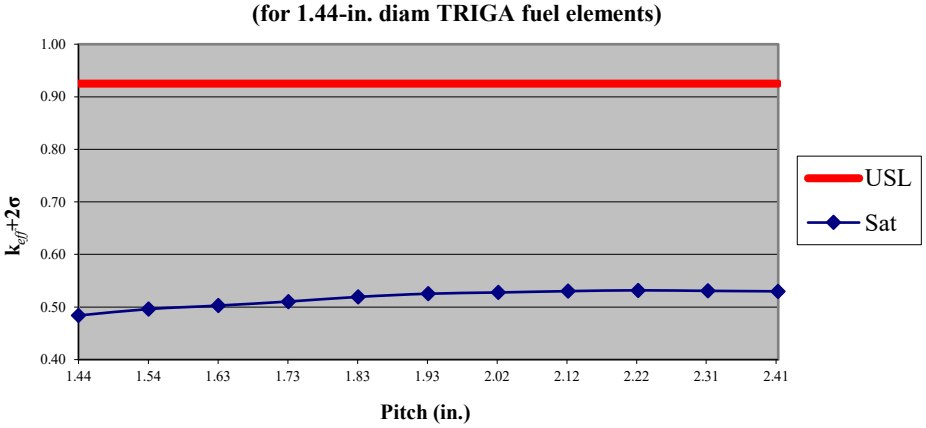


Fig. 6.17. k_{eff} + 2σ versus pitch for triangular arrangement of content in the containment vessel.

Parametric cases were also run as a function of the moisture fraction ("mocfr") in the CV. As shown in Fig. 6.18, the k_{eff} + 2σ values decrease with decreasing water content in the CV; and content spacing has less of an effect on k_{eff} at lower at the lower fractions.

The first of the three physical parameters which characterize the TRIGA fuel is enrichment. Table 6.9.6-19a presents results for 20 % enriched and 70 % enriched TRIGA fuel where the diameter of the active fuel is 1.44 in. The calculated k_{eff} + 2σ values for TRIGA fuel content at the lower enrichment is greater than for the fuel with the higher enrichment due to the greater quantity of fissile isotope present. The 20% enriched TRIGA fuel is considered the bounding content.

The second physical parameter which characterizes the TRIGA fuel is the uranium weight fraction. For a TRIGA fuel enriched to 20 wt % ^{235}U in U, the uranium weight fractions for the $UZrH_{1.6}$ fuel are: 45 wt %; 30 wt %; 20 wt %; 12 wt %; and 8.5 wt % U. A set of parametric cases were run where the uranium weight fraction is varied from the minimum value of 8.5 wt % to the maximum value of 45 wt %. Additionally, moderation in the CV is varied from the dry to the flooded condition. As shown in Fig. 6.19, the k_{eff} + 2σ values decrease with both decreasing uranium weight fraction and decreasing water content in the CV. Details are provided in Table 6.9.6-19c.

Third physical parameter which characterizes the TRIGA fuel is active fuel diameter. The active fuel diameters are: 1.44 in.; 1.41 in.; 1.40 in.; 1.37 in.; 1.34in.; and 1.31 in. The smaller the diameter, the less the amount of ^{235}U is present resulting in lower k_{eff} + 2σ values, as demonstrated later in this section.

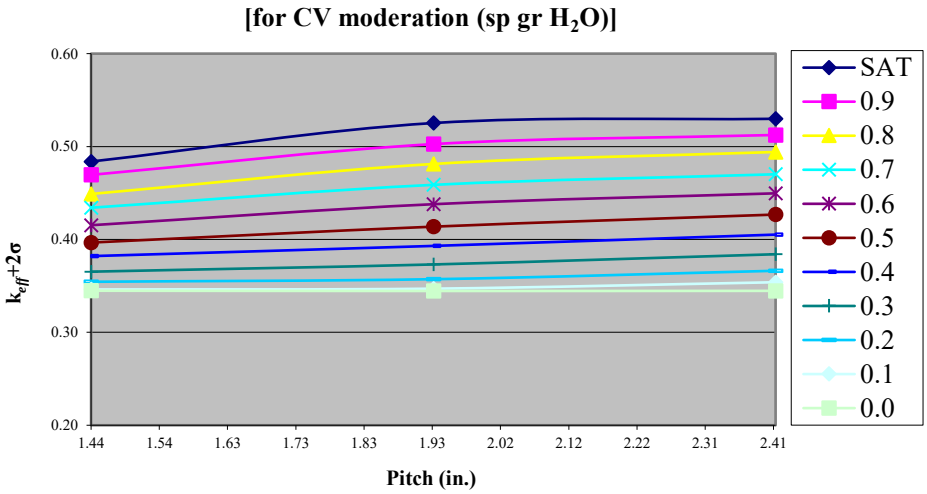


Fig. 6.18. k_{eff} + 2σ versus triangular pitch over range of containment vessel moderation.

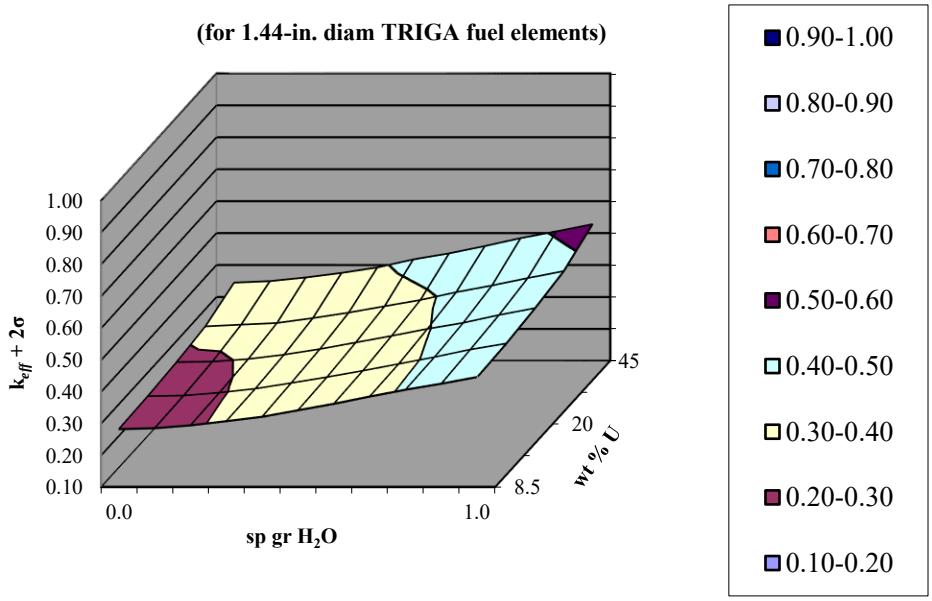


Fig. 6.19. k_{eff} + 2σ as a function of uranium weight fraction and moderation.

Cases **cvcrtriga_1_1** through **cvcrtriga_1_15** (Appendix 6.9.6, Table 6.9.6-19a) represent the TRIGA fuel content in a flooded CV, reflected by 30.48 cm of water. The flooded CV under full water reflection is a more reactive configuration than the CV inside of flooded ES-3100 packaging, Case **ncsrtriga_1_15_15** (Appendix 6.9.6, Table 6.9.6-20a). Further examination of the results in Table 6.9.6-20a indicates the content loading is adequately subcritical loading and that 277-4 canned spacers are not required for criticality control. Comparison of results for the NCT Case **ncsrtriga_1_15_15** and the HAC **hcsrtriga_1_15_15**, both with $k_{eff} + 2\sigma = 0.495$, reveal that changes to the packaging external to the CV due to the HAC do not result in an appreciable change in the neutron multiplication factor for the single package.

Additional CV cases were performed to exam the effect that 500 g of polyethylene will have on TRIGA fuel evaluations. The original cases previously found in Table 6.1f were rerun using SCALE 6.1.3, with updated cross-sections and more particles. These cases were also modified by adding 500 g of polyethylene. The results of these cases are found in Table 6.8.

Table 6.8. Reflected CV model, TRIGA fuel, with and without 500 g polyethylene, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff} + 2\sigma$
cvcrtriga_1_15	Three 5 in.-tall TRIGA fuel elements per can, no spacers or polyethylene	0.52737	0.00065	0.52867
cvcrtrigap_1_15	Three 5 in.-tall TRIGA fuel elements per can, no spacers, 500 g polyethylene	0.53581	0.00064	0.53709
cvcrtriga_70_1_15	Three 5 in.-tall TRIGA fuel elements per can, no spacers or polyethylene, 70% enriched	0.49000	0.00065	0.49130
cvcrtrigap_70_1_15	Three 5 in.-tall TRIGA fuel elements per can, no spacers, 500 g polyethylene, 70% enriched	0.49726	0.00065	0.49856

From the results of the CV cases for TRIGA fuel, modeling 500 g of polyethylene surrounding the HEU metal are more reactive than no polyethylene.

Cases **ncsrtriga70_1_1_1** through **ncsrtriga70_1_15_15** (Appendix 6.9.6, Table 6.9.6-20b) represent the 70 % enriched TRIGA fuel content in a flooded ES-3100 package, reflected by 30.48 cm of water. Comparison of results for these cases with results for the 20 % enriched TRIGA fuel (Cases **ncsrtriga_1_1_1** through **ncsrtriga_1_15_15**) confirm that the 20 % enriched TRIGA fuel is the bounding content.

Cases **ncsrT70_131_1_1_15** through **ncsrT70_131_1_15_15** (Appendix 6.9.6, Table 6.9.6-20c) represent the 1.31-in.-diam TRIGA fuel content in a flooded ES-3100 package, reflected by 30.48 cm of water. Comparison of results for these cases with results for the larger 1.44-in.-diam TRIGA fuel content (Cases **ncsrtriga70_1_1_1** through ncsrtriga70_1_15_15) confirm that the 1.44-in.-diam TRIGA fuel is the bounding content.

Additional cases were performed to exam the effect that 500 g of polyethylene will have on TRIGA fuel for single packages. The original cases previously found in Table 6.1f were rerun using SCALE 6.1.3, with updated cross-sections and more particles. These cases were also modified by adding 500 g of polyethylene. The results of these cases are found in Tables 6.9 and 6.10.

Table 6.9. Reflected NCT single package model, TRIGA fuel, with and without 500 g polyethylene, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff} + 2\sigma$
ncsrtriga_1_15_15	Three 5 in.-tall TRIGA fuel elements per can, no spacers or polyethylene	0.49330	0.00061	0.49452
ncsrtrigap_1_15_15	Three 5 in.-tall TRIGA fuel elements per can, no spacers, 500 g polyethylene	0.50474	0.00057	0.50588
ncsrtriga_70_1_15_15	Three 5 in.-tall TRIGA fuel elements per can, no spacers or polyethylene, 70% enriched	0.45779	0.00068	0.45915
ncsrtrigap_70_1_15_15	Three 5 in.-tall TRIGA fuel elements per can, no spacers, 500 g polyethylene, 70% enriched	0.46768	0.00061	0.46890

Table 6.10. Reflected HAC single package model, TRIGA fuel, with and without 500 g polyethylene, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff} + 2\sigma$
hcsrtriga_1_15_15	Three 5 in.-tall TRIGA fuel element per can, no spacers or polyethylene	0.49431	0.00063	0.49557
hcsrtrigap_1_15_15	Three 5 in.-tall TRIGA fuel element per can, no spacers, 500 g polyethylene	0.50541	0.00074	0.50689
hcsrtriga_70_1_15_15	Three 5 in.-tall TRIGA fuel element per can, no spacers or polyethylene, 70% enriched	0.45831	0.00059	0.45949
hcsrtrigap_70_1_15_15	Three 5 in.-tall TRIGA fuel element per can, no spacers, 500 g polyethylene, 70% enriched	0.46890	0.00060	0.47010

From the results of the single package cases for TRIGA fuel, modeling 500 g of polyethylene surrounding the HEU metal are more reactive than no polyethylene.

10 CFR 71.55(d)(2) requires the geometric form of a package's content not be substantially altered under the NCT. Also, 10 CFR 7155(e)(1) requires that the package be adequately subcritical under HAC with the package contents in the most reactive credible configuration. However, conclusions about damage to the fuel content cannot be extrapolated from test data because a mock (test weight) content rather than actual TRIGA content is evaluated in the NCT and HAC tests of 10 CFR 71.71 and 10 CFR 71.73. Consequently, one way for addressing these requirements is to model the content in an extremely damaged condition and make a determination of subcriticality through a series of criticality calculations. Cases **ncsrt55d2_ 1_1_1**5 through **ncsrt55d2_1_15_15** (Appendix 6.9.6, Table 6.9.6-20d) represent TRIGA fuel content homogenized with variable density water over the free volume of the CV, where the ES-3100 packaging is flooded and reflected by 30.48 cm of water. The variable density water ranges from the dry containment condition to the fully flooded condition. Credit for physical integrity of the content is not taken in this set of cases which model the substantially altered content. The calculation results in Table 6.9.6-20d indicate extremely damaged content (Case **ncsrt55d2_1_15_15** with $k_{eff} + 2\sigma = 0.611$) is more reactive than the unaltered configuration (Case **ncsrtriga_1_15_15** with $k_{eff} + 2\sigma = 0.403$). Nevertheless, both cases are adequately below the USL of 0.925 and the requirement of 10 CFR 71.55(d)(2) is satisfied. Given that changes external to the CV due to the HAC do not result in an appreciable change in the neutron multiplication for the single package, similar results are expected for the cases demonstrating compliance with 10 CFR 7155(e)(1).

The shipping configuration for disassembled TRIGA fuel addressed in this subsection is not the only permissible shipping configuration for TRIGA fuel in the ES-3100. TRIGA fuel may also be configured as clad fuel rods (Appendix 6.9.3.1). Each 15-in.-long rod is derived from a single TRIGA fuel element. The clad fuel rod consists of the 3 fuel pellets and the exterior sheath of stainless steel or aluminum clad. Clad fuel rods are packed into stainless steel or tin-plated carbon steel convenience cans with a maximum of three fuel rods per loaded convenience can. This shipping configuration requires that only one convenience can is loaded with clad fuel rods.

Except for a 0.02-in.-thick sheath of stainless steel clad added to the exterior surface of the $UZrH_{1.6}$, a calculation model for the clad fuel rod configuration is essentially the same as the NCT shipping configuration model for disassembled TRIGA fuel. A 0.02-in. thickness of stainless steel is insignificant for an external reflection. As illustrated in Fig. 6.24 (Sect. 6.7.2), stainless steel up to several cm in thickness acts as a neutron absorber. Several inches in thickness are required for neutron multiplication to increase from neutron reflection by the stainless steel. The NCT shipping configuration model for disassembled TRIGA fuel is bounding. The same applies for TRIGA fuel with aluminum clad.

A clad fuel rod with 1.44-in.-diam fuel pellets contains 2,282.4-g $UZrH_x$ (Appendix 6.9.3.1) and ~179 to 191 g of stainless steel. Stainless steel tends to act as a neutron absorber; moreover, its presence as clad in the TRIGA fuel content replaces water moderator otherwise present in the geometry configuration of TRIGA fuel meats. When stainless steel is homogenized with the $UZrH_{1.6}$ as in the calculation model for package content in the extremely damaged condition [10 CFR 71.55(d)(2) and 10 CFR 7155(e)(1)], the stainless steel acts more effectively as a neutron absorber. However, the amount of stainless steel added and water displaced is not expected to have a statistically significant affect on neutron multiplication. Thus, the HAC shipping configuration model for disassembled TRIGA fuel (bare fuel meats) is bounding.

A clad fuel rod with 1.41-in.-diam fuel pellets contains ~2,188-g $UZrH_x$ and ~90 to 96 g of aluminum. While aluminum tends to act as a neutron scatter, its presence in the TRIGA fuel content replaces water moderator otherwise present in the geometry configuration of TRIGA fuel meats. The amount of aluminum added and water displaced is not sufficient to have a statistically significant affect on neutron multiplication. Thus, the HAC shipping configuration model for disassembled TRIGA fuel is also bounding for aluminum clad TRIGA fuel content.

The TRIGA content is to be transported by air; consequently, additional discussion is included in Sect. 6.7.

The 1.5-in.–diam × 2-in.–tall slugs may be packed up to ten items per press-fit lid type convenience can and up to twelve items per crimp-lid type convenience can. With nominal dimensions, each slug weighs ~1,090 g. With +1/16-in. tolerance on both the diameter and height, each slug in the calculation model weighs ~1218 g. As described in Appendix 6.9.1, different arrangements of slugs in the convenience cans are possible. A configuration of slugs in a flooded reflected CV must be shown to be adequately subcritical and so limited either by the use of 277-4 canned spacers, by limitation of fissile mass, or by both.

Several slug arrangements depicted in Fig. 6.9.1-4b are evaluated for demonstrating that the most conservative arrangement of slugs is being analyzed. The blue marker shown in Fig. 6.9.1-4c depicts the 4.13-in. diam of the canned spacer. Content within a configuration radius of 2.125 in. (5.4 cm) are within the boundary of the convenience can wall. The convenience cans are not modeled and contents are allowed to project beyond the convenience can wall boundary. The slugs are modeled only as 100 wt % ^{235}U for this portion of the criticality evaluation. Cases **cvcr5st11_1_1**, **cvcr5est11_1_1**, **cvcr50st11_1**, **cvcr5e0st11_1**, **cvcr5u0st11_1**, and **cvcr5l0st11_1** depict very different spacing arrangements with five slugs per convenience can, three cans per package. The statistical difference in the calculated "$k_{eff} + 2\sigma$" values is

insignificant. Cases **cvcr6e0st11_1** and **cvcr6st11_1_1** depict arrangements with six slugs per convenience can, and Case **cvcr70st11_1** depicts seven slugs per convenience can. (Considerable deformation of the 4.25-in.–diam convenience can wall is required to achieve all but the simple pentagonal-ring arrangement of slugs.) Calculation results reveal the primary dependence of the "$k_{eff} + 2\sigma$" value is on the fissile mass loading and the secondary dependence is on the arrangement and spacing of slugs. The calculation results presented in Table 6.9.6-8 (Appendix 6.9.6) for a flooded CV indicate that only five slugs per convenience can (18,277-g ^{235}U per package) may be loaded without the use of 277-4 canned spacers (Cases **cvcr5st11_1_1** and **cvcr5est11_1_1**). Further evaluation of the single package and array configurations are required. Also, results highlighted in red indicate that 277-4 canned spacers are required for the slug content.

The sensitivity of k_{eff} to the space between slugs arranged in a pentagonal ring is evident in the calculation results for Cases **cvcr5st11_1_2** and **cvcr5est11_1_2,** which model content for three convenience cans, each location with two pentagonal rings (10 slugs) per can. These two configurations represent degrees of separation between adjacent neighbors in the pentagonal rings of 0.0 cm and 1.0 cm, respectively. The most reactive configuration occurs when the slugs are spaced 1.0 cm apart from direct contact with adjacent neighbors in the pentagonal rings. Because positioning devices are not used in the convenience cans to control spacing and prevent an optimal arrangement of contents from occurring, both calculation models for slug arrangement are the basis for additional calculations where 277-4 canned spacers may not be required.

Cases **cvcr5st11_2_1**, **cvcr5est11_2_1**, **cvcr50st11_2**, **cvcr5e0st11_2**, **cvcr5u0st11_2**, and **cvcr5l0st11_2** represent the different spacing arrangements with five slugs per convenience can, three cans per package, and cans separated by canned spacers. Likewise, Cases **cvcr6e0st11_2** and **cvcr6st11_2_1** represent arrangements with six slugs per convenience can, three can per package, and cans separated by can spacers. Case **cvcr70st11_2** represents seven slugs per convenience can. While the differences in the calculated "$k_{eff} + 2\sigma$" values for equal numbers of slugs per can are ≤ 0.006, the "$k_{eff} + 2\sigma$" values are significantly below the USL. Again, the calculation results presented in Table 6.9.6-8 (Appendix 6.9.6) for these cases reveal the primary dependence of the "$k_{eff} + 2\sigma$" value is on fissile mass loading, and the secondary dependence is on the arrangement and spacing of slugs.

Additional CV cases were performed to exam the effect that 500 g of polyethylene will have on HEU metal slugs. The original cases previously found in Table 6.1b were rerun using SCALE 6.1.3, with updated cross-sections and more particles. These cases were also modified by adding 500 g of polyethylene. The results of these cases are found in Table 6.11.

Table 6.11. Reflected CV model, HEU metal slugs, with and without 500 g polyethylene, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff} + 2\sigma$
cvcr5st11_1_1	18.277 kg ^{235}U, 5 slugs per can, d=1.5625 in., h=2.0624 in., no spacers or polyethylene	0.91514	0.0006	0.91634
cvcr5st11p_1_1	18.277 kg ^{235}U, 5 slugs per can, d=1.5625 in., h=2.0624 in., no spacers, 500 g polyethylene	0.92015	0.00073	0.92161
cvcr5st11_2_2	36.555 kg ^{235}U, 10 slugs per can, d=1.5625 in., h=2.0624 in., no spacers or polyethylene	0.90561	0.00061	0.90683
cvcr5st11p_2_2	36.555 kg ^{235}U, 10 slugs per can, d=1.5625 in., h=2.0624 in., no spacers, 500 g polyethylene	0.90566	0.0007	0.90706

From the result of the CV cases for HEU metal slugs, modeling 500 g of polyethylene surrounding the HEU metal are as or slightly more reactive than no polyethylene.

Case **cvcr6e0st11_2** models three sets of slugs, six slugs in a pentagonal ring with one slug in the center, and each set of slugs separated by a 277-4 canned spacer. Cases **cv0r6e0st11_2** and **cvwr6e0st11_2** are variations of the reference case where the 1.4-in. spacer is replaced with void in the first case and is replaced with water in the second case. Comparison of the "$k_{eff} + 2\sigma$" values between Cases **cvcr6e0st11_2** and **cv0r6e0st11_2** reveals that the spacers reduce k_{eff} by ~ 0.03. Comparison of the "$k_{eff} + 2\sigma$" values for Cases **cvcr6e0st11_2** and **cvwr6e0st11_2** reveals that axial spacing of the content provided by the content cans inside the CV serves to reduce k_{eff}.

The calculation results presented in Table 6.9.1-8 for a flooded CV indicate that up to ten slugs per convenience can (36,555-g ^{235}U per package) *might* be loaded when 277-4 canned spacers are used. Conceivable arrangements are considered in Cases **cvcr5st11_2_2**, **cvcr5est11_2_2**, **cvcr6e4st11_2**, and **cvcr73st11_2** (Table 6.9.6-8). Suitability is contingent on the results of single package and array calculations.

Cases **ncsr5est11_2_1_1** through **ncsr5est11_2_1_15** (Appendix 6.9.6, Table 6.9.6-9) model a reflected package with one pentagonal ring of slugs per content location with 277-4 canned spacers between content locations and HEU content at 100 wt % ^{235}U. The $k_{eff} + 2\sigma$ values range from a low value of 0.688 to 0.736. These results show that the most reactive configuration is the flooded condition with MOIFR=1.0.

As shown by the cylindrical content calculation models, the ES-3100 package is not as an efficient reflector as full water reflection provided to the flooded CV. This is also true for content loadings of one pentagonal ring of slugs per content location without 277-4 canned spacers between locations and HEU content at 100 wt % ^{235}U. For Cases **cvcr5est11_1_1** and **ncsr5est11_1_1_15**, the $k_{eff} + 2\sigma$ values are 0.910 and 0.871, respectively. Likewise, the $k_{eff} + 2\sigma$ values are 0.901 and 0.867 for content loadings of two pentagonal rings of slugs per content location with 277-4 canned spacers between locations, Cases **cvcr5est11_2_2** and **ncsr5est11_2_2_15**, respectively.

For the flooded CV under full water reflection and loaded with the slugs in a pentagonal arrangement and 277-4 canned spacers between content locations, the $k_{eff} + 2\sigma$ value is 0.903, Case **cvcr5st11_2_2** [10 CFR 71.55(b)]. This value is below the USL value of 0.925. For packages with the required 1.4-in. spacers, the calculated $k_{eff} + 2\sigma$ value is 0.878 for the water-reflected package, Case **ncsr5st11_2_2_15** [10 CFR 71.55(d)]. Case **hcsr5st11_02_2_15** represents the HAC model of the damaged ES-3100 package, where the outer dimensions of the package are reduced accordingly and the entire package is flooded except the neutron poison of the body weldment liner inner cavity. This single-unit case with a MOIFR = 1.0 pertains specifically to the flooded drum under conditions specified in 10 CFR 71.55(e). The $k_{eff} + 2\sigma$ value is 0.872 for this HAC. The changes in both the outer dimensions of the package and the compositions of the Kaolite and 277-4 due to HAC result in an ~0.001 change in the neutron multiplication factor.

Additional cases were performed to exam the effect that 500 g of polyethylene will have on HEU metal slugs for a single package. The original cases previously found in Table 6.1b were rerun using SCALE 6.1.3, with updated cross-sections and more particles. These cases were also modified by adding 500 g of polyethylene. The results of these cases are found in Tables 6.12 and 6.13.

Table 6.12. Reflected NCT single package, HEU metal slugs, with and without 500 g polyethylene, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff} + 2\sigma$
ncsr5st11_1_1_15	18.277 kg ^{235}U, 5 slugs per can, d=1.5625 in., h=2.0624 in., no spacers or polyethylene	0.87487	0.00068	0.87623
ncsr5st11p_1_1_15	18.277 kg ^{235}U, 5 slugs per can, d=1.5625 in., h=2.0624 in., no spacers, 500 g polyethylene	0.88341	0.00067	0.88475
ncsr5st11_2_2_15	36.555 kg ^{235}U, 10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers or polyethylene	0.87962	0.00065	0.88092
ncsr5st11p_2_2_15	36.555 kg ^{235}U, 10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers, 500 g polyethylene	0.87589	0.00064	0.87717

Table 6.13. Reflected HAC single package, HEU metal slugs, with and without 500 g polyethylene, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff} + 2\sigma$
hcsr5st12_1_1_15	18.277 kg ^{235}U, 5 slugs per can, d=1.5625 in., h=2.0624 in., no spacers or polyethylene	0.88673	0.00061	0.88795
hcsr5st12p_1_1_15	18.277 kg ^{235}U, 5 slugs per can, d=1.5625 in., h=2.0624 in., no spacers, 500 g polyethylene	0.87734	0.00064	0.87862
hcsr5st12_2_2_15	36.555 kg ^{235}U, 10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers or polyethylene	0.88067	0.00064	0.88195
hcsr5st12p_2_2_15	36.555 kg ^{235}U, 10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers, 500 g polyethylene	0.87734	0.00064	0.87862

From the results of the single package cases for HEU metal slugs, modeling 500 g of polyethylene surrounding the HEU metal are as or slightly more reactive than no polyethylene.

6.4.2 HEU Broken Metal; Solid HEU Metal with Unspecified Geometric Shape and Characterized as Broken Metal; or Turnings, Fines, or Powder

Broken metal pieces are distinguished from turnings, fines, or powder as having a surface-area-to-mass ratio of not greater than 1 cm^2/g or must not pass through a 3/8-in. mesh sieve (or equivalent size-grading method). In the CV calculations, broken metal is evaluated using the "lha" content model (Fig. 6.9.1-5c). The "lha" approximation model is derived from the "sqa" model (Figs. 6.9.1-5b) where HEU metal is homogenized with the water inside the rectangular lattice formed by an array of discretely modeled items of uniform size and shape (Appendix 6.9.1). The overall volume (and shape) of the content "envelope" containing the HEU and the amount of interstitial moderator between the actual pieces of HEU is preserved in the "lha" content model. This representation of discrete solid HEU broken metal in the CV calculation model as fissile material homogenized with moderator is bounding (Table 6.9.3.1-2). In the CV calculations, turnings, fines, and powder are evaluated using the "cha" content model (Fig. 6.9.1-5d) where HEU metal and the water inside a flooded CV are homogenized as a uranium "solution" and dispersed over the internal volume of the CV.

Credit for the presence of convenience cans is not taken in either the "lha" or the "cha" model. Content spacing provided by the convenience cans is absent in the models such that the canned spacer, if present, is located above the rectangular lattice (content envelop) between the convenience can locations

(Fig. 6.9.1-5c). Credit for the presence of canned spacers is taken for broken metal but not for fines, turnings, and powder where the fissile material form is not conducive to maintaining spacer separation nor prevent gravitation of the canned spacers to the bottom of the CV. For conservatism, the "cha" model was used to represent HEU metal content in the single package calculations.

Like packages with solid HEU metal shapes, the neutron multiplication factor for reflected single packages with HEU broken metal, turnings, fines, or powder increases as a function of the ^{235}U mass and the MOIFR. For example, consider the ES-3100 package loaded with three convenience cans for a total of 35,142-g ^{235}U. The $k_{eff} + 2\sigma$ values range from 0.814 to 0.891 with increasing MOIFR in the water-reflected package [Cases **ncsrbmt11_36_1_1** through **ncsrbmt11_36_1_15** (Appendix 6.9.6, Table 6.9.6-11)]. The addition of water to the package reduces the NLF, thereby increasing k_{eff}.

For the CV loaded with the broken metal content (excluding turnings, fines, or powder) and without 277-4 canned spacers between content locations, the $k_{eff} + 2\sigma$ values increase from 0.751 to 0.949 as the water content in the CV increases [Cases **cvr3lha_36_1_8_1** through **cvr3lha_36_1_8_15** (Appendix 6.9.6, Table 6.9.6-10)]. Cases **cvr3lha_36_1_8_15** through **cvr3lha_36_1_1_15** model the flooded CV with 35 kg of broken HEU metal where the enrichment ranges from 100 to 19 wt % ^{235}U. The $k_{eff} + 2\sigma$ values decrease from 0.949 to 0.657. The $k_{eff} + 2\sigma = 0.949$ for Case **cvr3lha_36_1_8_15** indicates that the 35,142-g ^{235}U mass loading at 100% enrichment with canned spacers absent must be reduced below 35,142-g ^{235}U for establishing a loading limit over the range of 95 to 100 wt % ^{235}U. The result for Case **cvr3lha_26_1_8_15** indicates that for an enrichment of 100 wt % ^{235}U, the mass loading over the range $95 < \text{enr.} \leq 100$ wt % ^{235}U cannot exceed 25,894-g ^{235}U in the absence of canned spacers. (The orange highlighted cases in Table 6.9.6-10 indicate potential fissile loading limits, or evaluation limits.)

The result for Case **cvr3lha_29_1_7_15** indicates that for an enrichment of 95 wt % ^{235}U, the mass loading limit conservatively applied over the range $90 < \text{enr.} \leq 95$ wt % ^{235}U cannot exceed 27,252-g ^{235}U in the absence of canned spacers. Application of this 27,252-g ^{235}U limit to higher enrichment material is non-conservative, as illustrated by the result for Case **cvr3lha_28_1_8_15** where $k_{eff} + 2\sigma = 0.933$ for 100 wt % ^{235}U. As the enrichment increases, the mass loading limit must decrease from 27,252-g to 25,894-g^{235}U in this example due to less ^{238}U present for neutron absorption. Potential fissile loading limits for the reduced enrichment ranges are derived in a similar manner. For enrichments ≤ 60 wt % ^{235}U, the CV is load-limited to 35,320-g U. As enrichment drops from 60 to 19 wt % ^{235}U, the $k_{eff} + 2\sigma$ values decrease from 0.829 to 0.657. The ^{235}U (or U) evaluation limits conservatively applied over the indicated ranges of enrichment are listed in the column headings of Table 6.1c. These evaluation limits represent the maximum amount of ^{235}U (or U) permissible in a flooded, reflected CV for maintaining an adequate margin of subcriticality.

For the CV loaded with the HEU metal content in the form of turnings, fines, or powder and without 277-4 canned spacers between content locations, the $k_{eff} + 2\sigma$ values increase from 0.613 to 0.983 as the water content in the CV increases [Cases **cvr3cha_36_1_8_1** through **cvr3cha_36_1_8_15** (Appendix 6.9.6, Table 6.9.6-10)]. Cases **cvr3cha_36_1_8_15** through **cvr3cha_36_1_1_15** model the flooded CV with 35.32 kg of HEU metal turnings, fines, or powder having an enrichment ranging from 100 to 19 wt % ^{235}U. The $k_{eff} + 2\sigma$ values decrease from 0.983 to 0.791. The $k_{eff} + 2\sigma = 0.983$ for Case **cvr3cha_36_1_8_15** indicates that the 35,142-g ^{235}U mass loading at 100% enrichment without canned spacers must be reduced in order to be considered as a loading limit over the range of 95 to 100 wt % ^{235}U. The result for Case **cvr3cha_8_1_8_15** indicates that for an enrichment of 100 wt % ^{235}U, the mass loading conservatively applied over the range $95 < \text{enr.} \leq 100$ wt % ^{235}U cannot exceed 7,398-g ^{235}U in the absence of canned spacers.

The result for Case **cvr3cha_12_1_7_15** indicates that for an enrichment of 95 wt % ^{235}U, the mass loading conservatively applied over the range $90 < \text{enr.} \leq 95$ wt % ^{235}U cannot exceed 10,549-g ^{235}U

in the absence of canned spacers. Similarly, the application of this 10,549-g ^{235}U limit for HEU metal turnings, fines, or powder in the range 90 < enr. ≤ 95 wt % ^{235}U to higher enrichment material in the range 95 < enr. ≤ 100 wt % ^{235}U is non-conservative. As the enrichment increases, the mass loading limit must decrease from 10,549-g to 7,398-g ^{235}U in this example due to less ^{238}U present for neutron absorption. The result for Case **cvr3cha_16_1_6_15** indicates that for an enrichment of 90 wt % ^{235}U, the mass loading conservatively applied over the range 80 < enr. ≤ 90 wt % ^{235}U cannot exceed 14,167-g ^{235}U in the absence of canned spacers. The result for Case **cvr3cha_25_1_5_15** indicates that for an enrichment of 80 wt % ^{235}U, the mass loading conservatively applied over the range 70 < enr. ≤ 80 wt % ^{235}U cannot exceed 19,284-g ^{235}U in the absence of canned spacers. The result for Case **cvr3cha_36_1_4_15** indicates that for an enrichment of 70 wt % ^{235}U, the mass loading conservatively applied over the range 60 < enr. ≤ 70 wt % ^{235}U cannot exceed 24,693-g ^{235}U in the absence of canned spacers. The result for Case **cvr3cha_36_1_3_15** indicates that for an enrichment of 60 wt % ^{235}U, the mass loading conservatively applied over the range 40 < enr. ≤ 60 wt % ^{235}U cannot exceed 21,192-g ^{235}U in the absence of canned spacers. As enrichment drops from 60 to 19 wt % ^{235}U, the $k_{eff} + 2\sigma$ values decrease from 0.900 to 0.791. However, the CV is load-limited to 35,320-g U; therefore, the maximum permissible loadings shown for Cases **cvr3cha_36_1_2_15** and **cvr3cha_36_1_1_15** are not achievable. For this reason, the uranium mass rather the fissile isotope mass (g ^{235}U) is indicated as the potential mass loading limit for ≤ 60 wt % ^{235}U. The ^{235}U (or U) evaluation limits conservatively applied over the indicated ranges of enrichment are listed in the column headings of Tables 6.1d. These evaluation limits represent the maximum amount of ^{235}U (or U) in the form of HEU metal turnings, fines, or powder permissible in a flooded, reflected CV for maintaining an adequate margin of subcriticality.

Additional calculations were performed modeling 500 g of polyethylene for both HEU broken metal (**cvr3lha_*** cases) and HEU metal turning, fines, or powder (**cvr3cha_*** cases). These calculations were performed using an updated version of the SCALE code as discussed in Sect. 6.3.3 and using a validation with a higher USL. The models used in these calculations also evaluated the amount of uranium in smaller increments (100 g) instead of the higher increments used in the previous calculations. This resulted in higher uranium mass limits calculated in some of the array calculations, with lower uranium mass limits in some of the more recent calculations. Enrichments from 60% up to 100% were evaluated for both HEU broken metal and HEU metal turning, fines, or powder. The range of water inside the CV was not evaluated since it is already shown in the non-polyethylene cases that a flooded CV is most reactive. The results of these calculations can be found in Table 6.9.6-10a. The most reactive results that are below the USL were rerun to examine the effect of adding thorium metal. The results of these calculations are found in Table 6.9.6-10b.

For the CV loaded with broken metal content (excluding turnings, fines, or powder) with 500 g of polyethylene, the result for Case **cvr3lhap_9_1_6_15** indicates that for an enrichment of 100%, the mass loading limit cannot exceed 22.4 kg uranium (22.4 kg ^{235}U) in the absence of canned spacers. The result for Case **cvr3lhpa_18_1_5_15** indicates that for an enrichment of 95%, the mass loading limit cannot exceed 24.6 kg uranium (23.37 kg ^{235}U) in the absence of canned spacers. The result for Case **cvr3lhap_28_1_4_15** indicates that for an enrichment of 90%, the mass loading limit cannot exceed 31.1 kg uranium (27.99 kg ^{235}U) in the absence of canned spacers. The result for Case **cvr3lhap_34_1_3_15** indicates that for an enrichment of 80% and lower, the mass loading limit cannot exceed 36 kg uranium in the absence of canned spacers. As the enrichment increases, the mass loading limit must decrease. The ^{235}U (or U) evaluation limits conservatively applied over the indicated ranges of enrichment are listed in the column headings of Table 6.1c. These evaluation limits represent the maximum amount of ^{235}U (or U) permissible in a flooded, reflected CV for maintaining an adequate margin of subcriticality.

For the CV loaded with the turnings, fines, or powder content with 500 g of polyethylene, the result for Case **cvr3chap_5_1_6_15** indicates that for an enrichment of 100%, the mass loading limit cannot exceed 10.5 kg uranium (10.5 kg ^{235}U) in the absence of canned spacers. The result for Case

cvr3chap_14_1_5_15 indicates that for an enrichment of 95%, the mass loading limit cannot exceed 16.1 kg uranium (15.295 kg ^{235}U) in the absence of canned spacers. The result for Case **cvr3chap_23_1_4_15** indicates that for an enrichment of 90%, the mass loading limit cannot exceed 22.0 kg uranium (19.80 kg ^{235}U) in the absence of canned spacers. The result for Case **cvr3chap_34_1_3_15** indicates that for an enrichment of 80%, the mass loading limit cannot exceed 33.0 kg uranium (26.40 kg ^{235}U) in the absence of canned spacers. The result for Case **cvr3chap_38_1_2_15** indicates that for an enrichment of 70% and lower, the mass loading limit cannot exceed 36 kg uranium in the absence of canned spacers. As the enrichment increases, the mass loading limit must decrease. The ^{235}U (or U) evaluation limits conservatively applied over the indicated ranges of enrichment are listed in the column headings of Table 6.1c. These evaluation limits represent the maximum amount of ^{235}U (or U) permissible in a flooded, reflected CV for maintaining an adequate margin of subcriticality. Comparative calculations were performed to exam the effect of thorium metal mixed with HEU broken metal, turnings, fines, and powders. Up to 5 kg of thorium metal was evaluated with the mass loading limit model. The results of these calculations (Table 6.9.6-10b) show that reactivity decreases as thorium metal is added to HEU.

The most reactive credible configuration consistent with the chemical and physical form of the material consists of the CV under full water reflection but with 277-4 canned spacers absent between content locations. For the flooded CV loaded with the HEU broken metal content at 100% enrichment (excluding turnings, fines, or powder), the $k_{eff} + 2\sigma = 0.918$ in Case **cvr3lha_26_1_8_15,** and for HEU broken metal content with 500 g of polyethylene at 100% enrichment, the $k_{eff} + 2\sigma = 0.934$ in Case **cvr3lhap_9_1_6_15** [Table 6.1c, 10 CFR 71.55(b)]. For the flooded CV loaded with HEU metal turnings, fines, or powder (excluding unspecified geometric shape and characterized as broken metal, or broken metal), the $k_{eff} + 2\sigma = 0.923$ in Case **cvr3cha_8_1_8_15**, and for HEU broken turnings, fines, or powders with 500 g polyethylene the $k_{eff} + 2\sigma = 0.934$ in Case **cvr3chap_5_1_6_15** [Table 6.1d, 10 CFR 71.55(b)].

For single packages loaded with HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder), the calculated $k_{eff} + 2\sigma$ value for Case **ncsrbmt11_36_1_15** is 0.891 and for HEU broken metal content with 500 g of polyethylene, the $k_{eff} + 2\sigma = 0.892$ in Case **ncsrbmt11p_8_6_15** [Tables 6.1c and 6.1d, 10 CFR 71.55(d)]. Case **hcsrbmt12_36_1_15** (Appendix 6.9.6, Table 6.9.6-11) represents the HAC model of the damaged ES-3100 package, where the outer dimensions of the package are reduced accordingly and the entire package is flooded except the neutron poison of the body weldment liner inner cavity. This single-unit case with a MOIFR = 1.0 pertains specifically to the flooded drum under conditions specified in 10 CFR 71.55(e) (Tables 6.1c and 6.1d). The $k_{eff} + 2\sigma = 0.891$ for this HAC condition. For HEU broken turnings, fines, or powders with 500 g of polyethylene the $k_{eff} + 2\sigma = 0.984$ in Case **hcsrbmt12p_8_6_15**. The changes in both the outer dimensions of the package and the compositions of the Kaolite and 277-4 due to HAC does not result in detectible change in the neutron multiplication factor.

The finalized mass loading limits documented in Table 6.2a are derived from Tables 6.1c and 6.1d at the conclusion of the array analyses after consideration of other packing arrangements (i.e., single package under NCT and HAC and the various package array configurations under NCT and HAC).

6.4.3 HEU Oxide

HEU product oxide content is non-hygroscopic or mildly hygroscopic. The bulk density of HEU oxides considered for shipment in the ES-3100 ranges from 0.5 to 6.54 g/cm^3. HEU skull oxide is a less dense form of U_3O_8 intermixed with graphite. Of interest are those compositions with carbon/fissile uranium (C/^{235}U) ratios up to 2.3×10^5 μg C/g^{235}U. The quantity of fissile uranium is extremely low where even higher C/^{235}U ratios are present. Removal of the carbon limit (i.e., 921-g C) is addressed in Appendix 6.9.11.

HEU product oxide content may be packed in polyethylene bottles or metal convenience cans; HEU skull oxide content is packed in metal convenience cans. Polyethylene bottles and hydrogenous packing material are represented by 500 g polyethylene. While both the size and shape of the polyethylene bottles prevents the use of 277-4 canned spacers with product oxide loadings, the 10-in. height of the metal convenience cans eliminates the use of 277-4 canned spacers for product or skull oxide content packaged in these size cans. However, the convenience cans are not modeled in this criticality evaluation and this analysis is performed from the standpoint that metal-type convenience cans may be used for both oxide types.

HEU oxide content is not considered a "rigid" content like solid or broken HEU metal. For the calculation models of HEU oxides, the polyethylene is homogenized with the saturated bulk oxide. At a density of 0.9200 g/cm^3, polyethylene adds 543.47826 cm^3 to the volume of the saturated bulk oxide and reduces the free volume of the CV by an equal amount. The evaluation water in the void region of the CV fills the volume of the CV that not occupied by oxide content. (The void region of the CV is defined as the CV volume minus the oxide content volume.) Because of the differences in densities and compositions, product oxides are addressed separately from skull oxides.

Like packages with HEU metal or broken metal, the neutron multiplication factor for reflected single packages with HEU oxide increases as a function of increasing MOIFR and decreases with decreasing ^{235}U mass. For example, consider the ES-3100 package loaded with oxide at 6.54 g/cm^3 in three convenience cans for a total of 24,000-g UO_2 (21,125-g ^{235}U). The $k_{eff} + 2\sigma$ values range from 0.724 to 0.804 with increasing MOIFR in the reflected package [Cases **ncsrpoxt11_1_24_1** through **ncsrpoxt11_1_24_15** (Table 6.9.6-13)]. The addition of water to the package reduces the NLF, thereby increasing k_{eff}. The flooded, reflected package is the most reactive single package configuration; consequently, MOIFR is treated as a constant rather than a variable in subsequent "**pdox**" cases.

Parametric calculations are performed for oxide content loadings in a flooded, reflected package by varying the oxide bulk density from 6.54 g/cm^3 to a lower value limited by the capacity of the convenience cans. The maximum content capacity of the ES-3100 is ~6,975 cm^3, where each of three 4.25-in.-diam × 10.0-in.-tall convenience cans has a capacity of ~2,325 cm^3. As shown in Table 6.9.6-13a, calculations for a loading of 24,000-g UO_2 are performed at bulk densities of 6.54 g/cm^3, 5.0 g/cm^3, and 4.0 g/cm^3, but not 3.0 g/cm^3 because the capacity of the convenience cans is exceeded for this mass loading. Note that Case **ncsrpoxt11_1_24_15** (Table 6.9.6-13) is identical to Case **ncsrpdoxt11_1_5_24** (Table 6.9.6-13a). Results for the parametric Cases **ncsrpdoxt11_1_*n*_24**, **ncsrpdoxt11_1_*n*_20**, and **ncsrpdoxt11_1_*n*_15** reveal the consistent increase in the $k_{eff} + 2\sigma$ values as the bulk density decreases. This increase in neutron multiplication is due to the increased moderation of the HEU oxide.

Cases **ncsrpdoxt11_1_*n*_14** for UO_2 (12,323-g ^{235}U), **ncsrpdoxt11_2_*n*_14** for U_3O_8 (11,850-g ^{235}U), and **ncsrpdoxt11_3_*n*_14** for UO_3 (11,627-g ^{235}U) evaluate the ES-3100 package loaded with 14 kg oxide over the range of bulk density "*n*." The $k_{eff} + 2\sigma$ values reveal a consistent increase over the range of density. Results for Cases **ncsrpdoxt11_2_1_14** and **ncsrpdoxt11_3_1_14** indicate that both the U_3O_8 content ($k_{eff} + 2\sigma = 0.778$) and the UO_3 content ($k_{eff} + 2\sigma = 0.760$) are bounded by the UO_2 content ($k_{eff} + 2\sigma = 0.814$). Even though the capacity of the convenience cans is exceeded by 25 g, these cases are retained for the purpose of illustrating this point.

Results for a reflected CV loaded with HEU oxide reveal the same trends in the $k_{eff} + 2\sigma$ values as do results for the reflected package; however, the $k_{eff} + 2\sigma$ values are ~0.1 greater in the CV cases. For the flooded CV loaded with UO_2, the $k_{eff} + 2\sigma$ values increase from 0.838 to 0.911 with decreasing bulk density [Cases **cvcrpdoxt11_1_5_14_15** through **cvcrpdoxt11_1_1_14_15** (Table 6.9.6-12 and Fig. 6.9.1-6)]. For the dry CV, the $k_{eff} + 2\sigma$ values increase from 0.824 to 0.912 [Cases **cvcrpdoxt11_1_5_14_1** through **cvcrpdoxt11_1_1_14_1** (Table 6.9.6-12 and Fig. 6.9.1-6)]. Comparison of results for high density UO_2 oxide saturated with 862 g water reveals a small increase in $k_{eff} + 2\sigma$ from 0.824 to 0.838 due to flooding of the CV. Comparison of results for low density UO_2 oxide saturated with 5,712 g water reveals an insignificant increase in $k_{eff} + 2\sigma$ due to flooding of the CV, [Cases **cvcrpdoxt11_1_5_14_15** and **cvcrpdoxt11_1_5_14_1** (Table 6.9.6-12 and Fig. 6.9.1-6)].

Cases **cvcrpdoxt11_1_11_14_15** through **cvcrpdoxt11_1_1_14_15** demonstrate that the $k_{eff} + 2\sigma$ values decrease for decreased mass loadings of HEU oxide at constant bulk density.

For the flooded CV under full water reflection containment, the $k_{eff} + 2\sigma$ value is 0.914, Case **cvcrpdoxt11_1_3_24_15** [10 CFR 71.55(b)]. The $k_{eff} + 2\sigma$ value is 0.817 for water-reflected package, Case **ncsrpdoxt11_1_3_24** [10 CFR 71.55(d)]. Case **hcsrpdoxt12_1_3_24** (Table 6.9.6-13a) represents the HAC model of the damaged ES-3100 package, where the outer dimensions of the package are reduced accordingly and the entire package is flooded except the neutron poison of the body weldment liner inner cavity. This single-unit case pertains specifically to the flooded drum under conditions specified in 10 CFR 71.55(e). The $k_{eff} + 2\sigma$ value is 0.819 for this HAC condition. The changes in both the outer dimensions of the package and the compositions of the Kaolite and 277-4 due to HAC result in an ~0.002 change in the neutron multiplication factor.

Calculations were performed for bulk densities from 1.75 g/cm^3 to 0.5 g/cm^3. In this analysis, the CV is examined as dry (MOCFR of 1.0E-20) and fully flooded (MOCFR of 1.0). For the reflected CV cases, calculations are performed to exam uranium oxide at bulk densities of 1.75, 1.5, 1.25, 1.0, 0.75, and 0.5 g/cm^3 at 100% enrichment mixed with 500 g of polyethylene. The results of these calculations can be found in Tables 6.9.6-12a and 6.9.6-13c. At a density of 1.75 g/cm^3 the highest uranium oxide mass that was evaluated is 16 kg (maximum uranium oxide allowed is 15.13 kg due to structural limitations). For densities of 1.5 g/cm^3 and less, uranium oxide masses above a certain point were not evaluated, since larger amounts would exceed the CV internal volume.

In these calculations, the CV is modeled as dry and fully flooded. The bulk densities were evaluated from 1.75 g/cm^3 down to 0.5 g/cm^3, and the maximum amount of oxide evaluated was limited to either the maximum allowed or the maximum volume of oxide that would fill the CV. These calculations were evaluated in increments of 1 kg except for the 0.5 g/cm^3 cases, where the oxide was evaluated in increments of 500 g. The results for the highest oxide mass are found in Tables 6.14 and 6.15, and the results of all of these calculations are found in Table 6.9.6-12a.

Table 6.14. Reflected CV model, oxide mixed with 500 g polyethylene, MOCFR of 1.0E-20, (USL=0.935)

Case	Density (g/cm^3)	UO_2 mass (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$
cvcrldoxt11_1_20_1	1.75	16.0	0.9158	0.0012	0.9182
cvcrldoxt11_2_18_1	1.50	14.0	0.9140	0.0019	0.9178
cvcrldoxt11_3_16_1	1.25	12.0	0.9130	0.0013	0.9156
cvcrldoxt11_4_13_1	1.00	9.0	0.9081	0.0015	0.9111
cvcrldoxt11_5_11_1	0.75	7.0	0.9040	0.0010	0.9060
cvcrldoxt11_6_8_1	0.50	4.5	0.8915	0.0014	0.8943

Table 6.15. Reflected CV model, oxide mixed with 500 g polyethylene, MOCFR of 1.0, (USL=0.935)

Case	Density (g/cm^3)	UO_2 mass (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$
cvcrldoxt11_1_20_15	1.75	16.0	0.9172	0.0012	0.9196
cvcrldoxt11_2_18_15	1.50	14.0	0.9128	0.0013	0.9154
cvcrldoxt11_3_16_15	1.25	12.0	0.9173	0.0016	0.9205
cvcrldoxt11_4_13_15	1.00	9.0	0.9081	0.0015	0.9111
cvcrldoxt11_5_11_15	0.75	7.0	0.9040	0.0010	0.9060
cvcrldoxt11_6_8_15	0.50	4.5	0.8915	0.0014	0.8943

In the single package calculations, the CV is modeled as fully flooded, and the NCT and HAC package is fully reflected on all sides at the same densities as the CV cases. As the CV cases, the maximum amount of oxide evaluated was limited to either the maximum allowed or the maximum volume of oxide that would fill the CV. These calculations were evaluated in increments of 1 kg except for the 0.5 g/cm^3 cases, where the oxide was evaluated in increments of 500 g. The results for the highest oxide mass are found in Tables 6.16 and 6.17, and the results of all of these calculations are found in Table 6.9.6-13c.

Table 6.16. Reflected NCT single package model, oxide mixed with 500 g polyethylene, MOCFR of 1.0, (USL=0.935)

Case	Density (g/cm^3)	UO_2 mass (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$
ncsrldoxt11_1_20	1.75	16.0	0.8095	0.0014	0.8123
ncsrldoxt11_2_18	1.50	14.0	0.8080	0.0015	0.8110
ncsrldoxt11_3_16	1.25	12.0	0.8064	0.0014	0.8092
ncsrldoxt11_4_13	1.00	9.0	0.8024	0.0014	0.8052
ncsrldoxt11_5_11	0.75	7.0	0.7962	0.0011	0.7984
ncsrldoxt11_6_8	0.50	4.5	0.7845	0.0013	0.7871

Table 6.17. Reflected HAC single package model, oxide mixed with 500 g polyethylene, MOCFR of 1.0 (USL=0.935)

Case	Density (g/cm^3)	UO_2 mass (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$
hcsrldoxt12_1_20	1.75	16.0	0.8108	0.0012	0.8132
hcsrldoxt12_2_18	1.50	14.0	0.8070	0.0014	0.8098
hcsrldoxt12_3_16	1.25	12.0	0.8093	0.0012	0.8117
hcsrldoxt12_4_13	1.00	9.0	0.8029	0.0017	0.8063
hcsrldoxt12_5_11	0.75	7.0	0.7967	0.0015	0.7997
hcsrldoxt12_6_8	0.50	4.5	0.7856	0.0017	0.7890

From the results in the Tables 6.14–6.17, all cases are well below the USL. The comparison of the single package case results with corresponding case results for the reflected CV reveals that 30.48-cm water surrounding the CV is a better reflector than the flooded ES-3100 packaging. Additional calculations were performed for uranium oxide mixed with thorium oxide and uranium oxide mixed with thorium metal at the same densities as uranium oxide. Thorium is not fissile and would not increase the reactivity of this system; however, the saturated water that is in the thorium oxide and thorium metal model may provide a more optimum moderation configuration, especially at lower bulk densities. Parametric studies were performed for various uranium oxide loadings varying the amount of thorium oxide and thorium metal.

In the CV cases, the CV loaded with UO_2 mixed with either ThO_2 or thorium metal is modeled fully flooded and reflected. For the reflected CV cases, calculations are performed to exam UO_2 mixed with ThO_2 or thorium metal at bulk densities of 2.0, 1.75, 1.5, 1.25, 1.0, 0.75, and 0.5 g/cm^3 at 100% enrichment mixed with 500 g of polyethylene. The amount of ThO_2 or thorium metal that is added is dependent upon the amount of available space within the CV and the total amount of oxide allowed (13.15 kg). At lower densities, the amount of ThO_2 or thorium metal that can be added to the CV decreases with decreasing density. As shown in Tables 6.9.6-12b and 6.9.6-12d for all bulk oxide densities, reactivity decreases as ThO_2 or thorium metal is added.

In the single package calculations, the CV is modeled as fully flooded and the NCT and HAC package is fully reflected on all sides at the same densities as the CV cases. As in the CV cases, calculations are performed to exam UO_2 mixed with ThO_2 or thorium metal at bulk densities of 2.0, 1.75, 1.5, 1.25, 1.0, 0.75, and 0.5 g/cm^3 at 100% enrichment mixed with 500 g of polyethylene. The amount of ThO_2 or thorium metal that is added is dependent upon the amount of available space within the CV. At lower densities, the amount of ThO_2 and thorium metal that can be added to the CV decreases with decreasing density. As shown in Table 6.9.6-13e and 6.9.6-13g, for all bulk oxide densities, as ThO_2 or thorium metal is added, reactivity decreases.

Calculations were also performed for zirconium oxide mixed with uranium oxide at the same densities as uranium oxide. The saturated water that is in the zirconium oxide model may provide a more optimum moderation configuration, especially at lower bulk densities. Parametric studies were performed for various uranium oxide loadings varying the amount of oxide.

In the CV cases, the CV loaded with UO_2 and $ZrO_2$is modeled fully flooded and reflected. For the reflected CV cases, calculations are performed to exam UO_2 mixed with ZrO_2 at bulk densities of 2.0, 1.75, 1.5, 1.25, 1.0, 0.75, and 0.5 g/cm^3 at 100% enrichment mixed with 500 g of polyethylene. The amount of ZrO_2 that is added is dependent upon the amount of available space within the CV and the total

amount of oxide allowed (13.15 kg). At lower densities, as for the ThO_2, the amount of ZrO_2 that can be added to the CV decreases with decreasing density. As shown in Table 6.9.6-12c for all bulk oxide densities, reactivity decreases as ZrO_2 is added.

In the single package calculations, the CV is modeled as fully flooded, and the NCT and HAC package is fully reflected on all sides at the same densities as the CV cases. As in the CV cases, calculations are performed to exam UO_2 mixed with ZrO_2 at bulk densities of 2.0, 1.75, 1.5, 1.25, 1.0, 0.75, and 0.5 g/cm^3 at 100% enrichment mixed with 500 g of polyethylene. The amount of ZrO_2 that is added is dependent upon the amount of available space within the CV. At lower densities, the amount of ZrO_2 that can be added to the CV decreases with decreasing density. As shown in Table 6.9.6-13f for all bulk oxide densities, reactivity decreases as ZrO_2 is added.

Cases **cvcrsk3cc_1_15_17** through **cvcrsk3cc_10_15_17** (Appendix 6.9.6, Table 6.9.6-17) evaluate the 10 skull oxide compositions identified Table 6.9.3.1-3b, where the CV is loaded with 3 convenience cans. The fissile enrichment is ~70 wt % ^{235}U for contents "**sk3cc_1**" through "**sk3cc_5**" and ~38 wt % ^{235}U for contents "**sk3cc_6**" through "**sk3cc_8**." The observed maximums of 7.1 kg skull oxide and ~93.2 wt % ^{235}U enrichment present in 292 convenience cans are the basis for the hypothetical contents "**sk3cc_9**" and "**sk3cc_10**," where unidentified material is treated as ^{235}U and the carbon content is either maximized or minimized. Content "**sk3cc_10**" differs from "**sk3cc_9**" in that 921 g of graphite in the skull oxide is replaced with 921-g ^{235}U in the form of U_3O_8. Content "**sk3cc_10**" is more representative of high enrichment skull oxides where < 85 g of graphite is present. For each of the 10 content models, 513 g of the skull oxide content is modeled as polyethylene, representing the potential use of hydrogenous packing material. The U_3O_8 content ranges from 8 to 21 kg, while the ^{235}U content ranges from 3.7 to 16.4 kg. The graphite content ranges from 0 to 921-g C, and the C/^{235}U ratio ranges from 0 to 223,432 µg C/g ^{235}U. For Cases **cvcrsk3cc_1_15_17** through **cvcrsk3cc_10_15_17** at both saturation moisture and full graphite content, the $k_{eff} + 2\sigma$ values range from 0.759 to 0.855 in the flooded, water-reflected CV. Cases **cvcrsk3cc_9_15_17** and **cvcrsk3cc_10_15_17** reveal that $k_{eff} + 2\sigma$ increases slightly when the 921 g of carbon in the skull oxide is replaced with 726-g ^{235}U in the form of U_3O_8.

Cases **cvcrsk3cc_4_1_1** through **cvcrsk3cc_4_*m*_*g*** evaluate the effects of moisture and skull oxide graphite content on reactivity. The case designator "***m***" ranges from 1 to 15, signifying the variation in moisture; "***g***" ranges from 1 to 17, signifying the variation in graphite. Examination of results indicates that moisture content has a predominate effect on the neutron multiplication factor, while variation in graphite content has a minor effect. The peak $k_{eff} + 2\sigma$ value occurs at saturated moisture and full graphite content.

Mixtures of UO_2 and ThO_2 are also examined. Thorium is not fissile and as such would not increase reactivity; however, since the CV is modeled fully flooded, the additional water that would be provided by the ThO_2 may increase reactivity, especially at densities lower than 2.0 g/cm^3. Parametric studies are performed to exam the mixing of UO_2 with varying amounts of ThO_2.

Cases **ncsrsk_1_15** through **ncsrsk_10_15** (Appendix 6.9.6, Table 6.9.6-18a) model the 10 skull oxide compositions in a flooded CV in a water reflected package. The $k_{eff} + 2\sigma$ values range from 0.641 to 0.745. Likewise, Cases **hcsrsk_1_15** through **hcsrsk_10_15** (Appendix 6.9.6, Table 6.9.6-18b) evaluate infinite arrays damage packages. The $k_{eff} + 2\sigma$ values ranging from 0.658 to 0.767 are not statistically significantly different from the NCT case results.

Cases **ncsrsk_9_1** through **ncsrsk_9_15** evaluate the bounding skull oxide content containing ~19.9 kg U_3O_8 and 921 g graphite, where the saturation moisture is varied from 0 to 3801 g water. Likewise, Cases **ncsrsk_10_1** through **ncsrsk_10_15** evaluate the skull oxide content containing ~20.8 kg U_3O_8 where the 921 g of graphite in the skull oxide is replaced with 726-g ^{235}U in the form of U_3O_8. The $k_{eff} + 2\sigma$ values range from 0.403 to 0.741 in the former set of cases and range from

0.404 to 0.746 in the latter set of cases. The $k_{eff} + 2\sigma$ values are well below the USL value of 0.925, indicating that canned spacers are not required for criticality control. Moreover, these results indicate that moisture content has a predominate effect on the neutron multiplication factor, while the graphite content has an insignificant effect.

6.4.4 UNH Crystals

UNH crystal content is to be packed in Teflon bottles, which may be placed in polyethylene bags. The Teflon bottles are not credited for containing the UNH crystal content. The 277-4 canned spacers are not used in this packing configuration. Teflon is polytetrafluoroethylene (or polyethylene tetrafluoride) having a monomer formula of C_2F_4 with a melting point of ~280°C (536°F). Teflon will not melt at the much lower CV inner wall temperatures associated with NCT and HAC. The use of Teflon and polyethylene packing material is conservatively represented by 500 g of polyethylene in the calculation model. UNH crystal content is not considered a "rigid" content like solid or broken HEU metal. Like HEU oxide content, the UNH crystal content is homogenized with the polyethylene.

Unlike the other HEU contents, UNH crystals are soluble in water. The most reactive content condition occurs at an optimum solution concentration derived from the UNH crystal loading and the volume of water flooding the CV. Both flooding of the CV and a reduced loading of UNH crystals going into solution is required to achieve the most reactive configuration.

Consider a flooded CV with the UNH crystals in solution and no polyethylene. For Cases **cvcrunhct11_24_1** through **cvcrunhct11_1_1** (Table 6.9.6-14), the $k_{eff} + 2\sigma$ values range from 0.823 to 0.609 and optimum concentration occurs at ~9,000-g UNH (Case **cvcrunhct11_9_1**, $k_{eff} + 2\sigma = 0.857$). Consider a flooded CV with a solution of UNH crystals homogenized with 500 g polyethylene. For Cases **cvcrpunhct11_24_15** through **cvcrpunhct11_1_15** (Table 6.9.6-14), the $k_{eff} + 2\sigma$ values range from 0.827 to 0.613 and optimum concentration occurs at ~10,000-g UNH (Case **cvcrpunhct11_10_15**, $k_{eff} + 2\sigma = 0.863$). The replacement of water with 500 g of polyethylene in the latter set of cases results in changes to the neutron multiplication factor on the order of ~0.004 to 0.006. The concentration for a 24,000 g loading in both set of cases is 1,106-g ^{235}U per liter of flooded CV. In the calculation of the uranium concentration, the solution volume is not reduced by the volume of polyethylene because polyethylene is homogenized with UNH in the solution.

For Cases **cvcrpunhct11_24_1** through **cvcrpunhct11_1_1** (Table 6.9.6-14), the homogenized UNH crystals and polyethylene are dispersed over a dry CV. The $k_{eff} + 2\sigma$ values range from 0.769 to 0.251 as the mass loading decreases. Comparison with results for corresponding Cases **cvcrpunhct11_24_15** through **cvcrpunhct11_1_15** for a flooded CV reveals that the most reactive content condition occurs for UNH in the solution state.

For Cases **cvcrbpunhct11_24_15** through **cvcrbpunhct11_1_15** (Table 6.9.6-14), homogenized UNH crystals and polyethylene are settled on the bottom of the CV and the residual volume above it is flooded. The $k_{eff} + 2\sigma$ values range from 0.817 to 0.553 as the mass loading decreases. For Cases **cvcrbpunhct11_24_1** through **cvcrbpunhct11_1_1**, the residual volume above the content is dry. Likewise, the $k_{eff} + 2\sigma$ values range from 0.815 to 0.478 as the mass loading decreases.

Comparison of results for corresponding Cases **cvdrpunhct11_*n*_1** and **cvcrbpunhct11_*n*_15** reveal greater changes in the k_{eff} values occurring at the lower mass loadings when dispersed content is settled to the bottom of the CV. Nevertheless, interspersed moderation has a dominant effect on k_{eff} occurring when settled content goes into solution (Case **cvcrbpunhct11_10_15** vs Case **cvcrpunhct11_10_15**).

Similar to packages loaded with HEU metal, broken metal, or oxide, the neutron multiplication factor for a reflected single package with UNH crystals increases as a function of MOIFR. Consider the ES-3100 package loaded with bottles for a total of 24,000-g UNH crystals (11,303-g ^{235}U). For Cases **ncsrunhct11_24_1_1** through **ncsrunhct11_24_1_15** (Table 6.9.6-15), the $k_{eff} + 2\sigma$ values range from 0.605 to 0.702 with increasing MOIFR in the water-reflected package. For Cases **ncsrpunhct11_24_1** and **ncsrpunhct11_24_15** (Table 6.9.6-15), the $k_{eff} + 2\sigma$ values range from 0.609 to 0.708 with increasing MOIFR in the water-reflected package. These cases confirm that the replacement of water with 500 g of polyethylene results in changes to the neutron multiplication factor on the order of ~0.004 to 0.006.

For a flooded CV with UNH crystals in solution, the $k_{eff} + 2\sigma$ values range from 0.702 to 0.646 [Cases **ncsrunhct11_24_1_15** through **ncsrunhct11_2_1_15** (Table 6.9.6-15)]. Similarly, for a flooded CV with a solution of UNH crystals homogenized with 500 g of polyethylene, the $k_{eff} + 2\sigma$ values range from 0.708 to 0.545 [Cases **ncsrpunhct11_24_15** through **ncsrpunhct11_1_15** (Table 6.9.6-15)]. At optimal concentration (~8,000-g UNH), the calculated $k_{eff} + 2\sigma$ value is 0.863 for Case **cvcrpunhct11_10_15** and $k_{eff} + 2\sigma = 0.753$ for Case **ncsrpunhct11_8_15**. The water-reflected CV is more reactive than the water-reflected package; therefore, the result for Case **cvcrpunhct11_10_15** is reported [10 CFR 71.55(b)]. The result for Case **ncsrpunhct11_8_15** having the maximum $k_{eff} + 2\sigma$ value is reported for the NCT water-reflected package [10 CFR 71.55(d)].

Unlike solid HEU metal and oxide content, which are confined to the CV and only water leakage into the CV need be considered, the evaluation of UNH crystal content for compliance with 10 CFR 71.55(b) also requires that the leakage of liquid HEU contents out of the containment be addressed. This is because UNH crystals are soluble in water and would dissolve in the water flooding the CV and the CV well. For a content loading of 24,000-g UNH, the uranium concentration inside the CV drops from 1,106-g ^{235}U/L to 710-g ^{235}U/L. Optimum solution concentrations occurs for fissile mass loadings of ~15,000-g UNH. In the calculation of the uranium concentration, the solution volume is not reduced by the volume of polyethylene because polyethylene is homogenized with UNH in the solution.

Cases **hcsrpunhct12_8_15** (Table 6.9.6-15) and **icsrpunhct12_15_15** (Table 6.9.6-16) represent the HAC model of the damaged ES-3100 package where the outer dimensions of the package are reduced accordingly. For Case **hcsrpunhct12_8_15**, the dilution of the UNH crystals is confined to the CV, and maximum reactivity occurs at ~8000-g UNH homogenized with 500 g polyethylene. For Case **icsrpunhct12_15_15**, UNH crystals are dissolved in the water flooding the CV and the CV well. The fissile material is uniformly distributed over the volume of the CV and the well, but the polyethylene is confined to the CV. Maximum reactivity occurs at ~15,000-g UNH. These single-unit cases with a MOIFR = 1.0 pertain specifically to the flooded drum under conditions specified in 10 CFR 71.55(e), where the $k_{eff} + 2\sigma$ values are 0.752 and 0.814 for this HAC condition. The result for Case **icsrpunhct12_15_15** having the maximum $k_{eff} + 2\sigma$ value is reported for the HAC water-reflected package [10 CFR 71.55(e)].

6.5 EVALUATION OF PACKAGE ARRAYS UNDER NORMAL CONDITIONS OF TRANSPORT

For the NCT array evaluation of ES-3100 packages, the package content is confined within the CV, consistent with the result of the tests specified in §71.71 (Normal Conditions of Transport). The array sizes examined in this evaluation are infinite, 13×13×6, 9×9×4, 7×7×3, 5×5×2, ETP 27×3, and the degenerate single unit. The "N" and corresponding CSI values for arrays determined to be adequately subcritical are as follows: N = ∞, CSI = 0; N = 202, CSI = 0.3; N = 64, CSI = 0.8; N = 29, CSI = 1.7; and N = 16, CSI = 3.2. All arrays, except the infinite array, are reflected with 30 cm (1 ft) of water. These arrays are nearly cubic in shape for optimum array reactivity, thus eliminating the need for placing criticality controls on package arrangements in terms of stack height, width, and depth of an array. The array configurations and the range of water contents (Table 6.4) evaluated bound all possible packaging arrangements and moderation conditions for NCT.

6.5.1 Solid HEU Metal of Specified Geometric Shapes

For infinite and finite arrays of packages with HEU metal, the neutron multiplication factor increases as a function of the ^{235}U mass and decreases as a function of MOIFR. For example, consider the ES-3100 package loaded with three convenience cans for a total of 36,000-g ^{235}U where each can contains a 3.24-in.-diam cylinder. For package content without 277-4 canned spacers, the $k_{eff} + 2\sigma$ values range from 1.027 to 0.963 with increasing MOIFR in the package [Cases **nciacyt11_36_1_1** through **nciacyt11_36_1_15** (Appendix 6.9.6, Table 6.9.6-3)]. For package content with 277-4 canned spacers, the $k_{eff} + 2\sigma$ values range from 0.957 to 0.880 with increasing MOIFR in the package [Cases **nciacyt11_36_2_1** through **nciacyt11_36_2_15** (Appendix 6.9.6, Table 6.9.6-3)].

The effect of increasing the water content of the array is straightforward. As interspersed water is added to the packages of an array, two reactivity effects occur in series. The first effect is the tendency for reactivity to remain constant due to controlled neutron interaction between the packages of the array. For an infinite array where neutrons cannot escape from the system, neutrons are scattered about the array. In the MOIFR range of 1E-20 to 1E-02, both the interspersed moderator inside the packages of the dry array and the interstitial moderator between the package drums of the array are not sufficient for neutron thermalization and absorption to occur in the adjacent packaging materials. However, hydrogen in the 277-4 provides moderation, and neutrons are absorbed in the interspersed boron of this neutron poison. This results in a subcritical system with near constant neutron multiplication factors over the range of MOIFR. The second effect is the tendency for reactivity to decrease due to internal moderation in packages of the array. The introduction of water above ~0.01 MOIFR shows the effect of isolating the individual array units from each other. The neutron multiplication factor approaches k_{eff} for the single, water-reflected unit at a full-content water fraction (MOIFR = 1.0).

The array case with a water fraction of MOIFR = 1E-04 pertains specifically to packages under NCT where the Kaolite and recesses of the package external to the CV do not contain any residual moisture. This NCT case is more reactive than all other NCT cases where more moisture is present in the Kaolite and recesses of the package. Interspersed water between the CVs in the array will reduce neutronic interaction between the flooded contents because neutrons are absorbed in the hydrogen of the water. As more water is added, the packages of the array become isolated, and array reactivity ($k_{eff} + 2\sigma$ = 0.880, Case **nciacyt11_36_2_1**5) approaches the reactivity of the single unit ($k_{eff} + 2\sigma$ = 0.873, Case **ncsrcyt11_36_2_1**5).

Repeated for 4.25-in.-diam cylinders (Appendix 6.9.6, Table 6.9.6-7); 2.29-in. -square bars (Table 6.9.6-5); and 1.5-in.-diam × 2-in.-tall slugs (Table 6.9.6-9), this type of analysis for the 3.24-in.-diam cylinders demonstrates that arrays of packages with restricted fissile material (^{235}U) loading remain subcritical over the entire range of water content or MOIFR. HEU metal or alloy content not covered by the specified geometric shapes (cylinder, square bar, or slug contents) will be in the HEU broken metal category, and so limited.

Additional cases were performed to exam the effect that 500 g of polyethylene will have on HEU metal cylinders and bars in arrays of packages for both NCT and HAC. The original cases previously found in Table 6.1a were rerun using SCALE 6.1.3 with updated cross-sections and more particles. These cases were also modified by adding 500 g of polyethylene. The results of these cases are found in Tables 6.18 and 6.19.

Table 6.18. NCT infinite array model, HEU metal cylinders and bars, with and without 500 g polyethylene, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff} + 2\sigma$
nciacyt11_18_1_3	18 kg 235U, 3.24 in.-diam cylinder, no spacers or polyethylene	0.92377	0.00070	0.92517
nciacyt11p_18_1_3	18 kg 235U, 3.24 in.-diam cylinder, no spacers, 500 g polyethylene	0.91346	0.00059	0.91464
nciacyt11_30_2_3	30 kg 235U, 3.24 in.-diam cylinder, with spacers and no polyethylene	0.91999	0.00056	0.92111
nciacyt11p_30_2_3	30 kg 235U, 3.24 in.-diam cylinder, with spacers and 500 g polyethylene	0.91087	0.00069	0.91225
nciasqt11_30_1_3	30 kg 235U, 2.29 in. l,w bars, no spacers or polyethylene	0.92187	0.00065	0.92317
nciasqt11p_30_1_3	30 kg 235U, 2.29 in. l,w bars, no spacers, 500 g polyethylene	0.91720	0.00061	0.91842
nciacyct11_15_1_3	15 kg 235U, 4.25 in.-diam cylinder, no spacers or polyethylene	0.90101	0.00066	0.90233
nciacyct11p_15_1_3	15 kg 235U, 4.25 in.-diam cylinder, no spacers, 500 g polyethylene	0.90614	0.00070	0.90754
nciacyct11_25_2_3	25 kg 235U, 4.25 in.-diam cylinder, with spacers and no polyethylene	0.91341	0.00057	0.91455
nciacyct11p_25_2_3	25 kg 235U, 4.25 in.-diam cylinder, with spacers and 500 g polyethylene	0.90107	0.00055	0.90217
nciasqt11_36_2_3	36 kg 235U, 2.29 in. l,w bars, with spacers or polyethylene	0.89252	0.00063	0.89378
nciasqt11p_36_2_3	36 kg 235U, 2.29 in. l,w bars, with spacers, 500 g polyethylene	0.89448	0.00078	0.89604

Table 6.19. HAC infinite array model, HEU metal cylinders and bars, with and without 500 g polyethylene, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff} + 2\sigma$
hciacyt12_18_1_3	18 kg ^{235}U, 3.24 in.-diam cylinder, no spacers or polyethylene	0.92426	0.00064	0.92554
hciacyt12p_18_1_3	18 kg ^{235}U, 3.24 in.-diam cylinder, no spacers, 500 g polyethylene	0.91275	0.00064	0.91403
hciacyt12_30_2_3	30 kg ^{235}U, 3.24 in.-diam cylinder, with spacers and no polyethylene	0.92026	0.00063	0.92152
hciacyt12p_30_2_3	30 kg ^{235}U, 3.24 in.-diam cylinder, with spacers and 500 g polyethylene	0.91262	0.00068	0.91398
hciasqt12_30_1_3	30 kg ^{235}U, 2.29 in. l,w bars, no spacers or polyethylene	0.92231	0.00060	0.92351
hciasqt12p_30_1_3	30 kg ^{235}U, 2.29 in. l,w bars, no spacers, 500 g polyethylene	0.91634	0.00073	0.91780
hciacyct12_15_1_3	15 kg ^{235}U, 4.25 in.-diam cylinder, no spacers or polyethylene	0.89934	0.00066	0.90066
hciacyct12p_15_1_3	15 kg ^{235}U, 4.25 in.-diam cylinder, no spacers, 500 g polyethylene	0.90657	0.00068	0.90793
hciacyct12_25_2_3	25 kg ^{235}U, 4.25 in.-diam cylinder, with spacers and no polyethylene	0.91300	0.00064	0.91428
hciacyct12p_25_2_3	25 kg ^{235}U, 4.25 in.-diam cylinder, with spacers and 500 g polyethylene	0.90095	0.00059	0.90213
hciasqt12_36_2_3	36 kg ^{235}U, 2.29 in. l,w bars, with spacers or polyethylene	0.89219	0.00075	0.89369
hciasqt12p_36_2_3	36 kg ^{235}U, 2.29 in. l,w bars, with spacers, 500 g polyethylene	0.89506	0.00063	0.89632

From the result of the infinite array package cases for HEU metal cylinders and bars, modeling 500 g of polyethylene surrounding the HEU metal is as reactive or slightly less reactive than no polyethylene. For the two types of annular cylinders the NCT cases for an infinite array of packages (Appendix 6.9.6, Table 6.9.6-3d), the CV is modeled fully flooded and the interstitial water moderation is modeled at MOIFR = 1E-04. Each cylinder is modeled at the bottom of the CV. Case **nciacylc11** for Cylinder C has a calculated $k_{eff} \pm 2\sigma$ value of 0.83219 (k_{eff} = 0.83107, σ = 0.00056), while Case **nciacyld11** for Cylinder D has a calculated $k_{eff} \pm 2\sigma$ value of 0.85387 (k_{eff} = 0.85241, σ = 0.00073). Additional cases were run with the cylinder modeled vertically centered in the CV. Case **nciacylcc11** for Cylinder C has a calculated $k_{eff} \pm 2\sigma$ value of 0.80889 (k_{eff} = 0.80727, σ = 0.00081), while Case **nciacyldc11** for Cylinder D has a calculated $k_{eff} \pm 2\sigma$ value is 0.82521 (k_{eff} = 0.82393, σ = 0.00064).

Calculations were also performed to exam the effect of aluminum shielding to Cylinder D (Appendix 6.9.6, Table 6.9.6-3d). As the amount of aluminum shielding is added, reactivity decreases. This is due to the fact that the CV is flooded, and in order to add aluminum cladding, water must be removed to conserve volume. Thus, aluminum cladding is not controlled for Cylinder D.

All Cylinder C and D infinite array cases were shown to be below the USL of 0.9352, and the models with the cylinders located at the bottom of the CV were the most reactive.

Cases **nciatriga_1_1_3** through **nciatriga_1_15_3** (Appendix 6.9.6, Table 6.9.6-20a) represent infinite arrays of packages containing the bounding TRIGA fuel content (20 % enrichment with 45 wt % U containing 307-g ^{235}U), without 277-4 canned spacers. The MOIFR is set at 1.0E-04 such that neutronic interaction between packages is maximized. For these cases, the $k_{eff} + 2\sigma$ values increase from 0.218 to 0.525 as MOIFR increases. The $k_{eff} + 2\sigma = 0.525$ for Case **nciatriga_1_15_3** is substantially below the USL value of 0.925, indicating that canned spacers are not required for criticality control.

As stated in Sect. 6.4.1, 10 CFR 71.55(d)(2) requires the geometric form of a package's content not be substantially altered under the NCT. Similarly, 10 CFR 71.55(e)(1) requires that the package be adequately subcritical under HAC with the package contents in the most reactive credible configuration. Even though visible signs of damage to the metal convenience can have not been observed resulting from the regulatory tests, conclusions about damage to the TRIGA fuel content are not extrapolated from test data. The regulatory requirements are addressed by modeling the TRIGA fuel content in an extremely damaged condition. A series of criticality calculations is performed for making a determination of subcriticality. Cases **nciat55d2_1_1_3** through **ncia55d2_1_15_3** (Appendix 6.9.6, Table 6.9.6-20d) represent TRIGA fuel content homogenized with variable density water over the free volume of the CV. The packaging is flooded in each ES-3100 package of the infinite array. The variable density water ranges from the dry containment condition to the fully flooded condition. Credit for physical integrity of the content is not taken in this set of cases which model the substantially altered content. The calculation results in Table 6.9.6-20d indicate extremely damaged content (Case **nciat55d2_1_15_3** with $k_{eff} + 2\sigma = 0.716$) is more reactive than the unaltered configuration (Case **nciatriga_1_15_3** with $k_{eff} + 2\sigma = 0.442$). Nevertheless, both cases are adequately below the USL of 0.925 and the requirement of 10 CFR 71.55(d)(2) is satisfied. Given that changes external to the CV due to the HAC do not result in an appreciable change in neutron multiplication for an array of packages, similar results are expected for the cases demonstrating compliance with 10 CFR 71.55(e)(1).

For TRIGA fuel content as clad fuel rods, the amount of cladding added (stainless steel as a neutron absorber or aluminum as a neutron scatter) and corresponding amount of water moderator displaced by the cladding is not expected to have a statistically significant affect on the calculated k_{eff}. Thus, the NCT shipping configuration model for disassembled TRIGA fuel (bare fuel meats) bounds shipping configuration model for TRIGA fuel configured as clad fuel rods (Appendix 6.9.3.1).

Additional cases were performed to exam the effect that 500 g of polyethylene will have on TRIGA fuel for arrays. The original cases previously found in Table 6.1f were rerun using SCALE 6.1.3, with updated cross-sections and more particles. These cases were also modified by adding 500 g of polyethylene. The results of these cases are found in Tables 6.20 and 6.21.

Table 6.20 NCT array model, TRIGA fuel, with and without 500 g polyethylene, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff} + 2\sigma$
nciatriga_1_15_3	Three 5 in.-tall TRIGA fuel elements per can, no spacers or polyethylene	0.54514	0.00064	0.54642
nciatrigap_1_15_3	Three 5 in.-tall TRIGA fuel elements per can, no spacers, 500 g polyethylene	0.53671	0.00059	0.53789
nciatriga_2_15_3	Three 5 in.-tall TRIGA fuel elements per can, with spacers or polyethylene	0.44062	0.00056	0.44174
nciatrigap_2_15_3	Three 5 in-all TRIGA fuel elements per can, with spacers, 500 g polyethylene	0.45166	0.00057	0.45280
nciatriga_70_1_15_3	Three 5 in.-tall TRIGA fuel elements per can, no spacers or polyethylene, 70% enriched	0.48635	0.00061	0.48757
nciatrigap_70_1_15_3	Three 5 in.-tall TRIGA fuel elements per can, no spacers, 500 g polyethylene, 70% enriched	0.49667	0.00062	0.49791

Table 6.21. Reflected HAC array model, TRIGA fuel, with and without 500 g polyethylene, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff} + 2\sigma$
hciatriga_1_15_3	Three 5 in.-tall TRIGA fuel element per can, no spacers or polyethylene	0.52553	0.00061	0.52675
hciatrigap_1_15_3	Three 5 in.-tall TRIGA fuel element per can, no spacers, 500 g polyethylene	0.53602	0.00069	0.53740
hciatriga_2_15_3	Three 5 in.-tall TRIGA fuel element per can, with spacers or polyethylene	0.44070	0.00067	0.44204
hciatrigap_2_15_3	Three 5 in.-tall TRIGA fuel element per can, with spacers, 500 g polyethylene	0.45229	0.00054	0.45337
hciatriga_70_1_15_3	Three 5 in.-tall TRIGA fuel element per can, no spacers or polyethylene, 70% enriched	0.48713	0.00058	0.48829
hciatrigap_70_1_15_3	Three 5 in.-tall TRIGA fuel element per can, no spacers, 500 g polyethylene, 70% enriched	0.49812	0.00070	0.49952

From the results of the CV cases for TRIGA fuel, modeling 500 g of polyethylene surrounding the HEU metal is more reactive than no polyethylene.

The array results for three slug configurations presented in Table 6.9.6-9 (Appendix 6.9.6) are for five or ten slugs touching or spaced apart in a pentagonal ring (Cases **ncia5st11** and **ncia5est11**) and for seven slugs formed by a hexagonal ring of slugs with one slug in the center of the ring **(ncia70st11**). These cases are used to establish the mass loading limitations, which in turn limit the number of slugs in the package to less than the number required to assemble a critical configuration.

Cases **ncia5est11_1_1_8_3** through **ncia5est11_1_1_1_3** (Appendix 6.9.6, Table 6.9.6-9) represent infinite arrays of packages containing 18,277-g U without 277-4 canned spacers. For these cases, the $k_{eff} + 2\sigma$ values increase from 0.550 to 0.924 as the enrichment is increased from 19.0 wt % to 100.0 wt % ^{235}U. The $k_{eff} + 2\sigma$ value is 0.924 for Case **ncia5est11_1_1_8_3**, which is below the USL of 0.925. Likewise, the $k_{eff} + 2\sigma$ values for Cases **ncia5st11_1_1_8_3** through **ncia5st11_1_1_1_3** increase from 0.521 to 0.929 as the enrichment is increased. However, the $k_{eff} + 2\sigma$ value is 0.929 for Case **ncia5st11_1_1_8_3**, which is slightly above the USL of 0.925. For simplification of the criticality evaluation, the maximum enrichment is limited to 95% and the corresponding fissile mass limit is 17,374-g ^{235}U. For Cases **ncia5st11_1_1_7_3** and **ncia5est11_1_1_7_3**, the $k_{eff} + 2\sigma$ values are below the USL. Moreover, the values are not statistically different.

Cases **ncia70st11_2_8_3** through **ncia70st11_2_1_3** (Appendix 6.9.6, Table 6.9.6-9) represent infinite arrays of packages containing 25,588-g U with 277-4 canned spacers. For these cases, the $k_{eff} + 2\sigma$ values increase from 0.473 to 0.915 as the enrichment is increased from 19.0 wt % to 100.0 wt % ^{235}U. The $k_{eff} + 2\sigma$ value of 0.894 for Case **ncia70st11_2_7_3** at the 95% enrichment limit is adequately below the USL of 0.925.

Cases **ncia5est11_2_2_8_3** through **ncia5est11_2_2_1_3** (Appendix 6.9.6, Table 6.9.6-9) represent infinite arrays of packages containing 36,555-g ^{235}U with 277-4 canned spacers. For these cases, the $k_{eff} + 2\sigma$ values increase from 0.583 to 0.983 as the enrichment is increased from 19.0 wt % to 100.0 wt % ^{235}U. At 80 wt % ^{235}U, the $k_{eff} + 2\sigma$ value (0.908) for Case **ncia5est11_2_2_5_3** with spaced-apart slugs is just below the USL. Similarly, Case **ncia5st11_2_2_5_3** with touching slugs has a calculated $k_{eff} + 2\sigma$ value of 0.902. Therefore, a restriction on mass and enrichment for slug content is that for ≤ 80 wt % ^{235}U, the mass of ^{235}U in the package must not exceed 29,318 g as a prerequisite for the shipment of the package slug content and with 277-4 canned spacers under a CSI = 0.0.

Cases **ncf15est11_2_2_8_3** through **ncf15est11_2_2_1_3** (Appendix 6.9.6, Table 6.9.6-9) represent a 13 × 13 × 6 array of packages containing 36,555-g ^{235}U with 277-4 canned spacers for which the corresponding rounded CSI = 0.4. For these cases, the $k_{eff} + 2\sigma$ values increase from 0.550 to 0.942 as the enrichment is increased from 19.0 wt % to 100.0 wt % ^{235}U. Case **ncf15est11_2_2_7_3** at 95 wt % ^{235}U with $k_{eff} + 2\sigma = 0.922$ is below the USL of 0.93520 to permit increasing the limit on enrichment for mass loadings of ≤ 34.7 kg uranium metal.

Additional calculations were also performed to exam the effect that 500 g of polyethylene will have on HEU metal slugs in arrays of packages for both NCT and HAC. The original cases previously found in Table 6.1b were rerun using SCALE 6.1.3 with updated cross-sections and more particles. These cases were also modified by adding 500 g of polyethylene. The results of these cases are found in Tables 6.22 and 6.23.

Table 6.22. NCT infinite array model, HEU metal slugs, with and without 500 g polyethylene, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff} + 2\sigma$
ncia5st11_1_1_7_3	17.374 kg ^{235}U, 95% enriched, 5 slugs per can, d=1.5625 in., h=2.0624 in., no spacers or polyethylene	0.91153	0.00068	0.91289
ncia5st11p_1_1_7_3	17.374 kg ^{235}U, 95% enriched, 5 slugs per can, d=1.5625 in., h=2.0624 in., no spacers, 500 g polyethylene	0.91659	0.00069	0.91797
ncia70st11_2_7_3	24.324 kg ^{235}U, 95% enriched,10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers or polyethylene	0.89504	0.00065	0.89634
ncia70st11p_2_7_3	24.324 kg ^{235}U, 95% enriched, 10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers, 500 g polyethylene	0.88248	0.00062	0.88372
ncia5est11_2_2_5_3	29.318 kg ^{235}U, 85% enriched,10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers or polyethylene	0.90942	0.00057	0.91056
ncia5est11p_2_2_5_3	29.318 kg ^{235}U, 85% enriched, 10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers, 500 g polyethylene	0.90559	0.00079	0.90717
ncf15est11_2_2_7_3	34.749 kg ^{235}U, 95% enriched,10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers or polyethylene, CSI=0.4	0.92087	0.00066	0.92219
ncf15est11p_2_2_7_3	34.749 kg ^{235}U, 95% enriched, 10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers, 500 g polyethylene, CSI=0.4	0.92335	0.00060	0.92455
ncf15est11_2_2_5_3	29.318 kg ^{235}U, 80% enriched,10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers or polyethylene, CSI=0.4	0.86743	0.00057	0.86857
ncf15est11p_2_2_5_3	29.318 kg ^{235}U, 80% enriched, 10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers, 500 g polyethylene, CSI=0.4	0.86878	0.00064	0.87006

Table 6.23. HAC infinite array model, HEU metal slugs, with and without 500 g polyethylene, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff} + 2\sigma$
hcia5st12_1_1_7_3	17.374 kg ^{235}U, 95% enriched, 5 slugs per can, d=1.5625 in., h=2.0624 in., no spacers or polyethylene	0.91061	0.0006	0.91181
hcia5st12p_1_1_7_3	17.374 kg ^{235}U, 95% enriched, 5 slugs per can, d=1.5625 in., h=2.0624 in., no spacers, 500 g polyethylene	0.91759	0.00074	0.91907
hcia70st12_2_7_3	24.324 kg ^{235}U, 95% enriched,10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers or polyethylene	0.89481	0.00059	0.89599
hcia70st12p_2_7_3	24.324 kg ^{235}U, 95% enriched, 10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers, 500 g polyethylene	0.88246	0.00066	0.88378
hcia5est12_2_2_5_3	29.318 kg ^{235}U, 85% enriched,10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers or polyethylene	0.90946	0.00060	0.91066
hcia5est12p_2_2_5_3	29.318 kg ^{235}U, 85% enriched, 10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers, 500 g polyethylene	0.90458	0.00065	0.90588
hcf25est12_2_2_7_3	34.749 kg ^{235}U, 95% enriched,10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers or polyethylene, CSI=0.4	0.90669	0.00066	0.90801
hcf25est12p_2_2_7_3	34.749 kg ^{235}U, 95% enriched, 10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers, 500 g polyethylene, CSI=0.4	0.91112	0.00064	0.91240
hcf25est12_2_2_5_3	29.318 kg ^{235}U, 80% enriched,10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers or polyethylene, CSI=0.4	0.85393	0.00069	0.85831
hcf25est12p_2_2_5_3	29.318 kg ^{235}U, 80% enriched, 10 slugs per can, d=1.5625 in., h=2.0624 in., with spacers, 500 g polyethylene, CSI=0.4	0.85621	0.00056	0.85733

From the results of the array package cases for HEU metal slugs, modeling 500 g of polyethylene surrounding the HEU metal is as or slightly less reactive than no polyethylene.

The CSI determinations provided in this section are contingent upon satisfactory results under the HAC evaluation (Sect. 6.6.1).

6.5.2 HEU Broken Metal; Solid HEU Metal of Unspecified Geometric Shape and Characterized as Broken Metal; or Turnings, Fines, or Powder

The ^{235}U (or U) evaluation limits listed in the column headings of Tables 6.1c and 6.1d represent the maximum amount of ^{235}U (or U) permissible in a flooded, reflected CV for maintaining an adequate margin of subcriticality. These potential loading limits are taken into consideration for the determination of the fissile mass loading limit specified for a given CSI over a specified enrichment range. Under the subheading "Standards for arrays of fissile material packages (§ 71.59)," the fissile mass loading limits are identified for HEU broken metal in Table 6.1c and for HEU metal turnings, fines, or powder in Table 6.1d.

Consider the enrichment range >95 to 100 wt % ^{235}U. Comparison of results in Table 6.9.6-10 for Case **cvr3lha_26_1_8_15** (broken metal without canned spacers) and for Case **cvr3lha_36_2_8_15** (broken metal with canned spacers) reveals a considerable increase in the fissile mass loading from 25,894-g to 35,142-g ^{235}U is possible when 277-4 canned spacers are used. This result suggests the possibility of canned spacers not being required for certain packaging array configurations with broken metal. However, the comparison of results for Case **cvr3cha_8_1_8_15** without canned spacers and Case **cvr3cha_10_2_8_15** with canned spacers indicates only a minor increase from 7,398-g to 9,248-g ^{235}U in the fissile mass loading of metal turnings, fines, or powder might be possible if 277-4 canned spacers are used. The evaluation of the NCT and HAC array configuration for establishing the CSI = 0 for the ES-3100 package with broken metal (Table 6.9.6-11) reveals that 277-4 canned spacers are required in packages with enrichments >80% (Cases **nciabmt11_4_1_5_3** and **hciabmt12_4_1_5_3**).

Like arrays of packages with solid HEU metal shapes, the neutron multiplication factor for arrays of packages with HEU broken metal, turnings, fines, or powder decreases as a function of MOIFR and increases as a function of the ^{235}U mass. Consider the ES-3100 package loaded with three convenience cans for a total of 35,142-g ^{235}U and no canned spacers between content locations. The $k_{eff} + 2\sigma$ values range from 1.138 to 0.913 with increasing MOIFR [Cases **nciabmt11_36_1_8_1** through **nciabmt11_36_1_8_15** (Appendix 6.9.6, Table 6.9.6-11)]. The introduction of water above MOIFR = 0.01 shows the effect of isolating the individual array units from each other. Array reactivity ($k_{eff} + 2\sigma = 0.913$) approaches the reactivity of the water-saturated, water-reflected single package Case **ncsrbmt11_36_1_15** ($k_{eff} + 2\sigma = 0.891$).

In the series of calculations using the ES-3100 package model with NCT geometry (Cases **nciabmt11_1_*n*_*m*_3** through **nciabmt11_*36*_*n*_*m*_3**), the enrichment of the content is varied from 19 wt % to 100 wt % ^{235}U. These array cases with a water fraction of MOIFR = 1E-04 pertain specifically to NCT packages where both the neutron poison of the body weldment liner inner cavity and the Kaolite are dry (in the as-manufactured condition) and both the recesses of the package external to the CV and the interstitial space between the drums of the array do not contain any residual moisture. As stated before, this NCT case is more reactive than all other NCT cases where more moisture is present in the Kaolite and recesses of the package. Increased interspersed water between the CVs in the array will reduce neutronic interaction between the flooded contents to a point where the packages of the array become isolated.

Evaluation of arrays of packages with HEU broken metal and canned spacers present. For enrichments <95 wt % ^{235}U, the maximum amount of ^{235}U permissible in a flooded ES-3100 package is 25,894-g ^{235}U of the broken metal. With 277-4 canned spacers present in the NCT package, the potential fissile mass loading limit for broken metal with enrichments >95% to 100 wt % ^{235}U and for a CSI = 0 must be limited to 2,774-g ^{235}U (Case **nciabmt11_3_2_8_3**) in order for the $k_{eff} + 2\sigma$ value (= 0.904) to be below the USL of 0.925. Suitability of this 2,774-g ^{235}U fissile mass loading limit for a CSI = 0, which is based

on an infinite array of NCT packages, is contingent upon the infinite array of damaged packages also being adequately subcritical for HAC (Sect. 6.6.2).

For NCT arrays loaded with broken metal content, (excluding turnings, fines, or powder) with 500 g of polyethylene and with canned spacers, calculations were performed for various enrichments with a CSI of 0.0, 0.4, 0.8, 2.0, and 3.2. The original broken metal models were used for these calculations. These models were modified by adding 500 g of polyethylene, modifying the format of the input decks to run on SCALE 6.1.3, and adding more particles. The results for the highest broken metal mass are found in Table 6.24, with all cases shown to be below the USL. The results of all of these calculations are found in Table 6.9.6-11a. Cases **nciambt11_14_2_6_3**, **nciambt11_18_2_5_3**, and **nciambt11_22_2_4_3** were rerun modeling no polyethylene for comparison purposes. The $k_{eff} + 2\sigma$ results of these cases are lower than the cases modeled with polyethylene shown in Table 6.24. The results of the no polyethylene cases, with $k_{eff} + 2\sigma$ of 0.92757, 0.92695, and 0.92708 respectively, are less than the polyethylene cases in Table 6.24.

The loading limits for solid HEU metal of unspecified geometric shape or for HEU broken metal are summarized in Table 6.2a based on array calculations performed using the uniform dispersal approximation "**cha**" model (Fig. 6.9.1-5d). The calculation results on which the determination of the loading limits is based are summarized in Table 6.1c.

As discussed in Appendix 6.9.1, the "**cha**" model is a first-order approximation model. The 500 g polyethylene representing the use of hydrogenous packing material is replaced with water in the flooded CV. Broken metal and water is homogenized as a uranium "solution" and uniformly dispersed over the entire volume of the CV. The vertical location of the 277-4 canned spacers inside the CV is based on a fixed HEU packing fraction of ~0.59. The use of this large packing fraction results in minimum separation between canned spacers, which minimizes the size of the lower and middle content locations and maximizes the size of the upper content location. Reactivity of the CV is driven by the oversized upper content location having a proportionately greater amount of fissile material. Conversely, the use of a small packing fraction (~0.2) in the "**cha**" model would result in greater separation between the canned spacers, which increases the size of the lower and middle content locations, while reducing the size of the upper content location. Reactivity of the CV would decrease as the proportions of fissile material in the content regions equalize. Calculations based on a packing fraction of ~0.59 bound similar cases based on lower packing fractions.

The "**cha**" model is characteristic of the situation where the dimensions of the broken metal pieces are sufficiently small to allow pieces of HEU to pass between the void spaces formed between the inner wall of the CV and the exterior wall of the canned spacers.

As shown in Fig. 6.9.3.1-3, HEU broken metal content typically consists of irregular pieces, sufficiently large (0.5 in. to several inches on a side), that will not pass between the 277-4 canned spacer locations. The packing fraction calculation model "**fl**" and the dispersed content calculation model "**fd**" better represent broken metal content which does not pass between the canned spacer locations. Inside the CV, the content locations between canned spacers are established based on a variable packing fraction for HEU broken metal ranging from 0.2 to 0.6. The 500 g polyethylene is included in the flooded CV. HEU broken metal, polyethylene and water are homogenized as a uranium "solution" residing within the content locations (Figs. 6.9.1-5e and 6.9.1-5f) rather than distributed uniformly over the CV (Fig. 6.9.1-5d). The "**fl**" model defines the upper content location based on packing fraction, while the "**fd**" model defines the upper content location as the entire region above the upper canned spacer.

Table 6.24. Array, NCT package model, broken metal mixed with 500 g polyethylene, with canned spacers

Case	Enrichment (%)	U mass (kg)	^{235}U mass (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
CSI=0.0							
nciabmt11p_14_2_6_3	100	3.6	3.600	0.93403	0.00082	0.93567	0.93680
nciabmt11p_19_2_5_3	95	4.1	3.895	0.93404	0.00080	0.93564	0.93680
nciabmt11p_22 2_4_3	90	4.6	4.140	0.93097	0.00068	0.93233	0.93680
nciabmt11p_32 2_3_3	80	6.1	4.880	0.93095	0.00069	0.93233	0.93680
nciabmt11p_45 2_2_3	70	9.4	6.580	0.93165	0.00076	0.93317	0.93520
nciabmt11p_52 1_1_3	60	14.1	8.460	0.93232	0.00068	0.93368	0.93520
CSI=0.4							
ncf1bmt11p_19_2_6_3	100	5.9	5.900	0.93244	0.00077	0.93398	0.93520
ncf1bmt11p_24_2_5_3	95	7.3	6.935	0.93391	0.00090	0.93571	0.93520
ncf1bmt11p_30_2_4_3	90	9.4	8.460	0.93125	0.00079	0.93283	0.93520
ncf1bmt11p_42_2_3_3	80	13.8	11.040	0.93232	0.00073	0.93378	0.93520
ncf1bmt11p_57_2_2_3	70	21.8	15.260	0.93327	0.00074	0.93475	0.93520
ncf1bmt11p_68_2_1_3	60	32.9	19.740	0.93189	0.00067	0.93323	0.93520
CSI=0.8							
ncf2bmt11p_20_2_6_3	100	10.5	10.500	0.93370	0.00073	0.93516	0.93520
ncf2bmt11p_27_2_5_3	95	13.5	12.825	0.93227	0.00088	0.93403	0.93520
ncf2bmt11p_40_2_4_3	90	17.4	15.660	0.93310	0.00100	0.93510	0.93520
ncf2bmt11p_56_2_3_3	80	25.6	20.480	0.93371	0.00071	0.93513	0.93520
ncf2bmt11p_71_2_2_3	70	35.4	24.780	0.93224	0.00070	0.93364	0.93520
ncf2bmt11p_73_2_1_3	60	36.0	21.600	0.90441	0.00073	0.90587	0.93520
CSI=2.0							
ncf3bmt11p_20_2_6_3	100	17.5	17.500	0.93207	0.00069	0.93345	0.93520
ncf3bmt11p_32_2_5_3	95	22.4	21.280	0.93353	0.00066	0.93485	0.93520
ncf3bmt11p_45_2_4_3	90	27.5	24.750	0.93263	0.00073	0.93409	0.93520
ncf3bmt11p_58_2_3_3	80	36.0	28.800	0.93205	0.00065	0.93335	0.93520
ncf3bmt11p_58_2_2_3	70	36.0	25.200	0.90459	0.00072	0.90603	0.93520
ncf3bmt11p_58_2_1_3	60	36.0	21.600	0.87663	0.00070	0.87803	0.93520
CSI=3.2							
ncf4bmt11p_20_2_6_3	100	27.4	27.400	0.93306	0.00068	0.93442	0.93520
ncf4bmt11p_34_2_5_3	95	32.6	30.970	0.93087	0.00086	0.93259	0.93520
ncf4bmt11p_42_2_4_3	90	36.0	32.400	0.92744	0.00076	0.92896	0.93520
ncf4bmt11p_42_2_3_3	80	36.0	28.800	0.90042	0.00074	0.90190	0.93520
ncf4bmt11p_42_2_2_3	70	36.0	25.200	0.87283	0.00061	0.87405	0.93520
ncf4bmt11p_42_2_1_3	60	36.0	21.600	0.84553	0.00064	0.84681	0.93520

NCT cases for the "**fl**" and "**fd**" calculation models are documented in Table 6.9.6-11b. The reference case results based on the uniform dispersal approximation "**cha**" model are highlighted. The corresponding cases for the packaging fraction ("**fl**") and for the dispersed content ("**fd**") calculation models are given in the rows below the reference case. Consider Case **nciabmt11_4_1_5_3** where the quantity of HEU content in the model is calculated based on a discrete number of 1-in. cubes. The HEU in corresponding Cases **nciapbmflt11_1_*n*_4_5** and **nciapbmfdt11_1_*n*_4_5** is not limited to fractional kilogram quantities based on whole cubes as in Case **nciabmt11_4_1_5_3**. Instead, the intended whole kilogram quantities of HEU are evaluated as a function of the packing fraction ("***n***") in the ". . . flt11_1_***n***_ . . ." and ". . . fdt11_1_***n***_ . . ." cases.

An increase of ~0.08 in the k_{eff} + 2σ value is observed as the packing fraction is reduced and more water is homogenized with the fissile material, (i.e., Cases **nciapbmtfl11_1_6_4_5** through **nciapbmtfl11_1_2_4_5**, Table 6.9.6-11b). As the packing fraction is reduced and the volume of the content location increases accordingly, neutron multiplication increases due to increased moderation of the fissile material. A considerable increase of ~0.22 in the k_{eff} + 2σ value is observed when fissile material in the upper can location is homogenized with water in the upper content location and dispersed over that region, (i.e., Case **nciapbmtfl11_1_6_4_5** vs Case **nciapbmtfd11_1_6_4_5**, Table 6.9.6-11b). Nevertheless, the k_{eff} + 2σ values for the packaging fraction "**fl**" and dispersed content calculation "**fd**" models are lower than values for the corresponding uniform dispersal approximation "**cha**" model. The "**cha**" model evaluated without polyethylene bounds results for the more realistic "**fl**" and "**fd**" models evaluated with 500 g polyethylene and the HEU content of the package confined to the specific content locations.

Powder, particulate, or small pieces of HEU potentially present in broken metal are capable of passing between content locations. The quantity of this material, potentially present, represents a small fraction of the total HEU broken metal content. The placement of a limit on content size for criticality control is adopted as a package content loading restriction (Sect. 6.2.4, Item 6). Moreover, the loading limits for broken metal content established based on the "**cha**" model are retained, recognizing that the use of polyethylene is not addressed in "**cha**" model.

Evaluation of arrays of packages with HEU broken metal, turnings, fines, or powder, and no canned spacers. For enrichments 70 to 80 wt % ^{235}U, the maximum amount of ^{235}U permissible in a flooded ES-3100 package is 27,443-g ^{235}U for broken metal or 19,284-g ^{235}U for metal turnings, fines, or powder. As discussed in Sect. 6.4.2, credit for the presence of 277-4 canned spacers for criticality safety cannot be taken when determining the loading limits for metal turnings, fines, and powder. Without 277-4 canned spacers present in the NCT package containing broken metal, turnings, fines, or powder, the potential fissile mass loading limit over the range 70 to 80 wt % ^{235}U and for a CSI = 0 must be 2,967-g ^{235}U (Case **nciabmt11_4_1_5_3**) in order for the k_{eff} + 2σ value (0.921) to be below the USL of 0.925. Suitability of this 2,967-g ^{235}U fissile mass loading limit for a CSI = 0, which is based on an infinite array of NCT packages, is contingent upon an infinite array of damaged packages also being adequately subcritical for HAC (Sect. 6.6.2).

For NCT arrays loaded with the broken metal content, including turnings, fines, or powder with 500 g of polyethylene and with no canned spacers, calculations were performed for various enrichments with a CSI of 0.0, 0.4, 0.8, 2.0, and 3.2. The original broken metal models were used for these calculations. These models were modified by adding 500 g of polyethylene, modifying the format of the input decks to run on SCALE 6.1.3, and adding more particles. The results for the highest broken metal mass are found in Table 6.25, with all cases shown to be below the USL. The results of all of these calculations are found in Table 6.9.6-12a.

Table 6.25. Array, NCT package model, broken metal (including turnings, fines, or powders) mixed with 500 g polyethylene, with no canned spacers

Case	Enrichment (%)	U mass (kg)	^{235}U mass (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
CSI=0.0							
nciabmt11p_5_1_6_3	100	2.6	2.600	0.93264	0.00081	0.93426	0.93680
nciabmt11p_8_1_5_3	95	2.9	2.755	0.93326	0.00069	0.93464	0.93680
nciabmt11p_11 1_4_3	90	3.2	2.880	0.93401	0.00074	0.93549	0.93680
nciabmt11p_18 1_3_3	80	4.0	3.200	0.93356	0.00067	0.93490	0.93680
nciabmt11p_27 1_2_3	70	5.1	3.570	0.93247	0.00065	0.93377	0.93680
nciabmt11p_39 1_1_3	60	7.2	4.320	0.93473	0.00078	0.93629	0.93680
CSI=0.4							
ncf1bmt11p_5_1_6_3	100	4.0	4.000	0.93470	0.00094	0.93658	0.93680
ncf1bmt11p_9_1_5_3	95	4.6	4.370	0.93504	0.00072	0.93648	0.93680
ncf1bmt11p_15_1_4_3	90	5.4	4.860	0.93423	0.00077	0.93577	0.93680
ncf1bmt11p_24_1_3_3	80	7.3	5.840	0.93242	0.00072	0.93386	0.93520
ncf1bmt11p_35_1_2_3	70	10.5	7.350	0.93351	0.00073	0.93497	0.93520
ncf1bmt11p_50_1_1_3	60	17.3	10.380	0.93319	0.00074	0.93467	0.93520
CSI=0.8							
ncf2bmt11p_4_1_6_3	100	6.2	6.200	0.93336	0.00078	0.93492	0.93520
ncf2bmt11p_9_1_5_3	95	7.7	7.315	0.93341	0.00082	0.93505	0.93520
ncf2bmt11p_15_1_4_3	90	9.5	8.550	0.93295	0.00075	0.93445	0.93520
ncf2bmt11p_31_1_3_3	80	14.2	11.360	0.93189	0.00079	0.93347	0.93520
ncf2bmt11p_48_1_2_3	70	21.8	15.260	0.93082	0.00076	0.93234	0.93520
ncf2bmt11p_66_1_1_3	60	34.5	20.700	0.93148	0.00064	0.93276	0.93520
CSI=2.0							
ncf3bmt11p_5_1_6_3	100	10.7	10.700	0.93343	0.00074	0.93491	0.93520
ncf3bmt11p_13_1_5_3	95	14.0	13.300	0.93298	0.00079	0.93456	0.93520
ncf3bmt11p_24_1_4_3	90	17.9	16.110	0.93323	0.00067	0.93457	0.93520
ncf3bmt11p_39_1_3_3	80	25.4	20.320	0.93151	0.00079	0.93309	0.93520
ncf3bmt11p_58_1_2_3	70	36.0	25.200	0.93377	0.00063	0.93503	0.93520
ncf3bmt11p_58_1_1_3	60	36.0	21.600	0.90595	0.00066	0.90727	0.93520
CSI=3.2							
ncf4bmt11p_21_1_6_3	100	19.1	19.100	0.93303	0.00088	0.93479	0.93520
ncf4bmt11p_34_1_5_3	95	24.8	23.560	0.93374	0.00067	0.93508	0.93520
ncf4bmt11p_42_1_4_3	90	29.0	26.100	0.93225	0.00071	0.93367	0.93520
ncf4bmt11p_42_1_3_3	80	36.0	28.800	0.92674	0.00076	0.92826	0.93520
ncf4bmt11p_42_1_2_3	70	36.0	25.200	0.90203	0.00071	0.90345	0.93520
ncf4bmt11p_42_1_1_3	60	36.0	21.600	0.87562	0.00077	0.87716	0.93520

Repetitious use of the evaluation technique. This evaluation technique for determination of mass loading limits for enrichment intervals is repeated over the range of HEU enrichments identified in Tables 6.1c and 6.1d.

6.5.3 HEU Oxide

Like packages with HEU metal or broken metal, the neutron multiplication factor for an NCT array of packages with HEU product oxide decreases as a function of decreasing ^{235}U mass [parametric Cases **nciapdoxt11_1_*n*_24_3**, **nciapdoxt11_1_*n*_20_3**, **nciapdoxt11_1_*n*_15_3**, **nciapdoxt11_1_*n*_12_3**, **nciapdoxt11_1_*n*_11_3**, and **nciapdoxt11_1_1_10_3** through **nciapdoxt11_1_1_6_3** (Table 6.9.6-13b)]. For these NCT cases, the MOIFR is set at 1.0E-04 such that neutronic interaction between packages of an array is maximized. Results for the parametric cases reveal the same consistent increase in the $k_{eff} + 2\sigma$ values with decreasing bulk density as observed in the single package calculation results (Sect. 6.4.3). Results for Cases **nciapdoxt11_1_*n*_11_3** and **nciapdoxt11_1_1_10_3** through **nciapdoxt11_1_1_6_3** demonstrate that over the range of HEU oxide bulk densities from 6.54 to 2.0 g/cm^3, the $k_{eff} + 2\sigma$ values are below the USL of 0.925.

Cases **nciask_1_15** through **nciask_10_15** (Appendix 6.9.6, Table 6.9.6-18) evaluate infinite arrays of packages having the 10 skull oxide compositions described in Sect. 6.4.3. The MOIFR is set at 1.0E-04 such that neutronic interaction between packages is maximized. The $k_{eff} + 2\sigma$ values, ranging from 0.656 to 0.764, are substantially below the below the USL value of 0.925, indicating that canned spacers are not required for criticality control.

The CSI is 0.0 for an infinite array of packages having product oxide content with a bulk density ≥2.0 g/cm^3 and with a maximum of 9,682-g ^{235}U or having skull oxide content with a maximum of 16,399-g ^{235}U and 921 g graphite. The suitability of this determination is contingent upon satisfactory results under the HAC evaluation (Sect. 6.6.3).

Additional calculations are performed for bulk densities from 1.75 g/cm^3 to 0.5 g/cm^3 for NCT, varying the specific gravity outside of the CV (MOIFR) from dry to fully flooded. The uranium oxide is evaluated at bulk densities of 1.75, 1.5, 1.25, 1.0, 0.75, and 0.5 g/cm^3 at 100% enrichment mixed with 500 g of polyethylene. The results for the highest oxide mass are found in Table 6.26 below, with all cases shown to be below the USL. The results of all of these calculations are found in Table 6.9.6-13d. Note that the 2.0 g/cm^3 cases are found in Appendix 6.9.9.

Table 6.26. Infinite array, NCT package model, uranium oxide mixed with 500 g polyethylene, (USL=0.935)

Case	MOIFR	Density (g/cm^3)	UO_2 Mass (kg)	^{235}U Mass (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$
ncialdoxt11_1_19_1	1.0E-20	1.75	10.75	9.4	0.9320	0.0012	0.9344
ncialdoxt11_2_16_3	1.0E-04	1.50	9.5	8.3	0.9313	0.0013	0.9339
ncialdoxt11_3_12_2	1.0E-05	1.25	8.25	7.2	0.9321	0.0013	0.9347
ncialdoxt11_4_9_1	1.0E-20	1.00	6.75	5.9	0.9290	0.0018	0.9326
ncialdoxt11_5_5_2	1.0E-05	0.75	5.5	4.8	0.9306	0.0013	0.9332
ncialdoxt11_6_1_2	1.0E-05	0.50	4.0	3.5	0.9247	0.0012	0.9271

Additional calculations were performed for uranium oxide mixed with thorium oxide and uranium oxide mixed with thorium metal oxide at the same densities as uranium oxide. Thorium is not fissile and would not increase the reactivity of this system; however, the saturated water that is in the thorium oxide model may provide a more optimum moderation configuration, especially at lower bulk densities. Calculations were also performed for uranium oxide mixed with zirconium oxide. Parametric

studies were performed for various uranium oxide loadings varying the amount of thorium oxide, thorium metal, or zirconium oxide.

In the infinite array calculations, the CV is modeled fully flooded and the NCT package is evaluated at various interstitial moderated cases. As in the CV cases, calculations are performed to exam UO_2 mixed with ThO_2, thorium metal, or ZrO_2 at bulk densities of 2.0, 1.75, 1.5, 1.25, 1.0, 0.75, and 0.5 g/cm^3 at 100% enrichment mixed with 500 g of polyethylene. The amount of ThO_2, thorium metal, or ZrO_2 that is added is dependent upon the amount of available space within the CV and the total amount of oxide allowed (13.15 kg). At lower densities, the amount of ThO_2, thorium metal, or ZrO_2 that can be added to the CV decreases with decreasing density. Unlike the CV and single package cases, as shown in Tables 6.9.6-13h, 6.9.6-13i, and 6.9.6-13j, for all bulk oxide densities, as ThO_2, thorium metal, or ZrO_2 is added, reactivity increases. The UO_2 oxide limit is not bounding for bulk densities of UO_2 mixed with ThO_2. Thus, for these densities, lower limits are required. The results for the highest oxide mass are found in Table 6.27 for thorium oxide, Table 6.28 for zirconium oxide, and Table 6.29 for thorium metal, with all cases shown to be below the USL.

Table 6.27. Infinite array, NCT package model, uranium and thorium oxide mixed with 500 g polyethylene

Case ncialdoxtho2t11_*	MOIFR	Density (g/cm^3)	UO_2 mass (kg)	ThO_2 mass (kg)	^{235}U mass (kg)	k_{eff}	σ	k_{eff} + 2σ	USL
13_1_16b	1.0E-04	2.00	11.0	5.0	9.682	0.91989	0.00076	0.92141	0.93520
14_2_15	1.0E-20	1.75	10.1	5.10	8.890	0.93268	0.00084	0.93436	0.93520
20_3_11	1.0E-20	1.50	7.75	6.75	6.822	0.93307	0.00083	0.93473	0.93520
16_4_9b	1.0E-04	1.25	6.55	5.50	5.765	0.93299	0.00067	0.93433	0.93520
10_5_6	1.0E-20	1.00	5.50	4.15	4.841	0.93271	0.00069	0.93409	0.93680
6_6_4	1.0E-20	0.75	4.60	2.65	4.049	0.93468	0.00076	0.93620	0.93680
3_7_2a	1.0E-04	0.50	3.75	1.05	3.301	0.93467	0.00087	0.93641	0.93680

Table 6.28. Infinite array, NCT package model, uranium and zirconium oxide mixed with 500 g polyethylene

Case ncialdoxzro2t11_*	MOIFR	Density (g/cm^3)	UO_2 mass (kg)	ZrO_2 mass (kg)	^{235}U mass (kg)	k_{eff}	σ	k_{eff} + 2σ	USL
12_1_17a	1.0E-05	2.00	11.0	5.0	9.682	0.92528	0.00089	0.92706	0.93520
13_2_15	1.0E-20	1.75	9.55	5.65	8.406	0.93312	0.00073	0.93458	0.93520
20_3_10	1.0E-20	1.50	6.90	7.55	6.073	0.93218	0.00081	0.93380	0.93520
15_4_7a	1.0E-5	1.25	5.80	6.25	5.105	0.93286	0.00084	0.93454	0.93520
11_5_5a	1.0E-05	1.00	4.90	4.75	4.313	0.93400	0.00073	0.93546	0.93680
7_6_4a	1.0E-05	0.75	4.10	3.15	3.609	0.93290	0.00077	0.93444	0.93680
3_7_2b	1.0E-04	0.50	3.50	1.30	3.081	0.93291	0.00087	0.93465	0.93680

Table 6.29. Infinite array, NCT package model, uranium and thorium metal mixed with 500 g polyethylene

Case ncialdoxthmt11_*	MOIFR	Density (g/cm^3)	UO_2 mass (kg)	Th mass (kg)	^{235}U mass (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
13_1_16a	1.0E-05	2.00	11.0	5.0	9.682	0.91940	0.00076	0.92092	0.93520
14_2_15	1.0E-20	1.75	10.1	5.10	8.890	0.93229	0.00079	0.93387	0.93520
20_3_11	1.0E-20	1.50	7.70	6.78	6.822	0.93325	0.00087	0.93499	0.93520
16_4_9a	1.0E-05	1.25	6.55	5.50	5.765	0.93166	0.00070	0.93306	0.93520
10_5_6	1.0E-20	1.00	5.50	4.15	4.481	0.93186	0.00084	0.93354	0.93680
6_6_4b	1.0E-04	0.75	4.60	2.65	4.049	0.93312	0.00080	0.93472	0.93680
3_7_2a	1.0E-05	0.50	3.75	1.05	3.301	0.93465	0.00089	0.93643	0.93680

6.5.4 UNH Crystals

Unlike the HEU metal, broken metal, or oxide content, UNH crystals are soluble in water (Sect. 6.4.4). The most reactive content condition occurs at an optimum solution concentration derived from the UNH crystal loading and the volume of water flooding the CV. Both flooding of the CV and a reduced loading of UNH crystals going into solution is required to achieve the most reactive configuration.

Similar to packages with HEU metal, broken metal, or oxide, the neutron multiplication factor for an array of packages with UNH crystals decreases as a function of increasing MOIFR. Cases **nciaunhct11_8_24_1_1** through **nciaunhct11_8_24_1_15** for content without polyethylene and Cases **nciapunhct11_24_1** and **nciapunhct11_24_15** for content with 500 g polyethylene (Table 6.9.6-15) reveal the effect of isolating the individual array units from each other with the introduction of water above ~0.01 MOIFR. Array reactivity ($k_{eff} + 2\sigma = 0.721$ without polyethylene and 0.729 with polyethylene) approaches the reactivity of the water-saturated, water-reflected single-unit package ($k_{eff} + 2\sigma = 0.702$ without polyethylene and 0.708 with polyethylene).

In a series of NCT calculations (Cases **nciapunhct11_*nn*_3**), the $k_{eff} + 2\sigma$ values are above the USL of 0.925 for mass loadings between 8,000 and 24,000-g UNH crystals. Credit is not taken for water tightness that is demonstrated by the NCT (and HAC) tests. Therefore, mass loading is limited to 7,000-g UNH crystals. The CSI is 0.0 [10 CFR 71.59(a)(1) and 10 CFR 71.59(b)] for ES-3100 packages having a maximum of 3,297-g ^{235}U. The suitability of this determination depends upon satisfactory results under the HAC evaluation of Sect. 6.6.4 [10 CFR 71.59(a)(2) and 10 CFR 71.59(b)].

The $k_{eff} + 2\sigma$ values are expected to range from subcritical to critical for array configurations where UNH crystals are dissolved in the water flooding the CV and the CV well. This requires intrusion of water into the CV, dissolving of UNH crystals in the influent, and leakage of solution out of the CVs in each package of an array (catastrophic failure of all packages in an infinite array). Given that loss of containment is deemed not credible by merit of the 10 CFR 71.71 and 10 CFR 71.73 tests performed on the ES-3100, this accident condition is not credible.

For Cases **ncf1punhct12_*nn*_3**, the $k_{eff} + 2\sigma$ values are below the USL of 0.925. Given that the results for NCT and HAC (Sect. 6.6.4) are adequately subcritical, packages may be shipped under a CSI = 0.4 for packages with a maximum of 24,000-g UNH crystals [10 CFR 71.59(a)(1) and

10 CFR 71.59(b)]. Likewise, the suitability of this determination depends upon satisfactory results under the HAC evaluation of Sect. 6.6.4.

6.6 EVALUATION OF PACKAGE ARRAYS UNDER HYPOTHETICAL ACCIDENT CONDITIONS

Except for UNH crystals, the package content is confined within the CV for the HAC array evaluation of ES-3100 packages, consistent with the result of the tests specified in 10 CFR 71.73 (Hypothetical Accident Conditions). The array sizes examined in this evaluation are infinite, 13×13×6, 9×9×4, 7×7×3, 5×5×2, ETP 16×3, and the degenerate single unit. The "N" and corresponding CSI values for arrays determined to be adequately subcritical are as follows: N = ∞, CSI = 0; N =162, CSI = 0.4; N = 73, CSI = 0.7; N = 25, CSI = 2.0; and N = 24, CSI = 2.1. All arrays, except the infinite array, are reflected with 30 cm (1 ft) of water. These array are nearly cubic in shape for optimum reactivity of the array, thus eliminating the need for placing criticality controls on package arrangements in terms of stack height, width, and depth of an array. The array configurations and the range of water contents (Table 6.4) evaluated bound all possible packaging arrangements and moderation conditions for HAC.

For the single damaged package, and for infinite and finite arrays of damaged packages with HEU metal, HEU oxide, or UNH crystal content, the neutron multiplication factor changes as a function of the ^{235}U mass, MOIFR, or applicable solution concentration in the same manner as in an array of undamaged packages.

6.6.1 Solid HEU Metal of Specified Geometric Shapes

For infinite and finite arrays of damaged packages with HEU metal, the neutron multiplication factor increases as a function of the ^{235}U mass and decreases as a function of MOIFR. For example, consider the ES-3100 package loaded with three convenience cans that contain a 3.24-in.-diam cylinder with 12,000-g ^{235}U for a total of 36,000-g ^{235}U. For package content without 277-4 canned spacers, the $k_{eff} + 2\sigma$ values range from 1.027 to 0.967 with increasing MOIFR in the damaged packages [Cases **hciacyct12_36_1_1** through **hciacyt12_36_1_15** (Appendix 6.9.6, Table 6.9.6-3)]. For package content with 277-4 canned spacers, the $k_{eff} + 2\sigma$ values range from 0.956 to 0.884 with increasing MOIFR in the damaged package [Cases **hciacyt12_36_2_1** through **hciacyt12_36_2_15** (Appendix 6.9.6, Table 6.9.6-3)].

The introduction of water above ~0.01 MOIFR shows the effect of isolating the individual array units from each other. The neutron multiplication factor approaches k_{eff} for the single, water-reflected unit at a full content-water fraction (MOIFR = 1.0). Comparison of these results with the corresponding NCT cases (Sect. 6.5.1) indicates no significant differences. This result is as expected given that the neutron multiplication in an infinite array is independent of pitch between fissile contents but is dependent on changes in mass and moderation in the array. The changes in both the outer dimensions and the compositions of the Kaolite and 277-4 of the ES-3100 package due to HAC result in changes to the neutron multiplication factor on the order of ~0.001 to 0.002.

Repeated for 4.25-in.-diam cylinders (Appendix 6.9.6, Table 6.9.6-7); 2.29-in.-square bars (Table 6.9.6-5); and 1.5-in.-diam × 2-in.-tall slugs (Table 6.9.6-9), this type of analysis for the 3.24-in.-diam cylinders demonstrates that arrays of damaged packages with restricted fissile material (^{235}U) loading remain subcritical over the entire range of water content or MOIFR. HEU metal or alloy content not covered by the specified geometric shapes (cylinder, square bar, or slug contents) will be in the HEU broken metal category, and so limited.

For the two types of annular cylinders, the NCT cases for an infinite array of packages, the CV is modeled fully flooded and the interstitial water moderation is modeled at MOIFR = 1E-04. Each cylinder is modeled at the bottom of the CV. Case **nciacylc11** for Cylinder C has a calculated $k_{eff} \pm 2\sigma$ value of 0.83219 (k_{eff} = 0.83107, σ = 0.00056), while Case **nciacyld11** for Cylinder D has a calculated $k_{eff} \pm 2\sigma$ value of 0.85387 (k_{eff} = 0.85241, σ = 0.00073). Additional cases were run with the cylinder modeled vertically centered in the CV. Case **nciacylcc11** for Cylinder C has a calculated $k_{eff} \pm 2\sigma$ value of 0.80889 (k_{eff} = 0.80727, σ = 0.00081), while Case **nciacyldc11** for Cylinder D has a calculated $k_{eff} \pm 2\sigma$ value of 0.82521 (k_{eff} = 0.82393, σ = 0.00064).

For the HAC cases for an infinite array of damaged packages (Appendix 6.9.6, Table 6.9.6-3d), the CV is modeled fully flooded and the interstitial water moderation is modeled at MOIFR = 1E-04. Each cylinder is modeled at the bottom of the CV. Case **hciacylc12** for Cylinder C has a calculated $k_{eff} \pm 2\sigma$ value of 0.83238 (k_{eff} = 0.83124, σ = 0.00057), while for Case **hciacyld12** for Cylinder D has a calculated $k_{eff} \pm 2\sigma$ value of 0.85459 (k_{eff} = 0.85343, σ = 0.00058). Additional cases were run with the cylinder modeled vertically centered in the CV. Case **hciacylcc**12 for Cylinder C has a calculated $k_{eff} \pm 2\sigma$ value of 0.80679 (k_{eff} = 0.80557, σ = 0.00061), while Case **hciacyldc12** for Cylinder D has a calculated $k_{eff} \pm 2\sigma$ value of 0.82510 (k_{eff} = 0.82380, σ = 0.00065).

All Cylinder C and D infinite array cases were shown to be below the USL of 0.9352, with the models in which the cylinders are at the bottom of the CV being the most reactive.

Cases **hciatriga_1_1_3** through **hciatriga_1_15_3** (Appendix 6.9.6, Table 6.9.6-20) represent infinite arrays of damaged packages containing the bounding TRIGA fuel content (20 % enrichment with 45 wt % U containing 307-g ^{235}U), without 277-4 canned spacers. For these cases, the $k_{eff} + 2\sigma$ values increase from 0.218 to 0.526 as MOIFR increases. The $k_{eff} + 2\sigma$ = 0.526 for Case **hciatriga_1_15_3** is substantially below the USL of 0.925, indicating that canned spacers are not required for criticality control. Given that the results for NCT (Sect. 6.5.2) and HAC are adequately subcritical, packages with TRIGA fuel content ≤ 921-g ^{235}U may be shipped under a CSI = 0.

As stated in Sect. 6.5.1, calculation results presented in Table 6.9.6-20d for an infinite array of ES-3100 packages (NCT packaging with extremely damaged TRIGA fuel content) is substantially below the USL of 0.925. Similar results are expected for an infinite array of ES-3100 packages (HAC packaging with extremely damaged TRIGA fuel content) given that changes external to the CV due to the HAC do not result in an appreciable change in the neutron multiplication for the an array of packages. Therefore, the 10 CFR 71.55(e)(1) requirement that the package be adequately subcritical under HAC with the package contents in the most reactive credible configuration is satisfied.

The array results for three slug configurations presented in Table 6.9.6-9 (Appendix 6.9.6) are for five or ten slugs touching or spaced apart in a pentagonal ring (Cases **hcia5st12** and **hcia5est12**) and for seven slugs formed by a hexagonal ring of slugs with one slug in the center of the ring **(hcia70st12**). These cases are used to establish the mass loading limitations for damaged packages, which in turn limit the number of slugs in the package to less than the number required to assemble a critical configuration.

Cases **hcia5est12_1_1_8_3** through **hcia5est12_1_1_1_3** and Cases **hcia5st12_1_1_8_3** through **hcia5st12_1_1_1_3** (Appendix 6.9.6, Table 6.9.6-9) represent infinite arrays of damaged packages containing 18,277-g U without 277-4 canned spacers. Infinite array Cases **hcia70st11_2_8_3** through **hcia70st11_2_1_3** represent damaged packages containing 25,588-g U with 277-4 canned spacers, while Cases **hcia5est12_2_2_8_3** through **hcia5est12_2_2_1_3** represent damaged packages containing 36,558-g U also with 277-4 canned spacers. Cases **hcf25est12_2_2_8_3** through **hcf25est12_2_2_1_3** represent a 9 × 9 × 4 array of damaged packages containing 36,558-g U with 277-4 canned spacers. The $k_{eff} + 2\sigma$ values for these cases representing arrays of damaged packages are slightly less than values for the corresponding cases representing undamaged packages. (The changes in both the outer dimensions of

the package and the compositions of the Kaolite and 277-4 due to HAC result in an ~0.001 change in the neutron multiplication factor.) Therefore, the prospective CSI values determined in the NCT evaluation (Sect. 6.5.1) for arrays of undamaged packages with slug content are controlling.

6.6.2 HEU Broken Metal; Solid HEU Metal of Unspecified Geometric Shape and Characterized as Broken Metal; or Turnings, Fines, or Powder

The evaluation of various HAC array configurations for establishing the CSI for packages with broken metal (Table 6.9.6-11) reveals that 277-4 canned spacers are required in packages with enrichments >80%. As discussed in Sect. 6.4.2, credit for the presence of canned spacers required for criticality safety cannot be taken when determining the loading limits for HEU metal turnings, fines, or powder. An evaluation of HEU metal turnings, fines, or powder with enrichments ranging from 80% to 100% is presented in Appendix 6.9.11.

Like arrays of packages with solid HEU metal shapes, the neutron multiplication factor for arrays of packages with HEU broken metal, turnings, fines, or powder decreases as a function of MOIFR and increases as a function of the ^{235}U mass. Consider the ES-3100 package loaded with three convenience cans for a total of 35,142-g ^{235}U with no canned spacers between content locations. The $k_{eff} + 2\sigma$ values range from 1.14 to 0.939 with increasing MOIFR, Cases **hciabmt12_36_1_8_1** through **hciabmt12_36_1_8_15** (Appendix 6.9.6, Table 6.9.6-11). The introduction of water above MOIFR = 0.01 shows the effect of isolating the individual array units from each other. Array reactivity ($k_{eff} + 2\sigma = 0.939$) approaches the reactivity of the water-saturated, water-reflected single package ($k_{eff} + 2\sigma = 0.891$, Case **hcsrbmt12_36_1_15**, Table 6.9.6-11).

Cases **hciabmt12_1_*nn_mm*_3** through **hciabmt12_36_*nn_mm*_3** model the ES-3100 with the reduced-diameter HAC package model where the enrichment of the content is varied from 60 wt % to 100 wt % ^{235}U. These array cases with MOIFR = 1E-04 pertain specifically to HAC packages where the neutron poison of the body weldment liner inner cavity is at 90% moisture content, but the Kaolite is dry (in the as-manufactured condition), and neither recess of the package external to the CV and the interstitial space between the drums of the array contains any residual moisture. As stated before, this HAC case is more reactive than all other HAC cases where more moisture is present in the Kaolite and recesses of the package. Increasing the interspersed water between the CVs in the array will reduce neutronic interaction between the flooded contents to a point where the packages of the array become isolated.

Evaluation of arrays of packages with HEU broken metal and canned spacers present. For enrichments < 95 wt % ^{235}U, the maximum amount of ^{235}U permissible in a flooded ES-3100 package is 25,894-g ^{235}U in the broken metal. With 277-4 canned spacers present in the HAC package, the potential fissile mass loading limit for broken metal >95 to 100 wt % ^{235}U and for a CSI = 0 must be limited to 2,774-g ^{235}U (Case **hciabmt12_3_2_8_3**) in order for the $k_{eff} + 2\sigma$ value (= 0.905) to be below the USL of 0.925. Given that the results for NCT (Sect. 6.5.2) and HAC are adequately subcritical, packages ≤ 2,774-g ^{235}U and enrichment >95 wt % ^{235}U may be shipped under a CSI = 0.

For HAC arrays loaded with the broken metal content, (excluding turnings, fines, or powder) with 500 g of polyethylene and with canned spacers, calculations were performed for various enrichments with a CSI of 0.0, 0.4, 0.8, 2.0, and 3.2. The original broken metal models in this SARP were used for these calculations. These models were modified by adding 500 g of polyethylene, modifying the format of the input decks to run on SCALE 6.1.3, and adding more particles. The results for the highest broken metal mass are found in Table 6.30 below, with all cases shown to be below the USL. The results of all of these calculations are found in Table 6.9.6-11a.

Table 6.30. Infinite array, HAC package model, broken metal mixed with 500 g polyethylene, with canned spacers

Case	Enrichment (%)	U mass (kg)	^{235}U mass (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
CSI=0.0							
hciabmt12p_14_2_6_3	100	3.6	3.600	0.93421	0.00075	0.93571	0.93680
hciabmt12p_19_2_5_3	95	4.1	3.895	0.93476	0.00087	0.93650	0.93680
hciabmt12p_22 2_4_3	90	4.6	4.140	0.93408	0.00073	0.93554	0.93680
hciabmt12p_32 2_3_3	80	6.1	4.880	0.93423	0.00075	0.93573	0.93680
hciabmt12p_45 2_2_3	70	9.4	6.580	0.93288	0.00075	0.93438	0.93520
hciabmt12p_52 1_1_3	60	14.1	8.460	0.93362	0.00070	0.93502	0.93520
CSI=0.4							
hcf2bmt12p_19_2_6_3	100	5.9	5.900	0.91192	0.00084	0.91360	0.93520
hcf2bmt12p_24_2_5_3	95	7.3	6.935	0.91251	0.00073	0.91397	0.93520
hcf2bmt12p_30_2_4_3	90	9.4	8.460	0.91020	0.00080	0.91180	0.93520
hcf2bmt12p_42_2_3_3	80	13.8	11.040	0.91108	0.00063	0.91234	0.93520
hcf2bmt12p_57_2_2_3	70	21.8	15.260	0.91105	0.00066	0.91237	0.93520
hcf1bmt12p_68_2_1_3	60	32.9	19.740	0.90727	0.00063	0.90853	0.93520
CSI=0.8							
hcf3bmt12p_20_2_6_3	100	10.5	10.500	0.91506	0.00073	0.91652	0.93520
hcf3bmt12p_27_2_5_3	95	13.5	12.825	0.91481	0.00088	0.91657	0.93520
hcf3bmt12p_40_2_4_3	90	17.4	15.660	0.91088	0.00072	0.91232	0.93520
hcf3bmt12p_56_2_3_3	80	25.6	20.480	0.91427	0.00082	0.91591	0.93520
hcf3bmt12p_71_2_2_3	70	35.4	24.780	0.91273	0.00062	0.91397	0.93520
hcf3bmt12p_73_2_1_3	60	36.0	21.600	0.88487	0.00065	0.88617	0.93520
CSI=2.0							
hcf4bmt12p_20_2_6_3	100	17.5	17.500	0.89674	0.00081	0.89836	0.93520
hcf4bmt12p_32_2_5_3	95	22.4	21.280	0.89782	0.00091	0.89964	0.93520
hcf4bmt12p_45_2_4_3	90	27.5	24.750	0.89764	0.00084	0.89932	0.93520
hcf4bmt12p_58_2_3_3	80	36.0	28.800	0.89469	0.00066	0.89601	0.93520
hcf4bmt12p_58_2_2_3	70	36.0	25.200	0.86714	0.00063	0.86840	0.93520
hcf4bmt12p_58_2_1_3	60	36.0	21.600	0.84037	0.00069	0.84175	0.93520
CSI=3.2							
hcf5bmt12p_21_2_6_3	100	27.4	27.400	0.91421	0.00065	0.91551	0.93520
hcf5bmt12p_34_2_5_3	95	32.6	30.970	0.91324	0.00071	0.91466	0.93520
hcf5bmt12p_42_2_4_3	90	36.0	32.400	0.90769	0.00062	0.90893	0.93520
hcf5bmt12p_42_2_3_3	80	36.0	28.800	0.87995	0.00064	0.88123	0.93520
hcf5bmt12p_42_2_2_3	70	36.0	25.200	0.85513	0.00075	0.85663	0.93520
hcf5bmt12p_42_2_1_3	60	36.0	21.600	0.82746	0.00070	0.82886	0.93520

The loading limits for solid HEU metal of unspecified geometric shape or for HEU broken metal are summarized in Table 6.2a based on array calculations performed using the uniform dispersal approximation "**cha**" model (Fig. 6.9.1-5d). The calculation results on which the determination of the loading limits is based are summarized in Table 6.1c.

As discussed in Sect. 6.5.2, criticality calculations with the "**cha**" model for a packing fraction of ~0.59 bound similar cases at the lower packing fractions. The "**cha**" model is characteristic of the situation where the dimensions of the broken metal pieces are sufficiently small to allow for HEU to pass between void space formed between the inner wall of the CV and the exterior wall of each canned spacer.

As shown in Fig. 6.9.3.1-3, HEU broken metal content typically consists of irregular pieces, sufficiently large (0.5 in. to several inches on a side), that will not pass between the 277-4 canned spacer locations. The packing fraction calculation model "**fl**" and the dispersed content calculation model "**fd**" better represent broken metal content which does not pass between the canned spacer locations.

HAC cases are documented in Table 6.9.6-11c. The reference case results based on the uniform dispersal approximation "**cha**" model are highlighted. The corresponding cases for the packaging fraction ("**fl**") and for the dispersed content ("**fd**") calculation models are given in the rows below the reference case.

An increase of ~0.08 in the $k_{eff} + 2\sigma$ value is observed as the packing fraction is reduced and more water is homogenized with the fissile material (i.e., Cases **hciapbmtfl11_1_6_4_5** through **hciapbmtfl11_1_2_4_5**, Table 6.9.6-11c). As the packing fraction is reduced and the volume of the content location is increased, moderation of the fissile material increases. A considerable increase of ~0.22 in the $k_{eff} + 2\sigma$ value is observed when fissile material in the upper can location is homogenized with water in the upper content location and dispersed over that region (i.e., Case **hciapbmtfl11_1_6_4_5** vs Case **hciapbmtfd11_1_6_4_5**, Table 6.9.6-11c). Nevertheless, the $k_{eff} + 2\sigma$ values for the packaging fraction "**fl**" and dispersed content calculation "**fd**" models are lower than values for the corresponding uniform dispersal approximation "**cha**" model. The "**cha**" model evaluated without polyethylene bounds results for the more realistic "**fl**" and "**fd**" models evaluated with 500 g polyethylene and the HEU content of the package confined to the specific content locations.

Powder, particulate, or small pieces of HEU potentially present in broken metal are capable of passing between content locations. The quantity of this material, potentially present, represents a small fraction of the total HEU broken metal content. The placement of a limit on content size for criticality control is adopted as a package content loading restriction (Sect. 6.2.4, Item 6). Moreover, the loading limits for broken metal content established based on the "**cha**" model are retained, recognizing that the use of polyethylene is not addressed in "**cha**" model.

Evaluation of arrays of packages with HEU broken metal, turnings, fines, or powder, and no canned spacers. For enrichments >70 and ≤ 80 wt % ^{235}U, the maximum amount of ^{235}U permissible in a flooded ES-3100 package is 27,443-g ^{235}U for broken metal or 19,284-g ^{235}U for metal turnings, fines, or powder. As discussed in Sect. 6.4.2, credit for the presence of 277-4 canned spacers for criticality safety cannot be taken when determining the loading limits for metal turnings, fines, and powder. Without 277-4 canned spacers present in the HAC package containing broken metal, turnings, fines, or powder, the potential fissile mass loading limit over the range >70 and ≤80 wt % ^{235}U and for a CSI = 0 must be 2,967-g ^{235}U (Case **hciabmt12_4_1_5_3**) in order for the $k_{eff} + 2\sigma$ value (0.925) to be at the USL of 0.925. Given that the results for NCT (Sect. 6.5.2) and HAC are adequately subcritical, packages ≤ 2,967-g ^{235}U and enrichment >70 and ≤ 80 wt % ^{235}U may be shipped under a CSI = 0.

For HAC arrays loaded with the broken metal content, including turnings, fines, or powder with 500 g of polyethylene and with no canned spacers, calculations were performed for various enrichments with a CSI of 0.0, 0.4, 0.8, 2.0, and 3.2. The original broken metal models were used for these calculations. These models were modified by adding 500 g of polyethylene, modifying the format of the input decks to run on SCALE 6.1.3, and adding more particles. The results for the highest broken metal mass are found in Table 6.31, with all cases shown to be below the USL. The results of all of these calculations are found in Table 6.9.6-11a.

Table 6.31. Infinite array, NCT package model, broken metal (including turnings, fines, or powders) mixed with 500 g polyethylene, with no canned spacers

Case	Enrichment (%)	U mass (kg)	^{235}U mass (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
CSI=0.0							
hciabmt12p_5_1_6_3	100	2.6	2.600	0.93291	0.00078	0.93447	0.93680
hciabmt12p_8_1_5_3	95	2.9	2.755	0.93429	0.00070	0.93569	0.93680
hciabmt12p_11 1_4_3	90	3.2	2.880	0.93446	0.00074	0.93594	0.93680
hciabmt12p_18 1_3_3	80	4.0	3.200	0.93452	0.00080	0.93612	0.93680
hciabmt12p_27 1_2_3	70	5.1	3.570	0.93466	0.00068	0.93602	0.93680
hciabmt12p_39 1_1_3	60	7.2	4.320	0.93484	0.00082	0.93648	0.93680
CSI=0.4							
hcf2bmt12p_5_1_6_3	100	4.0	4.000	0.90997	0.00077	0.91151	0.93680
hcf2bmt12p_9_1_5_3	95	4.6	4.370	0.91000	0.00075	0.91150	0.93680
hcf2bmt12p_15_1_4_3	90	5.4	4.860	0.91172	0.00079	0.91330	0.93680
hcf2bmt12p_24_1_3_3	80	7.3	5.840	0.91219	0.00072	0.91363	0.93520
hcf2bmt12p_35_1_2_3	70	10.5	7.350	0.90829	0.00078	0.90985	0.93520
hcf2bmt12p_50_1_1_3	60	17.3	10.380	0.90910	0.00100	0.91110	0.93520
CSI=0.8							
hcf3bmt12p_4_1_6_3	100	6.2	6.200	0.91318	0.00085	0.91488	0.93520
hcf3bmt12p_9_1_5_3	95	7.7	7.315	0.91323	0.00082	0.91487	0.93520
hcf3bmt12p_15_1_4_3	90	9.5	8.550	0.91261	0.00088	0.91437	0.93520
hcf3bmt12p_31_1_3_3	80	14.2	11.360	0.91118	0.00094	0.91306	0.93520
hcf3bmt12p_48_1_2_3	70	21.8	15.260	0.91300	0.00081	0.91462	0.93520
hcf3bmt12p_66_1_1_3	60	34.5	20.700	0.91250	0.00068	0.91386	0.93520
CSI=2.0							
hcf4bmt12p_5_1_6_3	100	10.7	10.700	0.89664	0.00073	0.89810	0.93520
hcf4bmt12p_13_1_5_3	95	14.0	13.300	0.89394	0.00074	0.89542	0.93520
hcf4bmt12p_24_1_4_3	90	17.9	16.110	0.89614	0.00070	0.89754	0.93520
hcf4bmt12p_39_1_3_3	80	25.4	20.320	0.89349	0.00070	0.89489	0.93520
hcf4bmt12p_58_1_2_3	70	36.0	25.200	0.89639	0.00077	0.89793	0.93520
hcf4bmt12p_58_1_1_3	60	36.0	21.600	0.86948	0.00075	0.87098	0.93520
CSI=3.2							
hcf5bmt12p_5_1_6_3	100	19.1	19.100	0.91336	0.00074	0.91484	0.93520
hcf5bmt12p_14_1_5_3	95	24.8	23.560	0.91530	0.00079	0.91688	0.93520
hcf5bmt12p_27_1_4_3	90	29.0	26.100	0.91364	0.00066	0.91496	0.93520
hcf5bmt12p_42_1_3_3	80	36.0	28.800	0.90753	0.00061	0.90875	0.93520
hcf5bmt12p_42_1_2_3	70	36.0	25.200	0.88165	0.00077	0.88319	0.93520
hcf5bmt12p_42_1_1_3	60	36.0	21.600	0.85640	0.00066	0.85772	0.93520

Repetition of the evaluation technique. This evaluation technique for determination of mass loading limits for enrichment intervals is repeated over the range of HEU enrichments identified in Tables 6.1c and 6.1d. At HEU enrichments ≤ 60 wt % ^{235}U, the evaluated package mass loading limit of 35.32-kg uranium is achieved, so further delineation of fissile mass loading limits by g ^{235}U is not required.

6.6.3 HEU Oxide

Like packages with HEU metal or broken metal, the neutron multiplication factor for an array of HAC packages with HEU product oxide decreases as a function of decreasing ^{235}U mass [parametric Cases **hciapdoxt11_1_*n*_24_3**, **hciapdoxt11_1_*n*_20_3**, **hciapdoxt11_1_*n*_15_3**, **hciapdoxt11_1_*n*_12_3**, **hciapdoxt11_1_*n*_11_3**, and **hciapdoxt11_1_1_10_3** through **hciapdoxt11_1_1_6_3** (Table 6.9.6-13b)]. For these HAC cases, the MOIFR is set at 1.0E-04 such that neutronic interaction between packages of an array is maximized. Results for the parametric cases reveal the same consistent increase in the $k_{eff} + 2\sigma$ values with decreasing bulk density as observed in the single package calculation results (Sect. 6.4.3). Results for Cases **hciapdoxt11_1_*n*_11_3** and **hciapdoxt11_1_1_10_3** through **hciapdoxt11_1_1_6_3** demonstrate that over the range of HEU oxide bulk densities from 6.54 to 2.0 g/cm^3, the $k_{eff} + 2\sigma$ values are below the USL of 0.925. Given that the results for NCT (Sect. 6.5.3) and HAC are adequately subcritical, packages may be shipped under a CSI = 0.0 for an infinite array of packages having product oxide with a maximum of 9,682-g ^{235}U.

Cases **hciask_1_15** through **hciask_10_15** (Appendix 6.9.6, Table 6.9.6-18b) evaluate infinite arrays of damaged packages having the 10 skull oxide compositions described in Sect. 6.4.3. The differences between the HAC case results and the NCT case results are not statistically significant. The $k_{eff} + 2\sigma$ values, ranging from 0.658 to 0.767, are substantially below the USL value of 0.925. Given that the results for NCT (Sect. 6.5.3) and HAC are adequately subcritical, packages may be shipped under a CSI = 0.0 for an infinite array of packages having skull oxide content with a maximum of 16,399-g ^{235}U and 921 g graphite.

Additional calculations are performed for bulk densities ranging from 1.75 g/cm^3 to 0.5 g/cm^3 for HAC and varying the specific gravity outside of the CV (MOIFR) from dry to fully flooded. The uranium oxide is evaluated at bulk densities of 1.75, 1.5, 1.25, 1.0, 0.75, and 0.5 g/cm^3 at 100% enrichment mixed with 500 g of polyethylene. The results for the highest oxide mass are found in Table 6.32, with all cases shown to be below the USL.

Table 6.32. Infinite array, HAC package model, uranium oxide mixed with 500 g polyethylene, (USL=0.935)

Case	MOIFR	Density (g/cm^3)	UO_2 mass (kg)	^{235}U mass (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$
hcialdoxt12_1_19_2	1.0E-05	1.75	10.75	9.4	0.9324	0.0013	0.9350
hcialdoxt12_2_16_2	1.0E-05	1.50	9.5	8.3	0.9321	0.0013	0.9347
hcialdoxt12_3_12_3	1.0E-04	1.25	8.0	7.0	0.9316	0.0013	0.9342
hcialdoxt12_4_9_1	1.0E-20	1.00	6.75	5.9	0.9301	0.0013	0.9327
hcialdoxt12_5_5_2	1.0E-05	0.75	5.5	4.8	0.9290	0.0014	0.9318
hcialdoxt12_6_1_1	1.0E-20	0.50	4.0	3.5	0.9234	0.0013	0.9260

The HAC cases are about as reactive as the NCT cases except at a bulk density of 1.25 g/cm^3. At this bulk density, the HAC cases are slightly more reactive at 8.25 kg oxide (7.2 kg ^{235}U) than the NCT cases and are above the USL. Additional calculations at 8.00 kg oxide (7.0 kg ^{235}U) for HAC are shown to be below the USL.

Additional calculations were performed for uranium oxide mixed with thorium oxide and uranium oxide mixed with thorium metal oxide at the same densities as uranium oxide. Thorium is not

fissile and would not increase the reactivity of this system; however, the saturated water that is in the thorium oxide model may provide a more optimum moderation configuration, especially at lower bulk densities. Calculations were also performed for uranium oxide mixed with zirconium oxide. Parametric studies were performed for various uranium oxide loadings varying the amount of thorium oxide, thorium metal, or zirconium oxide.

In the infinite array calculations, the CV is modeled fully flooded and the HAC package is evaluated at various interstitial moderated cases. As in the CV cases, calculations are performed to exam UO_2 mixed with ThO_2, thorium metal, or ZrO_2 at bulk densities of 2.0, 1.75, 1.5, 1.25, 1.0, 0.75, and 0.5 g/cm^3 at 100% enrichment mixed with 500 g of polyethylene. The amount of ThO_2, thorium metal, or ZrO_2 that is added is dependent upon the amount of available space within the CV and the total amount of oxide allowed (13.15 kg). At lower densities, the amount of ThO_2, thorium metal, or ZrO_2 that can be added to the CV decreases with decreasing density. Unlike the CV and single package cases, as shown in Tables 6.9.6-13h, 6.9.6-13i, and 6.9.6-13j, for all bulk oxide densities, as ThO_2, thorium metal, or ZrO_2 is added, reactivity increases. The UO_2 oxide limit is not bounding for bulk densities of UO_2 mixed with ThO_2. Thus, for these densities, lower limits are required. The results for the highest oxide mass are found in Table 6.33 for thorium oxide, Table 6.34 for zirconium oxide, and Table 6.35 for thorium metal, with all cases shown to be below the USL.

Table 6.33. Infinite array, HAC package model, uranium oxide and thorium oxide mixed with 500 g polyethylene

Case hcialdoxtho2t12_*	MOIFR	Density (g/cm^3)	UO_2 mass (kg)	ThO_2 mass (kg)	^{235}U mass (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
13_1_16a	1.0E-05	2.00	11.0	5.0	9.682	0.91963	0.00074	0.92111	0.93520
14_2_15a	1.0E-05	1.75	10.1	5.10	8.890	0.93310	0.00100	0.93510	0.93520
20_3_11	1.0E-20	1.50	7.75	6.75	6.822	0.93276	0.00069	0.93414	0.93520
16_4_9a	1.0E-05	1.25	6.55	5.50	5.765	0.93351	0.00068	0.93487	0.93520
10_5_6a	1.0E-05	1.00	5.50	4.15	4.841	0.93322	0.00074	0.93470	0.93680
6_6_4b	1.0E-04	0.75	4.60	2.65	4.049	0.93453	0.00077	0.93607	0.93680
3_7_2	1.0E-20	0.50	3.75	1.05	3.301	0.93519	0.00079	0.93677	0.93680

Table 6.34. Infinite array, HAC package model, uranium oxide and zirconium oxide mixed with 500 g polyethylene

Case hcialdoxzro2t12_*	MOIFR	Density (g/cm^3)	UO_2 mass (kg)	ZrO_2 mass (kg)	^{235}U mass (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
12_1_17a	1.0E-05	2.00	11.0	5.0	9.682	0.92606	0.00069	0.92744	0.93520
13_2_15	1.0E-20	1.75	9.55	5.65	8.406	0.93355	0.00075	0.93505	0.93520
20_3_10a	1.0E-05	1.50	6.90	7.55	6.073	0.93194	0.00069	0.93332	0.93520
15_4_7a	1.0E-05	1.25	5.80	6.25	5.105	0.93327	0.00072	0.93471	0.93520
11_5_5	1.0E-20	1.00	4.90	4.75	4.313	0.93473	0.00094	0.93661	0.93680
7_6_4a	1.0E-05	0.75	4.10	3.15	3.609	0.93297	0.00081	0.93459	0.93680
3_7_2b	1.0E-04	0.50	3.50	1.30	3.081	0.93337	0.00082	0.93501	0.93680

Table 6.35. Infinite Array, HAC Package model, uranium oxide and thorium metal mixed with 500 g polyethylene

Case hcialdoxthmt12_*	MOIFR	Density (g/cm^3)	UO_2 mass (kg)	Th mass (kg)	^{235}U mass (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
13_1_16	1.0E-20	2.00	11.0	5.0	9.682	0.91916	0.00078	0.92072	0.93520
14_2_15a	1.0E-05	1.75	10.1	5.10	8.890	0.93257	0.00071	0.93399	0.93520
20_3_11a	1.0E-05	1.50	7.75	6.80	6.821	0.91847	0.00074	0.91995	0.93520
16_4_9a	1.0E-05	1.25	6.55	5.50	5.765	0.93260	0.00100	0.93460	0.93520
10_5_6a	1.0E-05	1.00	5.50	4.15	4.841	0.93149	0.00074	0.93297	0.93680
6_6_4a	1.0E-05	0.75	4.60	2.65	4.049	0.93373	0.00076	0.93525	0.93680
3_7_2b	1.0E-04	0.50	3.75	1.05	3.301	0.93407	0.00078	0.93563	0.93680

The HAC cases are about as reactive as the NCT cases, with all cases, both NCT and HAC, were shown to be below the USL.

6.6.4 UNH Crystals

Unlike the HEU metal, broken metal, or oxide content, UNH crystals are soluble in water (Sect. 6.4.4). The most reactive content condition occurs at an optimum solution concentration derived from the UNH crystal loading and the volume of water flooding the CV. Both flooding of the CV and a reduced loading of UNH crystals going into solution is required to achieve the most reactive configuration.

Similar to packages with HEU metal, broken metal, or oxide, the neutron multiplication factor for an array of damaged packages with UNH crystals decreases as a function of increasing MOIFR. Cases **hciaunhct12_8_24_1_1** through **hciaunhct12_8_24_1_15** for content without polyethylene and Cases **hciapunhct12_24_1** and **hciapunhct12_24_15** for content with 500 g polyethylene (Table 6.9.6-15) reveal the effect of isolating the individual array units from each other with the introduction of water above ~0.01 MOIFR. Array reactivity ($k_{eff} + 2\sigma = 0.729$ without polyethylene

and 0.733 with polyethylene) approaches the reactivity of the water-saturated, water-reflected unit single package ($k_{eff} + 2\sigma = 0.704$ without polyethylene and 0.711 with polyethylene).

In a series of HAC calculations (Cases **hciapunhct11_*nn*_3**), the calculated $k_{eff} + 2\sigma$ values are below the USL of 0.925 for loading with <8,000-g UNH crystals. Given that the results for NCT (Sect. 6.5.4) and HAC are adequately subcritical, the CSI is 0.0 [10 CFR 71.59(a)(2) and 10 CFR 71.59(b)] for packages having a maximum of 3,297-g ^{235}U.

The $k_{eff} + 2\sigma$ values are expected to range from subcritical to critical for array configurations where UNH crystals are dissolved in the water flooding the CV and the CV well. This requires intrusion of water into the CV, dissolving of UNH crystals in the influent, and leakage of solution out of the CVs in each package of an array. The leakage out of the CV of content moderated "to such an extent as to cause maximum reactivity consistent with the physical and chemical form of material" is not considered credible HAC based on results for tests specified in 10 CFR 71.73.

In a series of HAC calculations (Cases **hcf2punhct12_*nn*_3**), the calculated $k_{eff} + 2\sigma$ values are below the USL of 0.925. Given that the results for NCT (Sect. 6.5.4) and HAC are adequately subcritical, packages may be shipped under a CSI = 0.4 for packages with a maximum of 24,000-g UNH crystals.

6.7 FISSILE MATERIAL PACKAGES FOR AIR TRANSPORT

A series of calculations is performed for determining the most reactive configuration of the content and surrounding packaging material in an ES-3100 package that undergoes catastrophic destruction. Fissile content mass loadings that remain under the USL for these catastrophic events are identified. Subcriticality is demonstrated after due consideration of such aspects as the efficiency of moderator, loss of neutron absorbers, rearrangement of packaging components and contents, geometry changes and temperature effects. The six calculation models used in this evaluation are described in Sect. 6.3.1.4. Key model dimensions and parameters are tabulated in Tables 6.9.6-21 through 6.9.6-23, Appendix 6.9.6.

6.7.1 Results for HEU Metal (Excluding TRIGA Fuel Elements)

In this section, "HEU metal" refers to HEU metal content of specified geometric shape (cylinder, bar, or slug), of an unspecified geometric shape (characterized as broken metal), or broken metal. The uranium is homogenized with hydrogenous packaging material and evaluated as a distinct lump ("fissile core") that is not mixed with other packing or packaging materials.

Cases **atdmr_10_8** through **atdmr_7_1** (Table 6.9.6-21, Appendix 6.9.6) pertain to Model 1 (Fig. 6.11, Sect. 6.3.1.4). HEU metal of three convenience cans is homogenized with 500 g of polyethylene, representing the potential use of hydrogenous packing materials in the ES-3100. The fissile core is configured into a spherical shape with an exterior 20 cm water reflector. As shown in Fig. 6.20 and Table 6.9.6-21, the $k_{eff} + 2\sigma$ values decrease as a function of both enrichment and ^{235}U mass. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.925. The $k_{eff} + 2\sigma$ value for 7 kg of HEU at 100 % enrichment is 0.791.

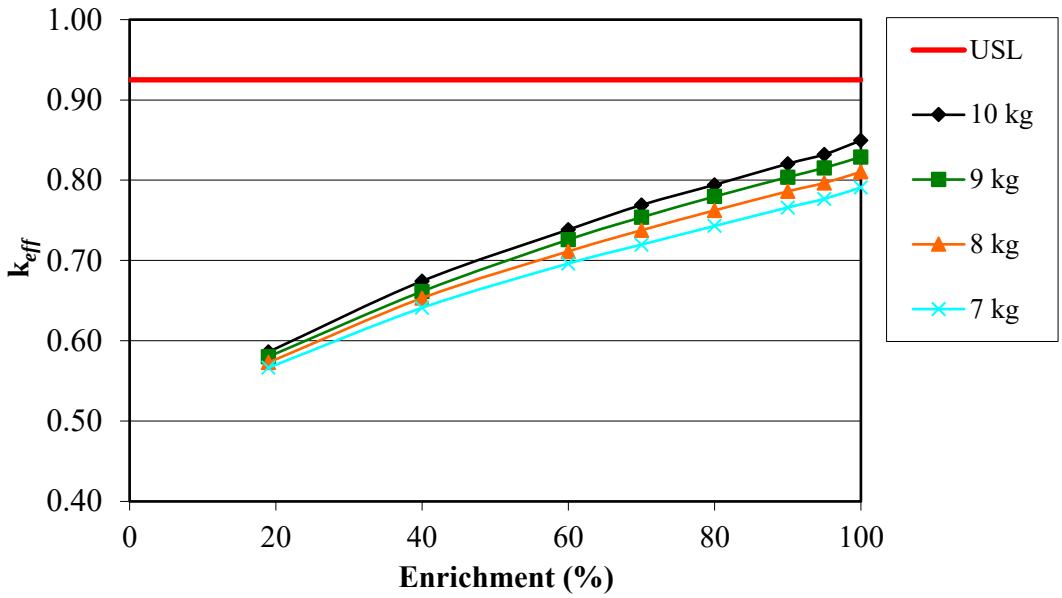


Fig. 6.20. k_{eff} vs enrichment (wt % ^{235}U) for HEU ranging from 7 to 10 kg.

Cases **atdmsr_7_8_11** through **atdmsr_7_1_1** (Table 6.9.6-21, Appendix 6.9.6) pertain to Model 2 (Fig. 6.12, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness stainless steel shell and an exterior 20 cm water reflector. As shown in Fig. 6.21 and Table 6.9.6-21, the maximum $k_{eff} + 2\sigma$ values occur at zero stainless steel thickness. The $k_{eff} + 2\sigma$ value for 7 kg of HEU at 100% enrichment and zero stainless steel thickness is 0.791. The $k_{eff} + 2\sigma$ values decrease to minimum values for steel thicknesses of 2.49 cm over the range of 100% enrichment to 19% enrichment, while the NLF decreases from ~ 0.07 to 0.05. The NLF further decreases to a value of 0.03 as stainless steel is added up to the 66,133 g amount of the CV, and the liner and drum assembly. At maximum stainless steel thickness, the $k_{eff} + 2\sigma$ values increase to within 0.02 of the values for zero stainless steel thickness. The stainless steel of the ES-3100 packaging is not as effective a reflector as the 20 cm water surrounding the core. The overall effect of adding the stainless steel of the ES-3100 packaging to the configuration is the reduction in the neutron multiplication factor for the system. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.925.

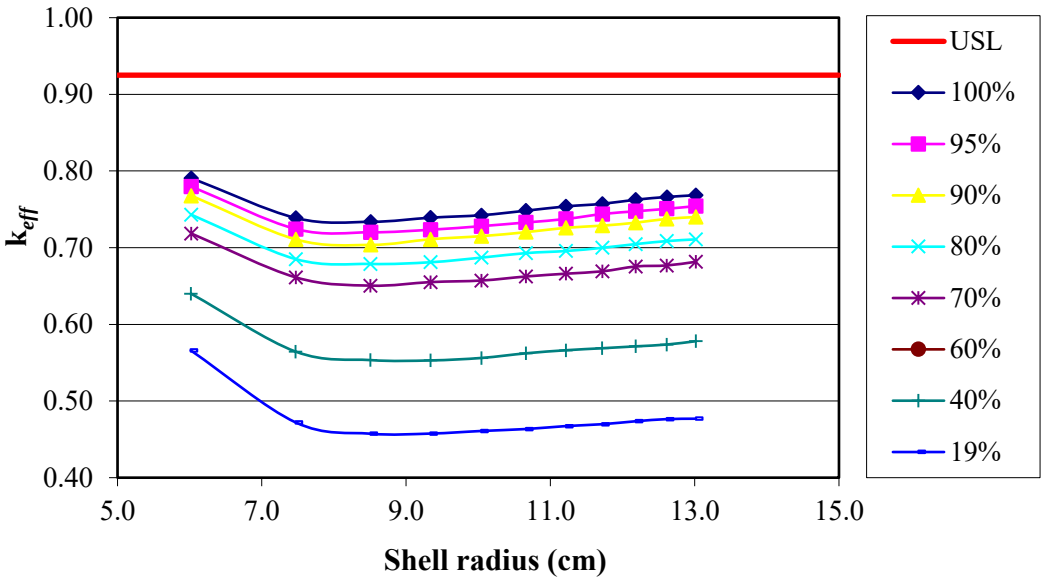


Fig. 6.21. k_{eff} vs stainless steel shell radius (cm) for 7 kg HEU with enrichments ranging from 19 to 100 wt % ^{235}U.

Cases **atdm15kr_7_8_6** through **atdm15kr_7_1_1** (Table 6.9.6-21, Appendix 6.9.6) pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness wet-Kaolite shell and an exterior 20 cm water reflector. As explained in Sect. 6.3.1.4, wet Kaolite to a maximum of 60,223 g consists of the dry Kaolite [51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug] and up to 6,803.8 g free water—moisture which dampens the Kaolite and may also be present in the CV well. As shown in Fig. 6.22 and Table 6.9.6-21, the maximum $k_{eff} + 2\sigma$ values at various enrichments occur at zero shell-thickness for the wet Kaolite. Consider the curve for 7 kg of HEU at 100 % enrichment where $k_{eff} + 2\sigma = 0.790$. At a shell radius of ~ 23 cm (24,089.2 g wet Kaolite with a shell thickness of ~ 17 cm), $k_{eff} + 2\sigma$ becomes quasi-asymptotic and the decrease in the NLF from ~ 0.07 to 0.05 is slight. With the addition of ~8.1 cm of wet Kaolite to the shell, the NLF decreases further from 0.05 to 0.04. The $k_{eff} + 2\sigma$ value decreases to a minimum value at a shell radius of 31.08 cm (60,223 g wet Kaolite with a steel thickness of 25.06 cm). In the range of 17 to 25 cm shell thickness, the quasi-asymptotic values for $k_{eff} + 2\sigma$ are ~ 0.04 below maximum $k_{eff} + 2\sigma$ values occurring at zero Kaolite thickness. To summarize, a significant drop in the neutron multiplication factor is observed for the addition of the initial 17 cm of wet-Kaolite shell to the fissile core, but an asymptotic value is not reached. With increasing build-up in the shell thickness, neutron multiplication decreases rather than increases, and the decrease in neutron leakage from the system is small. This behavior occurs because water at saturation levels, which is required for the Kaolite to act as a modest reflector, is not present in the wet Kaolite.

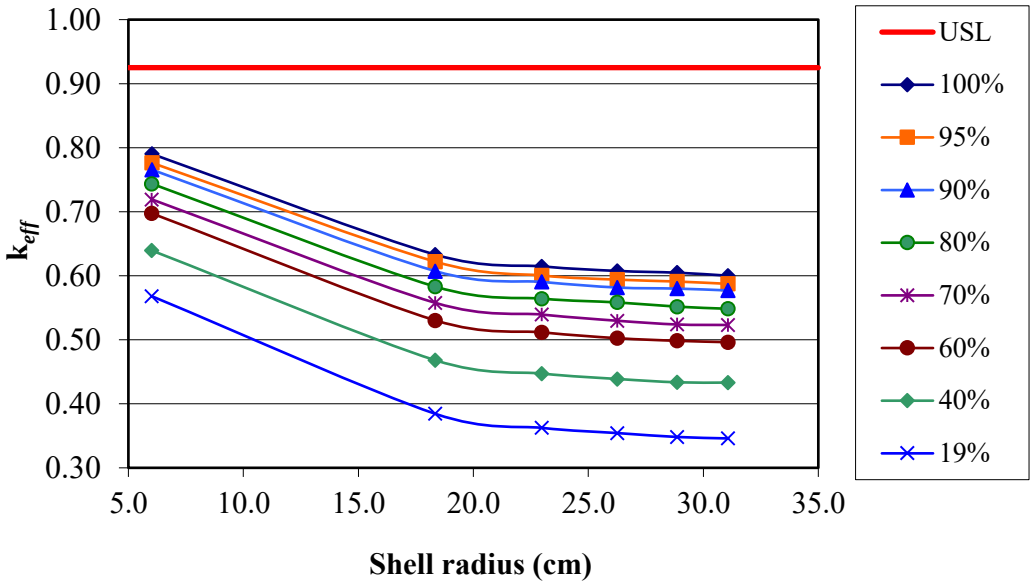


Fig. 6.22. k_{eff} vs wet Kaolite shell radius (cm) for 7 kg HEU with enrichments ranging from 19 to 100 wt % ^{235}U.

Cases **atdmdkr_7_8_6** through **atdmdkr_7_8_1** (Table 6.9.6-21, Appendix 6.9.6) pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4), where dry Kaolite is being evaluated consistent with test results of 10 CFR 71.55(d). As explained in Sect. 6.3.1.4, 53,419.1 g of dry Kaolite contained inside the body weldment outer liner and the drum top plug is NCT Kaolite (51,214.9 g vermiculite-cement and 2,204.7 g bound water). Only 7 kg of HEU at 100% enrichment is evaluated in the "atdmdkr" cases. As shown in Fig. 6.23 and Table 6.9.6-21, the behavior in $k_{eff} + 2\sigma$ for dry Kaolite where the value decreases to a minimum at a shell radius of 31.08 cm (shell thickness of 25.06 cm) is the same as for wet Kaolite. The $k_{eff} + 2\sigma$ values for the system with dry or wet Kaolite are substantially below the USL of 0.925. The decrease in NLF from ~ 0.07 to 0.05 for dry Kaolite is slightly less than from ~ 0.07 to 0.04 for wet Kaolite. The overall effect of adding dry or wet Kaolite to the system is the reduction of the neutron multiplication in the system. NCT Kaolite of the ES-3100 packaging or wet Kaolite is not as effective a reflector as the 20 cm water surrounding the core. The absence of water in the Kaolite minimizes its effect.

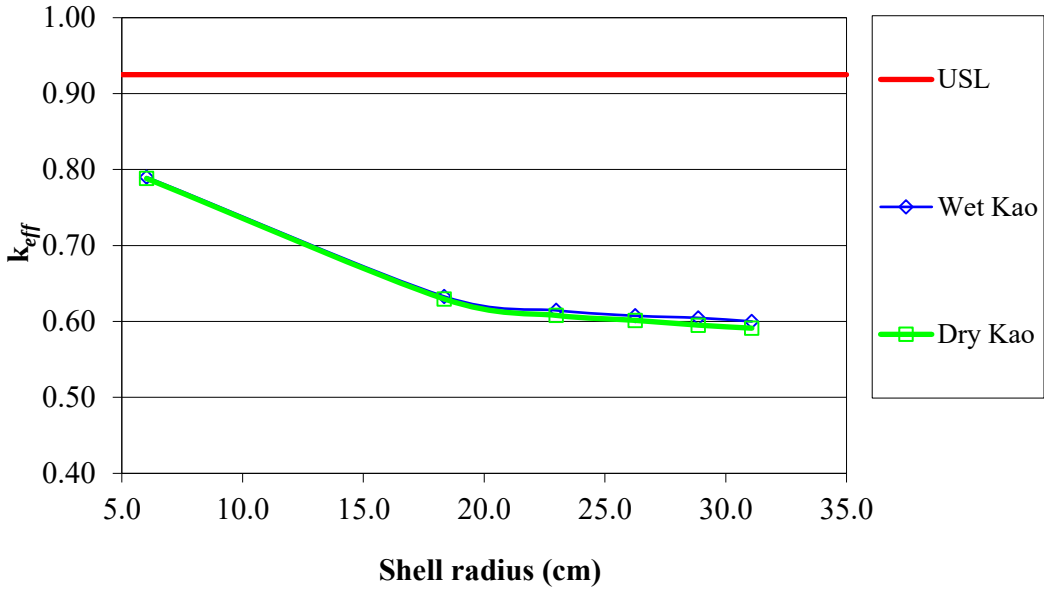


Fig. 6.23. k_{eff} vs shell radius for wet and dry Kaolite for 7 kg HEU at 100% enrichment.

A uranium alloy is conservatively assessed when scattering media (aluminum or molybdenum) is treated as multiplying media (^{235}U) in the calculation models. Thus, limits established for HEU metal apply to the alloy.

6.7.2 Results for TRIGA Fuel Elements, Three Pieces per Convenience Can

Case **atdzr** pertains to Model 1 (Fig. 6.11, Sect. 6.3.1.4), in which 10.4 kg of $UZrH_x$ (921-g ^{235}U) of three TRIGA fuel elements is homogenized with 500 g polyethylene. The fissile core is configured into a spherical shape with an exterior 20 cm water reflector. The $k_{eff} + 2\sigma$ value of 0.679 (Table 6.9.6-22a, Appendix 6.9.6) is substantially below the USL of 0.925. Similarly, Case **atdzr_70** pertains to Model 1, in which 6.85 kg of $UZrH_x$ (408-g ^{235}U) of three TRIGA fuel elements is homogenized with 500 g polyethylene. The fissile core is configured into a spherical shape with an exterior 20 cm water reflector. The $k_{eff} + 2\sigma$ value is 0.682 (Table 6.9.6-22b, Appendix 6.9.6). The statistical difference between the $k_{eff} + 2\sigma$ values for Cases **atdzr** and **atdzr_70** is not significant.

Cases **atdzsr_11** through **atdzsr_1** pertain to Model 2 (Fig. 6.12, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness stainless steel shell with an exterior 20 cm water reflector. As shown in Fig. 6.24 and Table 6.9.6-22a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero steel thickness. The $k_{eff} + 2\sigma$ value for 10.4 kg of $UZrH_x$ and zero stainless steel thickness is 0.678. The $k_{eff} + 2\sigma$ value decreases to minimum value for a stainless steel thickness of 1.87 cm, while the NLF decreases from ~ 0.06 to 0.04. The NLF decreases to 0.03 as stainless steel is added up to the 66,133 g amount of the CV and the liner and drum assembly. At maximum stainless steel thickness, the $k_{eff} + 2\sigma$ values increase to within 0.058 of the values for zero stainless steel thickness. The overall effect of adding stainless steel to the system is the reduction of the neutron multiplication in the system. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.925.

Cases **atdzsr70_11** through **atdzsr70_1** for 6,847 g of $UZrH_x$ at 70% enrichment having 408-g ^{235}U also pertain to Model 2 (Fig. 6.12, Sect. 6.3.1.4). Case results (Table 6.9.6-22b, Appendix 6.9.6) manifest the same behavior as results for corresponding Cases **atdzsr_11** through **atdzsr_1** for 10.4 kg of $UZrH_x$ at 20% enrichment having 921-g ^{235}U.

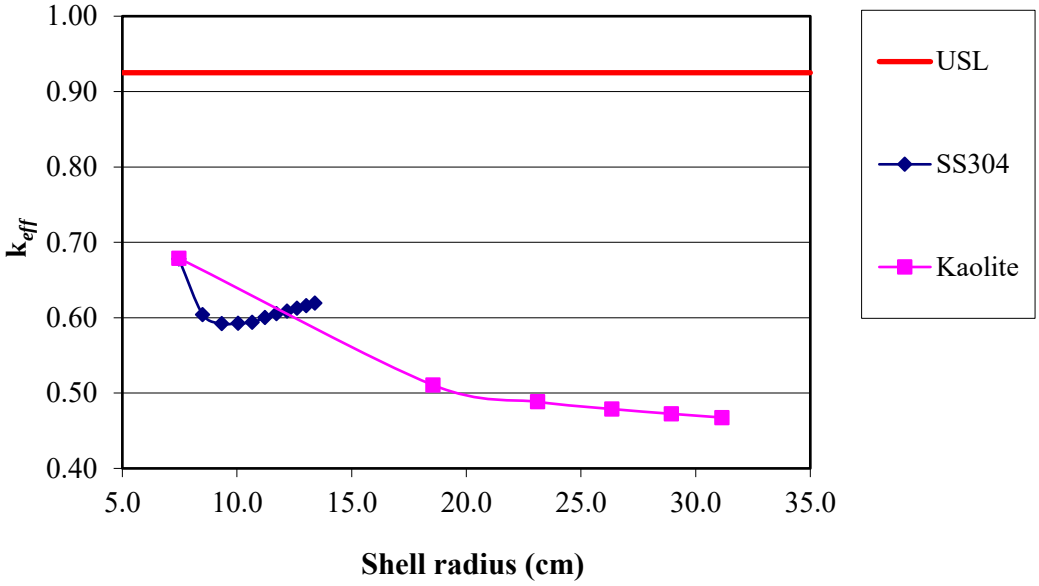


Fig. 6.24. k_{eff} vs shell radius (cm) for 10.4 kg core of $UZrH_x$ with stainless steel or wet Kaolite shell.

Cases **atdz15kr_6** through **atdz15kr_1** pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness wet-Kaolite shell with an exterior 20 cm water reflector. As explained in Sect. 6.3.1.4, wet Kaolite to a maximum of 60,223 g consists of the dry Kaolite [51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug] and up to 6,803.8 g free water—moisture which dampens the Kaolite and may also be present in the CV well. As shown in Fig. 6.24 and Table 6.9.6-22a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero shell-thickness for the wet Kaolite. The $k_{eff} + 2\sigma = 0.679$ for 10.4 kg of $UZrH_x$. At a shell radius of ~23 cm (24,089.2 g wet Kaolite with a shell thickness of ~ 17 cm), $k_{eff} + 2\sigma$ becomes quasi-asymptotic and the decrease in the NLF from ~ 0.06 to 0.05 is slight. With the addition of ~8.1 cm of wet Kaolite to the shell, the NLF decreases further from 0.05 to 0.04. The $k_{eff} + 2\sigma$ value decreases to a minimum value at a shell radius of 31.08 cm (60,223 g wet Kaolite with a steel thickness of 25.06 cm). The quasi-asymptotic values for $k_{eff} + 2\sigma$ are ~ 0.21 below the maximum $k_{eff} + 2\sigma$ value occurring at zero Kaolite thickness. To summarize, a significant drop in the neutron multiplication factor is observed for the addition of the initial 17 cm of wet-Kaolite shell to the fissile core, but an asymptotic value is not reached. With increasing build-up in the shell thickness, neutron multiplication decreases rather than increases, and the decrease in neutron leakage from the system is small. This behavior occurs because water at saturation levels, which is required for the Kaolite to act as a modest reflector, is not present in the wet Kaolite.

Dry Kaolite is consistent with test results of 10 CFR 71.55(d). As explained in Sect. 6.3.1.4, 53,419.1 g of dry Kaolite contained inside the body weldment outer liner and the drum top plug is NCT Kaolite (51,214.9 g vermiculite-cement and 2,204.7 g bound water). Demonstrated for HEU metal in Sect. 6.7.1, the behavior in $k_{eff} + 2\sigma$ where the value decreases to a minimum at a shell radius of 31.08 cm (shell thickness of 25.06 cm) is the same in dry Kaolite as for wet Kaolite. The overall effect of adding

dry or wet Kaolite to the system is the reduction of the neutron multiplication in the system. NCT Kaolite of the ES-3100 packaging or wet Kaolite is not as effective a reflector as the 20 cm water surrounding the core. The absence of water in the Kaolite minimizes its effect. The $k_{eff} + 2\sigma$ values for Model 3 with dry or wet Kaolite are substantially below the USL of 0.925.

Cases **atdz15kr70_6** through **atdz15kr70_1** for 6,847 g of $UZrH_x$ at 70% enrichment having 408-g ^{235}U also pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). Case results (Table 6.9.6-22b, Appendix 6.9.6) manifest the same behavior as results for corresponding Cases **atdz15kr_6** through **atdz15kr_1** for 10.4 kg of $UZrH_x$ at 20% enrichment having 921-g ^{235}U.

Cases **athzp15kr_5** through **athzp15kr_1** pertain to Model 4 (Fig. 6.14, Sect. 6.3.1.4). The homogenized core consists of 10.4 kg of $UZrH_x$ at 19.7% enrichment having 921-g ^{235}U, 500 g of polyethylene, and Kaolite. For this set of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water) [Table 6.9.6-22a, Appendix 6.9.6]. For Model 4, the overall radius at 31.1484 cm is constant for several reasons. First, the 500 g of polyethylene has a fixed volume. Second, the Kaolite is a porous material and its volume does not change appreciably as the material is dried out or absorbs water.

Cases **athzp15kr70_6** through **athzp15kr70_1** for 6,847 g of $UZrH_x$ at 70% enrichment having 408-g ^{235}U also pertain to Model 4 (Fig. 6.14, Sect. 6.3.1.4). While the $k_{eff} + 2\sigma$ values are lower, the results for these cases (Table 6.9.6-22b, Appendix 6.9.6) manifest the same behavior as corresponding Cases **athzp15kr_6** through **athzp15kr_1** for 10.4 kg of $UZrH_x$ at 20% enrichment having 921-g ^{235}U.

As shown in Fig. 6.25 and Tables 6.9.6-22a and 6.9.6-22b, a gradual increase in $k_{eff} + 2\sigma$ occurs from dry condition to the wet condition. The homogenization of the Kaolite shell and the fissile material core from Model 3 produces two competing effects in Model 4:

- homogenization expands the fissile material core resulting in a decrease in neutron multiplication (from $k_{eff} + 2ó = 0.4675$ in Case **atdz15kr_6** to $k_{eff} + 2ó = 0.3577$ in Case **athzp15kr_5**), and
- the increase in the free water content of the Kaolite (and CV well) increases neutron multiplication in the core (from $k_{eff} + 2ó = 0.3100$ in Case **athpz15kr_1** to $k_{eff} + 2ó = 0.3577$ in Case **athzp15kr_5**).

Consequently, the scenario of water penetration of fissile material core under Model 5 requires evaluation.

Cases **athzpw15kr_5** through **athzpw15kr_1** pertain to Model 5 (Fig. 6.15, Sect. 6.3.1.4). Model 5 is a variation of Model 3, which represents a fissile material core blanketed with wet Kaolite and reflected by 20 cm of water. In Model 5, excess water from the wet Kaolite shell is assumed to migrate into the homogenized core. The homogenized core consists of 10.4 kg of $UZrH_x$ at 19.7% enrichment having 921-g ^{235}U, 500 g of polyethylene, and excess water from the wet Kaolite. The water content of the Kaolite shell ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water) [Table 6.9.6-22a, Appendix 6.9.6]. As excess water migrates from the wet Kaolite shell into the homogenized core, the core radius expands from 7.4677 to 12.6903 cm. However, the volume of the Kaolite shell remains constant because the Kaolite is a porous material and its volume does not change appreciably as the material loses or gains water. Consequently, the overall radius of the system increases from 31.1484 to 31.6977 cm.

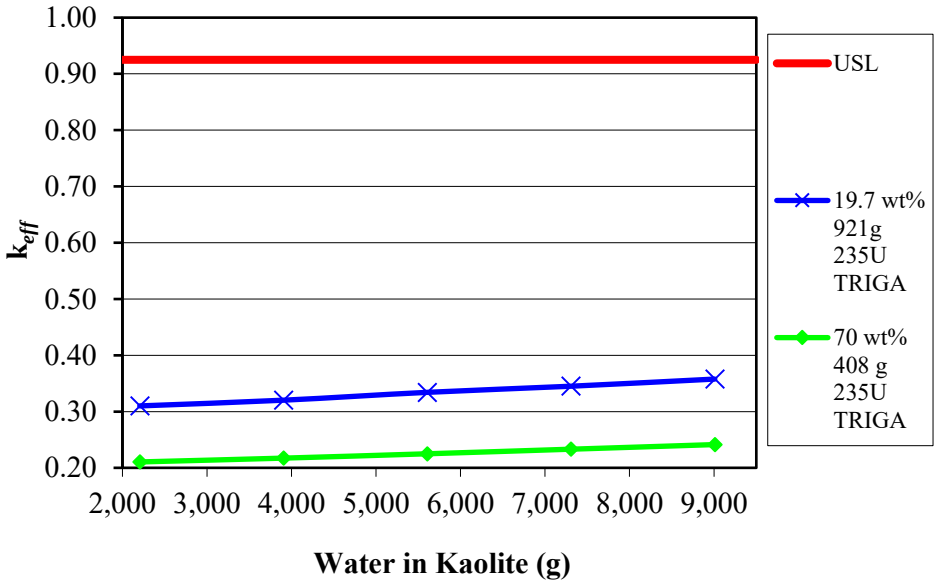


Fig. 6.25. k_{eff} vs water content (g) for homogenized core of $UZrH_x$, 500 g polyethylene and Kaolite where the Kaolite water content ranges from the dry to the wet condition.

Cases **athzpw15kr70_6** through **athzpw15kr70_1** for 6,847 g of $UZrH_x$ at 70% enrichment having 408-g ^{235}U also pertain to Model 5 (Fig. 6.15, Sect. 6.3.1.4). While the $k_{eff} + 2\sigma$ values are lower, the results for these cases (Table 6.9.6-22b, Appendix 6.9.6) manifest the same behavior as corresponding Cases **athzpw15kr_6** through **athzpw15kr_1** for 10.4 kg of $UZrH_x$ at 20% enrichment having 921-g ^{235}U.

As shown in Fig. 6.26 and Tables 6.9.6-22a and 6.9.6-22b (Appendix 6.9.6), the $k_{eff} + 2\sigma$ values increase to maximums of 0.8078 and 0.7215 with the addition of the entire 6,803.9 g of water from wet Kaolite into the fissile material core. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.925. The homogenized core is under moderated because sufficient water is not present in the wet Kaolite and CV well to reach the point of optimum moderation. The total free water is conservatively evaluated up to 15 lb (6,803.9 g).

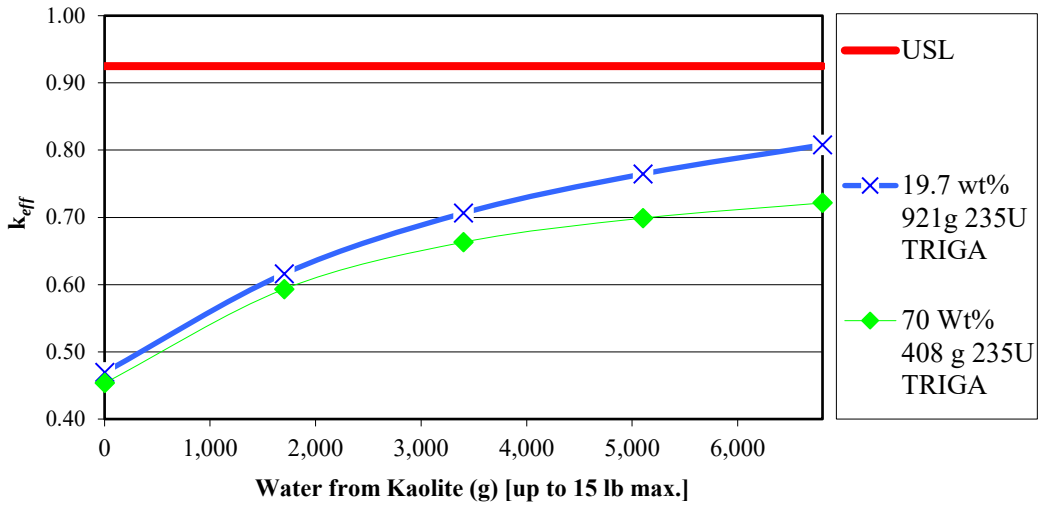


Fig. 6.26. k_{eff} vs excess water (g) from wet Kaolite for fissile core blanketed with a variable thickness Kaolite shell.

In the absence of 10 CFR 71.55(f) test data or dynamic impact simulations per Type-C test criteria, the assumption of water penetration of the fissile material core is valid under the severe air transport evaluation criteria. Model 5 is applicable to air transport of the ES-3100 package given that the geometric form of the TRIGA fuel content following the air transport accident cannot be established.

Case results are presented in Table 6.9.6-22c (Cases **athopw15kr20_1** through **athopw15kr20_5**, Cases **athopw15kr70_1** through **athopw15kr70_5**, and Cases **athopw15kr93_1** through **athopw15kr93_5**) for U_3O_8-Al at the TRIGA content limits of 921-g ^{235}U for 20% enrichment and 408-g ^{235}U for 70% and 93.2% enrichments, respectively. As shown in Fig. 6.27 and Table 6.9.6-22c (Appendix 6.9.6), the $k_{eff} + 2\sigma$ values for U_3O_8-Al are exceeded by values for TRIGA content; therefore, the TRIGA loading limits are bounding for the research reactor related contents of U_3O_8 and U_3O_8-Al oxide.

Case results are presented in Table 6.9.6-22d (Cases **athupw15kr09_1** through **athupw15kr09_5**, Cases **athupw15kr20_1** through **athupw15kr20_5**, and Cases **athupw15kr93_1** through **athupw15kr93_5**) for UO_2-Mg in Al cladding at content limits of 921-g ^{235}U for 9.89% and 20% and 408-g ^{235}U for 93.2% enrichment, respectively. Cases **athbpw15kr93_1** through **athbpwskr93_5** for UO_2 are at content limits of 408-g ^{235}U for 93.2% enrichment. As shown in Fig. 6.28 and Table 6.9.6-22d (Appendix 6.9.6), the $k_{eff} + 2\sigma$ values for research reactor contents of UO_2-Mg or UO_2 exceed values for TRIGA content. These values are well below the USL; therefore, the TRIGA loading limits may be applied to the research reactor related contents of UO_2 and UO_2-Mg oxide.

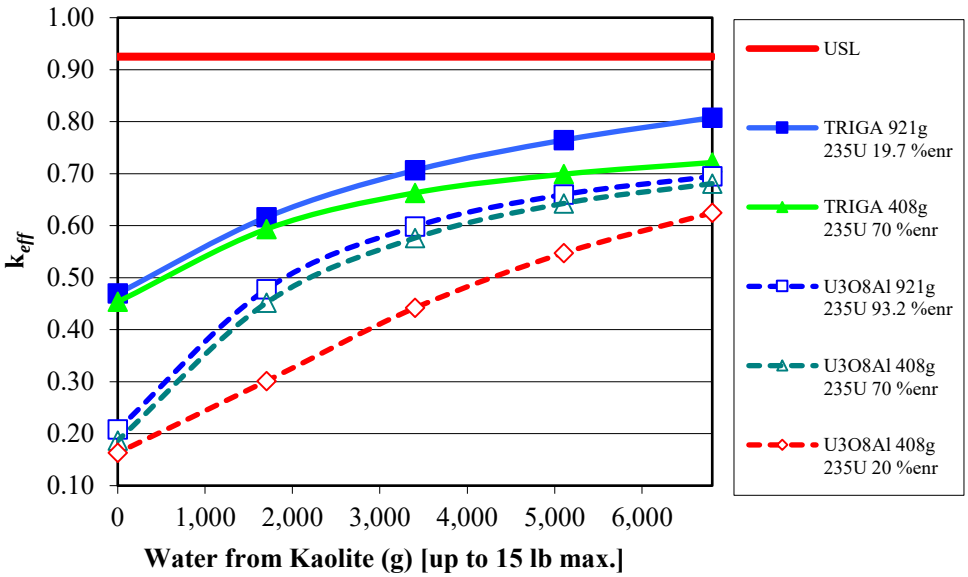


Fig. 6.27. k_{eff} vs excess water (g) from wet Kaolite for fissile material core blanketed with a variable thickness Kaolite shell.

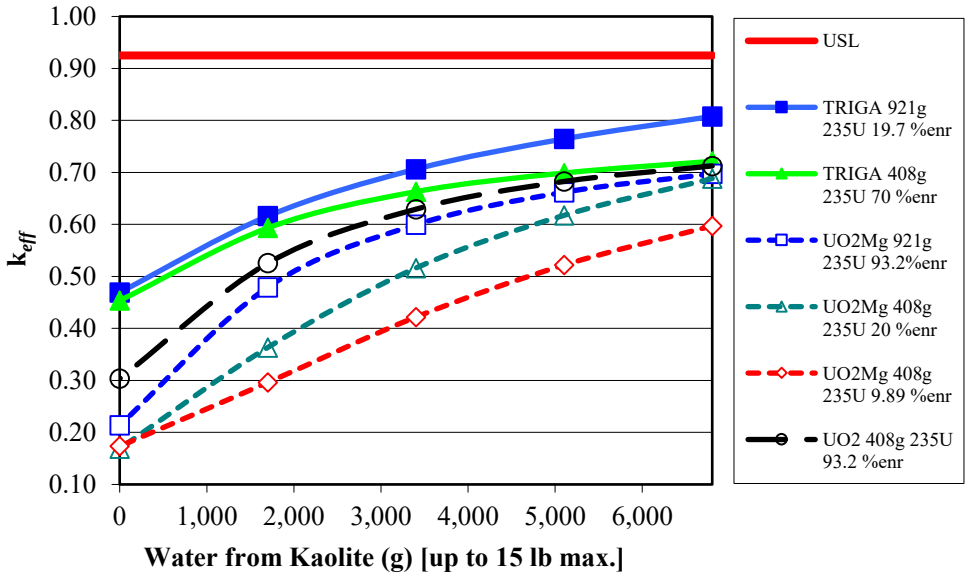


Fig. 6.28. k_{eff} vs excess water (g) from wet Kaolite for fissile material core blanketed with a variable thickness Kaolite shell.

Model 6 (Fig. 6.16, Sect. 6.3.1.4) pertains to the case where fissile material from the homogenized core of Model 4 forms a shell external to the core. Given that the total amount of fissile material is limited to 921-g ^{235}U, the quantity is not sufficient to form a critical configuration. As shown

in Section 6.7.3, this is apparent even if kilogram quantities of additional fissile material were located in the shell adjacent to the core.

6.7.3 Results for HEU Broken Metal, Turnings, Fines, or Powder

The results for Models 1–3 presented in Sect. 6.7.1 address HEU metal evaluated as a fissile core uranium metal and hydrogenous packing material surrounded by but not mixed with other materials. Results for Models 4–6 presented in this section address HEU metal evaluated as a fissile core but where the integrity of the fissile core is lost. Preferential mixing of the fissile core with packing material (non-hydrogenous) and packaging material (stainless steel, Kaolite) is evaluated. Also, reconfiguration of the fissile core is evaluated. This evaluation addresses broken metal, metal turnings, fines, and powder. HEU oxide content for air transport is addressed in Appendix 6.9.10.

Cases **athmp15kr_12_8_5** through **athmp15kr_12_8_1** and Cases **athmp15kr_12_1_5** through **athmp15kr_12_1_1** (Table 6.9.6-23, Appendix 6.9.6) pertain to Model 4 (Fig. 6.14, Sect. 6.3.1.4). In the former set of cases, the homogenized core consists of 7 kg of HEU metal at 100% enrichment, 500 g of polyethylene, and Kaolite. In the latter set of cases, the homogenized core consists of 35 kg of HEU metal at 20% enrichment having 7 kg ^{235}U, 500 g of polyethylene, and Kaolite. For these sets of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water) [Table 6.9.6-23, Appendix 6.9.6]. For Model 4, the overall radius is 31.0803 cm for homogenized core with 100% enrichment and is 31.2009 cm for homogenized core with 20% enrichment. The core radius is constant with changing moisture conditions for the following reasons. First, the 500 g of polyethylene has a fixed volume. Second, the Kaolite is a porous material and its volume does not change appreciably as the material is dried out or absorbs water.

As shown in Fig. 6.29 and Table 6.9.6-23, a gradual increase in the $k_{eff} + 2\sigma$ value occurs from the dry condition to the wet condition. The homogenization of the Kaolite shell and the fissile material core from Model 3 produces two competing effects in Model 4:

- homogenization expands the fissile material core resulting in a slight decrease in neutron multiplication (from $k_{eff} + 2ó = 0.6001$ in Case **atdm15kr_7_8_6** to $k_{eff} + 2ó = 0.5909$ in Case **athmp15kr_12_8_5**) and

- the increase in the free water content of the Kaolite (and CV well) increases neutron multiplication in the core (from $k_{eff} + 2ó = 0.5024$ in Case **athmp15kr_1** to $k_{eff} + 2ó = 0.5909$ in Case **athmp15kr_5**).

Consequently, the scenario of water penetration of fissile material core under Model 5 requires evaluation.

Cases **athmpw15kr_12_8_5** through **athmpw15kr12_8_1**, Cases **athmpw13kr_12_8_5** through **athmpw13kr12_8_1**, and Cases **athzpw12kr70_5** through **athzpw12kr70_1** pertain to Model 5 (Fig. 6.15, Sect. 6.3.1.4). Model 5 is a variation of Model 3, which represents a fissile material core blanketed with wet Kaolite and reflected by 20 cm of water. In Model 5, excess water from the wet Kaolite shell is assumed to migrate into the homogenized core. In each set of cases, the homogenized core consists of HEU metal loading of 7 kg ^{235}U for uranium at 100% enrichment, 500 g of polyethylene, and excess water from the wet Kaolite. In the three sets of cases "**athmpw15kr**," "**athmpw13kr**," and "**athmpw12kr**," the corresponding amounts of free water for the wet condition are 15 lb (6,803.9 g), 13 lb (5,896.7 g), and 12 lb (5,443.1 g), respectively. For all of these sets of parametric cases, the water content of the Kaolite shell ranges from the wet condition (9,008.5 g water or 8,101.4 g or 7,647.8 g) to the dry condition (2,204.7 g water) [Table 6.9.6-23, Appendix 6.9.6]. As excess water migrates from the wet Kaolite shell into the homogenized core, the radius for either fuel type expands accordingly but the

volume of the Kaolite shell remains constant. Consequently, the overall radius of the system increases. As stated previously, the 500 g of polyethylene has a fixed volume. Also, Kaolite is a porous material and its volume does not change appreciably as the material looses or gains water.

As shown in Fig. 6.30 and Table 6.9.6-23 (Appendix 6.9.6), the $k_{eff} + 2\sigma$ values increase to maximums of 0.9062, 0.9272, and 0.9596 with the addition to the fissile core of the entire 12 lb, 13 lb, and 15 lb amounts of free water from wet Kaolite. The homogenized core is under moderated because sufficient water is not present in the wet Kaolite and CV well to reach the point of optimum moderation. However, $k_{eff} + 2\sigma$ exceeds the USL of 0.925 for those cases where the total free water is greater than 12 lb (5,443.1 g). This signifies the fissile mass loading limit for HEU is 7 kg ^{235}U and the range of excess water cannot exceed 12 lb from the Kaolite and the CV well in order for the content to be shipped by air transport. Therefore, the evaluation of Model 6 is focused on this limit.

Cases **athmp15kmr_13_1_8_5** through **athmp15kmr_1_13_8_1** (Table 6.9.6-23, Appendix 6.9.6) pertain to Model 6 (Fig. 6.16, Sect. 6.3.1.4), where fissile material from the homogenized core of Model 4 forms a shell external to the core. The homogenized core consists of HEU at 100% enrichment, 500 g polyethylene, and Kaolite. In a series of cases, the amount of HEU in the shell is varied from 500 g to 6,500-g ^{235}U in 500 g increments and the remainder of the 7 kg ^{235}U is contained in the homogenized core. For these sets of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water). As shown in Fig. 6.31, all $k_{eff} + 2\sigma$ values are adequately below the USL of 0.925.

As stated previously, uranium alloy is conservatively assessed when alloy constituents, such as aluminum, molybdenum, zirconium, stainless steel, titanium, tungsten, niobium, silicon, or vanadium, are modeled as ^{235}U. Thus, limits established for HEU metal apply to the uranium alloys where the content mass of ^{235}U includes the mass of the non-uranium alloy constituents.

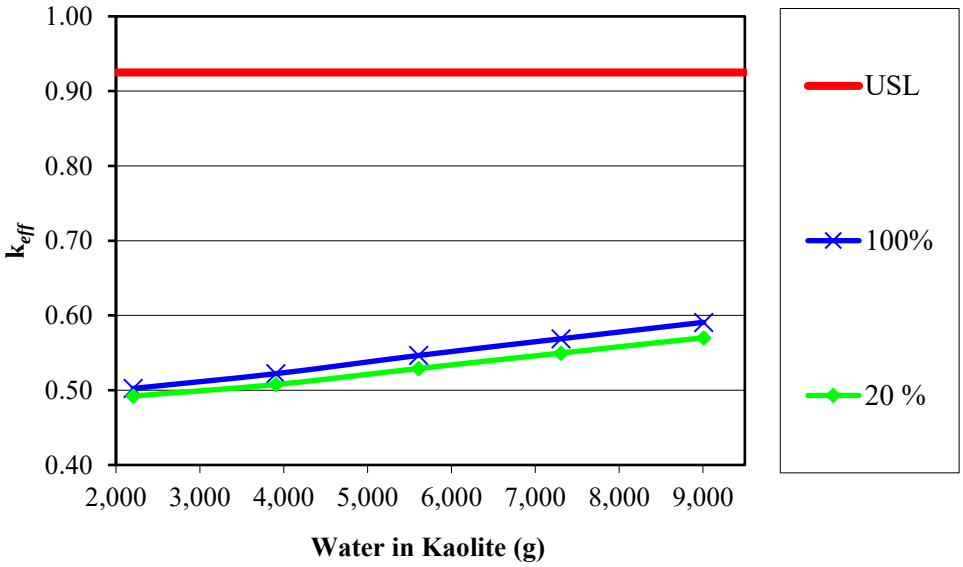


Fig. 6.29. k_{eff} vs water content (g) for homogenized core of HEU with 7 kg ^{235}U, 500 g polyethylene, and Kaolite where the Kaolite water content ranges from the dry to the wet condition.

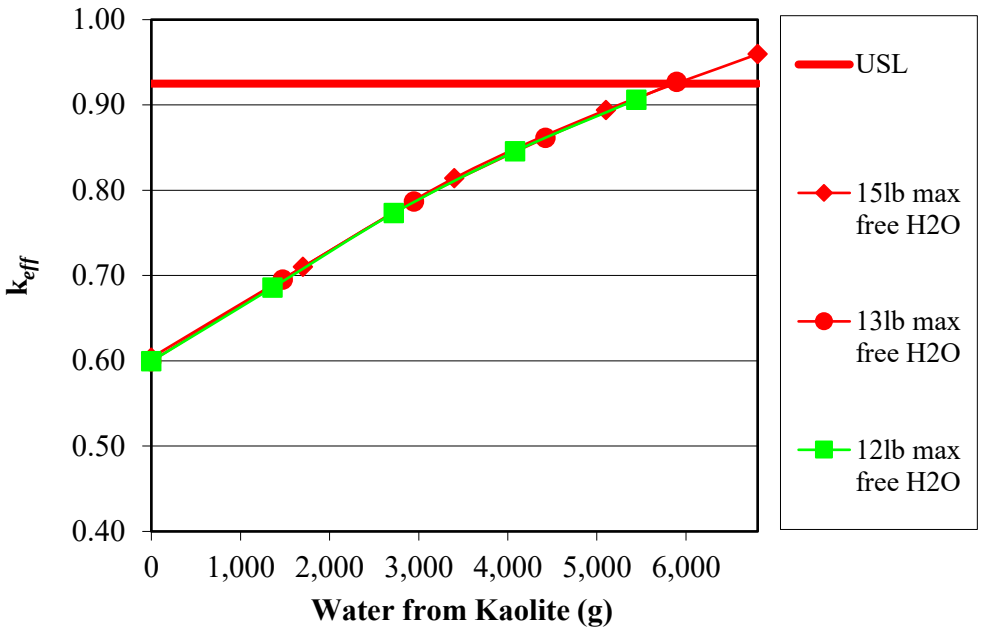
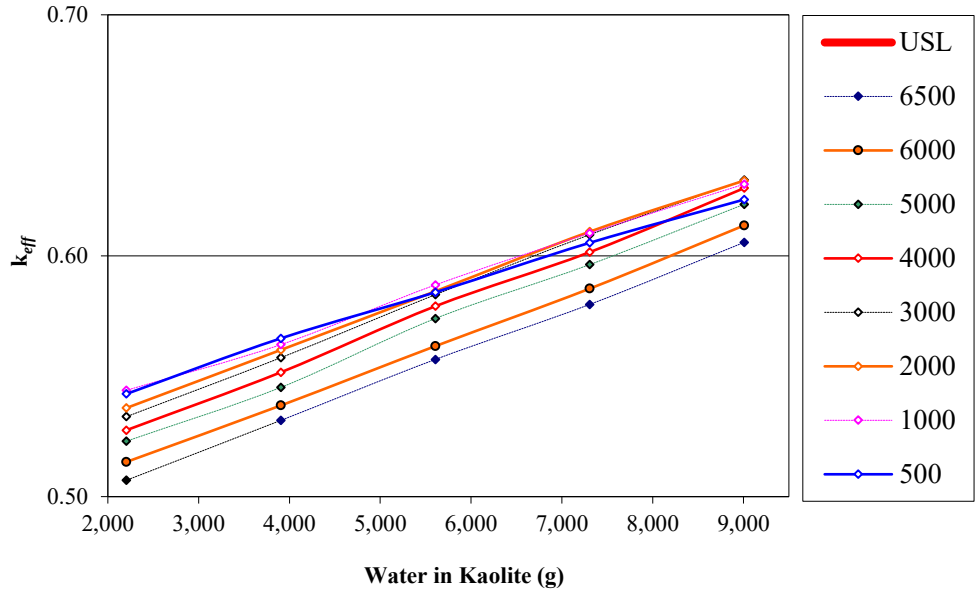


Fig. 6.30. k_{eff} vs excess water (g) from wet Kaolite for fissile core blanketed with a variable thickness Kaolite shell.



Note: Total quantity of HEU is 7-kg ^{235}U where the shell ranges from 500-g to 6,500-g ^{235}U and the remainder of the HEU is contained in the homogenized core.

Fig. 6.31. k_{eff} vs water (g) in Kaolite for homogenized core of HEU at 100% enrichment, 500-g polyethylene, and wet Kaolite encompassed by shell of ^{235}U.

6.7.4 Results for UF_4 Compounds

Case **atduf4r_1** through **atduf4r_10** (Table 6.9.6-24a, Appendix 6.9.6) pertains to Model 1 (Fig. 6.11, Sect. 6.3.1.4), in which varying amounts of UF_4 is homogenized with 500 g polyethylene. The fissile core is configured into a spherical shape with an exterior 20 cm water reflector. The UF_4 mass is evaluated up to 24 kg (which is the maximum allowed for ground transport), and the highest $k_{eff} + 2\sigma$ value of 0.807 (Table 6.9.6-24a, Appendix 6.9.6) is well below the USL of 0.93520.

Cases **atduf4sr_1** through **atduf4sr_11** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 2 (Fig. 6.12, Sect. 6.3.1.4), in which 24 kg of UF_4 is homogenized with 500 g polyethylene. The fissile core of Model 1 is blanketed with a variable thickness stainless steel shell with an exterior 20 cm water reflector. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero steel thickness. The $k_{eff} + 2\sigma$ value for 24 kg of UF_4 and zero stainless steel thickness is 0.805. Reactivity decreases, then increases as stainless steel is added to a maximum of 66,133 g, which is the highest amount of the CV and the liner and drum assembly. At maximum stainless steel thickness, the $k_{eff} + 2\sigma$ values increase but are well below the maximum reactivity at zero stainless steel thickness. The overall effect of adding stainless steel to the system is the reduction of the neutron multiplication in the system. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520.

Cases **atduf4dkr_1** through **atduf4dkr_6** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness dry-Kaolite shell with an exterior 20 cm water reflector. Dry Kaolite consists of 51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero shell-thickness for the dry Kaolite. The $k_{eff} + 2\sigma = 0.679$ for 24 kg of UF_4. As the amount of dry Kaolite is added to the shell surrounding the UF_4, reactivity decreases. A significant drop in the neutron multiplication factor is observed for the addition of the dry-Kaolite shell to the fissile core. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520.

Cases **atduf415kr_1** through **atduf415kr_6** (Table 6.9.6-24a, Appendix 6.9.6) also pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness wet-Kaolite shell with an exterior 20 cm water reflector. As explained in Sect. 6.3.1.4, wet Kaolite to a maximum of 60,223 g consists of the dry Kaolite [51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug] and up to 6,803.8 g free water—moisture which dampens the Kaolite and may also be present in the CV well. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero shell-thickness for the wet Kaolite. The $k_{eff} + 2\sigma = 0.806$ for 24 kg of UF_4. As the amount of wet Kaolite is added to the shell surrounding the UF_4, reactivity decreases. A significant drop in the neutron multiplication factor is observed for the addition of the wet-Kaolite shell to the fissile core. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520.

Note that in these calculations the water comes from three sources: bound water in the Kaolite, free water in the Kaolite, and saturated water inside the compound. The amount of bounded water in the Kaolite is 2,205 g. The amount of free water is calculated at 12 and 15 pounds, which is 5,445 g of free water and 6,804 g, respectively. The remaining water is the saturated water that is originally in the compound.

Cases **athuf4p15kr_1** through **athuf4p15kr_5** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 4 (Fig. 6.14, Sect. 6.3.1.4). The homogenized core consists of 24 kg of UF_4, 500 g of polyethylene, and Kaolite. For this set of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water) [Table 6.9.6-24a, Appendix 6.9.6]. For Model 4, the overall radius at 31.34526 cm is constant for several reasons. First, the 500 g of

polyethylene has a fixed volume. Second, the Kaolite is a porous material and the volume does not change appreciably as the material is dried out or absorbs water.

As shown in Table 6.9.6-24a, a gradual increase in $k_{eff} + 2\sigma$ occurs from dry condition to the wet condition. The homogenization of the Kaolite shell and the fissile material core from Model 3 produces two competing effects in Model 4:

- homogenization expands the fissile material core resulting in a decrease in neutron multiplication (from $k_{eff} + 2\sigma = 0.806$ in Case **atduf415kr_1** to $k_{eff} + 2\sigma = 0.603$ in Case **atduf415kr_6**), and

- the increase in the free water content of the Kaolite (and CV well) increases neutron multiplication in the core (from $k_{eff} + 2\sigma = 0.568$ in Case **athuf4p15kr_1** to $k_{eff} + 2\sigma = 0.661$ in Case **athuf4p15kr_5**).

Consequently, the scenario of water penetration of fissile material core under Model 5 requires evaluation.

Cases **athuf4pw12kr_1_7** through **athuf4pw12kr_5_7** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 5 (Fig. 6.15, Sect. 6.3.1.4). Model 5 is a variation of Model 3, which represents a fissile material core blanketed with wet Kaolite and reflected by 20 cm of water. In Model 5, excess water from the wet Kaolite shell is assumed to migrate into the homogenized core. The homogenized core consists of 24 kg of UF_4, 500 g of polyethylene, and excess water from the wet Kaolite. The water content of the Kaolite shell ranges from the wet condition (7,648 g water, free and bounded) to the dry condition (2,205 g bounded water) [Table 6.9.6-24a, Appendix 6.9.6]. As excess water migrates from the wet Kaolite shell into the homogenized core, the core radius expands from 9.9770 to 13.18986 cm. However, the volume of the Kaolite shell remains constant because the Kaolite is a porous material and the volume does not change appreciably as the material loses or gains water.

As shown in Table 6.9.6-24a (Appendix 6.9.6), the $k_{eff} + 2\sigma$ values increase to maximum of 0.908 with the addition of the entire 6,803.9 g of water from wet Kaolite into the fissile material core. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520. The homogenized core is under moderated because sufficient water is not present in the wet Kaolite and CV well to reach the point of optimum moderation. The total free water is conservatively evaluated up to 12 lb (5,443 g).

In the absence of 10 CFR 71.55(f) test data or dynamic impact simulations per Type-C test criteria, the assumption of water penetration of the fissile material core is valid under the severe air transport evaluation criteria. Model 5 is applicable to air transport of the ES-3100 package given that the geometric form of the content following the air transport accident cannot be established.

Cases **athuf4p15kor_1_1_1** through **athuf4p15kor_5_5_5** (Table 6.9.6-24b, Appendix 6.9.6) pertain to Model 6 (Fig. 6.16, Sect. 6.3.1.4), where fissile material from the homogenized core of Model 4 forms a shell external to the core. The homogenized core consists of 24 kg of UF_4, 500 g polyethylene, and Kaolite. In a series of cases, the amount of UF_4 in the shell is varied from 2,000 g to 22,000-g UF_4 in 4,000 g increments and the remainder of the 24 kg UF_4 is contained in the homogenized core [Table 6.9.6-24b, Appendix 6.9.6]. For these sets of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water). All $k_{eff} + 2\sigma$ values are adequately below the USL of 0.93680.

6.7.5 Results for UO_2F_2 Compounds

Case **atduo2f2r_1 through atduo2f2r_3** (Table 6.9.6-24a, Appendix 6.9.6) pertains to Model 1 (Fig. 6.11, Sect. 6.3.1.4), in which varying amounts of UO_2F_4 is homogenized with 500 g polyethylene. The fissile core is configured into a spherical shape with an exterior 20 cm water reflector. The UO_2F_2 mass is evaluated up to 3 kg (which is the maximum allowed for ground transport), with the highest $k_{eff} + 2\sigma$ value of 0.678 (Table 6.9.6-24a, Appendix 6.9.6) is well below the USL of 0.93520.

Cases **atduo2f2sr_1** through **atduo2f2sr_11** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 2 (Fig. 6.12, Sect. 6.3.1.4), in which 3 kg of UO_2F_4 is homogenized with 500 g polyethylene. The fissile core of Model 1 is blanketed with a variable thickness stainless steel shell with an exterior 20 cm water reflector. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero steel thickness. The $k_{eff} + 2\sigma$ value for 3 kg of UO_2F_2 and zero stainless steel thickness is 0.678. Reactivity decreases, then increases as stainless steel is added to a maximum of 66,133 g, which is the highest amount of the CV and the liner and drum assembly. At maximum stainless steel thickness, the $k_{eff} + 2\sigma$ values increase but are well below the maximum reactivity at zero stainless steel thickness. The overall effect of adding stainless steel to the system is the reduction of the neutron multiplication in the system. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520.

Cases **atduo2f2dkr_1** through **atduo2f2dkr_6** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness dry-Kaolite shell with an exterior 20 cm water reflector. Dry Kaolite consists of 51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero shell-thickness for the dry Kaolite. The $k_{eff} + 2\sigma = 0.679$ for 3 kg of UO_2F_2. As the amount of dry Kaolite is added to the shell surrounding the UO_2F_4, reactivity decreases. A significant drop in the neutron multiplication factor is observed for the addition of the dry-Kaolite shell to the fissile core. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520.

Cases **atduo2f215kr_1** through **atduo2f215kr_6** (Table 6.9.6-24a, Appendix 6.9.6) also pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness wet-Kaolite shell with an exterior 20 cm water reflector. As explained in Sect. 6.3.1.4, wet Kaolite to a maximum of 60,223 g consists of the dry Kaolite [51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug] and up to 6,803.8 g free water—moisture which dampens the Kaolite and may also be present in the CV well. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero shell-thickness for the wet Kaolite. The $k_{eff} + 2\sigma = 0.678$ for 3 kg of UO_2F_4. As the amount of wet Kaolite is added to the shell surrounding the UO_2F_2, reactivity decreases. A significant drop in the neutron multiplication factor is observed for the addition of the wet-Kaolite shell to the fissile core. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520.

Note that in these calculations the water comes from three sources: bound water in the Kaolite, free water in the Kaolite, and saturated water inside the compound. The amount of bounded water in the Kaolite is 2,205 g. The amount of free water is calculated at 12 and 15 pounds, which is 5,445 g of free water and 6,804 g respectively. The remaining water is the saturated water that is originally in the compound.

Cases **athuo2f2p15kr_1** through **athuo2f2p15kr_5** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 4 (Fig. 6.14, Sect. 6.3.1.4). The homogenized core consists of 3 kg of UO_2F_2, 500 g of polyethylene, and Kaolite. For this set of parametric cases, the Kaolite water content ranges from the wet condition (7,648 g water, free and bounded) to the dry condition (2,205 g bounded water) [Table 6.9.6-24a, Appendix 6.9.6]. For Model 4, the overall radius at 31.10196 cm is constant for several

reasons. First, the 500 g of polyethylene has a fixed volume. Second, the Kaolite is a porous material and the volume does not change appreciably as the material is dried out or absorbs water.

As shown in Table 6.9.6-24a, a gradual increase in $k_{eff} + 2\sigma$ occurs from dry condition to the wet condition. The homogenization of the Kaolite shell and the fissile material core from Model 3 produces two competing effects in Model 4:

- homogenization expands the fissile material core resulting in a decrease in neutron multiplication (from $k_{eff} + 2\sigma = 0.679$ in Case **atduo2f215kr_1** to $k_{eff} + 2\sigma = 0.433$ in Case **atduo2f215kr_6**), and

- the increase in the free water content of the Kaolite (and CV well) increases neutron multiplication in the core (from $k_{eff} + 2\sigma = 0.405$ in Case **athuo2f2p15kr_1** to $k_{eff} + 2\sigma = 0.478$ in Case **athuo2f2p15kr_5**).

Consequently, the scenario of water penetration of fissile material core under Model 5 requires evaluation.

Cases **athuo2f2pw12kr_1_3** through **athuo2f2pw12kr_5_3** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 5 (Fig. 6.15, Sect. 6.3.1.4). Model 5 is a variation of Model 3, which represents a fissile material core blanketed with wet Kaolite and reflected by 20 cm of water. In Model 5, excess water from the wet Kaolite shell is assumed to migrate into the homogenized core. The homogenized core consists of 3 kg of UO_2F_2, 500 g of polyethylene, and excess water from the wet Kaolite. The water content of the Kaolite shell ranges from the wet condition (7,648 g water, free and bounded) to the dry condition (2,205 g bounded water) [Table 6.9.6-22a, Appendix 6.9.6]. As excess water migrates from the wet Kaolite shell into the homogenized core, the core radius expands from 6.55398 to 11.40090 cm. However, the volume of the Kaolite shell remains constant because the Kaolite is a porous material, and the volume does not change appreciably as the material loses or gains water.

As shown in Table 6.9.6-24a (Appendix 6.9.6), the $k_{eff} + 2\sigma$ values increase to maximum of 0.864 with the addition of the entire 5,445 g of water from wet Kaolite into the fissile material core. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93680. The homogenized core is under moderated because sufficient water is not present in the wet Kaolite and CV well to reach the point of optimum moderation. The total free water is conservatively evaluated up to 12 lb (5,443 g).

In the absence of 10 CFR 71.55(f) test data or dynamic impact simulations per Type-C test criteria, the assumption of water penetration of the fissile material core is valid under the severe air transport evaluation criteria. Model 5 is applicable to air transport of the ES-3100 package given that the geometric form of the content following the air transport accident cannot be established.

Cases **athuo2f2p15kor_1_1_1** through **athuo2f2p15kor_5_5_5** (Table 6.9.6-24b, Appendix 6.9.6) pertain to Model 6 (Fig. 6.16, Sect. 6.3.1.4), where fissile material from the homogenized core of Model 4 forms a shell external to the core. The homogenized core consists of 3 kg of UO_2F_4, 500 g polyethylene, and Kaolite. In a series of cases, the amount of UO_2F_2 in the shell is varied from 500 g to 2,500-g UO_2F_2 in 500 g increments and the remainder of the 3 kg UO_2F_2 is contained in the homogenized core. For these sets of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water). All $k_{eff} + 2\sigma$ values are adequately below the USL of 0.93680.

6.7.6 Results for UC Compounds

Case **atducr_1 through atducr_4** (Table 6.9.6-24a, Appendix 6.9.6) pertains to Model 1 (Fig. 6.11, Sect. 6.3.1.4), in which varying amounts of UC is homogenized with 500 g polyethylene. The fissile core is configured into a spherical shape with an exterior 20 cm water reflector. The UC mass is evaluated up to 2 kg (which is the maximum allowed for ground transport), with the highest $k_{eff} + 2\sigma$ value of 0.756 (Table 6.9.6-24a, Appendix 6.9.6) is well below the USL of 0.93680.

Cases **atducsr_1** through **atducsr_11** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 2 (Fig. 6.12, Sect. 6.3.1.4), in which 2 kg of UC is homogenized with 500 g polyethylene. The fissile core of Model 1 is blanketed with a variable thickness stainless steel shell with an exterior 20 cm water reflector. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero steel thickness. The $k_{eff} + 2\sigma$ value for 2 kg of UC and zero stainless steel thickness is 0.757. Reactivity decreases, then increases as stainless steel is added to a maximum of 66,133 g, which is the highest amount of the CV and the liner and drum assembly. At maximum stainless steel thickness, the $k_{eff} + 2\sigma$ values increase but are well below the maximum reactivity at zero stainless steel thickness. The overall effect of adding stainless steel to the system is initially a reduction of the neutron multiplication in the system, but as the maximum amount of steel is added there is an increase of the neutron multiplication in the system. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520.

Cases **atducdkr_1** through **atducdkr_6** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness dry-Kaolite shell with an exterior 20 cm water reflector. Dry Kaolite consists of 51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero shell-thickness for the dry Kaolite. The $k_{eff} + 2\sigma = 0.756$ for 2 kg of UC. As the amount of dry Kaolite is added to the shell surrounding the UC, reactivity decreases. A significant drop in the neutron multiplication factor is observed for the addition of the dry-Kaolite shell to the fissile core. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520.

Cases **atduc15kr_1** through **atduc15kr_6** (Table 6.9.6-24a, Appendix 6.9.6) also pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness wet-Kaolite shell with an exterior 20 cm water reflector. As explained in Sect. 6.3.1.4, wet Kaolite to a maximum of 60,223 g consists of the dry Kaolite [51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug] and up to 6,803.8 g free water—moisture which dampens the Kaolite and may also be present in the CV well. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero shell-thickness for the wet Kaolite. The $k_{eff} + 2\sigma = 0.757$ for 2 kg of UC. As the amount of wet Kaolite is added to the shell surrounding the UC, reactivity decreases. A significant drop in the neutron multiplication factor is observed for the addition of the wet-Kaolite shell to the fissile core. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520.

Note that in these calculations the water comes from three sources: bound water in the Kaolite, free water in the Kaolite, and saturated water inside the compound. The amount of bounded water in the Kaolite is 2,205 g. The amount of free water is calculated at 12 and 15 pounds, which is 5,445 g of free water and 6,804 g respectively. The remaining water is the saturated water that is originally in the compound.

Cases **athucp15kr_1** through **athucp15kr_5** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 4 (Fig. 6.14, Sect. 6.3.1.4). The homogenized core consists of 2 kg of UC, 500 g of polyethylene, and Kaolite. For this set of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water) [Table 6.9.6-24a, Appendix 6.9.6]. For Model 4,

the overall radius at 31.13189 cm is constant for several reasons. First, the 500 g of polyethylene has a fixed volume. Second, the Kaolite is a porous material, and the volume does not change appreciably as the material is dried out or absorbs water.

As shown in Table 6.9.6-24a, a gradual increase in $k_{eff} + 2\sigma$ occurs from dry condition to the wet condition. The homogenization of the Kaolite shell and the fissile material core from Model 3 produces two competing effects in Model 4:

- homogenization expands the fissile material core resulting in a decrease in neutron multiplication (from $k_{eff} + 2\sigma = 0.757$ in Case **atduc15kr_1** to $k_{eff} + 2\sigma = 0.531$ in Case **atduc15kr_6**), and

- the increase in the free water content of the Kaolite (and CV well) increases neutron multiplication in the core (from $k_{eff} + 2\sigma = 0.401$ in Case **athucp15kr_1** to $k_{eff} + 2\sigma = 0.473$ in Case **athucp15kr_5**).

Consequently, the scenario of water penetration of fissile material core under Model 5 requires evaluation.

Cases **athucpw12kr_1_5** through **athucpw12kr_4_5** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 5 (Fig. 6.15, Sect. 6.3.1.4). Model 5 is a variation of Model 3, which represents a fissile material core blanketed with wet Kaolite and reflected by 20 cm of water. In Model 5, excess water from the wet Kaolite shell is assumed to migrate into the homogenized core. The homogenized core consists of 2 kg of UC, 500 g of polyethylene, and excess water from the wet Kaolite. The water content of the Kaolite shell ranges from the wet condition (7,648 g water, free and bounded) to the dry condition (2,205 g bounded water) [Table 6.9.6-24a, Appendix 6.9.6]. As excess water migrates from the wet Kaolite shell into the homogenized core, the core radius expands from 7.16920 to 11.86429 cm. However, the volume of the Kaolite shell remains constant because the Kaolite is a porous material and the volume does not change appreciably as the material loses or gains water.

As shown in Table 6.9.6-24a (Appendix 6.9.6), the $k_{eff} + 2\sigma$ values increase to maximum of 0.882 with the addition of the entire 5,445 g of water from wet Kaolite into the fissile material core. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520. The homogenized core is under moderated because sufficient water is not present in the wet Kaolite and CV well to reach the point of optimum moderation. The total free water is conservatively evaluated up to 12 lb (5,443 g).

In the absence of 10 CFR 71.55(f) test data or dynamic impact simulations per Type-C test criteria, the assumption of water penetration of the fissile material core is valid under the severe air transport evaluation criteria. Model 5 is applicable to air transport of the ES-3100 package given that the geometric form of the content following the air transport accident cannot be established.

Cases **athucp15kor_1_1_1** through **athucp15kor_5_3_3** (Table 6.9.6-24b, Appendix 6.9.6) pertain to Model 6 (Fig. 6.16, Sect. 6.3.1.4), where fissile material from the homogenized core of Model 4 forms a shell external to the core. The homogenized core consists of 2 kg of UC, 500 g polyethylene, and Kaolite. In a series of cases, the amount of UC in the shell is varied from 500 g to 1,500-g UC in 500 g increments and the remainder of the 2 kg UC is contained in the homogenized core. For these sets of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water). All $k_{eff} + 2\sigma$ values are adequately below the USL of 0.93680.

6.7.7 Results for UN Compounds

Case **atdunr_1** through **atdunr_4** (Table 6.9.6-24a, Appendix 6.9.6) pertains to Model 1 (Fig. 6.11, Sect. 6.3.1.4), in which varying amounts of UN is homogenized with 500 g polyethylene. The fissile core is configured into a spherical shape with an exterior 20 cm water reflector. The UC mass is evaluated up to 2 kg (which is the maximum allowed for ground transport), with the highest $k_{eff} + 2\sigma$ value of 0.755 (Table 6.9.6-24a, Appendix 6.9.6) is well below the USL of 0.93680.

Cases **atdunsr_1** through **atducnr_11** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 2 (Fig. 6.12, Sect. 6.3.1.4), in which 2 kg of UN is homogenized with 500 g polyethylene. The fissile core of Model 1 is blanketed with a variable thickness stainless steel shell with an exterior 20 cm water reflector. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero steel thickness. The $k_{eff} + 2\sigma$ value for 2 kg of UN and zero stainless steel thickness is 0.756. Reactivity decreases, then increases as stainless steel is added to a maximum of 66,133 g, which is the highest amount of the CV and the liner and drum assembly. At maximum stainless steel thickness, the $k_{eff} + 2\sigma$ values increase but are well below the maximum reactivity at zero stainless steel thickness. The overall effect of adding stainless steel to the system is the reduction of the neutron multiplication in the system. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520.

Cases **atdundkr_1** through **atdundkr_6** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness dry-Kaolite shell with an exterior 20 cm water reflector. Dry Kaolite consists of 51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero shell-thickness for the dry Kaolite. The $k_{eff} + 2\sigma = 0.756$ for 2 kg of UN. As the amount of dry Kaolite is added to the shell surrounding the UN, reactivity decreases. A significant drop in the neutron multiplication factor is observed for the addition of the dry-Kaolite shell to the fissile core. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520.

Cases **atdun15kr_1** through **atdun15kr_6** (Table 6.9.6-24a, Appendix 6.9.6) also pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness wet-Kaolite shell with an exterior 20 cm water reflector. As explained in Sect. 6.3.1.4, wet Kaolite to a maximum of 60,223 g consists of the dry Kaolite [51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug] and up to 6,803.8 g free water—moisture which dampens the Kaolite and may also be present in the CV well. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero shell-thickness for the wet Kaolite. The $k_{eff} + 2\sigma = 0.756$ for 2 kg of UN. As the amount of wet Kaolite is added to the shell surrounding the UN, reactivity decreases. A significant drop in the neutron multiplication factor is observed for the addition of the wet-Kaolite shell to the fissile core. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520.

Note that in these calculations the water comes from three sources: bound water in the Kaolite, free water in the Kaolite, and saturated water inside the compound. The amount of bounded water in the Kaolite is 2,205 g. The amount of free water is calculated at 12 and 15 pounds, which is 5,445 g of free water and 6,804 g respectively. The remaining water is the saturated water that is originally in the compound.

Cases **athunp15kr_1** through **athunp15kr_5** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 4 (Fig. 6.14, Sect. 6.3.1.4). The homogenized core consists of 2 kg of UN, 500 g of polyethylene, and Kaolite. For this set of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water) [Table 6.9.6-24a, Appendix 6.9.6]. For Model 4, the overall radius at 31.13189 cm is constant for several reasons. First, the 500 g of polyethylene has a

fixed volume. Second, the Kaolite is a porous material and the volume does not change appreciably as the material is dried out or absorbs water.

As shown in Table 6.9.6-24a, a gradual increase in $k_{eff} + 2\sigma$ occurs from dry condition to the wet condition. The homogenization of the Kaolite shell and the fissile material core from Model 3 produces two competing effects in Model 4:

- homogenization expands the fissile material core resulting in a decrease in neutron multiplication (from $k_{eff} + 2\sigma = 0.756$ in Case **atdun15kr_1** to $k_{eff} + 2\sigma = 0.531$ in Case **atdun15kr_6**), and

- the increase in the free water content of the Kaolite (and CV well) increases neutron multiplication in the core (from $k_{eff} + 2\sigma = 0.399$ in Case **athunp15kr_1** to $k_{eff} + 2\sigma = 0.470$ in Case **athunp15kr_5**).

Consequently, the scenario of water penetration of fissile material core under Model 5 requires evaluation.

Cases **athunpw12kr_1_5** through **athunpw12kr_4_5** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 5 (Fig. 6.15, Sect. 6.3.1.4). Model 5 is a variation of Model 3, which represents a fissile material core blanketed with wet Kaolite and reflected by 20 cm of water. In Model 5, excess water from the wet Kaolite shell is assumed to migrate into the homogenized core. The homogenized core consists of 2 kg of UN, 500 g of polyethylene, and excess water from the wet Kaolite. The water content of the Kaolite shell ranges from the wet condition (7,648 g water, free and bounded) to the dry condition (2,205 g bounded water) [Table 6.9.6-24a, Appendix 6.9.6]. As excess water migrates from the wet Kaolite shell into the homogenized core, the core radius expands from 7.16920 to 11.86429 cm. However, the volume of the Kaolite shell remains constant because the Kaolite is a porous material and the volume does not change appreciably as the material loses or gains water.

As shown in Table 6.9.6-24a (Appendix 6.9.6), the $k_{eff} + 2\sigma$ values increase to maximum of 0.882 with the addition of the entire 5,445 g of water from wet Kaolite into the fissile material core. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520. The homogenized core is under moderated because sufficient water is not present in the wet Kaolite and CV well to reach the point of optimum moderation. The total free water is conservatively evaluated up to 12 lb (5,443 g).

In the absence of 10 CFR 71.55(f) test data or dynamic impact simulations per Type-C test criteria, the assumption of water penetration of the fissile material core is valid under the severe air transport evaluation criteria. Model 5 is applicable to air transport of the ES-3100 package given that the geometric form of the content following the air transport accident cannot be established.

Cases **athunp15kor_1_1_1** through **athunp15kor_5_3_3** (Table 6.9.6-24b, Appendix 6.9.6) pertain to Model 6 (Fig. 6.16, Sect. 6.3.1.4), where fissile material from the homogenized core of Model 4 forms a shell external to the core. The homogenized core consists of 2 kg of UC, 500 g polyethylene, and Kaolite. In a series of cases, the amount of UN in the shell is varied from 500 g to 1,500-g UN in 500 g increments and the remainder of the 2 kg UN is contained in the homogenized core. For these sets of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water). All $k_{eff} + 2\sigma$ values are adequately below the USL of 0.93680.

6.7.8 Results for U_3Si_2 Compounds at 40% Enriched

Case **atdu3si2r40_1** through **atdu3si2r40_8** (Table 6.9.6-24a, Appendix 6.9.6) pertains to Model 1 (Fig. 6.11, Sect. 6.3.1.4), in which varying amounts of U_3Si_2 is homogenized with 500 g polyethylene. The fissile core is configured into a spherical shape with an exterior 20 cm water reflector. The U_3Si_2 mass is evaluated up to 11 kg (which is less than what is allowed for ground transport), with the highest $k_{eff} + 2\sigma$ value of 0.938 (Table 6.9.6-24a, Appendix 6.9.6) is above the USL of 0.93520. A lower U_3Si_2 mass is evaluated, 10.5 kg, with the $k_{eff} + 2\sigma$ value of 0.930 (Table 6.9.6-22a, Appendix 6.9.6) is below the USL of 0.93520

Cases **atdu3si2sr40_1** through **atdu3si2sr40_11** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 2 (Fig. 6.12, Sect. 6.3.1.4), in which 10.5 kg of U_3Si_2 is homogenized with 500 g polyethylene. The fissile core of Model 1 is blanketed with a variable thickness stainless steel shell with an exterior 20 cm water reflector. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero steel thickness. The $k_{eff} + 2\sigma$ value for 10.5 kg of U_3Si_2 and zero stainless steel thickness is 0.930. The $k_{eff} + 2\sigma$ value decreases to minimum value for a stainless steel thickness. Reactivity decreases, then increases as stainless steel is added to a maximum of 66,133 g, which is the highest amount of the CV and the liner and drum assembly. At maximum stainless steel thickness, the $k_{eff} + 2\sigma$ values increase but are well below the maximum reactivity at zero stainless steel thickness. The overall effect of adding stainless steel to the system is the reduction of the neutron multiplication in the system. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520.

Cases **atdu3si2dkr40_1** through **atdu3si2dkr40_6** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness dry-Kaolite shell with an exterior 20 cm water reflector. Dry Kaolite consists of 51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero shell-thickness for the dry Kaolite. The $k_{eff} + 2\sigma = 0.930$ for 11 kg of U_3Si_2. As the amount of dry Kaolite is added to the shell surrounding the U_3Si_2, reactivity decreases. A significant drop in the neutron multiplication factor is observed for the addition of the dry-Kaolite shell to the fissile core. The $k_{eff} + 2\sigma$ values are below the USL of 0.93520.

Cases **atdu3si215kr40_1** through **atdu3si215kr40_6** (Table 6.9.6-24a, Appendix 6.9.6) also pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness wet-Kaolite shell with an exterior 20 cm water reflector. As explained in Sect. 6.3.1.4, wet Kaolite to a maximum of 60,223 g consists of the dry Kaolite [51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug] and up to 6,803.8 g free water—moisture which dampens the Kaolite and may also be present in the CV well. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero shell-thickness for the wet Kaolite. The $k_{eff} + 2\sigma = 0.930$ for 10.5 kg of U_3Si_2. As the amount of wet Kaolite is added to the shell surrounding the U_3Si_2, reactivity decreases. A significant drop in the neutron multiplication factor is observed for the addition of the wet-Kaolite shell to the fissile core. The $k_{eff} + 2\sigma$ values are below the USL of 0.93520.

Note that in these calculations the water comes from three sources: bound water in the Kaolite, free water in the Kaolite, and saturated water inside the compound. The amount of bounded water in the Kaolite is 2,205 g. The amount of free water is calculated at 12 and 15 pounds, which is 5,445 g of free water and 6,804 g respectively. The remaining water is the saturated water that is originally in the compound.

Cases **athu3si2p15kr40_1** through **athu3si2p15kr40_5** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 4 (Fig. 6.14, Sect. 6.3.1.4). The homogenized core consists of 10.5 kg of U_3Si_2, 500 g of

polyethylene, and Kaolite. For this set of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water) [Table 6.9.6-24a, Appendix 6.9.6]. For Model 4, the overall radius at 31.47701 cm is constant for several reasons. First, the 500 g of polyethylene has a fixed volume. Second, the Kaolite is a porous material and the volume does not change appreciably as the material is dried out or absorbs water.

As shown in Table 6.9.6-24a, a gradual increase in $k_{eff} + 2\sigma$ occurs from dry condition to the wet condition. The homogenization of the Kaolite shell and the fissile material core from Model 3 produces two competing effects in Model 4:

- homogenization expands the fissile material core resulting in a decrease in neutron multiplication (from $k_{eff} + 2\sigma = 0.930$ in Case **atdu3si215kr40_1** to $k_{eff} + 2\sigma = 0.769$ in Case **atdu3si215kr40_6**), and

- the increase in the free water content of the Kaolite (and CV well) increases neutron multiplication in the core (from $k_{eff} + 2\sigma = 0.500$ in Case **athu3si2p15kr40_1** to $k_{eff} + 2\sigma = 0.582$ in Case **athu3si2p15kr40_5**).

Consequently, the scenario of water penetration of fissile material core under Model 5 requires evaluation.

Cases **athu3si2pw12kr40_1_5** through **athu3si2pw12kr40_7_5** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 5 (Fig. 6.15, Sect. 6.3.1.4). Model 5 is a variation of Model 3, which represents a fissile material core blanketed with wet Kaolite and reflected by 20 cm of water. In Model 5, excess water from the wet Kaolite shell is assumed to migrate into the homogenized core. The homogenized core consists of 8.5 kg of U_3Si_2 (note this mass is less than 10.5 kg evaluated in Models 1 through 4), 500 g of polyethylene, and excess water from the wet Kaolite. The water content of the Kaolite shell ranges from the wet condition (7,648 g water, free and bounded) to the dry condition (2,205 g bounded water) [Table 6.9.6-24a, Appendix 6.9.6]. As excess water migrates from the wet Kaolite shell into the homogenized core, the core radius expands from 10.45974 to 13.47350 cm. However, the volume of the Kaolite shell remains constant because the Kaolite is a porous material and the volume does not change appreciably as the material loses or gains water.

As shown in Table 6.9.6-24a, the $k_{eff} + 2\sigma$ values increase to maximum of 0.924 with the addition of the entire 5,445 g of water from wet Kaolite into the fissile material core. The $k_{eff} + 2\sigma$ values are below the USL of 0.93680. The homogenized core is under moderated because sufficient water is not present in the wet Kaolite and CV well to reach the point of optimum moderation. The total free water is conservatively evaluated up to 12 lb (5,443 g).

In the absence of 10 CFR 71.55(f) test data or dynamic impact simulations per Type-C test criteria, the assumption of water penetration of the fissile material core is valid under the severe air transport evaluation criteria. Model 5 is applicable to air transport of the ES-3100 package given that the geometric form of the content following the air transport accident cannot be established.

Cases **athu3si2p15kor40_1_1_1** through **athu3si2p15kor40_5_6_6** (Table 6.9.6-24b, Appendix 6.9.6) pertain to Model 6 (Fig. 6.16, Sect. 6.3.1.4), where fissile material from the homogenized core of Model 4 forms a shell external to the core. The homogenized core consists of 8.5 kg of U_3Si_2, 500 g polyethylene, and Kaolite. In a series of cases, the amount of U_3Si_2 in the shell is varied from 1,000 g to 7,500-g U_3Si_2 in various increments and the remainder of the 8.5 kg U_3Si_2 is contained in the homogenized core. For these sets of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water). All $k_{eff} + 2\sigma$ values are adequately below the USL of 0.93680.

6.7.9 Results for U_3Si_2 Compounds at 60% Enriched

Case **atdu3si2r60_1** through **atdu3si2r60_4** (Table 6.9.6-24a, Appendix 6.9.6) pertains to Model 1 (Fig. 6.11, Sect. 6.3.1.4), in which varying amounts of U_3Si_2 is homogenized with 500 g polyethylene. The fissile core is configured into a spherical shape with an exterior 20 cm water reflector. The U_3Si_2 mass is evaluated up to 7 kg (which is the maximum allowed for ground transport), with the highest $k_{eff} + 2\sigma$ value of 0.888 (Table 6.9.6-24a, Appendix 6.9.6) is below the USL of 0.93520.

Cases **atdu3si2sr60_1** through **atdu3si2sr60_11** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 2 (Fig. 6.12, Sect. 6.3.1.4), in which 7 kg of U_3Si_2 is homogenized with 500 g polyethylene. The fissile core of Model 1 is blanketed with a variable thickness stainless steel shell with an exterior 20 cm water reflector. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero steel thickness. The $k_{eff} + 2\sigma$ value for 7 kg of U_3Si_2 and zero stainless steel thickness is 0.888. Reactivity decreases, then increases as stainless steel is added to a maximum of 66,133 g, which is the highest amount of the CV and the liner and drum assembly. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520.

Cases **atdu3si2dkr60_1** through **atdu3si2dkr60_6** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness dry-Kaolite shell with an exterior 20 cm water reflector. Dry Kaolite consists of 51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero shell-thickness for the dry Kaolite. The $k_{eff} + 2\sigma = 0.887$ for 7 kg of U_3Si_2. As the amount of dry Kaolite is added to the shell surrounding the U_3Si_2, reactivity decreases. A significant drop in the neutron multiplication factor is observed for the addition of the dry-Kaolite shell to the fissile core. The $k_{eff} + 2\sigma$ values are below the USL of 0.93520.

Cases **atdu3si215kr60_1** through **atdu3si215kr60_6** (Table 6.9.6-24a, Appendix 6.9.6) also pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness wet-Kaolite shell with an exterior 20 cm water reflector. As explained in Sect. 6.3.1.4, wet Kaolite to a maximum of 60,223 g consists of the dry Kaolite [51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug] and up to 6,803.8 g free water—moisture which dampens the Kaolite and may also be present in the CV well. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero shell-thickness for the wet Kaolite. The $k_{eff} + 2\sigma = 0.887$ for 7 kg of U_3Si_2. As the amount of wet Kaolite is added to the shell surrounding the U_3Si_2, reactivity decreases. A significant drop in the neutron multiplication factor is observed for the addition of the wet-Kaolite shell to the fissile core. The $k_{eff} + 2\sigma$ values are below the USL of 0.93520.

Note that in these calculations the water comes from three sources: bound water in the Kaolite, free water in the Kaolite, and saturated water inside the compound. The amount of bounded water in the Kaolite is 2,205 g. The amount of free water is calculated at 12 and 15 pounds, which is 5,445 g of free water and 6,804 g respectively. The remaining water is the saturated water that is originally in the compound.

Cases **athu3si2p15kr60_1** through **athu3si2p15kr60_5** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 4 (Fig. 6.14, Sect. 6.3.1.4). The homogenized core consists of 7 kg of U_3Si_2, 500 g of polyethylene, and Kaolite. For this set of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water) [Table 6.9.6-24a, Appendix 6.9.6]. For Model 4, the overall radius at 31.33582 cm is constant for several reasons. First, the 500 g of polyethylene has a fixed volume. Second, the Kaolite is a porous material and the volume does not change appreciably as the material is dried out or absorbs water.

As shown in Table 6.9.6-24a, a gradual increase in $k_{eff} + 2\sigma$ occurs from dry condition to the wet condition. The homogenization of the Kaolite shell and the fissile material core from Model 3 produces two competing effects in Model 4:

- homogenization expands the fissile material core resulting in a decrease in neutron multiplication (from $k_{eff} + 2\sigma = 0.887$ in Case **atdu3si215kr60_1** to $k_{eff} + 2\sigma = 0.708$ in Case **atdu3si215kr60_6**), and

- the increase in the free water content of the Kaolite (and CV well) increases neutron multiplication in the core (from $k_{eff} + 2\sigma = 0.487$ in Case **athu3si2p15kr60_1** to $k_{eff} + 2\sigma = 0.569$ in Case **athu3si2p15kr60_5**).

Consequently, the scenario of water penetration of fissile material core under Model 5 requires evaluation.

Cases **athu3si2pw12kr60_1_5** through **athu3si2pw12kr60_6_5** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 5 (Fig. 6.15, Sect. 6.3.1.4). Model 5 is a variation of Model 3, which represents a fissile material core blanketed with wet Kaolite and reflected by 20 cm of water. In Model 5, excess water from the wet Kaolite shell is assumed to migrate into the homogenized core. The homogenized core consists of 6.5 kg of U_3Si_2 (note this mass is less than 7 kg evaluated in Models 1 through 4), 500 g of polyethylene, and excess water from the wet Kaolite. The water content of the Kaolite shell ranges from the wet condition (7,648 g water, free and bounded) to the dry condition (2,205 g bounded water) [Table 6.9.6-24a, Appendix 6.9.6]. As excess water migrates from the wet Kaolite shell into the homogenized core, the core radius expands from 9.67497 to 13.02005 cm. However, the volume of the Kaolite shell remains constant because the Kaolite is a porous material and the volume does not change appreciably as the material loses or gains water.

As shown in Table 6.9.6-24a (Appendix 6.9.6), the $k_{eff} + 2\sigma$ values increase to maximum of 0.934 with the addition of the entire 5,445 g of water from wet Kaolite into the fissile material core. The $k_{eff} + 2\sigma$ values are below the USL of 0.93680. The homogenized core is under moderated because sufficient water is not present in the wet Kaolite and CV well to reach the point of optimum moderation. The total free water is conservatively evaluated up to 12 lb (5,443 g).

In the absence of 10 CFR 71.55(f) test data or dynamic impact simulations per Type-C test criteria, the assumption of water penetration of the fissile material core is valid under the severe air transport evaluation criteria. Model 5 is applicable to air transport of the ES-3100 package given that the geometric form of the content following the air transport accident cannot be established.

Cases **athu3si2p15kor60_1_1_1** through **athu3si2p15kor60_5_6_6** (Table 6.9.6-24b, Appendix 6.9.6) pertain to Model 6 (Fig. 6.16, Sect. 6.3.1.4), where fissile material from the homogenized core of Model 4 forms a shell external to the core. The homogenized core consists of 6.5 kg of U_3Si_2, 500 g polyethylene, and Kaolite. In a series of cases, the amount of U_3Si_2 in the shell is varied from 1,000 g to 5,500-g U_3Si_2 in various increments and the remainder of the 6.5 kg U_3Si_2 is contained in the homogenized core. For these sets of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water). All $k_{eff} + 2\sigma$ values are adequately below the USL of 0.93680.

6.7.10 Results for U_3Si Compounds at 40% Enriched

Case **atdu3sir40_1** through **atdu3sir40_7** (Table 6.9.6-24a, Appendix 6.9.6) pertains to Model 1 (Fig. 6.11, Sect. 6.3.1.4), in which varying amounts of U_3Si_2 is homogenized with 500 g polyethylene. The fissile core is configured into a spherical shape with an exterior 20 cm water reflector. The U_3Si_2 mass is evaluated up to 10.5 kg (which is less than what is allowed for ground transport), with the highest $k_{eff} + 2\sigma$ value of 0.936 (Table 6.9.6-24a, Appendix 6.9.6) is above the USL of 0.93520. A lower U_3Si mass is evaluated, 10 kg, with the $k_{eff} + 2\sigma$ value of 0.926 (Table 6.9.6-24a, Appendix 6.9.6) is below the USL of 0.93520

Cases **atdu3sisr40_1** through **atdu3sisr40_11** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 2 (Fig. 6.12, Sect. 6.3.1.4), in which 10 kg of U_3Si is homogenized with 500 g polyethylene. The fissile core of Model 1 is blanketed with a variable thickness stainless steel shell with an exterior 20 cm water reflector. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero steel thickness. The $k_{eff} + 2\sigma$ value for 10 kg of U_3Si and zero stainless steel thickness is 0.926. The $k_{eff} + 2\sigma$ value decreases to minimum value for a stainless steel thickness. Reactivity decreases, then increases as stainless steel is added to a maximum of 66,133 g, which is the highest amount of the CV and the liner and drum assembly. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520.

Cases **atdu3sidkr40_1** through **atdu3sidkr40_6** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness dry-Kaolite shell with an exterior 20 cm water reflector. Dry Kaolite consists of 51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero shell-thickness for the dry Kaolite. The $k_{eff} + 2\sigma = 0.926$ for 10 kg of U_3Si. As the amount of dry Kaolite is added to the shell surrounding the U_3Si_2, reactivity decreases. A significant drop in the neutron multiplication factor is observed for the addition of the dry-Kaolite shell to the fissile core. The $k_{eff} + 2\sigma$ values are below the USL of 0.93520.

Cases **atdu3si15kr40_1** through **atdu3si15kr40_6** (Table 6.9.6-24a, Appendix 6.9.6) also pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness wet-Kaolite shell with an exterior 20 cm water reflector. As explained in Sect. 6.3.1.4, wet Kaolite to a maximum of 60,223 g consists of the dry Kaolite [51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug] and up to 6,803.8 g free water—moisture which dampens the Kaolite and may also be present in the CV well. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero shell-thickness for the wet Kaolite. The $k_{eff} + 2\sigma = 0.926$ for 10 kg of U_3Si. As the amount of wet Kaolite is added to the shell surrounding the U_3Si, reactivity decreases. A significant drop in the neutron multiplication factor is observed for the addition of the wet-Kaolite shell to the fissile core. The $k_{eff} + 2\sigma$ values are below the USL of 0.93520.

Note that in these calculations the water comes from three sources: bound water in the Kaolite, free water in the Kaolite, and saturated water inside the compound. The amount of bounded water in the Kaolite is 2,205 g. The amount of free water is calculated at 12 and 15 pounds, which is 5,445 g of free water and 6,804 g respectively. The remaining water is the saturated water that is originally in the compound.

Cases **athu3sip15kr40_1** through **athu3sip15kr40_5** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 4 (Fig. 6.14, Sect. 6.3.1.4). The homogenized core consists of 10 kg of U_3Si, 500 g of polyethylene, and Kaolite. For this set of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water) [Table 6.9.6-24a, Appendix 6.9.6]. For Model 4, the overall radius at 31.45691 cm is constant for several reasons. First, the 500 g of

polyethylene has a fixed volume. Second, the Kaolite is a porous material and the volume does not change appreciably as the material is dried out or absorbs water.

As shown in Table 6.9.6-24a, a gradual increase in $k_{eff} + 2\sigma$ occurs from dry condition to the wet condition. The homogenization of the Kaolite shell and the fissile material core from Model 3 produces two competing effects in Model 4:

- homogenization expands the fissile material core resulting in a decrease in neutron multiplication (from $k_{eff} + 2\sigma = 0.926$ in Case **atdu3si15kr40_1** to $k_{eff} + 2\sigma = 0.764$ in Case **atdu3si15kr40_6**), and

- the increase in the free water content of the Kaolite (and CV well) increases neutron multiplication in the core (from $k_{eff} + 2\sigma = 0.500$ in Case **athu3sip15kr40_1** to $k_{eff} + 2\sigma = 0.582$ in Case **athu3sip15kr40_5**).

Consequently, the scenario of water penetration of fissile material core under Model 5 requires evaluation.

Cases **athu3sipw12kr40_1_5** through **athu3sipw12kr40_7_5** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 5 (Fig. 6.15, Sect. 6.3.1.4). Model 5 is a variation of Model 3, which represents a fissile material core blanketed with wet Kaolite and reflected by 20 cm of water. In Model 5, excess water from the wet Kaolite shell is assumed to migrate into the homogenized core. The homogenized core consists of 8.5 kg of U_3Si (note this mass is less than 10 kg evaluated in Models 1 through 4), 500 g of polyethylene, and excess water from the wet Kaolite. The water content of the Kaolite shell ranges from the wet condition (7,648 g water, free and bounded) to the dry condition (2,205 g bounded water) [Table 6.9.6-24a, Appendix 6.9.6]. As excess water migrates from the wet Kaolite shell into the homogenized core, the core radius expands from 10.45974 to 13.47350 cm. However, the volume of the Kaolite shell remains constant because the Kaolite is a porous material and the volume does not change appreciably as the material loses or gains water.

As shown in Table 6.9.6-24a (Appendix 6.9.6), the $k_{eff} + 2\sigma$ values increase to maximum of 0.931 with the addition of the entire 5,445 g of water from wet Kaolite into the fissile material core. The $k_{eff} + 2\sigma$ values are below the USL of 0.93680. The homogenized core is under moderated because sufficient water is not present in the wet Kaolite and CV well to reach the point of optimum moderation. The total free water is conservatively evaluated up to 12 lb (5,443 g).

In the absence of 10 CFR 71.55(f) test data or dynamic impact simulations per Type-C test criteria, the assumption of water penetration of the fissile material core is valid under the severe air transport evaluation criteria. Model 5 is applicable to air transport of the ES-3100 package given that the geometric form of the content following the air transport accident cannot be established.

Cases **athu3sip15kor40_1_1_1** through **athu3sip15kor40_5_6_6** (Table 6.9.6-24b, Appendix 6.9.6) pertain to Model 6 (Fig. 6.16, Sect. 6.3.1.4), where fissile material from the homogenized core of Model 4 forms a shell external to the core. The homogenized core consists of 8.5 kg of U_3Si, 500 g polyethylene, and Kaolite. In a series of cases, the amount of U_3Si in the shell is varied from 1,000 g to 7,500-g U_3Si_2 in various increments and the remainder of the 8.5 kg U_3Si is contained in the homogenized core. For these sets of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water). All $k_{eff} + 2\sigma$ values are adequately below the USL of 0.93680.

6.7.11 Results for U_3Si Compounds at 60% Enriched

Case **atdu3sir60_1** through **atdu3sir60_5** (Table 6.9.6-24a, Appendix 6.9.6) pertains to Model 1 (Fig. 6.11, Sect. 6.3.1.4), in which varying amounts of U_3Si is homogenized with 500 g polyethylene. The fissile core is configured into a spherical shape with an exterior 20 cm water reflector. The U_3Si mass is evaluated up to 8.5 kg, with the highest $k_{eff} + 2\sigma$ value of 0.924 (Table 6.9.6-24a, Appendix 6.9.6) is below the USL of 0.93520.

Cases **atdu3sisr60_1** through **atdu3sisr60_11** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 2 (Fig. 6.12, Sect. 6.3.1.4), in which 8.5 kg of U_3Si is homogenized with 500 g polyethylene. The fissile core of Model 1 is blanketed with a variable thickness stainless steel shell with an exterior 20 cm water reflector. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero steel thickness. The $k_{eff} + 2\sigma$ value for 8.5 kg of U_3Si and zero stainless steel thickness is 0.923. Reactivity decreases, then increases as stainless steel is added to a maximum of 66,133 g, which is the highest amount of the CV and the liner and drum assembly. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.93520.

Cases **atdu3sidkr60_1** through **atdu3sidkr60_6** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness dry-Kaolite shell with an exterior 20 cm water reflector. Dry Kaolite consists of 51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero shell-thickness for the dry Kaolite. The $k_{eff} + 2\sigma = 0.927$ for 8.5 kg of U_3Si. As the amount of dry Kaolite is added to the shell surrounding the U_3Si, reactivity decreases. A significant drop in the neutron multiplication factor is observed for the addition of the dry-Kaolite shell to the fissile core. The $k_{eff} + 2\sigma$ values are below the USL of 0.93520.

Cases **atdu3si15kr60_1** through **atdu3si15kr60_6** (Table 6.9.6-24a, Appendix 6.9.6) also pertain to Model 3 (Fig. 6.13, Sect. 6.3.1.4). The fissile core of Model 1 is blanketed with a variable thickness wet-Kaolite shell with an exterior 20 cm water reflector. As explained in Sect. 6.3.1.4, wet Kaolite to a maximum of 60,223 g consists of the dry Kaolite [51,214.9 g vermiculite-cement and 2,204.7 g bound water from inside the body weldment outer liner and the drum top plug] and up to 6,803.8 g free water—moisture which dampens the Kaolite and may also be present in the CV well. As shown in Table 6.9.6-24a (Appendix 6.9.6), the maximum $k_{eff} + 2\sigma$ value occurs at zero shell-thickness for the wet Kaolite. The $k_{eff} + 2\sigma = 0.927$ for 8.5 kg of U_3Si. As the amount of wet Kaolite is added to the shell surrounding the U_3Si, reactivity decreases. A significant drop in the neutron multiplication factor is observed for the addition of the wet-Kaolite shell to the fissile core. The $k_{eff} + 2\sigma$ values are below the USL of 0.93520.

Note that in these calculations the water comes from three sources: bound water in the Kaolite, free water in the Kaolite, and saturated water inside the compound. The amount of bounded water in the Kaolite is 2,205 g. The amount of free water is calculated at 12 and 15 pounds, which is 5,445 g of free water and 6,804 g respectively. The remaining water is the saturated water that is originally in the compound.

Cases **athu3sip15kr60_1** through **athu3sip15kr60_5** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 4 (Fig. 6.14, Sect. 6.3.1.4). The homogenized core consists of 8 kg of U_3Si, 500 g of polyethylene, and Kaolite. For this set of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water) [Table 6.9.6-24a, Appendix 6.9.6]. For Model 4, the overall radius at 31.39648 cm is constant for several reasons. First, the 500 g of polyethylene has a fixed volume. Second, the Kaolite is a porous material and the volume does not change appreciably as the material is dried out or absorbs water.

As shown in Table 6.9.6-24a, a gradual increase in $k_{eff} + 2\sigma$ occurs from dry condition to the wet condition. The homogenization of the Kaolite shell and the fissile material core from Model 3 produces two competing effects in Model 4:

- homogenization expands the fissile material core resulting in a decrease in neutron multiplication (from $k_{eff} + 2\sigma = 0.927$ in Case **atdu3si15kr60_1** to $k_{eff} + 2\sigma = 0.758$ in Case **atdu3si15kr60_6**), and

- the increase in the free water content of the Kaolite (and CV well) increases neutron multiplication in the core (from $k_{eff} + 2\sigma = 0.513$ in Case **athu3sip15kr60_1** to $k_{eff} + 2\sigma = 0.600$ in Case **athu3sip15kr60_5**).

Consequently, the scenario of water penetration of fissile material core under Model 5 requires evaluation.

Cases **athu3sipw12kr60_1_5** through **athu3sipw12kr60_6_5** (Table 6.9.6-24a, Appendix 6.9.6) pertain to Model 5 (Fig. 6.15, Sect. 6.3.1.4). Model 5 is a variation of Model 3, which represents a fissile material core blanketed with wet Kaolite and reflected by 20 cm of water. In Model 5, excess water from the wet Kaolite shell is assumed to migrate into the homogenized core. The homogenized core consists of 6.5 kg of U_3Si (note this mass is less than 8 kg evaluated in Models 1 through 4), 500 g of polyethylene, and excess water from the wet Kaolite. The water content of the Kaolite shell ranges from the wet condition (7,648 g water, free and bounded) to the dry condition (2,205 g bounded water) [Table 6.9.6-24a, Appendix 6.9.6]. As excess water migrates from the wet Kaolite shell into the homogenized core, the core radius expands from 9.67497 to 13.02005 cm. However, the volume of the Kaolite shell remains constant because the Kaolite is a porous material and the volume does not change appreciably as the material loses or gains water.

As shown in Table 6.9.6-24a (Appendix 6.9.6), the $k_{eff} + 2\sigma$ values increase to maximum of 0.936 with the addition of the entire 5,445 g of water from wet Kaolite into the fissile material core. The $k_{eff} + 2\sigma$ values are below the USL of 0.93680. The homogenized core is under moderated because sufficient water is not present in the wet Kaolite and CV well to reach the point of optimum moderation. The total free water is conservatively evaluated up to 12 lb (5,443 g).

In the absence of 10 CFR 71.55(f) test data or dynamic impact simulations per Type-C test criteria, the assumption of water penetration of the fissile material core is valid under the severe air transport evaluation criteria. Model 5 is applicable to air transport of the ES-3100 package given that the geometric form of the content following the air transport accident cannot be established.

Cases **athu3sip15kor60_1_1_1** through **athu3sip15kor60_5_6_6** (Table 6.9.6-24b, Appendix 6.9.6) pertain to Model 6 (Fig. 6.16, Sect. 6.3.1.4), where fissile material from the homogenized core of Model 4 forms a shell external to the core. The homogenized core consists of 6.5 kg of U_3Si, 500 g polyethylene, and Kaolite. In a series of cases, the amount of U_3Si in the shell is varied from 1,000 g to 5,500-g U_3Si_2 in various increments and the remainder of the 6.5 kg U_3Si_2 is contained in the homogenized core. For these sets of parametric cases, the Kaolite water content ranges from the wet condition (9,008.5 g water) to the dry condition (2,204.7 g water). All $k_{eff} + 2\sigma$ values are adequately below the USL of 0.93680.

6.7.12 Conclusions

Given that the results for catastrophic damage are adequately subcritical, ES-3100 packages may be shipped via air transport with:

- up to 7-kg ^{235}U HEU metal in the form of solid shapes (cylinders, bars, billets, buttons, or slugs), broken metal, metal turnings, fines, powder, or as an unspecified geometric shape (characterized as broken metal) unless a lesser amount is determined by ground transport consideration (Table 6.2a);
- up to 7-kg ^{235}U with enrichment up to 100%;
- three fuel sections ("meats") of $UZrH_x$ per loaded convenience can and up to three loaded cans per package where the ^{235}U does not exceed 921 g at 20% enrichment or 408-g ^{235}U at 70%;
- ~15-in.-long clad fuel rods, each rod derived from a single TRIGA fuel element, and where per package ^{235}U does not exceed 921 g at 20% enrichment or 408-g ^{235}U at 70%; or
- research reactor related contents of U_3O_8-Al, UO_2, and UO_2-Mg where the per package ^{235}U content does not exceed 921 g at enrichments less than or equal to 20% or 408-g ^{235}U at enrichments greater than 20%.
- up to 24 kg UF_4 (18.13-kg ^{235}U) with enrichments up to 100% unless a lesser amount is determined by ground transport consideration;
- up to 3 kg UO_2F_2 (2.067-kg ^{235}U) with enrichments up to 100%;
- up to 2 kg UC (1.815-kg ^{235}U) with enrichments up to 100%;
- up to 2 kg UN (1.888 kg ^{235}U) with enrichments up to 100%;
- up to 8.5 kg U_3Si_2 (3.150-kg ^{235}U) with enrichments up to 40%;
- up to 6.5 kg U_3Si_2 (3.613-kg ^{235}U) with enrichments up to 60%;
- up to 8.5 kg U_3Si (3.270-kg ^{235}U) with enrichments up to 40%;
- up to 6.5 kg U_3Si (3.751-kg ^{235}U) with enrichments up to 60%;

6.8 BENCHMARK EXPERIMENTS

6.8.1 Applicability of Benchmark Experiments

The criticality validation is specific to uranium, plutonium, and uranium-233 systems encompassing a substantial subset of the database used to prepare the Organization for Economic Cooperation and Development (OECD) Handbook, Volumes I–VI. The benchmark specifications are intended for use by criticality safety engineers to validate the application of criticality calculation techniques such as SCALE 4.4a. Example calculations presented in the handbook do not constitute a validation of the codes or cross-section data sets by themselves, but the Handbook information can be and has been used to validate SCALE 4.4a by competent nuclear criticality safety persons.

The data from the benchmark experiments involving uranium represent a sufficiently wide range of enrichments and physical and chemical forms to cover many existing or presently planned activities for Y-12. These include enriched uranium with ^{235}U only and natural and depleted uranium, as well as highly enriched uranium, intermediate enriched uranium, and low enriched uranium. Data analyzed from critical experiments in this validation include systems having fast, intermediate, and thermal neutron energy spectra, and they include materials in various physical and chemical forms such as uranium metals, solutions, and oxide compounds. With the benchmark experiments that are directly applicable to uranium systems, there is a high level of confidence that the calculated results presented in this evaluation are sufficiently accurate to establish the safety of the package under both NCT and HAC. This conclusion is based on the validation of the code and cross-section library described in Sect. 6.3.3.

6.8.2 Details of Benchmark Calculations

The validation of CSAS25 control module of SCALE 4.4a with the 238-group ENDF/B-V cross-section library is documented in Y/DD-896/R1 and Y/DD-972R1. Y/DD-896/R1 addresses the establishment of bias, bias trends, and uncertainty associated with the use of SCALE 4.4a for performance of criticality calculations. This evaluation is directed at uranium systems consisting of fissile and fissionable material in metallic, solution, and other physical forms, as well as plutonium and ^{233}U systems, as described in the OECD Handbook [NEA/NSC/DOC(95)03]. The focus is on comparison of k_{eff} with the associated experimental results for establishment of bias, bias trends, and uncertainty as a final step. Compiled data for 1217 critical experiments are used as the basis for the calculation models. The calculated results from SCALE 4.4a using the 238-group ENDF/B-V cross-section library have been compared with reported results for the benchmark experiments. Comparison of results demonstrates that SCALE 4.4a run on the SAE HP J-5600 unclassified workstation (CMODB) produces the same results within the statistical uncertainty of the Monte Carlo calculations as reported by the OECD for the experiments.

Y/DD-972R1 addresses determining USL and for incorporating uncertainty and margin into this USL. Y/DD-972R1 establishes subcritical limits determined through an evaluation of statistical parameters of calculation results for critical experiments. The correlating parameters (i.e., mass, enrichment, geometry, absorption, moderation, reflection) and values for applying additional margin to the subcritical limits are application dependent. The determination of correlating parameters and additional margin is an integral part of the process analysis for a particular application. For the critical experiment results, no correlation between calculation results and neutron energy causing fission was found. As such, this document does not specify "final" USL values as has been done in the past.

The criticality validation for SCALE 6.1.1 is based on benchmark experiments documented in the Organization for Economic Cooperation and Development (OECD) Handbook [NEA/NSC/DOC(95)03, *International Handbook of Evaluated Criticality Safety Benchmark Experiments*]. The upper subcritical limit (USL) without any safety margin for running SCALE 6.1.1 on this workstation is 0.985 (which covers all HEU systems with enrichments > 60%) as documented in RP YAREA-F-0455. NUREG/CR-5661 provides guidance that the USL should be established with a minimum margin of subcriticality of 0.05. Using this safety margin, the USL for the calculations performed would be 0.935.

The criticality validation for SCALE 6.1.3 is based on benchmark experiments documented in the Organization for Economic Cooperation and Development (OECD) Handbook [NEA/NSC/DOC(95)03, *International Handbook of Evaluated Criticality Safety Benchmark Experiments*]. The USL without any safety margin—derived for the validation of CSAS5 control module of SCALE 6.1.3 with the multi-group V7-238-gr cross-section library run on ENGHPC workstation—is 0.9852 for intermediate energy HEU systems as documented in RP YAREA-F-0524. NUREG/CR-5661 provides guidance that the USL should be established with a minimum margin of subcriticality of 0.05. Using this safety margin, the USL for the calculations performed in this document would be 0.9368 for thermal energy systems, 0.9352 for intermediate energy systems, and 0.9386 for fast energy systems.

6.8.3 Bias Determination

The USL is based on the non-parametric statistics-based lower tolerance limit (LTL) for greater than 0.99/99% where there is a probability of greater than 0.99 that 99% of the population is greater than a specified result, reduced by additional margin. From Table 1 of Y/DD-972R1, the LTL combining bias and bias uncertainty is 0.975 for uranium systems, including HEU metal. Tables 4.2, 4.3, and 4.4 of Y/DD-896/R1 list the maximum (positive) and minimum (negative) biases for HEU (metal, compound, solution), IEU (metal, compound) and LEU (compound, solution) systems. Since the positive bias is

conservatively treated as a “zero” bias in the validation analysis, the negative bias is applied to determine the USL for the systems. The minimum bias for the HEU, IEU, and LEU systems is given as −0.14356, −0.0055 and −0.0247, respectively.

The minimum result for the HEU systems is from one of four k-infinite models, which are somewhat different than the actual benchmark experiments. As discussed in Sect 5.3 of Y/DD-896/R1, four outlier results are for benchmark experiments that were modeled infinite in extent. The models required additional interpretation and adjustment form the actual finite experiment configuration to create an infinite benchmark model. After eliminating the outlier models from the bias determination, the minimum bias determined from data in Table 4.2 (Y/DD-896/R1) is −0.0203 for HEU systems.

The global minimum bias for these uranium systems [−0.0247 (conservatively rounded to −0.025)] is applied to all uranium enrichments. Ordinarily, the USL would be 0.955 where an additional margin of subcriticality of 0.02 is subtracted from the LTL of 0.975. However, NUREG/CR-5661 provides guidance that the USL should be established with a minimum margin of subcriticality of 0.05. Thus, the USL is equal to 0.95 plus the minimum bias (−0.025), giving a value of 0.925.

6.9 APPENDIX

Appendix 6.9.1 Fissile Content and Packaging Models 6-167
Appendix 6.9.2 HAC Package Model.....6-197
Appendix 6.9.3 Package Material Compositions.....6-209
Appendix 6.9.4 Qualification of a Neutron-absorber Material for the ES-3100.....6-245
Appendix 6.9.5 Miscellaneous Information and Data 6-257
Appendix 6.9.6 Abridged Summary Tables of Criticality Calculation Results 6-261
Appendix 6.9.7 Input Listings of ES-3100 Calculation Models for Select Cases 6-507
Appendix 6.9.8 Criticality Evaluation of Additional Content 6-795
Appendix 6.9.9 Criticality Evaluation for Increasing the Fissile Loading Limit for HEU Oxide 6-859
Appendix 6.9.10 Criticality Evaluation of HEU Oxide Product Content for Air Transportation.....6-915
Appendix 6.9.11 Criticality Evaluation of the Removal of Carbon Limits for Oxides; Removal of Cladding Limits; and Uranium Tetrafluoride at a Criticality Safety Index of 2.0 6-1019
Appendix 6.9.12 Chapter 6 References 6-1041

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Appendix 6.9.1
Fissile Content and Packaging Models

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Appendix 6.9.1
Fissile Content and Packaging Models

Calculation model for solid HEU metal, 3.24-in.-diam cylinders. Figure 6.9.1-1 depicts the wire-mesh view of the 3.24-in.-diam highly enriched uranium (HEU) cylindrical content configuration inside the containment vessel (CV). The interstitial water has been removed for illustration purposes. As can be seen from Fig. 6.9.1-1, the cylindrical content model contains one cylinder per convenience can and 1.4-in.-thick 277-4 canned spacers between the can locations. Cylinders are at the maximum diameter that will fit through the opening of a press-fit lid type convenience can. The cylindrical content shown is at the maximum mass loading; the height of the cylinders may change depending upon the mass loading. Figure 6.9.1-1b depicts a section view of the CV with 3.24-in.-diam cylinders at 4.826 and 0.254 cm separation.

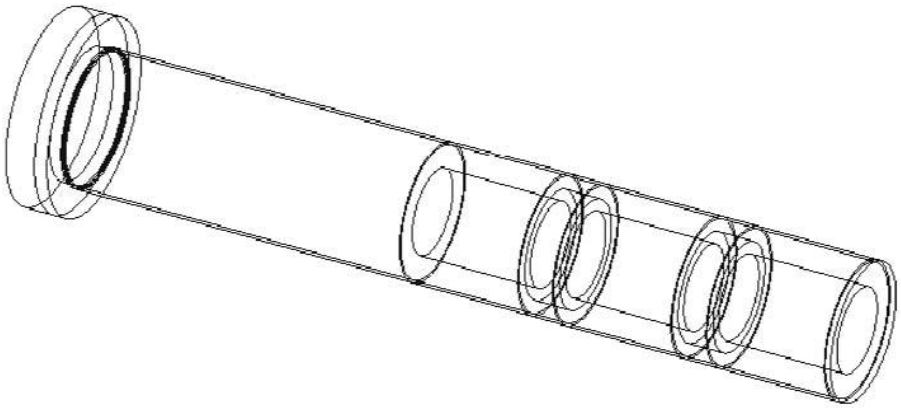


Fig. 6.9.1-1. Containment vessel containing 3.24-in.-diam cylinders and 1.4-in.-thick 277-4 canned spacers.

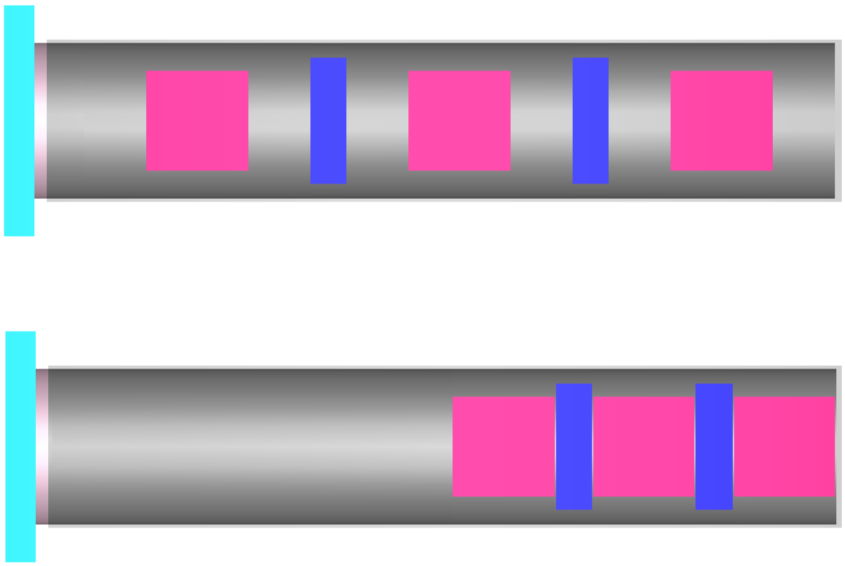


Fig. 6.9.1-1b. Section view of the containment vessel depicting 4.826 and 0.254 cm separation distances for 3.24-in.-diam cylinders (pink) with 1.4-in.-thick canned spacers (blue).

Calculation model for solid HEU metal, 4.25-in.-diam cylinders. Figure 6.9.1-2 depicts the wire-mesh view of the 4.25-in.-diam HEU cylindrical content configuration inside the CV. The interstitial water has been removed for illustration purposes. As can be seen from Fig. 6.9.1-2, the cylindrical content model contains one cylinder per convenience can and 1.4-in.-thick 277-4 canned spacers between the can locations. Cylinders are at the maximum diameter that will fit through the opening of a crimp-seal lid type convenience can. The cylindrical content shown is at the maximum mass loading; the height of the cylinders may change depending upon the mass loading.

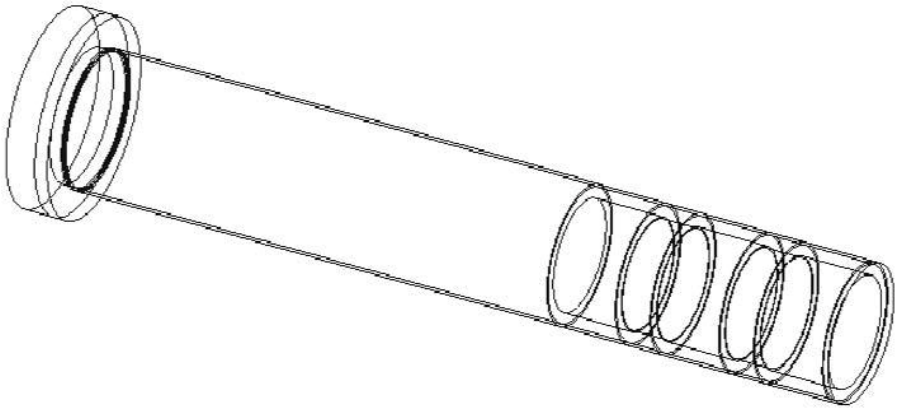


Fig. 6.9.1-2. Containment vessel containing 4.25-in.-diam cylinders and 1.4-in.-thick 277-4 canned spacers.

Calculation model for solid HEU metal, bars. Figure 6.9.1-3 depicts the wire-mesh view of the 2.29-in.-square HEU bar content configuration inside the CV. The interstitial water inside the CV has been removed for illustration purposes. The square bar content model contains one bar per convenience can and 1.4-in.-thick 277-4 canned spacers between the can locations. The 2.29-in.-square bar is the largest size that will fit through the 3.24-in.-diam opening of a press-fit lid type convenience can. Similar to the cylindrical model, the height of the square bar is dependent upon the HEU mass.

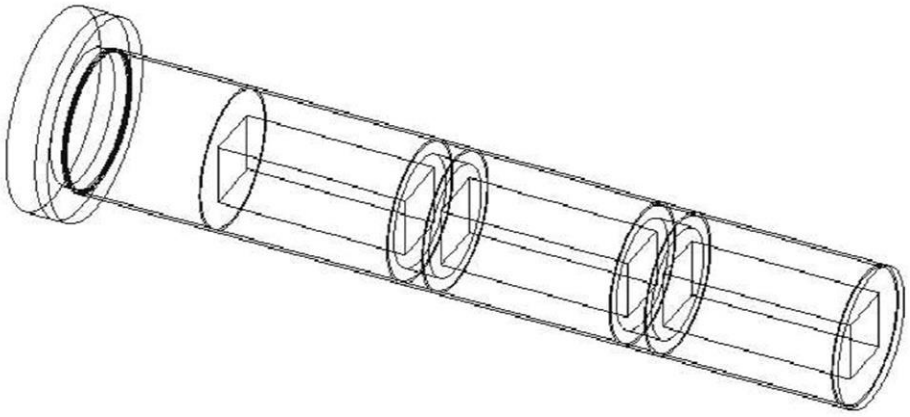


Fig. 6.9.1-3. Containment vessel containing 2.29-in.-square bars and 1.4-in.-thick 277-4 canned spacers.

Calculation model for solid HEU metal, slugs. Figure 6.9.1-4 depicts the wire-mesh view of a pentagonal ring configuration of the 1.5-in.-diam × 2.0-in.-tall slugs inside the CV. The axial centerline of each slug is located 1.27598 in. from the origin of the pentagon such that a tight fitting configuration of slugs is modeled (i.e., there are no gaps between adjacent slugs). The slug content model contains two rings of the 1.5-in.-diam × 2.0-in.-tall slugs per convenience can and the 277-4 canned spacers between the convenience cans locations. The interstitial water inside the CV has been removed for illustration purposes. Figure 6.9.1-4b depicts typical slug configurations that were evaluated.

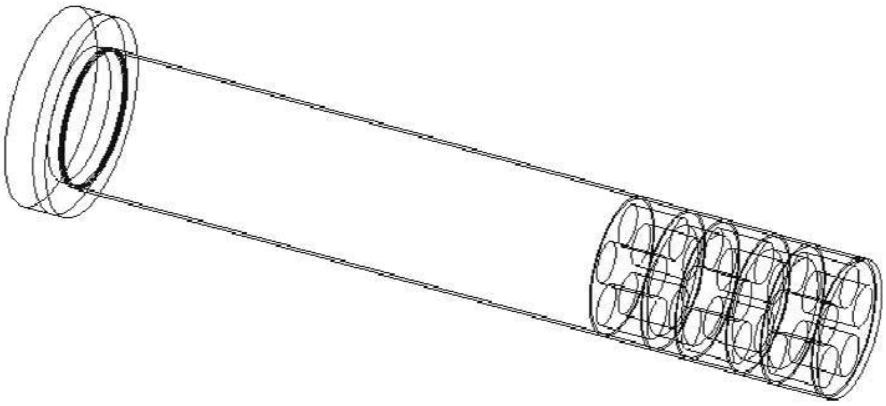
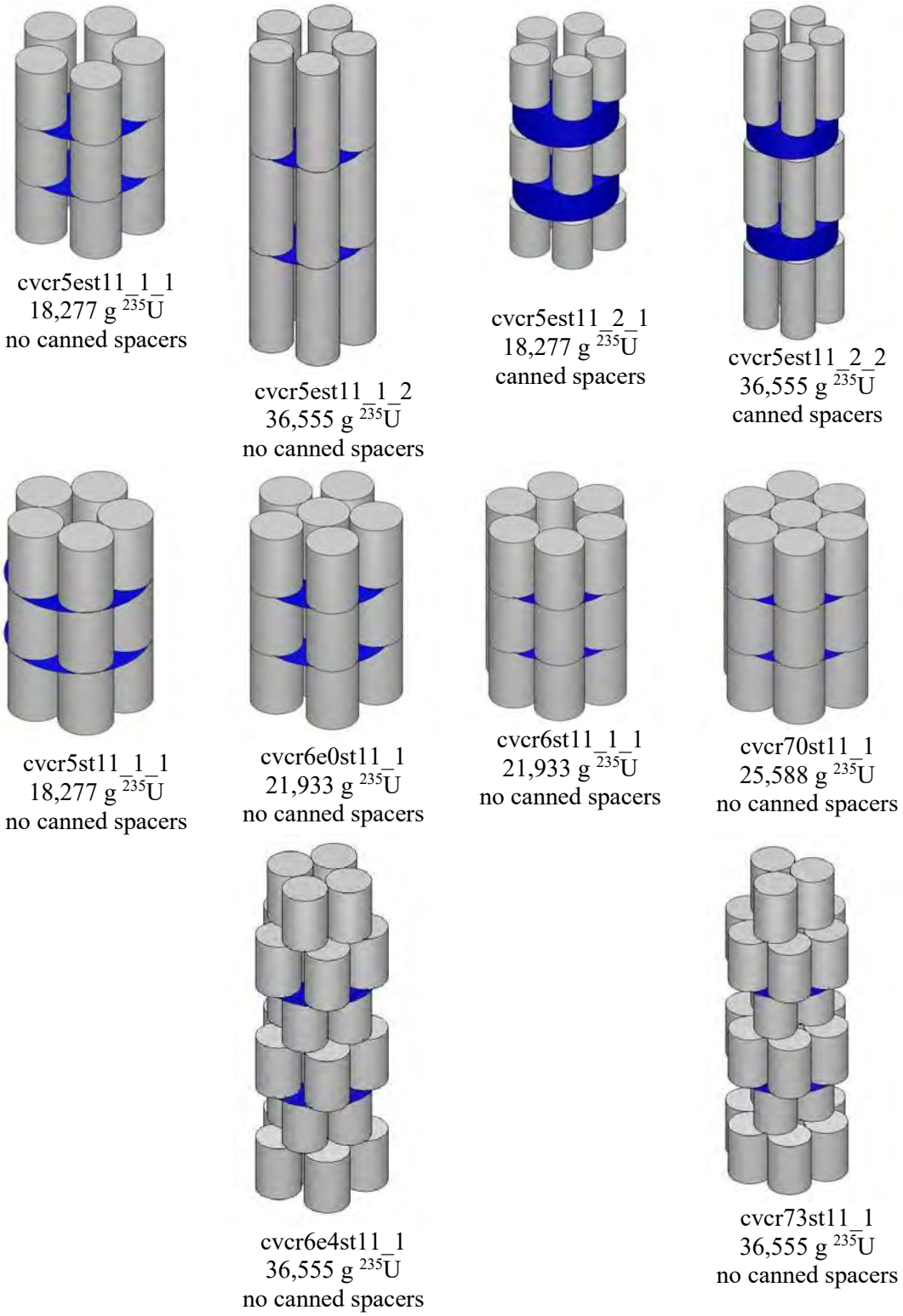


Fig. 6.9.1-4. Containment vessel containing the 1.5-in.-diam × 2.0-in.–tall slugs in a pentagonal ring configuration with 0.0-cm spacing between slugs and 1.4-in.-thick 277-4 canned spacers.

A 1.5-in.–diam × 2.0-in.–tall slug was modeled with a maximum tolerance of 1/16 in. applied to both the radius and height. The resulting dimensions are 1.984375 cm in radius and 5.23875 cm in height; the calculated volume of a single slug is 64.80746 cm^3. For 100% enriched uranium (density = 18.81109 g/cm^3), the calculated mass of 15 slugs is 18,286.5 g. Subsequently, the radius of each slug was reduced by 0.0005 cm thus eliminating a geometry intersection error in KENO V.a which occurs when the hole option is used to place slugs into an encompassing piece of the geometry unit. In the case of a pentagonal ring with spaced-apart slugs (Case **cvcr5est11_1_1**, Fig. 6.9.1-4b), the calculated volume reported for 15 slugs in KENO V.a is 971.622 cm^3 and the corresponding mass is 18277.3 g or 1,218.5 g per slug. This reduction in mass of 0.6333 g per slug is insignificant when considering the mass of a slug is nominally 1,089 g.

The maximum tolerance slug was also used in other slug geometry configurations, such as, “cvcr5s”, “cvcr6e0s”, “cvcr6s”, “cvcr70s”, “cvcr6e4s”, and “cvcr73s” orientations shown in Fig. 6.9.1-4b. For the pentagonal geometry configuration with slugs stacked two high in a ring (Case **cvcr5est11_1_2** or **cvcr5st11_1_2**), the model volume and mass of the slugs are twice the values of the single ring (Case **cvcr5est11_1_1** or **cvcr5st11_1_1**). For a pentagonal geometry configuration with a central slug (“cvcr6e0s”) and the hexagonal geometry configuration (“cvcr6"), the calculated volume reported in KENO V.a is 1,165.95 cm^3 and the corresponding mass is 21,932.7 g. For a hexagonal geometry configuration with a central slug (“cvcr70s”), the calculated volume reported in KENO V.a is 1,360.27 cm^3 and the corresponding mass is 25,588.2 g. For the compact ten-slug-per-can configurations (“cvcr5est”, “cvcr5est”, “cvcr6e4s”, and “cvcr73s”), the calculated volume reported in KENO V.a is 1,943.24 cm^3, and the corresponding mass is 36,554.6 g.



Note: Blue marker depicted for configurations without 1.4-in.-thick 277-4 canned spacers.

Fig. 6.9.1-4b. Isometric views for typical slug configurations.

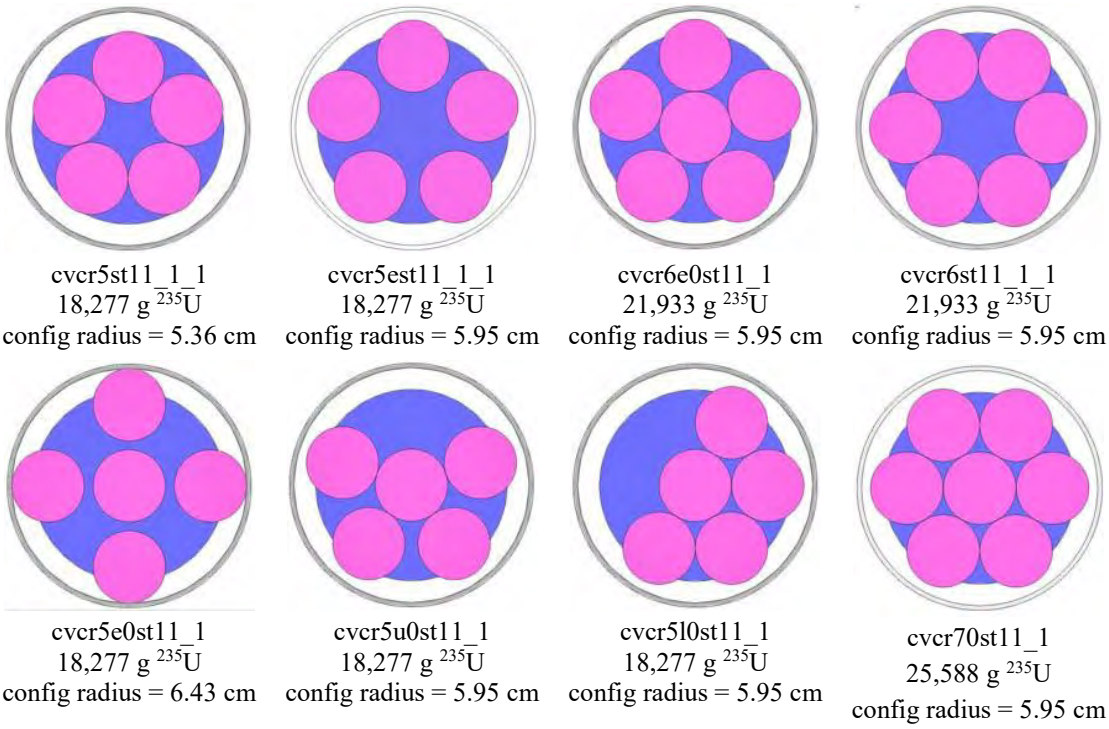
Several slug arrangements were evaluated for demonstrating that the most conservative arrangement of slugs has been analyzed. Figure 6.9.1-4c depicts radial section views of the CV showing the slugs (pink) in relation to the footprint (blue) for a 4.25-in.–diam (5.3975-cm) convenience can. Cases **cvcr5st11_1_1**, **cvcr5est11_1_1**, **cvcr5e0st11_1**, **cvcr5u0st11_1**, and **cvcr5l0st11_1** depict different arrangements with five slugs per convenience can, three cans per package. Cases **cvcr6e0st11_1_1** and **cvcr6st11_1_1** depict arrangements with six slugs per convenience can, and Case **cvcr70st11_1** depicts seven slugs per convenience can. (Considerable deformation of a 4.25-in.–diam convenience can wall is required to achieve all but the simple pentagonal-ring arrangement of slugs.) The 277-4 canned spacers are not present in these calculation models.

Calculation models for solid HEU metal of unspecified geometric shapes characterized as broken metal. The intended use of the "broken metal" category is for shipment of solid HEU metal of unspecified geometric shape characterized as broken metal, packed in 4.25-in.-diam convenience cans where the packing fraction would not exceed 0.59. The packing fraction is a parameter which characterizes the volume that broken metal occupies. A typical broken metal content is depicted in Fig. 6.9.3.1-3 where the packing fraction for content in a convenience can ranges from 0.2 to ~0.6.

In the criticality evaluation of broken metal, convenience cans are not credited for containing the content nor for maintaining spacing between the 277-4 canned spacers. Consequently, the shape and size of the broken metal pieces establishes the separation between canned spacers which in turn determines the size of the HEU content locations inside the CV. Given the irregular shape of broken metal, the packing fraction is the parameter which quantifies the volume of space that the broken metal occupies. The use of a large packing fraction (~0.6) results in minimum separation between canned spacers which minimizes the size of the lower and middle content locations and maximizes the size of the upper content location. Reactivity of the CV is driven by the oversized upper content location. Conversely, the use of a small packing fraction (~0.2) results in greater separation between the canned spacers which increases the size of the lower and middle content locations, while reducing the size of the upper content location. Reactivity of the CV decreases accordingly.

The "**sqa**", "**lha**", and "**cha**" calculation models are devised for evaluating broken metal in the idealized forms described in the following paragraphs. The heights of the lower can locations and separation between the first and second 277-4 canned spacers inside the CV are conservatively established on the basis that broken metal is confined within a rectangular lattice formed by the unit cells of fissile material having a packing fraction of ~0.59.

In the "sqa" model for HEU broken metal, a uniform-size metal cube is contained inside a unit cell of content. The unit cells are configured into arrays with one array for each can location inside the CV. HEU metal cubes ranging in size from 1.0 to 0.25 in. are correspondingly arranged into 3 × 3, 6 × 6, or 12 × 12 configurations with ***N*** layers stacked vertically. A rectangular lattice of unit cells is defined by a square prism circumscribed by the wall of the CV with an inner diameter of 5.06 in. (12.8524 cm). The width and depth of the square base is 3.57796 in. (9.08802 cm). The height of the lattice is determined by both the size of a cube and the number of layers of cubes required for a given HEU mass loading.



Note: Blue marker depicts 4.25-in.–diam wall of the convenience can.

Fig. 6.9.1-4c. Plan view of slug configurations in the confines of the containment vessel.

Figure 6.9.1-5 depicts a wire mesh view of the CV and lid with three 12 × 12 × 18 arrays of HEU content separated by 277-4 canned spacers. Figure 6.9.1-5b depicts an isometric view of this same content with the **evaluation** water surrounding the HEU removed for illustration. The corner unit cells touch the inside wall of the CV. The HEU cubes are centered within the individual unit cells and uniform spacing between cubes is modeled. The 277-4 canned spacers are modeled as cylindrical disks with dimensions of 4.13-in. diam × 1.37-in. height.

Uranium mass is reduced in the calculation model by removing one or more cubes from the array and filling these vacancies with water. The location of the 277-4 canned spacers between the arrays of cubes decreases as complete layers of cubes are removed from each array. The volume of the CV above the top layer of the top array of cubes is filled with full-density water.

In the "lha" model of HEU broken metal, the metal cubes of the "sqa" model are homogeneously mixed with **evaluation** water within the square prism of the "sqa" model. Figure 6.9.1-5c depicts an isometric view of the "lha" model. The boundaries of each square prism shown in the figure are defined by the 12 × 12 × 18 array of unit cells of the explicit "sqa" model. Each prism contains the same mass of HEU and **evaluation** water that the respective explicit cube model contains. The volume outside the prisms and the canned spacers is filled with full density water.

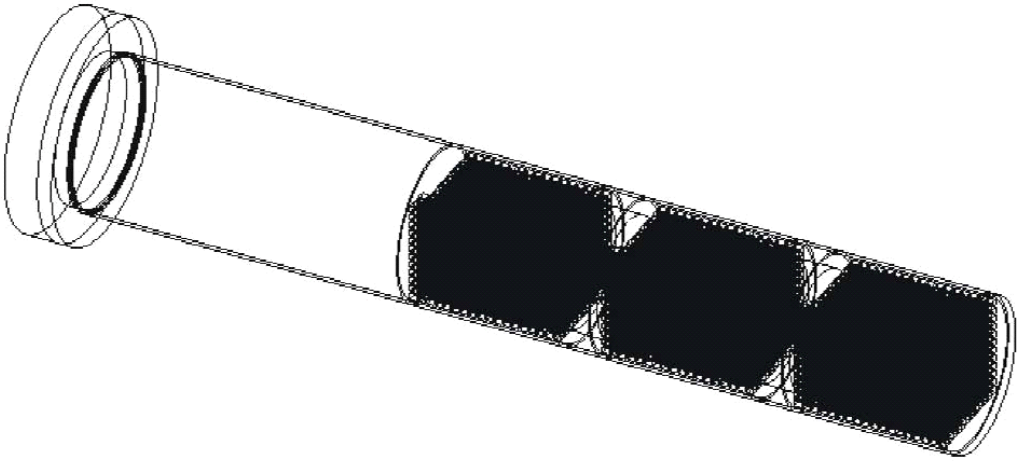


Fig. 6.9.1-5. Wire mesh view of the "sqa" model with three 12 × 12 × 18 lattices of HEU broken metal as 1-in. cubes separated by 1.4-in. 277-4 canned spacers.

In the "cha" model of HEU broken metal, the metal cubes of the "sqa" model are homogeneously mixed with the **evaluation** water within the free volume of the CV. Figure 6.9.1-5d depicts an isometric view of the "cha" model. The 277-4 canned spacers are positioned for similarity with the "sqa" and "lha" models using the height of the prism, defined in this case by the 12 × 12 × 18 array of unit cells of the explicit "sqa" model. The mass of HEU and **evaluation** water of the explicit "sqa" model is preserved.

Once the locations of the canned spacers in the CV are established based on the height of the square prism, the HEU broken metal and evaluation water inside the CV are homogenized over the internal volume of the 12.8524-cm-diam CV not being occupied by the canned spacers. The homogenization of fissile material with moderator to represent discrete solid HEU metal of unspecified geometric shape characterized as broken metal is unquestionably bounding only when the overall volume (and shape) containing HEU and interstitial moderator between the pieces of HEU is preserved in the approximation model.

In the "cha" model, the uniform dispersal of the homogenized HEU and evaluation water over the residual internal volume of the CV has the effect of relocating ^{235}U from the two lower can locations into the upper can location. When the 277-4 canned spacers are present, the neutronic coupling of can locations is weak and the reactivity of the packaged content is determined by the reactivity of the largest can location. This model may not be conservative when canned spacers are absent because nothing would prevent settling of content inside the CV into a single mass given that the convenience cans are not credited for containing the content nor for maintaining spacing between the contents of each can.

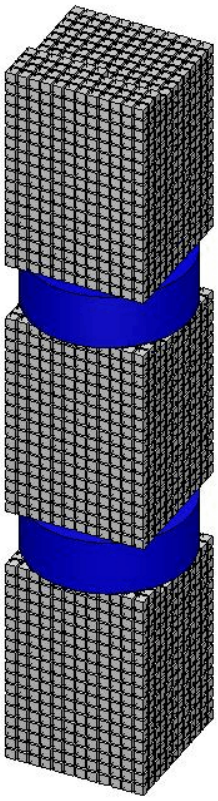


Fig. 6.9.1-5b. Detailed isometric view of the explicit "sqa" model for HEU broken metal. Three 12 × 12 × 18 lattices of 1-in. cubes separated by 1.4-in. 277-4 spacers are shown.

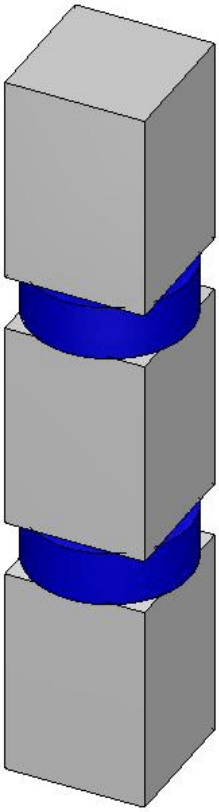


Fig. 6.9.1-5c. Isometric view of the homogeneous "lha" model with HEU homogeneously mixed with evaluation water within the rectangular lattices formed by the units cells.

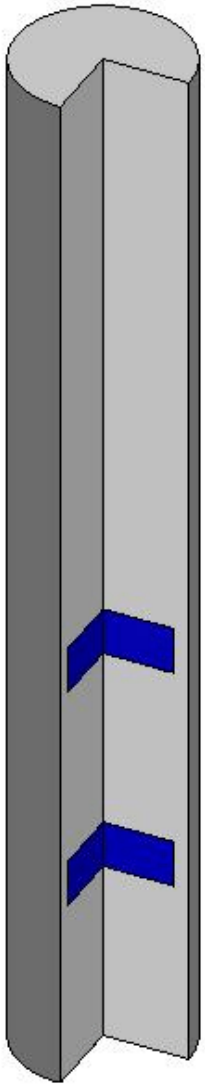


Fig. 6.9.1-5d. Isometric view of the homogeneous "cha" model with HEU homogeneously mixed with evaluation water within the interior of the containment vessel.

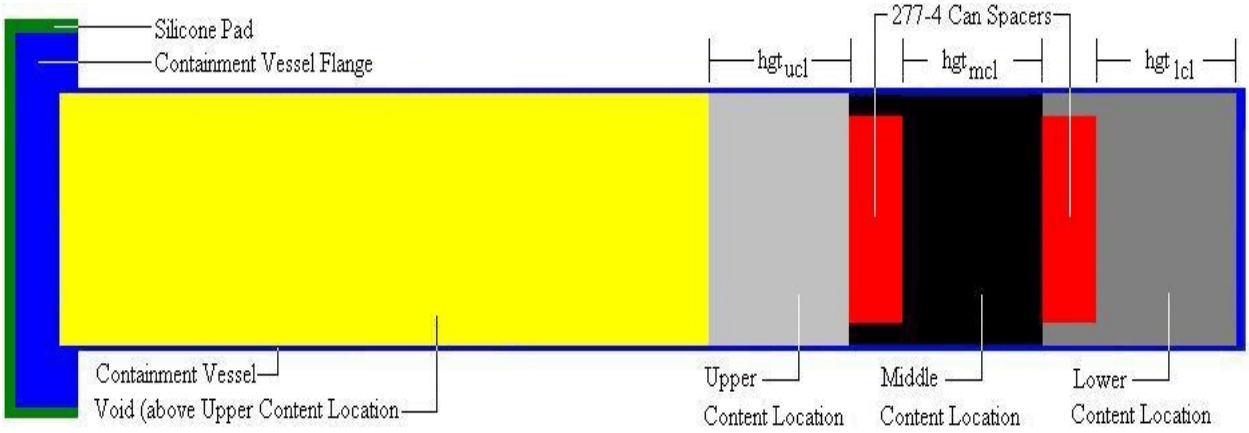
As stated in Sect. 6.9.3.1, the "cha" model is used to represent broken metal in single packages and the array of packages under NCT and HAC. For addressing the issue that the uniform dispersal approximation model ("cha") may not be conservative, especially when the 277-4 canned spacers are absent, the settling of content may be evaluated by establishing the material geometry and composition based on a maximum packing fraction. The packing fraction calculation model is described for this purpose.

In the packing fraction model, the material within a variable height can location is evaluated over the range of packing fractions from loosely packed material (PF ~0.2) to densely packed material (PF ~0.6). The height of can locations is determined based on the packing fraction instead of the fictitious cube stacking algorithm which was used in the "cha" uniform dispersal approximation model. The height of can locations used in the packing fraction calculation model is given by the following formula:

$$hgt = [(HEU_{vol} / PF) + Poly_{vol}] / CV_{area}$$

(500 g of polyethylene is included in the calculation model to represent the potential use of packing material.)

Fig. 6.9.1-5e depicts a section view of the CV for the packing fraction calculation model. The height of the lower, middle, and upper can locations are equal. Only in the upper location does the can location coincide with the content location. The "**fl**" is used in the case name to designate calculations are based on the packing fraction model.



Note: The height (hgt) of the upper, middle, and lower can locations are determined by the HEU packing fraction.

Fig. 6.9.1-5e. Section view of the containment vessel for the packaging fraction calculation model depicting the content locations for broken metal.

The volume fractions for material constituents in the middle and lower content locations are calculated as follows:

$$VF_{HEU} = HEU_{vol} / (hgt \times CV_{area} + Spacer_{void})$$

where HEU_{vol} is the volume of HEU at theoretical density and $Spacer_{void}$ is the volume of the void region between the CV wall an the can spacer assumed filled with evaluation water.

$$VF_{H2O} = [(HEU_{vol} / PF) - HEU_{vol} + Spacer_{void}] / (hgt \times CV_{area} + Spacer_{void})$$
$$VF_{Poly} = Poly_{vol} / (hgt \times CV_{area} + Spacer_{void})$$

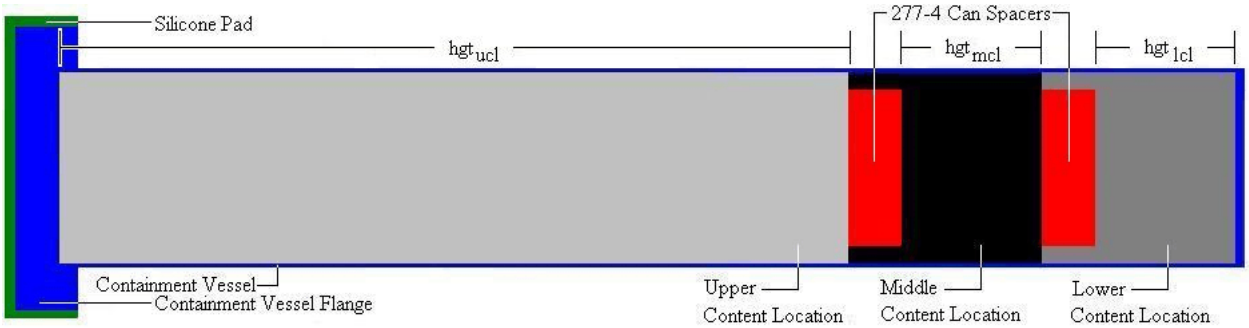
The volume fractions for material constituents in the upper content location are calculated as follows:

$$VF_{HEU} = HEU_{vol} / (hgt \times CV_{area})$$
$$VF_{H2O} = [(HEU_{vol} / PF) - HEU_{vol}] / (hgt \times CV_{area})$$
$$VF_{Poly} = Poly_{vol} / (hgt \times CV_{area})$$

The void region above the upper content location (Vol_{above}) is filled with full density water.

In addressing the issue that the uniform dispersal approximation "cha" model may not be conservative because homogenization of HEU is performed over a much larger volume and shape than the HEU content conceivably occupies, the effect of dispersing content within a can location may be evaluated using a variation of the packing fraction calculation model. The dispersed content calculation model is described for this purpose.

In the dispersed content calculation model, the HEU, the polyethylene, and the evaluation water of the upper content location is homogenized over the entire volume of this location. Figure 6.9.1-5f depicts a section view of the CV for the dispersed content calculation model. The height of the lower and middle content locations are equal, while the height of the upper content location extends to the top of the CV cavity. The "**fd**" designation in the case name is used to identify the dispersed content calculation model.



Note: The height (hgt) of the middle and lower content locations are determined by the HEU packing fraction. The height of the upper content location extends to the top of the containment vessel cavity.

Fig. 6.9.1-5f. Section view of the containment vessel in the dispersed content calculation model depicting the content locations for broken metal.

The volume fractions for material constituents in the middle and lower content locations are specified the same as in the "**fl**" model. However, the volume fractions for material constituents dispersed into the upper content location are calculated as follows:

$$VF_{HEU} = HEU_{vol} / (hgt \times CV_{area} + Vol_{above})$$

where Vol_{above} is the void region above the upper can location into which the content is dispersed.

$$VF_{H2O} = [(HEU_{vol} / PF) - HEU_{vol} + Vol_{above}] / (hgt \times CV_{area} + Vol_{above})$$
$$VF_{H2O} = Poly_{vol} / (hgt \times CV_{area} + Vol_{above})$$

For example, consider reference Case **hciabmt12_4_1_5_3** (Table 6.9.6-11) which defines the loading limit for broken metal in the 70% < enr. ≤ 80% range where canned spacers are not used in the CV. In revised Case **hciapbmflt12_1_6_4_5**, HEU broken metal with a packing fraction of 0.6, the 500 g of polyethylene and evaluation water in each can location is homogenized over the content location. Case **hciapbmflt12_1_2_4_5** is the same as Case **hciapbmflt12_1_6_4_5**, except the packing fraction is 0.2. In Case **hciapbmfdt12_1_6_4_5**, HEU broken metal with a packing fraction of 0.6, the 500 g of polyethylene and evaluation water in each content location is homogenized over the content location. Case **hciapbmfdt12_1_2_4_5** is the same as Case **hciapbmfdt12_1_6_4_5,** except the packing fraction is 0.2. Table 6.9.1.0 provides details for the packing fraction and dispersed content calculation models.

Table 6.9.1.0. Details for the packing fraction "fl" and dispersed content "fd" calculation models

Location	Height (cm)	Material	Density × VF × region volume	HEU (g)	Water (g)	Polyethylene (g)
Case hciapbmflt12_1_6_4_5, packing fraction = 0.6						
Lower	2.30470	HEU	(18.85873)(0.23645)(299.031)	1333.4		
		Water	(0.9982)(1.5773E-01)(299.031)		47.1	
		Poly	(0.9200)(6.0582E-01)(299.031)			166.7
Spacer	0.00030	Water	(0.9982)(8.64286E-03)		0.0	
Middle	2.30470	HEU	(18.85873)(0.23645)(299.031)	1333.4		
		Water	(0.9982)(1.5773E-01)(299.031)		47.1	
		Poly	(0.9200)(6.0582E-01)(299.031)			166.7
Spacer	0.00030	Water	(0.9982)(8.64286E-03)		0.0	
Top	2.30470	HEU	(18.85873)(0.23647)(299.001)	1333.4		
		Water	(0.9982)(1.5765E-01)(299.001)		47.1	
		Poly	(0.9200)(6.0588E-01)(299.001)			166.7
Above	71.82530	Water	(0.9982)(1.0)(9318.28)		9301.5	
Total	**78.74000**			**4000.2**	**9442.8**	**500.0**
Case hciapbmflt12_1_2_4_5, packing fraction = 0.2						
Lower	4.12133	HEU	(18.85873)(0.13223)(534.713)	1333.4		
		Water	(0.9982)(5.2897E-01)(534.713)		282.3	
		Poly	(0.9200)(3.3880E-01)(534.713)			166.7
Spacer	0.00030	Water	(0.9982)(8.64286E-03)		0.0	
Middle	4.12133	HEU	(18.85873)(0.13223)(534.713)	1333.4		
		Water	(0.9982)(5.2897E-01)(534.713)		282.3	
		Poly	(0.9200)(3.3880E-01)(534.713)			166.7
Spacer	0.00030	Water	(0.9982)(8.64286E-03)		0.0	
Top	4.12133	HEU	(18.85873)(0.13224)(534.682)	1333.4		
		Water	(0.9982)(5.2895E-01)(534.682)		282.3	
		Poly	(0.9200)(3.3882E-01)(534.682)			166.7

Table 6.9.1.0. Details for the packing fraction "fl" and dispersed content "fd" calculation models

Location	Height (cm)	Material	Density × VF × region volume	HEU (g)	Water (g)	Polyethylene (g)
Above	66.37541	Water	(0.9982)(1.0)(8.61124E+03)		8595.7	
Total	**78.74000**			**4000.2**	**9442.7**	**500.0**
Case hciapbmfdt12_1_6_4_5, packing fraction = 0.6						
Lower	2.30470	HEU	(18.85873)(0.23645)(299.031)	1333.4		
		Water	(0.9982)(1.5773E-01)(299.031)		47.1	
		Poly	(0.9200)(6.0582E-01)(299.031)			166.7
Spacer	0.00030	Water	(0.9982)(8.64286E-03)		0.0	
Middle	2.30470	HEU	(18.85873)(0.23645)(299.031)	1333.4		
		Water	(0.9982)(1.5773E-01)(299.031)		47.1	
		Poly	(0.9200)(6.0582E-01)(299.031)			166.7
Spacer	0.00030	Water	(0.9982)(8.64286E-03)		0.0	
Top	74.13000	HEU	(18.85873)(0.00735)(9617.28)	1333.4		
		Water	(0.9982)(9.7381E-01)(9617.28)		9348.5	
		Poly	(0.9200)(1.8837E-02)(9617.28)			166.7
Total	**78.74000**			**4000.2**	**9442.7**	**500.0**
Case hciapbmfdt12_1_2_4_5, packing fraction = 0.2						
Lower	4.12133	HEU	(18.85873)(0.13223)(534.713)	1333.4		
		Water	(0.9982)(5.2897E-01)(534.713)		282.3	
		Poly	(0.9200)(3.3880E-01)(534.713)			166.7
Spacer	0.00030	Water	(0.9982)(8.64286E-03)		0.0	
Middle	4.12133	HEU	(18.85873)(0.13223)(534.713)	1333.4		
		Water	(0.9982)(5.2897E-01)(534.713)		282.3	
		Poly	(0.9200)(3.3880E-01)(534.713)			166.7
Spacer	0.00030	Water	(0.9982)(8.64286E-03)		0.0	
Top	4.12133	HEU	(18.8587)(0.00773)(9145.92)	1333.3		
		Water	(0.9982)(9.7246E-01)(9145.92)		8878.0	
		Poly	(0.9200)(1.9808E-02)(9145.92)			166.7
Total	**12.36459**			**4000.1**	**9442.7**	**500.0**

Powder, particulate, or small pieces of HEU potentially present in broken metal are capable of passing between content locations. The quantity of this material represents a small fraction of the total broken metal content. The placement of a limit on content size for criticality control is adopted as a package content loading restriction (Sect. 6.2.4, Item 6).

Calculation model for solid HEU of unspecified geometric shape, HEU oxides. Figure 6.9.1-6 depicts the wire-mesh view of the HEU oxide content inside the CV. The interstitial water inside the CV has been removed for illustration purposes. The HEU oxide mixture at bulk density is located at the bottom of the CV and fills the space to the wall of the CV. The height of the HEU oxide mixture is dependant upon the mass loading.

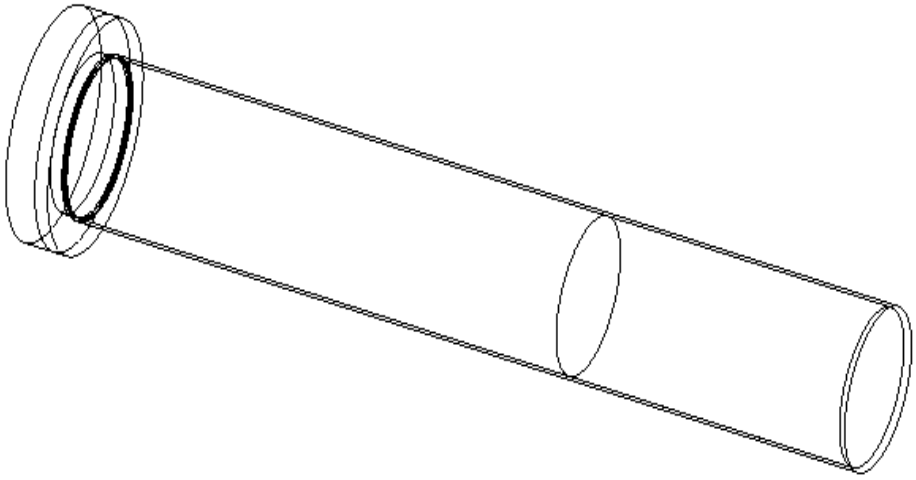


Fig. 6.9.1-6. Wire-mesh view of the containment vessel containing the HEU oxide mixture.

HEU product oxide is assumed to be saturated with water in the criticality calculation models. Maximum saturation in the oxide material occurs in a volume defined as the difference between the specific volume of bulk oxide and the minimum specific volume of the product oxide. Product oxide has a bulk density of 6.54 g/cm^3 or a specific volume of 0.152905 cm^3/g (Sect. 6.9.3.1). UO_2 has a theoretical density of 10.96 g/cm^3 or a minimum specific volume of 0.091241 cm^3/g. Therefore, the maximum volume per gram of UO_2 available for saturation by water is 0.061664 cm^3/g. Additionally, an assumed maximum of 500 g of polyethylene is homogenized with the water-saturated product oxide. The homogenized oxide containing polyethylene (density = 0.92 g/cm^3) occupies an additional 543.47826 cm^3.

The height of polyethylene homogenized with water-saturated product oxide inside the CV is calculated by dividing the volume of the homogenized oxide by the internal area of the base of the CV. The area of the base is 129.73536 cm^2 for the CV with an inner diameter of 5.06 in. (12.8524 cm). The height of the void space above the homogenized oxide is calculated by subtracting the homogenized oxide height from the 78.84-cm (31.0-in.) inside height of the CV.

As an example, consider Case **cvcrpoxt11_1_21_15** where 21,000 g of UO_2 (18,484.3 g ^{235}U) is saturated with 1,292.62 g water (Table 6.9.6-12). The calculated H/X ratio for the water saturated product oxide is 1.83. The water-saturated product oxide homogenized with 500 g of polyethylene rises to a height of ~28.93955 cm inside the CV. The 6,460.87 cm^3 of void space is flooded with 6449.2 g of evaluation water, such that the calculated H/X ratio inside the CV is 11.84. The 500 g of polyethylene adds 0.90 to the calculated H/X ratio of water-saturated product oxide. The calculated H/X ratio for the water-saturated product oxide homogenized with 500 g of polyethylene in a dry CV is 1.83 + 0.90 = 2.73 (Case **cvcrpoxt11_1_21_1**). In all cases, the H/X ratio is a computed value rather than an evaluation parameter.

The same modeling technique is applied to product oxides of U_3O_8 and UO_3. U_3O_8 has a theoretical density of 8.30 g/cm^3 or a minimum specific volume of 0.120482 cm^3/g. UO_3 has a theoretical

density of 7.29 g/cm^3 or a minimum specific volume of 0.137174 cm^3/g. The maximum volumes per gram of U_3O_8 and UO_3 available for saturation by water are 0.032423 cm^3/g and 0.015731 cm^3/g, respectively.

The eight skull oxide content compositions described in Table 6.9.3.1-3b for evaluating skull oxide are derived from 292 samples of canned skull oxide. Two additional compositions are listed in the table for addressing skull oxides with an enrichment of 93.2 wt %. The skull oxide content is assumed to be U_3O_8 plus polyethylene, graphite, and unidentified material. A maximum of 513 g of polyethylene is assumed to be present in the skull oxide content. The volume of skull oxide content in the CV (**vsoc**) is calculated as the grams of skull oxide content (**gsoc**) divided by the bulk density of the skull oxide content (**densoc**). The height of skull oxide content inside the CV is calculated by dividing the volume of skull oxide content (**vsoc**) by the internal area of the base of the CV (129.73536 cm^3).

Calculation model for solid HEU of unspecified geometric shape, UNH crystals. Figure 6.9.1-7 depicts the wire-mesh view of the UNH crystal content inside the CV. A solution of UNH crystals dissolved in water fills the entire volume of the CV.

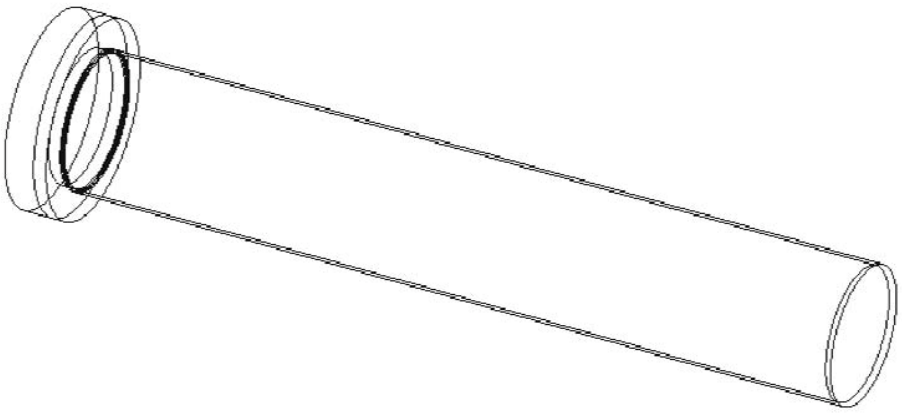


Fig. 6.9.1-7. Wire mesh view of the containment vessel containing the UNH crystal mixture.

Table 6.9.1.1 provides details of the calculation models used to establish the mass loading limits identified in Table 6.2a for surface-only modes of transportation. The table provides exact dimensions of the fissile material used in the analyses; the mass of fissile material, enrichment, and density of the fissile material used in the analysis; moderating properties of materials inside the CV (water, hydrogenous packing material, represented by polyethylene, etc.), moderator density and h/x ratios; and arrangement of the fissile material including amount of spacing (if any) between the fissile material and/or 277-4 canned spacers. In the creation of a generalized geometry model for treatment of 277-4 canned spacers, the use of a non-zero thickness spacer was required by KENO V.a. An insignificant thickness of 0.0001 cm was used for representing this imaginary region.

Table 6.9.1.1. Details of calculation models used to establish mass loading limits for surface-only modes of transportation identified in Table 6.2a

Case	Dimensions (cm)	Enrichment (wt % ^{235}U)	Density (g/cm^3)
Cylinders (d ≤ 3.24 in.)			
nciacyt11_18_1_3	r = 4.1148 cm h = 5.99639 cm	100	18.81109
The moderator is full density water (0.9982 g/cm^3) surrounding three stacked cylindrical contents. The contents have an overall stack height of 17.99171 cm (7.08335 in.). No polyethylene was used in this model. Each cylindrical content is separated by a 0.0001 cm 277-4 canned spacer and 0.0012 cm of moderating material. The bottom cylinder has a 0.0005 cm gap between it and the bottom of the CV. The contents sit in the exact center on the bottom of the CV. Therefore, the cylinder content has 2.3114 cm of moderating material around each side and 60.74779 cm of moderating material above. The modeled material masses are: 18 kg ^{235}U, 9.2418 kg H_2O, resulting in an h/x ratio of ~13.40.			
nciacyt11_30_2_3	r = 4.11480 cm h = 9.99399 cm	100	18.81109
The moderator is full density water (0.9982 g/cm^3) surrounding three stacked cylindrical contents separated by 277-4 canned spacers between each cylindrical content. The contents (uranium and spacers) have an overall stack height of 37.09657 cm (14.60495 in.). No polyethylene was used in this model. Each cylindrical content is separated by a 3.5561 cm spacer and 0.0012 cm of moderating material. The bottom cylinder has a 0.0005 cm gap between it and the bottom of the CV. The contents sit in the exact center on the bottom of the CV. Therefore, the cylinder content has 2.3114 cm of moderating material around each side and 41.64293 cm of moderating material above. The modeled material masses are: 30 kg ^{235}U, 7.9915 kg H_2O, resulting in an h/x ratio of ~6.95.			
Cylinders (3.24 in. < d ≤ 4.25 in.)			
nciacyct11_15_1_3	r = 5.39750 cm h = 2.90416 cm	100	18.81109
The moderator is full density water (0.9982 g/cm^3) surrounding three stacked cylindrical contents separated by 277-4 canned spacers. The contents have an overall stack height of 8.71508 cm (3.43133 in.). No polyethylene was used in this model. Each cylindrical content is separated by a 0.0001 cm spacer and 0.0012 cm of moderating material. The bottom cylinder has a 0.0005 cm gap between it and the bottom of the CV. The contents sit in the exact center on the bottom of the CV. Therefore, the cylinder content has 1.0287 cm of moderating material around each side and 70.02442 cm of moderating material above. The modeled material masses are: 15 kg ^{235}U, 9.4010 kg H_2O, resulting in an h/x ratio of ~16.36.			
nciacyct11_25_2_3	r = 5.39750 cm h = 4.84031 cm	100	18.81109
The moderator is full density water (0.9982 g/cm^3) surrounding three stacked cylindrical contents separated by 277-4 canned spacers. The contents have an overall stack height of 21.63433 cm (8.517453 in.). No polyethylene was used in this model. Each cylindrical content is separated by a 3.5561 cm spacer and 0.0012 cm of moderating material. The bottom cylinder has a 0.0005 cm gap between it and the bottom of the CV. The contents sit in the exact center on the bottom of the CV. Therefore, the cylinder content has 1.0287 cm of moderating material around each side and 57.10417 cm of moderating material above. The modeled material masses are: 25 kg ^{235}U, 8.2568 kg H_2O, resulting in an h/x ratio of ~8.62.			

Table 6.9.1.1. Details of calculation models used to establish mass loading limits for surface-only modes of transportation identified in Table 6.2a

Case	Dimensions (cm)	Enrichment (wt % ^{235}U)	Density (g/cm^3)
Bars			
hciasqt12_30_1_3	x = 5.81920 cm y = 5.81920 cm z = 15.69855 cm	100	18.81109
The moderator is full density water (0.9982 g/cm^3) surrounding three stacked square or cuboid contents separated by 277-4 canned spacers. The contents have an overall stack height of 47.09825 cm (18.54262 in.). No polyethylene was used in this model. Each cuboid content is separated by a 0.0001 cm spacer and 0.0012 cm of moderating material. The bottom cuboid has a 0.0005 cm gap between it and the bottom of the CV. The contents sit in the exact center on the bottom of the CV. Therefore, the cuboid content is surrounded by moderating material ranging from 3.6166 to 2.4144 cm (center to outer edge) and 31.64125 cm of moderating material above. The modeled material masses are: 30 kg ^{235}U, 8.6050 kg H_2O, resulting in an h/x ratio of ~7.49.			
nciasqt11_36_2_3	x = 5.81920 cm y = 5.81920 cm z = 18.83826 cm	100	18.81109
The moderator is full density water (0.9982 g/cm^3) surrounding three stacked square or cuboid contents separated by 277-4 canned spacers. The contents have an overall stack height of 63.62938 cm (25.05094 in.). No polyethylene was used in this model. Each cuboid content is separated by a 3.5561 cm spacer and 0.0012 cm of moderating material. The bottom cuboid has a 0.0005 cm gap between it and the bottom of the CV. Therefore, the cuboid content is surrounded by moderating material ranging from 3.6166 to 2.4144 cm (center to outer edge) and 15.11012 cm of moderating material above. The modeled material masses are: 36 kg ^{235}U, 7.6731 kg H_2O, resulting in an h/x ratio of ~5.56.			
Slugs (enr. ≤ 95%–no can spacers)			
ncia5st11_1_1_7_3	r = 1.983875 cm h = 5.23875 cm	95	18.82298
The moderator is full density water (0.9982 g/cm^3) surrounding three stacked pentagonal rings of slug content separated by 277-4 canned spacers. (Slugs are inserted into the cylindrical geometry segment of the CV using the hole option.) The contents have an overall stack height of 15.71885 cm (6.18852 in.). No polyethylene is used in this model. Each ring is separated by a 0.0001 cm spacer and 0.0012 cm of moderating material. The bottom ring of slugs has a 0.0005 cm gap between it and the bottom of the CV. Above the stack of slugs is 63.02065 cm of moderating material. The modeled material masses are: 18.288 kg U (17.374 kg ^{235}U), 9.2269 kg H_2O, resulting in an h/x ratio of ~13.86. The loading arrangement of slugs is depicted in Fig. 6.9.1-4b for the Case **cvcr5st11_1_1**.			
Slugs (80% < enr. ≤ 95%–with can spacers)			
hcia70st12_2_7_3	r = 1.983875 cm h = 5.23875 cm	95	18.82298
The moderator is full density water (0.9982 g/cm^3) surrounding three stacked rings of slugs, each ring with a central slug surrounded by slugs in a hexagonal pattern. (Slugs are inserted into the cylindrical geometry segment of the CV using the hole option.) Each ring is separated by a 277-4 canned spacer. The contents (uranium and spacers) have an overall stack height of 22.83085 cm (8.98852 in.). No polyethylene was used in this model. Each ring is separated by a 3.5561 cm spacer and 0.0012 cm of moderating material. The bottom ring has a 0.0005 cm gap between it and the bottom of the CV. The stack of slugs has 55.90865 cm of moderating material above. The modeled material masses are: 25.604 kg U (24.324 kg ^{235}U), 8.2253 kg H_2O, resulting in an h/x ratio of ~8.83. The loading arrangement of slugs is similar to that depicted in Fig. 6.9.1-4b for the Case **cvcr70st11_1** except that the canned spacers are present.			

Table 6.9.1.1. Details of calculation models used to establish mass loading limits for surface-only modes of transportation identified in Table 6.2a

Case	Dimensions (cm)	Enrichment (wt % ^{235}U)	Density (g/cm^3)
ncf15est11_2_2_7_3	r = 1.983875 cm h = 5.23875 cm	95	18.82298
The moderator is full density water (0.9982 g/cm^3) surrounding three rings of double stacked slugs, each ring separated by a 277-4 canned spacer. (Slugs are inserted into the cylindrical geometry segment of the CV using the hole option.) The contents (uranium and spacers) have an overall stack height of 22.83085 cm (8.98852 in.). No polyethylene was used in this model. Each ring is separated by a 3.5561 cm spacer and 0.0012 cm of moderating material. The bottom ring has a 0.0005 cm gap between it and the bottom of the CV. The stack of slugs has 55.90865 cm of moderating material above. The modeled material masses are: 36.578 kg U (34.749 kg ^{235}U), 7.6434 kg H_2O, resulting in an h/x ratio of ~5.74. The loading arrangement of slugs is depicted in Fig. 6.9.1-4b for the Case **cvcr5est11_2_2**.			
Slugs (enr. ≤ 80%–with can spacers)			
hcia5est12_2_2_5_3	r = 1.983875 cm h = 5.23875 cm	80	18.85873
The moderator is full density water (0.9982 g/cm^3) surrounding three rings of double stacked slugs, each ring separated by a 277-4 canned spacer. (Slugs are inserted into the cylindrical geometry segment of the CV using the hole option.) The contents (uranium and spacers) have an overall stack height of 22.83085 cm (8.98852 in.). No polyethylene was used in this model. Each ring is separated by a 3.5561 cm spacer and 0.0012 cm of moderating material. The bottom ring has a 0.0005 cm gap between it and the bottom of the CV. The stack of slugs has 55.90865 cm of moderating material above. The modeled material masses are: 36.647 kg U (29.318 kg ^{235}U), 7.6434 kg H_2O, resulting in an h/x ratio of ~6.80. The loading arrangement of slugs is depicted in Fig. 6.9.1-4b for the Case **cvcr5est11_2_2**.			
ncf15est11_2_2_5_3	r = 1.983875 cm h = 5.23875 cm	80	18.85873
The moderator is full density water (0.9982 g/cm^3) surrounding three rings of double stacked slugs, each ring separated by a 277-4 canned spacer. (Slugs are inserted into the cylindrical geometry segment of the CV using the hole option.) The contents (uranium and spacers) have an overall stack height of 22.83085 cm (8.98852 in.). No polyethylene was used in this model. Each ring is separated by a 3.5561 cm spacer and 0.0012 cm of moderating material. The bottom ring has a 0.0005 cm gap between it and the bottom of the CV. The stack of slugs has 55.90865 cm of moderating material above. The modeled material masses are: 36.647 kg U (29.318 kg ^{235}U), 7.6434 kg H_2O, resulting in an h/x ratio of ~6.80. The loading arrangement of slugs is depicted in Fig. 6.9.1-4b for the Case **cvcr5est11_2_2**.			
Broken Metal for CSI=0.0			
hciabmt12_4_1_5_3	r = 6.52620 cm h = 78.74000 cm	80	18.85873
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. No 277-4 canned spacers are used in this calculation. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls. The modeled material masses are: 3.7085 kg U (2.9668 kg ^{235}U), 10.0007 kg H_2O, resulting in an h/x ratio of ~87.98.			

Table 6.9.1.1. Details of calculation models used to establish mass loading limits for surface-only modes of transportation identified in Table 6.2a

Case	Dimensions (cm)	Enrichment (wt % ^{235}U)	Density (g/cm^3)
hciabmt12_5_1_4_3	r = 6.52620 cm h = 78.74000 cm	70	18.88264
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. No 277-4 canned spacers are used in this calculation. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls. The modeled material masses are: 4.6415 kg U (3.2490 kg ^{235}U), 9.9516 kg H_2O, resulting in an h/x ratio of ~79.95.			
nciabmt11_6_1_3_3	r = 6.52620 cm h = 78.74000 cm	60	18.90661
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. No 277-4 canned spacers are used in this calculation. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls. The modeled material masses are: 5.5768 kg U (3.3461 kg ^{235}U), 9.9025 kg H_2O, resulting in an h/x ratio of ~77.24.			
hciabmt12_3_2_8_3	r = 6.52620 cm h = 78.74000 cm	100	18.81109
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 2.7743 kg ^{235}U, 9.4362 kg H_2O, resulting in an h/x ratio of ~88.78.			
hciabmt12_4_2_7_3	r = 6.52620 cm h = 78.74000 cm	95	18.82298
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 3.7014 kg U (3.5164 kg ^{235}U), 9.3871 kg H_2O, resulting in an h/x ratio of ~69.68.			
hciabmt12_4_2_6_3	r = 6.52620 cm h = 78.74000 cm	90	18.83488
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 3.7038 kg U (3.3334 kg ^{235}U), 9.3871 kg H_2O, resulting in an h/x ratio of ~73.50.			
hciabmt12_6_2_5_3	r = 6.52620 cm h = 78.74000 cm	80	18.85873
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 5.5627 kg U (4.4502 kg ^{235}U), 9.2890 kg H_2O, resulting in an h/x ratio of ~54.48.			

Table 6.9.1.1. Details of calculation models used to establish mass loading limits for surface-only modes of transportation identified in Table 6.2a

Case	Dimensions (cm)	Enrichment (wt % ^{235}U)	Density (g/cm^3)
nciabmt11_8_2_4_3	r = 6.52620 cm h = 78.74000 cm	70	18.88264
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 7.4263 kg U (5.1984 kg ^{235}U), 9.1908 kg H_2O, resulting in an h/x ratio of ~46.15.			
hciabmt12_12_2_3_3	r = 6.52620 cm h = 78.74000 cm	60	18.90661
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 11.1537 kg U (6.6922 kg ^{235}U), 8.9945 kg H_2O, resulting in an h/x ratio of ~35.08.			
Broken Metal for CSI=0.4			
ncf1bmt11_7_1_5_3	r = 6.52620 cm h = 78.74000 cm	80	18.85873
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. No 277-4 canned spacers are used in this calculation. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls. The modeled material masses are: 6.4898 kg U (5.1919 kg ^{235}U), 9.8535 kg H_2O, resulting in an h/x ratio of ~49.54.			
ncf1bmt11_9_1_4_3	r = 6.52620 cm h = 78.74000 cm	70	18.88264
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. No 277-4 canned spacers are used in this calculation. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls. The modeled material masses are: 8.3546 kg U (5.8482 kg ^{235}U), 9.7553 kg H_2O, resulting in an h/x ratio of ~43.54.			
ncf1bmt11_15_1_3_3	r = 6.52620 cm h = 78.74000 cm	60	18.90661
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. No 277-4 canned spacers are used in this calculation. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls. The modeled material masses are: 14.8715 kg U (8.9229 kg ^{235}U), 9.4118 kg H_2O, resulting in an h/x ratio of ~27.53.			

Table 6.9.1.1. Details of calculation models used to establish mass loading limits for surface-only modes of transportation identified in Table 6.2a

Case	Dimensions (cm)	Enrichment (wt % ^{235}U)	Density (g/cm^3)
ncf1bmt11_6_2_8_3	r = 6.52620 cm h = 78.74000 cm	100	18.81109
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 5.5487 kg ^{235}U, 9.2890 kg H_2O, resulting in an h/x ratio of ~43.70.			
ncf1bmt11_7_2_7_3	r = 6.52620 cm h = 78.74000 cm	95	18.82298
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 6.4775 kg U (6.1536 kg ^{235}U), 9.2399 kg H_2O, resulting in an h/x ratio of ~39.19.			
ncf1bmt11_9_2_6_3	r = 6.52620 cm h = 78.74000 cm	90	18.83488
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 8.3335 kg U (7.5002 kg ^{235}U), 9.1417 kg H_2O, resulting in an h/x ratio of ~31.81.			
ncf1bmt11_12_2_5_3	r = 6.52620 cm h = 78.74000 cm	80	18.85873
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 11.1254 kg U (8.9003 kg ^{235}U), 8.9945 kg H_2O, resulting in an h/x ratio of ~26.38.			
ncf1bmt11_19_2_4_3	r = 6.52620 cm h = 78.74000 cm	70	18.88264
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 18.5659 kg U (12.9961 kg ^{235}U), 8.6019 kg H_2O, resulting in an h/x ratio of ~17.28.			

Table 6.9.1.1. Details of calculation models used to establish mass loading limits for surface-only modes of transportation identified in Table 6.2a

Case	Dimensions (cm)	Enrichment (wt % ^{235}U)	Density (g/cm^3)
ncf1bmt11_29_2_3_3	r = 6.52620 cm h = 78.74000 cm	60	18.90661
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 28.8136 kg U (17.2882 kg ^{235}U), 8.0621 kg H_2O, resulting in an h/x ratio of ~12.17.			
Broken metal for CSI=0.8			
ncf2bmt11_12_1_5_3	r = 6.52620 cm h = 78.74000 cm	80	18.85873
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. No 277-4 canned spacers are used in this calculation. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls. The modeled material masses are: 11.1254 kg U (8.9003 kg ^{235}U), 9.6081 kg H_2O, resulting in an h/x ratio of ~28.18.			
ncf2bmt11_20_1_4_3	r = 6.52620 cm h = 78.74000 cm	70	18.88264
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. No 277-4 canned spacers are used in this calculation. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls. The modeled material masses are: 19.4942 kg U (13.6459 kg ^{235}U), 9.1664 kg H_2O, resulting in an h/x ratio of ~17.53.			
ncf2bmt11_29_1_3_3	r = 6.52620 cm h = 78.74000 cm	60	18.90661
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. No 277-4 canned spacers are used in this calculation. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls. The modeled material masses are: 28.8136 kg U (17.2882 kg ^{235}U), 8.6757 kg H_2O, resulting in an h/x ratio of ~13.10.			
ncf2bmt11_10_2_8_3	r = 6.52620 cm h = 78.74000 cm	100	18.81109
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 9.2478 kg ^{235}U, 9.0927 kg H_2O, resulting in an h/x ratio of ~25.66.			

Table 6.9.1.1. Details of calculation models used to establish mass loading limits for surface-only modes of transportation identified in Table 6.2a

Case	Dimensions (cm)	Enrichment (wt % ^{235}U)	Density (g/cm^3)
ncf2bmt11_12_2_7_3	r = 6.52620 cm h = 78.74000 cm	95	18.82298
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 11.1043 kg U (10.5491 kg ^{235}U), 8.9945 kg H_2O, resulting in an h/x ratio of ~22.25.			
ncf2bmt11_14_2_6_3	r = 6.52620 cm h = 78.74000 cm	90	18.83488
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 13.8892 kg U (12.5003 kg ^{235}U), 8.8473 kg H_2O, resulting in an h/x ratio of ~31.81.			
ncf2bmt11_21_2_5_3	r = 6.52620 cm h = 78.74000 cm	80	18.85873
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 20.3966 kg U (16.3173 kg ^{235}U), 8.5038 kg H_2O, resulting in an h/x ratio of ~13.60.			
ncf2bmt11_30_2_4_3	r = 6.52620 cm h = 78.74000 cm	70	18.88264
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 29.7054 kg U (20.7938 kg ^{235}U), 8.0131 kg H_2O, resulting in an h/x ratio of ~10.06.			
ncf2bmt11_36_2_3_3	r = 6.52620 cm h = 78.74000 cm	60	18.90661
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 35.3199 kg U (21.1920 kg ^{235}U), 7.7186 kg H_2O, resulting in an h/x ratio of ~9.51.			

Table 6.9.1.1. Details of calculation models used to establish mass loading limits for surface-only modes of transportation identified in Table 6.2a

Case	Dimensions (cm)	Enrichment (wt % ^{235}U)	Density (g/cm^3)
Broken metal for CSI=2.0			
ncf3bmt11_22_1_5_3	r = 6.52620 cm h = 78.74000 cm	80	18.85873
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. No 277-4 canned spacers are used in this calculation. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls. The modeled material masses are: 21.3237 kg U (17.0590 kg ^{235}U), 9.0683 kg H_2O, resulting in an h/x ratio of ~13.87.			
ncf3bmt11_31_1_4_3	r = 6.52620 cm h = 78.74000 cm	70	18.88264
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. No 277-4 canned spacers are used in this calculation. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls. The modeled material masses are: 30.6337 kg U (21.4436 kg ^{235}U), 8.5776 kg H_2O, resulting in an h/x ratio of ~10.44.			
ncf3bmt11_36_1_3_3	r = 6.52620 cm h = 78.74000 cm	60	18.90661
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. No 277-4 canned spacers are used in this calculation. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 35.3199 kg U (21.1920 kg ^{235}U), 8.3322 kg H_2O, resulting in an h/x ratio of ~10.26.			
ncf3bmt11_14_2_8_3	r = 6.52620 cm h = 78.74000 cm	100	18.81109
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 13.8716 kg ^{235}U, 8.8473 kg H_2O, resulting in an h/x ratio of ~16.65.			
ncf3bmt11_20_2_7_3	r = 6.52620 cm h = 78.74000 cm	95	18.82298
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 19.4326 kg U (18.4609 kg ^{235}U), 8.5529 kg H_2O, resulting in an h/x ratio of ~12.09.			

Table 6.9.1.1. Details of calculation models used to establish mass loading limits for surface-only modes of transportation identified in Table 6.2a

Case	Dimensions (cm)	Enrichment (wt % ^{235}U)	Density (g/cm^3)
ncf3bmt11_23_2_6_3	r = 6.52620 cm h = 78.74000 cm	90	18.83488
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 22.2227 kg U (20.0004 kg ^{235}U), 8.4057 kg H_2O, resulting in an h/x ratio of ~10.97.			
ncf3bmt11_32_2_5_3	r = 6.52620 cm h = 78.74000 cm	80	18.85873
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 31.5220 kg U (25.2176 kg ^{235}U), 7.9149 kg H_2O, resulting in an h/x ratio of ~8.19.			
ncf3bmt11_36_2_4_3	r = 6.52620 cm h = 78.74000 cm	70	18.88264
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 35.2751 kg U (24.6926 kg ^{235}U), 7.7186 kg H_2O, resulting in an h/x ratio of ~8.16.			
ncf3bmt11_36_2_3_3	r = 6.52620 cm h = 78.74000 cm	60	18.90661
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 35.3199 kg U (21.1920 kg ^{235}U), 7.7186 kg H_2O, resulting in an h/x ratio of ~9.51.			
Broken metal for CSI=3.2			
ncf5bmt11_35_1_5_3	r = 6.52620 cm h = 78.74000 cm	80	18.85873
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. No 277-4 canned spacers are used in this calculation. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls. The modeled material masses are: 34.3034 kg U (27.4427 kg ^{235}U), 8.3813 kg H_2O, resulting in an h/x ratio of ~7.97.			

Table 6.9.1.1. Details of calculation models used to establish mass loading limits for surface-only modes of transportation identified in Table 6.2a

Case	Dimensions (cm)	Enrichment (wt % ^{235}U)	Density (g/cm^3)
ncf5bmt11_36_1_4_3	r = 6.52620 cm h = 78.74000 cm	70	18.88264
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. No 277-4 canned spacers are used in this calculation. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls. The modeled material masses are: 35.2751 kg U (24.6926 kg ^{235}U), 8.3322 kg H_2O, resulting in an h/x ratio of ~8.81.			
ncf5bmt11_36_1_3_3	r = 6.52620 cm h = 78.74000 cm	60	18.90661
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. No 277-4 canned spacers are used in this calculation. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls. The modeled material masses are: 35.3199 kg U (21.1920 kg ^{235}U), 8.3322 kg H_2O, resulting in an h/x ratio of ~10.26.			
ncf5bmt11_25_2_8_3	r = 6.52620 cm h = 78.74000 cm	100	18.81109
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 24.9689 kg ^{235}U, 8.2584 kg H_2O, resulting in an h/x ratio of ~8.63.			
ncf5bmt11_28_2_7_3	r = 6.52620 cm h = 78.74000 cm	95	18.82298
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 27.7608 kg U (26.3728 kg ^{235}U), 8.1112 kg H_2O, resulting in an h/x ratio of ~8.03.			
ncf5bmt11_35_2_6_3	r = 6.52620 cm h = 78.74000 cm	90	18.83488
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 34.2600 kg U (30.8340 kg ^{235}U), 7.7677 kg H_2O, resulting in an h/x ratio of ~6.58.			
ncf5bmt11_36_2_5_3	r = 6.52620 cm h = 78.74000 cm	80	18.85873
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 35.2305 kg U (28.1844 kg ^{235}U), 7.7186 kg H_2O, resulting in an h/x ratio of ~7.15.			

Table 6.9.1.1. Details of calculation models used to establish mass loading limits for surface-only modes of transportation identified in Table 6.2a

Case	Dimensions (cm)	Enrichment (wt % ^{235}U)	Density (g/cm^3)
ncf5bmt11_36_2_4_3	r = 6.52620 cm h = 78.74000 cm	70	18.88264
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 35.2751 kg U (24.6926 kg ^{235}U), 7.7186 kg H_2O, resulting in an h/x ratio of ~8.16.			
ncf5bmt11_36_2_3_3	r = 6.52620 cm h = 78.74000 cm	60	18.90661
The uranium "broken metal" content is homogenized with a moderator of water with a specific gravity of 1.0×10^{-4} over the interior volume of the CV. The 277-4 canned spacers with a thickness of 3.5561 cm (1.4000 in.) are used and are modeled at 3.02984 cm and 9.61638 cm above the bottom of the CV. No polyethylene was used in this calculation. Since the contents are homogenized over the internal volume of the CV, there is no moderating material between the content and the CV walls or the spacers. The modeled material masses are: 35.3199 kg U (21.1920 kg ^{235}U), 7.7186 kg H_2O, resulting in an h/x ratio of ~9.51.			
Product oxide			
hciapdoxt12_1_1_11_3	r = 6.42620 cm h = 46.58351 cm	100	2.00000
Water-saturated HEU product oxide with 500 g polyethylene (0.9200 g/cm^3) is dispersed within the CV to a height determined by the mass of the product oxide, polyethylene, and saturation moisture. The product oxide is saturated with 4.488 kg H_2O of full density water (0.9982 g/cm^3). Since the product oxide content is assumed to be dispersed within the CV, there are no gaps between the content and the CV wall or bottom. There are 32.15649 cm of moderator above the product oxide content. No 277-4 canned spacers are used in this analysis. The modeled material masses are: 11.00 kg UO_2 (9.682 kg ^{235}U), 8,652.6 kg H_2O, and 500 g polyethylene resulting in an h/x ratio of ~25.06.			
Skull oxide			
nciask_9_15	r = 6.42620 cm h = 28.18623 cm	100	6.54000
The skull oxide is dispersed within the CV to a height determined by the mass of the skull oxide. The skull oxide is saturated with a moderator of full density water (0.9982 g/cm^3). No polyethylene is used in this analysis. Since the skull oxide content is assumed to be dispersed within the CV, there are no gaps between the content and the CV wall or bottom. There are 50.55377 cm of moderator above the skull oxide content. No 277-4 canned spacers are used in this analysis. The modeled material masses are: 21.3000 kg skull oxide, 19.8653 kg U_3O_8, 15.6728 kg ^{235}U, 3.8014 kg H_2O, resulting in an h/x ratio of ~7.43.			
UNX crystals			
nciapunhct11_7_3	r = 6.42620 cm h = 78.74000 cm	100	2.79329
The UNX crystals are homogenized with 1515.7 g full density water (0.9982 g/cm^3) and 500 g polyethylene (0.9200 g/cm^3) dispersed over the entire inner volume of the CV. There is no gap between the homogenized UNX content and the CV bottom or sides. Since the content is homogenized over the inner volume of the CV, no moderating material is above the content. No 277-4 canned spacers are used in this model. The modeled material masses are 7.0 kg UNX crystals (3.2968 kg ^{235}U), 8.6886 kg H_2O, and 500 g polyethylene resulting in an h/x ratio of ~73.73.			

Table 6.9.1.1. Details of calculation models used to establish mass loading limits for surface-only modes of transportation identified in Table 6.2a

Case	Dimensions (cm)	Enrichment (wt % ^{235}U)	Density (g/cm^3)
ncf1punhct11_24_3	r = 6.42620 cm h = 78.74000 cm	100	2.79329
The UNX crystals are homogenized with 5,196.7 g full density water (0.9982 g/cm^3) and 500 g polyethylene (0.9200 g/cm^3) dispersed over the entire inner volume of the CV. There is no gap between the homogenized UNX crystals and the CV bottom or sides. Since the content is homogenized over the inner volume of the CV, no moderating material is above the content. No 277-4 canned spacers are used in this model. The modeled material masses are 24.0 kg UNX crystals (11.3031 kg ^{235}U), 6.2746 kg H_2O, and 500 g polyethylene, resulting in an h/x ratio of ~15.97.			
TRIGA fuel			
nciatriga_1_15_3	r = 1.8288 cm h = 12.7000 cm	20	8.65974
The moderator is full density water (0.9982 g/cm^3) surrounding three stacked "bundles" of three TRIGA fuel elements separated by 277-4 canned spacers. The content has an overall height of 38.10310 cm (15.00122 in.). No polyethylene was used in this model. Each content is separated by a 0.0001 cm spacer and 0.0012 cm of moderating material. The bottom content has a 0.0005 cm gap between it and the bottom of the CV. The contents sit in the exact center on the bottom of the CV. The modeled material masses are 10.4 kg $UZrH_x$, 0.9210 kg ^{235}U, and 8.9982 kg H_2O, resulting in an h/x ratio of ~255.01.			
nciatriga70_1_15_3	r = 1.8288 cm h = 12.7000 cm	70	5.70132
The moderator is full density water (0.9982 g/cm^3) surrounding three stacked "bundles" of three TRIGA fuel elements separated by 277-4 canned spacers. The content has an overall height of 38.10310 cm (15.00122 in.). No polyethylene was used in this model. Each content is separated by a 0.0001 cm spacer and 0.0012 cm of moderating material. The bottom content has a 0.0005 cm gap between it and the bottom of the CV. The contents sit in the exact center on the bottom of the CV. The modeled material masses are 6.8471 kg $UZrH_x$, 0.4080 kg ^{235}U, and 8.9982 kg H_2O, resulting in an h/x ratio of ~575.64.			

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Appendix 6.9.2
HAC Package Model

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Appendix 6.9.2
HAC Package Model

6.9.2.1 Prediction of HAC Damage in the ES-3100 Package

Finite element analysis of an ES-3100 package under Hypothetical Accident Conditions (HAC) is used to predict the deformed outer diameters of the drum at node points along the vertical axis of an upright package. Selected node points are designated in a downward direction from the top of the drum as "UR," "MUR," "MR," "MLR," and "LR." Table 6.9.2.1-1 lists diameters at the five node points measured along the 90–270° and 0–180° axes. These dimensions represent major and minor axes at each deformation point on the assumption that the drum cross section is ellipsoidal. A corresponding equivalent circular diameter is also listed for each node point in Table 6.9.2.1-1.

A set of KENO V.a calculation models based on reduced package diameters at the "MR," "MLR," and "LR" deformation points are derived from the Normal Conditions of Transport (NCT) geometry model. These geometry models are evaluated for the purpose of establishing a bounding geometry model for representing the ES-3100 package under HAC. The primary changes made to the KENO V.a geometry input statements in the NCT model are reductions in the drum's radii. The change to the drum's inner radius also affects the outer radius of both the angle iron and the Kaolite located inside the CV outer liner. The volume fractions for these materials are adjusted in the KENO V.a calculation models so that material masses of the affected package components are conserved. Table 6.9.2.1-2 provides data for transforming the KENO V.a calculation model from an NCT model into an HAC model.

6.9.2.2 Criticality Calculations

Sets of criticality calculations are performed for the "MR," "MLR," and "LR" models at five different package water contents over the range of HAC. The five package water contents of the void spaces external to the containment vessel (CV) and the interstitial space between drums are as follows: 1e-20 spg water, 1E-04 spg water, 0.1 spg water, 0.3 spg water, and 1.0 spg water. The water content in the Kaolite corresponds to the dry condition (VF= 0.0287) where neutronic interaction between the packages of an array is maximized.

An infinite array of packages is evaluated in order to eliminate any biases arising from spectral leakage effects in the reflector of the finite array. The k_{eff} values for each KENO V.a case are based on 500,000 neutron histories produced by running for 215 generations with 2,500 neutrons per generation and truncating the first 15 generations of data. Each package modeled has 36 kg of 100% enriched uranium in the form of broken metal content.

Each case is rerun using a different starting random number in order to produce sets of computed k_{eff} values that are statistically independent. The random starting number, the mean value (k_{eff}), and the corresponding standard error (s_i) computed for ten individual runs are shown in Tables 6.9.2.2-1, -2, and -3. The same statistical method (described in DAC-FS-900000-A014) used in the evaluation of Kaolite models (Appendix 6.9.3, Sect. 6.9.3.4) is also used here for determining whether or not differences in neutronic performance between the package models are statistically significant.

Table 6.9.2.1-1. Deformation of the ES-3100 drum at five node points, projected by finite element analysis "Case 3100 RUN1HL Lower Bound Kaolite May 2004"

Deformation point	FEA node	Diameter at 90° (in.)	Diameter at 180° (in.)	Equivalent circular diameter	
				(in.)	(cm)
UR	098194	20.02	15.60	17.6724	44.8878
MUR	100238	20.74	15.07	17.6791	44.9050
MR	101589	20.74	14.18	17.1492	43.5588
MLR	103012	22.00	13.44	17.1954	43.6762
LR	105786	20.92	12.92	16.4404	41.7586

Table 6.9.2.1-2. Parameter changes for converting an NCT package model into an HAC package model

Parameter	Reference NCT package model	HAC model at MR node point of package	HAC model at MLR node point of package	HAC model at LR node point of package
Package model dimension				
OR_{Drum} (cm)	23.32990	21.77942	21.83809	20.87929
IR_{Drum} (cm)	23.17750	21.62702	21.68569	20.72689
$th_{Drum\ wall}$ (cm)	0.15240	0.15240	0.15240	0.15240
OR_{Lid} (cm)	23.11400	21.56352	21.62219	20.66339
IR_{Lid} (cm)	22.96160	21.41112	21.46979	20.51099
$th_{Kaolite}$ (cm)	12.10310	10.55262	10.61129	9.65249
Kaolite of the body weldment inner liner				
Mass (g)	117,563.0	97,080.4	97,829.7	85,839.8
Volume (cm^3)	134,888.0	111,387.0	112,246.0	98,489.5
Volume fraction multiplier [a]	–	1.21099	1.20171	1.36956
VF for water component of Kaolite	0.52294	0.63327 [b]	0.62843 [b]	0.71620 [b]
VF for dry mix component of Kaolite	0.34864	0.42220 [b]	0.41897 [b]	0.47749 [b]
Angle iron				
Mass (g)	5,621.76	4,521.40	4,561.66	3,917.54
Volume (cm^3)	708.030	569.446	574.516	493.393
VF	1.0	1.24337	1.23239	1.43502
Drum steel				
Mass (g)	25,446.3	23,397.6	23,474.2	22,231.2
Volume (cm^3)	3,204.82	2,946.80	2,956.50	2,799.90
VF	1.0	1.08756	1.08401	1.14462

[a] Volume fraction multiplier is an NCT density multiplier for conserving mass in components having modified volumes in the HAC calculation models.

[b] Volume fraction (VF) for Kaolite components calculated by multiplying the VF used in the NCT model by volume fraction multiplier for the HAC model.

Table 6.9.2.2-1. Neutron multiplication factors with standard deviations for the ES-3100 package models at the "MR" and "MLR" node points

MOIFR	Random number	"A" cases	k_{eff}	s	"B" cases	k_{eff}	s
1.0E-20	109E77866CF6	mrandnum_01_01	1.04965	0.00119	mlrrandnum_01_01	1.05024	0.00139
1.0E-20	16AA4A58735C	mrandnum_01_02	1.05132	0.00131	mlrrandnum_01_02	1.05051	0.00135
1.0E-20	1814171B652A	mrandnum_01_03	1.05368	0.00123	mlrrandnum_01_03	1.05121	0.00128
1.0E-20	1A423B9472C7	mrandnum_01_04	1.05165	0.00145	mlrrandnum_01_04	1.04954	0.00120
1.0E-20	20E876D82248	mrandnum_01_05	1.05344	0.00106	mlrrandnum_01_05	1.05249	0.00110
1.0E-20	3F6E65CA7440	mrandnum_01_06	1.05188	0.00157	mlrrandnum_01_06	1.04924	0.00132
1.0E-20	479D21DB7509	mrandnum_01_07	1.05149	0.00148	mlrrandnum_01_07	1.05105	0.00111
1.0E-20	55D4371D3A23	mrandnum_01_08	1.05083	0.00113	mlrrandnum_01_08	1.05039	0.00129
1.0E-20	6E1A14672B8F	mrandnum_01_09	1.04910	0.00106	mlrrandnum_01_09	1.05161	0.00125
1.0E-20	77A0308C0E44	mrandnum_01_10	1.05254	0.00106	mlrrandnum_01_10	1.05041	0.00129
1.0E-04	109E77866CF6	mrandnum_03_01	1.04994	0.00132	mlrrandnum_03_01	1.05108	0.00151
1.0E-04	16AA4A58735C	mrandnum_03_02	1.05023	0.00118	mlrrandnum_03_02	1.05245	0.00116
1.0E-04	1814171B652A	mrandnum_03_03	1.05090	0.00139	mlrrandnum_03_03	1.05169	0.00138
1.0E-04	1A423B9472C7	mrandnum_03_04	1.05072	0.00115	mlrrandnum_03_04	1.05303	0.00102
1.0E-04	20E876D82248	mrandnum_03_05	1.05052	0.00119	mlrrandnum_03_05	1.05191	0.00115
1.0E-04	3F6E65CA7440	mrandnum_03_06	1.05383	0.00131	mlrrandnum_03_06	1.05017	0.00110
1.0E-04	479D21DB7509	mrandnum_03_07	1.05205	0.00153	mlrrandnum_03_07	1.05232	0.00128
1.0E-04	55D4371D3A23	mrandnum_03_08	1.05343	0.00106	mlrrandnum_03_08	1.05100	0.00144
1.0E-04	6E1A14672B8F	mrandnum_03_09	1.04831	0.00132	mlrrandnum_03_09	1.05046	0.00145
1.0E-04	77A0308C0E44	mrandnum_03_10	1.05353	0.00111	mlrrandnum_03_10	1.05130	0.00134
0.10	109E77866CF6	mrandnum_06_01	0.97948	0.00120	mlrrandnum_06_01	0.98071	0.00129
0.10	16AA4A58735C	mrandnum_06_02	0.98104	0.00125	mlrrandnum_06_02	0.98006	0.00110
0.10	1814171B652A	mrandnum_06_03	0.98056	0.00134	mlrrandnum_06_03	0.98043	0.00116
0.10	1A423B9472C7	mrandnum_06_04	0.97895	0.00114	mlrrandnum_06_04	0.98253	0.00109
0.10	20E876D82248	mrandnum_06_05	0.98058	0.00113	mlrrandnum_06_05	0.98256	0.00135
0.10	3F6E65CA7440	mrandnum_06_06	0.97966	0.00119	mlrrandnum_06_06	0.98093	0.00127
0.10	479D21DB7509	mrandnum_06_07	0.97953	0.00145	mlrrandnum_06_07	0.97959	0.00127
0.10	55D4371D3A23	mrandnum_06_08	0.97993	0.00130	mlrrandnum_06_08	0.98033	0.00111
0.10	6E1A14672B8F	mrandnum_06_09	0.97972	0.00138	mlrrandnum_06_09	0.97940	0.00117
0.10	77A0308C0E44	mrandnum_06_10	0.98157	0.00134	mlrrandnum_06_10	0.98318	0.00134
0.30	109E77866CF6	mrandnum_08_01	0.93412	0.00118	mlrrandnum_08_01	0.93254	0.00147
0.30	16AA4A58735C	mrandnum_08_02	0.93227	0.00138	mlrrandnum_08_02	0.93186	0.00142
0.30	1814171B652A	mrandnum_08_03	0.93390	0.00131	mlrrandnum_08_03	0.93200	0.00135
0.30	1A423B9472C7	mrandnum_08_04	0.93252	0.00144	mlrrandnum_08_04	0.93197	0.00150
0.30	20E876D82248	mrandnum_08_05	0.93334	0.00132	mlrrandnum_08_05	0.93601	0.00124
0.30	3F6E65CA7440	mrandnum_08_06	0.93168	0.00132	mlrrandnum_08_06	0.93249	0.00118
0.30	479D21DB7509	mrandnum_08_07	0.93514	0.00123	mlrrandnum_08_07	0.93299	0.00128
0.30	55D4371D3A23	mrandnum_08_08	0.93564	0.00132	mlrrandnum_08_08	0.93500	0.00133
0.30	6E1A14672B8F	mrandnum_08_09	0.93597	0.00136	mlrrandnum_08_09	0.93201	0.00122
0.30	77A0308C0E44	mrandnum_08_10	0.93525	0.00128	mlrrandnum_08_10	0.93238	0.00153

Table 6.9.2.2-1. Neutron multiplication factors with standard deviations for the ES-3100 package models at the "MR" and "MLR" node points

MOIFR	Random number	"A" cases	k_{eff}	s	"B" cases	k_{eff}	s
1.00	109E77866CF6	mrandnum_15_01	0.93103	0.00139	mlrrandnum_15_01	0.93180	0.00126
1.00	16AA4A58735C	mrandnum_15_02	0.93082	0.00131	mlrrandnum_15_02	0.93020	0.00159
1.00	1814171B652A	mrandnum_15_03	0.92890	0.00148	mlrrandnum_15_03	0.92956	0.00117
1.00	1A423B9472C7	mrandnum_15_04	0.93062	0.00145	mlrrandnum_15_04	0.92837	0.00165
1.00	20E876D82248	mrandnum_15_05	0.93055	0.00125	mlrrandnum_15_05	0.93220	0.00120
1.00	3F6E65CA7440	mrandnum_15_06	0.92950	0.00117	mlrrandnum_15_06	0.93177	0.00141
1.00	479D21DB7509	mrandnum_15_07	0.92952	0.00116	mlrrandnum_15_07	0.93217	0.00144
1.00	55D4371D3A23	mrandnum_15_08	0.92805	0.00154	mlrrandnum_15_08	0.92921	0.00125
1.00	6E1A14672B8F	mrandnum_15_09	0.93117	0.00140	mlrrandnum_15_09	0.92980	0.00177
1.00	77A0308C0E44	mrandnum_15_10	0.93218	0.00120	mlrrandnum_15_10	0.93070	0.00126

Table 6.9.2.2-2.Neutron multiplication factors with standard deviations for the ES-3100 package models at the "MLR" and "LR" node points

MOIFR	Random number	"A" cases	k_{eff}	s	"B" cases	k_{eff}	s
1.0E-20	109E77866CF6	mlrrandnum_01_01	1.05024	0.00139	lrrandnum_01_01	1.05093	0.00133
1.0E-20	16AA4A58735C	mlrrandnum_01_02	1.05051	0.00135	lrrandnum_01_02	1.05009	0.00118
1.0E-20	1814171B652A	mlrrandnum_01_03	1.05121	0.00128	lrrandnum_01_03	1.05057	0.00118
1.0E-20	1A423B9472C7	mlrrandnum_01_04	1.04954	0.00120	lrrandnum_01_04	1.05066	0.00120
1.0E-20	20E876D82248	mlrrandnum_01_05	1.05249	0.00110	lrrandnum_01_05	1.04882	0.00129
1.0E-20	3F6E65CA7440	mlrrandnum_01_06	1.04924	0.00132	lrrandnum_01_06	1.05316	0.00127
1.0E-20	479D21DB7509	mlrrandnum_01_07	1.05105	0.00111	lrrandnum_01_07	1.05229	0.00134
1.0E-20	55D4371D3A23	mlrrandnum_01_08	1.05039	0.00129	lrrandnum_01_08	1.05186	0.00131
1.0E-20	6E1A14672B8F	mlrrandnum_01_09	1.05161	0.00125	lrrandnum_01_09	1.05236	0.00113
1.0E-20	77A0308C0E44	mlrrandnum_01_10	1.05041	0.00129	lrrandnum_01_10	1.05098	0.00120
1.0E-04	109E77866CF6	mlrrandnum_03_01	1.05108	0.00151	lrrandnum_03_01	1.05122	0.00123
1.0E-04	16AA4A58735C	mlrrandnum_03_02	1.05245	0.00116	lrrandnum_03_02	1.05324	0.00121
1.0E-04	1814171B652A	mlrrandnum_03_03	1.05169	0.00138	lrrandnum_03_03	1.05143	0.00123
1.0E-04	1A423B9472C7	mlrrandnum_03_04	1.05303	0.00102	lrrandnum_03_04	1.05048	0.00121
1.0E-04	20E876D82248	mlrrandnum_03_05	1.05191	0.00115	lrrandnum_03_05	1.05095	0.00137
1.0E-04	3F6E65CA7440	mlrrandnum_03_06	1.05017	0.00110	lrrandnum_03_06	1.05029	0.00119
1.0E-04	479D21DB7509	mlrrandnum_03_07	1.05232	0.00128	lrrandnum_03_07	1.05124	0.00108
1.0E-04	55D4371D3A23	mlrrandnum_03_08	1.05100	0.00144	lrrandnum_03_08	1.05080	0.00116
1.0E-04	6E1A14672B8F	mlrrandnum_03_09	1.05046	0.00145	lrrandnum_03_09	1.05074	0.00122
1.0E-04	77A0308C0E44	mlrrandnum_03_10	1.05130	0.00134	lrrandnum_03_10	1.05094	0.00111
0.1	109E77866CF6	mlrrandnum_06_01	0.98071	0.00129	lrrandnum_06_01	0.98315	0.00118
0.1	16AA4A58735C	mlrrandnum_06_02	0.98006	0.00110	lrrandnum_06_02	0.98605	0.00124
0.1	1814171B652A	mlrrandnum_06_03	0.98043	0.00116	lrrandnum_06_03	0.98690	0.00120

Table 6.9.2.2-2.Neutron multiplication factors with standard deviations for the ES-3100 package models at the “MLR” and “LR” node points

MOIFR	Random number	"A" cases	k_{eff}	s	"B" cases	k_{eff}	s
0.1	1A423B9472C7	mlrrandnum_06_04	0.98253	0.00109	lrrandnum_06_04	0.98347	0.00126
0.1	20E876D82248	mlrrandnum_06_05	0.98256	0.00135	lrrandnum_06_05	0.98770	0.00124
0.1	3F6E65CA7440	mlrrandnum_06_06	0.98093	0.00127	lrrandnum_06_06	0.98734	0.00140
0.1	479D21DB7509	mlrrandnum_06_07	0.97959	0.00127	lrrandnum_06_07	0.98417	0.00133
0.1	55D4371D3A23	mlrrandnum_06_08	0.98033	0.00111	lrrandnum_06_08	0.98712	0.00136
0.1	6E1A14672B8F	mlrrandnum_06_09	0.97940	0.00117	lrrandnum_06_09	0.98533	0.00142
0.1	77A0308C0E44	mlrrandnum_06_10	0.98318	0.00134	lrrandnum_06_10	0.98412	0.00116
0.3	109E77866CF6	mlrrandnum_08_01	0.93254	0.00147	lrrandnum_08_01	0.93910	0.00146
0.3	16AA4A58735C	mlrrandnum_08_02	0.93186	0.00142	lrrandnum_08_02	0.93757	0.00117
0.3	1814171B652A	mlrrandnum_08_03	0.93200	0.00135	lrrandnum_08_03	0.93940	0.00146
0.3	1A423B9472C7	mlrrandnum_08_04	0.93197	0.00150	lrrandnum_08_04	0.93676	0.00130
0.3	20E876D82248	mlrrandnum_08_05	0.93601	0.00124	lrrandnum_08_05	0.93851	0.00111
0.3	3F6E65CA7440	mlrrandnum_08_06	0.93249	0.00118	lrrandnum_08_06	0.93914	0.00149
0.3	479D21DB7509	mlrrandnum_08_07	0.93299	0.00128	lrrandnum_08_07	0.94011	0.00131
0.3	55D4371D3A23	mlrrandnum_08_08	0.93500	0.00133	lrrandnum_08_08	0.93900	0.00139
0.3	6E1A14672B8F	mlrrandnum_08_09	0.93201	0.00122	lrrandnum_08_09	0.93781	0.00117
0.3	77A0308C0E44	mlrrandnum_08_10	0.93238	0.00153	lrrandnum_08_10	0.93965	0.00118
1.0	109E77866CF6	mlrrandnum_15_01	0.93180	0.00126	lrrandnum_15_01	0.93344	0.00126
1.0	16AA4A58735C	mlrrandnum_15_02	0.93020	0.00159	lrrandnum_15_02	0.93281	0.00121
1.0	1814171B652A	mlrrandnum_15_03	0.92956	0.00117	lrrandnum_15_03	0.93468	0.00132
1.0	1A423B9472C7	mlrrandnum_15_04	0.92837	0.00165	lrrandnum_15_04	0.93592	0.00126
1.0	20E876D82248	mlrrandnum_15_05	0.93220	0.00120	lrrandnum_15_05	0.93251	0.00143
1.0	3F6E65CA7440	mlrrandnum_15_06	0.93177	0.00141	lrrandnum_15_06	0.93374	0.00121
1.0	479D21DB7509	mlrrandnum_15_07	0.93217	0.00144	lrrandnum_15_07	0.93572	0.00138
1.0	55D4371D3A23	mlrrandnum_15_08	0.92921	0.00125	lrrandnum_15_08	0.93498	0.00145
1.0	6E1A14672B8F	mlrrandnum_15_09	0.92980	0.00177	lrrandnum_15_09	0.93224	0.00114
1.0	77A0308C0E44	mlrrandnum_15_10	0.93070	0.00126	lrrandnum_15_10	0.93158	0.00131

Table 6.9.2.2-3. Neutron multiplication factors with standard deviations for the ES-3100 package models at the "MR" and "LR" node points

MOIFR	Random number	"A" cases	k_{eff}	s	"B" cases	k_{eff}	s
1.0E-20	109E77866CF6	mrandnum_01_01	1.04965	0.00119	lrrandnum_01_01	1.05093	0.00133
1.0E-20	16AA4A58735C	mrandnum_01_02	1.05132	0.00131	lrrandnum_01_02	1.05009	0.00118
1.0E-20	1814171B652A	mrandnum_01_03	1.05368	0.00123	lrrandnum_01_03	1.05057	0.00118
1.0E-20	1A423B9472C7	mrandnum_01_04	1.05165	0.00145	lrrandnum_01_04	1.05066	0.00120
1.0E-20	20E876D82248	mrandnum_01_05	1.05344	0.00106	lrrandnum_01_05	1.04882	0.00129
1.0E-20	3F6E65CA7440	mrandnum_01_06	1.05188	0.00157	lrrandnum_01_06	1.05316	0.00127
1.0E-20	479D21DB7509	mrandnum_01_07	1.05149	0.00148	lrrandnum_01_07	1.05229	0.00134
1.0E-20	55D4371D3A23	mrandnum_01_08	1.05083	0.00113	lrrandnum_01_08	1.05186	0.00131
1.0E-20	6E1A14672B8F	mrandnum_01_09	1.04910	0.00106	lrrandnum_01_09	1.05236	0.00113
1.0E-20	77A0308C0E44	mrandnum_01_10	1.05254	0.00106	lrrandnum_01_10	1.05098	0.00120
1.0E-04	109E77866CF6	mrandnum_03_01	1.04994	0.00132	lrrandnum_03_01	1.05122	0.00123
1.0E-04	16AA4A58735C	mrandnum_03_02	1.05023	0.00118	lrrandnum_03_02	1.05324	0.00121
1.0E-04	1814171B652A	mrandnum_03_03	1.05090	0.00139	lrrandnum_03_03	1.05143	0.00123
1.0E-04	1A423B9472C7	mrandnum_03_04	1.05072	0.00115	lrrandnum_03_04	1.05048	0.00121
1.0E-04	20E876D82248	mrandnum_03_05	1.05052	0.00119	lrrandnum_03_05	1.05095	0.00137
1.0E-04	3F6E65CA7440	mrandnum_03_06	1.05383	0.00131	lrrandnum_03_06	1.05029	0.00119
1.0E-04	479D21DB7509	mrandnum_03_07	1.05205	0.00153	lrrandnum_03_07	1.05124	0.00108
1.0E-04	55D4371D3A23	mrandnum_03_08	1.05343	0.00106	lrrandnum_03_08	1.05080	0.00116
1.0E-04	6E1A14672B8F	mrandnum_03_09	1.04831	0.00132	lrrandnum_03_09	1.05074	0.00122
1.0E-04	77A0308C0E44	mrandnum_03_10	1.05353	0.00111	lrrandnum_03_10	1.05094	0.00111
0.10	109E77866CF6	mrandnum_06_01	0.97948	0.00120	lrrandnum_06_01	0.98315	0.00118
0.10	16AA4A58735C	mrandnum_06_02	0.98104	0.00125	lrrandnum_06_02	0.98605	0.00124
0.10	1814171B652A	mrandnum_06_03	0.98056	0.00134	lrrandnum_06_03	0.98690	0.00120
0.10	1A423B9472C7	mrandnum_06_04	0.97895	0.00114	lrrandnum_06_04	0.98347	0.00126
0.10	20E876D82248	mrandnum_06_05	0.98058	0.00113	lrrandnum_06_05	0.98770	0.00124
0.10	3F6E65CA7440	mrandnum_06_06	0.97966	0.00119	lrrandnum_06_06	0.98734	0.00140
0.10	479D21DB7509	mrandnum_06_07	0.97953	0.00145	lrrandnum_06_07	0.98417	0.00133
0.10	55D4371D3A23	mrandnum_06_08	0.97993	0.00130	lrrandnum_06_08	0.98712	0.00136
0.10	6E1A14672B8F	mrandnum_06_09	0.97972	0.00138	lrrandnum_06_09	0.98533	0.00142
0.10	77A0308C0E44	mrandnum_06_10	0.98157	0.00134	lrrandnum_06_10	0.98412	0.00116
0.30	109E77866CF6	mrandnum_08_01	0.93412	0.00118	lrrandnum_08_01	0.93910	0.00146
0.30	16AA4A58735C	mrandnum_08_02	0.93227	0.00138	lrrandnum_08_02	0.93757	0.00117
0.30	1814171B652A	mrandnum_08_03	0.93390	0.00131	lrrandnum_08_03	0.93940	0.00146
0.30	1A423B9472C7	mrandnum_08_04	0.93252	0.00144	lrrandnum_08_04	0.93676	0.00130
0.30	20E876D82248	mrandnum_08_05	0.93334	0.00132	lrrandnum_08_05	0.93851	0.00111
0.30	3F6E65CA7440	mrandnum_08_06	0.93168	0.00132	lrrandnum_08_06	0.93914	0.00149
0.30	479D21DB7509	mrandnum_08_07	0.93514	0.00123	lrrandnum_08_07	0.94011	0.00131
0.30	55D4371D3A23	mrandnum_08_08	0.93564	0.00132	lrrandnum_08_08	0.93900	0.00139
0.30	6E1A14672B8F	mrandnum_08_09	0.93597	0.00136	lrrandnum_08_09	0.93781	0.00117
0.30	77A0308C0E44	mrandnum_08_10	0.93525	0.00128	lrrandnum_08_10	0.93965	0.00118

Table 6.9.2.2-3. Neutron multiplication factors with standard deviations for the ES-3100 package models at the "MR" and "LR" node points

MOIFR	Random number	"A" cases	k_{eff}	s	"B" cases	k_{eff}	s
1.00	109E77866CF6	mrandnum_15_01	0.93103	0.00139	lrrandnum_15_01	0.93344	0.00126
1.00	16AA4A58735C	mrandnum_15_02	0.93082	0.00131	lrrandnum_15_02	0.93281	0.00121
1.00	1814171B652A	mrandnum_15_03	0.92890	0.00148	lrrandnum_15_03	0.93468	0.00132
1.00	1A423B9472C7	mrandnum_15_04	0.93062	0.00145	lrrandnum_15_04	0.93592	0.00126
1.00	20E876D82248	mrandnum_15_05	0.93055	0.00125	lrrandnum_15_05	0.93251	0.00143
1.00	3F6E65CA7440	mrandnum_15_06	0.92950	0.00117	lrrandnum_15_06	0.93374	0.00121
1.00	479D21DB7509	mrandnum_15_07	0.92952	0.00116	lrrandnum_15_07	0.93572	0.00138
1.00	55D4371D3A23	mrandnum_15_08	0.92805	0.00154	lrrandnum_15_08	0.93498	0.00145
1.00	6E1A14672B8F	mrandnum_15_09	0.93117	0.00140	lrrandnum_15_09	0.93224	0.00114
1.00	77A0308C0E44	mrandnum_15_10	0.93218	0.00120	lrrandnum_15_10	0.93158	0.00131

6.9.2.3 Statistical Evaluation

An evaluation of KENO V.a calculation results is made to determine if there is a statistically significant difference between the mean k_{eff} for the "MR" and "MLR" models, for the "MLR" and "LR" models, and for the "MR" and "LR" models. Cases are classified into five groups based on the amount of water assumed to be present in the shipping package. The symbol "I" is used to specify the case. The mean difference and standard deviation for each of the five sets of pair-wise differences are defined as follows:

(a) $d_i = (k_{effBi} - k_{effAi})/n$ and

(b) $s_{di} = \sqrt{[\, n\Sigma d_i^{\,2} - (\Sigma d_i)^2 \,] / n(n-1)}$ (conservatively defined for the t-test appropriate for small sample sizes),

where A_i and B_i denote the model types, and n denotes the sample size of ten. It is reasonable to assume that the paired differences have been randomly selected from a normally distributed population of paired differences with mean (μ_d) and standard deviation (σ_d), then the sampling distribution of

$$(d - \mu_d) / (s_d/\sqrt{n})$$

is a *t* distribution having n-1 degrees of freedom.

The evaluation of the mean differences (d_i) for the 10 sets of cases is accomplished through hypothesis testing, a statistical tool used to provide evidence that a difference exists or does not exist. The t_i values are given in Table 6.9.2.3-1. A value of 3.25 is obtained from the standard table for critical values for the t distribution from which the decision to accept or reject the null hypothesis H_0 is made with a Type I error probability (α) of 0.01.

For $|t| < 3.25$, the H_o hypothesis is not rejected. Acceptance of the null hypothesis is the result of insufficient evidence to reject it. Thus, it can be concluded that the mean estimates of the difference in k_{eff} between the "MR" and "MLR" calculation models, between the "MLR" and "LR" calculation models, and between the "MR" and "LR" calculation models are not statistically significant for the dry condition where neutronic interaction between packages is significant. Also, the mean estimate of the difference in k_{eff} between the "MR" and "MLR" calculation models is not statistically significant for wet or flooded conditions where the packages of the array become isolated.

Table 6.9.2.3-1. T-test values for establishing the statistical significance of the differences in calculated k_{eff} values for the ES-3100 package models at the "MR," "MLR," and "LR" node points

MOIFR	"MR" cases (k_{eff})	"MLR" cases (k_{eff})	di	Sdi	ta
1.0E-20	1.05154	1.05075	0.00089	1.58991E-03	1.77
1.0E-04	1.05146	1.05165	-0.00019	2.17840E-03	-0.28
0.1	0.98008	0.98091	-0.00087	1.33870E-03	-2.06
0.3	0.93404	0.93300	0.00106	1.88912E-03	1.77
1.0	0.93030	0.93067	-0.00034	1.68664E-03	-0.65

MOIFR	"MLR" cases (k_{eff})	"LR" cases (k_{eff})	di	Sdi	t
1.0E-20	1.05075	1.05116	-0.00050	1.92087E-03	-0.83
1.0E-04	1.05165	1.05113	0.00041	9.36819E-04	1.38
0.1	0.98091	0.98546	-0.00456	2.28535E-03	-6.31
0.3	0.93300	0.93863	-0.00578	1.59574E-03	-11.45
1.0	0.93067	0.93369	-0.00318	2.30797E-03	-4.36

MOIFR	"MR" cases (k_{eff})	"LR" cases (k_{eff})	di	Sdi	t
1.0E-20	1.05154	1.05116	0.00039	2.35840E-03	0.52
1.0E-04	1.05146	1.05113	0.00021	2.19813E-03	0.31
0.10	0.98008	0.98546	-0.00543	1.66324E-03	-10.33
0.30	0.93404	0.93863	-0.00472	1.46294E-03	-10.21
1.00	0.93030	0.93369	-0.00353	2.50750E-03	-4.45

[a] critical value = 3.25 for 10 cases.

For $|t| > 3.25$, the H_o hypothesis is rejected. Therefore, it can be concluded that the mean estimate of the difference in k_{eff} between the "MLR" and "LR" calculation models, and between the "MR" and "LR" calculation models, is statistically significant for wet or flooded conditions where the packages of the array become isolated. The negative t-values indicate that the calculated k_{eff} value for the "LR" model is slightly higher than for the "MR" and "MLR" models. This result is consistent with an expected increase in k_{eff} due to "tighter or closer" water reflector surrounding the package content.

Although flattening of the side of the package represents a reduction in the diameter of the drum, the points at which minimum flattening occurs provide an indication of the reduction of lattice spacing between packages of an array under HAC. The composite of the minimum deformation points at perpendicular axes (90–270° and 0–180°) represents the modified lattice spacing in an array of ES-3100 packages. As illustrated in Table 6.9.2.3-2, the equivalent diameter of the package for "composite" lattice spacing is not significantly different from the 18.37-in. diam of the pre-test package. Even though significant crushing of the drum midsection and bottom occurs, the effective center-to-center spacing of the contents actually increases under HAC. Selective rearrangement of alternating packages would be required to achieve a more compact array; however, this event is not credible.

As described in Sect. 6.3.1.2, a close-pack (triangular-pitch) array of packages would be represented by a reduced package in a rectangular-pitch configuration. For HAC, the 17.26-in. reduced diameter for the "composite close-pack" package is slightly larger than the 17.20-in. diam of the "MLR" calculation model used in the HAC calculations of Sect. 6.6. Therefore, packages evaluated with the "MLR" calculation model of packages in a rectangular-pitch configuration are deemed adequate for the HAC criticality evaluation. Considering both the irregular shape of the deformed drums and that array spacing is determined by overall (maximum) dimensions rather than by mean or minimum dimensions of a damaged package, the use of the "MLR" model for representing the ES-3100 package under HAC is conservative and bounding.

Table 6.9.2.3-2. Deformation of the ES-3100 drum projected by finite element analysis "Case 3100 RUN1HL Lower Bound Kaolite May 2004"

	FEA node	Diameter at 90° (in.)	Diameter at 180° (in.)	Equivalent circular diameter (in.)
Composite	103012/098194	22.00	15.60	18.56
Pre-test drum	-	18.37	18.37	
Pre-test, close-pack	-	17.08	17.08	
Composite, close-pack	103012/098194	-	-	17.26

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Appendix 6.9.3
Package Material Compositions

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Appendix 6.9.3
Package Material Compositions

Table 6.4 (Sect. 6.3.2) provides basic information for deriving the compositions for the ES-3100 package (Figs. 6.1 and 6.2). The atomic densities presented in Table 6.4 can be verified using additional information provided in Appendix 6.9.5. The following sections provide the rationale, the justification, or both for the material compositions used in the criticality calculations.

6.9.3.1 HEU, Unirradiated TRIGA, and Research Reactor Related Contents

HEU considered for shipment in the ES-3100 is categorized into the following material forms: highly enriched uranium (HEU) solid or broken metal; HEU oxide; uranyl nitrate hexahydrate (UNH) crystals. In the interest of adding conservatism, uranium is modeled as ^{235}U and ^{238}U, while the ^{234}U and ^{236}U isotopes are excluded. Any positive change in neutron multiplication represented by the presence of the ^{234}U is covered by the higher than actual ^{235}U content (Rothe). The theoretical density of 100 wt % ^{235}U HEU is 18.8111 g/cm^3. This value is determined by adjusting the density of natural uranium included in the SCALE Standard Composition Library with 100 wt % weight factors. The theoretical density of HEU oxide types are 10.96 g/cm^3 for UO_2, 8.30 g/cm^3 for U_3O_8, and 7.29 g/cm^3 for UO_3. The theoretical density of UNH crystals is 2.79 g/cm^3. Table 6.9.3.1-1 provides details of the calculated weight percentages input to KENO V.a calculated on the basis of the stoichiometric formula of $UO_2(NO_3)_2+6H_2O$ and crystalline density. The maximum enrichment considered in the analysis is 100 wt % ^{235}U, although actual material enrichments are lower. The unirradiated solid form TRIGA fuel is uranium zirconium hydride ($UZrH_x$) where "x" is ≤ 2, having a density of 8.65 g/cm^3. Research reactor related contents are fuel elements or fuel components, broken metal, U-Al alloy, or oxides. These contents are described at the end of this subsection.

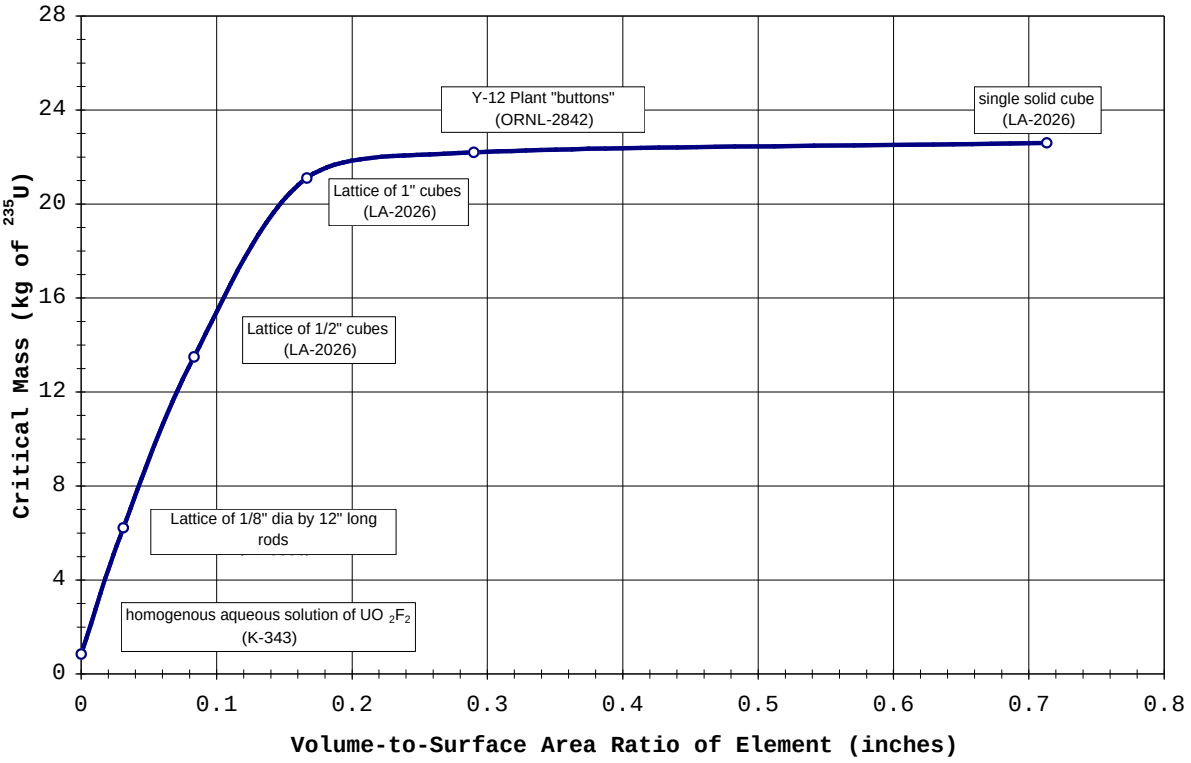
Table 6.9.3.1-1. Calculation of constituent weight-percentage values for uranyl nitrate hexahydrate crystals used in KENO V.a calculation models

Avogadro No. (N_o)	6.0221370E+23					
UNH						
$UO_2(NO_3)_2+6H_2O$	Atoms/Molecule	At. wt [a]	Mole. wt.	wt %	calc. Ni	NiAi
Hydrogen	12	1.0078	12.0936	2.4233	4.0401E+22	4.0716E+22
Nitrogen	2	14.0031	28.0062	5.6117	6.7333E+21	9.4286E+22
Oxygen	14	15.9949	223.9286	44.8690	4.7132E+22	7.5388E+23
U-235		235.0441		100.0000		
U-238		238.0510		0.0000		
Uranium	1	235.0441	235.0441	47.0962	3.3666E+21	7.9130E+23
			499.0725	100.0002		
summations				100.0002	9.7633E+22	1.6802E+24
At. wt. material						
assumed density	2.7900					
den.=($\sum N_iA_i$)/N_o						2.7900

[a] Source: Nuclides and Isotopes, Chart of the Nuclides, 14th ed., General Electric Company, 1989.

HEU broken metal. The critical mass of fissile material is dependent on factors such as the form and shape of the material, bulk density if the material is broken into pieces, and the enrichment. Broken metal can be compared to the minimum critical mass of submerged metal lattices of regular-shaped fissile material. Using experimental data, the approximation of a heterogeneous mixture of fissile material and moderator to a homogeneous mixture is justified as follows.

Figure 6.9.3.1-1 depicts the experimentally determined minimum critical mass of U (~ 94) lattices immersed in water as a function of the volume-to-surface area ratio of the fissile element (TID-7028). The critical mass is shown to increase from 850 g to 21 kg over the range of volume-to-surface ratios from 0 to 0.18 in. The critical mass is nearly constant in the range of volume-to-surface ratios from 0.18 to 0.8 in. For pieces greater than 1-in. cubes, the minimum critical mass will not be less than 21 kg. For smaller pieces, the minimum critical mass is a nearly linear function of the volume-to-surface-area ratio of the fissile element.

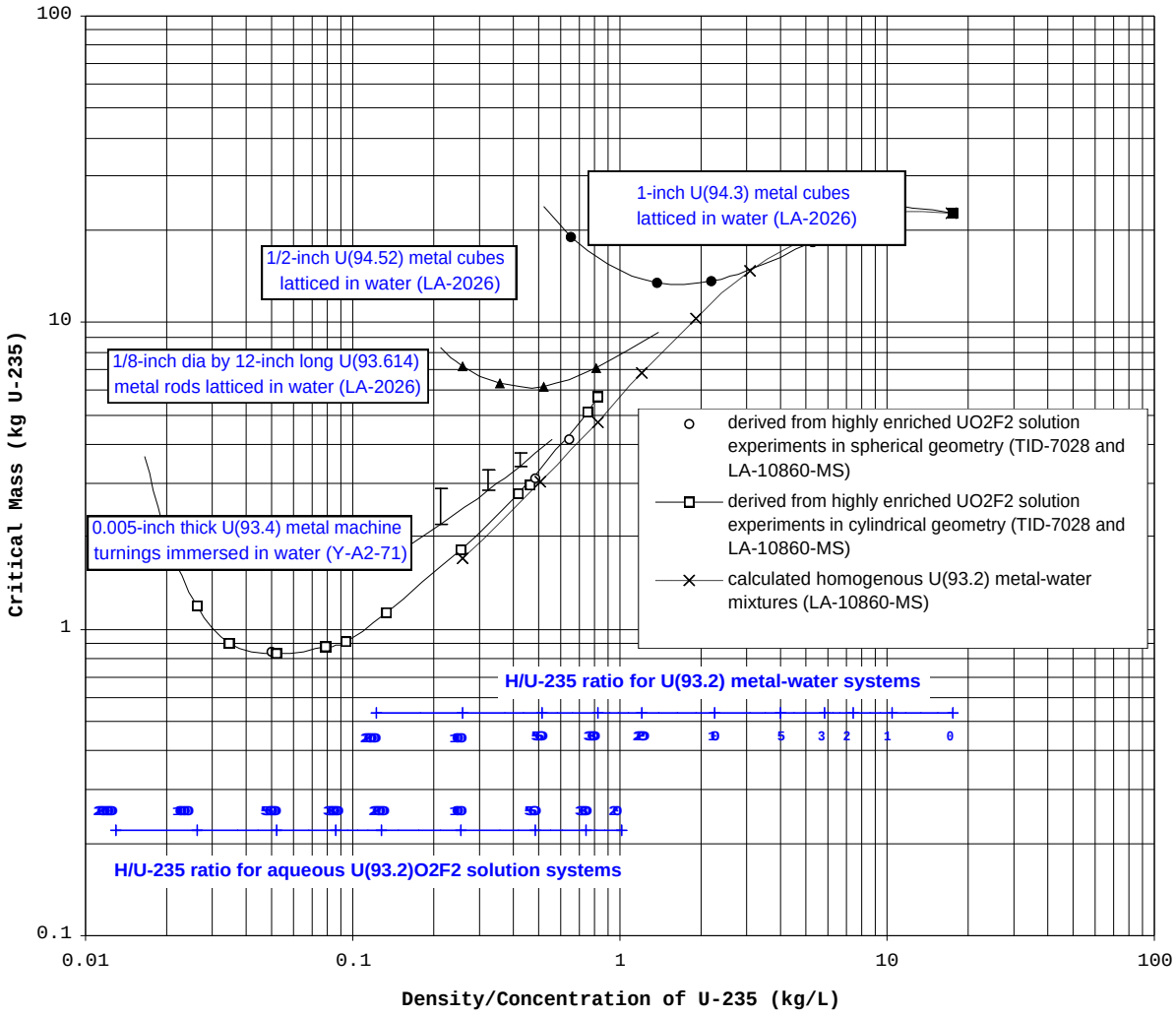


Source: H. C. Paxton et al., *Critical Dimensions of Systems Containing 235U,* TID-7028, Los Alamos Scientific Lab. and Oak Ridge Natl. Lab., June 1964, Fig. 19. Y-12 data have been added.

Fig. 6.9.3.1-1. Experimentally determined minimum critical mass U(~94) metal lattices immersed in water as a function of volume-to-surface area ratio of fissile material.

Figure 6.9.3.1-2 depicts the experimentally determined minimum critical mass of U (~ 94) metal water and solution systems as a function of the concentration of ^{235}U. The figure with added data reveals that: (1) a minimum critical mass exists for each metal lattice system plotted, and (2) as the bulk density of uranium or the uranium concentration increases, the curves for the critical mass of metal lattice systems converge with the curve for highly enriched solution experiments or the curve for calculated homogeneous metal water mixtures. Conversely stated, the critical mass is greater for a heterogenous system than for a homogeneous system, and this difference increases as the H/X ratio increases.

Therefore, the practice of approximating a heterogeneous mixture of fissile material and moderator as a homogeneous mixture is justifiable and also conservative at the higher H/X ratios.



Sources: A. W. Krass, *Survey of Experimental Data Concerning the Critical Mass of Highly Enriched Uranium–Water Systems*, CCG-365, Lockheed Martin Energy Systems, Inc., Oak Ridge Y-12 Plant, July 13, 2000, Fig. 1. Y-12 data added.

Fig. 6.9.3.1-2. Experimentally determined minimum critical mass of U(~94) metal water and solution systems as a function of the concentration of ^{235}U.

Approximating broken metal as a homogeneous mixture of uranium and water requires a defined space within which masses of the components are conserved. This space is generally characterized by a lattice constructed of unit cells and defined by the dimensions of the fissile material being approximated.

The broken HEU metal consists of large, irregular pieces ranging from 0.5 in. to several inches on a side as shown in Fig. 6.9.3.1-3. A lattice of cubes is chosen to represent broken metal inside the ES-3100 CV. Due to the constraints of KENO V.a, an idealized configuration is defined by a square lattice circumscribed by the inner wall of the CV. Water fills the truncated cylindrical regions between the inner wall of the CV and the vertical faces of the lattice. Two additional models are developed to evaluate conservatism at various stages of model approximations for broken metal.



Fig. 6.9.3.1-3. Pan of HEU broken metal.

Together, these models include an explicit arrangement of HEU metal cubes forming a compact rectangular lattice inside the CV, HEU metal homogeneously mixed with water within the rectangular lattice formed by the unit cells, and HEU metal homogeneously mixed with water within the volume of the CV.

Parameters varied in each of these three models include (1) the cube size in the explicit model from 1.0 in. to 0.25 in. on a side, (2) water moderation inside the CV from dry to the fully flooded condition, (3) enrichment from 100.0 wt % ^{235}U to 20.0 wt % ^{235}U, (4) thickness of the 277-4 canned spacers located between each convenience can, and (5) the mass of the uranium metal at each content location. One-quarter inch, 0.5-in., and 1.0-in. cubes are selected to evaluate "approach-to-homogeneity" of broken metal in this idealized form. The corresponding array configurations for 0.25-in., 0.5-in., and 1.0-in. cubes are 12 × 12 × N, 6 × 6 × N, and 3 × 3 × N. The N-th layer of unit cells for a given mass loading may not all contain HEU metal; the empty cells are filled with water. Nevertheless, a slight variation still arises in the total mass of HEU metal between these array configurations given whole cubes are contained in the calculation models.

The results for the calculation models representing the various configurations of broken uranium metal are shown in the Table 6.9.3.1-2. As the explicitly modeled cubes become smaller in size, the calculated k_{eff} values for the explicit "sqa" models approach values for the "lha" models where HEU metal cubes are homogenized with water within the rectangular lattice formed by the unit cells of the array. A representative or converged k_{eff} value is 0.87 for increasing by smaller cubes based on calculation results for the "lha" models. The "lha" results indicate a slight difference between the k_{eff} values for the three array sizes; these differences are attributed to the difference in the HEU for the arrays of whole cubes.

Calculation results reveal that the explicit ("sqa") model of HEU broken metal in a water moderated lattice is bounded by the homogeneous mixture ("lha") model of HEU metal and water. Calculation results for the "cha" models, where arrays of cubes are fully homogenized with the water

Table 6.9.3.1-2. Summary for evaluation of HEU broken metal models (95 wt % ^{235}U) in a flooded containment vessel, 1.4-in. canned spacers and full water reflection of containment vessel

Array type	U (g)	^{235}U (g)	H_2O (g)	h/x	k_{eff}	σ	$k_{eff} + 2\sigma$
Discrete array of cubes ("sqa" cases)							
$3 \times 3 \times n$	35,164	33,406	7,719	6.03	0.8352	0.0012	0.84
$6 \times 6 \times n$	35,973	34,175	7,676	5.86	0.8559	0.0011	0.86
$12 \times 12 \times n$	35,988	34,188	7,765	5.86	0.8603	0.0012	0.86
Cubes homogenized within footprint of lattice ("lha" cases)							
$3 \times 3 \times n$	35,164	33,406	7,719	6.03	0.8586	0.0011	0.86
$6 \times 6 \times n$	35,973	34,175	7,675	5.86	0.8650	0.0012	0.87
$12 \times 12 \times n$	35,988	34,188	7,675	5.86	0.8677	0.0010	0.87
Cubes homogenized within containment vessel ("cha" cases)							
$3 \times 3 \times n$	35,164	33,406	7,719	6.03	0.9427	0.0013	0.95
$6 \times 6 \times n$	35,973	34,175	7,676	5.86	0.9495	0.0015	0.95
$12 \times 12 \times n$	35,988	34,188	7,675	5.86	0.9517	0.0016	0.95

for the flooded CV, indicate the highest k_{eff} values. The neutron multiplication factor jumps from 0.87 to 0.95. The "cha" model is deemed to be overly conservative when applied to broken metal for the following reasons:

- HEU metal does not dissolve in water.
- HEU metal is not in an oxide or powder form that will absorb moisture or readily mix and become homogenized with the water inside the flooded CV.
- Because HEU metal is much denser than water, it will not float and become distributed throughout a flooded CV; instead it will gravitate toward the bottom of the CV.

However, the "cha" model is deemed an appropriate content model for the criticality evaluation when applied to HEU metal powder where fissile uranium as particulate is more fully homogenized with water than large pieces of broken metal and where fissile uranium could be in suspension. For simplicity, the "cha" model is chosen to represent HEU broken metal or metal powder inside a flooded CV under full water reflection and as content in a single package or in arrays of packages under NCT and HAC. Details regarding the "sqa," "lha," and "cha" calculation models are presented in Appendix 6.9.1.

HEU Oxide. Theoretical (crystalline) densities for HEU oxide are 10.96 g/cm^3, 8.30 g/cm^3, and 7.29 g/cm^3 for UO_2, U_3O_8, and UO_3, respectively. While bulk densities of product oxides with enrichments ranging from 19 to 100 wt % ^{235}U are typically on the order of 6.54 g/cm^3, the bulk density of HEU oxides considered for shipment in the ES-3100 ranges from 2.0 to 6.54 g/cm^3. Therefore, only less-than-theoretical mass loadings would actually be achieved. Skull oxides are a mixture of graphite and U_3O_8 with densities on the order of 2.44 g/cm^3 for poured material and 2.78 g/cm^3 for tapped material. The combined water saturation and crystallization of the HEU oxide are not expected in the HAC, given that UO_2 and UO_3 are non-hygroscopic, while U_3O_8 is only mildly hygroscopic. Table 6.9.3.1-3 provides summary data for 292 samples of canned skull oxide.

Table 6.9.3.1-3. Summary data for 292 samples of skull oxide

Statistic	wt % U	wt % ^{235}U	µg C/g U	µg C /g ^{235}U	Net wt (g)	U wt (g)	^{235}U wt (g)
Maximum	84.52	93.19	171,000	252,861	**7,072**	5,938	4,165
Minimum	12.93	20.28	13	17	442	312	221
Median	81.66	37.62	5,590	13,910	4,448	3,541	1,414
Mean	79.64	45.02	16,968	41,333	4,419	3,532	1,563
Std. dev.	6.87	16.40	24,304	59,027	745	698	606

Values of wt % U, wt % ^{235}U, µg C/g U, etc. for a given statistic (maximum, minimum, medium, or mean) do not occur simultaneously in a specific sample. Inspection of sample data reveals the following characteristics:

(1) the fissile material content is ≤ 221 g ^{235}U in samples with concentrations up to 252,861 µg C/g^{235}U,
(2) the enrichment is 93.2 wt % ^{235}U for samples with concentrations in the range of 12,600 to 18,600 µg C/gU,
(3) the enrichment ranges from 60 to 70.2 wt % ^{235}U for samples with concentrations in the range of 3,231 to 87,720 µg C/gU, and
(4) the enrichment ranges from 37 to 38 wt % ^{235}U for samples with concentrations in the range of 400 to 233,366 µg C/gU.

Eight skull oxide compositions representative of 292 samples of canned skull oxide were selected for establishing the bounding content calculation models. The skull oxide content is assumed to be U_3O_8 plus graphite, polyethylene, and unidentified material. Two additional compositions were derived for addressing skull oxides with an enrichment of 93.2 wt % ^{235}U where unidentified material is treated as ^{235}U and the carbon content is either maximized or minimized. Treatment of the unidentified material as fissile material in the criticality analysis assures that its presence in skull oxide does not increase reactivity beyond what is considered in the bounding analysis.

The composition of the skull oxide content is given in terms of the following parameters: the grams skull oxide content in a content can (**gramskul**), the content bulk density (**densoc**), the wt % uranium in skull oxide content (**wtpuskul**), the wt % ^{235}U in uranium (**wtpu25u**), and the grams of graphite in the content can (**gramg**). Values for the content specification parameters are provided in Table 6.9.3.1-3b.

Table 6.9.3.1-3b. Content specification parameters for skull oxide content

Content	gramskul (g)	densoc (g/cm^3)	wtpuskul (wt %)	wtpu25u (wt %)	gramg (g)
sk_01	3863	1.899	58.92	69.78	139
sk_02	4978	2.447	66.15	69.42	168
sk_03	4607	1.981	72.77	69.88	124
sk_04	5082	2.186	82.77	70.07	20
sk_05	7072	3.042	83.97	69.91	9
sk_06	5037	2.476	72.53	37.61	307
sk_07	4385	2.156	75.15	37.55	203
sk_08	4550	2.237	72.57	37.73	87
sk_09	7100	3.054	78.95	93.20	307
sk_10	7100	3.054	82.61	93.20	1.0E-05

The information in Table 6.9.3.1-3c is derived from the content specification parameters of Table 1-3b on the assumption that 513 g of polyethylene is present in the skull oxide content in three content locations inside the CV.

The amount of skull oxide content (Column 2, Table 6.9.3.1-3c) is **gsoc** = 3.0 × **gramskul**.

The amount of uranium in the skull oxide content (Column 6, Table 6.9.3.1-3c) is **gusoc** = **gsoc** × **wtpuskul** / 100.0.

The amount of ^{235}U (Column 7, Table 6.9.3.1-3c) is **gr235** = **gusoc** × **wtpu25u** / 100.0.

The amount of graphite in the skull oxide content (Column 8, Table 6.9.3.1-3c) is **ggsoc** = 3.0 × **gramg**.

The micrograms graphite per gram uranium in skull oxide content (Column 9, Table 6.9.3.1-3c) is **mggraphgu** = **ggsoc** × 1.0e6 / **gusoc**.

The amount of U_3O_8 in the skull oxide content (**guox**) [Column 3, Table 6.9.3.1-3c] is **guox** = **gusoc** / **wtpuuox**,

where **gusoc** (Column 6, Table 6.9.3.1-3c),
wtpuuox is the weight percent uranium in uranium oxide, and
wtpuuox = **mwu** / (**mwu** + **mwo**),

where **mwu** = (3){(235.0441 × wtpu25u) + [238.0510 × (100 − wtpu25u)]} /100.0 and
mwo = (8)(15.9949).

The amount of unidentified material in skull oxide content (**gramunid**) [Column 12, Table 6.9.3.1-3c] is **gramunid** = (**gsoc** − **guox** − **ggsoc** − **grampoly**)

Skull oxide content is assumed to be saturated with water. The amount of saturation moisture (**gmsatm**) [Column 4, Table 6.9.3.1-3c] is **gmsatm** = 0.9982 × **volsatm**,

where **volsatm** is the volume of saturation moisture in the skull oxide content and
volsatm = **vsox** − **volminsox**

The volume of skull oxide (**vsox**) in the CV is **vsox** = (**gsoc** / **densoc**) − (**grampoly** / **denpoly**),

where **gsoc** (Column 2, Table 6.9.3.1-3c),
densoc is the bulk density of skull oxide content,
grampoly is the 513 g of polyethylene, and
denpoly is the density of polyethylene, 0.92 g/cm^3.

The minimum volume of skull oxide (**volminsox**) in the CV is **volminsox** = (**gsoc** − **grampoly** − **gramunid**) / **dnsoxtheo**,

where **gsoc** (Column 2, Table 6.9.3.1-3c),
grampoly (513 g),
gramunid (Column 12, Table 6.9.3.1-3c), and
dnsoxtheo is the theoretical density of skull oxide.

Table 6.9.3.1-3c. Canned skull oxide (SO) content for ES-3100 calculation models, assuming 513 g polyethylene present and can spacers absent.

Content	SO (g)	UO_x (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	µg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)
sk_01	11,589	8,063	4,468	28.09	6,828	4,765	417	87,518	4,105	50.58	2,596 [a]
sk_02	14,934	11,665	4,015	17.79	9,879	6,858	504	73,492	4,105	33.41	2,252 [a]
sk_03	13,821	11,876	4,893	20.62	10,058	7,028	372	52,930	3,233	32.62	1,060 [a]
sk_04	15,246	14,900	4,599	15.52	12,619	8,842	60	6,786	3,235	25.07	-227 [b]
sk_05	21,216	21,036	3,869	9.49	17,815	12,455	27	2,168	3,235	16.27	-360 [b]
sk_06	15,111	12,933	3,765	28.02	10,960	4,122	921	223,432	4,105	54.01	744 [a]
sk_07	13,155	11,666	3,989	32.68	9,886	3,712	609	164,054	4,106	61.55	367 [a]
sk_08	13,650	11,689	4,068	33.01	9,906	3,737	261	69,834	4,106	61.69	1,187 [a]
sk_09	21,300	19,865	3,801	7.43	16,816	15,673	921	58,764	3,235	12.82	1
sk_10	21,300	20,786	3,905	7.27	17,596	16,399	0	0	3,235	12.41	1

[a] Positive value specifies grams of miscellaneous neutron-absorber elements in content, modeled as water.
[b] Negative value specifies grams of excess polyethylene included in the content model.

The theoretical density of skull oxide (**dnsoxtheo**) is **dnsoxtheo** = (**ggsoc** + **guox**) / [(**ggsoc** / **dnctheo**) + (**guox** / **dnuoxtheo**)],

where **ggsoc** (Column 8, Table 6.9.3.1-3c),
guox (Column 3, Table 6.9.3.1-3c),
dnuoxtheo is the theoretical density of U_3O_8, 8.3 g/cm^3, and
dnctheo is the theoretical density of graphite, 4.2 g/cm^3.

The hydrogen to fissile uranium ratio of canned skull (Column 5, Table 6.9.3.1-3c) is **sochtox** = {[(**gmsatm** × **wtphwat**) + (**grampoly** × **wtphpoly**)] × **atwu25**} / (**gr235** × **atwth** × 100.0),

where **gmsatm** (Column 4, Table 6.9.3.1-3c),
wtphwat is the weight percent hydrogen in water, 11.1913%,
grampoly (513 g),
wtphpoly is the weight percent hydrogen in polyethylene, 14.3811%,
atwu25 is the atomic weight of ^{235}U, 235.0441,
gr235 (Column 7, Table 6.9.3.1-3c), and
atwth is the atomic weight of hydrogen, 1.0078.

The amount of water in the voided region of the CV (Column 10, Table 6.9.3.1-3c) is **gwatcv** = 0.9982 × **volvcv**,

where **volvcv** is the void volume of the CV and
volvcv = (**cvarea** × **cvih**) − (**gsoc** / **densoc**),

where **cvarea** is the internal area (129.73536 cm^2) of the CV,
cvih is the internal height (78.74 cm),
gsoc (Column 2, Table 6.9.3.1-3c), and
densoc (Table 6.9.3.1-3b).

The hydrogen to fissile uranium ratio inside the CV (Column 11, Table 6.9.3.1-3c) is
htox = ⟨{[(**gmsatm** + **gwatcv**) × **wtphwat**] + [**grampoly** × **wtphpoly**]}
× **atwu25**⟩ / (**gr235** × **atwth** × 100.0),

where **gmsatm** (Column 4, Table 6.9.3.1-3c),
gwatcv is the amount of water in the voided region of CV,
wtphwat is the weight percent hydrogen in water, 11.1913%,
grampoly (513 g),
wtphpoly is the weight percent hydrogen in polyethylene, 14.3811%,
atwu25 is the atomic weight of ^{235}U, 235.0441,
gr235 (Column 7, Table 6.9.3.1-3c), and
atwth is the atomic weight of hydrogen, 1.0078.

Unirradiated TRIGA reactor fuel. TRIGA fuel is uranium zirconium hydride ($UZrH_x$), an alloy of uranium metal homogeneously dispersed as fine particles in a zirconium hydride matrix. The fuel is stable because uranium hydride does not form to any considerable extent. Moreover, uranium hydride has never been detected in the photomicrographic evaluations of TRIGA fuel.

The General Atomics catalog of stock items lists ~40 TRIGA fuel elements classified into four basic types: standard element, instrumented element, fuel-follower control rod, or cluster assembly. The TRIGA element active fuel region consists of three 5-in long sections "fuel meats" of $UZrH_x$. The H/Z atom ratio "x" in $UZrH_x$ equals 1.6 in all cases except for two stock items. For these cases, x = equals 1.0 and the fissile content is < 40 g ^{235}U. The unirradiated solid form TRIGA fuel is identified as either 20 % enriched or 70 % enriched, and has dimensions and material properties specific to its design function.

The fuel diameter for the 20 % enriched TRIGA elements is either 1.44 in., 1.41 in., 1.40 in., 1.37 in., 1.34 in., or 1.31 in. The uranium composition of the fuel is 45 wt %, 30 wt %, 20 wt %, 12 wt %, and 8.5 wt %. As illustrated in Table 6.9.3.1.4-a, the TRIGA element with a maximum fissile content of 307 g ^{235}U in 1,560 g U, 45 wt % U in $UZrH_x$, and a H/Zr atom ratio of 1.6 has a computed fuel density of ~8.66 g/cm^3. The calculated number density (N_i) for each element or isotope is also given. The TRIGA fuel element with a fuel diameter of 1.44 in. contains 3,466.7 g $UZrH_x$. Further evaluation of the manufacturers data reveals that fuel density is proportional to the uranium weight fraction. Calculated density values are: 8.6597 g/cm^3 for 45 wt % U in $UZrH_x$, 6.8995 g/cm^3 for 30 wt % U in $UZrH_x$, 6.2825 g/cm^3 for 20 wt % U in $UZrH_x$, 5.9328 g/cm^3 for 12 wt % U in $UZrH_x$, and 5.7895 g/cm^3 for 8.5 wt % U in $UZrH_x$.

The active fuel diameter for 70 % enriched TRIGA fuel is 1.44 in. in both the standard element and instrumented element, and 1.31 in. in the fuel follower control rod. The uranium composition of the fuel is 8.5 wt %. The standard element and instrumented elements contain ~136 g ^{235}U in 194 g U, while the fuel follower control rod contains ~113 g ^{235}U in 162 g U. As the calculation in Table 6.9.3.1.4-b illustrates, the 70 wt % enriched TRIGA fuel has a computed density of ~5.70 g/cm^3. The TRIGA fuel element with a fuel diameter of 1.44 in. contains 2,282.4 g $UZrH_x$, while the element with a fuel diameter of 1.31 in. contains 1,888.9 g $UZrH_x$.

The clad thickness is ~0.02 in. for a TRIGA fuel element with stainless steel cladding and ~0.03 in. for an element with aluminum cladding. In preparation for shipment in the ES-3100, a TRIGA fuel element is disassembled, the fuel meats are removed from the thin cladding and packed into convenience cans.

Table 6.9.3.1-4a. Calculation of constituent weight-percentage values for 20 wt % enriched uranium-zirconium hydride content in KENO V.a calculation models

Avogadro No. (N_o) =	6.0221370E+23						
U(ZrH$_x$) atom	**wt %**	**x**	**mass (g)**	**at. wt.**		**calc. N_i**	**N_iA_i**
Hydrogen	0.9554	1.6		1.00780	1.6125	4.9439E+22	4.9824E+22
Zirconium	54.0447	1		91.21960	91.2196	3.0897E+22	2.8184E+24
u-235	19.6795		307.0	235.04410			
u-238	80.3205			238.05099			
uranium	45.0000		1560.0	237.45318	75.9535	9.8830E+21	2.3468E+24
	100.0001				168.7856		
summations	100.0001					9.0219E+22	5.2150E+24
At. wt molecule							
Volume (cm^3)	400.3200						
Mass (g)	3466.66667						
density (g/cm^3)	8.65974						
den.=($\sum N_iA_i)/N_o$							8.6597

Table 6.9.3.1-4b. Calculation of constituent weight-percentage values for 70 wt % enriched uranium-zirconium hydride content in KENO V.a calculation models

Avogadro No. (N_o) =	6.0221370E+23						
U(ZrH$_x$) atom	**wt %**	**x**	**mass (g)**	**at. wt**		**calc. N_i**	**N_iA_i**
Hydrogen	1.5894	1.6		1.00780	1.6125	5.4148E+22	5.4571E+22
Zirconium	89.9107	1		91.21960	91.2196	3.3841E+22	3.0870E+24
u-235	70.1031		136.0	235.04410			
u-238	29.8969			238.05099			
uranium	8.5000		194.0	235.93508	8.6237	1.2370E+21	2.9184E+23
	100.0001				101.4558		
summations	100.0001					8.9227E+22	3.4334E+24
At. wt molecule							
Volume (cm^3)	400.3200						
Mass (g)	2282.35294						
density (g/cm^3)	5.70132						
den.=($\sum N_iA_i)/N_o$							5.7013

The TRIGA fuel may also be configured as clad fuel rods. Each clad fuel rod will be derived from a single TRIGA fuel element by removal of the stainless steel or aluminum clad extending beyond the plenum adjacent to the axial ends of the active fuel section. Each ~15-in.-long rod consists of the 3 fuel pellets and an

exterior sheath of stainless steel or aluminum clad, where the protruding clad at each end has been crimped in. The fuel rods will be packed into stainless steel or tin-plated carbon steel convenience cans, with a maximum of three fuel rods per loaded convenience can. This shipping configuration requires a minimum of two convenience cans; where only one convenience can is loaded with clad fuel rods. The loaded can is 17.5-in. tall, while the empty one is 8.75-in. tall. Although can spacers are not required for criticality control, can spacers or stainless steel pads may be used to take up free volume over the 31 in. internal height of the CV. The maximum quantity of fissile material per package is 408 g ^{235}U.

The clad fuel rod with 1.44-in.-diam fuel pellets contains 2,282.4-g $UZrH_x$, while rod with the 1.31-in.-diam fuel pellets contains 1,888.9-g $UZrH_x$. The 0.02-in.-thick sheath of stainless steel clad adds ~179 g to the mass of the active fuel for the 1.48-in.-diam standard element or instrumented element, and ~163 g to active fuel mass for the 1.35-in.-diam fuel follower control rod. Allowance for ½ in. of residual stainless steel crimped on each end of the clad fuel rod adds ~11–12-g stainless steel to these amounts. Likewise, the 0.03 in thick sheath of aluminum clad adds ~90 g to the mass of the active fuel for the 1.47-in.-diam standard element or instrumented element. Allowance for ½ in. of residual aluminum crimped on each end of the clad fuel rod adds ~6-g aluminum.

Research reactor fuel elements or fuel components are composed of U-Al, U_3O_8-Al, or UO_2-Mg. These items contain small quantities of fissile uranium typically ranging from 4.2–152-g ^{235}U. The maximum enrichment is ~93%. Components are of various solid shapes (rods, square bars, plates, or tubes) where diameters typically range from 0.18 to 4.0 in. and cross-sections typically range from 0.05 × 1.28 in. for an individual piece and 3.14 × 3.0 in. for an assembly of pieces. The active length for the various solid shapes ranges from 19.7 to 24 in.

U_3O_8-Al fuel elements are evaluated for demonstrating that research reactor related oxide contents are bounded by limits specified for TRIGA content. An aluminum-clad THAR plate (0.224 × 7.23 × 60.96 cm) contains ~101.52212 g of uranium and the enrichment is 20% ^{235}U. Table 6.9.3.1-4c presents the calculation of density values at enrichments of 20%, 70%, and 93.2% ^{235}U using plate dimensions, uranium mass, and theoretical density values of 8.3 g/cm^3 for U_3O_8 and 2.702 g/cm^3 for aluminum.

Table 6.9.3.1-4c. Calculation of constituent weight-percentage and content density values for 20 wt %, 70 wt %, and 93.2 wt % enriched uranium oxide-aluminum content in KENO V.a calculation models [a]

	Plate dimension	(cm)	Element	at. wt.	wt %	Density (g/cm^3)	Mass (g)	
	thickness	0.224	Al	26.9818	100	2.702	-	
	width	7.230	U_3O_8	variable	100	8.3	-	
	length	60.960	U	-	-	-	101.52212	

Isotope	at. wt.	wt %	Isotope	at. wt.	wt %	Isotope	at. wt.	wt %
^{235}U	235.0442	20.0	^{235}U	235.0442	70.0	^{235}U	235.0442	93.2
^{238}U	238.0510	80.0	^{238}U	238.0510	30.0	^{238}U	238.0510	6.8
U	237.4435	84.77161	U	235.9382	84.68933	U	235.2463	84.65121
O	15.9954	15.22839	O	15.9954	15.31067	O	15.9954	15.34879
U_3O_8	840.2937	100.0	U_3O_8	835.7779	100.0	U_3O_8	833.7020	100.0

Enrichment (%)	U_3O_8 (g)	Vol $_{U3O8}$ (cm^3)	Vol $_{Al}$ (cm^3)	Vol $_{Total}$ (cm^3)	Al (g)	wt % $_{U3O8}$	wt % $_{Al}$	Density (g/cm^3)
20	119.75958	14.42886	84.29707	98.72594	227.77069	34.46019	65.53981	3.52015
70	119.87593	14.44288	84.28306	98.72594	227.73282	34.48588	65.51412	3.52095
93.2	119.92992	14.44939	84.27655	98.72594	227.71524	34.49780	65.50220	3.52132

[a] Actual material at 20% enrichment, hypothetical materials at 70% and 93.2% enrichments.

A UO_2-Mg fuel element is evaluated for demonstrating that this form of research reactor related content is also bounded by limits specified for TRIGA content. An aluminum-clad EK-10 fuel rod (2.54 cm diameter and 139.7 cm length) contains ~92.35 g of uranium dioxide, 13.03 g of magnesium and 65.7 g of aluminum as cladding. The ^{235}U content is 8.05 g with a corresponding enrichment of 9.89%. Table 6.9.3.1-4d presents the calculation of density values at enrichments of 9.89%, 20%, and 93.2% ^{235}U using rod dimensions, material masses and theoretical density values of 10.96 g/cm^3 for UO_2 and 2.702 g/cm^3 for aluminum. For UO_2 content at 93.2% ^{235}U, an oxide density of 6.54 g/cm^3 is assumed consistent with bulk densities observed for product oxides with enrichments ranging from 19–100 wt % ^{235}U.

Table 6.9.3.1-4d. Calculation of constituent weight-percentage and content density values used in KENO V.a calculation models for 9.89 wt %, 20 wt %, and 93.2 wt % enriched uranium dioxide-magnesium, aluminum clad content, and for 93.2 wt % enriched uranium dioxide content [a]

		UO_2-Mg				Active	Overall	UO_2	
				Diam (cm)		0.69017	1.00000		
				Length (cm)		50.50000	55.00000		
				Vol (cm^3)		11.85982	43.19690		
		9.88 wt % ^{235}U		20 wt % ^{235}U		93.2 wt % ^{235}U		93.2 wt % ^{235}U	
	at. wt.	wt %	Mass (g)	wt %	Mass (g)	wt %	Mass (g)	wt %	Mass (g)
^{235}U	235.04420	9.88943	8.050	20.00000	16.280	93.20000	75.865	93.20000	408.000
^{238}U	238.05100	90.11057	73.350	80.00000	65.120	6.80000	5.535	6.80000	29.768
U	237.75020	88.14018	81.400	88.12668	81.400	88.02906	81.400	88.02906	437.767
O	15.99540	11.85982	10.953	11.87332	10.967	11.97094	11.069	11.97094	59.531
UO_2	269.74100		92.353		92.367		92.469		497.298
Mg	24.30480	100.00	13.030	100.00	13.030	100.00	13.030	-	-
Al	26.98180	100.00	65.670	100.00	65.670	100.00	65.670	-	-
Total			**171.053**		**171.067**		**171.169**		**497.298**
wt % U		47.58759		47.58369		47.55534		88.02906	
wt % O		6.40328		6.41096		6.46671		11.97094	
wt % Mg		7.61752		7.61690		7.61236		-	
wt % Al		38.39161		38.38846		38.36559		-	
Density (g/cm^3)		3.95984		3.96017		2.60651		6.95000	

[a] "per rod" values cited for UO_2-Mg. Actual material at 9.9% enrichment, hypothetical materials at 20% and 93.2% enrichments. Bulk values cited for UO_2.

6.9.3.2 Type 304 Stainless Steel

The metallic components of the ES-3100 package are composed of Type 304 stainless steel. These include the CV, the convenience cans, the drum liner, and the drum. Type 304 stainless steel with a density of 7.9400 g/cm^3 is included as a material in the SCALE Standard Composition Library.

6.9.3.3 277-4 Neutron Absorber

Catalog No. 277-0 dry mix is a proprietary mixture for producing a heat-resistant shielding material which combines the most effective shielding components into a single homogeneous composite. The shielding composite material is designed to maximize the hydrogen content necessary for thermalizing fast neutrons for capture in the boron constituent. Widely used in nuclear power plant

applications, the heat-resistant shielding material is capable of retaining a significant portion of its shielding properties up to 230°C (450°F). The recommended operating limit is 350°F, which is well above HAC temperatures expected inside the body weldment liner inner cavity and canned spacers.

The 277-4 neutron-absorber material used in the ES-3100 is a formulation of Cat 277-0 dry mix, a boron carbide additive, and water. 277-4 is produced through a quality-controlled batch process of dry blending, wet mixing, vibration casting, and timed cure (Equipment Specification JS-YMN3-801580-A005, Appendix 1.3.5). "Loss on drying" (LOD) tests are used to measure the amount of water in the as-manufactured 277-4 casting. The as-manufactured 277-4 at 100 lb/ft^3 and 31.8 % LOD has a hydrogen concentration of 3.56 wt % and a natural boron concentration of 4.359 wt % (DAC-PKG-801624-A001, Table 5).

The ability of 277-4 to perform its function depends upon the masses of hydrogen and ^{10}B locked inside the high alumina borated cement cast into the body weldment liner inner cavity and the spacer cans. A calculated amount of boron carbide is added to Cat 277-0 dry mix for producing as-manufactured 277-4 material with a volumetric isotopic concentration >7.621×10^{20} at/cm^3 of ^{10}B. The additive is boron carbide (B_4C) with small amount of a frit-like compound and trace amounts of unaccounted elements (0.17 wt %). Boron carbide has a theoretical density from 2.45 to 2.52 g/cm^3. 277-4 contains a large amount of hydrated alumina, also known as aluminum trihydrate [$Al(OH)_3$]. It is a nonabrasive powder with a specific gravity of 2.42. Given that both materials are of like density and similar particle size, separation and in homogeneity of 277-4 material is not expected during the controlled vibration casting process.

Table 6.9.3.3-1 provides detailed elemental composition data derived for as-manufactured neutron-absorber material at 100 lb/ft^3 and 31.8% LOD. This material description allows for clear specification of reduced boron and water contents required in the evaluation of NCT and HAC. As shown in Table 6.9.3.3-1, both the water and boron components are extracted from the material specification for the neutron absorber, and the constituent weight percents are recalculated accordingly (green box). 277-4 is specified in KENO V.a as three arbitrary materials: **arbmnpmx** with a density of 1.02276 g/cm^3, **arbmnph2o** with a density of 0.509253 g/cm^3, and **arbmboron** with a density of 6.98257E-02 g/cm^3. Model densities for 277-4 inside the body weldment liner inner cavity are reduced by a factor of 0.966893 to account for a material gap at the top of the liner. This material description allows for clear specification of reduced boron and water contents required in the evaluation of NCT and HAC.

The testing of 277-4 reveals that the material will dehydrate at elevated temperatures. Test specimens were dried at 250°F for 168 hours to reach the NCT state, and weight measurements were taken. These specimens where subsequently heated to 320°F for 4 hours to reach the HAC state, and weight measurements were again taken. The compositions of 277-4 at NCT and HAC states were derived by adjustment of the formulation specification for measured losses taking into account the statistical variations in the data. Conservation of mass for nonvolatile materials was observed in the derivation of material specifications based upon testing. Given that hydrogen must be present for the neutron absorber to be effective, conservative material specifications were derived for minimum hydrogen content and minimum material density.

Tables 6.9.3.3-2 and 6.9.3.3-3 respectively provide NCT and HAC composition data for as-manufactured 277-4 material at minimum density and hydrogen content. Respectively, Tables 6.9.3.3-4 and 6.9.3.3-5 provide NCT and HAC composition data or as-manufactured neutron-absorber material at minimum density and boron content. Because the amount of ^{10}B present in the neutron-absorber material is near saturation, a change in the hydrogen concentration has a major effect on the neutron multiplication factor, while a change in the amount of boron has a minor effect.

The neutron-absorbing material used in the ES-3100 Shipping Package will perform as analyzed. The analysis of 277-4 with criticality calculations is adequate in lieu of neutron transmission testing for the demonstration of acceptable performance by experimental means. Criticality calculations show boron content is adequate and k_{eff} is not dependent on absolute (microscopic) homogeneity. Geometry characteristics of the ES-3100 system preclude the need for uniformity in boron areal density as a prerequisite for criticality safety control. The neutron-absorbing material will be fabricated under strict quality control and accepted for use under an NQA-1 compliant quality assurance (QA) program. A QA-approved mixing process provides a method for creating an exact mix for the neutron absorber during ES-3100 fabrication. An important part of this QA-approved process is a 277-4 material verification and acceptance testing program. The following discussion elaborates on these key points:

The analysis of 277-4 with criticality calculations is adequate in lieu of neutron transmission testing for the demonstration of acceptable performance. Early on in the licensing process, BoroBond 4 ™ was selected as the neutron-absorber material for use in the ES-3100 package. The decision to use BoroBond 4 ™ in the ES-3100 was made because of favorable experience with its use in the Highly Enriched Uranium Materials Facility Rackable Can Storage Box (RCSB). From an economic standpoint, however, BoroBond 4 ™ proved not to be a viable option for the small quantities needed for the ES-3100 project. 277-4 neutron-absorber material, which has very similar nuclear material properties to BoroBond 4 ™, was then selected as an alternative.

Both the RCSB and the ES-3100 are fast systems in the normal condition when the HEU fissile material is essentially unmoderated. A key factor for an effective neutron absorber is that hydrogen should be present for moderation, and it should be interspersed with ^{10}B, thus promoting neutron capture. The potential for neutron streaming through an absorber is significant when a hydrogenous moderator is absent, as in the case of an aluminum boron-carbide matrix (a Boral alloy).

BoroBond 4 is a ceramicrete material with slightly greater than 4 wt % boron carbide (B_4C). The boron carbide powder is micro encapsulated by the crystalline matrix of the ceramic; therefore, leaching out the boron is not feasible. In BoroBond 4, 100 wt % of the B_4C has a particle size <500 μm; 90 wt % of the other constituents range from <164 μm to <36 μm. Given the differences in particle size, the potential for separation in the mixing process is real.

Some of the questions regarding the use of 277-4 as a neutron poison in the ES-3100 were previously addressed regarding the use of BoroBond 4 in the RCSB. Radiography was performed on BoroBond 4 samples ranging in thickness from 1.0 to 1.5 in. Inspections revealed little or no visual differences, indicating uniformity of the BoroBond 4. For 277-4 where the B_4C grit is on the order of 100 μm, the potential for separation is reduced.

Table 6.9.3.3-1. Calculation of constituent weight-percentage values used in KENO V.a calculation models for as-manufactured 277-4 at minimum acceptable density and boron content

			arbmboron	arbmnpmx	arbmnph2o			arbmboron	arbmnpmx	arbmnph2o
31.8% LOD	At. wt	lb/ft^3	lb/ft^3	lb/ft^3	lb/ft^3		NID	wt %	wt %	wt %
H	1.0078	3.5579			3.5579	H	1001			11.1913%
B10	10.0129	0.7911	0.7911			B10	5010	18.1482%		
B11	11.0093	3.5680	3.5680			B11	5011	81.8518%		
C	12.0000	1.2251		1.2251		C	6012		1.9187%	
N	14.0031	0.0090		0.0090		N	7014		0.0141%	
O	15.9949	55.9620		27.7281	28.2339	O	8016		43.4275%	88.8087%
Na	22.9895	0.0750		0.0750		Na	11023		0.1175%	
Mg	24.3051	0.2156		0.2156		Mg	12000		0.3377%	
Al	26.9818	24.9306		24.9306		Al	13027		39.0461%	
Si	28.0853	1.5752		1.5752		Si	14000		2.4671%	
S	32.0636	0.1969		0.1969		S	16000		0.3084%	
Ca	40.0803	7.5553		7.5553		Ca	20000		11.8331%	
Fe	55.8447	0.3383		0.3383		Fe	24000		0.5298%	
Totals		100.0000	4.3591	63.8491	31.7918			100.00%	100.00%	100.00%
H_2O	18.0105									
density (g/cm^3)		1.601838E+00	6.982572E-02	1.022759E+00	5.092532E-01	spacer density (g/cm^3)	1.601838E+00	6.98257E-02	1.02276E+00	5.09253E-01
						liner density (g/cm^3)	1.548806E+00	6.75140E-02	9.88899E-01	4.92393E-01
						liner den. multiplier	0.966893			

Source: G. A. Byington, *Mixing Weights and Elemental Composition of 277-4 Neutron Poison Used in the ES-3100*, DAC-PKG-801624-A001, BWXT Y-12, Y-12 National Security Complex, Jan. 25, 2006, Table 5.

Table 6.9.3.3-2. Calculation of constituent weight-percentage values used in KENO V.a calculation models for NCT as-manufactured 277-4 at minimum density and hydrogen content

			arbmboron	arbmnpmx	arbmnph2o			**arbmboron**	**arbmnpmx**	**arbmnph2o**
	At. wt	lb/ft^3	lb/ft^3	lb/ft^3	lb/ft^3		**NID**	**wt %**	**wt %**	**wt %**
H	1.0078	2.6840			2.6840	H	1001			11.1913%
B10	10.0129	0.8282	0.8282			B10	5010	18.1479%		
B11	11.0093	3.7354	3.7354			B11	5011	81.8520%		
C	12.0000	1.2826		1.2826		C	6012		1.9189%	
N	14.0031	0.0094		0.0094		N	7014		0.0141%	
O	15.9949	50.3252		29.0262		O	8016		43.4251%	
O	15.9949				21.2990	O	8016			88.8087%
Na	22.9895	0.0785		0.0785		Na	11023		0.1174%	
Mg	24.3051	0.2258		0.2258		Mg	12000		0.3378%	
Al	26.9818	26.1004		26.1004		Al	13027		39.0479%	
Si	28.0853	1.6491		1.6491		Si	14000		2.4672%	
S	32.0636	0.2061		0.2061		S	16000		0.3083%	
Ca	40.0803	7.9098		7.9098		Ca	20000		11.8336%	
Fe	55.8447	0.3541		0.3541		Fe	24000		0.5298%	
Totals		95.3886	4.5636	66.8420	23.9830			100.00%	100.00%	100.00%
H_2O	18.0105									
density (g/cm^3)		1.527971E+00	7.310148E-02	1.070700E+00	3.841692E-01	spacer density (g/cm^3)	1.527971E+00	7.31015E-02	1.07070E+00	3.84169E-01
						liner density (g/cm^3)	1.477385E+00	7.06813E-02	1.03525E+00	3.71451E-01
						liner den. multiplier	0.966893			

Source: G. A. Byington, *Mixing Weights and Elemental Composition of 277-4 Neutron Poison Used in the ES-3100*, DAC-PKG-801624-A001, BWXT Y-12, Y-12 National Security Complex, Jan. 25, 2006, Table 11.

Table 6.9.3.3-3. Calculation of constituent weight-percentage values used in KENO V.a calculation models for HAC as-manufactured 277-4 at minimum density and hydrogen content

			arbmboron	arbmnpmx	arbmnph2o			**arbmboron**	**arbmnpmx**	**arbmnph2o**
	At. wt	lb/ft^3	lb/ft^3	lb/ft^3	lb/ft^3		**NID**	**wt %**	**wt %**	**wt %**
H	1.0078	2.6758			2.6758	H	1001			11.1913%
B10	10.0129	0.8282	0.8282			N10	5010	18.1479%		
B11	11.0093	3.7354	3.7354			N11	5011	81.8520%		
C	12.0000	1.2826		1.2826		V	6012		1.9188%	
N	14.0031	0.0094		0.0094		N	7014		0.0141%	
O	15.9949	50.2605		29.0265		O	8016		43.4254%	
O	15.9949				21.2340	O	8016			88.8087%
Na	22.9895	0.0785		0.0785		Na	11023		0.1174%	
Mg	24.3051	0.2258		0.2258		,g	12000		0.3378%	
Al	26.9818	26.1004		26.1004		Al	13027		39.0477%	
Si	28.0853	1.6491		1.6491		Si	14000		2.4671%	
S	32.0636	0.2061		0.2061		S	16000		0.3083%	
Ca	40.0803	7.9098		7.9098		Ca	20000		11.8335%	
Fe	55.8447	0.3541		0.3541		Fe	24000		0.5298%	
Totals		95.3157	4.5636	66.8423	23.9098			100.00%	100.00%	100.00%
H_2O	18.0105									
density (g/cm^3)		1.52680E+00	7.31015E-02	1.07071E+00	3.82995E-01	spacer density (g/cm^3)	1.52680E+00	7.31015E-02	1.07071E+00	3.82995E-01
						liner density (g/cm^3)	1.47626E+00	7.06813E-02	1.03526E+00	3.70316E-01
						liner den. multiplier	0.966893			

Source: G. A. Byington, *Mixing Weights and Elemental Composition of 277-4 Neutron Poison Used in the ES-3100*, DAC-PKG-801624-A001, BWXT Y-12, Y-12 National Security Complex, Jan. 25, 2006, Table 12.

Table 6.9.3.3-4. Calculation of constituent weight-percentage values used in KENO V.a calculation models for NCT as-manufactured 277-4 at minimum density and boron content

			arbmboron	arbmnpmx	arbmnph2o			arbmboron	arbmnpmx	arbmnph2o
	At. wt	lb/ft^3	lb/ft^3	lb/ft^3	lb/ft^3		**NID**	**wt %**	**wt %**	**wt %**
H	1.0078	2.9617			2.9617	H	1001			11.1913%
B10	10.0129	0.7911	0.7911			B10	5010	18.1482%		
B11	11.0093	3.5680	3.5680			B11	5011	81.8517%		
C	12.0000	1.2251		1.2251		C	6012		1.9188%	
N	14.0031	0.0090		0.0090		N	7014		0.0141%	
O	15.9949	51.2291		27.7264		O	8016		43.4260%	
O	15.9949				23.5027	O	8016			88.8087%
Na	22.9895	0.0750		0.0750		Na	11023		0.1175%	
Mg	24.3051	0.2156		0.2156		Mg	12000		0.3377%	
Al	26.9818	24.9306		24.9306		Al	13027		39.0472%	
Si	28.0853	1.5752		1.5752		Si	14000		2.4671%	
S	32.0636	0.1969		0.1969		S	16000		0.3084%	
Ca	40.0803	7.5553		7.5553		Ca	20000		11.8334%	
Fe	55.8447	0.3383		0.3383		Fe	24000		0.5299%	
Totals		94.6709	4.3591	63.8474	26.4644			100.00%	100.00%	100.00%
H_2O	18.0105									
density (g/cm^3)		1.516474E+00	6.982572E-02	1.022731E+00	4.239172E-01	spacer density (g/cm^3)	1.516474E+00	6.98257E-02	1.02273E+00	4.23917E-01
						liner density (g/cm^3)	1.466269E+00	6.75140E-02	9.88872E-01	4.09883E-01
						liner den. multiplier	0.966893			

Source: G. A. Byington, *Mixing Weights and Elemental Composition of 277-4 Neutron Poison Used in the ES-3100*, DAC-PKG-801624-A001, BWXT Y-12, Y-12 National Security Complex, Jan. 25, 2006, Table 13.

Table 6.9.3.3-5. Calculation of constituent weight-percentage values used in KENO V.a calculation models for HAC as-manufactured 277-4 at minimum density and boron content

			arbmboron	arbmnpmx	arbmnph2o			arbmboron	arbmnpmx	arbmnph2o
	At. wt	lb/ft^3	lb/ft^3	lb/ft^3	lb/ft^3		**NID**	**wt %**	**wt %**	**wt %**
H	1.0078	2.9524			2.9524	H	1001			11.1913%
B10	10.0129	0.7911	0.7911			B10	5010	18.1482%		
B11	11.0093	3.5680	3.5680			B11	5011	81.8517%		
C	12.0000	1.2251		1.2251		C	6012		1.9188%	
N	14.0031	0.0090		0.0090		N	7014		0.0141%	
O	15.9949	51.1551		27.7262		O	8016		43.4258%	
O	15.9949				23.4289	O	8016			88.8087%
Na	22.9895	0.0750		0.0750		Na	11023		0.1175%	
Mg	24.3051	0.2156		0.2156		Mg	12000		0.3377%	
Al	26.9818	24.9306		24.9306		Al	13027		39.0473%	
Si	28.0853	1.5752		1.5752		Si	14000		2.4671%	
S	32.0636	0.1969		0.1969		S	16000		0.3084%	
Ca	40.0803	7.5553		7.5553		Ca	20000		11.8334%	
Fe	55.8447	0.3383		0.3383		Fe	24000		0.5299%	
Totals		94.5876	4.3591	63.8472	26.3813			100.00%	100.00%	100.00%
H_2O	18.0105									
density (g/cm^3)		1.515140E+00	6.982572E-02	1.022728E+00	4.225861E-01	spacer density (g/cm^3)	1.515140E+00	6.98257E-02	1.02273E+00	4.22586E-01
						liner density (g/cm^3)	1.464979E+00	6.75140E-02	9.88869E-01	4.08596E-01
						liner den. multiplier	0.966893			

Source: G. A. Byington, *Mixing Weights and Elemental Composition of 277-4 Neutron Poison Used in the ES-3100*, DAC-PKG-801624-A001, BWXT Y-12, Y-12 National Security Complex, Jan. 25, 2006, Table 14.

Measurements from neutron transmission tests on BoroBond 4 ™ for determination of areal density indicated greater boron content than was physically present. This is due to the presence of elements besides the aluminum and boron (principally hydrogen, oxygen and other low and intermediate-Z elements). Given the similarity of 277-4 to BoroBond 4 ™ (a ceramic-cement composite shielding material, with a similar elemental composition, more uniform particle size, and the same boron content), the 75% credit for boron content applied in the ES-3100 criticality calculations is an adequate enough correction for the efficiency of the material.

Criticality calculations show boron content is adequate and k_{eff} is not dependent on absolute (microscopic) homogeneity. The boron concentration calculations presented here model an infinite array of ES-3100 packages with the boron concentration of Cat 277-4 uniformly varied inside the body weldment inner liner. While the Cat 277-4 described herein is an earlier formulation of the neutron-absorber material, the behavior characteristics being demonstrated for Cat 277-4 apply to the revised formulation, 277-4.

Credit for only 75% of the boron is taken in the specification of Cat 277-4. Each package in the array contains 2.774 kg of ^{235}U in broken metal form uniformly distributed inside the CV. The presence of just the hydrogenous cement matrix in the inner liner reduces k_{eff} to 1.132 from a value of 1.35 without the cement matrix. As an initial 1 wt % natural boron is added to the high alumina cement system (Table 6.9.3.3-6), the calculated k_{eff} based on 75% of the boron present drops significantly. Cat 277-4 with 4.2284 wt % natural boron in the minimum cast density of 100 lb/ft^3 (1.60 g/cm^3) has an acceptable mixture concentration, generating a k_{eff} of 0.88. The saturation value for boron content is reached at ~8 wt %. This near doubling of the boron content results in ~4% decrease in k_{eff} to an asymptotic value of ~0.85.

The density of Cat 277-4 is the sum of constituent densities: the boron density, the base-material density, and the water density. In the calculation model, the density of water in Cat 277-4 is 0.48210 g/cm^3 (not shown in Table 6.9.3.3-6). Canned spacers are omitted from the calculation model. Credit for only 75% of the boron is taken in each parametric calculation. The volume of the 277-4 in the body weldment inner liner cavity is 1.32708×10^4 cm^3.

Table 6.9.3.3-6. Effect of boron concentration on array neutron multiplication

100%B (wt %)	Boron density (g/cm^3)	Base material density (g/cm^3)	NP277-4 mass (g)	Case name	$k_{eff} \pm 2\sigma$ (@75% B)
0.01	0.00016	1.11775	2.12326E+04	nbiabm_kvsb_1	1.13199 +/- 0.00138
0.1	0.0016	1.11631	2.12279E+04	nbiabm_kvsb_2	1.07944 +/- 0.00145
1	0.016	1.10191	2.11801E+04	nbiabm_kvsb_3	0.95564 +/- 0.00129
2	0.032	1.08591	2.11270E+04	nbiabm_kvsb_4	0.91708 +/- 0.00135
3	0.048	1.06991	2.10739E+04	nbiabm_kvsb_5	0.89396 +/- 0.00117
4.2284	0.068614	1.04930	2.10056E+04	nbiabm_kvsb_6	0.87985 +/- 0.00145
6	9.6000E-02	1.02191	2.09147E+04	nbiabm_kvsb_7	0.86029 +/- 0.00151
8	1.2800E-01	0.98991	2.08085E+04	nbiabm_kvsb_8	0.84769 +/- 0.00150
10	0.16	0.95791	2.07024E+04	nbiabm_kvsb_9	0.84086 +/- 0.00142

NUREG-1609 recommended that only 75% of the minimum boron density be credited in criticality evaluation in order to address the issue of non-homogeneity of ^{10}B in the neutron-absorber material. The boron non-homogenity calculations presented here model an infinite array of ES-3100

packages with the boron concentration of Cat 277-4 varying along the vertical height of the body weldment inner liner. However, the total amount of boron in each package is fixed. Each package in the array contains 2.774 kg of ^{235}U in broken metal form uniformly distributed inside the CV. Two sets of calculations are evaluated with this model to address the effects of boron distribution in the ES-3100 inner liner.

In one set of cases, the inner cavity is divided vertically into three equal-volume regions. The density in one region is increased to 95% of the minimum boron density, while the boron density in the other two regions is decreased to 65%, thus preserving the amount of neutron-absorber material in the package. In the other set of cases, the inner cavity is divided vertically into four equal volume regions, but two regions are combined. This creates two quarter-sized regions and one half-size region. The density in the half-size region is increased to 95% of the minimum boron density, while the density in the quarter-sized regions is decreased to 55%, thus preserving the amount of neutron absorber in the package. In both sets of calculations, the high-density region was shifted upward in the package to examine the effect of boron distribution.

As shown in Figs. 6.9.3.3-2 and 6.9.3.3-3, the effect of non-homogeneity of boron in the ES-3100 liner on k_{eff} is not statistically significant. The "65% - 95% - 65%" nonhomogeneous boron distribution represents a relative standard deviation of 23.1% in boron concentration. Given the controls on method of manufacture and installation of the neutron-absorber material, these calculated conditions bound the expected physical distribution of boron with a large degree of conservatism.

Geometry characteristics of the ES-3100 system preclude the need for uniformity in boron areal density as a prerequisite for criticality safety control. The U.S. Nuclear Regulatory Commission provides crucial guidance in SFST-ISG-15 for controlling areal density in a geometry configuration where one-dimensional effects are significant, such as a distributed source separated by thin Boral sheets (aluminum and boron carbide) which range in thickness from 0.075 to 0.4 in. In this example, Boral aluminum sheets are placed between fissile fuel rods just a few inches away and only become efficient when the low-enriched fissile material is placed in a sea of hydrogenous moderator. The cylindrical thickness of the ES-3100 cast neutron-absorber material (Cat 277-4) is 1.12 in., which is about three times thicker than the largest Boral sheet. Its purpose in the ES-3100 is to provide criticality safety control for arrays of packages.

In the ES-3100, the proposed fissile mass loads are separated by at least one drum diameter (19.36 in.). Drawing M2E801580A031 in Appendix 1.3.7 shows the cross-section view of the many different layers of materials that are between the fissile mass loads in adjacent packages in an array. The direct neutron transport path between dispersed fissile material (assuming a neutron passes through the following thickness of materials at a normal angle to the closest neighboring package) is:

- fissile material,
- 0.100 in. Type 304 stainless-steel CV wall,
- air gap,
- 0.06 in. Type 304 stainless-steel inner liner wall,
- 1.12 in. of 277-4 neutron-absorber material,
- 0.06 in. Type 304 stainless-steel outer liner wall,
- 4.77 in. of Kaolite,
- 0.06 in. Type 304 stainless-steel outer drum wall, and
- air gap,

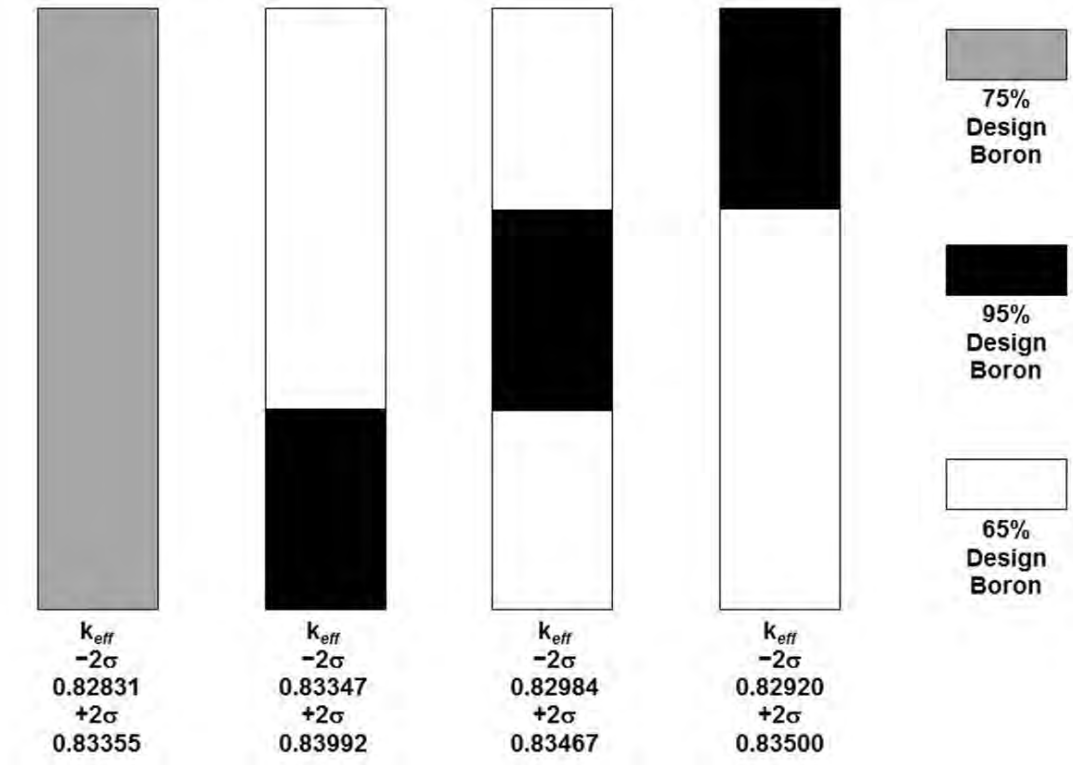


Fig. 6.9.3.3-2. Three equal-region models for evaluation of non-homogeneity in the boron distribution.

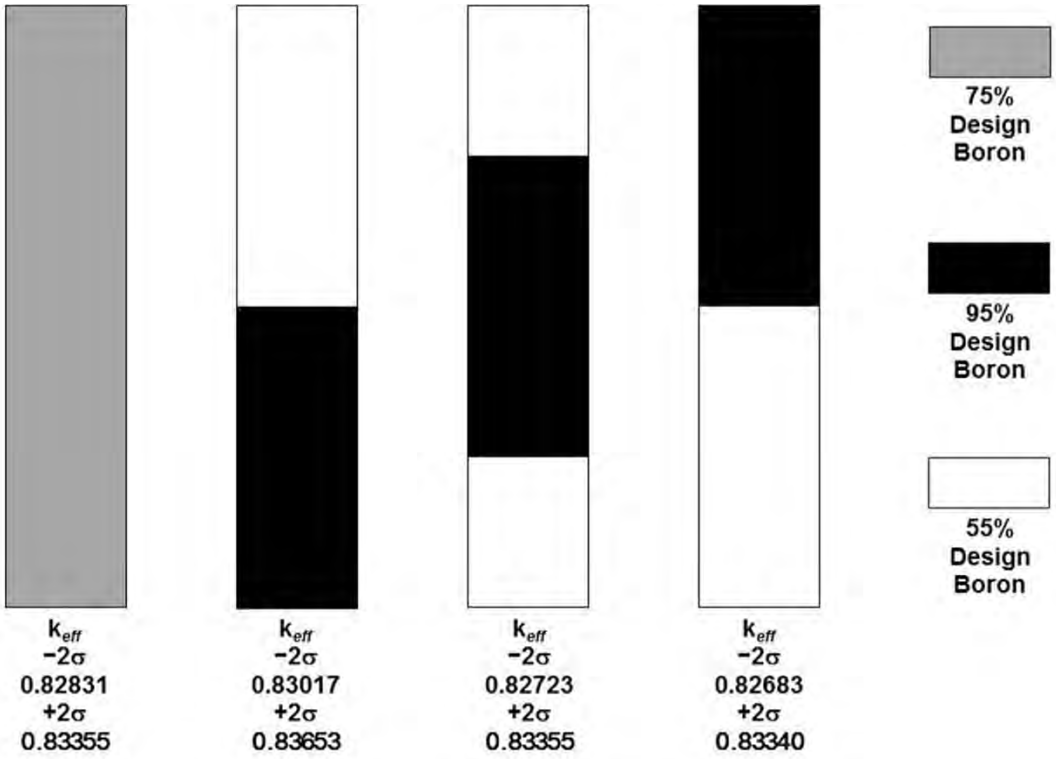


Fig. 6.9.3.3-3. Non-uniform region model for evaluation of non-homogeneity in the boron distribution.

followed by the reverse:

- 0.06 in. stainless-steel outer drum wall,
- 4.77 in. of Kaolite,
- 0.06 in. Type 304 stainless-steel outer liner wall,
- 1.12 in. of 277-4 neutron-absorber material,
- 0.06 in. Type 304 stainless-steel inner liner wall,
- air gap,
- 0.100 in. Type 304 stainless-steel CV wall, and
- back into a fissile material.

At the shortest distance between fissile materials, neutrons travel through the 1.12 in. (2.8448 cm) of 277-4 neutron-absorber material and 0.28 in. (0.7112 cm) of Type 304 stainless steel at least twice, with the high probability of several neutron scattering collisions along the way. Thus, the mean free path in the package is much smaller than the separation between the fissile material of adjacent packages.

In contrast to a Boral sheet application, the neutron-absorber component of the ES-3100 package physically represents a significant fraction of the total container volume and is large in comparison to the potential fissile material volume. Furthermore, the neutron-absorber component consists of boron dispersed throughout a hydraulic cement matrix with a high neutron scattering potential. The net result is that sensitivity to angular and spatial variations in the areal density of ^{10}B in the neutron-absorber volume is eliminated.

The calculation model for a 277-4 canned spacer was developed based on available information at the time of the initial design. The dimensions of the 277-4 filler are 4.13 in. for the diameter and 1.4 in. for the height with a resultant volume of 307.34 cm^3. Based on a density of 95.3886 lb/ft^3 (1.527971 g/cm^3), the amount of 277-4 represented in the calculation model is 469.61 g. As shown on Drawing M2E801580A043 (Appendix 1.3.7), the outer diameter of the stainless-steel can is 4.13 ± 0.09 in. and the height for the 277-4 filler is 1.37 ± 0.06 in. The wall thickness for the 30 gauge stainless steel is 0.012 in. The actual minimum volume of the 277-4 filler is 271.93 cm^3 based on this acceptance criteria. For cast material having a nominal density of 105 lb/ft^3 (1.68193 g/cm^3), the actual minimum amount of 277-4 present in a canned spacer is 457.36 g. An excess 12.25 g of neutron poison in the calculation model on which criticality safety is based is insignificant. Nevertheless, results of additional calculations are presented for demonstrating this fact.

A set of Cases **hciabmt12** establishing loading limits for broken metal were selected from Table 6.9.6-11. These cases based on the nominal 277-4 canned spacer were rerun using SCALE5 and are identified in Table 6.9.6-11d as reference Cases **5hciabmt12**. The corresponding cases for revised calculation model with 277-4 canned spacer sized per the minimal acceptance criteria are identified in Table 6.9.6-11d as Cases **5_401by131**. The minimum dimensions of the 277-4 filler in these cases are 4.01 in. for the diameter and 1.31 in. for the height; the amount of amount of 277-4 represented is 415 g. A statistically significant difference between case results for a configuration with the nominal canned spacer and one with the minimum-sized spacer occurs if the absolute value of the quantity "$\mathbf{(\Delta k_{eff}+2\sigma)/\sigma}$" is >3. As shown in Table 6.9.6-11d, the differences are statistically insignificant; therefore, loadings limits are adequate for content configurations with the canned spacer sized per the minimum acceptance criteria.

<u>The neutron-absorbing material will be fabricated under strict quality control and accepted for use under an NQA-1 compliant QA program.</u> The original equipment specification for the production of 277-4 neutron-absorber material used a proprietary mixture from the Thermo Electron Corporation that combined high alumina cement and a boron grit (Cat 277-4). The manufacturing process for the neutron

absorber was revised in order to obtain details necessary for material characterization and to achieve process control for ensuring consistency of absorber material among lots.

A two-part system of dry-blend components is now employed rather than relying on a single base material (a premixed powder of high alumina cement and boron grit). The vendor's proprietary high-alumina cement without boron grit (Cat 277-0) is mixed with boron carbide by the ES-3100 manufacturer under strict quality controls. A single batch is mixed on a per package basis. The boron carbide used in this process is strictly controlled. Boron carbide is specified as Type 1 material per ASTM C 750, "Nuclear-Grade Boron Carbide Powder." The particle size is controlled in accordance with JS-YMN5-801580-A003, Sect. 3.3.1.2.

The revised formulation designated "277-4" is produced through a quality-controlled batch process of dry blending, wet mixing, vibration casting, and timed cure (JS-YMN3-801580-A005, Appendix 1.3.5). The plan is to control the purity, boron carbide particle size, chemistry, measurements, weights, mixing, recording, casting, and testing using one batch per each shipping package (and its two companion spacer cans). A design analysis calculation shows all of the calculations used in mixing and determines (from the minimum acceptable chemical purities) the volumetric densities in g/cm^3 and an areal density in g/cm^3 of ^{10}B (DAC-PKG-801624-A001). These values will prove the acceptability of the mixing specifications.

An important part of this approach is a QA-approved 277-4 material verification and acceptance testing program. The applicant plans on performing 100% acceptance testing on the criticality safety significant properties of density, ^{10}B interaction (neutron absorption), and hydrogen content. The acceptance density shall be the as cast density in the drum to 105−5+10 lb/ft^3 and shall be determined as shown in Appendix 1.3.5. To test the other properties, two companion sample cans shall be cast from each batch used to cast a shipping container (the manufacturer will cast a fresh batch for each shipping container). The companion sample cans shall also have their density verified. The ^{10}B interaction will be tested in the manner described in Appendix A of the 277-4 specification (Appendix 1.3.5). Initially, a set of 277-4–certified cans will be cast using the proposed casting specification with the QA plan described previously. Then, on a companion sample can for each batch pour, a prompt gamma-ray neutron activation analysis (PGNAA) test will be used to neutronically test the ^{10}B for absorption. To pass the PGNAA test, the sample can results must be within the results obtained for the 277-4 certified standards, in units of Average Net Count rate (ANC/second) ±3 standard deviations. The second companion sample can will be used to test for hydrogen content using an LOD test as described in Appendix 1.3.5. Upon successful completion of the density, PGNAA, and LOD testing, the ES-3100 neutron-absorber material will be accepted for use.

6.9.3.4 Kaolite 1600

Kaolite 1600, manufactured by Thermal Ceramics of Augusta, Georgia [telephone number (404) 796-4200], is a super-lightweight, low thermal conductivity, castable material designed for backup insulation up to 1600°F. The material is obtained as a dry powder with the chemical composition given in Table 6.9.3.4-1. The powder is mixed with water in a water-to-powder ratio of 14.5 qt per 20-lb bag. The mixture is poured into the drum body weldment or top plug, vibrated to eliminate voids, and then dried and fired to form the finished product (Y/EN-5984). The density of the fired material is ~25 lb/ft^3. It is assumed that the wet mixture contains the maximum water possible. This value (14.5 qt per 20 lb) is therefore used to determine the maximum water content of the fired product,

$$S.G._{max} = \frac{14.5\ qt}{20\ lb\ dry} \times \frac{25\ lb}{ft^3} \times \frac{0.946\ L}{1\ qt} \times \frac{998.2\ g}{L} \times \frac{35.32\ ft^3}{10^6\ cm^3} = \frac{0.6045\ g}{cm^3}$$

Table 6.9.3.4-1. Kaolite 1600 chemical composition, percent fired basis

Component	Weight percent	Component	Weight percent
Al_2O_3	9.6	CaO	30.7
SiO_2	36.7	MgO	13.1
Fe_2O_3	6.7	Na_2O	2.0
TiO_2	1.2		

Tables 6.9.3.4-2 and 6.9.3.4-3 provide detailed information regarding the weight measurements taken during the casting of Kaolite 1600 for the production of a series of drum body weldment and top plug parts for a similar package (the CNS Model ES-2100). The mean values for the amount of Kaolite and water present after baking are 107.08 lb of Kaolite and 4.8 lb of water in the drum body weldment, and 16.99 lb of Kaolite and 0.58 lb of water in the top plug. An ES-2100 package contains, on the average, 124.07 lb (56,276.91 g) of Kaolite and 5.38 lb (2,440.32 g) of water. Given that the average volume is 5.72 ft^3, the average density of Kaolite is 22.63 lb/ft^3 (0.3625 g/cm^3).

The volume of the Kaolite region in the KENO models is 1.63417 × 5 cm^3. For NCT, the density of Kaolite is 0.34438 g/cm^3, and the density of water is 0.01493 g/cm^3. The data in Tables 6.9.3.4-2 and 6.9.3.4-3 indicate that the Kaolite may have as little as 1.90 lb (861.82 g) of water after baking (Part Serial Number 97) such that the corresponding density of water is 0.00527 g/cm^3. For the water-flooded HAC, the amount of water is assumed not to exceed the amount present before baking. The package would contain on the average 186.10 lb (84,413.1 g) of water such that the corresponding density is 0.51655 g/cm^3. The full range of NCT and HAC conditions would be covered by a variation of water in the Kaolite from 0 g/cm^3 to 0.51655 g/cm^3 in a calculation model.

The Kaolite components of ES-3100 shipping package had not been manufactured at the time this criticality safety evaluation was performed. Given the lack of production data for ES-3100 Kaolite, a material specification (mass and density) was derived from data for ES-2100 production units. This specification, denoted “as-manufactured” (AM) Kaolite, was used for the ES-3100 criticality calculations. This ES-2100 shipping package is similar in design to the ES-3100 currently being evaluated.

The Kaolite production process was re-evaluated and improved following the production of ES-3100 units (Y/DW-1890). Test samples were produced. These were classified into three groups: high density, medium density, and low density. The predominate number of samples fell into the medium density category (22.04 lb/ft^3), representing the expected, improved Kaolite production process (Y/DW-1890, Table 5). A material specification for use in criticality calculations was derived from the medium density “test sample” (TS) Kaolite data. However, the TS data are based on small sample volumes, whereas the AM data represents the entire package. Taking into consideration both the potential for scaling error and the uncertainty of how representative the test samples are of the manufactured ES-2100 units, the criticality safety packaging analysts chose to utilize the material specification derived from AM data rather than TS data in the criticality calculations for the ES-3100 safety analysis report for packaging.

Table 6.9.3.4-2. Fabrication data, before and after baking the drum body weldment parts of the ES-2100 shipping package

Part Serial Number	Clean and empty (lb)	Filled with water (lb)	Before baking (lb)	After baking (lb)	Density after baking (lb/ft^3)	Water conditions (lb)	Volume (ft^3)	Before baking			After baking		
								Kaolite and water (lb)	Kaolite (lb)	Water (lb)	Kaolite and water (lb)	Kaolite (lb)	Water (lb)
97	87.5	393.5	356.5	197.0	22.29	306.00	4.91	269.00	107.60	161.40	109.50	107.60	1.90
98	87.5	393.5	356.5	198.5	22.60	306.00	4.91	269.00	107.60	161.40	111.00	107.60	3.40
54	87.5	395.0	356.5	199.0	22.59	307.50	4.94	269.00	107.60	161.40	111.50	107.60	3.90
87	87.5	394.0	353.5	196.5	22.16	306.50	4.92	266.00	106.40	159.60	109.00	106.40	2.60
2	88.0	394.0	360.0	202.5	23.31	306.00	4.91	272.00	108.80	163.20	114.50	108.80	5.70
4	88.0	395.5	360.0	203.0	23.30	307.50	4.94	272.00	108.80	163.20	115.00	108.80	6.20
42	88.0	394.5	356.5	199.5	22.66	306.50	4.92	268.50	107.40	161.10	111.50	107.40	4.10
43	88.0	396.0	357.5	198.0	22.25	308.00	4.94	269.50	107.80	161.70	110.00	107.80	2.20
94	87.0	393.5	361.5	205.0	23.99	306.50	4.92	274.50	109.80	164.70	118.00	109.80	8.20
35	88.0	394.5	363.5	208.0	24.39	306.50	4.92	275.50	110.20	165.30	120.00	110.20	9.80
3	87.0	393.0	364.0	206.0	24.23	306.00	4.91	277.00	110.80	166.20	119.00	110.80	8.20
44	88.0	394.0	356.5	204.5	23.72	306.00	4.91	268.50	107.40	161.10	116.50	107.40	9.10
32	88.0	396.0	355.0	198.5	22.35	308.00	4.94	267.00	106.80	160.20	110.50	106.80	3.70
33	87.5	394.0	351.0	197.5	22.36	306.50	4.92	263.50	105.40	158.10	110.00	105.40	4.60
58	87.5	394.5	351.5	196.5	22.12	307.00	4.93	264.00	105.60	158.40	109.00	105.60	3.40
4	87.5	394.0	343.0	192.5	21.34	306.50	4.92	255.50	102.20	153.30	105.00	102.20	2.80
22	87.5	394.5	352.0	196.0	22.02	307.00	4.93	264.50	105.80	158.70	108.50	105.80	2.70
27	88.0	395.5	352.5	196.5	21.98	307.50	4.94	264.50	105.80	158.70	108.50	105.80	2.70
28	87.5	394.5	350.5	199.0	22.63	307.00	4.93	263.00	105.20	157.80	111.50	105.20	6.30
30	87.5	395.0	352.0	200.0	22.79	307.50	4.94	264.50	105.80	158.70	112.50	105.80	6.70
27	88.0	395.5	352.5	196.5	21.98	307.50	4.94	264.50	105.80	158.70	108.50	105.80	2.70
Mean	87.67	394.50	355.36	199.55	22.72	306.83	4.93	267.69	107.08	160.61	111.88	107.08	4.80
Std. dev.					0.8132						100%	95.71%	4.29%
Computed on means					22.72	306.83	4.93	267.69	107.08	160.61	111.88	107.08	4.80

Table 6.9.3.4-3. Fabrication data, before and after baking the top plug parts of the ES-2100 shipping package

Part Serial Number	Clean and empty (lb)	Filled with water (lb)	Before baking (lb)	After baking (lb)	Density after baking (lb/ft^3)	Water conditions (lb)	Volume (ft^3)	Before baking			After baking		
								Kaolite and water (lb)	Kaolite (lb)	Water (lb)	Kaolite and water (lb)	Kaolite (lb)	Water (lb)
97	10.5	60.0	53.5	28.5	22.65	49.50	0.79	43.00	17.20	25.80	18.00	17.20	0.80
83	10.5	59.0	50.5	27.0	50.50	27.00	50.50	27.00	16.00	24.00	16.00	24.00	16.00
86	10.5	60.0	50.5	27.5	21.40	49.50	0.79	40.00	16.00	24.00	17.00	16.00	1.00
87	10.5	59.0	53.0	28.5	23.12	48.50	0.78	42.50	17.00	25.50	18.00	17.00	1.00
28	11.0	59.0	53.0	28.5	22.71	48.00	0.77	42.00	16.80	25.20	17.50	16.80	0.70
23	10.5	59.5	52.5	28.0	22.25	49.00	0.79	42.00	16.80	25.20	17.50	16.80	0.70
24	10.5	59.0	53.5	28.5	23.12	48.50	0.78	43.00	17.20	25.80	18.00	17.20	0.80
25	10.5	58.5	54.0	29.0	24.01	48.00	0.77	43.50	17.40	26.10	18.50	17.40	1.10
26	10.5	59.0	54.0	29.0	23.76	48.50	0.78	43.50	17.40	26.10	18.50	17.40	1.10
27	10.5	60.0	54.5	29.0	23.28	49.50	0.79	44.00	17.60	26.40	18.50	17.60	0.90
0	10.5	60.0	52.0	27.0	20.77	49.50	0.79	41.50	16.60	24.90	16.50	16.60	-0.10a
20	10.5	60.0	53.5	28.0	22.03	49.50	0.79	43.00	17.20	25.80	17.50	17.20	0.30
22	10.5	60.0	54.0	28.5	22.65	49.50	0.79	43.50	17.40	26.10	18.00	17.40	0.60
21	10.5	61.0	53.0	28.0	21.59	50.50	0.81	42.50	17.00	25.50	17.50	17.00	0.50
19	10.5	60.0	53.0	27.5	21.40	49.50	0.79	42.50	17.00	25.50	17.00	17.00	0.00
11	10.5	60.0	52.5	28.0	22.03	49.50	0.79	42.00	16.80	25.20	17.50	16.80	0.70
14	10.5	60.0	52.5	27.5	21.40	49.50	0.79	42.00	16.80	25.20	17.00	16.80	0.20
15	10.5	60.5	54.0	28.0	21.81	50.00	0.80	43.50	17.40	26.10	17.50	17.40	0.10
16	10.5	59.0	52.0	27.5	21.84	48.50	0.78	41.50	16.60	24.90	17.00	16.60	0.40
17	10.5	60.5	54.5	28.5	22.43	50.00	0.80	44.00	17.60	26.40	18.00	17.60	0.40
Mean	10.53	59.70	53.00	28.10	23.74	48.10	3.28	42.48	16.99	25.49	17.58	16.99	0.59
Std. dev.					6.3565						100%	96.67%	3.33%
Computed on means					22.27	49.18	0.79	42.48	16.99	25.49	17.58	16.99	0.59

[a] No explanation is given for the negative amount of water in Part 0. Also, the smaller percentage of water present in the top plug compared with to the drum body weldment is attributed to the larger surface-to-volume ratio, which results in better drying of the parts.

A set of criticality calculations was performed for each of the packaging material specifications (i.e., the TS and the AM Kaolite) using three package water contents to represent the range of NCT and HAC. Y-12 statisticians were asked to determine whether or not the observed differences in neutronic performance are statistically significant for a package modeled with the TS specification versus one modeled with the AM specification. The purpose of this discussion is to summarize this comparison (DAC-FS-900000-A014) and draw conclusions.

Criticality Calculations. Each case is rerun using a different starting random number in order to produce computed k_{eff} values that are statistically independent. Table 6.9.3.4-4 presents the random starting number, the mean value (k_{eff}) and corresponding standard error (s_i) computed for 10 individual runs of each case.

Three sets of criticality calculations were run for both the AM Kaolite and TS Kaolite. One set of calculations is for dry Kaolite (i.e., low water content, IS = 1E-04 sp gr water); another set is for normal moisture Kaolite (i.e., NCT water content); and the third set is for flooded Kaolite (i.e., high water content, IS = 1.0 sp gr water). These conditions span the range of NCT and HAC addressed in the criticality evaluation. An infinite array of packages was evaluated in order to eliminate any biases arising from spectral leakage effects in the reflector of the finite array. Each package was modeled having 36 kg of 100% enriched uranium in the form of 3.24-in.-diam cylinder content. The k_{eff} values for each KENO V.a case are based on 500,000 neutron histories produced by running for 215 generations with 2,500 neutrons per generation and truncating the first 15 generations of data.

Statistical evaluation. A review of KENO V.a calculation results was made to determine if a statistically significant difference exists between the mean k_{eff} for the TS Kaolite specification and the AM Kaolite material specifications used in the criticality evaluation of the ES-3100 shipping package. Case results were classified into three groups (i.e., low water content, medium water content, or high water content) depending on the amount of water present in the ES-3100 shipping package. The symbol "I" is used to specify the group. The mean difference and standard deviation for each of the three (3) sets of pair-wise differences was defined as follows:

(a) $d_i = (k_{effBi} - k_{effAi})/n$ and

(b) $s_{di} = \sqrt{[\, n\Sigma d_i^{\,2} - (\Sigma d_i)^2 \,] / n(n-1)}$ (conservatively defined for the t-test appropriate for small sample sizes)

where A_i denotes the TS by group classification, B_i the AM by group classification, and n the sample size of ten (10). It is reasonable to assume that the paired differences have been randomly selected from a normally distributed population of paired differences with mean μ_d and standard deviation σ_d. Therefore, the sampling distribution of

$$(d - \mu_d) / (s_d/\sqrt{n})$$

is a *t*-distribution having n-1 degrees of freedom.

Table 6.9.3.4-4. Data for the statistical evaluation of "as-manufactured"and "test sample" Kaolite

As-manufactured Kaolite				Test sample Kaolite			
Case name	**Random number**	**k_{eff}**	**s_i**	**Case name**	**Random number**	**k_{eff}**	**s_i**
Group 1 – Low water content							
esrandnum_01_01_in	109E77866CF	1.00274	0.00138	mdrandnum_01_01_in	109E77866CF	1.00170	0.00125
esrandnum_01_02_in	16AA4A58735	1.00224	0.00120	mdrandnum_01_02_in	16AA4A58735	1.00416	0.00116
esrandnum_01_03_in	1814171B652	1.00121	0.00107	mdrandnum_01_03_in	1814171B652	1.00208	0.00125
esrandnum_01_04_in	1A423B9472C	1.00367	0.00118	mdrandnum_01_04_in	1A423B9472C	1.00271	0.00131
esrandnum_01_05_in	20E876D8224	1.00290	0.00133	mdrandnum_01_05_in	20E876D8224	1.00406	0.00125
esrandnum_01_06_in	3F6E65CA744	1.00266	0.00137	mdrandnum_01_06_in	3F6E65CA744	1.00418	0.00124
esrandnum_01_07_in	479D21DB750	1.00393	0.00108	mdrandnum_01_07_in	479D21DB750	1.00193	0.00133
esrandnum_01_08_in	55D4371D3A2	1.00313	0.00113	mdrandnum_01_08_in	55D4371D3A2	1.00196	0.00105
esrandnum_01_09_in	6E1A14672B8	1.00343	0.00119	mdrandnum_01_09_in	6E1A14672B8	1.00503	0.00118
esrandnum_01_10_in	77A0308C0E4	1.00229	0.00113	mdrandnum_01_10_in	77A0308C0E4	1.00358	0.00108
Group 2 – NCT medium density							
esrandnum_06_01_in	109E77866CF	0.99025	0.00119	mdrandnum_06_01_in	109E77866CF	0.98323	0.00118
esrandnum_06_02_in	16AA4A58735	0.98863	0.00128	mdrandnum_06_02_in	16AA4A58735	0.98630	0.00108
esrandnum_06_03_in	1814171B652	0.98811	0.00120	mdrandnum_06_03_in	1814171B652	0.98328	0.00125
esrandnum_06_04_in	1A423B9472C	0.98933	0.00114	mdrandnum_06_04_in	1A423B9472C	0.98487	0.00112
esrandnum_06_05_in	20E876D8224	0.98869	0.00103	mdrandnum_06_05_in	20E876D8224	0.98559	0.00109
esrandnum_06_06_in	3F6E65CA744	0.98854	0.00117	mdrandnum_06_06_in	3F6E65CA744	0.98412	0.00106
esrandnum_06_07_in	479D21DB750	0.98900	0.00119	mdrandnum_06_07_in	479D21DB750	0.98395	0.00118
esrandnum_06_08_in	55D4371D3A2	0.98844	0.00113	mdrandnum_06_08_in	55D4371D3A2	0.98546	0.00114
esrandnum_06_09_in	6E1A14672B8	0.99007	0.00126	mdrandnum_06_09_in	6E1A14672B8	0.98424	0.00121
esrandnum_06_10_in	77A0308C0E4	0.99028	0.00122	mdrandnum_06_10_in	77A0308C0E4	0.98465	0.00118
Group 3 – High water content							
esrandnum_09_01_in	109E77866CF	0.92872	0.00118	mdrandnum_09_01_in	109E77866CF	0.92800	0.00123
esrandnum_09_02_in	16AA4A58735	0.92800	0.00110	mdrandnum_09_02_in	16AA4A58735	0.92817	0.00107
esrandnum_09_03_in	1814171B652	0.92844	0.00118	mdrandnum_09_03_in	1814171B652	0.92770	0.00115
esrandnum_09_04_in	1A423B9472C	0.92780	0.00123	mdrandnum_09_04_in	1A423B9472C	0.92763	0.00126
esrandnum_09_05_in	20E876D8224	0.92783	0.00134	mdrandnum_09_05_in	20E876D8224	0.92584	0.00105
esrandnum_09_06_in	3F6E65CA744	0.92809	0.00128	mdrandnum_09_06_in	3F6E65CA744	0.92853	0.00112
esrandnum_09_07_in	479D21DB750	0.92725	0.00111	mdrandnum_09_07_in	479D21DB750	0.92682	0.00111
esrandnum_09_08_in	55D4371D3A2	0.92622	0.00126	mdrandnum_09_08_in	55D4371D3A2	0.92706	0.00116
esrandnum_09_09_in	6E1A14672B8	0.92925	0.00132	mdrandnum_09_09_in	6E1A14672B8	0.92733	0.00110
esrandnum_09_10_in	77A0308C0E4	0.92757	0.00114	mdrandnum_09_10_in	77A0308C0E4	0.92886	0.00132

The evaluation of the mean differences (d_i) for the 10 sets of cases is accomplished through hypothesis testing, a statistical tool used to provide evidence that a difference exists or does not exist. The ti values are 0.70, 10.0 and 0.95 for dry Kaolite, for NCT Kaolite, and for flooded Kaolite, respectively. A value of 3.25 is obtained from the standard table for critical values for the t distribution, from which the decision to accept or reject the null hypothesis H0 is made with a Type I error probability (α) of 0.01. For t <3.25, the Ho hypothesis is not rejected. Acceptance of the null hypothesis is the result of insufficient evidence to reject it. Thus, it can be concluded that the mean estimate of the difference of the AM Kaolite is not significantly different from the mean of the TS Kaolite for both dry and flooded Kaolite. For t >3.25, the Ho hypothesis is rejected. Therefore, it can be concluded that the mean estimate of the difference of the AM Kaolite is significantly different from the mean of the TS Kaolite for the normal moisture Kaolite. The mean k_{eff} for AM Kaolite is significantly greater than the mean k_{eff} of the TS Kaolite; therefore, the use of the AM specification in the ES-3100 criticality calculations is conservative and bounding. Details of the statistical evaluation are documented in Reference DAC-FS-900000-A014.

6.9.3.5 Packcrete

ES-3100 drum body assemblies and top plugs may be fabricated with Packcrete or Kaolite. Packcrete is a fireproof, lightweight, impact limiting, thermal insulating, cast refractory material. It is comprised of water, Airalon 3000 (air entraining agent), portland cement, and vermiculite as specified in SPC M801794-003 (Appendix 1.3.11) and SPC M801580-0003 (Appendix 1.3.12). The material is obtained as a dry powder with the chemical composition given in RP 802282-0002, *Packcrete Material Properties.* Only the major constituents in the dry powder were modeled with the weight percent of each component normalized to obtain 100% as shown in Table 6.9.3.5-1. Constituents less than 1% are ignored, and the water, which is a major constituent, is also ignored for the dry powder, since water is already varied in this analysis. The powder is mixed with water, with the mixture poured into a stainless-steel shell specified on Drawing M2E801580A002 (drum body weldment) and Drawing M2E801580A008 (top plug weldment). The filled weldements are vibrated to eliminate voids, and then dried and fired to form a finished product.

Table 6.9.3.5-1. Average Packcrete chemical composition, fired basis

Component	Before normalization (wt %)	Normalized (wt %)
Al_2O_3	7.59	8.93
SiO_2	24.61	28.96
Fe_2O_3	5.82	6.85
K_2O	1.90	2.54
CaO	35.63	41.93
MgO	7.26	8.55
SO_3	2.16	2.24
Total	84.97	100.00

As documented in RP 802282-0002, chemical analysis was performed on each sample taken during the initial production of Packcrete. A sample was taken from each 50 lb bag of material mixed. Properly cured Packcrete should have very little latent water, but it may have a significant amount of water of hydration. Dehydration testing was conducted on the samples to determine the water content.

The data of the evaluated samples were grouped as high-density dehydration data, medium-density dehydration data, and low-density dehydration data.

From dry mass data, the water composition in Packcrete ranges from a minimum of 10.16% to a maximum of 15.67%, with an average of 12.92%. The acceptable range for the baked density of Packcrete material is 22.4 ± 3 lb/ft^3 (19.4 to 25.4 lb/ft^3), while the acceptable range for the wet density of Packcrete material is 53.9 ± 5.6 lb/ft^3 (48.3 to 59.5 lb/ft^3).

In this analysis only the array calculations were performed. For these calculations, only the low density Packcrete and low density water was examined, since it has been shown in the Kaolite calculations that lower density materials are the most reactive for array calculations (due to the enhancement of interaction effects). An example of how these values were calculated is shown below. Although not calculated for single packages, an example calculating the maximum water density and dry Packcrete density is also provided below.

The maximum density of water remaining in the Packcrete is calculated by first multiplying the baked density (19.4, 22.4, or 25.4 lb/ft^3) by the water content (10.16 %, 12.92 %, or 15.67 %). This value is subtracted from the baked density to obtain the density of the dry Packcrete material. The maximum density of water is determined by subtracting the dry Packcrete material density from the maximum wet Packcrete density. An example of the calculation is found below for 25.4 lb/ft^3 at 15.67 % water content:

Dry Packcrete density: 25.4 lb/ft^3 × (1 - 0.1567) = 21.41982 lb/ft^3

Maximum density of water: 59.5 lb/ft^3 - 21.41982 lb/ft^3 = 38.08018 lb/ft^3.

The minimum density of water remaining in the Packcrete is calculated by first multiplying the baked density (19.4, 22.4, or 25.4 lb/ft^3) by the water content (10.16 %, 12.92 %, or 15.67 %). This value is subtracted from the baked density to obtain the density of the dry Packcrete material. The minimum density of water is determined by subtracting the dry Packcrete material density from the baked Packcrete density. An example of the calculation is found below for 19.4 lb/ft^3 at 10.16 % water content:

Minimum density of water: 19.4 lb/ft^3 × 0.1016 = 1.97104 lb/ft^3

Dry Packcrete density: 19.4 lb/ft^3 - 1.97104 lb/ft^3 = 17.42896 lb/ft^3.

All of the Kaolite calculations presented in this SARP were modeled with average Kaolite baked density for both single packages and arrays. The maximum amount of water was modeled in the Kaolite for the single package calculations and the minimum amount of water was modeled in the array calculations. The comparative calculations performed here will also use average density of both Kaolite and Packcrete.

Several series of calculations are performed in the analysis comparing Kaolite and Packcrete. In the first set of calculations, the maximum amount of water in both Kaolite and Packcrete was modeled. This value of water is the amount of water mixed with the dry constituent prior to baking. These calculations examined only single packages, since the maximum amount of water in Kaolite is more reactive in single package calculations than in array calculations. The results are found in Table 6.9.3.5-2.

From the results of Table 6.9.3.5-2 for single package calculations, there is no statistical difference between Kaolite and Packcrete at the average density with the maximum amount of water modeled in Kaolite and Packcrete.

Table 6.9.3.5-2. Comparative calculations Kaolite vs Packcrete for single package (maximum amount of water in Kaolite and Packcrete)

Description	Kaolite		Packcrete	
	Case	$k_{eff} + 2\sigma$	Case	$k_{eff} + 2\sigma$
Broken metal w/polyethylene	ncsrbmt11p_8_6_15	0.89242	ncsrbmt11ppckb_8_6_15	0.89088
Poly cyl and bars	ncsrcyct11p_17_1_15	0.89709	ncsrcyct11ppckb_17_1_15	0.89661
U_3Si compound	5ncsrdpu3st11_3_6_15	0.76239	5ncsrdpu3st11pckb_3_6_15	0.76119
4 kg oxide at 0.5 g/cm^3	ncsrltoxt11_6_8	0.78623	ncsrltoxt11pckb_6_8	0.78595

In the second set of calculations, the minimum amount of water is used. The amount of water modeled in the Kaolite calculations is based on the data from Table 6.9.3.4-2. For Packcrete, two calculations were performed using the minimum amount of water in the Packcrete samples and the minimum amount of water in the Kaolite samples. This was done because the minimum amount of water found in the Packcrete samples was greater than what was found in the Kaolite samples. This higher amount of water will reduce the interaction effects in the array calculations, resulting in a less reactive system. The results are found in Table 6.9.3.5-3.

Table 6.9.3.5-3. Comparative array calculations Kaolite vs Packcrete

Description	Case	Kaolite	Packcrete	
		$k_{eff} + 2\sigma$	$k_{eff} + 2\sigma$ [a]	$k_{eff} + 2\sigma$ [b]
Broken metal w/polyethylene	nciabmt11p_5_1_6_3	0.93426	0.87058	0.93718
U_3Si compound	5nciadpu3st11_3_4_3	0.93461	0.86636	0.93713
4 kg oxide at 0.5 g/cm^3	ncialdoxt11p_6_1_2	0.92405	0.86593	0.92544
15.5 kg oxide at 2 g/cm^3	ncf1oxt11_11_3	0.93250	0.88564	0.93165

[a] Minimum water density from Packcrete (ppckc).
[b] Minimum water density from Kaolite (ppckf).

When the Packcrete is modeled with the minimum amount of water from the samples documented in RP 802282-0002, the $k_{eff} + 2\sigma$ is lower than the original Kaolite cases. This is because the minimum amount of water from the samples is significantly higher than the Kaolite samples. This additional water is shown to reduce the amount of interaction between the ES-3100 packages. As seen from the results of Table 6.9.3.5-3 for array package calculations, modeling the Packcrete with the minimum amount of water based on the Packcrete samples is significantly less reactive than Kaolite modeled with the minimum amount of water based on the Kaolite samples. It is important to note that there were more Kaolite samples than Packcrete samples. To address this potential concern, additional cases were run using the minimum amount of water from the Kaolite cases in the Packcrete models for comparison purposes. From the results shown in Table 6.9.3.5-3, when modeling the minimum amount of water in the Packcrete the same as Kaolite, there is very little difference in the reactivity.

Additional calculations were performed modeling Kaolite and Packcrete with no water. Both were modeled at average density and with no water. This model will examine the effects that the dry constituents have on reactivity. The results are found in Table 6.9.3.5-4.

Table 6.9.3.5-4. Comparative array calculations for Kaolite vs Packcrete with no water

Description	Kaolite (with no water)		Packcrete (with no water)	
	Case	$k_{eff} + 2\sigma$	Case	$k_{eff} + 2\sigma$
Broken metal w/polyethylene	nciabmt11pnw_5_1_6_3	1.00341	nciabmt11ppcke_5_1_6_3	1.00534
U_3Si compound	5nciadpu3st11nw_3_4_3	1.00787	5nciadpu3st11pcke_3_4_3	1.00840
4 kg oxide at 0.5 g/cm^3	ncialdoxt11nw_6_1_2	0.98284	ncialdoxt11pcke_6_1_2	0.98613
15.5 kg oxide at 2 g/cm^3	ncf1oxt11nw_11_3	0.97964	ncf1oxt11pcke_11_3	0.97701

When modeling no water in Kaolite and Packcrete, there is no statistical difference in reactivity between the two. From the results of these calculations shown in Tables 6.9.3.5-3 and 6.9.3.5-4, the reactivity effects of the Kaolite and Packcrete are based on the amount of water in the Kaolite and Packcrete.

Based on the results of these calculations, it can be concluded that the calculations performed for Kaolite will also bound Packcrete.

6.9.3.6 Water

Water is used in various regions of the models to simulate HAC as an interstitial moderator and as a reflector. When used at full density, the density of water is 0.9982 g/cm^3 (NUREG/CR-0200, Rev. 6).

6.9.3.7 Calculation of Equivalent Water Mass for Polyethylene

In the calculation models for evaluation of NCT, water may be substituted for the polyethylene composition of bags present in the package. Based on hydrogen density, 1285.14 g of water are equivalent to 1000 g of polyethylene for nuclear criticality safety calculations. The equivalent water mass is calculated as follows:

$$1 \text{ kg polyethylene} = \frac{1000 \text{ g}}{0.92 \text{ g/cm}^3} = 1087.0197 \text{ cm}^3$$

$$\text{H number density} = \frac{(0.92)\,(4)\,(6.02252 \times 10^{23})}{(28.0312)\,(10^{24})} = 7.906502 \times 10^{-2} \text{ at/bn-cm}$$

$$\text{H in 1 kg} = (1087.0197 \text{ cm}^3)\,(7.906502 \times 10^{-2}) = 85.945234 \text{ at-cm}^2/\text{bn}$$

Hydrogen in 1 kg of polyethylene [$(CH_2)_2$, molecular weight = 28.0312; density = 0.92]:

Grams of water [H_2O, molecular weight = 18.0110; density = 0.9982] with hydrogen content equivalent to 1 kg of polyethylene:

$$\text{equivalent g of } H_2O = \frac{(85.945234)\,(18.0110)\,(10^{24})}{(2)\,(6.02252 \times 10^{23})} = 1285.1427 \text{ g}$$

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Appendix 6.9.4
Qualification of a Neutron-absorber Material for the ES-3100

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Appendix 6.9.4
Qualification of a Neutron-absorber Material for the ES-3100

6.9.4.1 Introduction

277-4 is a formulation of Thermo Electron Corporation's Cat. 277-0, a boron carbide additive and water. 277-4 is a neutron radiation shielding product and is one of several materials in its class that have been evaluated as a candidate neutron-absorber system for a variety of nuclear criticality safety applications by the Y-12 National Security Complex (Y-12). This class of materials is characterized as a dispersion of $^{nat}B_4C$ particulate[1] throughout a hardened hydraulic cement or binder, resulting in a high-hydrogen, borated material system. It offers many advantages for typical Y-12 applications over other classes of materials such as borated aluminum because a neutron moderator and neutron absorber are both integral to the solid material system itself. The separate addition of another neutron moderating material such as water or polyethylene is not required in order for it to function effectively.

Computational methods of analysis in simple geometry permit direct comparison of neutron-absorber system performance for nuclear criticality safety applications. The measure of comparison is the neutron interaction potential between two parallel 0.745-cm-thick slabs of infinite extent of ^{235}U metal at a density of 18.81 g/cm^3. The slabs are separated by a variable thickness of material and reflected by a 60-cm thickness of the same material (Fig. 6.9.4.1-1). Each material is modeled as an idealized homogeneous mixture of elements based on nominal density and constituent proportions (Table 6.9.4.1-1). The result is expressed in terms of calculated k_{eff}[2] as influenced by the thickness of the candidate material between the two parallel slabs (see Fig. 6.9.4.1-2).

The least effective neutron-absorber material systems are those with low hydrogen content and low neutron absorption cross section (e.g., ordinary concrete). The performance of concrete that contains $^{nat}B_4C$ particulate (e.g., borated concrete) is improved, but it is still hindered by its low hydrogen content. This is a function of the proportion and type of cement in the typical concrete mixture (i.e., a low proportion of lime- and silica-based Portland cement). Ordinary water is also included for comparison because of its high hydrogen content, but its performance is also limited by a low total mass density and low neutron absorption cross section.

As expected, materials with high hydrogen content and high boron content (e.g., 277-4, borated ceramics, and borated polymers) are predicted to be the most effective neutron-absorber systems. Although the mechanical and thermal properties of such systems can vary significantly, their nuclear properties are dictated almost exclusively by the relative proportion and content of ^{10}B and H and the total mass density of the material system. These things being equal, the nuclear performance of any material in this class (i.e., 277-4, borated ceramics, and borated polymers) is representative of the others.

[1] 277-4 is an improved variant of the Cat 277 product ca. 2000 which was originally formulated as a dispersion of ^{nat}Borosilicate glass granules rather than the current practice of using $^{nat}B_4C$ particulate.

[2] SCALE 4.4a, CSAS25 code sequence for KENO V.a with the 238-group ENDF B-IV neutron cross-section library on the Y-12 Safety Analysis Engineering Hewlett-Packard J5600 workstation (CMODB).

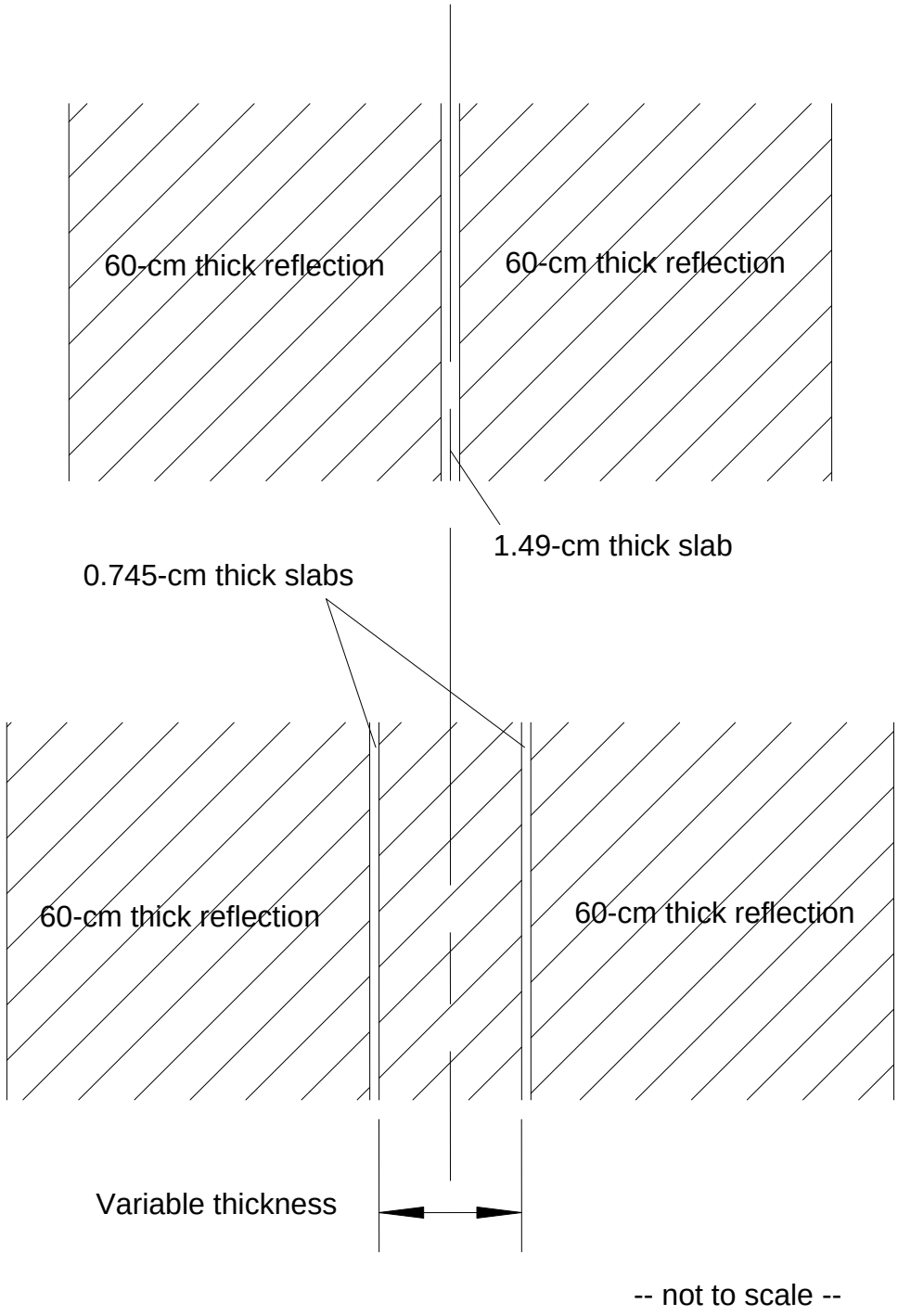


Fig. 6.9.4.1-1. Physical model of parallel ^{235}U metal slabs of infinite extent reflected and separated by various candidate neutron-absorber materials.

Table 6.9.4.1-1. Nominal elemental and isotopic compositions of idealized material models for comparison of various neutron absorbers (atoms/barn·cm)

	Ordinary concrete A 2.147 g/cm^3	Ordinary concrete B 2.299 g/cm^3	Water 0.9982 g/cm^3	Borated concrete 2.563 g/cm^3	Cat 277a 1.68 g/cm^3	Borated ceramic 1.91 g/cm^3	Borated polymer 1.717 g/cm^3	^{235}U metal 18.81 g/cm^3
H	4.2581E-03	8.5010E-03	6.6751E-02	4.2900E-03	3.3800E-02	2.7200E-02	5.7600E-02	
B-10				1.7600E-04	2.8400E-04	2.6500E-03	9.4600E-04	
B-11				6.8100E-04	1.1800E-03	1.1000E-02	3.9200E-03	
C	1.1348E-02	2.0217E-02		9.0000E-04		4.2600E-03	2.3500E-02	
N							1.3800E-03	
O	4.0370E-02	3.5511E-02	3.3376E-02	4.2400E-02	3.7100E-02	3.2900E-02	2.5900E-02	
Na	7.9356E-05	1.6299E-05		6.7100E-05	2.6000E-04	7.9200E-05		
Mg	5.0111E-03	1.8602E-03		2.3000E-04	2.0800E-04	2.3300E-03		
Al	3.7660E-04	5.5580E-04		2.2900E-03	8.9700E-03	1.7400E-03	7.7000E-03	
Si	1.9382E-03	1.7000E-03		1.1800E-02	7.6700E-04	3.2300E-03		
P						2.1200E-03		
S	1.0013E-04			9.6300E-05	6.0000E-05	7.7800E-05		
Cl	1.9074E-05							
K	3.1231E-04	4.0300E-05		3.1600E-04		2.3100E-03		
Ca	7.3008E-03	1.1101E-02		3.1200E-03	2.2300E-03	2.4600E-04		
Ti	4.0183E-05					7.0800E-05		
Mn	1.2050E-05			1.4000E-04				
Fe	1.2954E-04	1.9301E-04		4.6200E-03	4.8900E-05	5.2000E-04		
U-235								4.8200E-02

[a] The ^{10}B content of this material model for Cat 277 is based on its ca. 2000 formulation using crushed borosilicate glass rather than the current practice of using $^{nat}B_4C$ particulate. This particular formulation is roughly equivalent to ~2% $^{nat}B_4C$ particulate (i.e., equivalent ^{10}B content, by weight). For otherwise identical H and B-10 content, this difference is unimportant relative to its nuclear performance as an idealized homogeneous mixture of elements. However, the current use of more than 5% $^{nat}B_4C$ particulate (by weight) is preferred due to reasons relating to the method of preparation, chemical reaction, and placement of 277-4 and uniformity of ^{10}B distribution in the cured product. As with all the materials in this class, the amount of H and ^{10}B in the finished product is determined by the relative proportions of its major constituents, which are tailored to the requirements of the specific application.

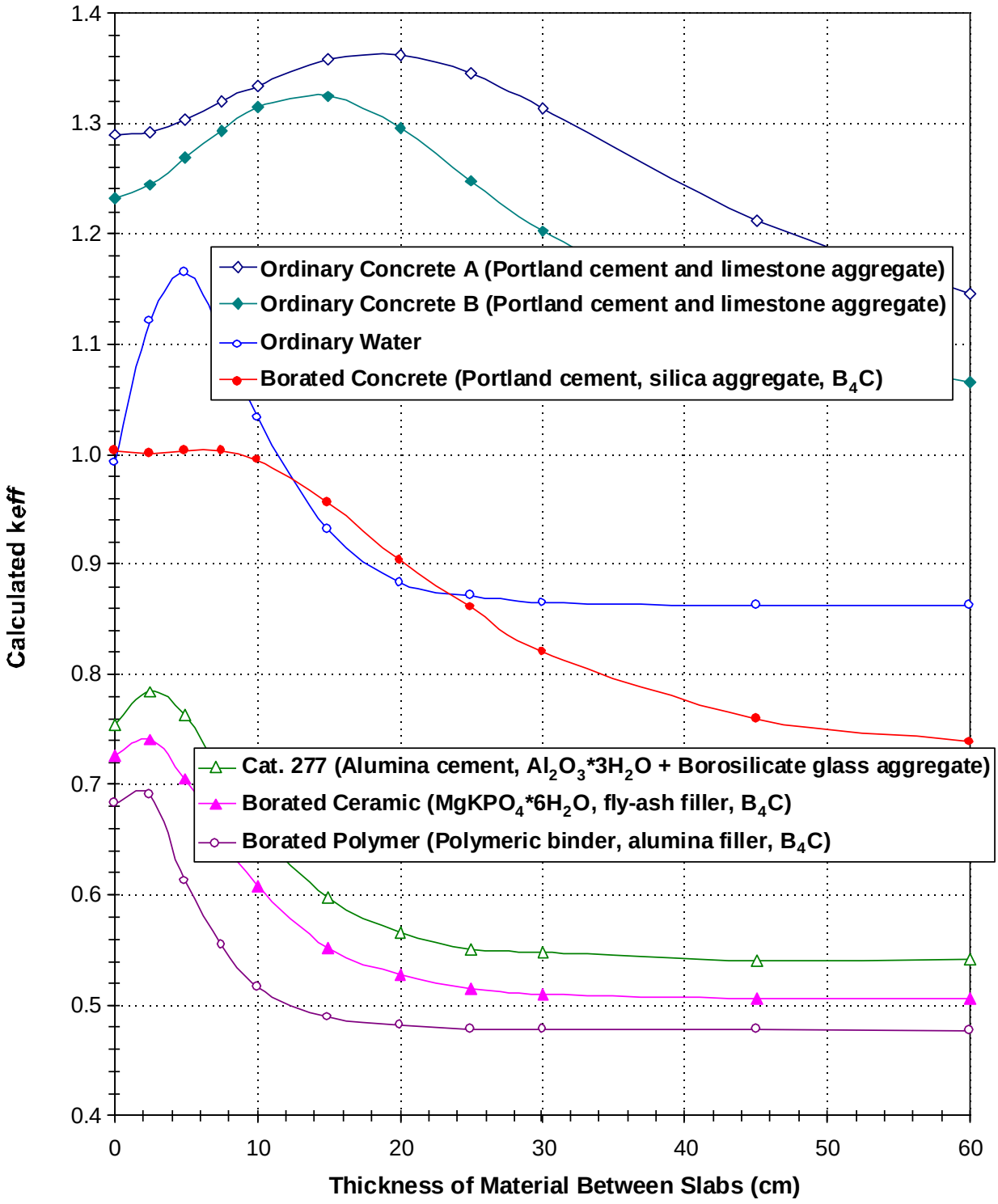


Fig. 6.9.4.1-2. The effect of various materials on neutron interaction between parallel slabs of ^{235}U metal of infinite extent.

6.9.4.2 Performance Testing

To investigate the performance of this class of neutron-absorbing materials further, Y-12 has studied neutron radiography and neutron transmission measurements on several samples of a borated ceramic. Like 277-4, the borated ceramic is also a dispersion of $^{nat}B_4C$ particulate throughout a hardened hydraulic crystalline solid material matrix for which the binder phase is $MgKPO_4 \cdot 6H_2O$ rather than the hydrates of CaO and Al_2O_3. In fact, the more finely divided $^{nat}B_4C$ particulate specified for 277-4 is a slight advantage over the modestly coarser particulate in the borated ceramic. As shown below in Table 6.9.4.2-1, the relative proportion and content of H and ^{10}B and their total mass density are very similar. The small differences between the nuclear properties of their associated low- and intermediate-Z elements (i.e., oxides of Mg, Al, P, K, and Ca) are negligible. Thus, performance and the most significant factors affecting performance are nearly identical for both materials, so the results of neutron radiography and neutron transmission for the borated ceramic samples are judged applicable to 277-4 specimens of similar dimension.

Table 6.9.4.2-1. Comparison of nominal values for 277-4 and borated ceramic samples subjected to neutron radiography and neutron transmission testing.

Attribute	Cat 277 original formulation ca. 2000	277-4 ES-3100 formulation as cured	Borated ceramic samples for testing
Principal binder phase(s)	Hydrates of CaO and Al_2O_3	Hydrates of CaO and Al_2O_3	$MgKPO_4 \cdot 6H_2O$
Neutron absorber	^{nat}Borosilicate glass granules	$^{nat}B_4C$ particulate	$^{nat}B_4C$ particulate
Particle Size	90 wt % <2360 μm 65 wt % <1180 μm 40 wt % <600 μm 15 wt % <102 μm 0 wt % <150 μm	100 wt % <102 μm	100 wt % <559 μm 90 wt % <356 μm 40 wt % <254 μm 3 wt % <122 μm 0 wt % <63 μm
Filler Material(s)	$Al_2O_3 \cdot 3H_2O$	$Al_2O_3 \cdot 3H_2O$	Class F Coal Fly-ash
Total Mass Density	1.68 g/cm^3	1.60 g/cm^3	1.91 g/cm^3
Total H_2O content	0.51 g/cm^3	0.51 g/cm^3	0.49 g/cm^3
Total ^{10}B content	0.005 g/cm^3	0.013 g/cm^3	0.012 g/cm^3

Samples were prepared from sectioned pieces of a single specimen from a vertically oriented mold measuring 10 × 10 × ~30 cm tall, as illustrated in Fig. 6.9.4.2-1 (nominally 4 × 4 × 12 in. tall). One specimen was prepared by the normal method of mixing and preparation for the borated ceramic material. Sectioning the first specimen resulted in two thick samples designated “1 of 2” and “2 of 2” which each measured 10-cm wide by ~30-cm long by ~2.4-cm thick (nominally 1-in. thick). A second specimen was prepared by abnormal methods intended to produce non-homogeneity (i.e., poorly mixed using retardants followed by excessive and extended vibration of the mold after installation). Sectioning this specimen resulted in two thin samples designated “062d1bc” and “062d1bd” which each measured 10-cm wide by ~30-cm long by ~1.2-cm thick (nominally 0.5-in. thick). The samples were delivered to the Breazeale Nuclear Reactor Building at Pennsylvania State University for inspection. Upon completion of inspection for all four samples as received, a thick sample “1 of 2” and a thin sample “062d1bc” were dehydrated by heating to 140°C to eliminate interference by hydrogen, and all four samples were tested again.

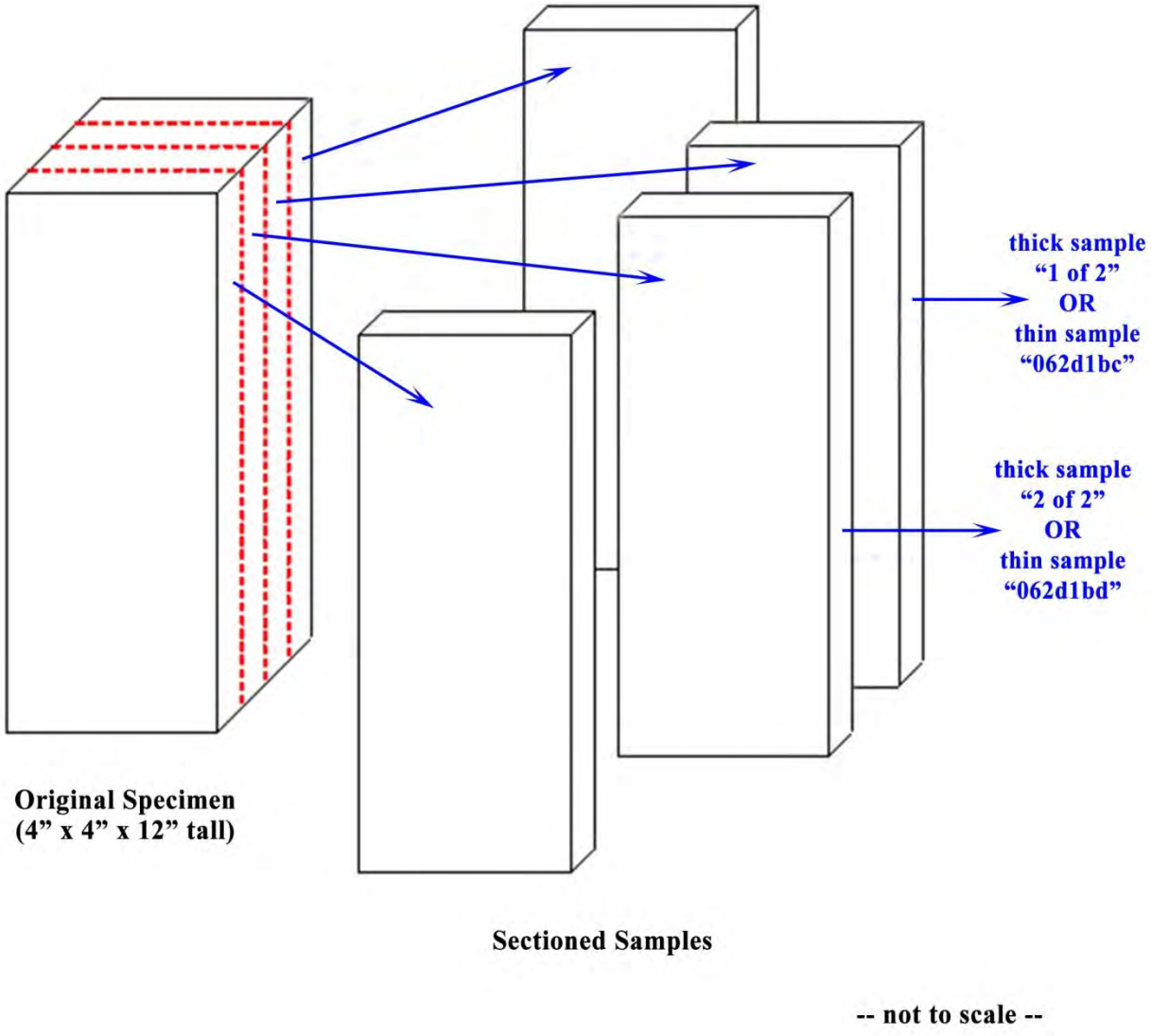


Fig. 6.9.4.2-1. Illustration of sectioning plan for borated ceramic samples for neutron radiography and neutron transmission measurements.

All four samples were qualitatively inspected for visual defects and subjected to neutron radiographic inspection. The inspections were intended to identify any variations in image luminance, which would indicate a variation in homogeneity and density. Neutron transmission measurements were calibrated to results for thin ZrB_2 reference coupons sandwiched with thick aluminum metal. The ^{10}B areal densities of the thin reference coupons ranged from 5.32 mg/cm^2 to 57.04 mg/cm^2 over a total ZrB_2 + Al reference thickness of 24.21–24.98 mm. By comparison, the thick samples contain an idealized ^{10}B areal density of 28.8 mg/cm^2 (i.e., 0.012 g/cm^3 over a 2.4-cm thickness), and the thin samples contain an idealized ^{10}B areal density of 14.4 mg/cm^2 (i.e., 0.012 g/cm^3 over a 1.2-cm thickness).

Radiographic examination of both thick samples "1 of 2" and "2 of 2" indicated uniformity of composition and density (see Fig. 6.9.4.2-2). Even after dehydration of thick sample "1 of 2," radioscopic examination indicated uniformity of composition and density. Initial neutron transmission results for both thick samples "1 of 2" and "2 of 2" indicated that neutron transmission was very low. In fact, the interference due to the hydrogen content implies an equivalent ^{10}B areal density measurement of ~67 ± 4 mg/cm^2. This is more than twice the actual physical value of 28.8 mg/cm^2. Only after thick sample of "1 of 2" is dehydrated and tested again do the results of neutron transmission measurements more accurately reflect the actual physical ^{10}B content. In fact, the average measured value of 27.419 mg/cm^2 at eleven points along the long axis of the dehydrated sample "1 of 2" is more than 95% of the actual physical value of 28.8 mg/cm^2 and varies no more than a few percent from one end to the other (see Tables 6.9.4.2-2 and 6.9.4.2-3).

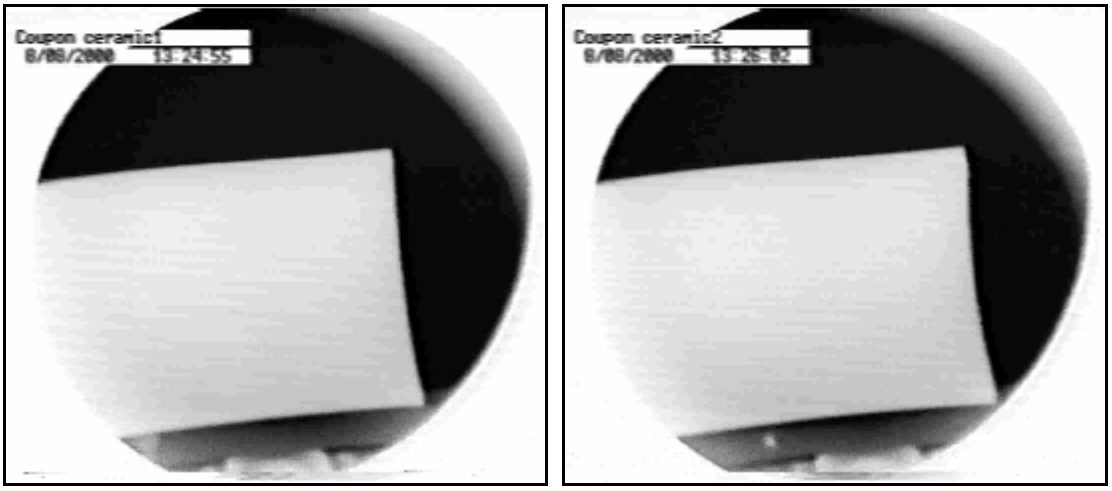


Fig. 6.9.4.2-2. Radiographic images of thick samples "1 of 2" (left) and "2 of 2" (right) indicating uniformity of composition and density.

Table 6.9.4.2-2. Results of neutron transmission measurements of thick samples

	Equivalent ^{10}B areal density (mg/cm^2)		
	End	**Center**	**End**
sample "1 of 2"	66.419	68.673	71.003
sample "2 of 2"	65.0	68.25	69.708
sample "1 of 2" (dehydrated)	27.586	27.191	28.555
sample "2 of 2" (re-test)	63.687	65.966	65.572

Table 6.9.4.2-3. Neutron transmission measurements of thick sample "1 of 2" after dehydration

Point of measurement (uniform intervals from one end to the other)	Equivalent ^{10}B areal density (mg/cm^2)	Deviation from average (%)
1	27.586	+0.6 %
2	26.909	-1.9 %
3	27.039	-1.4 %
4	27.358	-0.2 %
5	27.286	-0.5 %
6	27.191	-0.8 %
7	27.375	-0.2 %
8	27.179	-0.8 %
9	27.236	-0.7 %
10	27.897	-0.9 %
11	28.555	+4.1 %
Average	**27.419**	

Radiographic examination of both thin samples “062d1bc” and “062d1bd” indicates areas of nonuniformity and spots of lower neutron attenuation, along with greater dissimilarity between the samples themselves (see Fig. 6.9.4.2-3). Many of these areas and spots remained evident by radiographic examination even after dehydration of thin sample “062d1bc” and are attributed to physical voids revealed during visual inspection. Again, initial neutron transmission measurements implied a greater-than-actual equivalent ^{10}B areal density due to the interference of hydrogen (i.e., measured values averaged ~23.3 mg $^{10}B/cm^2$ rather than the actual value of 14.4 mg $^{10}B/cm^2$).

Measurements repeated after dehydration of sample “062d1bc” more correctly estimate the equivalent ^{10}B areal density to be ~11.1 mg/cm^2, which is ~77% of the actual physical ^{10}B content. Again, the relative values vary only a few percent from one end of the sample to the other (see Table 6.9.4.2-4). However, the measured values of a dehydrated sample in this case are known to be biased low. First, the total thicknesses of the ZrB_2 + Al reference coupons for calibration were ~24.21 to 24.98-mm compared to the 1.2-cm thickness of “062d1bc.” Second, the total mass density of the sample is ~1.4 to 1.5 g/cm^3 after dehydration compared to an Al mass density of ~2.7 g/cm^3 for the ZrB_2 + Al reference coupons. This indicates that even the performance of the thin samples (i.e., 1.2-cm thickness) exhibiting non-uniformity of composition and density is only marginally reduced from that of the idealized, homogeneous material model with respect to neutron absorber efficiency.

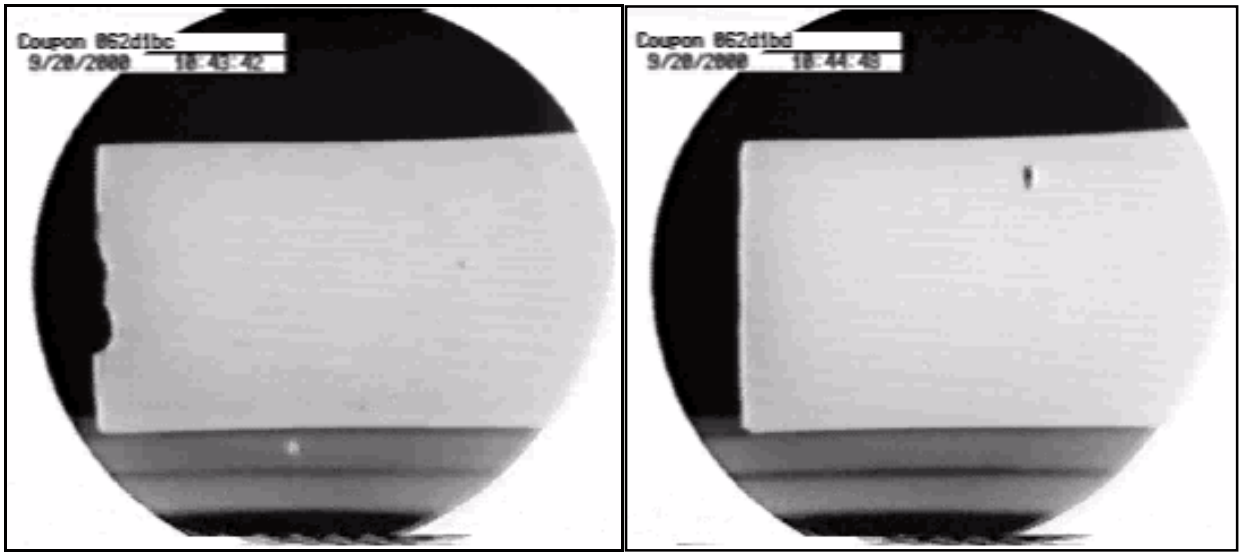


Fig. 6.9.4.2-3. Radiographic images of thin samples “062d1bc” (left) and “062d1bd” (right) indicating non-uniformity of composition and density and dissimilarity of samples.

Table 6.9.4.2-4. Neutron transmission results for dehydrated thin sample "062d1bc" and re-test of thin sample "062d1bd"

Position of measurement (see Fig. 6.9.4.2-4)	Minimum equivalent ^{10}B areal density (mg/cm^2)			
	Dehydrated thin sample "062d1bc"		Re-test of thin sample "062d1bd"	
	Line A	Line B	Line A	Line B
1	12.227	11.781	25.909	25.154
2	11.776	11.462	24.390	25.344
3	11.388	11.252	24.257	24.645
4	10.554	10.462	25.341	24.885
5	10.432	10.528	24.646	25.483
6	10.754	11.728	25.450	25.712
7	10.396	11.534	25.761	23.063
8	11.166	10.221	24.522	25.257
9	10.875	10.459	23.113	23.882
10	11.051	10.676	25.270	23.724
11	11.258	11.214	24.922	25.355
Combined average	**11.1**		**24.8**	

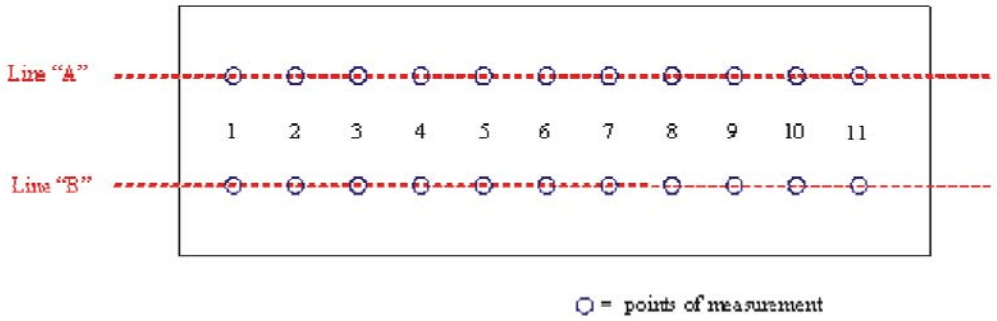


Fig. 6.9.4.2-4. Illustration of measurement plan for neutron transmission measurements of thin samples "062d1bc" and "062d1bd."

6.9.4.2.3 Conclusions

Provided that 277-4 is prepared in a controlled manner to ensure the proper specification and proportioning of batch constituents, thorough mixing of the wet slurry, and correct placement and installation to prevent large physical voids, a credible technical justification exists to credit no less than 75% of the $^{nat}B_4C$ particulate and its other constituents, by weight, as an idealized homogeneous mixture for nuclear criticality safety analysis of the ES-3100. There is no evidence of non-homogeneity, neutron self-shielding effects, or neutron streaming effects in borated hydraulic cement or ceramic material systems for thicknesses of 2.4-cm or more. The qualification of 277-4 for use in the design and construction of the ES-3100 described herein is based on sound nuclear engineering principles and direct application of performance test results for such material systems.

Appendix 6.9.5
Miscellaneous Information and Data

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Appendix 6.9.5
Miscellaneous Information and Data

Table 6.9.5.1 provides the atomic weights of the elements and isotopes of the materials used in this criticality safety evaluation. Atomic weights and isotopic weight percents of the naturally occurring materials are those taken from the Materials Information Processor in the SCALE Standard Composition Library.

Table 6.9.5.2 provides the molecular weights and weight percents of the corresponding elements and isotopes of the various compounds. The weight percents shown in this table are the input to KENO V.a (NUREG/CR-0200, Rev. 6).

Table 6.9.5.3 provides equations for determining atomic densities. These equations were derived based on the assumption that all constituents in the mixture are volume additive. Although these equations with their corresponding subscripts are for mixtures of elements, isotopes, or both, all except Equation (2) can be applied to compounds if the user substitutes certain subscript notations and meaning changes. For example, in Equations (1a) and (1b), the atomic weight becomes the molecular weight and the subscript "m" for mixture changes to the subscript "c" for compound. Likewise, in Equations (3a) and (3b), the atomic weight becomes the molecular weight, and the atom fraction (n_i) becomes the stoichiometric proportion of the elements making up the molecule. In Equations (3)–(5), the atom fraction (n_i) becomes the stoichiometric proportion (the element number subscript in the molecular formula), whose sum does not equal unity. Equation (2) is applicable only to the theoretical density of mixtures; it does not apply to the density of compounds.

Table 6.9.5.1. Atomic weights

Element or isotope	Atomic weight
H	1.0078
C	12.0000
O	15.9954
N	14.0033
Na	22.9895
Mg	24.3051
Al	26.9818
Si	28.0853
Ca	40.0803
Ti	47.8789
Cr	51.9957
Mn	54.9380
Fe	55.8447
Ni	58.6868
Zr	91.2196
^{235}U	235.0442
^{238}U	238.0510

Table 6.9.5.2. Molecular weights

Compound		Molecular or atomic weight	Weight percent in compound	Stoichiometric composition
Kaolite 1600™				
	Alumina	-	9.6	Al_2O_3
	Al	26.9818	52.92507	
	O	15.9954	47.07493	
	Silica	-	36.7	SiO_2
	Si	28.0853	46.74349	
	O	15.9954	53.25651	
	Ferric Oxide	-	6.7	Fe_2O_3
	Fe	55.8447	69.94330	
	O	15.9954	30.05670	
	Titanium Oxide	-	1.2	TiO_2
	Ti	47.8789	59.95084	
	O	15.9954	40.04916	
	Calcium Oxide	-	30.7	CaO
	Ca	40.0803	71.47009	
	O	15.9954	28.52991	
	Magnesium Oxide	-	13.1	MgO
	Mg	24.3051	60.30359	
	O	15.9954	39.69641	
	Alkalies	-	2.0	Na_2O
	Na	22.9895	74.18575	
	O	15.9954	25.81425	

Table 6.9.5.3. Useful equations

$$N_m = \rho_m N_o / A_m \quad (1a)$$

$$N_i = w_i \rho_m N_o / A_i \quad (1b)$$

$$\rho_m = 1/\Sigma w_i/\rho_i \quad (2)$$

$$A_m = 1/\Sigma w_i/A_i \quad (3a)$$

$$= \Sigma n_i A_i \quad (3b)$$

$$w_i = m_i/m_m \quad (4a)$$

$$= n_i A_i/\Sigma n_i A_i \quad (4b)$$

$$n_i = N_i/N_m \quad (5a)$$

$$= (w_i/A_i)/\Sigma(w_i/A_i) \quad (5b)$$

where

N_o = 0.602252×10^{24} (atoms/mol) Avogadro's number,
N = atom density (atoms/cm^3), $N_m = \Sigma N_i$,
ρ = density (g/cm^3),
A = atomic mass (g-mol),
w = weight fraction, $\Sigma w_i = 1$,
n = atom fraction, $\Sigma n_i = 1$,
subscript "m" = of the mixture,
subscript "i" = i^{th} component of the mixture,
(atoms/cm^3)$(1/10^{24})$ = atoms/barn-cm.

Appendix 6.9.6
Abridged Summary Tables of Criticality Calculation Results

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Appendix 6.9.6
Abridged Summary Tables of Criticality Calculation Results

This appendix contains the summary tables for calculation results identified in Sects. 6.4, 6.5, 6.6, and 6.7 of this document. The CV calculation model is a modification of the water-reflected, single-unit package calculation model where the packaging regions external to the containment vessel are replaced with full density water. The index is as follows:

Cylinder Content

Table 6.9.6-1. Results for the 3.24 in.-diam cylinder HEU content in CV calculation model.

Table 6.9.6-1a. Results for cylinder C and D HEU content in CV calculation model.

Table 6.9.6-2. Results for the 3.24 in.-diam cylinder HEU content in bare and water reflected package calculation models.

Table 6.9.6-2a. Results for cylinder C and D content in single package calculation model.

Table 6.9.6-3. Results for the 3.24-in.-diam cylinder HEU content in package calculation model.

Table 6.9.6-3b. Results for spacing of 3.24 in.-diam cylinder HEU metal content in CV calculation model.

Table 6.9.6-3c. Results for spacing of 3.24 in.-diam cylinder HEU metal content in packaging calculation model.

Table 6.9.6-3d. Results for cylinder C and D content in infinite array package calculation model.

Square Bar Content

Table 6.9.6-4. Results for the 2.29 in square bar HEU content in CV calculation model.

Table 6.9.6-5. Results for the 2.29 in square bar HEU content in packaging calculation model.

Cylinder Content

Table 6.9.6-6. Results for the 4.25 in.-diam cylinder HEU content in CV calculation model.

Table 6.9.6-7. Results for the 4.25 in.-diam cylinder HEU content in packaging calculation model.

Slugs Content

Table 6.9.6-8. Results for 1.5 in.-diam × 2.0-in.-tall slug HEU metal content in CV calculation model.

Table 6.9.6-9. Results for the 1.5 in.-diam × 2.0-in.-tall slug HEU metal content in packaging calculation model.

Broken Metal Content

Table 6.9.6-10. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in CV calculation model.

Table 6.9.6-10a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in CV calculation model.

Table 6.9.6-10b. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene with thorium in CV calculation model.

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model.

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model.

Table 6.9.6-11aa. Results for HEU content mixed with thorium (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model.

Table 6.9.6-11b. Comparison of NCT results for HEU broken metal content in ES-3100 NCT packaging calculation models.

Table 6.9.6-11c. Comparison of HAC results for HEU broken metal content in ES-3100 HAC packaging calculation models.

Table 6.9.6-11d. Comparison of results for the 277-4 canned spacer under the nominal and the minimal acceptance criteria for HEU broken metal content in ES-3100 HAC packaging calculation models.

HEU Product Oxide Content

Table 6.9.6-12. Results for low density HEU oxide content in CV calculation model.

Table 6.9.6-12a. Results for HEU oxide content with 500 g polyethylene in CV calculation model.

Table 6.9.6-12b. Results for HEU oxide/thorium oxide content with 500 g polyethylene in CV calculation model.

Table 6.9.6-12c. Results for HEU oxide/zirconium oxide content with 500 g polyethylene in CV calculation model.

Table 6.9.6-12d. Results for HEU oxide/thorium metal content with 500 g polyethylene in CV calculation model.

Table 6.9.6-13. Results for HEU product oxide content at 6.54 g/cm^3 in single-unit packaging calculation model.

Table 6.9.6-13a. Results for HEU oxide content in single-unit packaging calculation model.

Table 6.9.6-13b. Results for HEU oxide content in array packaging calculation model.

Table 6.9.6-13c. Results for low density HEU oxide content in single unit packaging calculation model.

Table 6.9.6-13d. Results for low density HEU oxide content in array packaging calculation model.

Table 6.9.6-13e. Results for HEU oxide/thorium oxide content in single-unit packaging calculation model.

Table 6.9.6-13f. Results for HEU oxide/zirconium oxide content in single-unit packaging calculation model.

Table 6.9.6-13g. Results for HEU oxide/thorium metal content in single-unit packaging calculation model.

Table 6.9.6-13h. Results for HEU oxide/thorium oxide content in array packaging calculation model.

Table 6.9.6-13i. Results for HEU oxide/zirconium oxide content in array packaging calculation model.

Table 6.9.6-13j. Results for HEU oxide/thorium metal content in array packaging calculation model.

UNX Crystal Content

Table 6.9.6-14. Results for UNX crystal content in CV calculation model.

Table 6.9.6-15. Results for UNX crystal content in packaging calculation model.

Table 6.9.6-16. Results for leakage of UNX crystal content out of containment vessel.

HEU Skull Oxide Content

Table 6.9.6-17. Results for skull oxide (SO) content in CV calculation model.

Table 6.9.6-18a. NCT results for skull oxide (SO) content in packaging calculation model.

Table 6.9.6-18b. HAC results for skull oxide (SO) content in packaging calculation model.

Unirradiated TRIGA Reactor Fuel Element Content

Table 6.9.6-19a. Results for $UZrH_x$ content in CV calculation model.

Table 6.9.6-19b. Results for $UZrH_x$ content spacing in CV calculation model.

Table 6.9.6-19c. Results for $UZrH_x$ content uranium weight fraction in CV calculation model.

Table 6.9.6-20a. Results for $UZrH_x$ content at 19.7 wt % ^{235}U in packaging calculation model.

Table 6.9.6-20b. Results for $UZrH_x$ content at 70.1 wt % ^{235}U in packaging calculation model.

Table 6.9.6-20c. Results for 1.31 in. smaller diameter $UZrH_x$ at 70.1 wt % ^{235}U content in packaging calculation model.

Table 6.9.6-20d. Results for 1.31 in. smaller diameter $UZrH_x$ at 19.7 wt % ^{235}U content in packaging calculation model.

Air Transport Content

Table 6.9.6-21. Results for solid HEU metal content for air transportation.

Table 6.9.6-22a. Results for TRIGA ($UZrH_x$) fuel element content at 19.7 wt % ^{235}U for air transportation.

Table 6.9.6-22b. Results for TRIGA ($UZrH_x$) fuel element content at 70.1 wt % ^{235}U for air transportation.

Table 6.9.6-22c. Results for research reactor fuel (U_3O_8-Al) content for air transportation.

Table 6.9.6-22d. Results for research reactor fuel (UO_2-Mg) content for air transportation.

Table 6.9.6-23. Results for HEU broken metal content for air transportation.

Table 6.9.6-24a. Results for compounds content for air transportation (Models 1-5).

Table 6.9.6-24b. Results for compounds content for air transportation (Model 6).

Table 6.9.6-1. Results for 3.24 in.-diam cylinder HEU metal content in CV calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
flooded containment vessel, reflected									
no can spacers (np thickness = 0.0 in.)									
cvcrcyt11_36_1_1	0.0	36000	36000	0	0.00	1.0E-20	0.90460	0.00107	0.90673
cvcrcyt11_36_1_6	0.0	36000	36000	829	0.60	1.0E-01	0.90726	0.00124	0.90973
cvcrcyt11_36_1_7	0.0	36000	36000	1657	1.20	2.0E-01	0.91182	0.00120	0.91422
cvcrcyt11_36_1_8	0.0	36000	36000	2486	1.80	3.0E-01	0.91690	0.00139	0.91967
cvcrcyt11_36_1_9	0.0	36000	36000	3315	2.40	4.0E-01	0.92263	0.00119	0.92500
cvcrcyt11_36_1_10	0.0	36000	36000	4143	3.00	5.0E-01	0.92840	0.00115	0.93071
cvcrcyt11_36_1_11	0.0	36000	36000	4972	3.60	6.0E-01	0.93827	0.00112	0.94050
cvcrcyt11_36_1_12	0.0	36000	36000	5801	4.21	7.0E-01	0.94633	0.00127	0.94886
cvcrcyt11_36_1_13	0.0	36000	36000	6629	4.81	8.0E-01	0.95397	0.00120	0.95636
cvcrcyt11_36_1_14	0.0	36000	36000	7458	5.41	9.0E-01	0.96276	0.00137	0.96551
cvcrcyt11_36_1_15	0.0	36000	36000	8287	6.01	1.0E+00	0.97121	0.00125	0.97371
cvcrcyt11_36_1	0.0	36000	36000	8287	6.01	1.0E+00	0.97121	0.00125	0.97371
cvcrcyt11_35_1	0.0	35000	35000	8340	6.22	1.0E+00	0.96937	0.00120	0.97177
cvcrcyt11_34_1	0.0	34000	34000	8393	6.44	1.0E+00	0.96886	0.00120	0.97126
cvcrcyt11_33_1	0.0	33000	33000	8446	6.68	1.0E+00	0.96531	0.00111	0.96754
cvcrcyt11_32_1	0.0	32000	32000	8499	6.93	1.0E+00	0.96360	0.00120	0.96600
cvcrcyt11_31_1	0.0	31000	31000	8552	7.20	1.0E+00	0.95960	0.00122	0.96205
cvcrcyt11_30_1	0.0	30000	30000	8605	7.49	1.0E+00	0.95842	0.00128	0.96097
cvcrcyt11_29_1	0.0	29000	29000	8658	7.79	1.0E+00	0.95488	0.00115	0.95717
cvcrcyt11_28_1	0.0	28000	28000	8711	8.12	1.0E+00	0.95409	0.00118	0.95645
cvcrcyt11_27_1	0.0	27000	27000	8764	8.47	1.0E+00	0.94797	0.00113	0.95023
cvcrcyt11_26_1	0.0	26000	26000	8817	8.85	1.0E+00	0.94376	0.00124	0.94623

Table 6.9.6-1. Results for 3.24 in.-diam cylinder HEU metal content in CV calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrcyt11_25_1	0.0	25000	25000	8870	9.26	1.0E+00	0.94075	0.00141	0.94357
cvcrcyt11_24_1	0.0	24000	24000	8923	9.70	1.0E+00	0.93510	0.00133	0.93776
cvcrcyt11_23_1	0.0	23000	23000	8977	10.19	1.0E+00	0.93038	0.00130	0.93298
cvcrcyt11_22_1	0.0	22000	22000	9030	10.71	1.0E+00	0.92658	0.00106	0.92870
cvcrcyt11_21_1	0.0	21000	21000	9083	11.29	1.0E+00	0.92046	0.00118	0.92282
cvcrcyt11_21_1(n)	0.0	21000	21000	9083	11.29	1.0E+00	0.92680	0.00056	0.92792
cvcrcyt11p_21_1	0.0	21000	21000	9083	11.29	1.0E+00	0.91355	0.00071	0.91497
cvcrcyt11_20_1	0.0	20000	20000	9136	11.92	1.0E+00	0.91168	0.00125	0.91418
cvcrcyt11_19_1	0.0	19000	19000	9189	12.62	1.0E+00	0.90618	0.00128	0.90874
cvcrcyt11_18_1	0.0	18000	18000	9242	13.40	1.0E+00	0.89978	0.00124	0.90226
with can spacers (np thickness=1.4 in.)									
cvcrcyt11_36_2_1	1.4	36000	36000	0	0.00	1.0E-20	0.83041	0.00103	0.83248
cvcrcyt11_36_2_6	1.4	36000	36000	767	0.56	1.0E-01	0.82885	0.00106	0.83096
cvcrcyt11_36_2_7	1.4	36000	36000	1535	1.11	2.0E-01	0.83022	0.00104	0.83230
cvcrcyt11_36_2_8	1.4	36000	36000	2302	1.67	3.0E-01	0.83492	0.00104	0.83699
cvcrcyt11_36_2_9	1.4	36000	36000	3069	2.23	4.0E-01	0.84066	0.00123	0.84311
cvcrcyt11_36_2_10	1.4	36000	36000	3837	2.78	5.0E-01	0.84789	0.00102	0.84993
cvcrcyt11_36_2_11	1.4	36000	36000	4604	3.34	6.0E-01	0.85423	0.00101	0.85624
cvcrcyt11_36_2_12	1.4	36000	36000	5371	3.89	7.0E-01	0.86190	0.00106	0.86403
cvcrcyt11_36_2_13	1.4	36000	36000	6139	4.45	8.0E-01	0.86687	0.00118	0.86923
cvcrcyt11_36_2_14	1.4	36000	36000	6906	5.01	9.0E-01	0.87589	0.00113	0.87816
cvcrcyt11_36_2_15	1.4	36000	36000	7673	5.56	1.0E+00	0.88436	0.00111	0.88657
cvcrcyt11_36_2	1.4	36000	36000	7673	5.56	1.0E+00	0.88436	0.00111	0.88657
cvcrcyt11_36_2(n)	1.4	36000	36000	7673	5.56	1.0E+00	0.88803	0.00064	0.88931

Table 6.9.6-1. Results for 3.24 in.-diam cylinder HEU metal content in CV calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrcyt11p_36_2	1.4	36000	36000	7673	5.56	1.0E+00	0.88486	0.00062	0.88610
cvcrcyt11_35_2	1.4	35000	35000	7726	5.76	1.0E+00	0.88274	0.00108	0.88491
cvcrcyt11_34_2	1.4	34000	34000	7779	5.97	1.0E+00	0.87740	0.00119	0.87977
cvcrcyt11_33_2	1.4	33000	33000	7832	6.19	1.0E+00	0.87234	0.00112	0.87459
cvcrcyt11_32_2	1.4	32000	32000	7885	6.43	1.0E+00	0.86817	0.00108	0.87033
cvcrcyt11_31_2	1.4	31000	31000	7938	6.68	1.0E+00	0.86047	0.00124	0.86295
cvcrcyt11_30_2	1.4	30000	30000	7992	6.95	1.0E+00	0.85525	0.00117	0.85760
flooded containment vessel, reflected, no can spacers (np thickness = 0.0 in.)									
no polyethylene									
cvcrcyt11_21_1	0.0	21000	21000	9083	11.29	1.0E+00	0.92046	0.00118	0.92282
500 g polyethylene									
cvcrpcyt11_21_1	0.0	21000	21000	8540	11.41	1.0E+00	0.90599	0.00107	0.90814
dry containment vessel, reflected, no can spacers (np thickness = 0.0 in.)									
500 g polyethylene									
cvdcrpcyt11_21_1	0.0	21000	21000	0	0.80	1.0E+00	0.84505	0.00105	0.84716

Table 6.9.6-1a. Results for cylinder C and D content in CV calculation model, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrcylc	cylinder C modeled at bottom of CV	0.82909	0.00064	0.83037
cvcrclycc	cylinder C modeled centered of CV	0.83511	0.00067	0.83645
cvcrcyld	cylinder D modeled at bottom of CV	0.84347	0.00061	0.84469
cvcrclydc	cylinder D modeled centered of CV	0.84440	0.00059	0.84558

Table 6.9.6-2. Results for 3.24 in.-diam cylinder HEU metal content in bare and water reflected packaging calculation models

Case	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	NLF	k_{eff}	σ	$k_{eff}+2\sigma$	Case	NLF	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded CV, single package bare										**content in flooded CV, single package reflected**				
no can spacers (np thickness = 0.0 in.)										**no can spacers (np thickness = 0.0 in.)**				
ncsbcyt11_36_1_1	36000	36000	8287	6.01	1.0E-20	0.4744	0.90856	0.00115	0.91087	ncsrcyt11_36_1_1	0.0021	0.91542	0.00120	0.91782
ncsbcyt11_36_1_2	36000	36000	8287	6.01	1.0E-05	0.4749	0.90825	0.00100	0.91026	ncsrcyt11_36_1_2	0.0021	0.91477	0.00123	0.91724
ncsbcyt11_36_1_3	36000	36000	8287	6.01	1.0E-04	0.4747	0.90817	0.00121	0.91059	ncsrcyt11_36_1_3	0.0022	0.91550	0.00111	0.91772
ncsbcyt11_36_1_4	36000	36000	8287	6.01	1.0E-03	0.4744	0.90926	0.00134	0.91194	ncsrcyt11_36_1_4	0.0022	0.91636	0.00117	0.91869
ncsbcyt11_36_1_5	36000	36000	8287	6.01	1.0E-02	0.4730	0.90883	0.00108	0.91100	ncsrcyt11_36_1_5	0.0022	0.91537	0.00109	0.91755
ncsbcyt11_36_1_6	36000	36000	8287	6.01	1.0E-01	0.4510	0.91550	0.00112	0.91774	ncsrcyt11_36_1_6	0.0019	0.92121	0.00133	0.92386
ncsbcyt11_36_1_8	36000	36000	8287	6.01	3.0E-01	0.3899	0.92546	0.00134	0.92814	ncsrcyt11_36_1_8	0.0016	0.92807	0.00112	0.93032
ncsbcyt11_36_1_15	36000	36000	8287	6.01	1.0E+00	0.1823	0.95215	0.00119	0.95454	ncsrcyt11_36_1_15	0.0007	0.95213	0.00129	0.95472
ncsbcyt11_36_1_15	36000	36000	8287	6.01	1.0E+00	0.1823	0.95215	0.00119	0.95454	ncsrcyt11_36_1_15	0.0007	0.95213	0.00129	0.95472
ncsbcyt11_35_1_15	35000	35000	8340	6.22	1.0E+00	0.1838	0.94834	0.00122	0.95077	ncsrcyt11_35_1_15	0.0008	0.94870	0.00107	0.95083
ncsbcyt11_34_1_15	34000	34000	8393	6.44	1.0E+00	0.1842	0.94748	0.00113	0.94975	ncsrcyt11_34_1_15	0.0008	0.94742	0.00124	0.94990
ncsbcyt11_33_1_15	33000	33000	8446	6.68	1.0E+00	0.1853	0.94613	0.00118	0.94850	ncsrcyt11_33_1_15	0.0008	0.94478	0.00119	0.94716
ncsbcyt11_32_1_15	32000	32000	8499	6.93	1.0E+00	0.1863	0.94237	0.00106	0.94448	ncsrcyt11_32_1_15	0.0007	0.94247	0.00111	0.94468
ncsbcyt11_31_1_15	31000	31000	8552	7.20	1.0E+00	0.1867	0.94052	0.00106	0.94264	ncsrcyt11_31_1_15	0.0008	0.94091	0.00107	0.94306
ncsbcyt11_30_1_15	30000	30000	8605	7.49	1.0E+00	0.1882	0.93819	0.00110	0.94039	ncsrcyt11_30_1_15	0.0007	0.94139	0.00137	0.94412
ncsbcyt11_29_1_15	29000	29000	8658	7.79	1.0E+00	0.1894	0.93483	0.00104	0.93692	ncsrcyt11_29_1_15	0.0007	0.93406	0.00108	0.93622
ncsbcyt11_28_1_15	28000	28000	8711	8.12	1.0E+00	0.1894	0.93339	0.00102	0.93543	ncsrcyt11_28_1_15	0.0008	0.93012	0.00124	0.93261
ncsbcyt11_27_1_15	27000	27000	8764	8.47	1.0E+00	0.1911	0.92636	0.00112	0.92860	ncsrcyt11_27_1_15	0.0008	0.92820	0.00122	0.93064
ncsbcyt11_26_1_15	26000	26000	8817	8.85	1.0E+00	0.1919	0.92366	0.00115	0.92597	ncsrcyt11_26_1_15	0.0008	0.92396	0.00141	0.92679
ncsbcyt11_25_1_15	25000	25000	8870	9.26	1.0E+00	0.1928	0.92122	0.00122	0.92366	ncsrcyt11_25_1_15	0.0008	0.91761	0.00102	0.91966
ncsbcyt11_24_1_15	24000	24000	8923	9.70	1.0E+00	0.1948	0.91432	0.00108	0.91648	ncsrcyt11_24_1_15	0.0008	0.91466	0.00107	0.91680
ncsbcyt11_23_1_15	23000	23000	8977	10.19	1.0E+00	0.1965	0.91055	0.00130	0.91314	ncsrcyt11_23_1_15	0.0008	0.91172	0.00116	0.91403

Table 6.9.6-2. Results for 3.24 in.-diam cylinder HEU metal content in bare and water reflected packaging calculation models

Case	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	NLF	k_{eff}	σ	$k_{eff}+2\sigma$	Case	NLF	k_{eff}	σ	$k_{eff}+2\sigma$
ncsbcyt11_22_1_15	22000	22000	9030	10.71	1.0E+00	0.1969	0.90695	0.00121	0.90936	ncsrcyt11_22_1_15	0.0008	0.90680	0.00153	0.90986
ncsbcyt11_21_1_15	21000	21000	9083	11.29	1.0E+00	0.1984	0.90241	0.00124	0.90490	ncsrcyt11_21_1_15	0.0009	0.90125	0.00113	0.90352
ncsbcyt11_20_1_15	20000	20000	9136	11.92	1.0E+00	0.2007	0.89477	0.00125	0.89726	ncsrcyt11_20_1_15	0.0009	0.89481	0.00109	0.89698
ncsbcyt11_19_1_15	19000	19000	9189	12.62	1.0E+00	0.2026	0.88819	0.00113	0.89044	ncsrcyt11_19_1_15	0.0008	0.88857	0.00136	0.89129
ncsbcyt11_18_1_15	18000	18000	9242	13.40	1.0E+00	0.2037	0.88255	0.00126	0.88507	ncsrcyt11_18_1_15	0.0008	0.88157	0.00127	0.88410
with can spacers (np thickness = 1.4 in.)										**with can spacers (np thickness = 1.4 in.)**				
ncsbcyt11_36_2_1	36000	36000	7673	5.56	1.0E-20	0.4882	0.83390	0.00106	0.83603	ncsrcyt11_36_2_1	0.0022	0.83904	0.00110	0.84125
ncsbcyt11_36_2_2	36000	36000	7673	5.56	1.0E-05	0.4879	0.83481	0.00142	0.83764	ncsrcyt11_36_2_2	0.0021	0.84122	0.00110	0.84342
ncsbcyt11_36_2_3	36000	36000	7673	5.56	1.0E-04	0.4883	0.83383	0.00100	0.83583	ncsrcyt11_36_2_3	0.0022	0.84013	0.00106	0.84225
ncsbcyt11_36_2_4	36000	36000	7673	5.56	1.0E-03	0.4880	0.83530	0.00126	0.83783	ncsrcyt11_36_2_4	0.0022	0.84001	0.00112	0.84224
ncsbcyt11_36_2_5	36000	36000	7673	5.56	1.0E-02	0.4861	0.83461	0.00120	0.83702	ncsrcyt11_36_2_5	0.0021	0.84128	0.00115	0.84359
ncsbcyt11_36_2_6	36000	36000	7673	5.56	1.0E-01	0.4642	0.83979	0.00110	0.84199	ncsrcyt11_36_2_6	0.0020	0.84524	0.00116	0.84755
ncsbcyt11_36_2_8	36000	36000	7673	5.56	3.0E-01	0.4000	0.84736	0.00123	0.84982	ncsrcyt11_36_2_8	0.0016	0.84947	0.00103	0.85153
ncsbcyt11_36_2_15	36000	36000	7673	5.56	1.0E+00	0.1881	0.87048	0.00109	0.87266	ncsrcyt11_36_2_15	0.0008	0.87062	0.00122	0.87305
ncsbcyt11_36_2_15	36000	36000	7673	5.56	1.0E+00	0.1881	0.87048	0.00109	0.87266	ncsrcyt11_36_2_15	0.0008	0.87062	0.00122	0.87305
ncsbcyt11_35_2_15	35000	35000	7726	5.76	1.0E+00	0.1879	0.86609	0.00114	0.86836	ncsrcyt11_35_2_15	0.0007	0.86649	0.00118	0.86886
ncsbcyt11_34_2_15	34000	34000	7779	5.97	1.0E+00	0.1885	0.86151	0.00103	0.86358	ncsrcyt11_34_2_15	0.0008	0.86038	0.00129	0.86296
ncsbcyt11_33_2_15	33000	33000	7832	6.19	1.0E+00	0.1901	0.85729	0.00099	0.85927	ncsrcyt11_33_2_15	0.0007	0.85903	0.00106	0.86115
ncsbcyt11_32_2_15	32000	32000	7885	6.43	1.0E+00	0.1908	0.85350	0.00116	0.85582	ncsrcyt11_32_2_15	0.0007	0.85357	0.00108	0.85573
ncsbcyt11_31_2_15	31000	31000	7938	6.68	1.0E+00	0.1922	0.84914	0.00108	0.85129	ncsrcyt11_31_2_15	0.0008	0.84895	0.00123	0.85142
ncsbcyt11_30_2_15	30000	30000	7992	6.95	1.0E+00	0.1913	0.84250	0.00100	0.84450	ncsrcyt11_30_2_15	0.0008	0.84343	0.00114	0.84572

Table 6.9.6-2a. Results for cylinder C and D content in single package calculation model, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsrcylc11	Cylinder C modeled at bottom of CV	0.80138	0.00062	0.80262	hcsrcylc12	0.80400	0.00058	0.80516
ncsrcylcc11	Cylinder C modeled centered of CV	0.80765	0.00061	0.80887	hcsrcylcc12	0.80930	0.00056	0.81042
ncsrcyld11	Cylinder D modeled at bottom of CV	0.81420	0.00062	0.81544	hcsrcyld12	0.81530	0.00061	0.81652
ncsrcyldc11	Cylinder D modeled centered of CV	0.81812	0.00064	0.81940	hcsrcyldc12	0.81814	0.00062	0.81938
ncsrcyldala11	Cylinder D with 0.01" aluminum cladding	0.81160	0.00061	0.81282				
ncsrcyldala11	Cylinder D with 0.1" aluminum cladding	0.79651	0.00056	0.79763				
ncsrcyldala11	Cylinder D with 0.25" aluminum cladding	0.77137	0.00065	0.77267				

Table 6.9.6-3. Results for 3.24 in.-diam cylinder HEU metal content in packaging calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded containment vessel, single package reflected													
NCT										**HAC**			
no can spacers (np thickness = 0.0 in.)													
ncsrcyt11_36_1_1	0.0	36000	36000	8287	6.01	1.0E-20	0.91542	0.00120	0.91782	hcsrcyt12_36_1_1	0.91636	0.00117	0.91869
ncsrcyt11_36_1_2	0.0	36000	36000	8287	6.01	1.0E-05	0.91477	0.00123	0.91724	hcsrcyt12_36_1_2	0.91593	0.00138	0.91869
ncsrcyt11_36_1_3	0.0	36000	36000	8287	6.01	1.0E-04	0.91550	0.00111	0.91772	hcsrcyt12_36_1_3	0.91660	0.00134	0.91929
ncsrcyt11_36_1_4	0.0	36000	36000	8287	6.01	1.0E-03	0.91636	0.00117	0.91869	hcsrcyt12_36_1_4	0.91565	0.00122	0.91810
ncsrcyt11_36_1_5	0.0	36000	36000	8287	6.01	1.0E-02	0.91537	0.00109	0.91755	hcsrcyt12_36_1_5	0.91489	0.00120	0.91729
ncsrcyt11_36_1_6	0.0	36000	36000	8287	6.01	1.0E-01	0.92121	0.00133	0.92386	hcsrcyt12_36_1_6	0.92198	0.00104	0.92407
ncsrcyt11_36_1_8	0.0	36000	36000	8287	6.01	3.0E-01	0.92807	0.00112	0.93032	hcsrcyt12_36_1_8	0.92950	0.00125	0.93201
ncsrcyt11_36_1_15	0.0	36000	36000	8287	6.01	1.0E+00	0.95213	0.00129	0.95472	hcsrcyt12_36_1_15	0.95112	0.00120	0.95353

Table 6.9.6-3. Results for 3.24 in.-diam cylinder HEU metal content in packaging calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsrcyt11_36_1_15	0.0	36000	36000	8287	6.01	1.0E+00	0.95213	0.00129	0.95472	hcsrcyt12_36_1_15	0.95112	0.00120	0.95353
ncsrcyt11_35_1_15	0.0	35000	35000	8340	6.22	1.0E+00	0.94870	0.00107	0.95083	hcsrcyt12_35_1_15	0.94915	0.00120	0.95155
ncsrcyt11_34_1_15	0.0	34000	34000	8393	6.44	1.0E+00	0.94742	0.00124	0.94990	hcsrcyt12_34_1_15	0.94863	0.00113	0.95088
ncsrcyt11_33_1_15	0.0	33000	33000	8446	6.68	1.0E+00	0.94478	0.00119	0.94716	hcsrcyt12_33_1_15	0.94610	0.00123	0.94856
ncsrcyt11_32_1_15	0.0	32000	32000	8499	6.93	1.0E+00	0.94247	0.00111	0.94468	hcsrcyt12_32_1_15	0.94528	0.00141	0.94810
ncsrcyt11_31_1_15	0.0	31000	31000	8552	7.20	1.0E+00	0.94091	0.00107	0.94306	hcsrcyt12_31_1_15	0.94090	0.00107	0.94304
ncsrcyt11_30_1_15	0.0	30000	30000	8605	7.49	1.0E+00	0.94139	0.00137	0.94412	hcsrcyt12_30_1_15	0.94035	0.00120	0.94275
ncsrcyt11_29_1_15	0.0	29000	29000	8658	7.79	1.0E+00	0.93406	0.00108	0.93622	hcsrcyt12_29_1_15	0.93540	0.00112	0.93765
ncsrcyt11_28_1_15	0.0	28000	28000	8711	8.12	1.0E+00	0.93012	0.00124	0.93261	hcsrcyt12_28_1_15	0.93239	0.00118	0.93475
ncsrcyt11_27_1_15	0.0	27000	27000	8764	8.47	1.0E+00	0.92820	0.00122	0.93064	hcsrcyt12_27_1_15	0.93043	0.00144	0.93331
ncsrcyt11_26_1_15	0.0	26000	26000	8817	8.85	1.0E+00	0.92396	0.00141	0.92679	hcsrcyt12_26_1_15	0.92632	0.00119	0.92870
ncsrcyt11_25_1_15	0.0	25000	25000	8870	9.26	1.0E+00	0.91761	0.00102	0.91966	hcsrcyt12_25_1_15	0.92218	0.00109	0.92436
ncsrcyt11_24_1_15	0.0	24000	24000	8923	9.70	1.0E+00	0.91466	0.00107	0.91680	hcsrcyt12_24_1_15	0.91688	0.00117	0.91922
ncsrcyt11_23_1_15	0.0	23000	23000	8977	10.19	1.0E+00	0.91172	0.00116	0.91403	hcsrcyt12_23_1_15	0.91134	0.00119	0.91371
ncsrcyt11_22_1_15	0.0	22000	22000	9030	10.71	1.0E+00	0.90680	0.00153	0.90986	hcsrcyt12_22_1_15	0.90850	0.00113	0.91077
ncsrcyt11_21_1_15	0.0	21000	21000	9083	11.29	1.0E+00	0.90125	0.00113	0.90352	hcsrcyt12_21_1_15	0.90188	0.00124	0.90437
ncsrcyt11_21_1_15(n)	0.0	21000	21000	9083	11.29	1.0E+00	0.90427	0.00067	0.90561	hcsrcyt12_21_1_15(n)	0.90663	0.00056	0.90775
ncsrcyt11p_21_1_15	0.0	21000	21000	9083	11.29	1.0E+00	0.89441	0.00060	0.89561	hcsrcyt12p_21_1_15	0.89464	0.00057	0.89578
ncsrcyt11_20_1_15	0.0	20000	20000	9136	11.92	1.0E+00	0.89481	0.00109	0.89698	hcsrcyt12_20_1_15	0.89612	0.00115	0.89842
ncsrcyt11_19_1_15	0.0	19000	19000	9189	12.62	1.0E+00	0.88857	0.00136	0.89129	hcsrcyt12_19_1_15	0.89080	0.00122	0.89323
ncsrcyt11_18_1_15	0.0	18000	18000	9242	13.40	1.0E+00	0.88157	0.00127	0.88410	hcsrcyt12_18_1_15	0.88276	0.00128	0.88532
with can spacers (np thickness = 1.4 in.)													
ncsrcyt11_36_2_1	1.4	36000	36000	7673	5.56	1.0E-20	0.83904	0.00110	0.84125	hcsrcyt12_36_2_1	0.84250	0.00103	0.84456
ncsrcyt11_36_2_2	1.4	36000	36000	7673	5.56	1.0E-05	0.84122	0.00110	0.84342	hcsrcyt12_36_2_2	0.84146	0.00118	0.84382

Table 6.9.6-3. Results for 3.24 in.-diam cylinder HEU metal content in packaging calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsrcyt11_36_2_3	1.4	36000	36000	7673	5.56	1.0E-04	0.84013	0.00106	0.84225	hcsrcyt12_36_2_3	0.84182	0.00105	0.84392
ncsrcyt11_36_2_4	1.4	36000	36000	7673	5.56	1.0E-03	0.84001	0.00112	0.84224	hcsrcyt12_36_2_4	0.83975	0.00103	0.84181
ncsrcyt11_36_2_5	1.4	36000	36000	7673	5.56	1.0E-02	0.84128	0.00115	0.84359	hcsrcyt12_36_2_5	0.84070	0.00129	0.84328
ncsrcyt11_36_2_6	1.4	36000	36000	7673	5.56	1.0E-01	0.84524	0.00116	0.84755	hcsrcyt12_36_2_6	0.84484	0.00127	0.84738
ncsrcyt11_36_2_8	1.4	36000	36000	7673	5.56	3.0E-01	0.84947	0.00103	0.85153	hcsrcyt12_36_2_8	0.85159	0.00102	0.85364
ncsrcyt11_36_2_15	1.4	36000	36000	7673	5.56	1.0E+00	0.87062	0.00122	0.87305	hcsrcyt12_36_2_15	0.87110	0.00117	0.87344
ncsrcyt11_36_2_15	1.4	36000	36000	7673	5.56	1.0E+00	0.87062	0.00122	0.87305	hcsrcyt12_36_2_15	0.87110	0.00117	0.87344
ncsrcyt11_36_2_15(n)	1.4	36000	36000	7673	5.56	1.0E+00	0.87298	0.00060	0.87418	hcsrcyt12_36_2_15(n)	0.87412	0.00061	0.87534
ncsrcyt11p_36_2_15	1.4	36000	36000	7673	5.56	1.0E+00	0.86916	0.00062	0.87040	hcsrcyt12p_36_2_15	0.86907	0.00067	0.87041
ncsrcyt11_35_2_15	1.4	35000	35000	7726	5.76	1.0E+00	0.86649	0.00118	0.86886	hcsrcyt12_35_2_15	0.86666	0.00110	0.86886
ncsrcyt11_34_2_15	1.4	34000	34000	7779	5.97	1.0E+00	0.86038	0.00129	0.86296	hcsrcyt12_34_2_15	0.86109	0.00117	0.86343
ncsrcyt11_33_2_15	1.4	33000	33000	7832	6.19	1.0E+00	0.85903	0.00106	0.86115	hcsrcyt12_33_2_15	0.86022	0.00123	0.86267
ncsrcyt11_32_2_15	1.4	32000	32000	7885	6.43	1.0E+00	0.85357	0.00108	0.85573	hcsrcyt12_32_2_15	0.85544	0.00096	0.85736
ncsrcyt11_31_2_15	1.4	31000	31000	7938	6.68	1.0E+00	0.84895	0.00123	0.85142	hcsrcyt12_31_2_15	0.84745	0.00105	0.84956
ncsrcyt11_30_2_15	1.4	30000	30000	7992	6.95	1.0E+00	0.84343	0.00114	0.84572	hcsrcyt12_30_2_15	0.84390	0.00112	0.84615
content in flooded containment vessel, array packaging model for CSI=0.0													
NCT										**HAC**			
no can spacers (np thickness = 0.0 in.)													
nciacyt11_36_1_1	0.0	36000	36000	8287	6.01	1.0E-20	1.02410	0.00125	1.02660	hciacyt12_36_1_1	1.02427	0.00120	1.02667
nciacyt11_36_1_2	0.0	36000	36000	8287	6.01	1.0E-05	1.02380	0.00124	1.02628	hciacyt12_36_1_2	1.02384	0.00130	1.02644
nciacyt11_36_1_3	0.0	36000	36000	8287	6.01	1.0E-04	1.02208	0.00111	1.02430	hciacyt12_36_1_3	1.02390	0.00135	1.02660
nciacyt11_36_1_4	0.0	36000	36000	8287	6.01	1.0E-03	1.02276	0.00134	1.02545	hciacyt12_36_1_4	1.02441	0.00122	1.02684
nciacyt11_36_1_5	0.0	36000	36000	8287	6.01	1.0E-02	1.01749	0.00124	1.01997	hciacyt12_36_1_5	1.01867	0.00114	1.02094
nciacyt11_36_1_6	0.0	36000	36000	8287	6.01	1.0E-01	0.98560	0.00118	0.98797	hciacyt12_36_1_6	0.98825	0.00112	0.99048

Table 6.9.6-3. Results for 3.24 in.-diam cylinder HEU metal content in packaging calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciacyt11_36_1_8	0.0	36000	36000	8287	6.01	3.0E-01	0.96228	0.00116	0.96461	hciacyt12_36_1_8	0.96519	0.00122	0.96763
nciacyt11_36_1_15	0.0	36000	36000	8287	6.01	1.0E+00	0.96088	0.00119	0.96326	hciacyt12_36_1_15	0.96417	0.00119	0.96655
nciacyt11_36_1_3	0.0	36000	36000	8287	6.01	1.0E-04	1.02208	0.00111	1.02430	hciacyt12_36_1_3	1.02390	0.00135	1.02660
nciacyt11_35_1_3	0.0	35000	35000	8340	6.22	1.0E-04	1.01930	0.00118	1.02166	hciacyt12_35_1_3	1.01912	0.00127	1.02165
nciacyt11_34_1_3	0.0	34000	34000	8393	6.44	1.0E-04	1.01654	0.00130	1.01914	hciacyt12_34_1_3	1.01860	0.00104	1.02068
nciacyt11_33_1_3	0.0	33000	33000	8446	6.68	1.0E-04	1.01121	0.00116	1.01353	hciacyt12_33_1_3	1.01077	0.00142	1.01361
nciacyt11_32_1_3	0.0	32000	32000	8499	6.93	1.0E-04	1.00876	0.00134	1.01144	hciacyt12_32_1_3	1.00943	0.00114	1.01171
nciacyt11_31_1_3	0.0	31000	31000	8552	7.20	1.0E-04	1.00544	0.00116	1.00777	hciacyt12_31_1_3	1.00148	0.00102	1.00353
nciacyt11_30_1_3	0.0	30000	30000	8605	7.49	1.0E-04	0.99921	0.00131	1.00182	hciacyt12_30_1_3	0.99963	0.00138	1.00238
nciacyt11_29_1_3	0.0	29000	29000	8658	7.79	1.0E-04	0.99494	0.00121	0.99736	hciacyt12_29_1_3	0.99453	0.00117	0.99687
nciacyt11_28_1_3	0.0	28000	28000	8711	8.12	1.0E-04	0.98905	0.00124	0.99152	hciacyt12_28_1_3	0.99159	0.00123	0.99405
nciacyt11_27_1_3	0.0	27000	27000	8764	8.47	1.0E-04	0.98520	0.00115	0.98750	hciacyt12_27_1_3	0.98720	0.00122	0.98963
nciacyt11_26_1_3	0.0	26000	26000	8817	8.85	1.0E-04	0.97887	0.00117	0.98120	hciacyt12_26_1_3	0.97870	0.00130	0.98129
nciacyt11_25_1_3	0.0	25000	25000	8870	9.26	1.0E-04	0.97441	0.00118	0.97676	hciacyt12_25_1_3	0.97501	0.00106	0.97713
nciacyt11_24_1_3	0.0	24000	24000	8923	9.70	1.0E-04	0.96997	0.00115	0.97228	hciacyt12_24_1_3	0.96945	0.00122	0.97188
nciacyt11_23_1_3	0.0	23000	23000	8977	10.19	1.0E-04	0.96203	0.00122	0.96447	hciacyt12_23_1_3	0.96228	0.00121	0.96469
nciacyt11_22_1_3	0.0	22000	22000	9030	10.71	1.0E-04	0.95256	0.00110	0.95475	hciacyt12_22_1_3	0.95313	0.00138	0.95589
nciacyt11_21_1_3	0.0	21000	21000	9083	11.29	1.0E-04	0.94755	0.00114	0.94982	hciacyt12_21_1_3	0.94735	0.00121	0.94976
nciacyt11_20_1_3	0.0	20000	20000	9136	11.92	1.0E-04	0.93967	0.00124	0.94215	hciacyt12_20_1_3	0.94131	0.00113	0.94357
nciacyt11_19_1_3	0.0	19000	19000	9189	12.62	1.0E-04	0.93107	0.00113	0.93334	hciacyt12_19_1_3	0.92967	0.00120	0.93207
nciacyt11_18_1_3	0.0	18000	18000	9242	13.40	1.0E-04	0.92165	0.00100	0.92366	hciacyt12_18_1_3	0.92083	0.00110	0.92302
nciacyt11_18_1_3(n)	0.0	18000	18000	9242	13.40	1.0E-04	0.92377	0.00070	0.92517	hciacyt12_18_1_3(n)	0.92426	0.00064	0.92554
nciacyt11p_18_1_3	0.0	18000	18000	9242	13.40	1.0E-04	0.91346	0.00059	0.91464	hciacyt12p_18_1_3	0.91275	0.00064	0.91403
nciacyt11_15_1_3	0.0	15000	15000	9401	16.36	1.0E-04	0.88925	0.00111	0.89146	hciacyt12_15_1_3	0.88802	0.00116	0.89034

Table 6.9.6-3. Results for 3.24 in.-diam cylinder HEU metal content in packaging calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciacyt11_12_1_3	0.0	12000	12000	9560	20.79	1.0E-04	0.84430	0.00103	0.84636	hciacyt12_12_1_3	0.84558	0.00110	0.84777
nciacyt11_9_1_3	0.0	9000	9000	9719	28.19	1.0E-04	0.78552	0.00116	0.78784	hciacyt12_9_1_3	0.78464	0.00132	0.78728
nciacyt11_6_1_3	0.0	6000	6000	9879	42.97	1.0E-04	0.69176	0.00119	0.69414	hciacyt12_6_1_3	0.69169	0.00122	0.69413
nciacyt11_3_1_3	0.0	3000	3000	10038	87.33	1.0E-04	0.53217	0.00084	0.53385	hciacyt12_3_1_3	0.53298	0.00091	0.53481
with can spacers (np thickness = 1.4 in.)													
nciacyt11_36_2_1	1.4	36000	36000	7673	5.56	1.0E-20	0.95474	0.00109	0.95693	hciacyt12_36_2_1	0.95429	0.00106	0.95641
nciacyt11_36_2_2	1.4	36000	36000	7673	5.56	1.0E-05	0.95402	0.00119	0.95640	hciacyt12_36_2_2	0.95522	0.00105	0.95732
nciacyt11_36_2_3	1.4	36000	36000	7673	5.56	1.0E-04	0.95362	0.00105	0.95571	hciacyt12_36_2_3	0.95319	0.00139	0.95596
nciacyt11_36_2_4	1.4	36000	36000	7673	5.56	1.0E-03	0.95222	0.00128	0.95478	hciacyt12_36_2_4	0.95333	0.00116	0.95564
nciacyt11_36_2_5	1.4	36000	36000	7673	5.56	1.0E-02	0.94649	0.00110	0.94869	hciacyt12_36_2_5	0.94837	0.00124	0.95084
nciacyt11_36_2_6	1.4	36000	36000	7673	5.56	1.0E-01	0.91268	0.00128	0.91524	hciacyt12_36_2_6	0.91591	0.00121	0.91834
nciacyt11_36_2_8	1.4	36000	36000	7673	5.56	3.0E-01	0.88453	0.00140	0.88733	hciacyt12_36_2_8	0.89062	0.00119	0.89300
nciacyt11_36_2_15	1.4	36000	36000	7673	5.56	1.0E+00	0.87822	0.00106	0.88034	hciacyt12_36_2_15	0.88152	0.00135	0.88423
nciacyt11_36_2_3	1.4	36000	36000	7673	5.56	1.0E-04	0.95362	0.00105	0.95571	hciacyt12_36_2_3	0.95319	0.00139	0.95596
nciacyt11_35_2_3	1.4	35000	35000	7726	5.76	1.0E-04	0.94906	0.00125	0.95156	hciacyt12_35_2_3	0.94788	0.00129	0.95046
nciacyt11_34_2_3	1.4	34000	34000	7779	5.97	1.0E-04	0.94393	0.00136	0.94664	hciacyt12_34_2_3	0.94428	0.00130	0.94687
nciacyt11_33_2_3	1.4	33000	33000	7832	6.19	1.0E-04	0.93703	0.00114	0.93930	hciacyt12_33_2_3	0.93708	0.00122	0.93952
nciacyt11_32_2_3	1.4	32000	32000	7885	6.43	1.0E-04	0.92940	0.00125	0.93191	hciacyt12_32_2_3	0.93065	0.00109	0.93283
nciacyt11_31_2_3	1.4	31000	31000	7938	6.68	1.0E-04	0.92483	0.00119	0.92721	hciacyt12_31_2_3	0.92625	0.00125	0.92874
nciacyt11_30_2_3	1.4	30000	30000	7992	6.95	1.0E-04	0.91737	0.00106	0.91949	hciacyt12_30_2_3	0.91983	0.00107	0.92198
nciacyt11_30_2_3(n)	1.4	30000	30000	7992	6.95	1.0E-04	0.91999	0.00056	0.92111	hciacyt12_30_2_3(n)	0.92026	0.00063	0.92152
nciacyt11p_30_2_3	1.4	30000	30000	7992	6.95	1.0E-04	0.91087	0.00069	0.91225	hciacyt12p_30_2_3	0.91262	0.00068	0.91398
nciacyt11_29_2_3	1.4	29000	29000	8045	7.24	1.0E-04	0.91253	0.00116	0.91484	hciacyt12_29_2_3	0.91204	0.00107	0.91419
nciacyt11_28_2_3	1.4	28000	28000	8098	7.55	1.0E-04	0.90504	0.00117	0.90737	hciacyt12_28_2_3	0.90515	0.00100	0.90716

Table 6.9.6-3. Results for 3.24 in.-diam cylinder HEU metal content in packaging calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciacyt11_27_2_3	1.4	27000	27000	8151	7.88	1.0E-04	0.89967	0.00121	0.90208	hciacyt12_27_2_3	0.89749	0.00097	0.89942
nciacyt11_26_2_3	1.4	26000	26000	8204	8.24	1.0E-04	0.89129	0.00107	0.89343	hciacyt12_26_2_3	0.88997	0.00124	0.89246
nciacyt11_25_2_3	1.4	25000	25000	8257	8.62	1.0E-04	0.88183	0.00104	0.88391	hciacyt12_25_2_3	0.88253	0.00129	0.88511
nciacyt11_24_2_3	1.4	24000	24000	8310	9.04	1.0E-04	0.87406	0.00117	0.87640	hciacyt12_24_2_3	0.87448	0.00117	0.87681
nciacyt11_23_2_3	1.4	23000	23000	8363	9.49	1.0E-04	0.86345	0.00109	0.86564	hciacyt12_23_2_3	0.86388	0.00119	0.86626
nciacyt11_22_2_3	1.4	22000	22000	8416	9.98	1.0E-04	0.85413	0.00107	0.85627	hciacyt12_22_2_3	0.85333	0.00109	0.85551
nciacyt11_21_2_3	1.4	21000	21000	8469	10.53	1.0E-04	0.84424	0.00109	0.84642	hciacyt12_21_2_3	0.84414	0.00111	0.84636
nciacyt11_20_2_3	1.4	20000	20000	8522	11.12	1.0E-04	0.83545	0.00106	0.83756	hciacyt12_20_2_3	0.83388	0.00099	0.83585
nciacyt11_19_2_3	1.4	19000	19000	8575	11.78	1.0E-04	0.82051	0.00130	0.82311	hciacyt12_19_2_3	0.82263	0.00109	0.82480
nciacyt11_18_2_3	1.4	18000	18000	8628	12.51	1.0E-04	0.81105	0.00122	0.81350	hciacyt12_18_2_3	0.81076	0.00113	0.81301
nciacyt11_15_2_3	1.4	15000	15000	8787	15.29	1.0E-04	0.76734	0.00107	0.76948	hciacyt12_15_2_3	0.76757	0.00102	0.76960
nciacyt11_12_2_3	1.4	12000	12000	8947	19.46	1.0E-04	0.71377	0.00097	0.71571	hciacyt12_12_2_3	0.71466	0.00102	0.71669
nciacyt11_9_2_3	1.4	9000	9000	9106	26.41	1.0E-04	0.64515	0.00110	0.64734	hciacyt12_9_2_3	0.64486	0.00103	0.64692
nciacyt11_6_2_3	1.4	6000	6000	9265	40.30	1.0E-04	0.54772	0.00094	0.54960	hciacyt12_6_2_3	0.54697	0.00098	0.54893
nciacyt11_3_2_3	1.4	3000	3000	9424	81.99	1.0E-04	0.39773	0.00080	0.39933	hciacyt12_3_2_3	0.39723	0.00087	0.39896

Table 6.9.6-3b. Results for spacing of 3.24 in.-diam cylinder HEU metal content in CV calculation model

Case	np (in.)	^{235}U (g)	H_2O (g)	h/x	separation (cm)	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded containment vessel, reflected									
NCT									
separation is the distance between the 3.24 in.-diam cylinders (an additional 1.4 in. is provided by the can spacer)									
cvcrcyat11_1_2	1.4	30000	7992	6.95	0.000	1.0E+00	0.85525	0.00117	0.85760
cvcrcyat11_2_2	1.4	30000	7992	6.95	0.254	1.0E+00	0.85568	0.00100	0.85768
cvcrcyat11_3_2	1.4	30000	7992	6.95	0.762	1.0E+00	0.85058	0.00110	0.85278
cvcrcyat11_4_2	1.4	30000	7992	6.95	1.270	1.0E+00	0.84834	0.00124	0.85082
cvcrcyat11_5_2	1.4	30000	7992	6.95	1.778	1.0E+00	0.84241	0.00123	0.84488
cvcrcyat11_6_2	1.4	30000	7992	6.95	2.286	1.0E+00	0.83866	0.00099	0.84063
cvcrcyat11_7_2	1.4	30000	7992	6.95	2.794	1.0E+00	0.83549	0.00117	0.83782
cvcrcyat11_8_2	1.4	30000	7992	6.95	3.302	1.0E+00	0.83213	0.00126	0.83465
cvcrcyat11_9_2	1.4	30000	7992	6.95	3.810	1.0E+00	0.82984	0.00125	0.83233
cvcrcyat11_10_2	1.4	30000	7992	6.95	4.318	1.0E+00	0.82777	0.00105	0.82986
cvcrcyat11_11_2	1.4	30000	7992	6.95	4.826	1.0E+00	0.82499	0.00116	0.82731
cvcrcyat11_12_2	1.4	30000	7992	6.95	12.230	1.0E+00	0.80870	0.00121	0.81113

Table 6.9.6-3c. Results for spacing of 3.24 in.-diam cylinder HEU metal content in packaging calculation model

Case	np (in.)	^{235}U (g)	H_2O (g)	h/x	separation (cm)	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded containment vessel, single package reflected									
NCT									
separation is the distance between the 3.24 in.-diam cylinders (an additional 1.4 in. is provided by the canned spacer)									
ncsrcyat11_1_2_15	1.4	30000	7992	6.95	0.000	1.0E+00	0.84343	0.00114	0.84572
ncsrcyat11_2_2_15	1.4	30000	7992	6.95	0.254	1.0E+00	0.84249	0.00111	0.84472
ncsrcyat11_3_2_15	1.4	30000	7992	6.95	0.762	1.0E+00	0.83638	0.00103	0.83845
ncsrcyat11_4_2_15	1.4	30000	7992	6.95	1.270	1.0E+00	0.83416	0.00110	0.83636
ncsrcyat11_5_2_15	1.4	30000	7992	6.95	1.778	1.0E+00	0.82786	0.00128	0.83043
ncsrcyat11_6_2_15	1.4	30000	7992	6.95	2.286	1.0E+00	0.82516	0.00113	0.82743
ncsrcyat11_7_2_15	1.4	30000	7992	6.95	2.794	1.0E+00	0.82161	0.00116	0.82393
ncsrcyat11_8_2_15	1.4	30000	7992	6.95	3.302	1.0E+00	0.82004	0.00114	0.82232
ncsrcyat11_9_2_15	1.4	30000	7992	6.95	3.810	1.0E+00	0.81641	0.00101	0.81843
ncsrcyat11_10_2_15	1.4	30000	7992	6.95	4.318	1.0E+00	0.81362	0.00109	0.81581
ncsrcyat11_11_2_15	1.4	30000	7992	6.95	4.826	1.0E+00	0.81218	0.00104	0.81426
ncsrcyat11_12_2_15	1.4	30000	7992	6.95	12.230	1.0E+00	0.79592	0.00100	0.79793

Table 6.9.6-3d. Results for cylinder C and D content in infinite array package calculation model, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciacylc11	Cylinder C modeled at bottom of CV	0.83107	0.00056	0.83219	hciacylc12	0.83124	0.00057	0.83238
nciacylcc11	Cylinder C modeled centered of CV	0.80727	0.00081	0.80889	hciacylcc12	0.80557	0.00061	0.80679
nciacyld11	Cylinder D modeled at bottom of CV	0.85241	0.00073	0.85387	hciacyld12	0.85343	0.00058	0.85459
nciacyldc11	Cylinder D modeled centered of CV	0.82393	0.00064	0.82521	hciacyldc12	0.82380	0.00065	0.82510
nciacyldala11	Cylinder D with 0.01" aluminum cladding	0.85082	0.00060	0.85202				
nciacyldala11	Cylinder D with 0.1" aluminum cladding	0.83662	0.00061	0.83784				
nciacyldala11	Cylinder D with 0.25" aluminum cladding	0.81652	0.00057	0.81766				

Table 6.9.6-4. Results for 2.29 in.-square bar HEU metal content in CV calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
flooded containment vessel, reflected									
no can spacers (np thickness = 0.0 in.)									
cvcrsqt11_36_1	0.0	36000	36000	8287	6.01	1.0E+00	0.87614	0.00128	0.87869
cvcrsqt11_36_1(n)	0.0	36000	36000	8287	6.01	1.0E+00	0.88228	0.00060	0.88348
cvcrsqt11p_36_1	0.0	36000	36000	8287	6.01	1.0E+00	0.87699	0.00064	0.87827
cvcrsqt11_35_1	0.0	35000	35000	8340	6.22	1.0E+00	0.87560	0.00111	0.87781
cvcrsqt11_34_1	0.0	34000	34000	8393	6.44	1.0E+00	0.87541	0.00126	0.87794
cvcrsqt11_33_1	0.0	33000	33000	8446	6.68	1.0E+00	0.87396	0.00108	0.87612
cvcrsqt11_32_1	0.0	32000	32000	8499	6.93	1.0E+00	0.87319	0.00119	0.87556
cvcrsqt11_31_1	0.0	31000	31000	8552	7.20	1.0E+00	0.86993	0.00116	0.87225
cvcrsqt11_30_1	0.0	30000	30000	8605	7.49	1.0E+00	0.87046	0.00120	0.87286

Table 6.9.6-4. Results for 2.29 in.-square bar HEU metal content in CV calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrsqt11_29_1	0.0	29000	29000	8658	7.79	1.0E+00	0.86852	0.00107	0.87067
cvcrsqt11_28_1	0.0	28000	28000	8711	8.12	1.0E+00	0.86740	0.00113	0.86966
cvcrsqt11_27_1	0.0	27000	27000	8764	8.47	1.0E+00	0.86366	0.00116	0.86597
cvcrsqt11_26_1	0.0	26000	26000	8817	8.85	1.0E+00	0.86498	0.00138	0.86773
cvcrsqt11_25_1	0.0	25000	25000	8870	9.26	1.0E+00	0.86077	0.00121	0.86319
cvcrsqt11_24_1	0.0	24000	24000	8923	9.70	1.0E+00	0.85955	0.00138	0.86231
cvcrsqt11_23_1	0.0	23000	23000	8977	10.19	1.0E+00	0.85604	0.00106	0.85816
cvcrsqt11_22_1	0.0	22000	22000	9030	10.71	1.0E+00	0.85211	0.00103	0.85417
cvcrsqt11_21_1	0.0	21000	21000	9083	11.29	1.0E+00	0.84970	0.00118	0.85206
cvcrsqt11_20_1	0.0	20000	20000	9136	11.92	1.0E+00	0.84694	0.00119	0.84931
cvcrsqt11_19_1	0.0	19000	19000	9189	12.62	1.0E+00	0.84285	0.00109	0.84503
cvcrsqt11_18_1	0.0	18000	18000	9242	13.40	1.0E+00	0.83888	0.00115	0.84117
with can spacers (np thickness=1.4 in.)									
cvcrsqt11_36_2	1.4	36000	36000	7673	5.56	1.0E+00	0.82217	0.00098	0.82414
cvcrsqt11_36_2(n)	1.4	36000	36000	7673	5.56	1.0E+00	0.88228	0.00060	0.88348
cvcrsqt11p_36_2	1.4	36000	36000	7673	5.56	1.0E+00	0.87699	0.00064	0.87827
cvcrsqt11_35_2	1.4	35000	35000	7726	5.76	1.0E+00	0.81622	0.00130	0.81881
cvcrsqt11_34_2	1.4	34000	34000	7779	5.97	1.0E+00	0.81548	0.00103	0.81755
cvcrsqt11_33_2	1.4	33000	33000	7832	6.19	1.0E+00	0.81272	0.00118	0.81508
cvcrsqt11_32_2	1.4	32000	32000	7885	6.43	1.0E+00	0.80782	0.00120	0.81022
cvcrsqt11_31_2	1.4	31000	31000	7938	6.68	1.0E+00	0.80495	0.00109	0.80712
cvcrsqt11_30_2	1.4	30000	30000	7992	6.95	1.0E+00	0.80163	0.00117	0.80397

Table 6.9.6-5. Results for 2.29 in.-square bar HEU metal content in packaging calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded containment vessel, single package reflected													
NCT										**HAC**			
no can spacers (np thickness = 0.0 in.)													
ncsrsqt11_36_1_1	0.0	36000	36000	8287	6.01	1.0E-20	0.82940	0.00124	0.83189	hcsrsqt12_36_1_1	0.83133	0.00125	0.83384
ncsrsqt11_36_1_2	0.0	36000	36000	8287	6.01	1.0E-05	0.83107	0.00107	0.83320	hcsrsqt12_36_1_2	0.83168	0.00121	0.83409
ncsrsqt11_36_1_3	0.0	36000	36000	8287	6.01	1.0E-04	0.83051	0.00120	0.83292	hcsrsqt12_36_1_3	0.83088	0.00103	0.83293
ncsrsqt11_36_1_4	0.0	36000	36000	8287	6.01	1.0E-03	0.82981	0.00116	0.83213	hcsrsqt12_36_1_4	0.83030	0.00122	0.83273
ncsrsqt11_36_1_5	0.0	36000	36000	8287	6.01	1.0E-02	0.82859	0.00123	0.83105	hcsrsqt12_36_1_5	0.83244	0.00126	0.83496
ncsrsqt11_36_1_6	0.0	36000	36000	8287	6.01	1.0E-01	0.83608	0.00123	0.83853	hcsrsqt12_36_1_6	0.83502	0.00119	0.83739
ncsrsqt11_36_1_8	0.0	36000	36000	8287	6.01	3.0E-01	0.84146	0.00118	0.84382	hcsrsqt12_36_1_8	0.84236	0.00115	0.84465
ncsrsqt11_36_1_15	0.0	36000	36000	8287	6.01	1.0E+00	0.86253	0.00131	0.86516	hcsrsqt12_36_1_15	0.86198	0.00112	0.86422
ncsrsqt11_36_1_15	0.0	36000	36000	8287	6.01	1.0E+00	0.86253	0.00131	0.86516	hcsrsqt12_36_1_15	0.86198	0.00112	0.86422
ncsrsqt11_36_1_15(n)	0.0	36000	36000	8287	6.01	1.0E+00	0.86298	0.00064	0.86426	hcsrsqt12_36_1_15(n)	0.86427	0.00065	0.86557
ncsrsqt11p_36_1_15	0.0	36000	36000	8287	6.01	1.0E+00	0.86007	0.00061	0.86129	hcsrsqt12p_36_1_15	0.86011	0.00058	0.86127
ncsrsqt11_35_1_15	0.0	35000	35000	8340	6.22	1.0E+00	0.86041	0.00112	0.86265	hcsrsqt12_35_1_15	0.86067	0.00121	0.86309
ncsrsqt11_34_1_15	0.0	34000	34000	8393	6.44	1.0E+00	0.85820	0.00129	0.86078	hcsrsqt12_34_1_15	0.85896	0.00102	0.86101
ncsrsqt11_33_1_15	0.0	33000	33000	8446	6.68	1.0E+00	0.85708	0.00106	0.85920	hcsrsqt12_33_1_15	0.86064	0.00110	0.86285
ncsrsqt11_32_1_15	0.0	32000	32000	8499	6.93	1.0E+00	0.85769	0.00107	0.85983	hcsrsqt12_32_1_15	0.85800	0.00110	0.86020
ncsrsqt11_31_1_15	0.0	31000	31000	8552	7.20	1.0E+00	0.85495	0.00127	0.85749	hcsrsqt12_31_1_15	0.85333	0.00123	0.85580
ncsrsqt11_30_1_15	0.0	30000	30000	8605	7.49	1.0E+00	0.85270	0.00120	0.85510	hcsrsqt12_30_1_15	0.85520	0.00132	0.85784
ncsrsqt11_29_1_15	0.0	29000	29000	8658	7.79	1.0E+00	0.85067	0.00119	0.85305	hcsrsqt12_29_1_15	0.85348	0.00114	0.85575
ncsrsqt11_28_1_15	0.0	28000	28000	8711	8.12	1.0E+00	0.85223	0.00111	0.85446	hcsrsqt12_28_1_15	0.85043	0.00101	0.85246
ncsrsqt11_27_1_15	0.0	27000	27000	8764	8.47	1.0E+00	0.84973	0.00121	0.85214	hcsrsqt12_27_1_15	0.85029	0.00111	0.85250
ncsrsqt11_26_1_15	0.0	26000	26000	8817	8.85	1.0E+00	0.84838	0.00127	0.85091	hcsrsqt12_26_1_15	0.84829	0.00115	0.85058

Table 6.9.6-5. Results for 2.29 in.-square bar HEU metal content in packaging calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsrsqt11_25_1_15	0.0	25000	25000	8870	9.26	1.0E+00	0.84598	0.00113	0.84824	hcsrsqt12_25_1_15	0.84583	0.00105	0.84792
ncsrsqt11_24_1_15	0.0	24000	24000	8923	9.70	1.0E+00	0.84390	0.00111	0.84611	hcsrsqt12_24_1_15	0.84296	0.00112	0.84521
ncsrsqt11_23_1_15	0.0	23000	23000	8977	10.19	1.0E+00	0.84101	0.00108	0.84317	hcsrsqt12_23_1_15	0.84241	0.00129	0.84499
ncsrsqt11_22_1_15	0.0	22000	22000	9030	10.71	1.0E+00	0.83888	0.00112	0.84111	hcsrsqt12_22_1_15	0.83951	0.00107	0.84164
ncsrsqt11_21_1_15	0.0	21000	21000	9083	11.29	1.0E+00	0.83473	0.00112	0.83696	hcsrsqt12_21_1_15	0.83577	0.00128	0.83832
ncsrsqt11_20_1_15	0.0	20000	20000	9136	11.92	1.0E+00	0.83029	0.00110	0.83250	hcsrsqt12_20_1_15	0.83094	0.00103	0.83300
ncsrsqt11_19_1_15	0.0	19000	19000	9189	12.62	1.0E+00	0.82676	0.00107	0.82889	hcsrsqt12_19_1_15	0.82652	0.00113	0.82879
ncsrsqt11_18_1_15	0.0	18000	18000	9242	13.40	1.0E+00	0.82247	0.00121	0.82489	hcsrsqt12_18_1_15	0.82440	0.00112	0.82664
with can spacers (np thickness = 1.4 in.)													
ncsrsqt11_36_2_1	1.4	36000	36000	7673	5.56	1.0E-20	0.78167	0.00104	0.78375	hcsrsqt12_36_2_1	0.78308	0.00128	0.78563
ncsrsqt11_36_2_2	1.4	36000	36000	7673	5.56	1.0E-05	0.78210	0.00112	0.78434	hcsrsqt12_36_2_2	0.78549	0.00112	0.78772
ncsrsqt11_36_2_3	1.4	36000	36000	7673	5.56	1.0E-04	0.78209	0.00104	0.78417	hcsrsqt12_36_2_3	0.78508	0.00119	0.78746
ncsrsqt11_36_2_4	1.4	36000	36000	7673	5.56	1.0E-03	0.78414	0.00111	0.78636	hcsrsqt12_36_2_4	0.78484	0.00121	0.78727
ncsrsqt11_36_2_5	1.4	36000	36000	7673	5.56	1.0E-02	0.78141	0.00137	0.78415	hcsrsqt12_36_2_5	0.78362	0.00114	0.78591
ncsrsqt11_36_2_6	1.4	36000	36000	7673	5.56	1.0E-01	0.78591	0.00113	0.78818	hcsrsqt12_36_2_6	0.78757	0.00108	0.78972
ncsrsqt11_36_2_8	1.4	36000	36000	7673	5.56	3.0E-01	0.79206	0.00130	0.79466	hcsrsqt12_36_2_8	0.79070	0.00128	0.79327
ncsrsqt11_36_2_15	1.4	36000	36000	7673	5.56	1.0E+00	0.80894	0.00103	0.81101	hcsrsqt12_36_2_15	0.80856	0.00110	0.81077
ncsrsqt11_36_2_15	1.4	36000	36000	7673	5.56	1.0E+00	0.80894	0.00103	0.81101	hcsrsqt12_36_2_15	0.80856	0.00110	0.81077
ncsrsqt11_35_2_15	1.4	35000	35000	7726	5.76	1.0E+00	0.80583	0.00113	0.80808	hcsrsqt12_35_2_15	0.80522	0.00112	0.80747
ncsrsqt11_34_2_15	1.4	34000	34000	7779	5.97	1.0E+00	0.80341	0.00125	0.80591	hcsrsqt12_34_2_15	0.80255	0.00107	0.80469
ncsrsqt11_33_2_15	1.4	33000	33000	7832	6.19	1.0E+00	0.80213	0.00108	0.80429	hcsrsqt12_33_2_15	0.79972	0.00096	0.80164
ncsrsqt11_32_2_15	1.4	32000	32000	7885	6.43	1.0E+00	0.79784	0.00124	0.80032	hcsrsqt12_32_2_15	0.79750	0.00118	0.79985
ncsrsqt11_31_2_15	1.4	31000	31000	7938	6.68	1.0E+00	0.79226	0.00107	0.79440	hcsrsqt12_31_2_15	0.79447	0.00099	0.79646
ncsrsqt11_30_2_15	1.4	30000	30000	7992	6.95	1.0E+00	0.79192	0.00110	0.79412	hcsrsqt12_30_2_15	0.79053	0.00108	0.79268

Table 6.9.6-5. Results for 2.29 in.-square bar HEU metal content in packaging calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded containment vessel, array packaging model for CSI=0.0													
NCT										**HAC**			
no can spacers (np thickness = 0.0 in.)													
nciasqt11_36_1_3	0.0	36000	36000	8287	6.01	1.0E-04	0.93786	0.00112	0.94011	hciasqt12_36_1_3	0.93760	0.00119	0.93998
nciasqt11_35_1_3	0.0	35000	35000	8340	6.22	1.0E-04	0.93414	0.00107	0.93629	hciasqt12_35_1_3	0.93524	0.00130	0.93785
nciasqt11_34_1_3	0.0	34000	34000	8393	6.44	1.0E-04	0.93004	0.00116	0.93235	hciasqt12_34_1_3	0.92962	0.00116	0.93195
nciasqt11_33_1_3	0.0	33000	33000	8446	6.68	1.0E-04	0.92897	0.00121	0.93139	hciasqt12_33_1_3	0.92744	0.00120	0.92984
nciasqt11_32_1_3	0.0	32000	32000	8499	6.93	1.0E-04	0.92703	0.00119	0.92942	hciasqt12_32_1_3	0.92854	0.00110	0.93073
nciasqt11_31_1_3	0.0	31000	31000	8552	7.20	1.0E-04	0.92403	0.00109	0.92621	hciasqt12_31_1_3	0.92290	0.00105	0.92499
nciasqt11_30_1_3	0.0	30000	30000	8605	7.49	1.0E-04	0.91959	0.00114	0.92188	hciasqt12_30_1_3	0.91960	0.00125	0.92211
nciasqt11_30_1_3(n)	0.0	30000	30000	8605	7.49	1.0E-04	0.92187	0.00065	0.92317	hciasqt12_30_1_3(n)	0.92231	0.00060	0.92351
nciasqt11p_30_1_3	0.0	30000	30000	8605	7.49	1.0E-04	0.91720	0.00061	0.91842	hciasqt12p_30_1_3	0.91634	0.00073	0.91780
nciasqt11_29_1_3	0.0	29000	29000	8658	7.79	1.0E-04	0.91544	0.00122	0.91787	hciasqt12_29_1_3	0.91645	0.00138	0.91922
nciasqt11_28_1_3	0.0	28000	28000	8711	8.12	1.0E-04	0.91153	0.00123	0.91399	hciasqt12_28_1_3	0.91477	0.00122	0.91722
nciasqt11_27_1_3	0.0	27000	27000	8764	8.47	1.0E-04	0.90851	0.00099	0.91050	hciasqt12_27_1_3	0.91066	0.00119	0.91305
nciasqt11_26_1_3	0.0	26000	26000	8817	8.85	1.0E-04	0.90835	0.00125	0.91084	hciasqt12_26_1_3	0.90452	0.00124	0.90699
nciasqt11_25_1_3	0.0	25000	25000	8870	9.26	1.0E-04	0.90272	0.00115	0.90501	hciasqt12_25_1_3	0.90142	0.00116	0.90374
nciasqt11_24_1_3	0.0	24000	24000	8923	9.70	1.0E-04	0.89930	0.00123	0.90177	hciasqt12_24_1_3	0.89640	0.00120	0.89881
nciasqt11_23_1_3	0.0	23000	23000	8977	10.19	1.0E-04	0.89380	0.00120	0.89619	hciasqt12_23_1_3	0.89613	0.00135	0.89882
nciasqt11_22_1_3	0.0	22000	22000	9030	10.71	1.0E-04	0.88934	0.00105	0.89144	hciasqt12_22_1_3	0.88839	0.00106	0.89051
nciasqt11_21_1_3	0.0	21000	21000	9083	11.29	1.0E-04	0.88358	0.00109	0.88576	hciasqt12_21_1_3	0.88413	0.00118	0.88649
nciasqt11_20_1_3	0.0	20000	20000	9136	11.92	1.0E-04	0.87812	0.00123	0.88058	hciasqt12_20_1_3	0.87811	0.00124	0.88058
nciasqt11_19_1_3	0.0	19000	19000	9189	12.62	1.0E-04	0.87206	0.00108	0.87423	hciasqt12_19_1_3	0.87171	0.00118	0.87408
nciasqt11_18_1_3	0.0	18000	18000	9242	13.40	1.0E-04	0.86772	0.00140	0.87052	hciasqt12_18_1_3	0.86555	0.00119	0.86794
nciasqt11_15_1_3	0.0	15000	15000	9401	16.36	1.0E-04	0.84518	0.00119	0.84756	hciasqt12_15_1_3	0.84416	0.00102	0.84620

Table 6.9.6-5. Results for 2.29 in.-square bar HEU metal content in packaging calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciasqt11_12_1_3	0.0	12000	12000	9560	20.79	1.0E-04	0.81425	0.00113	0.81651	hciasqt12_12_1_3	0.81332	0.00101	0.81534
nciasqt11_9_1_3	0.0	9000	9000	9719	28.19	1.0E-04	0.76947	0.00115	0.77178	hciasqt12_9_1_3	0.77066	0.00107	0.77280
nciasqt11_6_1_3	0.0	6000	6000	9879	42.97	1.0E-04	0.69668	0.00099	0.69866	hciasqt12_6_1_3	0.69648	0.00101	0.69850
nciasqt11_3_1_3	0.0	3000	3000	10038	87.33	1.0E-04	0.55857	0.00089	0.56036	hciasqt12_3_1_3	0.55806	0.00092	0.55989
with can spacers (np thickness = 1.4 in.)													
nciasqt11_36_2_3	1.4	36000	36000	7673	5.56	1.0E-04	0.89382	0.00114	0.89610	hciasqt12_36_2_3	0.89230	0.00114	0.89458
nciasqt11_36_2_3(n)	1.4	36000	36000	7673	5.56	1.0E-04	0.89252	0.00063	0.89378	hciasqt12_36_2_3(n)	0.89219	0.00075	0.89369
nciasqt11p_36_2_3	1.4	36000	36000	7673	5.56	1.0E-04	0.89448	0.00078	0.89604	hciasqt12p_36_2_3	0.89506	0.00063	0.89632
nciasqt11_35_2_3	1.4	35000	35000	7726	5.76	1.0E-04	0.88604	0.00105	0.88813	hciasqt12_35_2_3	0.88890	0.00130	0.89150
nciasqt11_34_2_3	1.4	34000	34000	7779	5.97	1.0E-04	0.88480	0.00105	0.88690	hciasqt12_34_2_3	0.88544	0.00139	0.88822
nciasqt11_33_2_3	1.4	33000	33000	7832	6.19	1.0E-04	0.87854	0.00118	0.88090	hciasqt12_33_2_3	0.87897	0.00106	0.88110
nciasqt11_32_2_3	1.4	32000	32000	7885	6.43	1.0E-04	0.87561	0.00104	0.87768	hciasqt12_32_2_3	0.87638	0.00121	0.87880
nciasqt11_31_2_3	1.4	31000	31000	7938	6.68	1.0E-04	0.86867	0.00123	0.87114	hciasqt12_31_2_3	0.87222	0.00105	0.87432
nciasqt11_30_2_3	1.4	30000	30000	7992	6.95	1.0E-04	0.86347	0.00122	0.86590	hciasqt12_30_2_3	0.86614	0.00121	0.86855
nciasqt11_29_2_3	1.4	29000	29000	8045	7.24	1.0E-04	0.85781	0.00109	0.86000	hciasqt12_29_2_3	0.85842	0.00113	0.86068
nciasqt11_28_2_3	1.4	28000	28000	8098	7.55	1.0E-04	0.85401	0.00119	0.85640	hciasqt12_28_2_3	0.85399	0.00116	0.85630
nciasqt11_27_2_3	1.4	27000	27000	8151	7.88	1.0E-04	0.84755	0.00127	0.85009	hciasqt12_27_2_3	0.84935	0.00125	0.85184
nciasqt11_26_2_3	1.4	26000	26000	8204	8.24	1.0E-04	0.84285	0.00119	0.84522	hciasqt12_26_2_3	0.84287	0.00106	0.84500
nciasqt11_25_2_3	1.4	25000	25000	8257	8.62	1.0E-04	0.83719	0.00124	0.83967	hciasqt12_25_2_3	0.83683	0.00113	0.83910
nciasqt11_24_2_3	1.4	24000	24000	8310	9.04	1.0E-04	0.82927	0.00102	0.83132	hciasqt12_24_2_3	0.83192	0.00111	0.83414
nciasqt11_23_2_3	1.4	23000	23000	8363	9.49	1.0E-04	0.82375	0.00132	0.82638	hciasqt12_23_2_3	0.82315	0.00124	0.82562
nciasqt11_22_2_3	1.4	22000	22000	8416	9.98	1.0E-04	0.81735	0.00107	0.81950	hciasqt12_22_2_3	0.81490	0.00105	0.81700
nciasqt11_21_2_3	1.4	21000	21000	8469	10.53	1.0E-04	0.80580	0.00118	0.80817	hciasqt12_21_2_3	0.81021	0.00121	0.81263
nciasqt11_20_2_3	1.4	20000	20000	8522	11.12	1.0E-04	0.79977	0.00110	0.80197	hciasqt12_20_2_3	0.80091	0.00116	0.80324
nciasqt11_19_2_3	1.4	19000	19000	8575	11.78	1.0E-04	0.79125	0.00109	0.79343	hciasqt12_19_2_3	0.79175	0.00113	0.79400

Table 6.9.6-5. Results for 2.29 in.-square bar HEU metal content in packaging calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciasqt11_18_2_3	1.4	18000	18000	8628	12.51	1.0E-04	0.78165	0.00110	0.78386	hciasqt12_18_2_3	0.78285	0.00110	0.78505
nciasqt11_15_2_3	1.4	15000	15000	8787	15.29	1.0E-04	0.74822	0.00105	0.75032	hciasqt12_15_2_3	0.74548	0.00107	0.74762
nciasqt11_12_2_3	1.4	12000	12000	8947	19.46	1.0E-04	0.70519	0.00106	0.70732	hciasqt12_12_2_3	0.70419	0.00105	0.70628
nciasqt11_9_2_3	1.4	9000	9000	9106	26.41	1.0E-04	0.64473	0.00106	0.64685	hciasqt12_9_2_3	0.64451	0.00101	0.64653
nciasqt11_6_2_3	1.4	6000	6000	9265	40.30	1.0E-04	0.55778	0.00097	0.55972	hciasqt12_6_2_3	0.55888	0.00098	0.56084
nciasqt11_3_2_3	1.4	3000	3000	9424	81.99	1.0E-04	0.41347	0.00085	0.41517	hciasqt12_3_2_3	0.41398	0.00074	0.41545

Table 6.9.6-6. Results for 4.25 in.-diam cylinder HEU metal content in CV calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
flooded containment vessel, reflected									
no can spacers (np thickness = 0.0 in.)									
cvcrcyct11_36_1	0.0	36000	36000	8287	6.01	1.0E+00	1.06320	0.00115	1.06549
cvcrcyct11_35_1	0.0	35000	35000	8340	6.22	1.0E+00	1.06114	0.00121	1.06356
cvcrcyct11_34_1	0.0	34000	34000	8393	6.44	1.0E+00	1.05675	0.00122	1.05919
cvcrcyct11_33_1	0.0	33000	33000	8446	6.68	1.0E+00	1.04990	0.00112	1.05214
cvcrcyct11_32_1	0.0	32000	32000	8499	6.93	1.0E+00	1.04469	0.00123	1.04714
cvcrcyct11_31_1	0.0	31000	31000	8552	7.20	1.0E+00	1.04101	0.00104	1.04310
cvcrcyct11_30_1	0.0	30000	30000	8605	7.49	1.0E+00	1.03487	0.00117	1.03722
cvcrcyct11_29_1	0.0	29000	29000	8658	7.79	1.0E+00	1.02817	0.00115	1.03046
cvcrcyct11_28_1	0.0	28000	28000	8711	8.12	1.0E+00	1.02183	0.00125	1.02433
cvcrcyct11_27_1	0.0	27000	27000	8764	8.47	1.0E+00	1.01524	0.00109	1.01742
cvcrcyct11_26_1	0.0	26000	26000	8817	8.85	1.0E+00	1.00971	0.00116	1.01203
cvcrcyct11_25_1	0.0	25000	25000	8870	9.26	1.0E+00	1.00149	0.00136	1.00420

Table 6.9.6-6. Results for 4.25 in.-diam cylinder HEU metal content in CV calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrcyct11_24_1	0.0	24000	24000	8923	9.70	1.0E+00	0.99327	0.00137	0.99600
cvcrcyct11_23_1	0.0	23000	23000	8977	10.19	1.0E+00	0.98432	0.00124	0.98680
cvcrcyct11_22_1	0.0	22000	22000	9030	10.71	1.0E+00	0.97759	0.00112	0.97984
cvcrcyct11_21_1	0.0	21000	21000	9083	11.29	1.0E+00	0.96672	0.00116	0.96904
cvcrcyct11_20_1	0.0	20000	20000	9136	11.92	1.0E+00	0.95743	0.00128	0.95999
cvcrcyct11_19_1	0.0	19000	19000	9189	12.62	1.0E+00	0.94629	0.00118	0.94866
cvcrcyct11_18_1	0.0	18000	18000	9242	13.40	1.0E+00	0.93349	0.00114	0.93576
cvcrcyct11_17_1	0.0	17000	17000	9295	14.27	1.0E+00	0.91942	0.00105	0.92152
cvcrcyct11_17_1(n)	0.0	17000	17000	9295	14.27	1.0E+00	0.92476	0.00067	0.92610
cvcrcyct11p_17_1	0.0	17000	17000	9295	14.27	1.0E+00	0.92373	0.00064	0.92501
cvcrcyct11_16_1	0.0	16000	16000	9348	15.25	1.0E+00	0.90458	0.00120	0.90699
cvcrcyct11_15_1	0.0	15000	15000	9401	16.36	1.0E+00	0.88788	0.00107	0.89002
with can spacers (np thickness=1.4 in.)									
cvcrcyct11_36_2	1.4	36000	36000	7673	5.56	1.0E+00	0.94321	0.00111	0.94543
cvcrcyct11_35_2	1.4	35000	35000	7726	5.76	1.0E+00	0.93828	0.00114	0.94056
cvcrcyct11_34_2	1.4	34000	34000	7779	5.97	1.0E+00	0.93114	0.00129	0.93372
cvcrcyct11_33_2	1.4	33000	33000	7832	6.19	1.0E+00	0.92558	0.00124	0.92805
cvcrcyct11_32_2	1.4	32000	32000	7885	6.43	1.0E+00	0.91799	0.00111	0.92021
cvcrcyct11_32_2(n)	1.4	32000	32000	7885	6.43	1.0E+00	0.92141	0.00062	0.92265
cvcrcyct11p_32_2	1.4	32000	32000	7885	6.43	1.0E+00	0.90981	0.00062	0.91105
cvcrcyct11_31_2	1.4	31000	31000	7938	6.68	1.0E+00	0.91146	0.00114	0.91375
cvcrcyct11_30_2	1.4	30000	30000	7992	6.95	1.0E+00	0.90499	0.00117	0.90734

Table 6.9.6-7. Results for 4.25 in.-diam cylinder HEU metal content in packaging calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded containment vessel, single package reflected													
NCT										**HAC**			
no can spacers (np thickness = 0.0 in.)													
ncsrcyct11_36_1_1	0.0	36000	36000	8286.7	6.01	1.0E-20	0.98628	0.00107	0.98841	hcsrcyct12_36_1_1	0.98723	0.00126	0.98975
ncsrcyct11_36_1_2	0.0	36000	36000	8286.7	6.01	1.0E-05	0.98712	0.00138	0.98988	hcsrcyct12_36_1_2	0.98582	0.00120	0.98823
ncsrcyct11_36_1_3	0.0	36000	36000	8287	6.01	1.0E-04	0.98624	0.00119	0.98861	hcsrcyct12_36_1_3	0.98691	0.00113	0.98917
ncsrcyct11_36_1_4	0.0	36000	36000	8287	6.01	1.0E-03	0.98433	0.00102	0.98637	hcsrcyct12_36_1_4	0.98537	0.00111	0.98759
ncsrcyct11_36_1_5	0.0	36000	36000	8287	6.01	1.0E-02	0.98646	0.00103	0.98852	hcsrcyct12_36_1_5	0.98809	0.00110	0.99028
ncsrcyct11_36_1_6	0.0	36000	36000	8287	6.01	1.0E-01	0.99092	0.00127	0.99346	hcsrcyct12_36_1_6	0.99096	0.00099	0.99295
ncsrcyct11_36_1_8	0.0	36000	36000	8287	6.01	3.0E-01	1.00000	0.00123	1.00246	hcsrcyct12_36_1_8	1.00334	0.00119	1.00572
ncsrcyct11_36_1_15	0.0	36000	36000	8287	6.01	1.0E+00	1.03142	0.00144	1.03430	hcsrcyct12_36_1_15	1.03141	0.00116	1.03374
ncsrcyct11_36_1_15	0.0	36000	36000	8287	6.01	1.0E+00	1.03142	0.00144	1.03430	hcsrcyct12_36_1_15	1.03141	0.00116	1.03374
ncsrcyct11_35_1_15	0.0	35000	35000	8340	6.22	1.0E+00	1.02816	0.00115	1.03045	hcsrcyct12_35_1_15	1.03309	0.00126	1.03561
ncsrcyct11_34_1_15	0.0	34000	34000	8393	6.44	1.0E+00	1.02658	0.00113	1.02884	hcsrcyct12_34_1_15	1.02529	0.00124	1.02776
ncsrcyct11_33_1_15	0.0	33000	33000	8446	6.68	1.0E+00	1.01975	0.00114	1.02203	hcsrcyct12_33_1_15	1.02060	0.00124	1.02308
ncsrcyct11_32_1_15	0.0	32000	32000	8499	6.93	1.0E+00	1.01647	0.00104	1.01854	hcsrcyct12_32_1_15	1.01688	0.00114	1.01916
ncsrcyct11_31_1_15	0.0	31000	31000	8552	7.20	1.0E+00	1.00952	0.00114	1.01179	hcsrcyct12_31_1_15	1.01218	0.00144	1.01505
ncsrcyct11_30_1_15	0.0	30000	30000	8605	7.49	1.0E+00	1.00434	0.00123	1.00679	hcsrcyct12_30_1_15	1.00757	0.00117	1.00992
ncsrcyct11_29_1_15	0.0	29000	29000	8658	7.79	1.0E+00	1.00074	0.00106	1.00287	hcsrcyct12_29_1_15	1.00071	0.00139	1.00348
ncsrcyct11_28_1_15	0.0	28000	28000	8711	8.12	1.0E+00	0.99381	0.00135	0.99652	hcsrcyct12_28_1_15	0.99442	0.00129	0.99700
ncsrcyct11_27_1_15	0.0	27000	27000	8764	8.47	1.0E+00	0.98595	0.00094	0.98782	hcsrcyct12_27_1_15	0.99057	0.00119	0.99296
ncsrcyct11_26_1_15	0.0	26000	26000	8817	8.85	1.0E+00	0.97783	0.00117	0.98017	hcsrcyct12_26_1_15	0.98010	0.00135	0.98281
ncsrcyct11_25_1_15	0.0	25000	25000	8870	9.26	1.0E+00	0.97189	0.00126	0.97440	hcsrcyct12_25_1_15	0.97263	0.00118	0.97499
ncsrcyct11_24_1_15	0.0	24000	24000	8923	9.70	1.0E+00	0.96439	0.00121	0.96681	hcsrcyct12_24_1_15	0.96656	0.00113	0.96881
ncsrcyct11_23_1_15	0.0	23000	23000	8977	10.19	1.0E+00	0.95375	0.00130	0.95635	hcsrcyct12_23_1_15	0.95783	0.00118	0.96018

Table 6.9.6-7. Results for 4.25 in.-diam cylinder HEU metal content in packaging calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsrcyct11_22_1_15	0.0	22000	22000	9030	10.71	1.0E+00	0.94744	0.00132	0.95008	hcsrcyct12_22_1_15	0.94901	0.00143	0.95187
ncsrcyct11_21_1_15	0.0	21000	21000	9083	11.29	1.0E+00	0.93842	0.00127	0.94095	hcsrcyct12_21_1_15	0.93880	0.00126	0.94132
ncsrcyct11_20_1_15	0.0	20000	20000	9136	11.92	1.0E+00	0.92684	0.00118	0.92920	hcsrcyct12_20_1_15	0.92929	0.00124	0.93176
ncsrcyct11_19_1_15	0.0	19000	19000	9189	12.62	1.0E+00	0.91527	0.00109	0.91745	hcsrcyct12_19_1_15	0.91879	0.00101	0.92081
ncsrcyct11_18_1_15	0.0	18000	18000	9242	13.40	1.0E+00	0.90374	0.00111	0.90597	hcsrcyct12_18_1_15	0.90716	0.00105	0.90927
ncsrcyct11_17_1_15	0.0	17000	17000	9295	14.27	1.0E+00	0.89147	0.00133	0.89412	hcsrcyct12_17_1_15	0.89585	0.00104	0.89794
ncsrcyct11_17_1_15(n)	0.0	17000	17000	9295	14.27	1.0E+00	0.89551	0.00079	0.89709	hcsrcyct12_17_1_15(n)	0.89820	0.00069	0.89958
ncsrcyct11p_17_1_15	0.0	17000	17000	9295	14.27	1.0E+00	0.89536	0.00075	0.89686	hcsrcyct12p_17_1_15	0.89598	0.00061	0.89720
ncsrcyct11_16_1_15	0.0	16000	16000	9348	15.25	1.0E+00	0.87788	0.00101	0.87990	hcsrcyct12_16_1_15	0.87933	0.00118	0.88168
ncsrcyct11_15_1_15	0.0	15000	15000	9401	16.36	1.0E+00	0.86209	0.00110	0.86429	hcsrcyct12_15_1_15	0.86488	0.00110	0.86708
with can spacers (np thickness = 1.4 in.)													
ncsrcyct11_36_2_1	1.4	36000	36000	7673	5.56	1.0E-20	0.87502	0.00112	0.87725	hcsrcyct12_36_2_1	0.87543	0.00107	0.87757
ncsrcyct11_36_2_2	1.4	36000	36000	7673	5.56	1.0E-05	0.87474	0.00108	0.87691	hcsrcyct12_36_2_2	0.87795	0.00117	0.88029
ncsrcyct11_36_2_3	1.4	36000	36000	7673	5.56	1.0E-04	0.87595	0.00126	0.87846	hcsrcyct12_36_2_3	0.87675	0.00112	0.87899
ncsrcyct11_36_2_4	1.4	36000	36000	7673	5.56	1.0E-03	0.87655	0.00100	0.87856	hcsrcyct12_36_2_4	0.87798	0.00106	0.88011
ncsrcyct11_36_2_5	1.4	36000	36000	7673	5.56	1.0E-02	0.87634	0.00104	0.87843	hcsrcyct12_36_2_5	0.87876	0.00109	0.88094
ncsrcyct11_36_2_6	1.4	36000	36000	7673	5.56	1.0E-01	0.87971	0.00102	0.88174	hcsrcyct12_36_2_6	0.88317	0.00111	0.88539
ncsrcyct11_36_2_8	1.4	36000	36000	7673	5.56	3.0E-01	0.88865	0.00115	0.89094	hcsrcyct12_36_2_8	0.89169	0.00103	0.89375
ncsrcyct11_36_2_15	1.4	36000	36000	7673	5.56	1.0E+00	0.91608	0.00120	0.91847	hcsrcyct12_36_2_15	0.91815	0.00118	0.92050
ncsrcyct11_36_2_15	1.4	36000	36000	7673	5.56	1.0E+00	0.91608	0.00120	0.91847	hcsrcyct12_36_2_15	0.91815	0.00118	0.92050
ncsrcyct11_35_2_15	1.4	35000	35000	7726	5.76	1.0E+00	0.91190	0.00116	0.91422	hcsrcyct12_35_2_15	0.91300	0.00117	0.91534
ncsrcyct11_34_2_15	1.4	34000	34000	7779	5.97	1.0E+00	0.90497	0.00112	0.90721	hcsrcyct12_34_2_15	0.90616	0.00116	0.90848
ncsrcyct11_33_2_15	1.4	33000	33000	7832	6.19	1.0E+00	0.90032	0.00120	0.90272	hcsrcyct12_33_2_15	0.90269	0.00118	0.90506
ncsrcyct11_32_2_15	1.4	32000	32000	7885	6.43	1.0E+00	0.89251	0.00102	0.89455	hcsrcyct12_32_2_15	0.89526	0.00120	0.89766

Table 6.9.6-7. Results for 4.25 in.-diam cylinder HEU metal content in packaging calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsrcyct11_32_2_15(n)	1.4	32000	32000	7885	6.43	1.0E+00	0.89586	0.00062	0.89710	hcsrcyct12_32_2_15(n)	0.89778	0.00061	0.89900
ncsrcyct11p_32_2_15	1.4	32000	32000	7885	6.43	1.0E+00	0.88573	0.00059	0.88691	hcsrcyct12p_32_2_15	0.88811	0.00063	0.88937
ncsrcyct11_31_2_15	1.4	31000	31000	7938	6.68	1.0E+00	0.88531	0.00136	0.88803	hcsrcyct12_31_2_15	0.88765	0.00108	0.88981
ncsrcyct11_30_2_15	1.4	30000	30000	7992	6.95	1.0E+00	0.88012	0.00120	0.88252	hcsrcyct12_30_2_15	0.88005	0.00120	0.88246
content in flooded containment vessel, array packaging model for CSI=0.0													
NCT										**HAC**			
no can spacers (np thickness = 0.0 in.)													
nciacyct11_36_1_3	0.0	36000	36000	8287	6.01	1.0E-04	1.10334	0.00135	1.10604	hciacyct12_36_1_3	1.10722	0.00119	1.10961
nciacyct11_35_1_3	0.0	35000	35000	8340	6.22	1.0E-04	1.10128	0.00116	1.10360	hciacyct12_35_1_3	1.10067	0.00114	1.10295
nciacyct11_34_1_3	0.0	34000	34000	8393	6.44	1.0E-04	1.09399	0.00125	1.09648	hciacyct12_34_1_3	1.09477	0.00124	1.09726
nciacyct11_33_1_3	0.0	33000	33000	8446	6.68	1.0E-04	1.08794	0.00127	1.09048	hciacyct12_33_1_3	1.08942	0.00134	1.09210
nciacyct11_32_1_3	0.0	32000	32000	8499	6.93	1.0E-04	1.08183	0.00131	1.08444	hciacyct12_32_1_3	1.08089	0.00128	1.08346
nciacyct11_31_1_3	0.0	31000	31000	8552	7.20	1.0E-04	1.07391	0.00114	1.07619	hciacyct12_31_1_3	1.07627	0.00101	1.07829
nciacyct11_30_1_3	0.0	30000	30000	8605	7.49	1.0E-04	1.06840	0.00131	1.07102	hciacyct12_30_1_3	1.06781	0.00107	1.06994
nciacyct11_29_1_3	0.0	29000	29000	8658	7.79	1.0E-04	1.06070	0.00108	1.06286	hciacyct12_29_1_3	1.05946	0.00121	1.06188
nciacyct11_28_1_3	0.0	28000	28000	8711	8.12	1.0E-04	1.05398	0.00116	1.05630	hciacyct12_28_1_3	1.05253	0.00102	1.05457
nciacyct11_27_1_3	0.0	27000	27000	8764	8.47	1.0E-04	1.04385	0.00142	1.04670	hciacyct12_27_1_3	1.04481	0.00121	1.04723
nciacyct11_26_1_3	0.0	26000	26000	8817	8.85	1.0E-04	1.03489	0.00124	1.03736	hciacyct12_26_1_3	1.03688	0.00118	1.03923
nciacyct11_25_1_3	0.0	25000	25000	8870	9.26	1.0E-04	1.02495	0.00128	1.02751	hciacyct12_25_1_3	1.02706	0.00120	1.02946
nciacyct11_24_1_3	0.0	24000	24000	8923	9.70	1.0E-04	1.01610	0.00120	1.01850	hciacyct12_24_1_3	1.01634	0.00118	1.01870
nciacyct11_23_1_3	0.0	23000	23000	8977	10.19	1.0E-04	1.00723	0.00108	1.00938	hciacyct12_23_1_3	1.00427	0.00110	1.00648
nciacyct11_22_1_3	0.0	22000	22000	9030	10.71	1.0E-04	0.99573	0.00122	0.99817	hciacyct12_22_1_3	0.99481	0.00112	0.99705
nciacyct11_21_1_3	0.0	21000	21000	9083	11.29	1.0E-04	0.98149	0.00122	0.98393	hciacyct12_21_1_3	0.98514	0.00127	0.98768
nciacyct11_20_1_3	0.0	20000	20000	9136	11.92	1.0E-04	0.97377	0.00104	0.97585	hciacyct12_20_1_3	0.97210	0.00120	0.97450
nciacyct11_19_1_3	0.0	19000	19000	9189	12.62	1.0E-04	0.95985	0.00127	0.96240	hciacyct12_19_1_3	0.95807	0.00143	0.96092

Table 6.9.6-7. Results for 4.25 in.-diam cylinder HEU metal content in packaging calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciacyct11_18_1_3	0.0	18000	18000	9242	13.40	1.0E-04	0.94375	0.00137	0.94649	hciacyct12_18_1_3	0.94639	0.00124	0.94887
nciacyct11_15_1_3	0.0	15000	15000	9401	16.36	1.0E-04	0.89699	0.00109	0.89917	hciacyct12_15_1_3	0.89646	0.00108	0.89862
nciacyct11_15_1_3(n)	0.0	15000	15000	9401	16.36	1.0E-04	0.90101	0.00066	0.90233	hciacyct12_15_1_3(n)	0.89934	0.00066	0.90066
nciacyct11p_15_1_3	0.0	15000	15000	9401	16.36	1.0E-04	0.90614	0.00070	0.90754	hciacyct12p_15_1_3	0.90657	0.00068	0.90793
nciacyct11_12_1_3	0.0	12000	12000	9560	20.79	1.0E-04	0.83537	0.00118	0.83772	hciacyct12_12_1_3	0.83858	0.00118	0.84093
nciacyct11_9_1_3	0.0	9000	9000	9719	28.19	1.0E-04	0.76061	0.00121	0.76303	hciacyct12_9_1_3	0.75657	0.00112	0.75882
nciacyct11_6_1_3	0.0	6000	6000	9879	42.97	1.0E-04	0.64959	0.00106	0.65172	hciacyct12_6_1_3	0.64940	0.00109	0.65157
nciacyct11_3_1_3	0.0	3000	3000	10038	87.33	1.0E-04	0.48405	0.00103	0.48611	hciacyct12_3_1_3	0.48552	0.00096	0.48745
with can spacers (np thickness = 1.4 in.)													
nciacyct11_36_2_3	1.4	36000	36000	7673	5.56	1.0E-04	1.01018	0.00139	1.01297	hciacyct12_36_2_3	1.01024	0.00120	1.01263
nciacyct11_35_2_3	1.4	35000	35000	7726	5.76	1.0E-04	1.00029	0.00110	1.00249	hciacyct12_35_2_3	1.00083	0.00105	1.00293
nciacyct11_34_2_3	1.4	34000	34000	7779	5.97	1.0E-04	0.99523	0.00100	0.99723	hciacyct12_34_2_3	0.99499	0.00116	0.99731
nciacyct11_33_2_3	1.4	33000	33000	7832	6.19	1.0E-04	0.98713	0.00110	0.98932	hciacyct12_33_2_3	0.98922	0.00108	0.99139
nciacyct11_32_2_3	1.4	32000	32000	7885	6.43	1.0E-04	0.97809	0.00109	0.98028	hciacyct12_32_2_3	0.98046	0.00098	0.98242
nciacyct11_31_2_3	1.4	31000	31000	7938	6.68	1.0E-04	0.96968	0.00130	0.97227	hciacyct12_31_2_3	0.96951	0.00147	0.97246
nciacyct11_30_2_3	1.4	30000	30000	7992	6.95	1.0E-04	0.96031	0.00132	0.96295	hciacyct12_30_2_3	0.96156	0.00107	0.96370
nciacyct11_29_2_3	1.4	29000	29000	8045	7.24	1.0E-04	0.95128	0.00117	0.95362	hciacyct12_29_2_3	0.95414	0.00120	0.95654
nciacyct11_28_2_3	1.4	28000	28000	8098	7.55	1.0E-04	0.94378	0.00138	0.94654	hciacyct12_28_2_3	0.94376	0.00138	0.94652
nciacyct11_27_2_3	1.4	27000	27000	8151	7.88	1.0E-04	0.93234	0.00111	0.93456	hciacyct12_27_2_3	0.93273	0.00132	0.93536
nciacyct11_26_2_3	1.4	26000	26000	8204	8.24	1.0E-04	0.92078	0.00104	0.92287	hciacyct12_26_2_3	0.92390	0.00128	0.92646
nciacyct11_25_2_3	1.4	25000	25000	8257	8.62	1.0E-04	0.91264	0.00100	0.91465	hciacyct12_25_2_3	0.91352	0.00105	0.91562
nciacyct11_25_2_3(n)	1.4	25000	25000	8257	8.62	1.0E-04	0.91341	0.00057	0.91455	hciacyct12_25_2_3(n)	0.91300	0.00064	0.91428
nciacyct11p_25_2_3	1.4	25000	25000	8257	8.62	1.0E-04	0.90107	0.00055	0.90217	hciacyct12p_25_2_3	0.90095	0.00059	0.90213
nciacyct11_24_2_3	1.4	24000	24000	8310	9.04	1.0E-04	0.89955	0.00124	0.90203	hciacyct12_24_2_3	0.90170	0.00109	0.90388
nciacyct11_23_2_3	1.4	23000	23000	8363	9.49	1.0E-04	0.89118	0.00128	0.89374	hciacyct12_23_2_3	0.89159	0.00128	0.89414

Table 6.9.6-7. Results for 4.25 in.-diam cylinder HEU metal content in packaging calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciacyct11_22_2_3	1.4	22000	22000	8416	9.98	1.0E-04	0.87715	0.00098	0.87910	hciacyct12_22_2_3	0.87791	0.00103	0.87997
nciacyct11_21_2_3	1.4	21000	21000	8469	10.53	1.0E-04	0.86679	0.00109	0.86898	hciacyct12_21_2_3	0.86482	0.00106	0.86693
nciacyct11_20_2_3	1.4	20000	20000	8522	11.12	1.0E-04	0.85029	0.00131	0.85292	hciacyct12_20_2_3	0.85207	0.00119	0.85445
nciacyct11_19_2_3	1.4	19000	19000	8575	11.78	1.0E-04	0.83585	0.00110	0.83805	hciacyct12_19_2_3	0.83631	0.00101	0.83833
nciacyct11_18_2_3	1.4	18000	18000	8628	12.51	1.0E-04	0.82112	0.00105	0.82323	hciacyct12_18_2_3	0.82020	0.00108	0.82236
nciacyct11_15_2_3	1.4	15000	15000	8787	15.29	1.0E-04	0.77012	0.00102	0.77216	hciacyct12_15_2_3	0.77067	0.00099	0.77265
nciacyct11_12_2_3	1.4	12000	12000	8947	19.46	1.0E-04	0.70996	0.00113	0.71222	hciacyct12_12_2_3	0.70716	0.00100	0.70915
nciacyct11_9_2_3	1.4	9000	9000	9106	26.41	1.0E-04	0.38338	0.00093	0.38524	hciacyct12_9_2_3	0.62982	0.00097	0.63175
nciacyct11_6_2_3	1.4	6000	6000	9265	40.30	1.0E-04	0.63066	0.00100	0.63267	hciacyct12_6_2_3	0.52901	0.00100	0.53101
nciacyct11_3_2_3	1.4	3000	3000	9424	81.99	1.0E-04	0.52971	0.00101	0.53173	hciacyct12_3_2_3	0.38124	0.00075	0.38274

Table 6.9.6-8. Results for 1.5 in.-diam × 2.0 in.-tall slug HEU metal content in CV calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$	Content description
flooded containment vessel, reflected										
no can spacers (np thickness = 0.0 in.)										
cvcr5st11_1_1	0.0	18277	18277	9227	13.18	1.0E+00	0.90734	0.00123	0.90980	5 slugs in a pentagonal ring
cvcr5st11_1_1(n)	0.0	18277	18277	9227	13.18	1.0E+00	0.91514	0.0006	0.91634	5 slugs in a pentagonal ring, SCALE 6.1.3
cvcr5st11p_1_1	0.0	18277	18277	9227	13.18	1.0E+00	0.92015	0.00073	0.92161	5 slugs in a pentagonal ring, 500 g poly, SCALE 6.1.3
cvcr5est11_1_1	0.0	18277	18277	9227	13.18	1.0E+00	0.90718	0.00119	0.90955	5 slugs in a pentagonal ring, extended spacing
cvcr50st11_1	0.0	18277	18277	9227	13.18	1.0E+00	0.90671	0.00120	0.90911	5 slugs in cruciform pattern
cvcr5e0st11_1	0.0	18277	18277	9227	13.18	1.0E+00	0.90690	0.00124	0.90938	5 slugs in cruciform pattern, extended spacing
cvcr5u0st11_1	0.0	18277	18277	9227	13.18	1.0E+00	0.90690	0.00122	0.90935	5 slugs in four pointed star pattern

Table 6.9.6-8. Results for 1.5 in.-diam × 2.0 in.-tall slug HEU metal content in CV calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$	Content description
cvcr5l0st11_1	0.0	18277	18277	9227	13.18	1.0E+00	0.90660	0.00113	0.90885	5 slugs, filled hex. ring with 2 slugs missing
cvcr6st11_1_1	0.0	21933	21933	9033	10.75	1.0E+00	0.95173	0.00118	0.95409	6 slugs in a hexagonal ring
cvcr6e0st11_1	0.0	21933	21933	9033	10.75	1.0E+00	0.95531	0.00106	0.95742	6 slugs in pentagonal ring with center slug
cvcr70st11_1	0.0	25588	25588	8839	9.02	1.0E+00	0.99827	0.00135	1.00097	7 slugs in hexagonal ring with center slug
cvcr5st11_1_2	0.0	36555	36555	8257	5.90	1.0E+00	0.99909	0.00125	1.00158	10 slugs in stacked pentagonal rings
cvcr5est11_1_2	0.0	36555	36555	8257	5.90	1.0E+00	1.00409	0.00136	1.00681	10 slugs in stacked pent. rings, extended spacing
cvcr6e4st11_1	0.0	36555	36555	8257	5.90	1.0E+00	1.00361	0.00134	1.00630	10 slugs, lower 6 slugs in hex ring, upper 4 in square
cvcr73st11_1	0.0	36555	36555	8257	5.90	1.0E+00	1.00523	0.00127	1.00776	10 slugs, lower 7 slugs in hex ring, upper 3 in triangle
cvcr6st11_1_2	0.0	43865	43865	7869	4.68	1.0E+00	1.05336	0.00130	1.05597	12 slugs in stacked hexagonal rings
with can spacers (np thickness=1.4 in.)										
cvcr5st11_2_1	1.4	18277	18277	8613	12.30	1.0E+00	0.76864	0.00113	0.77089	5 slugs in a pentagonal ring
cvcr5est11_2_1	1.4	18277	18277	8613	12.30	1.0E+00	0.76420	0.00102	0.76624	5 slugs in a pentagonal ring, extended spacing
cvcr50st11_2	1.4	18277	18277	8613	12.30	1.0E+00	0.76929	0.00117	0.77163	5 slugs in cruciform pattern
cvcr5e0st11_2	1.4	18277	18277	8613	12.30	1.0E+00	0.76532	0.00127	0.76785	5 slugs in cruciform pattern, extended spacing
cvcr5u0st11_2	1.4	18277	18277	8613	12.30	1.0E+00	0.76953	0.00108	0.77168	5 slugs in four pointed star pattern
cvcr5l0st11_2	1.4	18277	18277	8613	12.30	1.0E+00	0.77162	0.00102	0.77366	5 slugs, filled hex. ring with 2 slugs missing
cvcr6st11_2_1	1.4	21933	21933	8419	10.02	1.0E+00	0.81300	0.00148	0.81596	6 slugs in a hexagonal ring
cvcr6e0st11_2	1.4	21933	21933	8419	10.02	1.0E+00	0.81943	0.00116	0.82176	6 slugs in pentagonal ring with center slug
cvcr70st11_2	1.4	25588	25588	8225	8.39	1.0E+00	0.86296	0.00104	0.86503	7 slugs in hexagonal ring with center slug
cvcr5st11_2_2	1.4	36555	36555	7643	5.46	1.0E+00	0.90058	0.00115	0.90287	10 slugs in stacked pentagonal rings
cvcr5st11_2_2(n)	1.4	36555	36555	7643	5.46	1.0E+00	0.90561	0.00061	0.90683	10 slugs in stacked pentagonal rings, SCALE 6.1.3
cvcr5st11p_2_2	1.4	36555	36555	7643	5.46	1.0E+00	0.90566	0.0007	0.90706	10 slugs in stacked pentagonal rings, 500 g poly, SCALE 6.1.3
cvcr5est11_2_2	1.4	36555	36555	7643	5.46	1.0E+00	0.89862	0.00121	0.90104	10 slugs in stacked pent. rings, extended spacing
cvcr6e4st11_2	1.4	36555	36555	7643	5.46	1.0E+00	0.89991	0.00109	0.90209	10 slugs, lower 6 slugs in hex ring, upper 4 in square
cvcr73st11_2	1.4	36555	36555	7643	5.46	1.0E+00	0.89922	0.00109	0.90139	10 slugs, lower 7 slugs in hex ring, upper 3 in triangle

Table 6.9.6-8. Results for 1.5 in.-diam × 2.0 in.-tall slug HEU metal content in CV calculation model

Case	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$	Content description
cvcr6st11_2_2	1.4	43865	43865	7256	4.32	1.0E+00	0.94962	0.00126	0.95213	12 slugs in stacked hexagonal rings
evaluation of model approximations in no can spacer configurations (np thickness=0.0002 in.)										
cvcr6e0st11_1	0.0	21933	21933	9033	10.75	1.0E+00	0.95531	0.00106	0.95742	6 slugs in pentagonal ring with center slug
cv0r6e0s_1	0.0	21933	21933	9033	10.75	1.0E+00	0.95418	0.00135	0.95689	0.0002 cm thick spacers voided in above model
cvwr6e0s_1	0.0	21933	21933	9033	10.75	1.0E+00	0.95384	0.00117	0.95618	0.0002 cm thick spacers replaced with water in above
cvcr70st11_1	0.0	25588	25588	8839	9.02	1.0E+00	0.99827	0.00135	1.00097	7 slugs, hex ring with slug in center
cv0r70s_1	0.0	25588	25588	8839	9.02	1.0E+00	0.99814	0.00118	1.00051	0.0002 cm thick spacers voided in above model
cvwr70s_1	0.0	25588	25588	8839	9.02	1.0E+00	0.99847	0.00120	1.00088	0.0002 cm thick spacers flooded in above model
evaluation of model approximations in configurations with can spacers (np thickness=1.4 in.)										
cvcr6e0st11_2	1.4	21933	21933	8419	10.02	1.0E+00	0.81943	0.00116	0.82176	6 slugs in pentagonal ring with center slug
cv0r6e0s_2	1.4	21933	21933	8419	10.02	1.0E+00	0.84682	0.00118	0.84918	1.4 in thick spacers voided in above model
cvcr6e0st11_1	0.0	21933	21933	9033	10.75	1.0E+00	0.95531	0.00106	0.95742	6 slugs in pentagonal ring with center slug
cvwr6e0s_2	1.4	21933	21933	9033	10.75	1.0E+00	0.89988	0.00138	0.90263	1.4 in thick spacers replace with water
cvcr70st11_2	1.4	25588	25588	8225	8.39	1.0E+00	0.86296	0.00104	0.86503	7 slugs, hex ring with slug in center
cv0r70s_2	1.4	25588	25588	8225	8.39	1.0E+00	0.88250	0.00110	0.88470	1.4 in thick spacers voided in above model
cvcr70st11_1	0.0	25588	25588	8839	9.02	1.0E+00	0.99827	0.00135	1.00097	7 slugs, hex ring with slug in center
cvwr70s_2	1.4	25588	25588	8839	9.02	1.0E+00	0.93953	0.00111	0.94175	1.4 in thick spacers replace with water

Table 6.9.6-9. Results for 1.5 in.-diam × 2.0 in.-tall slug HEU metal content in packaging calculation model

Case	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded containment vessel, single package reflected													
NCT										HAC			
no can spacers (np thickness = 0.0 in.)													
ncsr5est11_1_1_15	100	18277	18277	9227	13.18	1.0E+00	0.86857	0.00128	0.87113	hcsr5est12_1_1_15	0.87319	0.00116	0.87551
ncsr5st11_1_1_15	100	18277	18277	9227	13.18	1.0E+00	0.88102	0.00119	0.88339	hcsr5st12_1_1_15	0.88322	0.00142	0.88606
ncsr5st11_1_1_15(n)	100	18277	18277	9227	13.18	1.0E+00	0.87487	0.00068	0.87623	hcsr5est12_1_1_15(n)	0.88673	0.00061	0.88795
ncsr5st11p_1_1_15	100	18277	18277	9227	13.18	1.0E+00	0.88341	0.00067	0.88475	hcsr5st12p_1_1_15	0.87734	0.00064	0.87862
ncsr6st11_1_1_15	100	21933	21933	9033	10.75	1.0E+00	0.91461	0.00110	0.91680				
ncsr5est11_1_2_15	100	36555	36555	8257	5.90	1.0E+00	0.96511	0.00123	0.96756	hcsr5est12_1_2_15	0.96512	0.00128	0.96768
ncsr5st11_1_2_15	100	36555	36555	8257	5.90	1.0E+00	0.96727	0.00116	0.96960	hcsr5st12_1_2_15	0.97082	0.00124	0.97330
ncsr6e4st11_1_1	100	36555	36555	8257	5.90	1.0E-20	0.92156	0.00105	0.92367				
ncsr6e4st11_1_2	100	36555	36555	8257	5.90	1.0E-05	0.92051	0.00114	0.92279				
ncsr6e4st11_1_3	100	36555	36555	8257	5.90	1.0E-04	0.92239	0.00107	0.92453				
ncsr6e4st11_1_4	100	36555	36555	8257	5.90	1.0E-03	0.91834	0.00126	0.92086				
ncsr6e4st11_1_5	100	36555	36555	8257	5.90	1.0E-02	0.92233	0.00111	0.92455				
ncsr6e4st11_1_6	100	36555	36555	8257	5.90	1.0E-01	0.92584	0.00123	0.92830				
ncsr6e4st11_1_8	100	36555	36555	8257	5.90	3.0E-01	0.93741	0.00125	0.93990				
ncsr6e4st11_1_15	100	36555	36555	8257	5.90	1.0E+00	0.97010	0.00114	0.97238				
ncsr73st11_1_1	100	36555	36555	8257	5.90	1.0E-20	0.92144	0.00127	0.92399				
ncsr73st11_1_2	100	36555	36555	8257	5.90	1.0E-05	0.92591	0.00108	0.92808				
ncsr73st11_1_3	100	36555	36555	8257	5.90	1.0E-04	0.92106	0.00121	0.92348				
ncsr73st11_1_4	100	36555	36555	8257	5.90	1.0E-03	0.92326	0.00122	0.92570				

Table 6.9.6-9. Results for 1.5 in.-diam × 2.0 in.-tall slug HEU metal content in packaging calculation model

Case	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsr73st11_1_5	100	36555	36555	8257	5.90	1.0E-02	0.92213	0.00113	0.92439				
ncsr73st11_1_6	100	36555	36555	8257	5.90	1.0E-01	0.92784	0.00111	0.93007				
ncsr73st11_1_8	100	36555	36555	8257	5.90	3.0E-01	0.93898	0.00115	0.94128				
ncsr73st11_1_15	100	36555	36555	8257	5.90	1.0E+00	0.96854	0.00128	0.97110				
ncsr6st11_1_2_15	100	43865	43865	7869	4.68	1.0E+00	1.01197	0.00132	1.01461				
with can spacers (np thickness = 1.4 in.)													
ncsr5est11_2_1_1	100	18277	18277	8613	12.30	1.0E-20	0.68597	0.00122	0.68841	hcsr5est12_2_1_1	0.68926	0.00101	0.69128
ncsr5est11_2_1_2	100	18277	18277	8613	12.30	1.0E-05	0.68486	0.00101	0.68688	hcsr5est12_2_1_2	0.68645	0.00110	0.68866
ncsr5est11_2_1_3	100	18277	18277	8613	12.30	1.0E-04	0.68766	0.00128	0.69022	hcsr5est12_2_1_3	0.68796	0.00105	0.69007
ncsr5est11_2_1_4	100	18277	18277	8613	12.30	1.0E-03	0.68729	0.00120	0.68969	hcsr5est12_2_1_4	0.68815	0.00098	0.69010
ncsr5est11_2_1_5	100	18277	18277	8613	12.30	1.0E-02	0.68465	0.00128	0.68720	hcsr5est12_2_1_5	0.69008	0.00097	0.69201
ncsr5est11_2_1_6	100	18277	18277	8613	12.30	1.0E-01	0.68906	0.00105	0.69117	hcsr5est12_2_1_6	0.69613	0.00117	0.69847
ncsr5est11_2_1_8	100	18277	18277	8613	12.30	3.0E-01	0.70289	0.00101	0.70491	hcsr5est12_2_1_8	0.70357	0.00107	0.70571
ncsr5est11_2_1_15	100	18277	18277	8613	12.30	1.0E+00	0.73412	0.00109	0.73629	hcsr5est12_2_1_15	0.73557	0.00101	0.73759
ncsr5st11_2_1_1	100	18277	18277	8613	12.30	1.0E-20	0.70896	0.00096	0.71087				
ncsr5st11_2_1_2	100	18277	18277	8613	12.30	1.0E-05	0.70901	0.00095	0.71092				
ncsr5st11_2_1_3	100	18277	18277	8613	12.30	1.0E-04	0.71109	0.00096	0.71300				
ncsr5st11_2_1_4	100	18277	18277	8613	12.30	1.0E-03	0.70980	0.00102	0.71184				
ncsr5st11_2_1_5	100	18277	18277	8613	12.30	1.0E-02	0.71089	0.00103	0.71294				
ncsr5st11_2_1_6	100	18277	18277	8613	12.30	1.0E-01	0.71505	0.00112	0.71729				
ncsr5st11_2_1_8	100	18277	18277	8613	12.30	3.0E-01	0.72364	0.00121	0.72605				
ncsr5st11_2_1_15	100	18277	18277	8613	12.30	1.0E+00	0.74773	0.00114	0.75001	hcsr5st12_2_1_15	0.74885	0.00101	0.75087

Table 6.9.6-9. Results for 1.5 in.-diam × 2.0 in.-tall slug HEU metal content in packaging calculation model

Case	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsr6st11_2_1_1	100	21933	21933	8419	10.02	1.0E-20	0.73305	0.00104	0.73514				
ncsr6st11_2_1_2	100	21933	21933	8419	10.02	1.0E-05	0.73284	0.00105	0.73494				
ncsr6st11_2_1_3	100	21933	21933	8419	10.02	1.0E-04	0.73419	0.00111	0.73641				
ncsr6st11_2_1_4	100	21933	21933	8419	10.02	1.0E-03	0.73339	0.00106	0.73551				
ncsr6st11_2_1_5	100	21933	21933	8419	10.02	1.0E-02	0.73282	0.00101	0.73484				
ncsr6st11_2_1_6	100	21933	21933	8419	10.02	1.0E-01	0.73962	0.00104	0.74170				
ncsr6st11_2_1_8	100	21933	21933	8419	10.02	3.0E-01	0.74981	0.00112	0.75206				
ncsr6st11_2_1_15	100	21933	21933	8419	10.02	1.0E+00	0.78295	0.00118	0.78531				
ncsr5est11_2_2_1	100	36555	36555	7643	5.46	1.0E-20	0.81441	0.00102	0.81646	hcsr5est12_2_2_1	0.81949	0.00126	0.82202
ncsr5est11_2_2_2	100	36555	36555	7643	5.46	1.0E-05	0.81751	0.00107	0.81966	hcsr5est12_2_2_2	0.81765	0.00108	0.81981
ncsr5est11_2_2_3	100	36555	36555	7643	5.46	1.0E-04	0.81443	0.00110	0.81664	hcsr5est12_2_2_3	0.81691	0.00115	0.81922
ncsr5est11_2_2_4	100	36555	36555	7643	5.46	1.0E-03	0.81628	0.00124	0.81876	hcsr5est12_2_2_4	0.81854	0.00123	0.82100
ncsr5est11_2_2_5	100	36555	36555	7643	5.46	1.0E-02	0.81513	0.00118	0.81749	hcsr5est12_2_2_5	0.81898	0.00104	0.82106
ncsr5est11_2_2_6	100	36555	36555	7643	5.46	1.0E-01	0.82099	0.00114	0.82326	hcsr5est12_2_2_6	0.82414	0.00111	0.82636
ncsr5est11_2_2_8	100	36555	36555	7643	5.46	3.0E-01	0.83205	0.00109	0.83424	hcsr5est12_2_2_8	0.83469	0.00107	0.83683
ncsr5est11_2_2_15	100	36555	36555	7643	5.46	1.0E+00	0.86471	0.00124	0.86719	hcsr5est12_2_2_15	0.86591	0.00115	0.86822
ncsr5est11_2_2_15(n)	100	36555	36555	7643	5.46	1.0E+00	0.87962	0.00065	0.88092	hcsr5est12_2_2_15(n)	0.88067	0.00064	0.88195
ncsr5est11p_2_2_15	100	36555	36555	7643	5.46	1.0E+00	0.87589	0.00064	0.87717	hcsr5est12_2_2_15p	0.87734	0.00064	0.87862
ncsr5st11_2_2_1	100	36555	36555	7643	5.46	1.0E-20	0.83654	0.00109	0.83872				
ncsr5st11_2_2_2	100	36555	36555	7643	5.46	1.0E-05	0.83389	0.00104	0.83597				
ncsr5st11_2_2_3	100	36555	36555	7643	5.46	1.0E-04	0.83615	0.00113	0.83841				
ncsr5st11_2_2_4	100	36555	36555	7643	5.46	1.0E-03	0.83524	0.00141	0.83806				
ncsr5st11_2_2_5	100	36555	36555	7643	5.46	1.0E-02	0.83580	0.00109	0.83797				

Table 6.9.6-9. Results for 1.5 in.-diam × 2.0 in.-tall slug HEU metal content in packaging calculation model

Case	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsr5st11_2_2_6	100	36555	36555	7643	5.46	1.0E-01	0.84206	0.00110	0.84426				
ncsr5st11_2_2_8	100	36555	36555	7643	5.46	3.0E-01	0.85011	0.00135	0.85281				
ncsr5st11_2_2_15	100	36555	36555	7643	5.46	1.0E+00	0.87549	0.00131	0.87810	hcsr5st12_2_2_15	0.87483	0.00116	0.87715
ncsr6e4st11_2_1	100	36555	36555	7643	5.46	1.0E-20	0.83636	0.00110	0.83857				
ncsr6e4st11_2_2	100	36555	36555	7643	5.46	1.0E-05	0.83532	0.00112	0.83757				
ncsr6e4st11_2_3	100	36555	36555	7643	5.46	1.0E-04	0.83689	0.00118	0.83924				
ncsr6e4st11_2_4	100	36555	36555	7643	5.46	1.0E-03	0.83744	0.00114	0.83972				
ncsr6e4st11_2_5	100	36555	36555	7643	5.46	1.0E-02	0.83615	0.00122	0.83858				
ncsr6e4st11_2_6	100	36555	36555	7643	5.46	1.0E-01	0.84173	0.00127	0.84426				
ncsr6e4st11_2_8	100	36555	36555	7643	5.46	3.0E-01	0.84987	0.00113	0.85213				
ncsr6e4st11_2_15	100	36555	36555	7643	5.46	1.0E+00	0.87722	0.00131	0.87984				
ncsr73st11_2_1	100	36555	36555	7643	5.46	1.0E-20	0.83665	0.00111	0.83887				
ncsr73st11_2_2	100	36555	36555	7643	5.46	1.0E-05	0.83570	0.00116	0.83801				
ncsr73st11_2_3	100	36555	36555	7643	5.46	1.0E-04	0.83716	0.00115	0.83946				
ncsr73st11_2_4	100	36555	36555	7643	5.46	1.0E-03	0.83728	0.00117	0.83961				
ncsr73st11_2_5	100	36555	36555	7643	5.46	1.0E-02	0.83790	0.00116	0.84023				
ncsr73st11_2_6	100	36555	36555	7643	5.46	1.0E-01	0.84068	0.00120	0.84309				
ncsr73st11_2_8	100	36555	36555	7643	5.46	3.0E-01	0.84928	0.00106	0.85139				
ncsr73st11_2_15	100	36555	36555	7643	5.46	1.0E+00	0.87257	0.00099	0.87455				
ncsr6st11_2_2_1	100	43865	43865	7256	4.32	1.0E-20	0.86427	0.00104	0.86636				
ncsr6st11_2_2_2	100	43865	43865	7256	4.32	1.0E-05	0.86386	0.00108	0.86601				
ncsr6st11_2_2_3	100	43865	43865	7256	4.32	1.0E-04	0.86637	0.00117	0.86870				

Table 6.9.6-9. Results for 1.5 in.-diam × 2.0 in.-tall slug HEU metal content in packaging calculation model

Case	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsr6st11_2_2_4	100	43865	43865	7256	4.32	1.0E-03	0.86498	0.00125	0.86747				
ncsr6st11_2_2_5	100	43865	43865	7256	4.32	1.0E-02	0.86541	0.00116	0.86773				
ncsr6st11_2_2_6	100	43865	43865	7256	4.32	1.0E-01	0.87070	0.00111	0.87292				
ncsr6st11_2_2_8	100	43865	43865	7256	4.32	3.0E-01	0.88148	0.00122	0.88392				
ncsr6st11_2_2_15	100	43865	43865	7256	4.32	1.0E+00	0.91478	0.00118	0.91713				
content in flooded containment vessel, array packaging model for CSI=0.0													
NCT										**HAC**			
no can spacers (np thickness = 0.0 in.)													
ncia5est11_1_1_8_3	100	18277	18277	9227	13.18	1.0E-04	0.92163	0.00126	0.92414	hcia5est12_1_1_8_3	0.91941	0.00126	0.92194
ncia5est11_1_1_7_3	95	18289	17374	9227	13.86	1.0E-04	0.90412	0.00109	0.90630	hcia5est12_1_1_7_3	0.90066	0.00110	0.90285
ncia5est11_1_1_5_3	90	18324	14659	9227	16.43	1.0E-04	0.85207	0.00110	0.85427	hcia5est12_1_1_6_3	0.88401	0.00108	0.88616
ncia5est11_1_1_4_3	80	18347	12843	9227	18.75	1.0E-04	0.81402	0.00108	0.81617	hcia5est12_1_1_5_3	0.84983	0.00117	0.85217
ncia5est11_1_1_6_3	70	18300	16470	9227	14.62	1.0E-04	0.88510	0.00118	0.88746	hcia5est12_1_1_4_3	0.81368	0.00111	0.81590
ncia5est11_1_1_3_3	60	18370	11022	9227	21.85	1.0E-04	0.77131	0.00109	0.77349	hcia5est12_1_1_3_3	0.77296	0.00113	0.77523
ncia5est11_1_1_2_3	40	18417	7367	9227	32.69	1.0E-04	0.67736	0.00103	0.67943	hcia5est12_1_1_2_3	0.67968	0.00108	0.68184
ncia5est11_1_1_1_3	19	18466	3509	9227	68.64	1.0E-04	0.54780	0.00092	0.54964	hcia5est12_1_1_1_3	0.54586	0.00117	0.54819
ncia5st11_1_1_8_3	100	18277	18277	9227	13.18	1.0E-04	0.92611	0.00127	0.92865	hcia5st12_1_1_8_3	0.92609	0.00110	0.92829
ncia5st11_1_1_7_3	95	18289	17374	9227	13.86	1.0E-04	0.90538	0.00116	0.90769	hcia5st12_1_1_7_3	0.90683	0.00113	0.90909
ncia5st11_1_1_7_3(n)	95	18289	17374	9227	13.86	1.0E-04	0.91153	0.00068	0.91289	hcia5st12_1_1_7_3(n)	0.91061	0.0006	0.91181
ncia5st11p_1_1_7_3	95	18289	17374	9227	13.86	1.0E-04	0.91659	0.00069	0.91797	hcia5st12p_1_1_7_3	0.91759	0.00074	0.91907
ncia5st11_1_1_5_3	90	18324	14659	9227	16.43	1.0E-04	0.88586	0.00112	0.88811	hcia5st12_1_1_6_3	0.88827	0.00110	0.89046
ncia5st11_1_1_4_3	80	18347	12843	9227	18.75	1.0E-04	0.84871	0.00124	0.85119	hcia5st12_1_1_5_3	0.85050	0.00113	0.85276
ncia5st11_1_1_6_3	70	18300	16470	9227	14.62	1.0E-04	0.80834	0.00102	0.81037	hcia5st12_1_1_4_3	0.80870	0.00112	0.81094
ncia5st11_1_1_3_3	60	18370	11022	9227	21.85	1.0E-04	0.76467	0.00098	0.76663	hcia5st12_1_1_3_3	0.76245	0.00105	0.76454

Table 6.9.6-9. Results for 1.5 in.-diam × 2.0 in.-tall slug HEU metal content in packaging calculation model

Case	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncia5st11_1_1_2_3	40	18417	7367	9227	32.69	1.0E-04	0.66040	0.00106	0.66252	hcia5st12_1_1_2_3	0.65955	0.00097	0.66149
ncia5st11_1_1_1_3	19	18466	3509	9227	68.64	1.0E-04	0.51929	0.00090	0.52109	hcia5st12_1_1_1_3	0.51805	0.00084	0.51973
with can spacers (np thickness = 1.4 in.)													
ncia5est11_2_1_8_3	100	18277	18277	8613	12.30	1.0E-04	0.80353	0.00113	0.80580	hcia5est12_2_1_8_3	0.80594	0.00121	0.80835
ncia5est11_2_1_7_3	95	18289	17374	8613	12.94	1.0E-04	0.78741	0.00118	0.78977	hcia5est12_2_1_7_3	0.78684	0.00107	0.78898
ncia5est11_2_1_6_3	90	18300	16470	8613	13.65	1.0E-04	0.77061	0.00112	0.77285	hcia5est12_2_1_6_3	0.77268	0.00114	0.77496
ncia5est11_2_1_5_3	80	18324	14659	8613	15.34	1.0E-04	0.73732	0.00118	0.73969	hcia5est12_2_1_5_3	0.73645	0.00094	0.73834
ncia5est11_2_1_4_3	70	18347	12843	8613	17.51	1.0E-04	0.70261	0.00108	0.70477	hcia5est12_2_1_4_3	0.70418	0.00107	0.70631
ncia5est11_2_1_3_3	60	18370	11022	8613	20.40	1.0E-04	0.66332	0.00094	0.66520	hcia5est12_2_1_3_3	0.66396	0.00114	0.66624
ncia5est11_2_1_2_3	40	18417	7367	8613	30.52	1.0E-04	0.57466	0.00097	0.57660	hcia5est12_2_1_2_3	0.57526	0.00080	0.57687
ncia5est11_2_1_1_3	19	18466	3509	8613	64.08	1.0E-04	0.45117	0.00082	0.45280	hcia5est12_2_1_1_3	0.45114	0.00084	0.45281
ncia70st11_2_8_3	100	25588	25588	8225	8.39	1.0E-04	0.91300	0.00104	0.91507	hcia70st12_2_8_3	0.91329	0.00111	0.91551
ncia70st11_2_7_3	95	25604	24324	8225	8.83	1.0E-04	0.89143	0.00108	0.89360	hcia70st12_2_7_3	0.89210	0.00124	0.89457
ncia70st11_2_7_3(n)	95	25604	24324	8225	8.83	1.0E-04	0.89504	0.00065	0.89634	hcia70st12_2_7_3(n)	0.89481	0.00059	0.85099
ncia70st11p_2_7_3	95	25604	24324	8225	8.83	1.0E-04	0.88248	0.00062	0.88372	hcia70st12p_2_7_3	0.88246	0.00066	0.88378
ncia70st11_2_6_3	90	25621	23059	8225	9.31	1.0E-04	0.87368	0.00108	0.87585	hcia70st12_2_6_3	0.87198	0.00113	0.87425
ncia70st11_2_5_3	80	25653	20522	8225	10.46	1.0E-04	0.83357	0.00110	0.83577	hcia70st12_2_5_3	0.83150	0.00106	0.83362
ncia70st11_2_4_3	70	25686	17980	8225	11.94	1.0E-04	0.78606	0.00105	0.78816	hcia70st12_2_4_3	0.78783	0.00099	0.78981
ncia70st11_2_3_3	60	25718	15431	8225	13.91	1.0E-04	0.73820	0.00099	0.74017	hcia70st12_2_3_3	0.73745	0.00100	0.73944
ncia70st11_2_2_3	40	25784	10313	8225	20.82	1.0E-04	0.62591	0.00090	0.62771	hcia70st12_2_2_3	0.62664	0.00107	0.62878
ncia70st11_2_1_3	19	25853	4912	8225	43.71	1.0E-04	0.47179	0.00077	0.47333	hcia70st12_2_1_3	0.47178	0.00086	0.47349
ncia5est11_2_2_8_3	100	36555	36555	7643	5.46	1.0E-04	0.98202	0.00112	0.98425	hcia5est12_2_2_8_3	0.98033	0.00111	0.98254
ncia5est11_2_2_7_3	95	36578	34749	7643	5.74	1.0E-04	0.96108	0.00119	0.96346	hcia5est12_2_2_7_3	0.96166	0.00113	0.96392

Table 6.9.6-9. Results for 1.5 in.-diam × 2.0 in.-tall slug HEU metal content in packaging calculation model

Case	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncia5est11_2_2_6_3	90	36601	32941	7643	6.06	1.0E-04	0.94424	0.00134	0.94692	hcia5est12_2_2_6_3	0.94560	0.00118	0.94796
ncia5est11_2_2_5_3	80	36647	29318	7643	6.80	1.0E-04	0.90628	0.00109	0.90846	hcia5est12_2_2_5_3	0.90763	0.00117	0.90997
ncia5est11_2_2_5_3(n)	80	36647	29318	7643	6.80	1.0E-04	0.90942	0.00057	0.91056	hcia5est12_2_2_5_3(n)	0.90946	0.00060	0.91066
ncia5est11_2_2_5_3p	80	36647	29318	7643	6.80	1.0E-04	0.90559	0.00079	0.90717	hcia5est12p_2_2_5_3	0.90458	0.00065	0.90588
ncia5est11_2_2_4_3	70	36694	25686	7643	7.77	1.0E-04	0.86606	0.00104	0.86814	hcia5est12_2_2_4_3	0.86855	0.00104	0.87064
ncia5est11_2_2_3_3	60	36740	22044	7643	9.05	1.0E-04	0.82451	0.00098	0.82647	hcia5est12_2_2_3_3	0.82536	0.00115	0.82767
ncia5est11_2_2_2_3	40	36834	14734	7643	13.54	1.0E-04	0.72349	0.00093	0.72535	hcia5est12_2_2_2_3	0.72285	0.00114	0.72513
ncia5est11_2_2_1_3	19	36932	7017	7643	28.43	1.0E-04	0.58171	0.00100	0.58370	hcia5est12_2_2_1_3	0.58235	0.00096	0.58427
ncia5st11_2_2_8_3	100	36555	36555	7643	5.46	1.0E-04	0.97720	0.00133	0.97986	hcia5st12_2_2_8_3	0.97562	0.00123	0.97807
ncia5st11_2_2_7_3	95	36578	34749	7643	5.74	1.0E-04	0.95854	0.00105	0.96064	hcia5st12_2_2_7_3	0.95594	0.00097	0.95789
ncia5st11_2_2_6_3	90	36601	32941	7643	6.06	1.0E-04	0.93619	0.00132	0.93883	hcia5st12_2_2_6_3	0.93579	0.00110	0.93800
ncia5st11_2_2_5_3	80	36647	29318	7643	6.80	1.0E-04	0.90011	0.00117	0.90244	hcia5st12_2_2_5_3	0.89786	0.00154	0.90095
ncia5st11_2_2_4_3	70	36694	25686	7643	7.77	1.0E-04	0.85499	0.00102	0.85703	hcia5st12_2_2_4_3	0.85363	0.00119	0.85601
ncia5st11_2_2_3_3	60	36740	22044	7643	9.05	1.0E-04	0.80868	0.00116	0.81101	hcia5st12_2_2_3_3	0.80882	0.00105	0.81091
ncia5st11_2_2_2_3	40	36834	14734	7643	13.54	1.0E-04	0.70077	0.00098	0.70274	hcia5st12_2_2_2_3	0.70205	0.00105	0.70415
ncia5st11_2_2_1_3	19	36932	7017	7643	28.43	1.0E-04	0.55139	0.00095	0.55330	hcia5st12_2_2_1_3	0.55187	0.00101	0.55389
content in flooded containment vessel, array packaging model for CSI=0.4													
NCT										**HAC**			
no can spacers (np thickness = 0.0 in.)													
ncf15est11_1_1_8_3	100	18277	18277	9227	13.18	1.0E-04	0.88418	0.00084	0.88586	hcf25est12_1_1_8_3	0.86992	0.00106	0.87204
ncf15est11_1_1_7_3	95	18289	17374	9227	13.86	1.0E-04	0.86612	0.00059	0.86730	hcf25est12_1_1_7_3	0.85401	0.00126	0.85652
ncf15est11_1_1_6_3	90	18300	16470	9227	14.62	1.0E-04	0.84560	0.00061	0.84682	hcf25est12_1_1_6_3	0.83451	0.00102	0.83656
ncf15est11_1_1_5_3	80	18324	14659	9227	16.43	1.0E-04	0.81317	0.00063	0.81443	hcf25est12_1_1_5_3	0.80144	0.00107	0.80358
ncf15est11_1_1_4_3	70	18347	12843	9227	18.75	1.0E-04	0.77579	0.00064	0.77707	hcf25est12_1_1_4_3	0.76516	0.00111	0.76739

Table 6.9.6-9. Results for 1.5 in.-diam × 2.0 in.-tall slug HEU metal content in packaging calculation model

Case	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncf15est11_1_1_3_3	60	18370	11022	9227	21.85	1.0E-04	0.73496	0.00058	0.73612	hcf25est12_1_1_3_3	0.72484	0.00118	0.72719
ncf15est11_1_1_2_3	40	18417	7367	9227	32.69	1.0E-04	0.64298	0.00056	0.64410	hcf25est12_1_1_2_3	0.63366	0.00107	0.63580
ncf15est11_1_1_1_3	19	18466	3509	9227	68.64	1.0E-04	0.51690	0.00051	0.51792	hcf25est12_1_1_1_3	0.51052	0.00094	0.51241
with can spacers (np thickness = 1.4 in.)													
ncf15est11_2_1_8_3	100	18277	18277	8613	12.30	1.0E-04	0.76708	0.00067	0.76842	hcf25est12_2_1_8_3	0.75353	0.00102	0.75558
ncf15est11_2_1_7_3	95	18289	17374	8613	12.94	1.0E-04	0.75224	0.00073	0.75370	hcf25est12_2_1_7_3	0.73938	0.00109	0.74156
ncf15est11_2_1_6_3	90	18300	16470	8613	13.65	1.0E-04	0.73054	0.00065	0.73184	hcf25est12_2_1_6_3	0.72401	0.00105	0.72611
ncf15est11_2_1_5_3	80	18324	14659	8613	15.34	1.0E-04	0.70159	0.00063	0.70285	hcf25est12_2_1_5_3	0.69017	0.00089	0.69195
ncf15est11_2_1_4_3	70	18347	12843	8613	17.51	1.0E-04	0.66499	0.00057	0.66613	hcf25est12_2_1_4_3	0.65691	0.00113	0.65916
ncf15est11_2_1_3_3	60	18370	11022	8613	20.40	1.0E-04	0.62699	0.00059	0.62817	hcf25est12_2_1_3_3	0.61903	0.00111	0.62125
ncf15est11_2_1_2_3	40	18417	7367	8613	30.52	1.0E-04	0.54152	0.00058	0.54268	hcf25est12_2_1_2_3	0.53450	0.00087	0.53625
ncf15est11_2_1_1_3	19	18466	3509	8613	64.08	1.0E-04	0.42217	0.00057	0.42331	hcf25est12_2_1_1_3	0.41671	0.00077	0.41825
ncf15est11_2_2_8_3	100	36555	36555	7643	5.46	1.0E-04	0.94069	0.00064	0.94197	hcf25est12_2_2_8_3	0.92186	0.00104	0.92394
ncf15est11_2_2_7_3	95	36578	34749	7643	5.74	1.0E-04				hcf25est12_2_2_7_3	0.90286	0.00137	0.90560
ncf15est11_2_2_7_3(n)	95	36578	34749	7643	5.74	1.0E-04	0.92087	0.00066	0.92219	hcf25est12_2_2_7_3(n)	0.90669	0.00066	0.90801
ncf15est11p_2_2_7_3	95	36578	34749	7643	5.74	1.0E-04	0.92335	0.00060	0.92455	hcf25est12p_2_2_7_3	0.91112	0.00064	0.91240
ncf15est11_2_2_6_3	90	36601	32941	7643	6.06	1.0E-04	0.90079	0.00066	0.90211	hcf25est12_2_2_6_3	0.88774	0.00119	0.89013
ncf15est11_2_2_5_3(n)	80	36647	29318	7643	6.80	1.0E-04	0.86743	0.00057	0.86857	hcf25est12_2_2_5_3(n)	0.85393	0.00069	0.85831
ncf15est11p_2_2_5_3	80	36647	29318	7643	6.80	1.0E-04	0.86878	0.00064	0.87006	hcf25est12p_2_2_5_3	0.85621	0.00056	0.85733
ncf15est11_2_2_4_3	70	36694	25686	7643	7.77	1.0E-04	0.82679	0.00062	0.82803	hcf25est12_2_2_4_3	0.81165	0.00110	0.81386
ncf15est11_2_2_3_3	60	36740	22044	7643	9.05	1.0E-04	0.78443	0.00060	0.78563	hcf25est12_2_2_3_3	0.77147	0.00114	0.77375
ncf15est11_2_2_2_3	40	36834	14734	7643	13.54	1.0E-04	0.68550	0.00054	0.68658	hcf25est12_2_2_2_3	0.67454	0.00112	0.67679
ncf15est11_2_2_1_3	19	36932	7017	7643	28.43	1.0E-04	0.54840	0.00054	0.54948	hcf25est12_2_2_1_3	0.53779	0.00105	0.53989

Table 6.9.6-10. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in CV calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
metal as 1-in. cubes, flooded containment vessel, reflected										
no can spacers (np thickness = 0.0 in.)										
cvr3sqa_36_1_8_15	0.0	100	35142	35142	8332	6.19	1.0E+00	0.93455	0.00107	0.93668
cvr3sqa_36_1_7_15	0.0	95	35164	33406	8332	6.51	1.0E+00	0.91663	0.00128	0.91920
cvr3sqa_36_1_6_15	0.0	90	35186	31667	8332	6.87	1.0E+00	0.90133	0.00123	0.90379
cvr3sqa_36_1_5_15	0.0	80	35230	28184	8332	7.72	1.0E+00	0.87330	0.00119	0.87567
cvr3sqa_36_1_4_15	0.0	70	35275	24693	8332	8.81	1.0E+00	0.84424	0.00113	0.84650
cvr3sqa_36_1_3_15	0.0	60	35320	21192	8332	10.26	1.0E+00	0.81162	0.00124	0.81410
cvr3sqa_36_1_2_15	0.0	40	35410	14164	8332	15.35	1.0E+00	0.73700	0.00098	0.73896
cvr3sqa_36_1_1_15	0.0	19	35505	6746	8332	32.24	1.0E+00	0.63755	0.00119	0.63992
cvr3sqa_36_1_8_1	0.0	100	35142	35142	0	0.00	1.0E-20	0.78442	0.00112	0.78667
cvr3sqa_36_1_8_6	0.0	100	35142	35142	833	0.62	1.0E-01	0.79134	0.00116	0.79366
cvr3sqa_36_1_8_7	0.0	100	35142	35142	1666	1.24	2.0E-01	0.80350	0.00113	0.80577
cvr3sqa_36_1_8_8	0.0	100	35142	35142	2500	1.86	3.0E-01	0.81548	0.00107	0.81761
cvr3sqa_36_1_8_9	0.0	100	35142	35142	3333	2.48	4.0E-01	0.83048	0.00122	0.83293
cvr3sqa_36_1_8_10	0.0	100	35142	35142	4166	3.09	5.0E-01	0.84727	0.00122	0.84971
cvr3sqa_36_1_8_11	0.0	100	35142	35142	4999	3.71	6.0E-01	0.86174	0.00123	0.86420
cvr3sqa_36_1_8_12	0.0	100	35142	35142	5832	4.33	7.0E-01	0.87977	0.00118	0.88213
cvr3sqa_36_1_8_13	0.0	100	35142	35142	6666	4.95	8.0E-01	0.89818	0.00110	0.90037
cvr3sqa_36_1_8_14	0.0	100	35142	35142	7499	5.57	9.0E-01	0.91611	0.00118	0.91846
cvr3sqa_36_1_8_15	0.0	100	35142	35142	8332	6.19	1.0E+00	0.93455	0.00107	0.93668

Table 6.9.6-10. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in CV calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
with can spacers (np thickness = 1.4 in.)										
cvr3sqa_36_2_8_15	1.4	100	35142	35142	7719	5.73	1.0E+00	0.85151	0.00123	0.85397
cvr3sqa_36_2_7_15	1.4	95	35164	33406	7719	6.03	1.0E+00	0.83521	0.00123	0.83766
cvr3sqa_36_2_6_15	1.4	90	35186	31667	7719	6.36	1.0E+00	0.82166	0.00125	0.82415
cvr3sqa_36_2_5_15	1.4	80	35230	28184	7719	7.15	1.0E+00	0.78928	0.00112	0.79152
cvr3sqa_36_2_4_15	1.4	70	35275	24693	7719	8.16	1.0E+00	0.75994	0.00113	0.76220
cvr3sqa_36_2_3_15	1.4	60	35320	21192	7719	9.51	1.0E+00	0.72673	0.00112	0.72898
cvr3sqa_36_2_2_15	1.4	40	35410	14164	7719	14.22	1.0E+00	0.65008	0.00102	0.65213
cvr3sqa_36_2_1_15	1.4	19	35505	6746	7719	29.86	1.0E+00	0.54677	0.00102	0.54881
metal as lattice homogenized 1-in. cubes, flooded containment vessel, reflected										
no can spacers (np thickness = 0.0 in.)										
cvr3lha_36_1_8_1	0.0	100	35142	35142	0	0.00	1.0E-20	0.74814	0.00123	0.75060
cvr3lha_36_1_8_6	0.0	100	35142	35142	833	0.62	1.0E-01	0.76415	0.00125	0.76665
cvr3lha_36_1_8_7	0.0	100	35142	35142	1666	1.24	2.0E-01	0.77899	0.00102	0.78103
cvr3lha_36_1_8_8	0.0	100	35142	35142	2500	1.86	3.0E-01	0.79660	0.00143	0.79946
cvr3lha_36_1_8_9	0.0	100	35142	35142	3333	2.48	4.0E-01	0.81635	0.00113	0.81861
cvr3lha_36_1_8_10	0.0	100	35142	35142	4166	3.09	5.0E-01	0.83767	0.00109	0.83986
cvr3lha_36_1_8_11	0.0	100	35142	35142	4999	3.71	6.0E-01	0.85716	0.00116	0.85949
cvr3lha_36_1_8_12	0.0	100	35142	35142	5832	4.33	7.0E-01	0.88187	0.00114	0.88415
cvr3lha_36_1_8_13	0.0	100	35142	35142	6666	4.95	8.0E-01	0.90182	0.00109	0.90399
cvr3lha_36_1_8_14	0.0	100	35142	35142	7499	5.57	9.0E-01	0.92553	0.00148	0.92849
cvr3lha_36_1_8_15	0.0	100	35142	35142	8332	6.19	1.0E+00	0.94654	0.00126	0.94906

Table 6.9.6-10. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in CV calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvr3lha_36_1_8_15	0.0	100	35142	35142	8332	6.19	1.0E+00	0.94654	0.00126	0.94906
cvr3lha_36_1_7_15	0.0	95	35164	33406	8332	6.51	1.0E+00	0.93172	0.00115	0.93403
cvr3lha_36_1_6_15	0.0	90	35186	31667	8332	6.87	1.0E+00	0.91744	0.00126	0.91995
cvr3lha_36_1_5_15	0.0	80	35230	28184	8332	7.72	1.0E+00	0.89049	0.00113	0.89274
cvr3lha_36_1_4_15	0.0	70	35275	24693	8332	8.81	1.0E+00	0.85930	0.00133	0.86196
cvr3lha_36_1_3_15	0.0	60	35320	21192	8332	10.26	1.0E+00	0.82623	0.00131	0.82886
cvr3lha_36_1_2_15	0.0	40	35410	14164	8332	15.35	1.0E+00	0.75317	0.00110	0.75536
cvr3lha_36_1_1_15	0.0	19	35505	6746	8332	32.24	1.0E+00	0.65522	0.00102	0.65726
cvr3lha_36_1_8_15	0.0	100	35142	35142	8332	6.19	1.0E+00	0.94654	0.00126	0.94906
cvr3lha_35_1_8_15	0.0	100	34217	34217	8381	6.39	1.0E+00	0.94183	0.00106	0.94396
cvr3lha_34_1_8_15	0.0	100	33292	33292	8430	6.61	1.0E+00	0.93673	0.00125	0.93922
cvr3lha_33_1_8_15	0.0	100	32367	32367	8479	6.84	1.0E+00	0.95706	0.00123	0.95952
cvr3lha_32_1_8_15	0.0	100	31442	31442	8528	7.08	1.0E+00	0.94986	0.00142	0.95271
cvr3lha_31_1_8_15	0.0	100	30518	30518	8578	7.34	1.0E+00	0.94716	0.00118	0.94953
cvr3lha_30_1_8_15	0.0	100	29593	29593	8627	7.61	1.0E+00	0.93908	0.00127	0.94162
cvr3lha_29_1_8_15	0.0	100	28668	28668	8676	7.90	1.0E+00	0.93306	0.00126	0.93557
cvr3lha_28_1_8_15	0.0	100	27743	27743	8725	8.21	1.0E+00	0.93059	0.00137	0.93333
cvr3lha_27_1_8_15	0.0	100	26818	26818	8774	8.54	1.0E+00	0.92502	0.00139	0.92780
cvr3lha_26_1_8_15	0.0	100	25894	25894	8823	8.89	1.0E+00	0.91519	0.00145	0.91810
cvr3lha_25_1_8_15	0.0	100	24969	24969	8872	9.27	1.0E+00	0.91200	0.00125	0.91451
cvr3lha_24_1_8_15	0.0	100	23119	23119	8970	10.13	1.0E+00	0.92028	0.00106	0.92241
cvr3lha_23_1_8_15	0.0	100	22195	22195	9019	10.61	1.0E+00	0.91201	0.00115	0.91430

Table 6.9.6-10. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in CV calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvr3lha_22_1_8_15	0.0	100	21270	21270	9068	11.13	1.0E+00	0.90500	0.00138	0.90777
cvr3lha_21_1_8_15	0.0	100	20345	20345	9117	11.70	1.0E+00	0.89763	0.00133	0.90030
cvr3lha_31_1_7_15	0.0	95	30537	29010	8578	7.72	1.0E+00	0.92875	0.00129	0.93134
cvr3lha_30_1_7_15	0.0	95	29612	28131	8627	8.00	1.0E+00	0.92618	0.00111	0.92840
cvr3lha_29_1_7_15	0.0	95	28686	27252	8676	8.31	1.0E+00	0.91841	0.00107	0.92055
cvr3lha_28_1_7_15	0.0	95	27761	26373	8725	8.63	1.0E+00	0.91075	0.00124	0.91322
cvr3lha_27_1_7_15	0.0	95	26835	25494	8774	8.98	1.0E+00	0.90920	0.00117	0.91153
cvr3lha_33_1_6_15	0.0	90	32408	29167	8479	7.59	1.0E+00	0.92553	0.00126	0.92804
cvr3lha_32_1_6_15	0.0	90	31482	28334	8528	7.86	1.0E+00	0.92000	0.00119	0.92238
cvr3lha_31_1_6_15	0.0	90	30556	27501	8578	8.14	1.0E+00	0.91758	0.00132	0.92021
cvr3lha_36_1_5_15	0.0	80	35230	28184	8332	7.72	1.0E+00	0.89049	0.00113	0.89274
cvr3lha_35_1_5_15	0.0	80	34303	27443	8381	7.97	1.0E+00	0.88496	0.00111	0.88719
cvr3lha_34_1_5_15	0.0	80	33376	26701	8430	8.24	1.0E+00	0.88044	0.00106	0.88256
cvr3lha_33_1_5_15	0.0	80	32449	25959	8479	8.53	1.0E+00	0.89355	0.00112	0.89579
cvr3lha_32_1_5_15	0.0	80	31522	25218	8528	8.83	1.0E+00	0.88961	0.00146	0.89253
cvr3lha_31_1_5_15	0.0	80	30595	24476	8578	9.15	1.0E+00	0.88752	0.00141	0.89034
cvr3lha_36_1_4_15	0.0	70	35275	24693	8332	8.81	1.0E+00	0.85930	0.00133	0.86196
cvr3lha_35_1_4_15	0.0	70	34347	24043	8381	9.10	1.0E+00	0.85473	0.00113	0.85698
cvr3lha_34_1_4_15	0.0	70	33419	23393	8430	9.41	1.0E+00	0.85237	0.00129	0.85496
cvr3lha_33_1_4_15	0.0	70	32490	22743	8479	9.73	1.0E+00	0.86299	0.00121	0.86542

Table 6.9.6-10. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in CV calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvr3lha_32_1_4_15	0.0	70	31562	22093	8528	10.08	1.0E+00	0.85876	0.00132	0.86140
cvr3lha_31_1_4_15	0.0	70	30634	21444	8578	10.44	1.0E+00	0.85471	0.00125	0.85720
cvr3lha_36_1_3_15	0.0	60	35320	21192	8332	10.26	1.0E+00	0.82623	0.00131	0.82886
cvr3lha_36_1_2_15	0.0	40	35410	14164	8332	15.35	1.0E+00	0.75317	0.00110	0.75536
cvr3lha_36_1_1_15	0.0	19	35505	6746	8332	32.24	1.0E+00	0.65522	0.00102	0.65726
cvr3lha_36_2_8_15	1.4	100	35142	35142	7719	5.73	1.0E+00	0.87286	0.00134	0.87554
cvr3lha_36_2_7_15	1.4	95	35164	33406	7719	6.03	1.0E+00	0.85858	0.00109	0.86077
cvr3lha_36_2_6_15	1.4	90	35186	31667	7719	6.36	1.0E+00	0.84459	0.00107	0.84672
cvr3lha_36_2_5_15	1.4	80	35230	28184	7719	7.15	1.0E+00	0.81698	0.00127	0.81952
cvr3lha_36_2_4_15	1.4	70	35275	24693	7719	8.16	1.0E+00	0.78484	0.00122	0.78727
cvr3lha_36_2_3_15	1.4	60	35320	21192	7719	9.51	1.0E+00	0.75584	0.00105	0.75795
cvr3lha_36_2_2_15	1.4	40	35410	14164	7719	14.22	1.0E+00	0.68360	0.00131	0.68623
cvr3lha_36_2_1_15	1.4	19	35505	6746	7719	29.86	1.0E+00	0.58144	0.00104	0.58352
metal as 1-in. cubes fully homogenized with water for flooded containment vessel, reflected no can spacers (np thickness = 0.0 in.)										
cvr3cha_36_1_8_1	0.0	100	35142	35142	0	0.00	1.0E-20	0.61068	0.00099	0.61266
cvr3cha_36_1_8_6	0.0	100	35142	35142	833	0.62	1.0E-01	0.64671	0.00117	0.64905
cvr3cha_36_1_8_7	0.0	100	35142	35142	1666	1.24	2.0E-01	0.68117	0.00106	0.68329
cvr3cha_36_1_8_8	0.0	100	35142	35142	2500	1.86	3.0E-01	0.71931	0.00121	0.72174

Table 6.9.6-10. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in CV calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvr3cha_36_1_8_9	0.0	100	35142	35142	3333	2.48	4.0E-01	0.75910	0.00125	0.76160
cvr3cha_36_1_8_10	0.0	100	35142	35142	4166	3.09	5.0E-01	0.79344	0.00123	0.79589
cvr3cha_36_1_8_11	0.0	100	35142	35142	4999	3.71	6.0E-01	0.83513	0.00132	0.83777
cvr3cha_36_1_8_12	0.0	100	35142	35142	5833	4.33	7.0E-01	0.87270	0.00117	0.87504
cvr3cha_36_1_8_13	0.0	100	35142	35142	6666	4.95	8.0E-01	0.90988	0.00115	0.91219
cvr3cha_36_1_8_14	0.0	100	35142	35142	7499	5.57	9.0E-01	0.94696	0.00136	0.94968
cvr3cha_36_1_8_15	0.0	100	35142	35142	8332	6.19	1.0E+00	0.98062	0.00128	0.98318
cvr3cha_36_1_8_15	0.0	100	35142	35142	8332	6.19	1.0E+00	0.98062	0.00128	0.98318
cvr3cha_36_1_7_15	0.0	95	35164	33406	8332	6.51	1.0E+00	0.96729	0.00134	0.96997
cvr3cha_36_1_6_15	0.0	90	35186	31667	8332	6.87	1.0E+00	0.95443	0.00144	0.95731
cvr3cha_36_1_5_15	0.0	80	35231	28184	8332	7.72	1.0E+00	0.93639	0.00114	0.93867
cvr3cha_36_1_4_15	0.0	70	35275	24693	8332	8.81	1.0E+00	0.91729	0.00125	0.91978
cvr3cha_36_1_3_15	0.0	60	35320	21192	8332	10.26	1.0E+00	0.89768	0.00137	0.90042
cvr3cha_36_1_2_15	0.0	40	35410	14164	8332	15.35	1.0E+00	0.85347	0.00132	0.85612
cvr3cha_36_1_1_15	0.0	19	35505	6746	8332	32.24	1.0E+00	0.78799	0.00132	0.79064
cvr3cha_9_1_8_15	0.0	100	8323	8323	9755	30.59	1.0E+00	0.92411	0.00165	0.92741
cvr3cha_8_1_8_15	0.0	100	7398	7398	9804	34.59	1.0E+00	0.91970	0.00146	0.92263
cvr3cha_7_1_8_15	0.0	100	6473	6473	9854	39.73	1.0E+00	0.91473	0.00144	0.91762
cvr3cha_6_1_8_15	0.0	100	5549	5549	9903	46.58	1.0E+00	0.90826	0.00144	0.91114
cvr3cha_5_1_8_15	0.0	100	4624	4624	9952	56.17	1.0E+00	0.89884	0.00156	0.90196
cvr3cha_4_1_8_15	0.0	100	3699	3699	10001	70.56	1.0E+00	0.88830	0.00130	0.89090
cvr3cha_3_1_8_15	0.0	100	2774	2774	10050	94.55	1.0E+00	0.86596	0.00144	0.86884

Table 6.9.6-10. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in CV calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvr3cha_2_1_8_15	0.0	100	1850	1850	10099	142.5	1.0E+00	0.82987	0.00147	0.83281
cvr3cha_1_1_8_15	0.0	100	925	925	10148	286.4	1.0E+00	0.73830	0.00123	0.74075
cvr3cha_13_1_7_15	0.0	95	12955	12307	9510	20.17	1.0E+00	0.92721	0.00146	0.93013
cvr3cha_12_1_7_15	0.0	95	11104	10549	9608	23.77	1.0E+00	0.92145	0.00152	0.92449
cvr3cha_11_1_7_15	0.0	95	10179	9670	9657	26.07	1.0E+00	0.92161	0.00139	0.92439
cvr3cha_10_1_7_15	0.0	95	9254	8791	9706	28.82	1.0E+00	0.91850	0.00146	0.92142
cvr3cha_9_1_7_15	0.0	95	8328	7912	9755	32.18	1.0E+00	0.91420	0.00139	0.91699
cvr3cha_8_1_7_15	0.0	95	7403	7033	9804	36.39	1.0E+00	0.91089	0.00129	0.91347
cvr3cha_7_1_7_15	0.0	95	6478	6154	9854	41.79	1.0E+00	0.90510	0.00141	0.90792
cvr3cha_6_1_7_15	0.0	95	5552	5275	9903	49.00	1.0E+00	0.89876	0.00141	0.90158
cvr3cha_5_1_7_15	0.0	95	4627	4396	9952	59.09	1.0E+00	0.89248	0.00137	0.89522
cvr3cha_4_1_7_15	0.0	95	3701	3516	10001	74.23	1.0E+00	0.87921	0.00123	0.88166
cvr3cha_3_1_7_15	0.0	95	2776	2637	10050	99.46	1.0E+00	0.85895	0.00143	0.86181
cvr3cha_2_1_7_15	0.0	95	1851	1758	10099	149.92	1.0E+00	0.82077	0.00151	0.82380
cvr3cha_1_1_7_15	0.0	95	925	879	10148	301.30	1.0E+00	0.72727	0.00130	0.72988
cvr3cha_17_1_6_15	0.0	90	16667	15000	9314	16.21	1.0E+00	0.92297	0.00142	0.92580
cvr3cha_16_1_6_15	0.0	90	15741	14167	9363	17.25	1.0E+00	0.92154	0.00140	0.92434
cvr3cha_15_1_6_15	0.0	90	14815	13334	9412	18.42	1.0E+00	0.92402	0.00131	0.92664
cvr3cha_14_1_6_15	0.0	90	13889	12500	9461	19.75	1.0E+00	0.91968	0.00162	0.92291
cvr3cha_13_1_6_15	0.0	90	12963	11667	9510	21.28	1.0E+00	0.91675	0.00152	0.91979

Table 6.9.6-10. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in CV calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvr3cha_28_1_5_15	0.0	80	27814	22251	8725	10.23	1.0E+00	0.92438	0.00137	0.92712
cvr3cha_27_1_5_15	0.0	80	26886	21509	8774	10.65	1.0E+00	0.92213	0.00147	0.92507
cvr3cha_26_1_5_15	0.0	80	25959	20767	8823	11.09	1.0E+00	0.92209	0.00165	0.92540
cvr3cha_25_1_5_15	0.0	80	24105	19284	8921	12.07	1.0E+00	0.91935	0.00157	0.92249
cvr3cha_24_1_5_15	0.0	80	23178	18542	8970	12.63	1.0E+00	0.91637	0.00132	0.91900
cvr3cha_23_1_5_15	0.0	80	22251	17801	9019	13.22	1.0E+00	0.91519	0.00139	0.91798
cvr3cha_36_1_4_15	0.0	70	35275	24693	8332	8.81	1.0E+00	0.91729	0.00125	0.91978
cvr3cha_35_1_4_15	0.0	70	34347	24043	8381	9.10	1.0E+00	0.91586	0.00125	0.91835
cvr3cha_34_1_4_15	0.0	70	33419	23393	8430	9.41	1.0E+00	0.91481	0.00139	0.91758
cvr3cha_33_1_4_15	0.0	70	32490	22743	8479	9.73	1.0E+00	0.91228	0.00128	0.91484
cvr3cha_32_1_4_15	0.0	70	31562	22093	8529	10.08	1.0E+00	0.91196	0.00129	0.91454
cvr3cha_31_1_4_15	0.0	70	30634	21444	8578	10.44	1.0E+00	0.90865	0.00139	0.91143
cvr3cha_36_1_3_15	0.0	60	35320	21192	8332	10.26	1.0E+00	0.89768	0.00137	0.90042
cvr3cha_35_1_3_15	0.0	60	34391	20634	8381	10.60	1.0E+00	0.89413	0.00135	0.89683
cvr3cha_34_1_3_15	0.0	60	33461	20077	8430	10.96	1.0E+00	0.89574	0.00118	0.89810
cvr3cha_33_1_3_15	0.0	60	32532	19519	8479	11.34	1.0E+00	0.89333	0.00129	0.89591
cvr3cha_32_1_3_15	0.0	60	31602	18961	8529	11.74	1.0E+00	0.89469	0.00121	0.89710
cvr3cha_31_1_3_15	0.0	60	30673	18404	8578	12.17	1.0E+00	0.89268	0.00145	0.89558
cvr3cha_36_1_2_15	0.0	40	35410	14164	8332	15.35	1.0E+00	0.85347	0.00132	0.85612
cvr3cha_35_1_2_15	0.0	40	34478	13791	8381	15.86	1.0E+00	0.85471	0.00109	0.85690
cvr3cha_34_1_2_15	0.0	40	33546	13419	8430	16.40	1.0E+00	0.85466	0.00125	0.85716

Table 6.9.6-10. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in CV calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvr3cha_33_1_2_15	0.0	40	32614	13046	8479	16.96	1.0E+00	0.85311	0.00132	0.85575
cvr3cha_32_1_2_15	0.0	40	31683	12673	8529	17.57	1.0E+00	0.85294	0.00136	0.85566
cvr3cha_31_1_2_15	0.0	40	30751	12300	8578	18.20	1.0E+00	0.85042	0.00127	0.85295
cvr3cha_36_1_1_15	0.0	19	35505	6746	8332	32.24	1.0E+00	0.78799	0.00132	0.79064
cvr3cha_35_1_1_15	0.0	19	34570	6568	8381	33.30	1.0E+00	0.78798	0.00132	0.79062
cvr3cha_34_1_1_15	0.0	19	33636	6391	8430	34.43	1.0E+00	0.78692	0.00142	0.78976
cvr3cha_33_1_1_15	0.0	19	32702	6213	8479	35.62	1.0E+00	0.78967	0.00115	0.79198
cvr3cha_32_1_1_15	0.0	19	31767	6036	8529	36.88	1.0E+00	0.78868	0.00135	0.79138
cvr3cha_31_1_1_15	0.0	19	30833	5858	8578	38.22	1.0E+00	0.78919	0.00118	0.79155
with can spacers (np thickness = 1.4 in.)										
cvr3cha_36_2_8_15	1.4	100	35142	35142	7719	5.73	1.0E+00	0.96066	0.00128	0.96321
cvr3cha_36_2_7_15	1.4	95	35164	33406	7719	6.03	1.0E+00	0.94267	0.00127	0.94521
cvr3cha_36_2_6_15	1.4	90	35186	31667	7719	6.36	1.0E+00	0.93250	0.00117	0.93484
cvr3cha_36_2_5_15	1.4	80	35231	28184	7719	7.15	1.0E+00	0.91364	0.00126	0.91615
cvr3cha_36_2_4_15	1.4	70	35275	24693	7719	8.16	1.0E+00	0.89707	0.00125	0.89957
cvr3cha_36_2_3_15	1.4	60	35320	21192	7719	9.51	1.0E+00	0.87509	0.00121	0.87751
cvr3cha_36_2_2_15	1.4	40	35410	14164	7719	14.22	1.0E+00	0.82672	0.00135	0.82943
cvr3cha_36_2_1_15	1.4	19	35505	6746	7719	29.86	1.0E+00	0.76024	0.00148	0.76320
cvr3cha_11_2_8_15	1.4	100	10173	10173	9044	23.20	1.0E+00	0.92383	0.00148	0.92679
cvr3cha_10_2_8_15	1.4	100	9248	9248	9093	25.66	1.0E+00	0.91980	0.00132	0.92244
cvr3cha_09_2_8_15	1.4	100	8323	8323	9142	28.67	1.0E+00	0.91510	0.00129	0.91768

Table 6.9.6-10. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in CV calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvr3cha_16_2_7_15	1.4	95	15731	14945	8749	15.28	1.0E+00	0.92275	0.00162	0.92599
cvr3cha_15_2_7_15	1.4	95	14806	14066	8798	16.33	1.0E+00	0.92071	0.00155	0.92380
cvr3cha_14_2_7_15	1.4	95	13880	13186	8847	17.51	1.0E+00	0.92004	0.00132	0.92268
cvr3cha_25_2_6_15	1.4	90	24075	21667	8308	10.01	1.0E+00	0.92554	0.00129	0.92813
cvr3cha_24_2_6_15	1.4	90	23149	20834	8357	10.47	1.0E+00	0.92042	0.00132	0.92306
cvr3cha_23_2_6_15	1.4	90	22223	20000	8406	10.97	1.0E+00	0.92148	0.00135	0.92419
cvr3cha_22_2_6_15	1.4	90	21297	19167	8455	11.51	1.0E+00	0.91898	0.00142	0.92181

Table 6.9.6-10a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in CV calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x U | CV	k_{eff}	σ	$k_{eff}+2\sigma$
cvr3lha model, flooded containment vessel, reflected no can spacers (np thickness = 0.0 in.), [USL=0.93520]									
cvr3lhap_1_1_6_15	0.0	100	16.00	16.00	8.805	1.22 | 15.41	0.89820	0.00079	0.89978
cvr3lhap_2_1_6_15	0.0	100	18.00	18.00	8.699	2.02 | 13.54	0.89599	0.00069	0.89737
cvr3lhap_3_1_6_15	0.0	100	20.00	20.00	8.593	1.68 | 12.05	0.91374	0.00064	0.91502
cvr3lhap_5_1_6_15	0.0	100	22.00	22.00	8.487	1.40 | 10.83	0.92785	0.00086	0.92957
cvr3lhap_6_1_6_15	0.0	100	22.10	22.10	8.481	1.39 | 10.77	0.93002	0.00080	0.93162
cvr3lhap_7_1_6_15	0.0	100	22.20	22.20	8.476	1.38 | 10.72	0.92974	0.00062	0.93098
cvr3lhap_8_1_6_15	0.0	100	22.30	22.30	8.471	1.36 | 10.66	0.93188	0.00072	0.93332

Table 6.9.6-10a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in CV calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x U | CV	k_{eff}	σ	$k_{eff}+2\sigma$
cvr3lhap_9_1_6_15	0.0	100	22.40	22.40	8.466	1.35 | 10.61	0.93248	0.00066	0.93380
cvr3lhap_10_1_6_15	0.0	100	22.50	22.50	8.461	1.34 | 10.55	0.93456	0.00064	0.93584
cvr3lhap_3_1_5_15	0.0	95	20.00	19.00	8.594	1.77 | 12.69	0.89805	0.00069	0.89943
cvr3lhap_5_1_5_15	0.0	95	22.00	20.90	8.488	1.48 | 11.40	0.91323	0.00076	0.91475
cvr3lhap_12_1_5_15	0.0	95	24.00	22.80	8.382	1.23 | 10.33	0.92844	0.00091	0.93026
cvr3lhap_13_1_5_15	0.0	95	24.10	22.90	8.376	1.22 | 10.28	0.93052	0.00066	0.93184
cvr3lhap_14_1_5_15	0.0	95	24.20	22.99	8.371	1.21 | 10.23	0.93046	0.00070	0.93186
cvr3lhap_15_1_5_15	0.0	95	24.30	23.09	8.366	1.20 | 10.18	0.93153	0.00065	0.93283
cvr3lhap_16_1_5_15	0.0	95	24.40	23.18	8.361	1.19 | 10.14	0.93221	0.00062	0.93345
cvr3lhap_17_1_5_15	0.0	95	24.50	23.28	8.355	1.18 | 10.09	0.93392	0.00062	0.93516
cvr3lhap_18_1_5_15	0.0	95	24.60	23.37	8.350	1.17 | 10.04	0.93522	0.00078	0.93678
cvr3lhap_19_1_5_15	0.0	95	25.00	23.75	8.329	1.95 | 9.86	0.90972	0.00065	0.91102
cvr3lhap_23_1_4_15	0.0	90	29.00	26.10	8.118	1.56 | 8.76	0.92066	0.00069	0.92204
cvr3lhap_24_1_4_15	0.0	90	30.00	27.00	8.065	1.46 | 8.42	0.92606	0.00065	0.92736
cvr3lhap_25_1_4_15	0.0	90	30.8	27.72	8.022	1.38 | 8.16	0.93137	0.00072	0.93281
cvr3lhap_26_1_4_15	0.0	90	30.9	27.81	8.017	1.37 | 8.13	0.93215	0.00067	0.93349
cvr3lhap_27_1_4_15	0.0	90	31.0	27.90	8.012	1.36 | 8.09	0.93204	0.00071	0.93346
cvr3lhap_28_1_4_15	0.0	90	31.1	27.99	8.006	1.35 | 8.06	0.93126	0.00066	0.93258
cvr3lhap_29_1_4_15	0.0	90	31.2	28.08	8.001	1.34 | 8.03	0.93390	0.00068	0.93526
cvr3lhap_27_1_3_15	0.0	80	31.0	24.80	8.014	1.53 | 9.10	0.90189	0.00058	0.90305
cvr3lhap_30_1_3_15	0.0	80	32.0	25.60	7.961	1.43 | 8.77	0.90656	0.00069	0.90794
cvr3lhap_31_1_3_15	0.0	80	33.0	26.40	7.908	1.33 | 8.45	0.91284	0.00061	0.91406

Table 6.9.6-10a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in CV calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x U | CV	k_{eff}	σ	$k_{eff}+2\sigma$
cvr3lhap_32_1_3_15	0.0	80	34.0	27.20	7.855	1.96 | 8.15	0.89462	0.00070	0.89602
cvr3lhap_33_1_3_15	0.0	80	35.0	28.00	7.802	1.86 | 7.87	0.89954	0.00067	0.90088
cvr3lhap_34_1_3_15	0.0	80	36.0	28.80	7.749	1.76 | 7.60	0.90286	0.00074	0.90434
cvr3lhap_31_1_2_15	0.0	70	33.0	23.10	7.910	1.53 | 9.66	0.88025	0.00082	0.88189
cvr3lhap_32_1_2_15	0.0	70	34.0	23.80	7.857	2.25 | 9.32	0.86566	0.00070	0.86706
cvr3lhap_33_1_2_15	0.0	70	35.0	24.50	7.804	2.13 | 9.00	0.86894	0.00063	0.87020
cvr3lhap_34_1_2_15	0.0	70	36.0	25.20	7.751	2.01 | 8.69	0.87409	0.00073	0.87555
cvr3lhap_32_1_1_15	0.0	60	34.0	20.40	7.859	2.62 | 10.88	0.83498	0.00078	0.83654
cvr3lhap_33_1_1_15	0.0	60	35.0	21.00	7.807	2.48 | 10.50	0.83693	0.00063	0.83819
cvr3lhap_34_1_1_15	0.0	60	36.0	21.60	7.754	2.35/10.14	0.84182	0.00067	0.84316
cvr3cha model, flooded containment vessel, reflected no can spacers (np thickness = 0.0 in.), [USL=0.93520]									
cvr3chap_1_1_6_15	0.0	100	9.0	9.000	9.177	28.47 | 28.47	0.93143	0.00072	0.93287
cvr3chap_2_1_6_15	0.0	100	10.0	10.000	9.124	25.49 | 25.49	0.93090	0.00082	0.93254
cvr3chap_3_1_6_15	0.0	100	10.3	10.300	9.108	24.71 | 24.71	0.93214	0.00076	0.93366
cvr3chap_4_1_6_15	0.0	100	10.4	10.400	9.103	24.46 | 24.46	0.93262	0.00074	0.93410
cvr3chap_5_1_6_15	0.0	100	10.5	10.500	9.097	24.21 | 24.21	0.93218	0.00074	0.93366
cvr3chap_6_1_6_15	0.0	100	10.6	10.600	9.092	23.97 | 23.97	0.93401	0.00077	0.93555
cvr3chap_10_1_5_15	0.0	95	15.0	14.250	8.859	17.40 | 17.40	0.93204	0.00069	0.93342
cvr3chap_11_1_5_15	0.0	95	15.8	15.010	8.817	16.45 | 16.45	0.93235	0.00088	0.93411
cvr3chap_12_1_5_15	0.0	95	15.9	15.105	8.811	16.34 | 16.34	0.93219	0.00073	0.93365
cvr3chap_13_1_5_15	0.0	95	16.0	15.200	8.806	16.22 | 16.22	0.93268	0.00070	0.93408

Table 6.9.6-10a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in CV calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x U | CV	k_{eff}	σ	$k_{eff}+2\sigma$
cvr3chap_14_1_5_15	0.0	95	16.1	15.295	8.801	16.11 | 16.11	0.93258	0.00079	0.93416
cvr3chap_15_1_5_15	0.0	95	16.2	15.390	8.795	16.01 | 16.01	0.93370	0.00086	0.93542
cvr3chap_19_1_4_15	0.0	90	21.0	18.900	8.542	12.68 | 12.68	0.93190	0.00068	0.93326
cvr3chap_20_1_4_15	0.0	90	21.7	19.530	8.504	12.22 | 12.22	0.93214	0.00068	0.93350
cvr3chap_21_1_4_15	0.0	90	21.8	19.620	8.499	12.16 | 12.16	0.93369	0.00075	0.93519
cvr3chap_22_1_4_15	0.0	90	21.9	19.710	8.494	12.10 | 12.10	0.93338	0.00072	0.93482
cvr3chap_23_1_4_15	0.0	90	22.0	19.800	8.489	12.04 | 12.04	0.93312	0.00077	0.93466
cvr3chap_24_1_4_15	0.0	90	22.1	19.890	8.483	11.98 | 11.98	0.93488	0.00072	0.93632
cvr3chap_30_1_3_15	0.0	80	32.0	25.600	7.961	8.77 | 8.77	0.93235	0.00071	0.93377
cvr3chap_31_1_3_15	0.0	80	32.7	26.160	7.924	8.55 | 8.55	0.93370	0.00074	0.93518
cvr3chap_32_1_3_15	0.0	80	32.8	26.240	7.918	8.52 | 8.52	0.93326	0.00069	0.93464
cvr3chap_33_1_3_15	0.0	80	32.9	26.320	7.913	8.48 | 8.48	0.93257	0.00075	0.93407
cvr3chap_34_1_3_15	0.0	80	33.0	26.400	7.908	8.45 | 8.45	0.93347	0.00071	0.93489
cvr3chap_35_1_3_15	0.0	80	33.1	26.480	7.903	8.42 | 8.42	0.93463	0.00069	0.93601
cvr3chap_37_1_2_15	0.0	70	35.0	24.500	7.804	9.00 | 9.00	0.91880	0.00069	0.92018
cvr3chap_38_1_2_15	0.0	70	36.0	25.200	7.751	8.69 | 8.69	0.91868	0.00071	0.92010
cvr3chap_37_1_1_15	0.0	60	35.0	21.000	7.807	10.50 | 10.50	0.89999	0.00067	0.90133
cvr3chap_38_1_1_15	0.0	60	36.0	21.600	7.754	10.15 | 10.15	0.90214	0.00077	0.90368

Table 6.9.6-10b. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene with thorium in CV calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	^{232}Th (kg)	H_2O (kg)	h/x U | CV	k_{eff}	σ	$k_{eff}+2\sigma$
cvr3lha model, flooded containment vessel, reflected no can spacers (np thickness = 0.0 in.), [USL=0.93520]										
cvr3lhap_9_1_6_15	0.0	100	22.40	22.40	0.00	8.466	1.35 | 10.61	0.93248	0.00066	0.93380
cvr3lhapth_1_6_1	0.0	100	22.40	22.40	1.00	8.381	1.25 | 10.51	0.91970	0.00062	0.92094
cvr3lhapth_1_6_2	0.0	100	22.40	22.40	2.00	8.295	1.15 | 10.41	0.90916	0.00079	0.91074
cvr3lhapth_1_6_3	0.0	100	22.40	22.40	3.00	8.210	1.05 | 10.31	0.89965	0.00062	0.90089
cvr3lhapth_1_6_4	0.0	100	22.40	22.40	4.00	8.125	0.95 | 10.21	0.88980	0.00062	0.89104
cvr3lhapth_1_6_5	0.0	100	22.40	22.40	5.00	8.039	0.85 | 10.11	0.87860	0.00071	0.88002
cvr3lhapth_1_6_6	0.0	100	22.40	22.40	6.00	7.954	0.75 | 10.01	0.86975	0.00065	0.87105
cvr3lhap_18_1_5_15	0.0	95	24.60	23.37	0.0	8.350	1.17 | 10.04	0.93522	0.00078	0.93678
cvr3lhapth_2_6_1	0.0	95	24.60	23.37	1.00	8.265	1.07 | 9.95	0.92313	0.00064	0.92441
cvr3lhapth_2_6_2	0.0	95	24.60	23.37	2.00	8.179	0.97 | 9.85	0.91197	0.00080	0.91357
cvr3lhapth_2_6_3	0.0	95	24.60	23.37	3.00	8.094	0.88 | 9.76	0.90250	0.00074	0.90398
cvr3lhapth_2_6_4	0.0	95	24.60	23.37	4.00	8.009	0.78 | 9.66	0.89213	0.00072	0.89357
cvr3lhap_28_1_4_15	0.0	90	31.1	27.99	0.0	8.006	1.35 | 8.07	0.93126	0.00066	0.93258
cvr3lhapth_3_6_1	0.0	90	31.1	27.99	1.00	7.921	1.27 | 7.98	0.92411	0.00067	0.92545
cvr3lhapth_3_6_2	0.0	90	31.1	27.99	2.00	7.836	1.19 | 7.90	0.91496	0.00066	0.91628
cvr3lhapth_3_6_3	0.0	90	31.1	27.99	3.00	7.750	1.11 | 7.82	0.90727	0.00073	0.90873
cvr3lhapth_3_6_4	0.0	90	31.1	27.99	4.00	7.665	1.03 | 7.74	0.89908	0.00062	0.90032

Table 6.9.6-10b. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene with thorium in CV calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	^{232}Th (kg)	H_2O (kg)	h/x U | CV	k_{eff}	σ	$k_{eff}+2\sigma$
cvr3lhap_33_1_3_15	0.0	80	35.0	28.00	0.0	7.802	1.86 | 7.87	0.89954	0.00067	0.90088
cvr3lhapth_3_6_1	0.0	80	35.0	28.00	1.00	7.664	1.68 | 7.74	0.89575	0.00064	0.89703
cvr3lhapth_3_6_2	0.0	80	35.0	28.00	2.00	7.578	1.60 | 7.66	0.88843	0.00068	0.88979
cvr3lhapth_3_6_3	0.0	80	35.0	28.00	3.00	7.493	1.53 | 7.58	0.88147	0.00069	0.88285
cvr3lhapth_3_6_4	0.0	80	35.0	28.00	4.00	7.408	1.45 | 7.50	0.87441	0.00075	0.87591

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded containment vessel, single package reflected														
NCT											**HAC**			
no can spacers (np thickness = 0.0 in.)														
ncsrbmt11_36_1_1	0.0	100	35142	35142	8332	6.19	1.0E-20	0.81144	0.00127	0.81397	hcsrbmt12_36_1_1	0.81597	0.00140	0.81877
ncsrbmt11_36_1_2	0.0	100	35142	35142	8332	6.19	1.0E-05	0.81278	0.00143	0.81563	hcsrbmt12_36_1_2	0.81496	0.00123	0.81741
ncsrbmt11_36_1_3	0.0	100	35142	35142	8332	6.19	1.0E-04	0.81066	0.00124	0.81314	hcsrbmt12_36_1_3	0.81490	0.00149	0.81787
ncsrbmt11_36_1_4	0.0	100	35142	35142	8332	6.19	1.0E-03	0.81064	0.00142	0.81347	hcsrbmt12_36_1_4	0.81512	0.00157	0.81826
ncsrbmt11_36_1_5	0.0	100	35142	35142	8332	6.19	1.0E-02	0.81069	0.00138	0.81346	hcsrbmt12_36_1_5	0.81594	0.00126	0.81846
ncsrbmt11_36_1_6	0.0	100	35142	35142	8332	6.19	1.0E-01	0.81880	0.00126	0.82132	hcsrbmt12_36_1_6	0.82255	0.00126	0.82507
ncsrbmt11_36_1_8	0.0	100	35142	35142	8332	6.19	3.0E-01	0.83502	0.00115	0.83732	hcsrbmt12_36_1_8	0.83846	0.00125	0.84095
ncsrbmt11_36_1_15	0.0	100	35142	35142	8332	6.19	1.0E+00	0.88830	0.00122	0.89075	hcsrbmt12_36_1_15	0.88841	0.00140	0.89122

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsrbmt11_36_1_15	0.0	100	35142	35142	8332	6.19	1.0E+00	0.88830	0.00122	0.89075				
ncsrbmt11_35_1_15	0.0	100	34217	34217	8381	6.39	1.0E+00	0.88662	0.00129	0.88921				
ncsrbmt11_34_1_15	0.0	100	33292	33292	8430	6.61	1.0E+00	0.88622	0.00119	0.88860				
ncsrbmt11_33_1_15	0.0	100	32367	32367	8479	6.84	1.0E+00	0.88175	0.00127	0.88429				
ncsrbmt11_32_1_15	0.0	100	31442	31442	8529	7.08	1.0E+00	0.88109	0.00124	0.88357				
ncsrbmt11_31_1_15	0.0	100	30518	30518	8578	7.34	1.0E+00	0.87995	0.00126	0.88247				
ncsrbmt11_30_1_15	0.0	100	29593	29593	8627	7.61	1.0E+00	0.87410	0.00144	0.87697				
ncsrbmt11_29_1_15	0.0	100	28668	28668	8676	7.90	1.0E+00	0.87385	0.00118	0.87621				
ncsrbmt11_28_1_15	0.0	100	27743	27743	8725	8.21	1.0E+00	0.87237	0.00119	0.87474				
ncsrbmt11_27_1_15	0.0	100	26819	26819	8774	8.54	1.0E+00	0.86800	0.00126	0.87053				
ncsrbmt11_26_1_15	0.0	100	25894	25894	8823	8.89	1.0E+00	0.86869	0.00123	0.87115				
ncsrbmt11_25_1_15	0.0	100	24969	24969	8872	9.27	1.0E+00	0.86558	0.00152	0.86862				
ncsrbmt11_24_1_15	0.0	100	23119	23119	8970	10.13	1.0E+00	0.85827	0.00123	0.86074				
ncsrbmt11_23_1_15	0.0	100	22195	22195	9019	10.61	1.0E+00	0.85657	0.00134	0.85924				
ncsrbmt11_22_1_15	0.0	100	21270	21270	9068	11.13	1.0E+00	0.85373	0.00156	0.85686				
ncsrbmt11_21_1_15	0.0	100	20345	20345	9117	11.70	1.0E+00	0.85521	0.00126	0.85774				
ncsrbmt11_20_1_15	0.0	100	19420	19420	9166	12.32	1.0E+00	0.84989	0.00157	0.85303				
ncsrbmt11_19_1_15	0.0	100	18496	18496	9216	13.00	1.0E+00	0.85069	0.00155	0.85378				
ncsrbmt11_18_1_15	0.0	100	17571	17571	9265	13.76	1.0E+00	0.84676	0.00182	0.85039				
ncsrbmt11_17_1_15	0.0	100	16646	16646	9314	14.60	1.0E+00	0.84566	0.00147	0.84859				
ncsrbmt11_16_1_15	0.0	100	15721	15721	9363	15.54	1.0E+00	0.84458	0.00125	0.84708				
ncsrbmt11_15_1_15	0.0	100	14796	14796	9412	16.60	1.0E+00	0.83932	0.00148	0.84229				
ncsrbmt11_14_1_15	0.0	100	13872	13872	9461	17.80	1.0E+00	0.83752	0.00133	0.84019				
ncsrbmt11_13_1_15	0.0	100	12947	12947	9510	19.17	1.0E+00	0.83532	0.00151	0.83834				

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsrbmt11_12_1_15	0.0	100	11097	11097	9608	22.60	1.0E+00	0.82792	0.00133	0.83057				
ncsrbmt11_11_1_15	0.0	100	10173	10173	9657	24.78	1.0E+00	0.82643	0.00127	0.82898				
ncsrbmt11_10_1_15	0.0	100	9248	9248	9706	27.39	1.0E+00	0.82649	0.00160	0.82968				
ncsrbmt11_9_1_15	0.0	100	8323	8323	9755	30.59	1.0E+00	0.81840	0.00140	0.82119				
ncsrbmt11_8_1_15	0.0	100	7398	7398	9804	34.59	1.0E+00	0.81808	0.00170	0.82148				
ncsrbmt11_7_1_15	0.0	100	6473	6473	9854	39.73	1.0E+00	0.81130	0.00152	0.81434				
ncsrbmt11_6_1_15	0.0	100	5549	5549	9903	46.58	1.0E+00	0.80480	0.00140	0.80761				
ncsrbmt11_5_1_15	0.0	100	4624	4624	9952	56.17	1.0E+00	0.79723	0.00124	0.79971				
ncsrbmt11_4_1_15	0.0	100	3699	3699	10001	70.56	1.0E+00	0.78533	0.00133	0.78799				
ncsrbmt11_3_1_15	0.0	100	2774	2774	10050	94.55	1.0E+00	0.76796	0.00152	0.77099				
ncsrbmt11_2_1_15	0.0	100	1850	1850	10099	142.51	1.0E+00	0.73495	0.00142	0.73778				
ncsrbmt11_1_1_15	0.0	100	925	925	10148	286.41	1.0E+00	0.65230	0.00132	0.65494				
with can spacers (np thickness = 1.4 in.)														
ncsrbmt11_36_2_1	1.4	100	35142	35142	7719	5.73	1.0E-20	0.79252	0.00122	0.79496	hcsrbmt12_36_2_1	0.79368	0.00134	0.79636
ncsrbmt11_36_2_2	1.4	100	35142	35142	7719	5.73	1.0E-05	0.79014	0.00147	0.79309	hcsrbmt12_36_2_2	0.79487	0.00120	0.79727
ncsrbmt11_36_2_3	1.4	100	35142	35142	7719	5.73	1.0E-04	0.79182	0.00134	0.79450	hcsrbmt12_36_2_3	0.79667	0.00135	0.79938
ncsrbmt11_36_2_4	1.4	100	35142	35142	7719	5.73	1.0E-03	0.79144	0.00116	0.79376	hcsrbmt12_36_2_4	0.79705	0.00133	0.79971
ncsrbmt11_36_2_5	1.4	100	35142	35142	7719	5.73	1.0E-02	0.78918	0.00111	0.79141	hcsrbmt12_36_2_5	0.79627	0.00135	0.79898
ncsrbmt11_36_2_6	1.4	100	35142	35142	7719	5.73	1.0E-01	0.80114	0.00117	0.80348	hcsrbmt12_36_2_6	0.80431	0.00130	0.80691
ncsrbmt11_36_2_8	1.4	100	35142	35142	7719	5.73	3.0E-01	0.81416	0.00141	0.81698	hcsrbmt12_36_2_8	0.82035	0.00119	0.82273
ncsrbmt11_36_2_15	1.4	100	35142	35142	7719	5.73	1.0E+00	0.86924	0.00119	0.87162	hcsrbmt12_36_2_15	0.87124	0.00142	0.87408
ncsrbmt11_36_2_15	1.4	100	35142	35142	7719	5.73	1.0E+00	0.86924	0.00119	0.87162				
ncsrbmt11_35_2_15	1.4	100	34217	34217	7768	5.93	1.0E+00	0.86697	0.00130	0.86957				

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsrbmt11_34_2_15	1.4	100	33292	33292	7817	6.13	1.0E+00	0.86435	0.00138	0.86712				
ncsrbmt11_33_2_15	1.4	100	32367	32367	7866	6.34	1.0E+00	0.86988	0.00130	0.87249				
ncsrbmt11_32_2_15	1.4	100	31442	31442	7915	6.57	1.0E+00	0.86598	0.00145	0.86889				
ncsrbmt11_31_2_15	1.4	100	30518	30518	7964	6.81	1.0E+00	0.86432	0.00153	0.86739				
ncsrbmt11_30_2_15	1.4	100	29593	29593	8013	7.07	1.0E+00	0.85951	0.00163	0.86277				
ncsrbmt11_29_2_15	1.4	100	28668	28668	8062	7.34	1.0E+00	0.85938	0.00134	0.86206				
ncsrbmt11_28_2_15	1.4	100	27743	27743	8111	7.63	1.0E+00	0.85890	0.00133	0.86157				
ncsrbmt11_27_2_15	1.4	100	26819	26819	8160	7.94	1.0E+00	0.85736	0.00143	0.86023				
ncsrbmt11_26_2_15	1.4	100	25894	25894	8209	8.28	1.0E+00	0.85189	0.00129	0.85447				
ncsrbmt11_25_2_15	1.4	100	24969	24969	8258	8.63	1.0E+00	0.84986	0.00148	0.85281				
ncsrbmt11_24_2_15	1.4	100	23119	23119	8357	9.43	1.0E+00	0.85225	0.00131	0.85488				
ncsrbmt11_23_2_15	1.4	100	22195	22195	8406	9.89	1.0E+00	0.84824	0.00142	0.85108				
ncsrbmt11_22_2_15	1.4	100	21270	21270	8455	10.38	1.0E+00	0.84600	0.00135	0.84869				
ncsrbmt11_21_2_15	1.4	100	20345	20345	8504	10.91	1.0E+00	0.84406	0.00150	0.84706				
ncsrbmt11_20_2_15	1.4	100	19420	19420	8553	11.50	1.0E+00	0.83992	0.00126	0.84244				
ncsrbmt11_19_2_15	1.4	100	18496	18496	8602	12.14	1.0E+00	0.83869	0.00134	0.84138				
ncsrbmt11_18_2_15	1.4	100	17571	17571	8651	12.85	1.0E+00	0.83488	0.00152	0.83793				
ncsrbmt11_17_2_15	1.4	100	16646	16646	8700	13.64	1.0E+00	0.83409	0.00130	0.83669				
ncsrbmt11_16_2_15	1.4	100	15721	15721	8749	14.53	1.0E+00	0.83520	0.00135	0.83789				
ncsrbmt11_15_2_15	1.4	100	14796	14796	8798	15.52	1.0E+00	0.83427	0.00129	0.83686				
ncsrbmt11_14_2_15	1.4	100	13872	13872	8847	16.65	1.0E+00	0.83162	0.00157	0.83476				
ncsrbmt11_13_2_15	1.4	100	12947	12947	8896	17.94	1.0E+00	0.82907	0.00147	0.83201				
ncsrbmt11_12_2_15	1.4	100	11097	11097	8995	21.16	1.0E+00	0.82195	0.00149	0.82493				
ncsrbmt11_11_2_15	1.4	100	10173	10173	9044	23.20	1.0E+00	0.81845	0.00120	0.82084				

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsrbmt11_10_2_15	1.4	100	9248	9248	9093	25.66	1.0E+00	0.81508	0.00142	0.81792				
ncsrbmt11_9_2_15	1.4	100	8323	8323	9142	28.67	1.0E+00	0.81075	0.00138	0.81351				
ncsrbmt11_8_2_15	1.4	100	7398	7398	9191	32.43	1.0E+00	0.81425	0.00169	0.81764				
ncsrbmt11_7_2_15	1.4	100	6473	6473	9240	37.26	1.0E+00	0.80774	0.00155	0.81084				
ncsrbmt11_6_2_15	1.4	100	5549	5549	9289	43.70	1.0E+00	0.80060	0.00138	0.80336				
ncsrbmt11_5_2_15	1.4	100	4624	4624	9338	52.71	1.0E+00	0.79537	0.00167	0.79870				
ncsrbmt11_4_2_15	1.4	100	3699	3699	9387	66.24	1.0E+00	0.78379	0.00136	0.78651				
ncsrbmt11_3_2_15	1.4	100	2774	2774	9436	88.78	1.0E+00	0.76586	0.00130	0.76846				
ncsrbmt11_2_2_15	1.4	100	1850	1850	9485	133.86	1.0E+00	0.73246	0.00135	0.73516				
ncsrbmt11_1_2_15	1.4	100	925	925	9534	269.10	1.0E+00	0.65664	0.00150	0.65963				
content in flooded containment vessel, array packaging model for CSI=0.0														
NCT											**HAC**			
no can spacers (np thickness = 0.0 in.)														
nciabmt11_36_1_8_1	0.0	100	35142	35142	8332	6.19	1.0E-20	1.13613	0.00121	1.13855	hciabmt12_36_1_8_1	1.13721	0.00124	1.13969
nciabmt11_36_1_8_2	0.0	100	35142	35142	8332	6.19	1.0E-05	1.13830	0.00153	1.14135	hciabmt12_36_1_8_2	1.13634	0.00114	1.13862
nciabmt11_36_1_8_3	0.0	100	35142	35142	8332	6.19	1.0E-04	1.13709	0.00121	1.13952	hciabmt12_36_1_8_3	1.13700	0.00127	1.13954
nciabmt11_36_1_8_4	0.0	100	35142	35142	8332	6.19	1.0E-03	1.13450	0.00115	1.13679	hciabmt12_36_1_8_4	1.13567	0.00121	1.13809
nciabmt11_36_1_8_5	0.0	100	35142	35142	8332	6.19	1.0E-02	1.11154	0.00120	1.11394	hciabmt12_36_1_8_5	1.12232	0.00129	1.12490
nciabmt11_36_1_8_6	0.0	100	35142	35142	8332	6.19	1.0E-01	0.98653	0.00121	0.98894	hciabmt12_36_1_8_6	1.03049	0.00115	1.03278
nciabmt11_36_1_8_8	0.0	100	35142	35142	8332	6.19	3.0E-01	0.91622	0.00135	0.91892	hciabmt12_36_1_8_8	0.95566	0.00126	0.95818
nciabmt11_36_1_8_15	0.0	100	35142	35142	8332	6.19	1.0E+00	0.91008	0.00124	0.91255	hciabmt12_36_1_8_15	0.93645	0.00120	0.93884
nciabmt11_7_1_5_3	0.0	80	6490	5192	9854	49.54	1.0E-04	0.96163	0.00130	0.96423	hciabmt12_7_1_5_3	0.96193	0.00149	0.96490
nciabmt11_6_1_5_3	0.0	80	5563	4450	9903	58.08	1.0E-04	0.95210	0.00130	0.95471	hciabmt12_6_1_5_3	0.95164	0.00139	0.95442

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciabmt11_5_1_5_3	0.0	80	4636	3709	9952	70.04	1.0E-04	0.93892	0.00161	0.94215	hciabmt12_5_1_5_3	0.93880	0.00141	0.94162
nciabmt11_4_1_5_3	0.0	80	3709	2967	10001	87.98	1.0E-04	0.91835	0.00149	0.92133	hciabmt12_4_1_5_3	0.92156	0.00160	0.92476
nciabmt11_3_1_5_3	0.0	80	2781	2225	10050	117.89	1.0E-04	0.89262	0.00129	0.89520	hciabmt12_3_1_5_3	0.89109	0.00160	0.89430
nciabmt11_9_1_4_3	0.0	70	8355	5848	9755	43.54	1.0E-04	0.95952	0.00130	0.96213	hciabmt12_9_1_4_3	0.95495	0.00150	0.95795
nciabmt11_8_1_4_3	0.0	70	7426	5198	9804	49.23	1.0E-04	0.94887	0.00152	0.95191	hciabmt12_8_1_4_3	0.95267	0.00156	0.95578
nciabmt11_7_1_4_3	0.0	70	6498	4549	9854	56.54	1.0E-04	0.94082	0.00132	0.94346	hciabmt12_7_1_4_3	0.94409	0.00125	0.94659
nciabmt11_6_1_4_3	0.0	70	5570	3899	9903	66.29	1.0E-04	0.92987	0.00119	0.93225	hciabmt12_6_1_4_3	0.93280	0.00123	0.93526
nciabmt11_5_1_4_3	0.0	70	4642	3249	9952	79.95	1.0E-04	0.91799	0.00136	0.92070	hciabmt12_5_1_4_3	0.92053	0.00147	0.92347
nciabmt11_10_1_3_3	0.0	60	9295	5577	9706	45.43	1.0E-04	0.94106	0.00152	0.94409	hciabmt12_10_1_3_3	0.94167	0.00126	0.94419
nciabmt11_9_1_3_3	0.0	60	8365	5019	9755	50.73	1.0E-04	0.93671	0.00123	0.93918	hciabmt12_9_1_3_3	0.93973	0.00135	0.94242
nciabmt11_8_1_3_3	0.0	60	7436	4462	9804	57.36	1.0E-04	0.92907	0.00129	0.93166	hciabmt12_8_1_3_3	0.93016	0.00128	0.93273
nciabmt11_7_1_3_3	0.0	60	6506	3904	9854	65.88	1.0E-04	0.92171	0.00118	0.92407	hciabmt12_7_1_3_3	0.92300	0.00130	0.92560
nciabmt11_6_1_3_3	0.0	60	5577	3346	9903	77.24	1.0E-04	0.91221	0.00147	0.91515	hciabmt12_6_1_3_3	0.91017	0.00128	0.91274
with can spacers (np thickness = 1.4 in.)														
nciabmt11_36_2_8_1	1.4	100	35142	35142	7719	5.73	1.0E-20	1.11012	0.00118	1.11249	hciabmt12_36_2_8_1	1.11021	0.00115	1.11250
nciabmt11_36_2_8_2	1.4	100	35142	35142	7719	5.73	1.0E-05	1.10934	0.00103	1.11141	hciabmt12_36_2_8_2	1.10929	0.00137	1.11202
nciabmt11_36_2_8_3	1.4	100	35142	35142	7719	5.73	1.0E-04	1.10991	0.00131	1.11252	hciabmt12_36_2_8_3	1.10922	0.00112	1.11145
nciabmt11_36_2_8_4	1.4	100	35142	35142	7719	5.73	1.0E-03	1.10774	0.00123	1.11020	hciabmt12_36_2_8_4	1.10732	0.00115	1.10963
nciabmt11_36_2_8_5	1.4	100	35142	35142	7719	5.73	1.0E-02	1.08309	0.00140	1.08589	hciabmt12_36_2_8_5	1.09559	0.00114	1.09786
nciabmt11_36_2_8_6	1.4	100	35142	35142	7719	5.73	1.0E-01	0.95955	0.00128	0.96212	hciabmt12_36_2_8_6	1.00216	0.00124	1.00463
nciabmt11_36_2_8_8	1.4	100	35142	35142	7719	5.73	3.0E-01	0.88829	0.00112	0.89053	hciabmt12_36_2_8_8	0.92859	0.00158	0.93175
nciabmt11_36_2_8_15	1.4	100	35142	35142	7719	5.73	1.0E+00	0.88638	0.00158	0.88953	hciabmt12_36_2_8_15	0.91405	0.00147	0.91698

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciabmt11_5_2_8_3	1.4	100	4624	4624	9338	52.71	1.0E-04	0.94785	0.00147	0.95079	hciabmt12_5_2_8_3	0.95226	0.00143	0.95511
nciabmt11_4_2_8_3	1.4	100	3699	3699	9387	66.24	1.0E-04	0.92504	0.00170	0.92845	hciabmt12_4_2_8_3	0.93069	0.00142	0.93352
nciabmt11_3_2_8_3	1.4	100	2774	2774	9436	88.78	1.0E-04	0.90131	0.00139	0.90409	hciabmt12_3_2_8_3	0.90243	0.00127	0.90497
nciabmt11_2_2_8_3	1.4	100	1850	1850	9485	133.86	1.0E-04	0.85414	0.00141	0.85696	hciabmt12_2_2_8_3	0.85600	0.00123	0.85846
nciabmt11_1_2_8_3	1.4	100	925	925	9534	269.10	1.0E-04	0.74985	0.00124	0.75232	hciabmt12_1_2_8_3	0.75078	0.00135	0.75347
nciabmt11_6_2_7_3	1.4	95	5552	5275	9289	45.97	1.0E-04	0.95078	0.00124	0.95327	hciabmt12_6_2_7_3	0.95399	0.00153	0.95704
nciabmt11_5_2_7_3	1.4	95	4627	4396	9338	55.45	1.0E-04	0.93742	0.00130	0.94002	hciabmt12_5_2_7_3	0.93696	0.00142	0.93981
nciabmt11_4_2_7_3	1.4	95	3701	3516	9387	69.68	1.0E-04	0.91690	0.00149	0.91987	hciabmt12_4_2_7_3	0.92094	0.00140	0.92374
nciabmt11_3_2_7_3	1.4	95	2776	2637	9436	93.39	1.0E-04	0.89089	0.00127	0.89343	hciabmt12_3_2_7_3	0.89250	0.00144	0.89537
nciabmt11_2_2_7_3	1.4	95	1851	1758	9485	140.81	1.0E-04	0.84225	0.00143	0.84510	hciabmt12_2_2_7_3	0.84604	0.00135	0.84875
nciabmt11_6_2_6_3	1.4	90	5556	5000	9289	48.49	1.0E-04	0.93703	0.00127	0.93956	hciabmt12_6_2_6_3	0.93967	0.00130	0.94227
nciabmt11_5_2_6_3	1.4	90	4630	4167	9338	58.49	1.0E-04	0.92640	0.00142	0.92925	hciabmt12_5_2_6_3	0.92390	0.00155	0.92700
nciabmt11_4_2_6_3	1.4	90	3704	3333	9387	73.50	1.0E-04	0.90541	0.00147	0.90835	hciabmt12_4_2_6_3	0.90643	0.00133	0.90909
nciabmt11_3_2_6_3	1.4	90	2778	2500	9436	98.52	1.0E-04	0.87970	0.00157	0.88283	hciabmt12_3_2_6_3	0.87916	0.00154	0.88224
nciabmt11_2_2_6_3	1.4	90	1852	1667	9485	148.54	1.0E-04	0.83371	0.00129	0.83628	hciabmt12_2_2_6_3	0.83414	0.00130	0.83674
nciabmt11_8_2_5_3	1.4	80	7417	5934	9191	40.43	1.0E-04	0.94131	0.00162	0.94455	hciabmt12_8_2_5_3	0.93963	0.00149	0.94261
nciabmt11_7_2_5_3	1.4	80	6490	5192	9240	46.45	1.0E-04	0.92939	0.00127	0.93193	hciabmt12_7_2_5_3	0.93070	0.00160	0.93391
nciabmt11_6_2_5_3	1.4	80	5563	4450	9289	54.48	1.0E-04	0.91981	0.00127	0.92235	hciabmt12_6_2_5_3	0.91987	0.00157	0.92301
nciabmt11_5_2_5_3	1.4	80	4636	3709	9338	65.72	1.0E-04	0.90533	0.00127	0.90787	hciabmt12_5_2_5_3	0.90772	0.00136	0.91044
nciabmt11_4_2_5_3	1.4	80	3709	2967	9387	82.59	1.0E-04	0.88537	0.00136	0.88808	hciabmt12_4_2_5_3	0.88792	0.00150	0.89092

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciabmt11_11_2_4_3	1.4	70	10211	7148	9044	33.02	1.0E-04	0.93094	0.00141	0.93376	hciabmt12_11_2_4_3	0.93119	0.00138	0.93395
nciabmt11_10_2_4_3	1.4	70	9283	6498	9093	36.52	1.0E-04	0.92534	0.00139	0.92813	hciabmt12_10_2_4_3	0.92795	0.00129	0.93052
nciabmt11_9_2_4_3	1.4	70	8355	5848	9142	40.80	1.0E-04	0.91866	0.00122	0.92110	hciabmt12_9_2_4_3	0.92290	0.00125	0.92540
nciabmt11_8_2_4_3	1.4	70	7426	5198	9191	46.15	1.0E-04	0.91902	0.00137	0.92175	hciabmt12_8_2_4_3	0.91835	0.00126	0.92086
nciabmt11_7_2_4_3	1.4	70	6498	4549	9240	53.02	1.0E-04	0.90863	0.00152	0.91166	hciabmt12_7_2_4_3	0.91042	0.00137	0.91316
nciabmt11_15_2_3_3	1.4	60	14872	8923	8798	25.74	1.0E-04	0.93047	0.00133	0.93313	hciabmt12_15_2_3_3	0.93032	0.00114	0.93259
nciabmt11_14_2_3_3	1.4	60	13942	8365	8847	27.61	1.0E-04	0.92560	0.00138	0.92837	hciabmt12_14_2_3_3	0.92828	0.00143	0.93115
nciabmt11_13_2_3_3	1.4	60	12083	7250	8946	32.21	1.0E-04	0.91963	0.00126	0.92214	hciabmt12_13_2_3_3	0.92389	0.00124	0.92638
nciabmt11_12_2_3_3	1.4	60	11154	6692	8995	35.08	1.0E-04	0.91502	0.00155	0.91812	hciabmt12_12_2_3_3	0.91776	0.00138	0.92053
nciabmt11_11_2_3_3	1.4	60	10224	6135	9044	38.48	1.0E-04	0.90892	0.00140	0.91172	hciabmt12_11_2_3_3	0.91237	0.00133	0.91503
content in flooded containment vessel, array packaging model for CSI=0.4														
NCT											**HAC**			
no can spacers (np thickness = 0.0 in.)														
											hcf2bmt12_11_1_5_3	0.91900	0.00131	0.92163
											hcf2bmt12_10_1_5_3	0.91775	0.00161	0.92097
											hcf2bmt12_9_1_5_3	0.91229	0.00127	0.91483
ncf1bmt11_8_1_5_3	0.0	80	7417	5934	9804	43.13	1.0E-04	0.92824	0.00156	0.93135	hcf2bmt12_8_1_5_3	0.90367	0.00138	0.90643
ncf1bmt11_7_1_5_3	0.0	80	6490	5192	9854	49.54	1.0E-04	0.92088	0.00131	0.92349				
ncf1bmt11_6_1_5_3	0.0	80	5563	4450	9903	58.08	1.0E-04	0.91164	0.00153	0.91470				
ncf1bmt11_5_1_5_3	0.0	80	4636	3709	9952	70.04	1.0E-04	0.90130	0.00135	0.90400				
ncf1bmt11_4_1_5_3	0.0	80	3709	2967	10001	87.98	1.0E-04	0.88094	0.00128	0.88350				

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
											hcf2bmt12_15_1_4_3	0.91711	0.00152	0.92016
											hcf2bmt12_14_1_4_3	0.91432	0.00164	0.91760
ncf1bmt11_13_1_4_3	0.0	70	12996	9097	9510	27.28	1.0E-04	0.93558	0.00138	0.93834	hcf2bmt12_13_1_4_3	0.91429	0.00141	0.91711
ncf1bmt11_12_1_4_3	0.0	70	11140	7798	9608	32.16	1.0E-04	0.92957	0.00130	0.93217	hcf2bmt12_12_1_4_3	0.90853	0.00161	0.91175
ncf1bmt11_11_1_4_3	0.0	70	10211	7148	9657	35.26	1.0E-04	0.92397	0.00139	0.92675				
ncf1bmt11_10_1_4_3	0.0	70	9283	6498	9706	38.99	1.0E-04	0.92240	0.00135	0.92510				
ncf1bmt11_9_1_4_3	0.0	70	8355	5848	9755	43.54	1.0E-04	0.91886	0.00139	0.92163				
											hcf2bmt12_21_1_3_3	0.91091	0.00139	0.91369
											hcf2bmt12_20_1_3_3	0.90915	0.00144	0.91203
ncf1bmt11_19_1_3_3	0.0	60	18589	11154	9216	21.57	1.0E-04	0.92771	0.00137	0.93044	hcf2bmt12_19_1_3_3	0.90638	0.00160	0.90958
ncf1bmt11_18_1_3_3	0.0	60	17660	10596	9265	22.82	1.0E-04	0.92867	0.00148	0.93164	hcf2bmt12_18_1_3_3	0.90466	0.00124	0.90715
ncf1bmt11_17_1_3_3	0.0	60	16731	10038	9314	24.22	1.0E-04	0.92948	0.00113	0.93173				
ncf1bmt11_16_1_3_3	0.0	60	15801	9481	9363	25.78	1.0E-04	0.92252	0.00158	0.92569				
ncf1bmt11_15_1_3_3	0.0	60	14872	8923	9412	27.53	1.0E-04	0.91999	0.00123	0.92246				
ncf1bmt11_14_1_3_3	0.0	60	13942	8365	9461	29.52	1.0E-04	0.91961	0.00144	0.92248				
with can spacers (np thickness = 1.4 in.)														
											hcf2bmt12_10_2_8_3	0.93154	0.00152	0.93458
ncf1bmt11_9_2_8_3	1.4	100	8323	8323	9142	28.67	1.0E-04	0.94429	0.00138	0.94704	hcf2bmt12_9_2_8_3	0.92329	0.00147	0.92622
ncf1bmt11_8_2_8_3	1.4	100	7398	7398	9191	32.43	1.0E-04	0.94337	0.00169	0.94674	hcf2bmt12_8_2_8_3	0.92153	0.00144	0.92442
ncf1bmt11_7_2_8_3	1.4	100	6473	6473	9240	37.26	1.0E-04	0.93117	0.00172	0.93460				
ncf1bmt11_6_2_8_3	1.4	100	5549	5549	9289	43.70	1.0E-04	0.92119	0.00147	0.92412				
											hcf2bmt12_13_2_7_3	0.93389	0.00167	0.93722

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
											hcf2bmt12_12_2_7_3	0.92649	0.00146	0.92941
ncf1bmt11_11_2_7_3	1.4	95	10179	9670	9044	24.41	1.0E-04	0.94326	0.00139	0.94604	hcf2bmt12_11_2_7_3	0.92061	0.00130	0.92320
ncf1bmt11_10_2_7_3	1.4	95	9254	8791	9093	27.00	1.0E-04	0.93829	0.00154	0.94138	hcf2bmt12_10_2_7_3	0.91423	0.00145	0.91712
ncf1bmt11_9_2_7_3	1.4	95	8328	7912	9142	30.16	1.0E-04	0.93239	0.00181	0.93600	hcf2bmt12_9_2_7_3	0.90883	0.00137	0.91156
ncf1bmt11_8_2_7_3	1.4	95	7403	7033	9191	34.11	1.0E-04	0.92812	0.00144	0.93100				
ncf1bmt11_7_2_7_3	1.4	95	6478	6154	9240	39.19	1.0E-04	0.91938	0.00130	0.92199				
											hcf2bmt12_15_2_6_3	0.93106	0.00129	0.93364
											hcf2bmt12_14_2_6_3	0.92492	0.00129	0.92749
ncf1bmt11_13_2_6_3	1.4	90	12963	11667	8896	19.90	1.0E-04	0.94806	0.00123	0.95052	hcf2bmt12_13_2_6_3	0.92272	0.00138	0.92548
ncf1bmt11_12_2_6_3	1.4	90	11111	10000	8995	23.48	1.0E-04	0.93464	0.00123	0.93710	hcf2bmt12_12_2_6_3	0.91625	0.00149	0.91924
ncf1bmt11_11_2_6_3	1.4	90	10185	9167	9044	25.75	1.0E-04	0.93068	0.00148	0.93363	hcf2bmt12_11_2_6_3	0.91097	0.00136	0.91370
ncf1bmt11_10_2_6_3	1.4	90	9260	8334	9093	28.48	1.0E-04	0.92732	0.00150	0.93032				
ncf1bmt11_9_2_6_3	1.4	90	8334	7500	9142	31.81	1.0E-04	0.91744	0.00145	0.92034				
ncf1bmt11_8_2_6_3	1.4	90	7408	6667	9191	35.98	1.0E-04	0.91952	0.00133	0.92218				
ncf1bmt11_17_2_5_3	1.4	80	16688	13351	8700	17.01	1.0E-04	0.93531	0.00128	0.93787	hcf2bmt12_17_2_5_3	0.91255	0.00114	0.91482
ncf1bmt11_16_2_5_3	1.4	80	15761	12609	8749	18.11	1.0E-04	0.93511	0.00160	0.93832	hcf2bmt12_16_2_5_3	0.91363	0.00123	0.91608
ncf1bmt11_15_2_5_3	1.4	80	14834	11867	8798	19.35	1.0E-04	0.93431	0.00141	0.93713	hcf2bmt12_15_2_5_3	0.91038	0.00115	0.91268
ncf1bmt11_14_2_5_3	1.4	80	13907	11125	8847	20.76	1.0E-04	0.92939	0.00133	0.93205	hcf2bmt12_14_2_5_3	0.90762	0.00139	0.91041
ncf1bmt11_13_2_5_3	1.4	80	12980	10384	8896	22.36	1.0E-04	0.92453	0.00131	0.92715	hcf2bmt12_13_2_5_3	0.90539	0.00137	0.90812
ncf1bmt11_12_2_5_3	1.4	80	11125	8900	8995	26.38	1.0E-04	0.91584	0.00142	0.91868	hcf2bmt12_12_2_5_3	0.89295	0.00174	0.89642
ncf1bmt11_24_2_4_3	1.4	70	23207	16245	8357	13.43	1.0E-04	0.93515	0.00143	0.93801	hcf2bmt12_24_2_4_3	0.91356	0.00125	0.91606

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncf1bmt11_23_2_4_3	1.4	70	22279	15595	8406	14.07	1.0E-04	0.93264	0.00113	0.93490	hcf2bmt12_23_2_4_3	0.91116	0.00113	0.91342
ncf1bmt11_22_2_4_3	1.4	70	21351	14946	8455	14.77	1.0E-04	0.93058	0.00128	0.93314	hcf2bmt12_22_2_4_3	0.90737	0.00145	0.91027
ncf1bmt11_21_2_4_3	1.4	70	20422	14296	8504	15.53	1.0E-04	0.92635	0.00112	0.92859	hcf2bmt12_21_2_4_3	0.90516	0.00140	0.90796
ncf1bmt11_20_2_4_3	1.4	70	19494	13646	8553	16.36	1.0E-04	0.92535	0.00141	0.92818	hcf2bmt12_20_2_4_3	0.90283	0.00136	0.90555
ncf1bmt11_19_2_4_3	1.4	70	18566	12996	8602	17.28	1.0E-04	0.92097	0.00177	0.92450	hcf2bmt12_19_2_4_3	0.89757	0.00144	0.90046
ncf1bmt11_18_2_4_3	1.4	70	17638	12346	8651	18.29	1.0E-04	0.91681	0.00140	0.91961	hcf2bmt12_18_2_4_3	0.89367	0.00144	0.89656
ncf1bmt11_36_2_3_3	1.4	60	35320	21192	7719	9.51	1.0E-04	0.93212	0.00121	0.93455	hcf2bmt12_36_2_3_3	0.90846	0.00137	0.91121
ncf1bmt11_35_2_3_3	1.4	60	34391	20634	7768	9.83	1.0E-04	0.93168	0.00129	0.93426	hcf2bmt12_35_2_3_3	0.90742	0.00118	0.90977
ncf1bmt11_34_2_3_3	1.4	60	33461	20077	7817	10.16	1.0E-04	0.93079	0.00145	0.93368	hcf2bmt12_34_2_3_3	0.90657	0.00134	0.90925
ncf1bmt11_33_2_3_3	1.4	60	32532	19519	7866	10.52	1.0E-04	0.92781	0.00131	0.93042	hcf2bmt12_33_2_3_3	0.90603	0.00117	0.90837
ncf1bmt11_32_2_3_3	1.4	60	31602	18961	7915	10.90	1.0E-04	0.92550	0.00131	0.92811	hcf2bmt12_32_2_3_3	0.90015	0.00127	0.90270
ncf1bmt11_31_2_3_3	1.4	60	30673	18404	7964	11.29	1.0E-04	0.92597	0.00128	0.92853	hcf2bmt12_31_2_3_3	0.90333	0.00122	0.90577
ncf1bmt11_30_2_3_3	1.4	60	29743	17846	8013	11.72	1.0E-04	0.92361	0.00120	0.92601	hcf2bmt12_30_2_3_3	0.89683	0.00144	0.89971
ncf1bmt11_29_2_3_3	1.4	60	28814	17288	8062	12.17	1.0E-04	0.92063	0.00143	0.92350				
content in flooded containment vessel, array packaging model for CSI=0.8														
NCT											**HAC**			
no can spacers (np thickness = 0.0 in.)														
ncf2bmt11_17_1_5_3	0.0	80	16688	13351	9314	18.21	1.0E-04	0.93655	0.00144	0.93942	hcf3bmt12_17_1_5_3	0.92003	0.00129	0.92262
ncf2bmt11_16_1_5_3	0.0	80	15761	12609	9363	19.38	1.0E-04	0.93242	0.00143	0.93529	hcf3bmt12_16_1_5_3	0.91399	0.00148	0.91694
ncf2bmt11_15_1_5_3	0.0	80	14834	11867	9412	20.70	1.0E-04	0.92982	0.00135	0.93251	hcf3bmt12_15_1_5_3	0.91169	0.00139	0.91448
ncf2bmt11_14_1_5_3	0.0	80	13907	11125	9461	22.20	1.0E-04	0.92699	0.00137	0.92972	hcf3bmt12_14_1_5_3	0.90943	0.00135	0.91213
ncf2bmt11_13_1_5_3	0.0	80	12980	10384	9510	23.90	1.0E-04	0.92634	0.00138	0.92909	hcf3bmt12_13_1_5_3	0.90348	0.00133	0.90615
ncf2bmt11_12_1_5_3	0.0	80	11125	8900	9608	28.18	1.0E-04	0.91826	0.00166	0.92158	hcf3bmt12_12_1_5_3	0.89805	0.00155	0.90115

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncf2bmt11_21_1_4_3	0.0	70	20422	14296	9117	16.65	1.0E-04	0.92723	0.00123	0.92968				
ncf2bmt11_20_1_4_3	0.0	70	19494	13646	9166	17.53	1.0E-04	0.92094	0.00124	0.92342	hcf3bmt12_20_1_4_3	0.90398	0.00124	0.90646
ncf2bmt11_19_1_4_3	0.0	70	18566	12996	9216	18.51	1.0E-04	0.92341	0.00144	0.92629	hcf3bmt12_19_1_4_3	0.90150	0.00151	0.90452
ncf2bmt11_18_1_4_3	0.0	70	17638	12346	9265	19.59	1.0E-04	0.91814	0.00135	0.92085	hcf3bmt12_18_1_4_3	0.89955	0.00134	0.90222
ncf2bmt11_17_1_4_3	0.0	70	16709	11697	9314	20.78	1.0E-04	0.91793	0.00133	0.92058	hcf3bmt12_17_1_4_3	0.89730	0.00133	0.89996
ncf2bmt11_16_1_4_3	0.0	70	15781	11047	9363	22.12	1.0E-04	0.91629	0.00133	0.91895	hcf3bmt12_16_1_4_3	0.89458	0.00122	0.89702
ncf2bmt11_15_1_4_3	0.0	70	14853	10397	9412	23.63	1.0E-04	0.91068	0.00125	0.91317	hcf3bmt12_15_1_4_3	0.89088	0.00130	0.89347
ncf2bmt11_36_1_3_3	0.0	60	35320	21192	8332	10.26	1.0E-04	0.93348	0.00105	0.93558	hcf3bmt12_36_1_3_3	0.91223	0.00113	0.91450
ncf2bmt11_35_1_3_3	0.0	60	34391	20634	8381	10.60	1.0E-04	0.93036	0.00127	0.93290	hcf3bmt12_35_1_3_3	0.91033	0.00128	0.91288
ncf2bmt11_34_1_3_3	0.0	60	33461	20077	8430	10.96	1.0E-04	0.92584	0.00127	0.92837	hcf3bmt12_34_1_3_3	0.90950	0.00126	0.91202
ncf2bmt11_33_1_3_3	0.0	60	32532	19519	8479	11.34	1.0E-04	0.92680	0.00142	0.92965	hcf3bmt12_33_1_3_3	0.90720	0.00143	0.91007
ncf2bmt11_32_1_3_3	0.0	60	31602	18961	8529	11.74	1.0E-04	0.92588	0.00144	0.92877	hcf3bmt12_32_1_3_3	0.90425	0.00126	0.90678
ncf2bmt11_31_1_3_3	0.0	60	30673	18404	8578	12.17	1.0E-04	0.92420	0.00123	0.92665	hcf3bmt12_31_1_3_3	0.90271	0.00118	0.90506
ncf2bmt11_30_1_3_3	0.0	60	29743	17846	8627	12.62	1.0E-04	0.92236	0.00165	0.92566	hcf3bmt12_30_1_3_3	0.90323	0.00138	0.90599
ncf2bmt11_29_1_3_3	0.0	60	28814	17288	8676	13.10	1.0E-04	0.91822	0.00113	0.92047	hcf3bmt12_29_1_3_3	0.89982	0.00121	0.90224
with can spacers (np thickness = 1.4 in.)														
ncf2bmt11_12_2_8_3	1.4	100	11097	11097	8995	21.16	1.0E-04	0.93137	0.00124	0.93385	hcf3bmt12_12_2_8_3	0.91417	0.00139	0.91696
ncf2bmt11_11_2_8_3	1.4	100	10173	10173	9044	23.20	1.0E-04	0.92641	0.00144	0.92928	hcf3bmt12_11_2_8_3	0.91315	0.00164	0.91642
ncf2bmt11_10_2_8_3	1.4	100	9248	9248	9093	25.66	1.0E-04	0.92058	0.00138	0.92334	hcf3bmt12_10_2_8_3	0.90570	0.00166	0.90902
ncf2bmt11_9_2_8_3	1.4	100	8323	8323	9142	28.67	1.0E-04	0.91671	0.00138	0.91947	hcf3bmt12_9_2_8_3	0.89648	0.00131	0.89911
ncf2bmt11_8_2_8_3	1.4	100	7398	7398	9191	32.43	1.0E-04	0.91365	0.00171	0.91706	hcf3bmt12_8_2_8_3	0.89682	0.00139	0.89960
ncf2bmt11_7_2_8_3	1.4	100	6473	6473	9240	37.26	1.0E-04	0.90684	0.00166	0.91016	hcf3bmt12_7_2_8_3	0.88907	0.00143	0.89192

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncf2bmt11_6_2_8_3	1.4	100	5549	5549	9289	43.70	1.0E-04	0.89705	0.00145	0.89995	hcf3bmt12_6_2_8_3	0.87797	0.00166	0.88130
ncf2bmt11_14_2_7_3	1.4	95	13880	13186	8847	17.51	1.0E-04	0.93174	0.00131	0.93437	hcf3bmt12_14_2_7_3	0.91453	0.00162	0.91777
ncf2bmt11_13_2_7_3	1.4	95	12955	12307	8896	18.87	1.0E-04	0.92685	0.00140	0.92965	hcf3bmt12_13_2_7_3	0.91006	0.00135	0.91276
ncf2bmt11_12_2_7_3	1.4	95	11104	10549	8995	22.25	1.0E-04	0.91939	0.00136	0.92210	hcf3bmt12_12_2_7_3	0.89784	0.00132	0.90048
ncf2bmt11_11_2_7_3	1.4	95	10179	9670	9044	24.41	1.0E-04	0.91215	0.00134	0.91483	hcf3bmt12_11_2_7_3	0.89423	0.00146	0.89715
ncf2bmt11_10_2_7_3	1.4	95	9254	8791	9093	27.00	1.0E-04	0.90898	0.00126	0.91151	hcf3bmt12_10_2_7_3	0.89121	0.00159	0.89438
ncf2bmt11_9_2_7_3	1.4	95	8328	7912	9142	30.16	1.0E-04	0.90123	0.00147	0.90416	hcf3bmt12_9_2_7_3	0.88311	0.00145	0.88602
ncf2bmt11_16_2_6_3	1.4	90	15741	14167	8749	16.12	1.0E-04	0.92855	0.00124	0.93103	hcf3bmt12_16_2_6_3	0.91007	0.00134	0.91276
ncf2bmt11_15_2_6_3	1.4	90	14815	13334	8798	17.22	1.0E-04	0.92599	0.00107	0.92813	hcf3bmt12_15_2_6_3	0.90421	0.00136	0.90693
ncf2bmt11_14_2_6_3	1.4	90	13889	12500	8847	18.47	1.0E-04	0.91938	0.00131	0.92200	hcf3bmt12_14_2_6_3	0.90163	0.00129	0.90422
ncf2bmt11_13_2_6_3	1.4	90	12963	11667	8896	19.90	1.0E-04	0.91387	0.00110	0.91607	hcf3bmt12_13_2_6_3	0.89824	0.00123	0.90069
ncf2bmt11_12_2_6_3	1.4	90	11111	10000	8995	23.48	1.0E-04	0.90989	0.00135	0.91258	hcf3bmt12_12_2_6_3	0.88832	0.00136	0.89105
ncf2bmt11_11_2_6_3	1.4	90	10185	9167	9044	25.75	1.0E-04	0.90334	0.00152	0.90637	hcf3bmt12_11_2_6_3	0.88574	0.00168	0.88911
ncf2bmt11_10_2_6_3	1.4	90	9260	8334	9093	28.48	1.0E-04	0.89868	0.00172	0.90212	hcf3bmt12_10_2_6_3	0.87986	0.00134	0.88254
ncf2bmt11_9_2_6_3	1.4	90	8334	7500	9142	31.81	1.0E-04	0.89190	0.00154	0.89499	hcf3bmt12_9_2_6_3	0.87453	0.00140	0.87733
											hcf3bmt12_24_2_5_3	0.90790	0.00134	0.91058
											hcf3bmt12_23_2_5_3	0.90282	0.00121	0.90523
ncf2bmt11_22_2_5_3	1.4	80	21324	17059	8455	12.94	1.0E-04	0.92358	0.00131	0.92619	hcf3bmt12_22_2_5_3	0.90006	0.00139	0.90284
ncf2bmt11_21_2_5_3	1.4	80	20397	16317	8504	13.60	1.0E-04	0.91640	0.00145	0.91930	hcf3bmt12_21_2_5_3	0.89948	0.00134	0.90216
ncf2bmt11_20_2_5_3	1.4	80	19470	15576	8553	14.33	1.0E-04	0.91428	0.00133	0.91694	hcf3bmt12_20_2_5_3	0.89698	0.00122	0.89941
ncf2bmt11_19_2_5_3	1.4	80	18542	14834	8602	15.14	1.0E-04	0.91020	0.00130	0.91281	hcf3bmt12_19_2_5_3	0.89282	0.00129	0.89541

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncf2bmt11_18_2_5_3	1.4	80	17615	14092	8651	16.02	1.0E-04	0.90784	0.00135	0.91054	hcf3bmt12_18_2_5_3	0.88897	0.00125	0.89148
ncf2bmt11_17_2_5_3	1.4	80	16688	13351	8700	17.01	1.0E-04	0.90364	0.00123	0.90610	hcf3bmt12_17_2_5_3	0.88452	0.00123	0.88697
ncf2bmt11_16_2_5_3	1.4	80	15761	12609	8749	18.11	1.0E-04	0.90402	0.00132	0.90666	hcf3bmt12_16_2_5_3	0.88688	0.00121	0.88929
ncf2bmt11_15_2_5_3	1.4	80	14834	11867	8798	19.35	1.0E-04	0.90496	0.00145	0.90786	hcf3bmt12_15_2_5_3	0.88496	0.00135	0.88765
ncf2bmt11_33_2_4_3	1.4	70	32490	22743	7866	9.03	1.0E-04	0.92631	0.00120	0.92871	hcf3bmt12_33_2_4_3	0.90516	0.00118	0.90752
ncf2bmt11_32_2_4_3	1.4	70	31562	22093	7915	9.35	1.0E-04	0.92304	0.00128	0.92560	hcf3bmt12_32_2_4_3	0.90236	0.00135	0.90507
ncf2bmt11_31_2_4_3	1.4	70	30634	21444	7964	9.69	1.0E-04	0.92250	0.00132	0.92514	hcf3bmt12_31_2_4_3	0.90127	0.00111	0.90349
ncf2bmt11_30_2_4_3	1.4	70	29705	20794	8013	10.06	1.0E-04	0.92048	0.00138	0.92325	hcf3bmt12_30_2_4_3	0.89944	0.00124	0.90192
ncf2bmt11_29_2_4_3	1.4	70	28777	20144	8062	10.45	1.0E-04	0.91607	0.00135	0.91878	hcf3bmt12_29_2_4_3	0.89544	0.00139	0.89823
ncf2bmt11_28_2_4_3	1.4	70	27849	19494	8111	10.86	1.0E-04	0.91338	0.00129	0.91596	hcf3bmt12_28_2_4_3	0.89451	0.00127	0.89706
ncf2bmt11_27_2_4_3	1.4	70	26921	18844	8160	11.30	1.0E-04	0.91255	0.00127	0.91510	hcf3bmt12_27_2_4_3	0.88990	0.00135	0.89261
ncf2bmt11_36_2_3_3	1.4	60	35320	21192	7719	9.51	1.0E-04	0.90382	0.00130	0.90642	hcf3bmt12_36_2_3_3	0.88262	0.00120	0.88503
ncf2bmt11_35_2_3_3	1.4	60	34391	20634	7768	9.83	1.0E-04	0.90020	0.00136	0.90291	hcf3bmt12_35_2_3_3	0.87857	0.00132	0.88120
ncf2bmt11_34_2_3_3	1.4	60	33461	20077	7817	10.16	1.0E-04	0.89689	0.00121	0.89932	hcf3bmt12_34_2_3_3	0.87717	0.00111	0.87939
ncf2bmt11_33_2_3_3	1.4	60	32532	19519	7866	10.52	1.0E-04	0.89834	0.00117	0.90069	hcf3bmt12_33_2_3_3	0.87502	0.00127	0.87757
ncf2bmt11_32_2_3_3	1.4	60	31602	18961	7915	10.90	1.0E-04	0.89483	0.00136	0.89755	hcf3bmt12_32_2_3_3	0.87552	0.00129	0.87809
ncf2bmt11_31_2_3_3	1.4	60	30673	18404	7964	11.29	1.0E-04	0.89450	0.00137	0.89723	hcf3bmt12_31_2_3_3	0.87475	0.00139	0.87752
ncf2bmt11_30_2_3_3	1.4	60	29743	17846	8013	11.72	1.0E-04	0.89227	0.00133	0.89493	hcf3bmt12_30_2_3_3	0.87454	0.00121	0.87695
content in flooded containment vessel, array packaging model for CSI=2.0														
NCT											**HAC**			
no can spacers (np thickness = 0.0 in.)														
ncf3bmt11_24_1_5_3	0.0	80	23178	18542	8970	12.63	1.0E-04	0.92510	0.00131	0.92772	hcf4bmt12_24_1_5_3	0.88778	0.00138	0.89054

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncf3bmt11_23_1_5_3	0.0	80	22251	17801	9019	13.22	1.0E-04	0.92307	0.00144	0.92595	hcf4bmt12_23_1_5_3	0.88545	0.00131	0.88806
ncf3bmt11_22_1_5_3	0.0	80	21324	17059	9068	13.87	1.0E-04	0.91977	0.00125	0.92228	hcf4bmt12_22_1_5_3	0.88238	0.00140	0.88519
ncf3bmt11_21_1_5_3	0.0	80	20397	16317	9117	14.58	1.0E-04	0.91607	0.00134	0.91876	hcf4bmt12_21_1_5_3	0.87917	0.00128	0.88173
ncf3bmt11_20_1_5_3	0.0	80	19470	15576	9166	15.36	1.0E-04	0.91812	0.00123	0.92059	hcf4bmt12_20_1_5_3	0.87731	0.00132	0.87995
ncf3bmt11_36_1_4_3	0.0	70	35275	24693	8332	8.81	1.0E-04	0.93179	0.00144	0.93467	hcf4bmt12_36_1_4_3	0.89390	0.00117	0.89625
ncf3bmt11_35_1_4_3	0.0	70	34347	24043	8381	9.10	1.0E-04	0.92998	0.00125	0.93248	hcf4bmt12_35_1_4_3	0.89164	0.00140	0.89444
ncf3bmt11_34_1_4_3	0.0	70	33419	23393	8430	9.41	1.0E-04	0.92792	0.00128	0.93049	hcf4bmt12_34_1_4_3	0.88829	0.00123	0.89075
ncf3bmt11_33_1_4_3	0.0	70	32490	22743	8479	9.73	1.0E-04	0.92421	0.00134	0.92690	hcf4bmt12_33_1_4_3	0.88600	0.00117	0.88834
ncf3bmt11_32_1_4_3	0.0	70	31562	22093	8529	10.08	1.0E-04	0.92329	0.00131	0.92591	hcf4bmt12_32_1_4_3	0.88581	0.00140	0.88861
ncf3bmt11_31_1_4_3	0.0	70	30634	21444	8578	10.44	1.0E-04	0.91896	0.00132	0.92160	hcf4bmt12_31_1_4_3	0.88314	0.00132	0.88577
ncf3bmt11_36_1_3_3	0.0	60	35320	21192	8332	10.26	1.0E-04	0.90201	0.00123	0.90447	hcf4bmt12_36_1_3_3	0.86792	0.00130	0.87053
ncf3bmt11_35_1_3_3	0.0	60	34391	20634	8381	10.60	1.0E-04	0.90103	0.00130	0.90363	hcf4bmt12_35_1_3_3	0.86477	0.00150	0.86777
ncf3bmt11_34_1_3_3	0.0	60	33461	20077	8430	10.96	1.0E-04	0.89984	0.00147	0.90278	hcf4bmt12_34_1_3_3	0.86396	0.00137	0.86670
ncf3bmt11_33_1_3_3	0.0	60	32532	19519	8479	11.34	1.0E-04	0.89745	0.00130	0.90004	hcf4bmt12_33_1_3_3	0.86136	0.00134	0.86404
ncf3bmt11_32_1_3_3	0.0	60	31602	18961	8529	11.74	1.0E-04	0.89310	0.00137	0.89585	hcf4bmt12_32_1_3_3	0.86115	0.00124	0.86362
ncf3bmt11_31_1_3_3	0.0	60	30673	18404	8578	12.17	1.0E-04	0.89440	0.00135	0.89711	hcf4bmt12_31_1_3_3	0.85909	0.00151	0.86212
with can spacers (np thickness = 1.4 in.)														
ncf3bmt11_19_2_8_3	1.4	100	18496	18496	8602	12.14	1.0E-04	0.93577	0.00135	0.93847	hcf4bmt12_19_2_8_3	0.89811	0.00149	0.90110
ncf3bmt11_18_2_8_3	1.4	100	17571	17571	8651	12.85	1.0E-04	0.93186	0.00154	0.93494	hcf4bmt12_18_2_8_3	0.89794	0.00151	0.90096
ncf3bmt11_17_2_8_3	1.4	100	16646	16646	8700	13.64	1.0E-04	0.92731	0.00135	0.93002	hcf4bmt12_17_2_8_3	0.89377	0.00134	0.89644
ncf3bmt11_16_2_8_3	1.4	100	15721	15721	8749	14.53	1.0E-04	0.92992	0.00126	0.93244	hcf4bmt12_16_2_8_3	0.89138	0.00121	0.89379
ncf3bmt11_15_2_8_3	1.4	100	14796	14796	8798	15.52	1.0E-04	0.92597	0.00134	0.92865	hcf4bmt12_15_2_8_3	0.89085	0.00130	0.89345

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncf3bmt11_14_2_8_3	1.4	100	13872	13872	8847	16.65	1.0E-04	0.91788	0.00124	0.92037	hcf4bmt12_14_2_8_3	0.88486	0.00143	0.88772
ncf3bmt11_13_2_8_3	1.4	100	12947	12947	8896	17.94	1.0E-04	0.91410	0.00116	0.91642	hcf4bmt12_13_2_8_3	0.88161	0.00147	0.88454
ncf3bmt11_12_2_8_3	1.4	100	11097	11097	8995	21.16	1.0E-04	0.90586	0.00164	0.90915	hcf4bmt12_12_2_8_3	0.87451	0.00129	0.87708
ncf3bmt11_11_2_8_3	1.4	100	10173	10173	9044	23.20	1.0E-04	0.90034	0.00144	0.90322	hcf4bmt12_11_2_8_3	0.86789	0.00129	0.87047
ncf3bmt11_24_2_7_3	1.4	95	23134	21977	8357	9.92	1.0E-04	0.93439	0.00143	0.93724	hcf4bmt12_24_2_7_3	0.89896	0.00122	0.90141
ncf3bmt11_23_2_7_3	1.4	95	22209	21098	8406	10.40	1.0E-04	0.93453	0.00131	0.93716	hcf4bmt12_23_2_7_3	0.89761	0.00131	0.90024
ncf3bmt11_22_2_7_3	1.4	95	21283	20219	8455	10.91	1.0E-04	0.92992	0.00130	0.93252	hcf4bmt12_22_2_7_3	0.89290	0.00142	0.89574
ncf3bmt11_21_2_7_3	1.4	95	20358	19340	8504	11.48	1.0E-04	0.92588	0.00136	0.92860	hcf4bmt12_21_2_7_3	0.89171	0.00135	0.89441
ncf3bmt11_20_2_7_3	1.4	95	19433	18461	8553	12.09	1.0E-04	0.92140	0.00126	0.92392	hcf4bmt12_20_2_7_3	0.88860	0.00138	0.89135
ncf3bmt11_19_2_7_3	1.4	95	18507	17582	8602	12.77	1.0E-04	0.91794	0.00128	0.92049	hcf4bmt12_19_2_7_3	0.88544	0.00131	0.88806
ncf3bmt11_18_2_7_3	1.4	95	17582	16703	8651	13.52	1.0E-04	0.91432	0.00143	0.91717	hcf4bmt12_18_2_7_3	0.87916	0.00119	0.88154
ncf3bmt11_28_2_6_3	1.4	90	27778	25001	8111	8.47	1.0E-04	0.93537	0.00113	0.93763	hcf4bmt12_28_2_6_3	0.89885	0.00127	0.90138
ncf3bmt11_27_2_6_3	1.4	90	26852	24167	8160	8.81	1.0E-04	0.93322	0.00129	0.93581	hcf4bmt12_27_2_6_3	0.89628	0.00137	0.89902
ncf3bmt11_26_2_6_3	1.4	90	25927	23334	8209	9.18	1.0E-04	0.92880	0.00119	0.93117	hcf4bmt12_26_2_6_3	0.89189	0.00127	0.89443
ncf3bmt11_25_2_6_3	1.4	90	24075	21667	8308	10.01	1.0E-04	0.92446	0.00149	0.92745	hcf4bmt12_25_2_6_3	0.88877	0.00144	0.89165
ncf3bmt11_24_2_6_3	1.4	90	23149	20834	8357	10.47	1.0E-04	0.92270	0.00138	0.92547	hcf4bmt12_24_2_6_3	0.88731	0.00129	0.88990
ncf3bmt11_23_2_6_3	1.4	90	22223	20000	8406	10.97	1.0E-04	0.91857	0.00138	0.92133	hcf4bmt12_23_2_6_3	0.88245	0.00133	0.88512
ncf3bmt11_22_2_6_3	1.4	90	21297	19167	8455	11.51	1.0E-04	0.91639	0.00145	0.91929	hcf4bmt12_22_2_6_3	0.87838	0.00119	0.88076
ncf3bmt11_34_2_5_3	1.4	80	33376	26701	7817	7.64	1.0E-04	0.92540	0.00127	0.92795	hcf4bmt12_34_2_5_3	0.88608	0.00131	0.88869
ncf3bmt11_33_2_5_3	1.4	80	32449	25959	7866	7.91	1.0E-04	0.92436	0.00140	0.92716	hcf4bmt12_33_2_5_3	0.88749	0.00156	0.89061
ncf3bmt11_32_2_5_3	1.4	80	31522	25218	7915	8.19	1.0E-04	0.91919	0.00120	0.92159	hcf4bmt12_32_2_5_3	0.88581	0.00130	0.88841

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncf3bmt11_31_2_5_3	1.4	80	30595	24476	7964	8.49	1.0E-04	0.91747	0.00126	0.92000	hcf4bmt12_31_2_5_3	0.88299	0.00141	0.88582
ncf3bmt11_36_2_4_3	1.4	70	35275	24693	7719	8.16	1.0E-04	0.90114	0.00120	0.90353	hcf4bmt12_36_2_4_3	0.86624	0.00106	0.86835
ncf3bmt11_35_2_4_3	1.4	70	34347	24043	7768	8.43	1.0E-04	0.89908	0.00131	0.90169	hcf4bmt12_35_2_4_3	0.86262	0.00143	0.86549
ncf3bmt11_34_2_4_3	1.4	70	33419	23393	7817	8.72	1.0E-04	0.89841	0.00115	0.90070	hcf4bmt12_34_2_4_3	0.86008	0.00129	0.86265
ncf3bmt11_36_2_3_3	1.4	60	35320	21192	7719	9.51	1.0E-04	0.87206	0.00120	0.87446	hcf4bmt12_36_2_3_3	0.83873	0.00122	0.84116
ncf3bmt11_35_2_3_3	1.4	60	34391	20634	7768	9.83	1.0E-04	0.86988	0.00123	0.87235	hcf4bmt12_35_2_3_3	0.83470	0.00130	0.83731
ncf3bmt11_34_2_3_3	1.4	60	33461	20077	7817	10.16	1.0E-04	0.86818	0.00130	0.87078	hcf4bmt12_34_2_3_3	0.83204	0.00117	0.83439
content in flooded containment vessel, array packaging model for CSI=3.1														
NCT											**HAC**			
no can spacers (np thickness = 0.0 in.)														
nctf5bmt11_36_1_5_3	0.0	80	35231	28184	8332	7.72	1.0E-04	0.92519	0.00130	0.92779	hctf5bmt12_36_1_5_3	0.90361	0.00119	0.90600
nctf5bmt11_35_1_5_3	0.0	80	34303	27443	8381	7.97	1.0E-04	0.91980	0.00138	0.92255	hctf5bmt12_35_1_5_3	0.90246	0.00137	0.90520
nctf5bmt11_34_1_5_3	0.0	80	33376	26701	8430	8.24	1.0E-04	0.92113	0.00138	0.92389	hctf5bmt12_34_1_5_3	0.89974	0.00136	0.90246
nctf5bmt11_33_1_5_3	0.0	80	32449	25959	8479	8.53	1.0E-04	0.91846	0.00117	0.92079	hctf5bmt12_33_1_5_3	0.89587	0.00129	0.89845
nctf5bmt11_32_1_5_3	0.0	80	31522	25218	8529	8.83	1.0E-04	0.91556	0.00119	0.91795	hctf5bmt12_32_1_5_3	0.89459	0.00148	0.89755
nctf5bmt11_36_1_4_3	0.0	70	35275	24693	8332	8.81	1.0E-04	0.90020	0.00139	0.90299	hctf5bmt12_36_1_4_3	0.87905	0.00142	0.88188
nctf5bmt11_35_1_4_3	0.0	70	34347	24043	8381	9.10	1.0E-04	0.89748	0.00118	0.89984	hctf5bmt12_35_1_4_3	0.87388	0.00126	0.87639
nctf5bmt11_34_1_4_3	0.0	70	33419	23393	8430	9.41	1.0E-04	0.89206	0.00115	0.89437	hctf5bmt12_34_1_4_3	0.87550	0.00150	0.87851
nctf5bmt11_36_1_3_3	0.0	60	35320	21192	8332	10.26	1.0E-04	0.87170	0.00131	0.87433	hctf5bmt12_36_1_3_3	0.85181	0.00121	0.85423
nctf5bmt11_35_1_3_3	0.0	60	34391	20634	8381	10.60	1.0E-04	0.87122	0.00146	0.87414	hctf5bmt12_35_1_3_3	0.85100	0.00135	0.85369

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nctf5bmt11_26_2_8_3	1.4	100	25894	25894	8209	8.28	1.0E-04	0.92880	0.00114	0.93108	hctf5bmt12_26_2_8_3	0.90779	0.00115	0.91009
nctf5bmt11_25_2_8_3	1.4	100	24969	24969	8258	8.63	1.0E-04	0.92250	0.00118	0.92485	hctf5bmt12_25_2_8_3	0.90619	0.00136	0.90890
nctf5bmt11_24_2_8_3	1.4	100	23119	23119	8357	9.43	1.0E-04	0.92133	0.00137	0.92406	hctf5bmt12_24_2_8_3	0.90163	0.00125	0.90413
nctf5bmt11_23_2_8_3	1.4	100	22195	22195	8406	9.89	1.0E-04	0.92154	0.00124	0.92401	hctf5bmt12_23_2_8_3	0.90028	0.00150	0.90329
nctf5bmt11_22_2_8_3	1.4	100	21270	21270	8455	10.38	1.0E-04	0.91455	0.00141	0.91737	hctf5bmt12_22_2_8_3	0.89693	0.00148	0.89990
nctf5bmt11_21_2_8_3	1.4	100	20345	20345	8504	10.91	1.0E-04	0.91027	0.00140	0.91306	hctf5bmt12_21_2_8_3	0.89420	0.00140	0.89700
nctf5bmt11_30_2_7_3	1.4	95	29612	28131	8013	7.43	1.0E-04	0.92409	0.00126	0.92660	hctf5bmt12_30_2_7_3	0.90413	0.00129	0.90670
nctf5bmt11_29_2_7_3	1.4	95	28686	27252	8062	7.72	1.0E-04	0.92175	0.00160	0.92495	hctf5bmt12_29_2_7_3	0.90149	0.00125	0.90400
nctf5bmt11_28_2_7_3	1.4	95	27761	26373	8111	8.03	1.0E-04	0.91662	0.00149	0.91960	hctf5bmt12_28_2_7_3	0.89554	0.00127	0.89809
nctf5bmt11_27_2_7_3	1.4	95	26835	25494	8160	8.35	1.0E-04	0.91290	0.00112	0.91515	hctf5bmt12_27_2_7_3	0.89349	0.00120	0.89588
nctf5bmt11_26_2_7_3	1.4	95	25910	24615	8209	8.71	1.0E-04	0.90934	0.00124	0.91182	hctf5bmt12_26_2_7_3	0.88954	0.00116	0.89187
nctf5bmt11_25_2_7_3	1.4	95	24985	23736	8258	9.08	1.0E-04	0.90900	0.00116	0.91131	hctf5bmt12_25_2_7_3	0.88811	0.00120	0.89051
nctf5bmt11_24_2_7_3	1.4	95	23134	21977	8357	9.92	1.0E-04	0.90460	0.00146	0.90752	hctf5bmt12_24_2_7_3	0.88850	0.00132	0.89113
nctf5bmt11_35_2_6_3	1.4	90	34260	30834	7768	6.58	1.0E-04	0.92200	0.00132	0.92464	hctf5bmt12_35_2_6_3	0.90072	0.00123	0.90318
nctf5bmt11_34_2_6_3	1.4	90	33334	30001	7817	6.80	1.0E-04	0.91799	0.00130	0.92059	hctf5bmt12_34_2_6_3	0.89921	0.00112	0.90145
nctf5bmt11_33_2_6_3	1.4	90	32408	29167	7866	7.04	1.0E-04	0.91789	0.00136	0.92061	hctf5bmt12_33_2_6_3	0.89931	0.00137	0.90206
nctf5bmt11_32_2_6_3	1.4	90	31482	28334	7915	7.29	1.0E-04	0.91514	0.00113	0.91740	hctf5bmt12_32_2_6_3	0.89395	0.00118	0.89631
nctf5bmt11_36_2_5_3	1.4	80	35231	28184	7719	7.15	1.0E-04	0.89457	0.00141	0.89739	hctf5bmt12_36_2_5_3	0.87726	0.00158	0.88041
nctf5bmt11_35_2_5_3	1.4	80	34303	27443	7768	7.39	1.0E-04	0.89528	0.00129	0.89787	hctf5bmt12_35_2_5_3	0.87420	0.00120	0.87660
nctf5bmt11_34_2_5_3	1.4	80	33376	26701	7817	7.64	1.0E-04	0.89346	0.00115	0.89576	hctf5bmt12_34_2_5_3	0.87530	0.00122	0.87775

Table 6.9.6-11. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nctf5bmt11_36_2_4_3	1.4	70	35275	24693	7719	8.16	1.0E-04	0.87119	0.00121	0.87361	hctf5bmt12_36_2_4_3	0.85030	0.00147	0.85323
nctf5bmt11_35_2_4_3	1.4	70	34347	24043	7768	8.43	1.0E-04	0.86740	0.00110	0.86959	hctf5bmt12_35_2_4_3	0.84958	0.00107	0.85173
nctf5bmt11_36_2_3_3	1.4	60	35320	21192	7719	9.51	1.0E-04	0.84212	0.00121	0.84454	hctf5bmt12_36_2_3_3	0.82413	0.00117	0.82647
nctf5bmt11_35_2_3_3	1.4	60	34391	20634	7768	9.83	1.0E-04	0.83953	0.00135	0.84223	hctf5bmt12_35_2_3_3	0.82142	0.00125	0.82393

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded containment vessel, single package reflected														
NCT											**HAC**			
no can spacers (np thickness = 0.0 in.), [USL=0.93520]														
ncsrbmt11p_1_6_15	0.0	100	26.00	26.00	8.275	8.95	1.0E+00	0.86670	0.00085	0.86840	hcsrbmt11p_1_6_15	0.86790	0.00067	0.86924
ncsrbmt11p_2_6_15	0.0	100	28.00	28.00	8.169	8.21	1.0E+00	0.87211	0.00072	0.87355	hcsrbmt11p_2_6_15	0.87229	0.00071	0.87371
ncsrbmt11p_3_6_15	0.0	100	30.00	30.00	8.063	7.57	1.0E+00	0.87493	0.00071	0.87635	hcsrbmt11p_3_6_15	0.87748	0.00072	0.87892
ncsrbmt11p_4_6_15	0.0	100	32.00	32.00	7.956	7.01	1.0E+00	0.88123	0.00076	0.88275	hcsrbmt11p_4_6_15	0.88224	0.00077	0.88378
ncsrbmt11p_5_6_15	0.0	100	33.00	33.00	7.903	6.76	1.0E+00	0.88251	0.00073	0.88397	hcsrbmt11p_5_6_15	0.88502	0.00086	0.88674
ncsrbmt11p_6_6_15	0.0	100	34.00	34.00	7.850	6.52	1.0E+00	0.88625	0.00069	0.88763	hcsrbmt11p_6_6_15	0.88598	0.00064	0.88726
ncsrbmt11p_7_6_15	0.0	100	35.00	35.00	7.797	6.29	1.0E+00	0.88820	0.00063	0.88946	hcsrbmt11p_7_6_15	0.88923	0.00078	0.89079
ncsrbmt11p_8_6_15	0.0	100	36.00	36.00	7.744	6.08	1.0E+00	0.89098	0.00072	0.89242	hcsrbmt11p_8_6_15	0.89242	0.00070	0.89382

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded containment vessel, array packaging model for CSI=0.0														
NCT											**HAC**			
no can spacers (np thickness = 0.0 in.), [USL=0.93680]														
nciabmt11p_1_1_6_3	0.0	100	1.0	1.000	9.601	267.57	1.0E-04	0.79370	0.00074	0.79518				
nciabmt11p_2_1_6_3	0.0	100	2.0	2.000	9.548	132.96	1.0E-04	0.90211	0.00086	0.90383				
nciabmt11p_3_1_6_3	0.0	100	2.4	2.400	9.527	110.59	1.0E-04	0.92408	0.00075	0.92558				
nciabmt11p_4_1_6_3	0.0	100	2.5	2.500	9.522	106.12	1.0E-04	0.93024	0.00071	0.93166				
nciabmt11p_5_1_6_3	0.0	100	2.6	2.600	9.517	101.98	1.0E-04	0.93264	0.00081	0.93426	hciabmt12p_5_1_6_3	0.93291	0.00078	0.93447
nciabmt11p_6_1_6_3	0.0	100	2.7	2.700	9.511	98.16	1.0E-04	0.93592	0.00074	0.93740	hciabmt12p_6_1_6_3	0.93811	0.00076	0.93963
nciabmt11p_2_1_5_3	0.0	95.0	2.0	1.900	9.548	140.00	1.0E-04	0.89163	0.00084	0.89331				
nciabmt11p_4_1_5_3	0.0	95.0	2.5	2.375	9.522	111.72	1.0E-04	0.91599	0.00077	0.91753				
nciabmt11p_6_1_5_3	0.0	95.0	2.7	2.565	9.511	103.33	1.0E-04	0.92611	0.00075	0.92761				
nciabmt11p_7_1_5_3	0.0	95.0	2.8	2.660	9.506	99.59	1.0E-04	0.92982	0.00082	0.93146				
nciabmt11p_8_1_5_3	0.0	95.0	2.9	2.755	9.501	96.11	1.0E-04	0.93326	0.00069	0.93464	hciabmt12p_8_1_5_3	0.93429	0.00070	0.93569
nciabmt11p_9_1_5_3	0.0	95.0	3.0	2.850	9.495	92.85	1.0E-04	0.93830	0.00065	0.93960	hciabmt12p_9_1_5_3	0.93820	0.00094	0.94008
nciabmt11p_2_1_4_3	0.0	90.0	2.0	1.800	9.549	147.84	1.0E-04	0.88088	0.00080	0.88248				
nciabmt11p_8_1_4_3	0.0	90.0	2.9	2.610	9.501	101.45	1.0E-04	0.92411	0.00079	0.92569				
nciabmt11p_9_1_4_3	0.0	90.0	3.0	2.700	9.496	98.01	1.0E-04	0.92884	0.00077	0.93038				
nciabmt11p_10_1_4_3	0.0	90.0	3.1	2.790	9.490	94.80	1.0E-04	0.93063	0.00067	0.93197				
nciabmt11p_11_1_4_3	0.0	90.0	3.2	2.880	9.485	91.78	1.0E-04	0.93401	0.00074	0.93549	hciabmt12p_11_1_4_3	0.93446	0.00074	0.93594
nciabmt11p_12_1_4_3	0.0	90.0	3.3	2.970	9.480	88.96	1.0E-04	0.93742	0.00076	0.93894	hciabmt12p_12_1_4_3	0.93753	0.00081	0.93915

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciabmt11p_9_1_3_3	0.0	80.0	3.0	2.400	9.496	110.27	1.0E-04	0.90654	0.00093	0.90840				
nciabmt11p_15_1_3_3	0.0	80.0	3.7	2.960	9.459	89.05	1.0E-04	0.92709	0.00067	0.92843				
nciabmt11p_16_1_3_3	0.0	80.0	3.8	3.040	9.453	86.66	1.0E-04	0.93059	0.00070	0.93199				
nciabmt11p_17_1_3_3	0.0	80.0	3.9	3.120	9.448	84.43	1.0E-04	0.93307	0.00075	0.93457				
nciabmt11p_18_1_3_3	0.0	80.0	4.0	3.200	9.443	82.27	1.0E-04	0.93356	0.00067	0.93490	hciabmt12p_18_1_3_3	0.93452	0.00080	0.93612
nciabmt11p_19_1_3_3	0.0	80.0	4.1	3.280	9.438	80.22	1.0E-04	0.93674	0.00072	0.93818	hciabmt12p_19_1_3_3	0.93716	0.00073	0.93862
nciabmt11p_18_1_2_3	0.0	70.0	4.0	2.800	9.443	94.00	1.0E-04	0.91338	0.00081	0.91500				
nciabmt11p_26_1_2_3	0.0	70.0	5.0	3.500	9.390	74.82	1.0E-04	0.93244	0.00076	0.93396				
nciabmt11p_27_1_2_3	0.0	70.0	5.1	3.570	9.385	73.31	1.0E-04	0.93247	0.00065	0.93377	hciabmt12p_27_1_2_3	0.93466	0.00068	0.93602
nciabmt11p_28_1_2_3	0.0	70.0	5.2	3.640	9.380	71.87	1.0E-04	0.93481	0.00064	0.93609	hciabmt12p_28_1_2_3	0.93645	0.00068	0.93781
nciabmt11p_29_1_2_3	0.0	70.0	5.3	3.710	9.374	70.47	1.0E-04	0.93519	0.00068	0.93655	hciabmt12p_29_1_2_3	0.93720	0.00081	0.93882
nciabmt11p_30_1_2_3	0.0	70.0	5.4	3.780	9.369	69.13	1.0E-04	0.93733	0.00075	0.93883	hciabmt12p_30_1_2_3	0.93869	0.00067	0.94003
nciabmt11p_31_1_1_3	0.0	60.0	6.0	3.600	9.338	72.36	1.0E-04	0.92363	0.00074	0.92511				
nciabmt11p_36_1_1_3	0.0	60.0	6.9	4.140	9.290	62.61	1.0E-04	0.93302	0.00065	0.93432				
nciabmt11p_37_1_1_3	0.0	60.0	7.0	4.200	9.285	61.70	1.0E-04	0.93364	0.00067	0.93498				
nciabmt11p_38_1_1_3	0.0	60.0	7.1	4.260	9.280	60.79	1.0E-04	0.93470	0.00070	0.93610				
nciabmt11p_39_1_1_3	0.0	60.0	7.2	4.320	9.274	59.91	1.0E-04	0.93473	0.00078	0.93629	hciabmt12p_39_1_1_3	0.93484	0.00082	0.93648
nciabmt11p_40_1_1_3	0.0	60.0	7.3	4.380	9.269	59.06	1.0E-04	0.93690	0.00068	0.93826	hciabmt12p_40_1_1_3	0.93649	0.00070	0.93789
with can spacers (np thickness = 1.4 in.) [USL=0.93680 for 100% to 80% enriched; USL=0.93520 for 70% to 60% enriched]														
nciabmt11p_2_2_6_3	1.4	100	2.0	2.000	8.935	125.03	1.0E-04	0.87031	0.00090	0.87211				
nciabmt11p_9_2_6_3	1.4	100	3.0	3.000	8.882	82.87	1.0E-04	0.91590	0.00075	0.91740				
nciabmt11p_13_2_6_3	1.4	100	3.5	3.500	8.855	70.83	1.0E-04	0.93058	0.00069	0.93196				

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciabmt11p_14_2_6_3	1.4	100	3.6	3.600	8.850	68.83	1.0E-04	0.93403	0.00082	0.93567	hciabmt12p_14_2_6_3	0.93421	0.00075	0.93571
nciabmt11p_15_2_6_3	1.4	100	3.7	3.700	8.845	66.91	1.0E-04	0.93438	0.00070	0.93578	hciabmt12p_15_2_6_3	0.93613	0.00075	0.93763
nciabmt11p_16_2_6_3	1.4	100	3.8	3.800	8.839	65.13	1.0E-04	0.93822	0.00080	0.93982	hciabmt12p_16_2_6_3	0.93898	0.00097	0.94092
nciabmt11p_9_2_5_3	1.4	95	3.0	2.850	8.882	87.23	1.0E-04	0.90670	0.00076	0.90822				
nciabmt11p_16_2_5_3	1.4	95	3.8	3.610	8.855	65.55	1.0E-04	0.92834	0.00088	0.93010				
nciabmt11p_17_2_5_3	1.4	95	3.9	3.705	8.834	66.76	1.0E-04	0.92922	0.00075	0.93072				
nciabmt11p_18_2_5_3	1.4	95	4.0	3.800	8.829	65.07	1.0E-04	0.93137	0.00078	0.93293	hciabmt12p_18_2_5_3	0.93284	0.00071	0.93426
nciabmt11p_19_2_5_3	1.4	95	4.1	3.895	8.824	63.43	1.0E-04	0.93404	0.00080	0.93564	hciabmt12p_19_2_5_3	0.93476	0.00087	0.93650
nciabmt11p_20_2_5_3	1.4	95	4.2	3.990	8.818	61.89	1.0E-04	0.93550	0.00082	0.93714	hciabmt12p_20_2_5_3	0.93836	0.00076	0.93988
nciabmt11p_18_2_4_3	1.4	90	4.0	3.600	8.829	68.67	1.0E-04	0.92144	0.00073	0.92290				
nciabmt11p_21_2_4_3	1.4	90	4.5	4.050	8.802	60.86	1.0E-04	0.93062	0.00081	0.93224				
nciabmt11p_22_2_4_3	1.4	90	4.6	4.140	8.797	59.51	1.0E-04	0.93097	0.00068	0.93233	hciabmt12p_22_2_4_3	0.93408	0.00073	0.93554
nciabmt11p_23_2_4_3	1.4	90	4.7	4.230	8.792	58.22	1.0E-04	0.93337	0.00084	0.93505	hciabmt12p_23_2_4_3	0.93566	0.00086	0.93738
nciabmt11p_24_2_4_3	1.4	90	4.8	4.320	8.787	56.98	1.0E-04	0.93475	0.00074	0.93623	hciabmt12p_24_2_4_3	0.93566	0.00070	0.93706
nciabmt11p_25_2_4_3	1.4	90	4.9	4.410	8.781	55.77	1.0E-04	0.93725	0.00080	0.93885	hciabmt12p_25_2_4_3	0.93923	0.00077	0.94077
nciabmt11p_26_2_3_3	1.4	80	5.0	4.000	8.776	61.45	1.0E-04	0.91900	0.00100	0.92100				
nciabmt11p_31_2_3_3	1.4	80	6.0	4.800	8.723	50.92	1.0E-04	0.93146	0.00071	0.93288				
nciabmt11p_32_2_3_3	1.4	80	6.1	4.880	8.718	50.07	1.0E-04	0.93095	0.00069	0.93233[b]	hciabmt12p_32_2_3_3	0.93423	0.00075	0.93573
nciabmt11p_33_2_3_3	1.4	80	6.2	4.960	8.713	49.23	1.0E-04	0.93409	0.00076	0.93561	hciabmt12p_33_2_3_3	0.93581	0.00080	0.93741
nciabmt11p_34_2_3_3	1.4	80	6.3	5.040	8.707	48.41	1.0E-04	0.93501	0.00078	0.93657	hciabmt12p_34_2_3_3	0.93648	0.00077	0.93802
nciabmt11p_35_2_3_3	1.4	80	6.4	5.120	8.702	47.63	1.0E-04	0.93596	0.00068	0.93732	hciabmt12p_35_2_3_3	0.93789	0.00071	0.93931

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciabmt11p_41_2_2_3	1.4	70	8.0	5.600	8.618	43.16	1.0E-04	0.93064	0.00071	0.93206				
nciabmt11p_42_2_2_3	1.4	70	9.0	6.300	8.565	38.14	1.0E-04	0.93176	0.00071	0.93318				
nciabmt11p_43_2_2_3	1.4	70	9.2	6.440	8.555	37.27	1.0E-04	0.93191	0.00072	0.93335				
nciabmt11p_44_2_2_3	1.4	70	9.3	6.510	8.549	36.85	1.0E-04	0.93284	0.00068	0.93420				
nciabmt11p_45_2_2_3	1.4	70	9.4	6.580	8.544	36.44	1.0E-04	0.93165	0.00076	0.93317	nciabmt11p_45_2_2_3	0.93288	0.00075	0.93438
nciabmt11p_46_2_2_3	1.4	70	9.5	6.650	8.539	36.04	1.0E-04	0.93433	0.00072	0.93577	nciabmt11p_46_2_2_3	0.93375	0.00070	0.93515
nciabmt11p_50_2_1_3	1.4	60	13.0	7.800	8.355	30.11	1.0E-04	0.92910	0.00078	0.93066				
nciabmt11p_51_2_1_3	1.4	60	14.0	8.400	8.302	27.79	1.0E-04	0.93244	0.00069	0.93382				
nciabmt11p_52_2_1_3	1.4	60	14.1	8.460	8.297	27.58	1.0E-04	0.93232	0.00068	0.93368	hciabmt12p_52_2_1_3	0.93362	0.00070	0.93502
nciabmt11p_53_2_1_3	1.4	60	14.2	8.520	8.291	27.37	1.0E-04	0.93287	0.00074	0.93435	hciabmt12p_53_2_1_3	0.93421	0.00074	0.93569
nciabmt11p_54_2_1_3	1.4	60	14.3	8.580	8.286	27.16	1.0E-04	0.93332	0.00075	0.93482	hciabmt12p_54_2_1_3	0.93451	0.00074	0.93599
nciabmt11p_55_2_1_3	1.4	60	14.4	8.640	8.281	26.96	1.0E-04	0.93358	0.00080	0.93518	hciabmt12p_55_2_1_3	0.93426	0.00070	0.93566
nciabmt11p_56_2_1_3	1.4	60	14.5	8.700	8.275	26.75	1.0E-04	0.93434	0.00073	0.93580	hciabmt12p_56_2_1_3	0.93592	0.00074	0.93740
content in flooded containment vessel, array packaging model for CSI=0.4														
NCT											**HAC**			
no can spacers (np thickness = 0.0 in.) [USL=0.93680 for 100% to 90% enriched; USL=0.93520 for 80% to 60% enriched]														
ncf1bmt11p_1_1_6_3	0.0	100.0	2.0	2.000	9.548	132.96	1.0E-04	0.86477	0.00076	0.86629				
ncf1bmt11p_2_1_6_3	0.0	100.0	3.0	3.000	9.495	92.85	1.0E-04	0.90921	0.00072	0.91065				
ncf1bmt11p_3_1_6_3	0.0	100.0	3.8	3.800	9.453	69.36	1.0E-04	0.92831	0.00082	0.92995				
ncf1bmt11p_4_1_6_3	0.0	100.0	3.9	3.900	9.448	67.51	1.0E-04	0.93232	0.00077	0.93386				
ncf1bmt11p_5_1_6_3	0.0	100.0	4.0	4.000	9.442	65.79	1.0E-04	0.93470	0.00094	0.93658	hcf2bmt12p_5_1_6_3	0.90997	0.00077	0.91151
ncf1bmt11p_6_1_6_3	0.0	100.0	4.1	4.100	9.437	64.15	1.0E-04	0.93546	0.00081	0.93708	hcf2bmt12p_6_1_6_3	0.91325	0.00075	0.91475

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncf1bmt11p_2_1_5_3	0.0	95.0	3.0	2.850	9.495	92.85	1.0E-04	0.89934	0.00075	0.90084				
ncf1bmt11p_5_1_5_3	0.0	95.0	4.0	3.800	9.442	69.28	1.0E-04	0.92264	0.00085	0.92434				
ncf1bmt11p_7_1_5_3	0.0	95.0	4.4	4.180	9.421	62.85	1.0E-04	0.92573	0.00088	0.92749				
ncf1bmt11p_8_1_5_3	0.0	95.0	4.5	4.275	9.416	61.42	1.0E-04	0.93176	0.00084	0.93344				
ncf1bmt11p_9_1_5_3	0.0	95.0	4.6	4.370	9.411	60.05	1.0E-04	0.93504	0.00072	0.93648	hcf2bmt12p_9_1_5_3	0.91000	0.00075	0.91150
ncf1bmt11p_10_1_5_3	0.0	95.0	4.7	4.465	9.405	58.74	1.0E-04	0.93748	0.00074	0.93896	hcf2bmt12p_10_1_5_3	0.91206	0.00086	0.91378
ncf1bmt11p_5_1_4_3	0.0	90.0	4.0	3.600	9.443	73.11	1.0E-04	0.91399	0.00072	0.91543				
ncf1bmt11p_12_1_4_3	0.0	90.0	5.1	4.590	9.384	57.01	1.0E-04	0.93106	0.00080	0.93266				
ncf1bmt11p_13_1_4_3	0.0	90.0	5.2	4.680	9.379	55.88	1.0E-04	0.93235	0.00081	0.93397				
ncf1bmt11p_14_1_4_3	0.0	90.0	5.3	4.770	9.374	54.80	1.0E-04	0.93306	0.00074	0.93454				
ncf1bmt11p_15_1_4_3	0.0	90.0	5.4	4.860	9.368	53.75	1.0E-04	0.93423	0.00077	0.93577	hcf2bmt12p_15_1_4_3	0.91172	0.00079	0.91330
ncf1bmt11p_16_1_4_3	0.0	90.0	5.5	4.950	9.363	52.75	1.0E-04	0.93628	0.00070	0.93768	hcf2bmt12p_16_1_4_3	0.91100	0.00110	0.91320
ncf1bmt11p_20_1_3_3	0.0	80.0	6.0	4.800	9.337	54.27	1.0E-04	0.92338	0.00070	0.92478				
ncf1bmt11p_21_1_3_3	0.0	80.0	7.0	5.600	9.284	46.26	1.0E-04	0.93180	0.00100	0.93380				
ncf1bmt11p_22_1_3_3	0.0	80.0	7.1	5.680	9.279	45.59	1.0E-04	0.93186	0.00073	0.93332				
ncf1bmt11p_23_1_3_3	0.0	80.0	7.2	5.760	9.273	44.96	1.0E-04	0.93208	0.00089	0.93386				
ncf1bmt11p_24_1_3_3	0.0	80.0	7.3	5.840	9.268	44.30	1.0E-04	0.93242	0.00072	0.93386	hcf2bmt12p_24_1_3_3	0.91219	0.00072	0.91363
ncf1bmt11p_25_1_3_3	0.0	80.0	7.4	5.920	9.263	43.67	1.0E-04	0.93421	0.00087	0.93595	hcf2bmt12p_25_1_3_3	0.91316	0.00080	0.91476
ncf1bmt11p_27_1_2_3	0.0	70.0	9.0	6.300	9.179	40.69	1.0E-04	0.92551	0.00074	0.92699				
ncf1bmt11p_32_1_2_3	0.0	70.0	10.0	7.000	9.126	36.42	1.0E-04	0.93079	0.00075	0.93229				

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncf1bmt11p_33_1_2_3	0.0	70.0	10.3	7.210	9.110	35.30	1.0E-04	0.93326	0.00078	0.93482				
ncf1bmt11p_34_1_2_3	0.0	70.0	10.4	7.280	9.105	34.94	1.0E-04	0.93139	0.00076	0.93291				
ncf1bmt11p_35_1_2_3	0.0	70.0	10.5	7.350	9.099	34.60	1.0E-04	0.93351	0.00073	0.93497	hcf2bmt12p_35_1_2_3	0.90829	0.00078	0.90985
ncf1bmt11p_36_1_2_3	0.0	70.0	10.6	7.420	9.094	34.25	1.0E-04	0.93395	0.00075	0.93545	hcf2bmt12p_36_1_2_3	0.91085	0.00071	0.91227
ncf1bmt11p_46_1_1_3	0.0	60.0	16.0	9.600	8.810	25.70	1.0E-04	0.93129	0.00071	0.93271				
ncf1bmt11p_47_1_1_3	0.0	60.0	17.0	10.200	8.757	24.05	1.0E-04	0.93129	0.00071	0.93271				
ncf1bmt11p_48_1_1_3	0.0	60.0	17.1	10.260	8.752	23.90	1.0E-04	0.93173	0.00080	0.93333				
ncf1bmt11p_49_1_1_3	0.0	60.0	17.2	10.320	8.746	23.74	1.0E-04	0.93368	0.00066	0.93500				
ncf1bmt11p_50_1_1_3	0.0	60.0	17.3	10.380	8.741	23.60	1.0E-04	0.93319	0.00074	0.93467	hcf2bmt12p_50_1_1_3	0.90910	0.00100	0.91110
ncf1bmt11p_51_1_1_3	0.0	60.0	17.4	10.440	8.736	23.45	1.0E-04	0.93371	0.00075	0.93521	hcf2bmt12p_51_1_1_3	0.90921	0.00072	0.91065
with can spacers (np thickness = 1.4 in.), [USL=0.93520]														
ncf1bmt11p_5_2_6_3	1.4	100	4.0	4.000	8.829	61.80	1.0E-04	0.90474	0.00072	0.90618				
ncf1bmt11p_11_2_6_3	1.4	100	5.0	5.000	8.776	49.16	1.0E-04	0.92117	0.00079	0.92275				
ncf1bmt11p_17_2_6_3	1.4	100	5.7	5.700	8.738	42.96	1.0E-04	0.93055	0.00087	0.93229				
ncf1bmt11p_18_2_6_3	1.4	100	5.8	5.800	8.733	42.18	1.0E-04	0.93220	0.00071	0.93362				
ncf1bmt11p_19_2_6_3	1.4	100	5.9	5.900	8.728	41.45	1.0E-04	0.93244	0.00077	0.93398	hcf2bmt12p_19_2_6_3	0.91192	0.00084	0.91360
ncf1bmt11p_20_2_6_3	1.4	100	6.0	6.000	8.723	40.74	1.0E-04	0.93564	0.00082	0.93728	hcf2bmt12p_20_2_6_3	0.91215	0.00088	0.91391
ncf1bmt11p_20_2_5_3	1.4	95	6.0	5.700	8.723	42.89	1.0E-04	0.92293	0.00089	0.92471				
ncf1bmt11p_21_2_5_3	1.4	95	7.0	6.650	8.670	36.54	1.0E-04	0.93185	0.00089	0.93363				
ncf1bmt11p_22_2_5_3	1.4	95	7.1	6.745	8.664	36.01	1.0E-04	0.93259	0.00085	0.93429				
ncf1bmt11p_23_2_5_3	1.4	95	7.2	6.840	8.659	35.50	1.0E-04	0.93173	0.00081	0.93335				
ncf1bmt11p_24_2_5_3	1.4	95	7.3	6.935	8.654	34.98	1.0E-04	0.93391	0.00090	0.93571	hcf2bmt12p_24_2_5_3	0.91251	0.00073	0.91397

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncf1bmt11p_25_2_5_3	1.4	95	7.4	7.030	8.649	34.49	1.0E-04	0.93423	0.00082	0.93587	hcf2bmt12p_25_2_5_3	0.91410	0.00071	0.91552
ncf1bmt11p_26_2_4_3	1.4	90	8.0	7.200	8.617	35.57	1.0E-04	0.92923	0.00070	0.93063				
ncf1bmt11p_27_2_4_3	1.4	90	9.0	8.100	8.564	29.67	1.0E-04	0.93068	0.00083	0.93234				
ncf1bmt11p_28_2_4_3	1.4	90	9.2	8.280	8.553	28.99	1.0E-04	0.93150	0.00074	0.93298				
ncf1bmt11p_29_2_4_3	1.4	90	9.3	8.370	8.548	28.66	1.0E-04	0.93007	0.00067	0.93141				
ncf1bmt11p_30_2_4_3	1.4	90	9.4	8.460	8.543	28.34	1.0E-04	0.93125	0.00079	0.93283	hcf2bmt12p_30_2_4_3	0.91020	0.00080	0.91180
ncf1bmt11p_31_2_4_3	1.4	90	9.5	8.550	8.537	28.02	1.0E-04	0.93357	0.00093	0.93543	hcf2bmt12p_31_2_4_3	0.90999	0.00080	0.91159
ncf1bmt11p_38_2_3_3	1.4	80	12.0	9.600	8.406	24.60	1.0E-04	0.92546	0.00073	0.92692				
ncf1bmt11p_39_2_3_3	1.4	80	13.0	10.400	8.353	22.58	1.0E-04	0.92975	0.00076	0.93127				
ncf1bmt11p_40_2_3_3	1.4	80	13.6	10.880	8.321	21.50	1.0E-04	0.93242	0.00082	0.93406				
ncf1bmt11p_41_2_3_3	1.4	80	13.7	10.960	8.316	21.33	1.0E-04	0.93209	0.00074	0.93357				
ncf1bmt11p_42_2_3_3	1.4	80	13.8	11.040	8.311	21.17	1.0E-04	0.93232	0.00073	0.93378	hcf2bmt12p_42_2_3_3	0.91108	0.00063	0.91234
ncf1bmt11p_43_2_3_3	1.4	80	13.9	11.120	8.305	21.00	1.0E-04	0.93401	0.00090	0.93581	hcf2bmt12p_43_2_3_3	0.91202	0.00088	0.91378
ncf1bmt11p_53_2_2_3	1.4	70	20.0	14.000	7.984	16.08	1.0E-04	0.92770	0.00100	0.92970				
ncf1bmt11p_54_2_2_3	1.4	70	21.0	14.700	7.931	15.22	1.0E-04	0.93062	0.00060	0.93182				
ncf1bmt11p_55_2_2_3	1.4	70	21.6	15.120	7.899	14.74	1.0E-04	0.93243	0.00071	0.93385				
ncf1bmt11p_56_2_2_3	1.4	70	21.7	15.190	7.894	14.67	1.0E-04	0.93240	0.00080	0.93400				
ncf1bmt11p_57_2_2_3	1.4	70	21.8	15.260	7.889	14.59	1.0E-04	0.93327	0.00074	0.93475	hcf2bmt12p_57_2_2_3	0.91105	0.00066	0.91237
ncf1bmt11p_58_2_2_3	1.4	70	21.9	15.330	7.883	14.16	1.0E-04	0.93358	0.00082	0.93522	hcf2bmt12p_58_2_2_3	0.90965	0.00070	0.91105
ncf1bmt11p_64_2_1_3	1.4	60	31.0	18.600	7.404	11.29	1.0E-04	0.92762	0.00062	0.92886				

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncf1bmt11p_65_2_1_3	1.4	60	32.0	19.200	7.351	10.87	1.0E-04	0.93004	0.00061	0.93126				
ncf1bmt11p_66_2_1_3	1.4	60	32.7	19.620	7.315	10.59	1.0E-04	0.93290	0.00081	0.93452				
ncf1bmt11p_67_2_1_3	1.4	60	32.8	19.680	7.309	10.55	1.0E-04	0.93159	0.00066	0.93291				
ncf1bmt11p_68_2_1_3	1.4	60	32.9	19.740	7.304	10.51	1.0E-04	0.93189	0.00067	0.93323	hcf2bmt12p_68_2_1_3	0.90727	0.00063	0.90853
ncf1bmt11p_69_2_1_3	1.4	60	33.0	19.800	7.299	10.47	1.0E-04	0.93388	0.00074	0.93536	hcf2bmt12p_69_2_1_3	0.90907	0.00091	0.91089
content in flooded containment vessel, array packaging model for CSI=0.8														
NCT											**HAC**			
no can spacers (np thickness = 0.0 in.), [USL=0.93520]														
ncf2bmt11p_1_1_6_3	0.0	100.0	5.0	5.000	9.389	52.370	1.0E-04	0.91969	0.00076	0.92121				
ncf2bmt11p_2_1_6_3	0.0	100.0	6.0	6.000	9.336	43.410	1.0E-04	0.93058	0.00080	0.93218				
ncf2bmt11p_3_1_6_3	0.0	100.0	6.1	6.100	9.331	42.680	1.0E-04	0.93292	0.00093	0.93478				
ncf2bmt11p_4_1_6_3	0.0	100.0	6.2	6.200	9.326	41.970	1.0E-04	0.93336	0.00078	0.93492	hcf3bmt12p_4_1_6_3	0.91318	0.00085	0.91488
ncf2bmt11p_5_1_6_3	0.0	100.0	6.3	6.300	9.320	41.280	1.0E-04	0.93430	0.00100	0.93630	hcf3bmt12p_5_1_6_3	0.91291	0.00076	0.91443
ncf2bmt11p_2_1_5_3	0.0	95.0	6.0	5.700	9.336	45.700	1.0E-04	0.92090	0.00083	0.92256				
ncf2bmt11p_6_1_5_3	0.0	95.0	7.0	6.650	9.283	38.960	1.0E-04	0.92841	0.00081	0.93003				
ncf2bmt11p_7_1_5_3	0.0	95.0	7.5	7.125	9.257	36.270	1.0E-04	0.93231	0.00083	0.93397				
ncf2bmt11p_8_1_5_3	0.0	95.0	7.6	7.220	9.251	35.760	1.0E-04	0.93186	0.00067	0.93320				
ncf2bmt11p_9_1_5_3	0.0	95.0	7.7	7.315	9.246	35.280	1.0E-04	0.93341	0.00082	0.93505	hcf3bmt12p_9_1_5_3	0.91323	0.00082	0.91487
ncf2bmt11p_10_1_5_3	0.0	95.0	7.8	7.410	9.241	34.810	1.0E-04	0.93398	0.00074	0.93546	hcf3bmt12p_10_1_5_3	0.91378	0.00079	0.91536
ncf2bmt11p_11_1_4_3	0.0	90.0	8.0	7.200	9.231	35.790	1.0E-04	0.92512	0.00085	0.92682				
ncf2bmt11p_12_1_4_3	0.0	90.0	9.0	8.100	9.178	31.640	1.0E-04	0.93187	0.00073	0.93333				
ncf2bmt11p_13_1_4_3	0.0	90.0	9.3	8.370	9.162	30.570	1.0E-04	0.93127	0.00081	0.93289				

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncf2bmt11p_14_1_4_3	0.0	90.0	9.4	8.460	9.156	30.230	1.0E-04	0.93334	0.00070	0.93474				
ncf2bmt11p_15_1_4_3	0.0	90.0	9.5	8.550	9.151	29.890	1.0E-04	0.93295	0.00075	0.93445	ncf3bmt11p_15_1_4_3	0.91261	0.00088	0.91437
ncf2bmt11p_16_1_4_3	0.0	90.0	9.6	8.640	9.146	29.570	1.0E-04	0.93480	0.00080	0.93640	ncf3bmt11p_16_1_4_3	0.91371	0.00074	0.91519
ncf2bmt11p_24_1_3_3	0.0	80	13.0	10.400	8.966	24.120	1.0E-04	0.92866	0.00078	0.93022				
ncf2bmt11p_29_1_3_3	0.0	80	14.0	11.200	8.913	22.270	1.0E-04	0.93235	0.00097	0.93429				
ncf2bmt11p_30_1_3_3	0.0	80	14.1	11.280	8.908	22.100	1.0E-04	0.93268	0.00098	0.93464				
ncf2bmt11p_31_1_3_3	0.0	80	14.2	11.360	8.903	21.930	1.0E-04	0.93189	0.00079	0.93347	hcf3bmt12p_31_1_3_3	0.91118	0.00094	0.91306
ncf2bmt11p_32_1_3_3	0.0	80	14.3	11.440	8.898	21.770	1.0E-04	0.93370	0.00082	0.93534	hcf3bmt12p_32_1_3_3	0.91239	0.00076	0.91391
ncf2bmt11p_44_1_2_3	0.0	70	20.0	14.000	8.597	17.230	1.0E-04	0.92807	0.00077	0.92961				
ncf2bmt11p_45_1_2_3	0.0	70	21.0	14.700	8.544	16.310	1.0E-04	0.92939	0.00087	0.93113				
ncf2bmt11p_46_1_2_3	0.0	70	21.6	15.120	8.513	15.800	1.0E-04	0.93328	0.00070	0.93468				
ncf2bmt11p_47_1_2_3	0.0	70	21.7	15.190	8.507	15.720	1.0E-04	0.93189	0.00070	0.93329				
ncf2bmt11p_48_1_2_3	0.0	70	21.8	15.260	8.502	15.640	1.0E-04	0.93082	0.00076	0.93234	hcf3bmt12p_48_1_2_3	0.91300	0.00081	0.91462
ncf2bmt11p_49_1_2_3	0.0	70	21.9	15.330	8.497	15.560	1.0E-04	0.93362	0.00081	0.93524	hcf3bmt12p_49_1_2_3	0.91212	0.00073	0.91358
ncf2bmt11p_62_1_1_3	0.0	60	33.0	19.800	7.912	11.280	1.0E-04	0.93084	0.00074	0.93232				
ncf2bmt11p_63_1_1_3	0.0	60	34.0	20.400	7.859	10.880	1.0E-04	0.93184	0.00076	0.93336				
ncf2bmt11p_64_1_1_3	0.0	60	34.3	20.580	7.844	10.760	1.0E-04	0.93011	0.00079	0.93169				
ncf2bmt11p_65_1_1_3	0.0	60	34.4	20.640	7.838	10.720	1.0E-04	0.93284	0.00069	0.93422				
ncf2bmt11p_66_1_1_3	0.0	60	34.5	20.700	7.833	10.690	1.0E-04	0.93148	0.00064	0.93276	hcf3bmt12p_66_1_1_3	0.91250	0.00068	0.91386
ncf2bmt11p_67_1_1_3	0.0	60	34.6	20.760	7.828	10.650	1.0E-04	0.93423	0.00063	0.93549	hcf3bmt12p_67_1_1_3	0.91294	0.00065	0.91424

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
with can spacers (np thickness = 1.4 in.), [USL=0.93520]														
ncf2bmt11p_12_2_6_3	1.4	100	9.0	9.000	8.563	26.700	1.0E-04	0.92139	0.00078	0.92295				
ncf2bmt11p_17_2_6_3	1.4	100	10.0	10.000	8.510	23.890	1.0E-04	0.93108	0.00076	0.93260				
ncf2bmt11p_18_2_6_3	1.4	100	10.3	10.300	8.494	23.150	1.0E-04	0.93218	0.00087	0.93392				
ncf2bmt11p_19_2_6_3	1.4	100	10.4	10.400	8.489	22.920	1.0E-04	0.93337	0.00069	0.93475				
ncf2bmt11p_20_2_6_3	1.4	100	10.5	10.500	8.484	22.690	1.0E-04	0.93370	0.00073	0.93516	hcf3bmt12p_20_2_6_3	0.91506	0.00073	0.91652
ncf2bmt11p_21_2_6_3	1.4	100	10.6	10.600	8.478	22.460	1.0E-04	0.93480	0.00100	0.93680	hcf3bmt12p_21_2_6_3	0.91522	0.00079	0.91680
ncf2bmt11p_23_2_5_3	1.4	95	12.0	11.400	8.405	20.710	1.0E-04	0.92528	0.00068	0.92664				
ncf2bmt11p_24_2_5_3	1.4	95	13.0	12.350	8.352	19.000	1.0E-04	0.93064	0.00084	0.93232				
ncf2bmt11p_25_2_5_3	1.4	95	13.3	12.635	8.336	18.540	1.0E-04	0.93230	0.00087	0.93404				
ncf2bmt11p_26_2_5_3	1.4	95	13.4	12.730	8.330	18.400	1.0E-04	0.93221	0.00080	0.93381				
ncf2bmt11p_27_2_5_3	1.4	95	13.5	12.825	8.325	18.250	1.0E-04	0.93227	0.00088	0.93403	hcf3bmt1sp_27_2_5_3	0.91481	0.00088	0.91657
ncf2bmt11p_28_2_5_3	1.4	95	13.6	12.920	8.320	18.100	1.0E-04	0.93496	0.00092	0.93680	hcf3bmt1sp_28_2_5_3	0.91503	0.00069	0.91641
ncf2bmt11p_34_2_4_3	1.4	90	16.0	14.400	8.193	16.020	1.0E-04	0.93122	0.00072	0.93266				
ncf2bmt11p_36_2_4_3	1.4	90	17.0	15.300	8.140	14.980	1.0E-04	0.92960	0.00074	0.93108				
ncf2bmt11p_38_2_4_3	1.4	90	17.2	15.480	8.129	14.790	1.0E-04	0.93073	0.00074	0.93221				
ncf2bmt11p_39_2_4_3	1.4	90	17.3	15.570	8.124	14.700	1.0E-04	0.93083	0.00072	0.93227				
ncf2bmt11p_40_2_4_3	1.4	90	17.4	15.660	8.119	14.600	1.0E-04	0.93310	0.00100	0.93510	hcf3bmt12p_40_2_4_3	0.91088	0.00072	0.91232
ncf2bmt11p_41_2_4_3	1.4	90	17.5	15.750	8.113	14.510	1.0E-04	0.93512	0.00078	0.93668	hcf3bmt12p_41_2_4_3	0.91121	0.00082	0.91285
ncf2bmt11p_50_2_3_3	1.4	80	24.0	19.200	7.876	12.630	1.0E-04	0.93260	0.00074	0.93408				
ncf2bmt11p_53_2_3_3	1.4	80	25.0	20.000	7.718	10.910	1.0E-04	0.93366	0.00067	0.93500				

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncf2bmt11p_54_2_3_3	1.4	80	25.4	20.320	7.697	10.710	1.0E-04	0.93347	0.00067	0.93481				
ncf2bmt11p_55_2_3_3	1.4	80	25.5	20.400	7.691	10.660	1.0E-04	0.93351	0.00068	0.93487				
ncf2bmt11p_56_2_3_3	1.4	80	25.6	20.480	7.686	10.610	1.0E-04	0.93371	0.00071	0.93513	hcf3bmt12p_56_2_3_3	0.91427	0.00082	0.91591
ncf2bmt11p_57_2_3_3	1.4	80	25.7	20.560	7.681	10.570	1.0E-04	0.93462	0.00067	0.93596	hcf3bmt12p_57_2_3_3	0.91397	0.00070	0.91537
ncf2bmt11p_63_2_2_3	1.4	70	34.0	23.800	7.244	8.650	1.0E-04	0.92872	0.00070	0.93012				
ncf2bmt11p_68_2_2_3	1.4	70	35.0	24.500	7.191	8.350	1.0E-04	0.93293	0.00064	0.93421				
ncf2bmt11p_69_2_2_3	1.4	70	35.2	24.640	7.180	8.290	1.0E-04	0.93370	0.00062	0.93494				
ncf2bmt11p_70_2_2_3	1.4	70	35.3	24.710	7.175	8.260	1.0E-04	0.93310	0.00064	0.93438				
ncf2bmt11p_71_2_2_3	1.4	70	35.4	24.780	7.170	8.230	1.0E-04	0.93224	0.00070	0.93364	hcf3bmt12p_71_2_2_3	0.91273	0.00062	0.91397
ncf2bmt11p_72_2_2_3	1.4	70	35.5	24.850	7.164	8.200	1.0E-04	0.93403	0.00062	0.93527	hcf3bmt12p_72_2_2_3	0.91281	0.00072	0.91425
ncf2bmt11p_68_2_1_3	1.4	60	35.0	21.000	7.193	10.690	1.0E-04	0.90125	0.00073	0.90271	hcf3bmt12p_66_2_1_3	0.88257	0.00087	0.88431
ncf2bmt11p_73_2_1_3	1.4	60	36.0	21.600	7.140	10.650	1.0E-04	0.90441	0.00073	0.90587	hcf3bmt12p_67_2_1_3	0.88487	0.00065	0.88617
content in flooded containment vessel, array packaging model for CSI=2.0														
NCT											**HAC**			
no can spacers (np thickness = 0.0 in.), [USL=0.93520]														
ncf3bmt11p_1_1_6_3	0.0	100.0	9.0	9.000	9.177	28.47	1.0E-04	0.92360	0.00074	0.92508				
ncf3bmt11p_2_1_6_3	0.0	100.0	10.0	10.000	9.124	25.49	1.0E-04	0.92895	0.00073	0.93041				
ncf3bmt11p_3_1_6_3	0.0	100.0	10.5	10.500	9.097	24.21	1.0E-04	0.93125	0.00084	0.93293				
ncf3bmt11p_4_1_6_3	0.0	100.0	10.6	10.600	9.092	23.97	1.0E-04	0.93336	0.00084	0.93504				
ncf3bmt11p_5_1_6_3	0.0	100.0	10.7	10.700	9.087	23.73	1.0E-04	0.93343	0.00074	0.93491	hcf4bmt12p_5_1_6_3	0.89664	0.00073	0.89810
ncf3bmt11p_6_1_6_3	0.0	100.0	10.8	10.800	9.081	23.50	1.0E-04	0.93534	0.00081	0.93696	hcf4bmt12p_6_1_6_3	0.89636	0.00081	0.89798

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncf3bmt11p_9_1_5_3	0.0	95.0	13.0	12.350	8.965	20.30	1.0E-04	0.92967	0.00085	0.93137				
ncf3bmt11p_10_1_5_3	0.0	95.0	13.7	13.015	8.928	19.19	1.0E-04	0.93100	0.00069	0.93238				
ncf3bmt11p_11_1_5_3	0.0	95.0	13.8	13.110	8.923	19.04	1.0E-04	0.93099	0.00078	0.93255				
ncf3bmt11p_12_1_5_3	0.0	95.0	13.9	13.205	8.917	18.89	1.0E-04	0.93093	0.00079	0.93251				
ncf3bmt11p_13_1_5_3	0.0	95.0	14.0	13.300	8.912	18.75	1.0E-04	0.93298	0.00079	0.93456	hcf4bmt12p_13_1_5_3	0.89394	0.00074	0.89542
ncf3bmt11p_14_1_5_3	0.0	95.0	14.1	13.395	8.907	18.61	1.0E-04	0.93375	0.00080	0.93535	hcf4bmt12p_14_1_5_3	0.89474	0.00078	0.89630
ncf3bmt11p_16_1_4_3	0.0	90.0	16.0	14.400	8.807	17.13	1.0E-04	0.92748	0.00071	0.92890				
ncf3bmt11p_17_1_4_3	0.0	90.0	17.0	15.300	8.754	16.03	1.0E-04	0.92926	0.00080	0.93086				
ncf3bmt11p_22_1_4_3	0.0	90.0	17.7	15.930	8.716	15.34	1.0E-04	0.93208	0.00065	0.93338				
ncf3bmt11p_23_1_4_3	0.0	90.0	17.8	16.020	8.711	15.24	1.0E-04	0.93346	0.00068	0.93482				
ncf3bmt11p_24_1_4_3	0.0	90.0	17.9	16.110	8.706	15.15	1.0E-04	0.93323	0.00067	0.93457	hcf4bmt12p_24_1_4_3	0.89614	0.00070	0.89754
ncf3bmt11p_25_1_4_3	0.0	90.0	18.0	16.200	8.701	15.05	1.0E-04	0.93370	0.00100	0.93570	hcf4bmt12p_25_1_4_3	0.89669	0.00075	0.89819
ncf3bmt11p_35_1_3_3	0.0	80	24.0	19.200	8.384	12.27	1.0E-04	0.92835	0.00077	0.92989				
ncf3bmt11p_36_1_3_3	0.0	80	25.0	20.000	8.331	11.71	1.0E-04	0.93112	0.00067	0.93246				
ncf3bmt11p_37_1_3_3	0.0	80	25.2	20.160	8.321	11.60	1.0E-04	0.93204	0.00081	0.93366				
ncf3bmt11p_38_1_3_3	0.0	80	25.3	20.240	8.315	11.55	1.0E-04	0.93170	0.00090	0.93350				
ncf3bmt11p_39_1_3_3	0.0	80	25.4	20.320	8.310	11.50	1.0E-04	0.93151	0.00079	0.93309	hcf4bmt12p_39_1_3_3	0.89349	0.00070	0.89489
ncf3bmt11p_40_1_3_3	0.0	80	25.5	20.400	8.305	11.45	1.0E-04	0.93376	0.00077	0.93530	hcf4bmt12p_40_1_3_3	0.89477	0.00066	0.89609
ncf3bmt11p_53_1_2_3	0.0	70	34.0	23.800	7.857	9.32	1.0E-04	0.92832	0.00062	0.92956				
ncf3bmt11p_54_1_2_3	0.0	70	35.0	24.500	7.804	9.00	1.0E-04	0.93069	0.00083	0.93235				

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncf3bmt11p_55_1_2_3	0.0	70	35.7	24.990	7.767	8.78	1.0E-04	0.93216	0.00087	0.93390				
ncf3bmt11p_56_1_2_3	0.0	70	35.8	25.060	7.762	8.75	1.0E-04	0.93223	0.00069	0.93361				
ncf3bmt11p_57_1_2_3	0.0	70	35.9	25.130	7.757	8.72	1.0E-04	0.93348	0.00086	0.93520	hcf4bmt12p_57_1_2_3	0.89634	0.00066	0.89766
ncf3bmt11p_58_1_2_3	0.0	70	36.0	25.200	7.751	8.69	1.0E-04	0.93377	0.00063	0.93503	hcf4bmt12p_58_1_2_3	0.89639	0.00077	0.89793
ncf3bmt11p_57_1_1_3	0.0	60	35.0	21.000	7.807	10.50	1.0E-04	0.90513	0.00065	0.90643	hcf4bmt12p_57_1_1_3	0.86802	0.00067	0.86936
ncf3bmt11p_58_1_1_3	0.0	60	36.0	21.600	7.754	10.15	1.0E-04	0.90595	0.00066	0.90727	hcf4bmt12p_58_1_1_3	0.86948	0.00075	0.87098
with can spacers (np thickness = 1.4 in.), [USL=0.93520]														
ncf3bmt11p_16_2_6_3	1.4	100	16.0	16.000	8.192	14.41	1.0E-04	0.93171	0.00079	0.93329				
ncf3bmt11p_17_2_6_3	1.4	100	17.0	17.000	8.139	13.48	1.0E-04	0.92924	0.00073	0.93070				
ncf3bmt11p_18_2_6_3	1.4	100	17.3	17.300	8.123	13.22	1.0E-04	0.93113	0.00079	0.93271				
ncf3bmt11p_19_2_6_3	1.4	100	17.4	17.400	8.118	13.14	1.0E-04	0.93152	0.00077	0.93306				
ncf3bmt11p_20_2_6_3	1.4	100	17.5	17.500	8.112	13.06	1.0E-04	0.93207	0.00069	0.93345	hcf4bmt12p_20_2_6_3	0.89674	0.00081	0.89836
ncf3bmt11p_21_2_6_3	1.4	100	17.6	17.600	8.107	12.98	1.0E-04	0.93348	0.00087	0.93522	hcf4bmt12p_21_2_6_3	0.89621	0.00075	0.89771
ncf3bmt11p_28_2_5_3	1.4	95	21.0	19.950	7.927	11.21	1.0E-04	0.92877	0.00075	0.93027				
ncf3bmt11p_29_2_5_3	1.4	95	22.0	20.900	7.874	10.64	1.0E-04	0.93021	0.00093	0.93207				
ncf3bmt11p_30_2_5_3	1.4	95	22.2	21.090	7.864	10.53	1.0E-04	0.93220	0.00078	0.93376				
ncf3bmt11p_31_2_5_3	1.4	95	22.3	21.185	7.858	10.47	1.0E-04	0.93284	0.00088	0.93460				
ncf3bmt11p_32_2_5_3	1.4	95	22.4	21.280	7.853	10.42	1.0E-04	0.93353	0.00066	0.93485	hcf4bmt12p_32_2_5_3	0.89782	0.00091	0.89964
ncf3bmt11p_33_2_5_3	1.4	95	22.5	21.375	7.848	10.37	1.0E-04	0.93492	0.00079	0.93650	hcf4bmt12p_33_2_5_3	0.89986	0.00078	0.90142
ncf3bmt11p_41_2_4_3	1.4	90	26.0	23.400	7.663	9.26	1.0E-04	0.92843	0.00068	0.92979				
ncf3bmt11p_42_2_4_3	1.4	90	27.0	24.300	7.610	8.86	1.0E-04	0.93174	0.00065	0.93304				

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncf3bmt11p_43_2_4_3	1.4	90	27.3	24.570	7.594	8.75	1.0E-04	0.93373	0.00067	0.93507				
ncf3bmt11p_44_2_4_3	1.4	90	27.4	24.660	7.589	8.71	1.0E-04	0.93341	0.00066	0.93473				
ncf3bmt11p_45_2_4_3	1.4	90	27.5	24.750	7.584	8.68	1.0E-04	0.93263	0.00073	0.93409	hcf4bmt12p_45_2_4_3	0.89764	0.00084	0.89932
ncf3bmt11p_46_2_4_3	1.4	90	27.6	24.840	7.578	8.64	1.0E-04	0.93579	0.00062	0.93703	hcf4bmt12p_46_2_4_3	0.89757	0.00096	0.89949
ncf3bmt11p_53_2_3_3	1.4	80	34.0	27.200	7.241	7.56	1.0E-04	0.92708	0.00070	0.92848				
ncf3bmt11p_54_2_3_3	1.4	80	35.0	28.000	7.188	7.30	1.0E-04	0.92931	0.00064	0.93059				
ncf3bmt11p_55_2_3_3	1.4	80	35.7	28.560	7.151	7.12	1.0E-04	0.93137	0.00075	0.93287				
ncf3bmt11p_56_2_3_3	1.4	80	35.8	28.640	7.146	7.10	1.0E-04	0.93250	0.00070	0.93390				
ncf3bmt11p_57_2_3_3	1.4	80	35.9	28.720	7.141	7.07	1.0E-04	0.93102	0.00062	0.93226	hcf4bmt12p_57_2_3_3	0.89349	0.00084	0.89517
ncf3bmt11p_58_2_3_3	1.4	80	36.0	28.800	7.135	7.05	1.0E-04	0.93205	0.00065	0.93335	hcf4bmt12p_58_2_3_3	0.89469	0.00066	0.89601
ncf3bmt11p_54_2_2_3	1.4	70	35.0	24.500	7.191	8.35	1.0E-04	0.90228	0.00067	0.90362	hcf4bmt12p_54_2_2_3	0.86662	0.00065	0.86792
ncf3bmt11p_58_2_2_3	1.4	70	36.0	25.200	7.138	8.06	1.0E-04	0.90459	0.00072	0.90603	hcf4bmt12p_58_2_2_3	0.86714	0.00063	0.86840
ncf3bmt11p_54_2_1_3	1.4	60	35.0	21.000	7.193	9.74	1.0E-04	0.87291	0.00064	0.87419	hcf4bmt12p_54_2_1_3	0.83804	0.00066	0.83936
ncf3bmt11p_58_2_1_3	1.4	60	36.0	21.600	7.140	9.40	1.0E-04	0.87663	0.00070	0.87803	hcf4bmt12p_58_2_1_3	0.84037	0.00069	0.84175
content in flooded containment vessel, array packaging model for CSI=3.2														
NCT											**HAC**			
no can spacers (np thickness = 0.0 in.), [USL=0.93520]														
nctf5bmt11p_1_1_6_3	0.0	100	18.0	18.000	8.699	13.55	1.0E-04	0.93094	0.00077	0.93248				
nctf5bmt11p_2_1_6_3	0.0	100	18.8	18.800	8.657	12.91	1.0E-04	0.93142	0.00074	0.93290				
nctf5bmt11p_3_1_6_3	0.0	100	18.9	18.900	8.652	12.84	1.0E-04	0.93324	0.00077	0.93478				
nctf5bmt11p_4_1_6_3	0.0	100	19.0	19.000	8.646	12.76	1.0E-04	0.93307	0.00082	0.93471				

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nctf5bmt11p_5_1_6_3	0.0	100	19.1	19.100	8.641	12.69	1.0E-04	0.93303	0.00088	0.93479	hctf5bmt12p_5_1_6_3	0.91336	0.00074	0.91484
nctf5bmt11p_6_1_6_3	0.0	100	19.2	19.200	8.636	12.61	1.0E-04	0.93461	0.00074	0.93609	hctf5bmt12p_6_1_6_3	0.91349	0.00075	0.91499
nctf5bmt11p_10_1_5_3	0.0	95	23.0	21.850	8.435	10.84	1.0E-04	0.92873	0.00078	0.93029				
nctf5bmt11p_11_1_5_3	0.0	95	24.0	22.800	8.382	10.33	1.0E-04	0.93120	0.00067	0.93254				
nctf5bmt11p_12_1_5_3	0.0	95	24.6	23.370	8.350	10.04	1.0E-04	0.93186	0.00063	0.93312				
nctf5bmt11p_13_1_5_3	0.0	95	24.7	23.465	8.345	10.00	1.0E-04	0.93220	0.00065	0.93350				
nctf5bmt11p_14_1_5_3	0.0	95	24.8	23.560	8.339	9.95	1.0E-04	0.93374	0.00067	0.93508	hctf5bmt12p_14_1_5_3	0.91530	0.00079	0.91688
nctf5bmt11p_15_1_5_3	0.0	95	24.9	23.655	8.334	9.90	1.0E-04	0.93532	0.00070	0.93672	hctf5bmt12p_15_1_5_3	0.91502	0.00070	0.91642
nctf5bmt11p_23_1_4_3	0.0	90	28.0	25.200	8.171	9.13	1.0E-04	0.93134	0.00082	0.93298				
nctf5bmt11p_24_1_4_3	0.0	90	28.7	25.830	8.133	8.87	1.0E-04	0.93352	0.00073	0.93498				
nctf5bmt11p_25_1_4_3	0.0	90	28.8	25.920	8.128	8.83	1.0E-04	0.93192	0.00085	0.93362				
nctf5bmt11p_26_1_4_3	0.0	90	28.9	26.010	8.123	8.80	1.0E-04	0.93373	0.00070	0.93513				
nctf5bmt11p_27_1_4_3	0.0	90	29.0	26.100	8.118	8.76	1.0E-04	0.93225	0.00071	0.93367	hctf5bmt12p_27_1_4_3	0.91364	0.00066	0.91496
nctf5bmt11p_28_1_4_3	0.0	90	29.1	26.190	8.112	8.73	1.0E-04	0.93424	0.00086	0.93596	hctf5bmt12p_28_1_4_3	0.91321	0.00079	0.91479
nctf5bmt11p_37_1_3_3	0.0	80	34.0	27.200	7.855	8.15	1.0E-04	0.92318	0.00067	0.92452				
nctf5bmt11p_38_1_3_3	0.0	80	35.0	28.000	7.802	7.87	1.0E-04	0.92473	0.00070	0.92613				
nctf5bmt11p_39_1_3_3	0.0	80	35.7	28.560	7.765	7.68	1.0E-04	0.92630	0.00069	0.92768				
nctf5bmt11p_40_1_3_3	0.0	80	35.8	28.640	7.760	7.66	1.0E-04	0.92701	0.00070	0.92841				
nctf5bmt11p_41_1_3_3	0.0	80	35.9	28.720	7.754	7.63	1.0E-04	0.92780	0.00084	0.92948	hctf5bmt12p_41_1_3_3	0.90692	0.00080	0.90852
nctf5bmt11p_42_1_3_3	0.0	80	36.0	28.800	7.749	7.60	1.0E-04	0.92674	0.00076	0.92826	hctf5bmt12p_42_1_3_3	0.90753	0.00061	0.90875

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nctf5bmt11p_38_1_2_3	0.0	70	35.0	24.500	7.804	9.00	1.0E-04	0.90063	0.00067	0.90197	hctf5bmt12p_38_1_2_3	0.87996	0.00074	0.88144
nctf5bmt11p_42_1_2_3	0.0	70	36.0	25.200	7.751	8.69	1.0E-04	0.90203	0.00071	0.90345	hctf5bmt12p_42_1_2_3	0.88165	0.00077	0.88319
nctf5bmt11p_38_1_1_3	0.0	60	35.0	21.000	7.807	10.50	1.0E-04	0.87479	0.00064	0.87607	hctf5bmt12p_38_1_1_3	0.85350	0.00081	0.85512
nctf5bmt11p_42_1_1_3	0.0	60	36.0	21.600	7.754	10.15	1.0E-04	0.87562	0.00077	0.87716	hctf5bmt12p_42_1_1_3	0.85640	0.00066	0.85772
with can spacers (np thickness = 1.4 in.), [USL=0.93520]														
nctf5bmt11p_17_2_6_3	1.4	100	26.0	26.000	7.661	8.34	1.0E-04	0.92848	0.00075	0.92998				
nctf5bmt11p_18_2_6_3	1.4	100	27.0	27.000	7.608	7.98	1.0E-04	0.93181	0.00066	0.93313				
nctf5bmt11p_19_2_6_3	1.4	100	27.2	27.200	7.598	7.91	1.0E-04	0.93219	0.00078	0.93375				
nctf5bmt11p_20_2_6_3	1.4	100	27.3	27.300	7.592	7.87	1.0E-04	0.93131	0.00072	0.93275				
nctf5bmt11p_21_2_6_3	1.4	100	27.4	27.400	7.587	7.84	1.0E-04	0.93306	0.00068	0.93442	hctf5bmt12p_21_2_6_3	0.91421	0.00065	0.91551
nctf5bmt11p_22_2_6_3	1.4	100	27.5	27.500	7.582	7.81	1.0E-04	0.93422	0.00067	0.93556	hctf5bmt12p_22_2_6_3	0.91461	0.00066	0.91593
nctf5bmt11p_30_2_5_3	1.4	95	31.0	29.450	7.397	7.13	1.0E-04	0.92789	0.00080	0.92949				
nctf5bmt11p_31_2_5_3	1.4	95	32.0	30.400	7.344	6.86	1.0E-04	0.92991	0.00075	0.93141				
nctf5bmt11p_32_2_5_3	1.4	95	32.4	30.780	7.323	6.75	1.0E-04	0.93192	0.00074	0.93340				
nctf5bmt11p_33_2_5_3	1.4	95	32.5	30.875	7.317	6.73	1.0E-04	0.93216	0.00075	0.93366				
nctf5bmt11p_34_2_5_3	1.4	95	32.6	30.970	7.312	6.70	1.0E-04	0.93087	0.00086	0.93259	hctf5bmt12p_34_2_5_3	0.91324	0.00071	0.91466
nctf5bmt11p_35_2_5_3	1.4	95	32.7	31.065	7.307	6.68	1.0E-04	0.93350	0.00098	0.93546	hctf5bmt12p_35_2_5_3	0.91399	0.00073	0.91545
nctf5bmt11p_38_2_4_3	1.4	90	35.0	31.500	7.186	6.49	1.0E-04	0.92275	0.00081	0.92437	hctf5bmt12p_38_2_4_3	0.90402	0.00069	0.90540
nctf5bmt11p_42_2_4_3	1.4	90	36.0	32.400	7.133	6.26	1.0E-04	0.92744	0.00076	0.92896	hctf5bmt12p_42_2_4_3	0.90769	0.00062	0.90893
nctf5bmt11p_38_2_3_3	1.4	80	35.0	28.000	7.188	7.30	1.0E-04	0.89795	0.00090	0.89975	hctf5bmt12p_38_2_3_3	0.87810	0.00079	0.87968

Table 6.9.6-11a. Results for HEU content (solid metal of unspecified geometric shape and characterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	H_2O (kg)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nctf5bmt11p_42_2_3_3	1.4	80	36.0	28.800	7.135	7.05	1.0E-04	0.90042	0.00074	0.90190	hctf5bmt12p_42_2_3_3	0.87995	0.00064	0.88123
nctf5bmt11p_38_2_2_3	1.4	70	35.0	24.500	7.191	8.35	1.0E-04	0.87146	0.00070	0.87286	hctf5bmt12p_38_2_2_3	0.85322	0.00063	0.85448
nctf5bmt11p_42_2_2_3	1.4	70	36.0	25.200	7.138	8.06	1.0E-04	0.87283	0.00061	0.87405	hctf5bmt12p_42_2_2_3	0.85513	0.00075	0.85663
nctf5bmt11p_38_2_1_3	1.4	60	35.0	21.000	7.193	9.74	1.0E-04	0.84382	0.00062	0.84506	hctf5bmt12p_38_2_1_3	0.82500	0.00091	0.82682
nctf5bmt11p_42_2_1_3	1.4	60	36.0	21.600	7.140	9.40	1.0E-04	0.84553	0.00064	0.84681	hctf5bmt12p_42_2_1_3	0.82746	0.00070	0.82886

Table 6.9.6-11aa. Results for HEU content mixed with thorium (solid metal of unspecified geometric shape and chacterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	^{232}Th (kg)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded containment vessel, single package model, (USL=0.93520)											
ncsrbmt11p_8_6_15	0.0	100	36.00	36.00	0.0	7.744	6.08	1.0E+00	0.89098	0.00072	0.89242
ncsrbmt11pth_6_1_15	0.0	100	36.00	36.00	1.00	7.659	6.02	1.0E+00	0.88427	0.00065	0.88557
ncsrbmt11pth_6_1_15	0.0	100	36.00	36.00	2.00	7.574	5.96	1.0E+00	0.87685	0.00082	0.87849
ncsrbmt11pth_6_1_15	0.0	100	36.00	36.00	3.00	7.488	5.90	1.0E+00	0.87292	0.00072	0.87436
ncsrbmt11pth_6_1_15	0.0	100	36.00	36.00	4.00	7.403	5.83	1.0E+00	0.86729	0.00067	0.86863
ncsrbmt11pth_6_1_15	0.0	100	36.00	36.00	5.00	7.318	5.77	1.0E+00	0.86270	0.00061	0.86392

Table 6.9.6-11aa. Results for HEU content mixed with thorium (solid metal of unspecified geometric shape and chacterized as broken metal, broken metal, turnings, fines, or powder) with 500 g polyethylene in packaging calculation model

Case	np (in.)	Enr. (wt %)	U (kg)	^{235}U (kg)	^{232}Th (kg)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
hcsrbmt11p_1_6_15	0.0	100	36.00	36.00	0.0	7.744	6.08	1.0E+00	0.86790	0.00067	0.86924
hcsrbmt11pth_6_1_15	0.0	100	36.00	36.00	1.00	7.659	6.02	1.0e+00	0.88427	0.00073	0.88573
hcsrbmt11pth_6_2_15	0.0	100	36.00	36.00	2.00	7.574	5.96	1.0e+00	0.87880	0.00074	0.88028
hcsrbmt11pth_6_3_15	0.0	100	36.00	36.00	3.00	7.488	5.90	1.0e+00	0.87347	0.00070	0.87487
hcsrbmt11pth_6_4_15	0.0	100	36.00	36.00	4.00	7.403	5.83	1.0e+00	0.86791	0.00069	0.86929
hcsrbmt11pth_6_5_15	0.0	100	36.00	36.00	5.00	7.318	5.77	1.0e+00	0.86332	0.00063	0.86458
content in flooded containment vessel, array packaging model for CSI=0.0, (USL=0.93680)											
nciabmt11p_5_1_8_3	0.0	100	2.6	2.600	0.0	9.517	101.98	1.0E-04	0.93264	0.00081	0.93426
nciabmt11pth_1_6_1	0.0	100	2.6	2.600	0.50	9.474	101.55	1.0E-04	0.92495	0.00075	0.92645
nciabmt11pth_1_6_2	0.0	100	2.6	2.600	1.00	9.431	101.13	1.0E-04	0.91648	0.00082	0.91812
nciabmt11pth_1_6_3	0.0	100	2.6	2.600	1.50	9.389	100.70	1.0E-04	0.90929	0.00071	0.91071
nciabmt11pth_1_6_4	0.0	100	2.6	2.600	2.00	9.346	100.27	1.0E-04	0.90356	0.00083	0.90522
nciabmt11pth_1_6_5	0.0	100	2.6	2.600	2.50	9.303	99.84	1.0E-04	0.89840	0.00076	0.89992
nciabmt11pth_1_6_6	0.0	100	2.6	2.600	3.00	9.261	99.41	1.0E-04	0.89251	0.00072	0.89395

Table 6.9.6-11b. Comparison of NCT results for HEU broken metal content in ES-3100 NCT packaging calculation models

Note: Reference results for content homogenized over volume of containment vessel are highlighted. Results shown below the reference results are for modified cases where the HEU packaging fraction varies from 0.2 to 0.6 and the content is homogenized with 500 g polyethylene.

nciabmt11*	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$				
nciapbmflt11*	**np (in.)**	**PF**	**U (g)**	**^{235}U (g)**	**H_2O (g)**	**h/x**	**MOIFR**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**	**nciapbmfdt11**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**
content in flooded containment vessel, array packaging model for CSI=0.0														
no can spacers (np thickness = 0.0 in.)														
_4_1_5_3	0.0	80.0	3709	2967	10001	87.98	1.0E-04	0.91835	0.00149	0.92133				
_1_2_4_5	0.0	0.2	4000	3200	9443	82.26	1.0E-04	0.68903	0.00121	0.69146	_1_2_4_5	0.85247	0.00116	0.85479
_1_3_4_5	0.0	0.3	4000	3200	9443	82.26	1.0E-04	0.65516	0.00136	0.65788	_1_3_4_5	0.84236	0.00121	0.84477
_1_4_4_5	0.0	0.4	4000	3200	9443	82.26	1.0E-04	0.63720	0.00123	0.63965	_1_4_4_5	0.83993	0.00137	0.84267
_1_5_4_5	0.0	0.5	4000	3200	9443	82.26	1.0E-04	0.62195	0.00105	0.62405	_1_5_4_5	0.83701	0.00126	0.83953
_1_6_4_5	0.0	0.6	4000	3200	9443	82.26	1.0E-04	0.61282	0.00101	0.61484	_1_6_4_5	0.83523	0.00118	0.83758
_5_1_4_3	0.0	70.0	4642	3249	9952	79.95	1.0E-04	0.91799	0.00136	0.92070				
_1_2_5_4	0.0	0.2	5000	3500	9390	74.82	1.0E-04	0.70497	0.00140	0.70778	_1_2_5_4	0.85830	0.00155	0.86140
_1_3_5_4	0.0	0.3	5000	3500	9390	74.82	1.0E-04	0.66703	0.00120	0.66942	_1_3_5_4	0.85296	0.00124	0.85545
_1_4_5_4	0.0	0.4	5000	3500	9390	74.82	1.0E-04	0.64665	0.00120	0.64904	_1_4_5_4	0.84681	0.00155	0.84991
_1_5_5_4	0.0	0.5	5000	3500	9390	74.82	1.0E-04	0.63242	0.00127	0.63496	_1_5_5_4	0.84544	0.00142	0.84827
_1_6_5_4	0.0	0.6	5000	3500	9390	74.82	1.0E-04	0.62104	0.00129	0.62362	_1_6_5_4	0.84411	0.00122	0.84656
_6_1_3_3	0.0	60.0	5577	3346	9903	77.24	1.0E-04	0.91221	0.00147	0.91515				
_1_2_6_3	0.0	0.2	6000	3600	9338	72.36	1.0E-04	0.71137	0.00124	0.71386	_1_2_6_3	0.85681	0.00117	0.85916
_1_3_6_3	0.0	0.3	6000	3600	9338	72.36	1.0E-04	0.67406	0.00124	0.67654	_1_3_6_3	0.85226	0.00126	0.85478
_1_4_6_3	0.0	0.4	6000	3600	9338	72.36	1.0E-04	0.65407	0.00115	0.65637	_1_4_6_3	0.84813	0.00119	0.85052

Table 6.9.6-11b. Comparison of NCT results for HEU broken metal content in ES-3100 NCT packaging calculation models

Note: Reference results for content homogenized over volume of containment vessel are highlighted. Results shown below the reference results are for modified cases where the HEU packaging fraction varies from 0.2 to 0.6 and the content is homogenized with 500 g polyethylene.

nciabmt11*	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$				
nciapbmflt11*	**np (in.)**	**PF**	**U (g)**	**^{235}U (g)**	**H_2O (g)**	**h/x**	**MOIFR**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**	**nciapbmfdt11**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**
_1_5_6_3	0.0	0.5	6000	3600	9338	72.36	1.0E-04	0.63393	0.00117	0.63626	_1_5_6_3	0.84385	0.00128	0.84642
_1_6_6_3	0.0	0.6	6000	3600	9338	72.36	1.0E-04	0.62196	0.00126	0.62449	_1_6_6_3	0.84286	0.00127	0.84541
with can spacers (np thickness = 1.4 in.)														
_3_2_8_3	1.4	100.0	2774	2774	9436	88.78	1.0E-04	0.90131	0.00139	0.90409				
_2_2_3_8	1.4	0.2	3000	3000	8882	82.86	1.0E-04	0.57463	0.00111	0.57684	_2_2_3_8	0.81623	0.00130	0.81883
_2_3_3_8	1.4	0.3	3000	3000	8882	82.86	1.0E-04	0.54703	0.00098	0.54900	_2_3_3_8	0.81643	0.00134	0.81912
_2_4_3_8	1.4	0.4	3000	3000	8882	82.86	1.0E-04	0.53274	0.00097	0.53467	_2_4_3_8	0.81357	0.00122	0.81600
_2_5_3_8	1.4	0.5	3000	3000	8882	82.86	1.0E-04	0.52613	0.00105	0.52822	_2_5_3_8	0.81038	0.00125	0.81288
_2_6_3_8	1.4	0.6	3000	3000	8882	82.86	1.0E-04	0.51882	0.00092	0.52065	_2_6_3_8	0.81249	0.00116	0.81482
_4_2_7_3	1.4	95.0	3701	3516	9387	69.68	1.0E-04	0.91690	0.00149	0.91987				
_2_2_4_7	1.4	0.2	4000	3800	8829	65.05	1.0E-04	0.61562	0.00115	0.61792	_2_2_4_7	0.85451	0.00154	0.85759
_2_3_4_7	1.4	0.3	4000	3800	8829	65.05	1.0E-04	0.58602	0.00121	0.58843	_2_3_4_7	0.84752	0.00128	0.85009
_2_4_4_7	1.4	0.4	4000	3800	8829	65.05	1.0E-04	0.56904	0.00124	0.57153	_2_4_4_7	0.84935	0.00118	0.85170
_2_5_4_7	1.4	0.5	4000	3800	8829	65.05	1.0E-04	0.55712	0.00096	0.55904	_2_5_4_7	0.84837	0.00138	0.85113
_2_6_4_7	1.4	0.6	4000	3800	8829	65.05	1.0E-04	0.55125	0.00100	0.55326	_2_6_4_7	0.84715	0.00114	0.84943
_4_2_6_3	1.4	90.0	3704	3333	9387	73.50	1.0E-04	0.90541	0.00147	0.90835				
_2_2_4_6	1.4	0.2	4000	3600	8829	68.67	1.0E-04	0.60511	0.00103	0.60717	_2_2_4_6	0.84248	0.00138	0.84524
_2_3_4_6	1.4	0.3	4000	3600	8829	68.67	1.0E-04	0.57445	0.00092	0.57628	_2_3_4_6	0.83740	0.00119	0.83978
_2_4_4_6	1.4	0.4	4000	3600	8829	68.67	1.0E-04	0.55835	0.00103	0.56041	_2_4_4_6	0.83957	0.00113	0.84184

Table 6.9.6-11b. Comparison of NCT results for HEU broken metal content in ES-3100 NCT packaging calculation models

Note: Reference results for content homogenized over volume of containment vessel are highlighted. Results shown below the reference results are for modified cases where the HEU packaging fraction varies from 0.2 to 0.6 and the content is homogenized with 500 g polyethylene.

nciabmt11*	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$				
nciapbmflt11*	**np (in.)**	**PF**	**U (g)**	**^{235}U (g)**	**H_2O (g)**	**h/x**	**MOIFR**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**	**nciapbmfdt11**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**
_2_5_4_6	1.4	0.5	4000	3600	8829	68.67	1.0E-04	0.54727	0.00106	0.54939	_2_5_4_6	0.83601	0.00137	0.83875
_2_6_4_6	1.4	0.6	4000	3600	8829	68.67	1.0E-04	0.53974	0.00107	0.54189	_2_6_4_6	0.83732	0.00140	0.84011
_6_2_5_3	1.4	80.0	5563	4450	9289	54.48	1.0E-04	0.91981	0.00127	0.92235				
_2_2_6_5	1.4	0.2	6000	4800	8723	50.93	1.0E-04	0.66266	0.00117	0.66500	_2_2_6_5	0.87671	0.00141	0.87952
_2_3_6_5	1.4	0.3	6000	4800	8723	50.93	1.0E-04	0.62900	0.00108	0.63116	_2_3_6_5	0.87268	0.00141	0.87551
_2_4_6_5	1.4	0.4	6000	4800	8723	50.93	1.0E-04	0.60636	0.00106	0.60848	_2_4_6_5	0.87070	0.00137	0.87344
_2_5_6_5	1.4	0.5	6000	4800	8723	50.93	1.0E-04	0.59549	0.00110	0.59769	_2_5_6_5	0.87064	0.00126	0.87316
_2_6_6_5	1.4	0.6	6000	4800	8723	50.93	1.0E-04	0.58580	0.00104	0.58789	_2_6_6_5	0.86937	0.00136	0.87209
_8_2_4_3	1.4	70.0	7426	5198	9191	46.15	1.0E-04	0.91902	0.00137	0.92175				
_2_2_8_4	1.4	0.2	8000	5600	8618	43.16	1.0E-04	0.69894	0.00117	0.70128	_2_2_8_4	0.88757	0.00154	0.89065
_2_3_8_4	1.4	0.3	8000	5600	8618	43.16	1.0E-04	0.65861	0.00101	0.66064	_2_3_8_4	0.88142	0.00149	0.88440
_2_4_8_4	1.4	0.4	8000	5600	8618	43.16	1.0E-04	0.63538	0.00119	0.63775	_2_4_8_4	0.88292	0.00164	0.88621
_2_5_8_4	1.4	0.5	8000	5600	8618	43.16	1.0E-04	0.62021	0.00120	0.62260	_2_5_8_4	0.88202	0.00141	0.88484
_2_6_8_4	1.4	0.6	8000	5600	8618	43.16	1.0E-04	0.61023	0.00116	0.61255	_2_6_8_4	0.88175	0.00132	0.88439
_12_2_3_3	1.4	60.0	11154	6692	8995	35.08	1.0E-04	0.91502	0.00155	0.91812				
_2_2_12_3	1.4	0.2	12000	7200	8407	32.81	1.0E-04	0.75340	0.00124	0.75588	_2_2_12_3	0.90142	0.00133	0.90409
_2_3_12_3	1.4	0.3	12000	7200	8407	32.81	1.0E-04	0.71017	0.00101	0.71220	_2_3_12_3	0.90203	0.00119	0.90441
_2_4_12_3	1.4	0.4	12000	7200	8407	32.81	1.0E-04	0.68355	0.00103	0.68561	_2_4_12_3	0.89718	0.00145	0.90009

Table 6.9.6-11b. Comparison of NCT results for HEU broken metal content in ES-3100 NCT packaging calculation models

Note: Reference results for content homogenized over volume of containment vessel are highlighted. Results shown below the reference results are for modified cases where the HEU packaging fraction varies from 0.2 to 0.6 and the content is homogenized with 500 g polyethylene.

nciabmt11*	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$				
nciapbmflt11*	**np (in.)**	**PF**	**U (g)**	**^{235}U (g)**	**H_2O (g)**	**h/x**	**MOIFR**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**	**nciapbmfdt11**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**
_2_5_12_3	1.4	0.5	12000	7200	8407	32.81	1.0E-04	0.66830	0.00090	0.67011	_2_5_12_3	0.90008	0.00114	0.90237
_2_6_12_3	1.4	0.6	12000	7200	8407	32.81	1.0E-04	0.65711	0.00100	0.65912	_2_6_12_3	0.89900	0.00120	0.90140

Table 6.9.6-11c. Comparison of HAC results for HEU broken metal content in ES-3100 HAC packaging calculation models

Note: Reference results for content homogenized over volume of containment vessel are highlighted. Results are for modified cases where the HEU packaging fraction varies from 0.2 to 0.6 and the content is homogenized with 500 g polyethylene.

hciabmt12*	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$				
hciapbmflt12*	**np (in.)**	**PF**	**U (g)**	**^{235}U (g)**	**H_2O (g)**	**h/x**	**MOIFR**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**	**hciapbmfdt12**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**
content in flooded containment vessel, array packaging model for CSI=0.0														
no can spacers (np thickness = 0.0 in.)														
_4_1_5_3	0.0	80.0	3709	2967	10001	87.98	1.0E-04	0.92156	0.00160	0.92476				
_1_2_4_5	0.0	0.2	4000	3200	9443	82.26	1.0E-04	0.69676	0.00134	0.69944	_1_2_4_5	0.85244	0.00119	0.85481
_1_3_4_5	0.0	0.3	4000	3200	9443	82.26	1.0E-04	0.66231	0.00119	0.66469	_1_3_4_5	0.84158	0.00146	0.84451
_1_4_4_5	0.0	0.4	4000	3200	9443	82.26	1.0E-04	0.64127	0.00133	0.64392	_1_4_4_5	0.84036	0.00120	0.84276
_1_5_4_5	0.0	0.5	4000	3200	9443	82.26	1.0E-04	0.62704	0.00115	0.62934	_1_5_4_5	0.83647	0.00127	0.83901
_1_6_4_5	0.0	0.6	4000	3200	9443	82.26	1.0E-04	0.61943	0.00110	0.62164	_1_6_4_5	0.83721	0.00128	0.83977

Table 6.9.6-11c. Comparison of HAC results for HEU broken metal content in ES-3100 HAC packaging calculation models

Note: Reference results for content homogenized over volume of containment vessel are highlighted. Results are for modified cases where the HEU packaging fraction varies from 0.2 to 0.6 and the content is homogenized with 500 g polyethylene.

hciabmt12*	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$				
hciapbmflt12*	**np (in.)**	**PF**	**U (g)**	**^{235}U (g)**	**H_2O (g)**	**h/x**	**MOIFR**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**	**hciapbmfdt12**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**
_5_1_4_3	0.0	70.0	4642	3249	9952	79.95	1.0E-04	0.92053	0.00147	0.92347				
_1_2_5_4	0.0	0.2	5000	3500	9390	74.82	1.0E-04	0.71271	0.00111	0.71494	_1_2_5_4	0.86056	0.00125	0.86305
_1_3_5_4	0.0	0.3	5000	3500	9390	74.82	1.0E-04	0.67372	0.00145	0.67662	_1_3_5_4	0.85614	0.00119	0.85851
_1_4_5_4	0.0	0.4	5000	3500	9390	74.82	1.0E-04	0.65481	0.00129	0.65738	_1_4_5_4	0.84829	0.00144	0.85117
_1_5_5_4	0.0	0.5	5000	3500	9390	74.82	1.0E-04	0.63822	0.00113	0.64047	_1_5_5_4	0.84683	0.00118	0.84919
_1_6_5_4	0.0	0.6	5000	3500	9390	74.82	1.0E-04	0.62688	0.00106	0.62899	_1_6_5_4	0.84497	0.00128	0.84754
_6_1_3_3	0.0	60.0	5577	3346	9903	77.24	1.0E-04	0.91017	0.00128	0.91274				
_1_2_6_3	0.0	0.2	6000	3600	9338	72.36	1.0E-04	0.71739	0.00119	0.71977	_1_2_6_3	0.85989	0.00142	0.86273
_1_3_6_3	0.0	0.3	6000	3600	9338	72.36	1.0E-04	0.68131	0.00126	0.68383	_1_3_6_3	0.85119	0.00113	0.85345
_1_4_6_3	0.0	0.4	6000	3600	9338	72.36	1.0E-04	0.65662	0.00118	0.65898	_1_4_6_3	0.84466	0.00126	0.84718
_1_5_6_3	0.0	0.5	6000	3600	9338	72.36	1.0E-04	0.63993	0.00109	0.64211	_1_5_6_3	0.84460	0.00144	0.84749
_1_6_6_3	0.0	0.6	6000	3600	9338	72.36	1.0E-04	0.62949	0.00119	0.63187	_1_6_6_3	0.84243	0.00125	0.84493
with can spacers (np thickness = 1.4 in.)														
_3_2_8_3	1.4	100.0	2774	2774	9436	88.78	1.0E-04	0.90243	0.00127	0.90497				
_2_2_3_8	1.4	0.2	3000	3000	8882	82.86	1.0E-04	0.57951	0.00103	0.58157	_2_2_3_8	0.81782	0.00115	0.82012
_2_3_3_8	1.4	0.3	3000	3000	8882	82.86	1.0E-04	0.55359	0.00094	0.55547	_2_3_3_8	0.81514	0.00148	0.81810
_2_4_3_8	1.4	0.4	3000	3000	8882	82.86	1.0E-04	0.53870	0.00102	0.54075	_2_4_3_8	0.81423	0.00122	0.81666
_2_5_3_8	1.4	0.5	3000	3000	8882	82.86	1.0E-04	0.52950	0.00097	0.53143	_2_5_3_8	0.81351	0.00131	0.81613
_2_6_3_8	1.4	0.6	3000	3000	8882	82.86	1.0E-04	0.52360	0.00120	0.52599	_2_6_3_8	0.81065	0.00127	0.81320

Table 6.9.6-11c. Comparison of HAC results for HEU broken metal content in ES-3100 HAC packaging calculation models

Note: Reference results for content homogenized over volume of containment vessel are highlighted. Results are for modified cases where the HEU packaging fraction varies from 0.2 to 0.6 and the content is homogenized with 500 g polyethylene.

hciabmt12*	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$				
hciapbmflt12*	**np (in.)**	**PF**	**U (g)**	**^{235}U (g)**	**H_2O (g)**	**h/x**	**MOIFR**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**	**hciapbmfdt12**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**
_4_2_7_3	1.4	95.0	3701	3516	9387	69.68	1.0E-04	0.92094	0.00140	0.92374				
_2_2_4_7	1.4	0.2	4000	3800	8829	65.05	1.0E-04	0.62129	0.00113	0.62355	_2_2_4_7	0.85574	0.00150	0.85874
_2_3_4_7	1.4	0.3	4000	3800	8829	65.05	1.0E-04	0.59045	0.00106	0.59256	_2_3_4_7	0.85080	0.00142	0.85364
_2_4_4_7	1.4	0.4	4000	3800	8829	65.05	1.0E-04	0.57686	0.00095	0.57875	_2_4_4_7	0.84954	0.00126	0.85205
_2_5_4_7	1.4	0.5	4000	3800	8829	65.05	1.0E-04	0.56383	0.00096	0.56576	_2_5_4_7	0.84837	0.00159	0.85155
_2_6_4_7	1.4	0.6	4000	3800	8829	65.05	1.0E-04	0.55861	0.00120	0.56100	_2_6_4_7	0.85112	0.00127	0.85366
_4_2_6_3	1.4	90.0	3704	3333	9387	73.50	1.0E-04	0.90643	0.00133	0.90909				
_2_2_4_6	1.4	0.2	4000	3600	8829	68.67	1.0E-04	0.61197	0.00116	0.61429	_2_2_4_6	0.84318	0.00154	0.84626
_2_3_4_6	1.4	0.3	4000	3600	8829	68.67	1.0E-04	0.58023	0.00112	0.58248	_2_3_4_6	0.83944	0.00123	0.84190
_2_4_4_6	1.4	0.4	4000	3600	8829	68.67	1.0E-04	0.56418	0.00111	0.56641	_2_4_4_6	0.83754	0.00123	0.84000
_2_5_4_6	1.4	0.5	4000	3600	8829	68.67	1.0E-04	0.55222	0.00100	0.55423	_2_5_4_6	0.83876	0.00144	0.84163
_2_6_4_6	1.4	0.6	4000	3600	8829	68.67	1.0E-04	0.54866	0.00099	0.55063	_2_6_4_6	0.83719	0.00119	0.83958
_6_2_5_3	1.4	80.0	5563	4450	9289	54.48	1.0E-04	0.91987	0.00157	0.92301				
_2_2_6_5	1.4	0.2	6000	4800	8723	50.93	1.0E-04	0.67004	0.00099	0.67203	_2_2_6_5	0.87714	0.00150	0.88015
_2_3_6_5	1.4	0.3	6000	4800	8723	50.93	1.0E-04	0.63588	0.00098	0.63783	_2_3_6_5	0.87335	0.00149	0.87633
_2_4_6_5	1.4	0.4	6000	4800	8723	50.93	1.0E-04	0.61580	0.00114	0.61809	_2_4_6_5	0.87067	0.00120	0.87306
_2_5_6_5	1.4	0.5	6000	4800	8723	50.93	1.0E-04	0.60063	0.00111	0.60284	_2_5_6_5	0.87386	0.00137	0.87660
_2_6_6_5	1.4	0.6	6000	4800	8723	50.93	1.0E-04	0.59340	0.00097	0.59534	_2_6_6_5	0.87070	0.00141	0.87353

Table 6.9.6-11c. Comparison of HAC results for HEU broken metal content in ES-3100 HAC packaging calculation models

Note: Reference results for content homogenized over volume of containment vessel are highlighted. Results are for modified cases where the HEU packaging fraction varies from 0.2 to 0.6 and the content is homogenized with 500 g polyethylene.

hciabmt12*	np (in.)	Enr. (wt %)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$				
hciapbmflt12*	**np (in.)**	**PF**	**U (g)**	**^{235}U (g)**	**H_2O (g)**	**h/x**	**MOIFR**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**	**hciapbmfdt12**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**
_8_2_4_3	1.4	70.0	7426	5198	9191	46.15	1.0E-04	0.91835	0.00126	0.92086				
_2_2_8_4	1.4	0.2	8000	5600	8618	43.16	1.0E-04	0.70405	0.00125	0.70655	_2_2_8_4	0.88804	0.00136	0.89077
_2_3_8_4	1.4	0.3	8000	5600	8618	43.16	1.0E-04	0.66628	0.00114	0.66856	_2_3_8_4	0.88503	0.00118	0.88740
_2_4_8_4	1.4	0.4	8000	5600	8618	43.16	1.0E-04	0.64431	0.00125	0.64681	_2_4_8_4	0.88186	0.00141	0.88467
_2_5_8_4	1.4	0.5	8000	5600	8618	43.16	1.0E-04	0.62989	0.00106	0.63201	_2_5_8_4	0.88416	0.00142	0.88701
_2_6_8_4	1.4	0.6	8000	5600	8618	43.16	1.0E-04	0.61934	0.00096	0.62126	_2_6_8_4	0.88358	0.00130	0.88618
_12_2_3_3	1.4	60.0	11154	6692	8995	35.08	1.0E-04	0.91776	0.00138	0.92053				
_2_2_12_3	1.4	0.2	12000	7200	8407	32.81	1.0E-04	0.75872	0.00115	0.76102	_2_2_12_3	0.90576	0.00134	0.90845
_2_3_12_3	1.4	0.3	12000	7200	8407	32.81	1.0E-04	0.71743	0.00106	0.71954	_2_3_12_3	0.90165	0.00138	0.90440
_2_4_12_3	1.4	0.4	12000	7200	8407	32.81	1.0E-04	0.69072	0.00115	0.69301	_2_4_12_3	0.90012	0.00124	0.90260
_2_5_12_3	1.4	0.5	12000	7200	8407	32.81	1.0E-04	0.67462	0.00099	0.67660	_2_5_12_3	0.89870	0.00124	0.90118
_2_6_12_3	1.4	0.6	12000	7200	8407	32.81	1.0E-04	0.66490	0.00106	0.66702	_2_6_12_3	0.90032	0.00117	0.90267

Table 6.9.6-11d. Comparison of results for the 277-4 canned spacer under the nominal and minimal acceptance criteria for HEU broken metal content in ES-3100 HAC packaging calculation models

Note: Reference Cases **hciabmt12** selected from Table 6.9.6-11 are based for the nominal 277-4 canned spacer. These cases which establish loading limits were rerun with SCALE5, indicated as Cases **5hciabmt12** where case results are highlighted in yellow. The results for the corresponding Cases **5_401by131** for the 277-4 canned spacer sized per the minimal acceptance criteria are presented on the lines below. An absolute value of the quantity " **$(\Delta k_{eff}+2\sigma)/\sigma$** " >3 indicates that a statistically significant difference occurs between the case results.

5hciabmt12*	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$		
5_401by131*	**np (in.)**	**U (g)**	**^{235}U (g)**	**H_2O (g)**	**h/x**	**MOIFR**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**	**$\Delta k_{eff}+2\sigma$**	**$(\Delta k_{eff}+2\sigma)/\sigma$**
content in flooded containment vessel, array packaging model for CSI=0.0											
with can spacers											
_3_2_8_3	1.40	2774	2774	9436	88.78	1.0E-04	0.90362	0.00128	0.90619		
_3_2_8_3	1.31	2774	2774	9507	89.44	1.0E-04	0.90271	0.00146	0.90563	0.00056	0.38
_4_2_7_3	1.40	3701	3516	9387	69.68	1.0E-04	0.91873	0.00154	0.92182		
_4_2_7_3	1.31	3701	3516	9458	70.20	1.0E-04	0.91848	0.00149	0.92145	0.00037	0.25
_4_2_6_3	1.40	3704	3333	9387	73.50	1.0E-04	0.90865	0.00143	0.91151		
_4_2_6_3	1.31	3704	3333	9458	74.06	1.0E-04	0.90937	0.00139	0.91216	-0.00065	-0.47
_6_2_5_3	1.40	5563	4450	9289	54.48	1.0E-04	0.92059	0.00142	0.92344		
_6_2_5_3	1.31	5563	4450	9360	54.90	1.0E-04	0.92273	0.00125	0.92524	-0.00180	-1.44
_8_2_4_3	1.40	7426	5198	9191	46.15	1.0E-04	0.91790	0.00124	0.92039		
_8_2_4_3	1.31	7426	5198	9262	46.50	1.0E-04	0.92080	0.00183	0.92445	-0.00406	-2.22

Table 6.9.6-11d. Comparison of results for the 277-4 canned spacer under the nominal and minimal acceptance criteria for HEU broken metal content in ES-3100 HAC packaging calculation models

Note: Reference Cases **hciabmt12** selected from Table 6.9.6-11 are based for the nominal 277-4 canned spacer. These cases which establish loading limits were rerun with SCALE5, indicated as Cases **5hciabmt12** where case results are highlighted in yellow. The results for the corresponding Cases **5_401by131** for the 277-4 canned spacer sized per the minimal acceptance criteria are presented on the lines below. An absolute value of the quantity " **$(\Delta k_{eff}+2\sigma)/\sigma$** " >3 indicates that a statistically significant difference occurs between the case results.

5hciabmt12*	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$		
5_401by131*	np (in.)	U (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	$\Delta k_{eff}+2\sigma$	$(\Delta k_{eff}+2\sigma)/\sigma$
_12_2_3_3	1.40	11154	6692	8995	35.08	1.0E-04	0.91638	0.00127	0.91892		
_12_2_3_3	1.31	11154	6692	9065	35.36	1.0E-04	0.91711	0.00133	0.91978	-0.00086	-0.65

Table 6.9.6-12. Results for HEU oxide content in CV calculation model

Case cvcrpdoxt11*	Ox (g)	^{235}U (g)	Ox density (g/cm^3)	Ox volume (cm^3)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
UO_2 content, 500 g polyethylene, flooded containment vessel, reflected											
_1_3_24_15	24000	21125	4.00	6000	3803	3665	10.02	1.0E+00	0.91157	0.00138	0.91434
_1_4_24_15	24000	21125	5.00	4800	2606	4863	10.02	1.0E+00	0.90264	0.00139	0.90541
_1_5_24_15	24000	21125	6.54	5000	1477	5991	10.02	1.0E+00	0.89152	0.00115	0.89382
_1_2_20_15	20000	17604	3.00	6667	4833	3000	12.57	1.0E+00	0.90943	0.00117	0.91177
_1_3_20_15	20000	17604	4.00	5000	3170	4663	12.57	1.0E+00	0.89797	0.00129	0.90055
_1_4_20_15	20000	17604	5.00	4000	2171	5662	12.57	1.0E+00	0.89035	0.00121	0.89278
_1_5_20_15	20000	17604	6.54	3058	1231	6602	12.57	1.0E+00	0.87565	0.00112	0.87789
_1_2_15_15	15000	13203	3.00	5000	3625	4664	17.66	1.0E+00	0.89891	0.00138	0.90166

Table 6.9.6-12. Results for HEU oxide content in CV calculation model

Case cvcrpdoxt11*	Ox (g)	^{235}U (g)	Ox density (g/cm^3)	Ox volume (cm^3)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
_1_3_15_15	15000	13203	4.00	3750	2377	5911	17.66	1.0E+00	0.87963	0.00116	0.88195
_1_4_15_15	15000	13203	5.00	3000	1629	6660	17.66	1.0E+00	0.86309	0.00134	0.86578
_1_5_15_15	15000	13203	6.54	2294	923	7365	17.66	1.0E+00	0.84270	0.00121	0.84513
14,000 g UO_2 content, 500 g polyethylene, flooded containment vessel, reflected											
_1_1_14_15	14000	12323	2.00	7000	5712	2667	19.11	1.0E+00	0.90801	0.00154	0.91110
_1_2_14_15	14000	12323	3.00	4667	3383	4996	19.11	1.0E+00	0.89261	0.00124	0.89510
_1_3_14_15	14000	12323	4.00	3500	2219	6161	19.11	1.0E+00	0.87604	0.00119	0.87842
_1_4_14_15	14000	12323	5.00	2800	1520	6860	19.11	1.0E+00	0.85585	0.00139	0.85863
_1_5_14_15	14000	12323	6.54	2141	862	7518	19.11	1.0E+00	0.83530	0.00112	0.83755
14,000 g U_3O_8 content, 500 g polyethylene, flooded containment vessel, reflected											
_2_1_14_15	14000	11850	2.00	7000	5304	2667	18.97	1.0E+00	0.88331	0.00144	0.88620
_2_2_14_15	14000	11850	3.00	4667	2975	4996	18.97	1.0E+00	0.85075	0.00129	0.85333
_2_3_14_15	14000	11850	4.00	3500	1810	6161	18.97	1.0E+00	0.82386	0.00123	0.82632
_2_4_14_15	14000	11850	5.00	2800	1111	6860	18.97	1.0E+00	0.79922	0.00143	0.80209
_2_5_14_15	14000	11850	6.54	2141	453	7518	18.97	1.0E+00	0.76510	0.00114	0.76738
14,000 g UO_3 content, 500 g polyethylene, flooded containment vessel, reflected											
_3_1_14_15	14000	11627	2.00	7000	5071	2667	18.81	1.0E+00	0.86835	0.00122	0.87079
_3_2_14_15	14000	11627	3.00	4667	2741	4996	18.81	1.0E+00	0.83069	0.00119	0.83307
_3_3_14_15	14000	11627	4.00	3500	1577	6161	18.81	1.0E+00	0.79457	0.00132	0.79720
_3_4_14_15	14000	11627	5.00	2800	878	6860	18.81	1.0E+00	0.76399	0.00140	0.76679
_3_5_14_15	14000	11627	6.54	2141	220	7518	18.81	1.0E+00	0.72235	0.00127	0.72490

Table 6.9.6-12. Results for HEU oxide content in CV calculation model

Case cvcrpdoxt11*	Ox (g)	^{235}U (g)	Ox density (g/cm^3)	Ox volume (cm^3)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
14,000 g UO_2 content, 500 g polyethylene, dry containment vessel, reflected											
_1_1_14_1	14000	12323	2.00	7000	5712	0	13.46	1.0E-20	0.90869	0.00156	0.91180
_1_2_14_1	14000	12323	3.00	4667	3383	0	8.53	1.0E-20	0.88628	0.00144	0.88916
_1_3_14_1	14000	12323	4.00	3500	2219	0	6.06	1.0E-20	0.86750	0.00131	0.87012
_1_4_14_1	14000	12323	5.00	2800	1520	0	4.58	1.0E-20	0.84555	0.00151	0.84857
_1_5_14_1	14000	12323	6.54	2141	862	0	3.19	1.0E-20	0.82157	0.00109	0.82375
UO_2 content, 2.0 g/cm^3 oxide density, 500 g polyethylene, flooded containment vessel, reflected											
_1_1_14_15	14000	12323	2.00	7000	5712	2667	19.11	1.0E+00	0.90801	0.00154	0.91110
_1_1_13_15	13000	11443	2.00	6500	5304	3166	20.79	1.0E+00	0.91011	0.00123	0.91258
_1_1_12_15	12000	10562	2.00	6000	4896	3665	22.74	1.0E+00	0.90176	0.00141	0.90457
_1_1_11_15	11000	9682	2.00	5500	4488	4164	25.06	1.0E+00	0.89737	0.00154	0.90044
_1_1_10_15	10000	8802	2.00	5000	4080	4663	27.83	1.0E+00	0.89620	0.00130	0.89880
_1_1_9_15	9000	7922	2.00	4500	3672	5163	31.23	1.0E+00	0.88551	0.00161	0.88872
_1_1_8_15	8000	7042	2.00	4000	3264	5662	35.47	1.0E+00	0.87598	0.00157	0.87912
_1_1_7_15	7000	6162	2.00	3500	2856	6161	40.92	1.0E+00	0.86765	0.00148	0.87061
_1_1_6_15	6000	5281	2.00	3000	2448	6660	48.19	1.0E+00	0.85412	0.00120	0.85652
_1_1_5_15	5000	4401	2.00	2500	2040	7159	58.37	1.0E+00	0.83022	0.00138	0.83298
_1_1_4_15	4000	3521	2.00	2000	1632	7658	73.63	1.0E+00	0.80856	0.00156	0.81168
_1_1_3_15	3000	2641	2.00	1500	1224	8157	99.08	1.0E+00	0.77245	0.00147	0.77539
_1_1_2_15	2000	1761	2.00	1000	816	8656	149.96	1.0E+00	0.72062	0.00132	0.72326
_1_1_1_15	1000	880	2.00	500	408	9155	302.58	1.0E+00	0.63401	0.00126	0.63653

Table 6.9.6-12a. Results for Low Density HEU oxide content with 500 g polyethylene in CV calculation model

Case cvcrldoxt11*	Ox (kg)	^{235}U (kg)	Ox density (g/cm^3)	Ox volume (cm^3)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	USL
UO_2 content, 500 g polyethylene, dry containment vessel (MOCFR=1.0E-20) reflected									
_1_20_1	16.0	14.083	1.75	9,143	7.669	0.91580	0.00120	0.91820	0.9350
_1_19_1	15.0	13.203	1.75	8,571	7.190	0.91190	0.00130	0.91450	0.9350
_1_18_1	14.0	12.323	1.75	8,000	6.711	0.91110	0.00120	0.91350	0.9350
_1_17_1	13.0	11.443	1.75	7,429	6.231	0.90410	0.00110	0.90630	0.9350
_1_16_1	12.0	10.562	1.75	6,857	5.752	0.90180	0.00100	0.90380	0.9350
_2_18_1	14.0	12.323	1.50	9,333	8.042	0.91400	0.00190	0.91780	0.9350
_2_17_1	13.0	11.443	1.50	8,667	7.467	0.91090	0.00140	0.91370	0.9350
_2_16_1	12.0	10.562	1.50	8,000	6.893	0.90910	0.00140	0.91190	0.9350
_2_15_1	11.0	9.682	1.50	7,333	6.318	0.90440	0.00160	0.90760	0.9350
_2_14_1	10.0	8.802	1.50	6,667	5.744	0.90430	0.00160	0.90750	0.9350
_3_16_1	12.0	10.562	1.25	9,600	8.490	0.91300	0.00130	0.91560	0.9350
_3_15_1	11.0	9.682	1.25	8,800	7.782	0.91040	0.00170	0.91380	0.9350
_3_14_1	10.0	8.802	1.25	8,000	7.075	0.90980	0.00130	0.91240	0.9350
_3_13_1	9.0	7.922	1.25	7,200	6.367	0.90370	0.00170	0.90710	0.9350
_3_12_1	8.0	7.042	1.25	6,400	5.660	0.89720	0.00140	0.90000	0.9350
_4_13_1	9.0	7.922	1.0	9,000	8.164	0.90810	0.00150	0.91110	0.9350
_4_12_1	8.0	7.042	1.0	8,000	7.257	0.90380	0.00130	0.90640	0.9350
_4_11_1	7.0	6.161	1.0	7,000	6.350	0.89890	0.00140	0.90170	0.9350
_4_10_1	6.0	5.281	1.0	6,000	5.443	0.89120	0.00120	0.89360	0.9350
_4_9_1	5.0	4.401	1.0	5,000	4.537	0.87800	0.00130	0.88060	0.9350

Table 6.9.6-12a. Results for Low Density HEU oxide content with 500 g polyethylene in CV calculation model

Case cvcrldoxt11*	Ox (kg)	^{235}U (kg)	Ox density (g/cm^3)	Ox volume (cm^3)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_5_11_1	7.0	6.161	0.75	9,333	8.679	0.90400	0.00100	0.90600	0.9350
_5_10_1	6.0	5.281	0.75	8,000	7.439	0.90130	0.00130	0.90390	0.9350
_5_9_1	5.0	4.401	0.75	6,667	6.199	0.88800	0.00150	0.89100	0.9350
_5_8_1	4.5	3.961	0.75	6,000	5.579	0.88160	0.00120	0.88400	0.9350
_5_7_1	4.0	6.521	0.75	5,333	4.959	0.87560	0.00150	0.87860	0.9350
_6_8_1	4.5	3.961	0.5	9,000	8.574	0.89150	0.00140	0.89430	0.9350
_6_7_1	4.0	3.521	0.5	8,000	7.621	0.88480	0.00150	0.88780	0.9350
_6_6_1	3.5	3.081	0.5	7,000	6.669	0.87830	0.00120	0.88070	0.9350
_6_5_1	3.0	2.641	0.5	6,000	5.716	0.87030	0.00170	0.87370	0.9350
UO_2 content, 500 g polyethylene, flooded containment vessel (MOCFR=1.0) reflected									
_1_20_15	16.0	14.083	1.75	9,143	7.669	0.91720	0.00120	0.91960	0.9350
_1_19_15	15.0	13.203	1.75	8,571	7.190	0.91410	0.00150	0.91710	0.9350
_1_18_15	14.0	12.323	1.75	8,000	6.711	0.91260	0.00130	0.91520	0.9350
_1_17_15	13.0	11.443	1.75	7,429	6.231	0.91020	0.00130	0.91280	0.9350
_1_16_15	12.0	10.562	1.75	6,857	5.752	0.90630	0.00130	0.90890	0.9350
_2_18_15	14.0	12.323	1.50	9,333	8.042	0.91280	0.00130	0.91540	0.9350
_2_17_15	13.0	11.443	1.50	8,667	7.467	0.91580	0.00180	0.91940	0.9350
_2_16_15	12.0	10.562	1.50	8,000	6.893	0.91050	0.00140	0.91330	0.9350
_2_15_15	11.0	9.682	1.50	7,333	6.318	0.90600	0.00190	0.90980	0.9350
_2_14_15	10.0	8.802	1.50	6,667	5.744	0.90380	0.00140	0.90660	0.9350

Table 6.9.6-12a. Results for Low Density HEU oxide content with 500 g polyethylene in CV calculation model

Case cvcrldoxt11*	Ox (kg)	^{235}U (kg)	Ox density (g/cm^3)	Ox volume (cm^3)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_3_16_15	12.0	10.562	1.25	9,600	8.490	0.91730	0.00160	0.92050	0.9350
_3_15_15	11.0	9.682	1.25	8,800	7.782	0.91200	0.00120	0.91440	0.9350
_3_14_15	10.0	8.802	1.25	8,000	7.075	0.90830	0.00130	0.91090	0.9350
_3_13_15	9.0	7.922	1.25	7,200	6.367	0.90560	0.00120	0.90800	0.9350
_3_12_15	8.0	7.042	1.25	6,400	5.660	0.89920	0.00130	0.90180	0.9350
_4_13_15	9.0	7.922	1.0	9,000	8.164	0.90810	0.00150	0.91110	0.9350
_4_12_15	8.0	7.042	1.0	8,000	7.257	0.90380	0.00130	0.90640	0.9350
_4_11_15	7.0	6.161	1.0	7,000	6.350	0.89890	0.00140	0.90170	0.9350
_4_10_15	6.0	5.281	1.0	6,000	5.443	0.89120	0.00120	0.89360	0.9350
_4_9_15	5.0	4.401	1.0	5,000	4.537	0.87800	0.00130	0.88060	0.9350
_5_11_15	7.0	6.161	0.75	9,333	8.679	0.90400	0.00100	0.90600	0.9350
_5_10_15	6.0	5.281	0.75	8,000	7.439	0.90130	0.00130	0.90390	0.9350
_5_9_15	5.0	4.401	0.75	6,667	6.199	0.88800	0.00150	0.89100	0.9350
_5_8_15	4.5	3.961	0.75	6,000	5.579	0.88160	0.00120	0.88400	0.9350
_5_7_15	4.0	6.521	0.75	5,333	4.959	0.87560	0.00150	0.87860	0.9350
_6_8_15	4.5	3.961	0.5	9,000	8.574	0.89150	0.00140	0.89430	0.9350
_6_7_15	4.0	3.521	0.5	8,000	7.621	0.88480	0.00150	0.88780	0.9350
_6_6_15	3.5	3.081	0.5	7,000	6.669	0.87830	0.00120	0.88070	0.9350
_6_5_15	3.0	2.641	0.5	6,000	5.716	0.87030	0.00170	0.87370	0.9350

Table 6.9.6-12b. Results for HEU oxide/thorium oxide content with 500 g polyethylene in CV calculation model

Case cvcrldoxtho2t11*	Ox density (g/cm^3)	Ox (kg)	^{235}U (kg)	ThOx (kg)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	USL
UO_2-ThO_2 content, 500 g polyethylene, flooded containment vessel (MOCFR=1.0) reflected									
_1_1_5	2.0	8.0	7.042	0.0	3.264	0.87360	0.00073	0.87506	0.93520
_3_1_5	2.0	8.0	7.042	2.0	4.063	0.85937	0.00076	0.86089	0.93520
_5_1_5	2.0	8.0	7.042	4.0	4.861	0.85252	0.00079	0.85410	0.93520
_7_1_5	2.0	8.0	7.042	6.0	5.660	0.84533	0.00087	0.84707	0.93520
_9_1_5	2.0	8.0	7.042	8.0	6.458	0.83790	0.00075	0.83940	0.93520
_1_1_6	2.0	10.0	8.802	0.0	4.080	0.88779	0.00075	0.88929	0.93520
_3_1_6	2.0	10.0	8.802	2.0	4.879	0.87409	0.00075	0.87559	0.93520
_5_1_6	2.0	10.0	8.802	4.0	5.677	0.86631	0.00077	0.86785	0.93520
_7_1_6	2.0	10.0	8.802	6.0	6.476	0.85847	0.00084	0.86015	0.93520
_1_1_7	2.0	11.0	9.682	0.0	4.488	0.89471	0.00081	0.89633	0.93520
_3_1_7	2.0	11.0	9.682	2.0	5.287	0.88092	0.00069	0.88230	0.93520
_5_1_7	2.0	11.0	9.682	4.0	6.085	0.87108	0.00084	0.87276	0.93520
_6_1_7	2.0	11.0	9.682	5.0	6.485	0.86617	0.00073	0.86763	0.93520
_7_1_7	2.0	11.0	9.682	6.0	6.884	0.86228	0.00078	0.86384	0.93520
_1_2_5	1.75	8.0	7.042	0.0	3.835	0.88307	0.00085	0.88477	0.93520
_3_2_5	1.75	8.0	7.042	2.0	4.776	0.86844	0.00079	0.87002	0.93520
_5_2_5	1.75	8.0	7.042	4.0	5.717	0.85932	0.00074	0.86080	0.93520
_7_2_5	1.75	8.0	7.042	6.0	6.658	0.85304	0.00067	0.85438	0.93520
_9_2_5	1.75	8.0	7.042	8.0	7.599	0.84463	0.00076	0.84615	0.93520
_1_2_6	1.75	10.0	8.802	0.0	4.793	0.89618	0.00074	0.89766	0.93520
_3_2_6	1.75	10.0	8.802	2.0	5.734	0.88283	0.00075	0.88433	0.93520
_5_2_6	1.75	10.0	8.802	4.0	6.676	0.87141	0.00070	0.87281	0.93520

Table 6.9.6-12b. Results for HEU oxide/thorium oxide content with 500 g polyethylene in CV calculation model

Case cvcrldoxtho2t11*	Ox density (g/cm^3)	Ox (kg)	^{235}U (kg)	ThOx (kg)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_7_2_6	1.75	10.0	8.802	6.0	7.617	0.86475	0.00072	0.86619	0.93520
_1_2_7	1.75	11.0	9.682	0.0	5.273	0.90224	0.00080	0.90384	0.93520
_3_2_7	1.75	11.0	9.682	2.0	6.214	0.88654	0.00084	0.88822	0.93520
_5_2_7	1.75	11.0	9.682	4.0	7.155	0.87791	0.00081	0.87953	0.93520
_6_2_7	1.75	11.0	9.682	5.0	7.626	0.87201	0.00069	0.87339	0.93520
_1_3_5	1.5	8.0	7.042	0.0	4.595	0.89098	0.00075	0.89248	0.93520
_3_3_5	1.5	8.0	7.042	2.0	5.726	0.87860	0.00100	0.88060	0.93520
_5_3_5	1.5	8.0	7.042	4.0	6.858	0.86760	0.00080	0.86920	0.93520
_7_3_5	1.5	8.0	7.042	6.0	7.989	0.86084	0.00080	0.86244	0.93680
_1_3_6	1.5	10.0	8.802	0.0	5.744	0.90360	0.00081	0.90522	0.93520
_3_3_6	1.5	10.0	8.802	2.0	6.875	0.88812	0.00071	0.88954	0.93520
_5_3_6	1.5	10.0	8.802	4.0	8.007	0.87816	0.00078	0.87972	0.93520
_1_3_7	1.5	11.0	9.682	0.0	6.318	0.90764	0.00096	0.90956	0.93520
_3_3_7	1.5	11.0	9.682	2.0	7.450	0.89264	0.00077	0.89418	0.93520
_4_3_7	1.5	11.0	9.682	3.0	8.015	0.88725	0.00072	0.88869	0.93520
_1_4_5	1.25	8.0	7.042	0.0	5.660	0.89987	0.00085	0.90157	0.93520
_3_4_5	1.25	8.0	7.042	2.0	7.057	0.88502	0.00082	0.88666	0.93520
_5_4_5	1.25	8.0	7.042	4.0	8.455	0.87347	0.00092	0.87531	0.93680
_1_4_6	1.25	10.0	8.802	0.0	7.075	0.90872	0.00076	0.91024	0.93520
_3_4_6	1.25	10.0	8.802	2.0	8.472	0.89364	0.00075	0.89514	0.93520
_1_3_7	1.25	11.0	9.682	0.0	7.782	0.91099	0.00078	0.91255	0.93520
_2_3_7	1.25	11.0	9.682	1.0	8.481	0.90465	0.00077	0.90619	0.93520

Table 6.9.6-12b. Results for HEU oxide/thorium oxide content with 500 g polyethylene in CV calculation model

Case cvcrldoxtho2t11*	Ox density (g/cm^3)	Ox (kg)	^{235}U (kg)	ThOx (kg)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_1_5_3	1.0	5.0	4.401	0.0	4.537	0.88215	0.00076	0.88367	0.93520
_3_5_3	1.0	5.0	4.401	2.0	6.332	0.86736	0.00084	0.86904	0.93680
_5_5_3	1.0	5.0	4.401	4.0	8.129	0.85577	0.00079	0.85735	0.93680
_1_5_4	1.0	6.0	5.281	0.0	5.443	0.89316	0.00078	0.89472	0.93520
_3_5_4	1.0	6.0	5.281	2.0	7.240	0.87955	0.00071	0.88097	0.93520
_4_5_4	1.0	6.0	5.281	3.0	8.138	0.87233	0.00079	0.87391	0.93520
_1_5_5	1.0	8.0	7.042	0.0	7.257	0.90779	0.00075	0.90929	0.93520
_2_5_5	1.0	8.0	7.042	1.0	8.155	0.89632	0.00092	0.89816	0.93520
_1_6_2	0.75	4.0	3.521	0.0	4.959	0.87903	0.00073	0.88049	0.93680
_3_6_2	0.75	4.0	3.521	2.0	7.422	0.86050	0.00100	0.86250	0.93680
_4_6_2	0.75	4.0	3.521	3.0	8.653	0.85272	0.00074	0.85420	0.93680
_1_6_3	0.75	5.0	4.401	0.0	6.199	0.89218	0.00087	0.89392	0.93680
_2_6_3	0.75	5.0	4.401	1.0	7.430	0.88199	0.00076	0.88351	0.93680
_3_6_3	0.75	5.0	4.401	2.0	8.662	0.87189	0.00074	0.87337	0.93680
_1_6_4	0.75	6.0	5.281	0.0	7.439	0.90244	0.00078	0.90400	0.93680
_2_6_4	0.75	6.0	5.281	1.0	8.670	0.89133	0.00086	0.89305	0.93680
_1_7_1	0.5	3.0	2.641	0.0	5.716	0.87066	0.00082	0.87230	0.93680
_1_7_1	0.5	3.0	2.641	1.0	7.613	0.8567	0.001	0.85870	0.93680
_2_7_1	0.5	4.0	3.521	0.0	7.621	0.88794	0.00087	0.88968	0.93520

Table 6.9.6-12c. Results for HEU oxide/zirconium oxide content with 500 g polyethylene in CV calculation model

Case cvcrldoxzro2t11*	Ox density (g/cm^3)	Ox (kg)	^{235}U (kg)	ZrOx (kg)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	USL
UO_2-ZrO_2 content, 500 g polyethylene, flooded containment vessel (MOCFR=1.0) reflected									
_1_1_5	2.0	8.0	7.042	0.0	3.264	0.87273	0.00083	0.87439	0.93520
_3_1_5	2.0	8.0	7.042	2.0	3.911	0.86564	0.00079	0.86722	0.93520
_5_1_5	2.0	8.0	7.042	4.0	4.558	0.85475	0.00083	0.85641	0.93520
_7_1_5	2.0	8.0	7.042	6.0	5.204	0.84858	0.00085	0.85028	0.93520
_9_1_5	2.0	8.0	7.042	8.0	5.851	0.84449	0.00084	0.84617	0.93520
_1_1_6	2.0	10.0	8.802	0.0	4.080	0.88965	0.00082	0.89129	0.93520
_3_1_6	2.0	10.0	8.802	2.0	4.727	0.88035	0.00075	0.88185	0.93520
_5_1_6	2.0	10.0	8.802	4.0	5.374	0.86714	0.00074	0.86862	0.93520
_7_1_6	2.0	10.0	8.802	6.0	6.020	0.86063	0.00074	0.86211	0.93520
_1_1_7	2.0	11.0	9.682	0.0	4.488	0.89396	0.00082	0.89560	0.93520
_3_1_7	2.0	11.0	9.682	2.0	5.135	0.88412	0.00071	0.88554	0.93520
_5_1_7	2.0	11.0	9.682	4.0	5.782	0.87376	0.00078	0.87532	0.93520
_6_1_7	2.0	11.0	9.682	5.0	6.105	0.87140	0.00081	0.87302	0.93520
_1_2_5	1.75	8.0	7.042	0.0	3.835	0.88144	0.00072	0.88288	0.93520
_3_2_5	1.75	8.0	7.042	2.0	4.624	0.87505	0.00094	0.87693	0.93520
_5_2_5	1.75	8.0	7.042	4.0	5.413	0.86673	0.00084	0.86841	0.93520
_7_2_5	1.75	8.0	7.042	6.0	6.203	0.85835	0.00078	0.85991	0.93520
_9_2_5	1.75	8.0	7.042	8.0	6.992	0.85319	0.00088	0.85495	0.93520
_1_2_6	1.75	10.0	8.802	0.0	4.793	0.89560	0.00096	0.89752	0.93520
_3_2_6	1.75	10.0	8.802	2.0	5.583	0.88633	0.00080	0.88793	0.93520
_5_2_6	1.75	10.0	8.802	4.0	6.372	0.87836	0.00091	0.88018	0.93520
_7_2_6	1.75	10.0	8.802	6.0	7.161	0.87188	0.00089	0.87366	0.93520

Table 6.9.6-12c. Results for HEU oxide/zirconium oxide content with 500 g polyethylene in CV calculation model

Case cvcrldoxzro2t11*	Ox density (g/cm^3)	Ox (kg)	^{235}U (kg)	ZrOx (kg)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_1_2_7	1.75	11.0	9.682	0.0	5.273	0.90125	0.00075	0.90275	0.93520
_3_2_7	1.75	11.0	9.682	2.0	6.062	0.89108	0.00089	0.89286	0.93520
_5_2_7	1.75	11.0	9.682	4.0	6.821	0.88311	0.00082	0.88475	0.93520
_6_2_7	1.75	11.0	9.682	5.0	7.246	0.87875	0.00074	0.88023	0.93520
_1_3_5	1.5	8.0	7.042	0.0	4.595	0.89059	0.00072	0.89203	0.93520
_3_3_5	1.5	8.0	7.042	2.0	5.575	0.88359	0.00083	0.88525	0.93520
_5_3_5	1.5	8.0	7.042	4.0	6.554	0.87520	0.00080	0.87680	0.93520
_7_3_5	1.5	8.0	7.042	6.0	7.534	0.86671	0.00077	0.86825	0.93680
_1_3_6	1.5	10.0	8.802	0.0	5.744	0.90241	0.00089	0.90419	0.93520
_3_3_6	1.5	10.0	8.802	2.0	6.723	0.89481	0.00081	0.89643	0.93520
_5_3_6	1.5	10.0	8.802	4.0	7.703	0.88518	0.00077	0.88672	0.93520
_1_3_7	1.5	11.0	9.682	0.0	6.318	0.90732	0.00077	0.90886	0.93520
_3_3_7	1.5	11.0	9.682	2.0	7.298	0.89855	0.00089	0.90033	0.93520
_4_3_7	1.5	11.0	9.682	3.0	7.788	0.89202	0.00090	0.89382	0.93520
_1_4_5	1.25	8.0	7.042	0.0	5.660	0.89830	0.00093	0.90016	0.93520
_3_4_5	1.25	8.0	7.042	2.0	6.906	0.89077	0.00097	0.89271	0.93520
_5_4_5	1.25	8.0	7.042	4.0	8.151	0.88450	0.00083	0.88616	0.93680
_1_4_6	1.25	10.0	8.802	0.0	7.075	0.91037	0.00070	0.91177	0.93520
_3_4_6	1.25	10.0	8.802	2.0	8.321	0.89968	0.00084	0.90136	0.93520
_1_3_7	1.25	11.0	9.682	0.0	7.782	0.91271	0.00082	0.91435	0.93520
_2_3_7	1.25	11.0	9.682	1.0	8.405	0.90761	0.00087	0.90935	0.93520

Table 6.9.6-12c. Results for HEU oxide/zirconium oxide content with 500 g polyethylene in CV calculation model

Case cvcrldoxzro2t11*	Ox density (g/cm^3)	Ox (kg)	^{235}U (kg)	ZrOx (kg)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_1_5_3	1.0	5.0	4.401	0.0	4.537	0.88161	0.00079	0.88319	0.93520
_3_5_3	1.0	5.0	4.401	2.0	6.181	0.87478	0.00089	0.87656	0.93680
_5_5_3	1.0	5.0	4.401	4.0	7.826	0.86619	0.00093	0.86805	0.93680
_1_5_4	1.0	6.0	5.281	0.0	5.443	0.89316	0.00099	0.89514	0.93520
_3_5_4	1.0	6.0	5.281	2.0	7.088	0.88325	0.00075	0.88475	0.93680
_4_5_4	1.0	6.0	5.281	3.0	7.910	0.88043	0.00077	0.88197	0.93680
_1_5_5	1.0	8.0	7.042	0.0	7.257	0.90687	0.00096	0.90879	0.93520
_2_5_5	1.0	8.0	7.042	1.0	8.079	0.90160	0.00100	0.90360	0.93680
_1_6_2	0.75	4.0	3.521	0.0	4.959	0.87988	0.00096	0.88180	0.93680
_3_6_2	0.75	4.0	3.521	2.0	7.270	0.86998	0.00082	0.87162	0.93680
_4_6_2	0.75	4.0	3.521	3.0	8.425	0.86287	0.00073	0.86433	0.93680
_1_6_3	0.75	5.0	4.401	0.0	6.199	0.89243	0.00089	0.89421	0.93680
_2_6_3	0.75	5.0	4.401	1.0	7.355	0.88665	0.00089	0.88843	0.93680
_3_6_3	0.75	5.0	4.401	2.0	8.510	0.88082	0.00077	0.88236	0.93680
_1_6_4	0.75	6.0	5.281	0.0	7.439	0.89926	0.00079	0.90084	0.93680
_2_6_4	0.75	6.0	5.281	1.0	8.594	0.89432	0.00085	0.89602	0.93680
_1_7_1	0.5	3.0	2.641	0.0	5.716	0.87178	0.00087	0.87352	0.93680
_1_7_1	0.5	3.0	2.641	1.0	7.537	0.86289	0.00093	0.86475	0.93680
_2_7_1	0.5	4.0	3.521	0.0	7.621	0.88382	0.00083	0.88548	0.93680

Table 6.9.6-12d. Results for HEU oxide/thorium metal content with 500 g polyethylene in CV calculation model

Case cvcrldoxtht11*	Ox density (g/cm^3)	Ox (kg)	^{235}U (kg)	ThOx (kg)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	USL
UO_2-Th content, 500 g polyethylene, flooded containment vessel (MOCFR=1.0) reflected									
_1_1_5	2.0	8.0	7.042	0.0	3.264	0.87368	0.00092	0.87552	0.93520
_3_1_5	2.0	8.0	7.042	2.0	4.063	0.86033	0.00082	0.86197	0.93520
_5_1_5	2.0	8.0	7.042	4.0	4.861	0.85123	0.00088	0.85299	0.93520
_7_1_5	2.0	8.0	7.042	6.0	5.660	0.84468	0.00076	0.84620	0.93520
_9_1_5	2.0	8.0	7.042	8.0	6.458	0.83822	0.00083	0.83988	0.93520
_1_1_6	2.0	10.0	8.802	0.0	4.080	0.89000	0.00079	0.89158	0.93520
_3_1_6	2.0	10.0	8.802	2.0	4.879	0.87419	0.00080	0.87579	0.93520
_5_1_6	2.0	10.0	8.802	4.0	5.677	0.86459	0.00072	0.86603	0.93520
_7_1_6	2.0	10.0	8.802	6.0	6.476	0.85772	0.00086	0.85944	0.93520
_1_1_7	2.0	11.0	9.682	0.0	4.488	0.89440	0.00076	0.89592	0.93520
_3_1_7	2.0	11.0	9.682	2.0	5.287	0.88111	0.00074	0.88259	0.93520
_5_1_7	2.0	11.0	9.682	4.0	6.085	0.87023	0.00073	0.87169	0.93520
_6_1_7	2.0	11.0	9.682	5.0	6.485	0.86605	0.00071	0.86747	0.93520
_7_1_7	2.0	11.0	9.682	6.0	6.884	0.86274	0.00095	0.86464	0.93520
_1_2_5	1.75	8.0	7.042	0.0	3.835	0.88211	0.00083	0.88377	0.93520
_3_2_5	1.75	8.0	7.042	2.0	4.776	0.86680	0.00071	0.86822	0.93520
_5_2_5	1.75	8.0	7.042	4.0	5.717	0.86017	0.00078	0.86173	0.93520
_7_2_5	1.75	8.0	7.042	6.0	6.658	0.85133	0.00071	0.85275	0.93520
_9_2_5	1.75	8.0	7.042	8.0	7.599	0.84533	0.00080	0.84693	0.93520
_1_2_6	1.75	10.0	8.802	0.0	4.793	0.89641	0.00078	0.89797	0.93520
_3_2_6	1.75	10.0	8.802	2.0	5.734	0.88248	0.00078	0.88404	0.93520
_5_2_6	1.75	10.0	8.802	4.0	6.676	0.87123	0.00080	0.87283	0.93520

Table 6.9.6-12d. Results for HEU oxide/thorium metal content with 500 g polyethylene in CV calculation model

Case cvcrldoxtht11*	Ox density (g/cm^3)	Ox (kg)	^{235}U (kg)	ThOx (kg)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_7_2_6	1.75	10.0	8.802	6.0	7.617	0.86431	0.00099	0.86629	0.93520
_1_2_7	1.75	11.0	9.682	0.0	5.273	0.90125	0.00080	0.90285	0.93520
_3_2_7	1.75	11.0	9.682	2.0	6.214	0.88752	0.00085	0.88922	0.93520
_5_2_7	1.75	11.0	9.682	4.0	7.155	0.87734	0.00072	0.87878	0.93520
_6_2_7	1.75	11.0	9.682	5.0	7.626	0.87256	0.00075	0.87406	0.93520
_1_3_5	1.5	8.0	7.042	0.0	4.595	0.89241	0.00078	0.89397	0.93520
_3_3_5	1.5	8.0	7.042	2.0	5.726	0.87860	0.00100	0.88060	0.93520
_5_3_5	1.5	8.0	7.042	4.0	6.858	0.86898	0.00086	0.87070	0.93520
_7_3_5	1.5	8.0	7.042	6.0	7.989	0.85910	0.00100	0.86110	0.93680
_1_3_6	1.5	10.0	8.802	0.0	5.744	0.90420	0.00090	0.90600	0.93520
_3_3_6	1.5	10.0	8.802	2.0	6.875	0.88853	0.00088	0.89029	0.93520
_5_3_6	1.5	10.0	8.802	4.0	8.007	0.87808	0.00073	0.87954	0.93520
_1_3_7	1.5	11.0	9.682	0.0	6.318	0.90771	0.00079	0.90929	0.93520
_3_3_7	1.5	11.0	9.682	2.0	7.450	0.89407	0.00074	0.89555	0.93520
_4_3_7	1.5	11.0	9.682	3.0	8.015	0.88882	0.00074	0.89030	0.93520
_1_4_5	1.25	8.0	7.042	0.0	5.660	0.89983	0.00075	0.90133	0.93520
_3_4_5	1.25	8.0	7.042	2.0	7.057	0.88607	0.00090	0.88787	0.93520
_5_4_5	1.25	8.0	7.042	4.0	8.455	0.87399	0.00088	0.87575	0.93680
_1_4_6	1.25	10.0	8.802	0.0	7.075	0.90798	0.00096	0.90990	0.93520
_3_4_6	1.25	10.0	8.802	2.0	8.472	0.89316	0.00073	0.89462	0.93520
_1_3_7	1.25	11.0	9.682	0.0	7.782	0.91293	0.00089	0.91471	0.93520
_2_3_7	1.25	11.0	9.682	1.0	8.481	0.90319	0.00079	0.90477	0.93520

Table 6.9.6-12d. Results for HEU oxide/thorium metal content with 500 g polyethylene in CV calculation model

Case cvcrldoxtht11*	Ox density (g/cm^3)	Ox (kg)	^{235}U (kg)	ThOx (kg)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_1_5_3	1.0	5.0	4.401	0.0	4.537	0.88168	0.00080	0.88328	0.93520
_3_5_3	1.0	5.0	4.401	2.0	6.332	0.86765	0.00082	0.86929	0.93680
_5_5_3	1.0	5.0	4.401	4.0	8.129	0.85303	0.00086	0.85475	0.93680
_1_5_4	1.0	6.0	5.281	0.0	5.443	0.89357	0.00075	0.89507	0.93520
_3_5_4	1.0	6.0	5.281	2.0	7.240	0.87863	0.00079	0.88021	0.93520
_4_5_4	1.0	6.0	5.281	3.0	8.138	0.87191	0.00078	0.87347	0.93520
_1_5_5	1.0	8.0	7.042	0.0	7.257	0.90515	0.00080	0.90675	0.93520
_2_5_5	1.0	8.0	7.042	1.0	8.155	0.89636	0.00093	0.89822	0.93520
_1_6_2	0.75	4.0	3.521	0.0	4.959	0.87981	0.00082	0.88145	0.93680
_3_6_2	0.75	4.0	3.521	2.0	7.422	0.86100	0.00077	0.86254	0.93680
_4_6_2	0.75	4.0	3.521	3.0	8.653	0.85167	0.00071	0.85309	0.93680
_1_6_3	0.75	5.0	4.401	0.0	6.199	0.89247	0.00075	0.89397	0.93680
_2_6_3	0.75	5.0	4.401	1.0	7.430	0.88182	0.00093	0.88368	0.93680
_3_6_3	0.75	5.0	4.401	2.0	8.662	0.87360	0.00082	0.87524	0.93680
_1_6_4	0.75	6.0	5.281	0.0	7.439	0.89970	0.00097	0.90164	0.93680
_2_6_4	0.75	6.0	5.281	1.0	8.670	0.89970	0.00097	0.90164	0.93680
_1_7_1	0.5	3.0	2.641	0.0	5.716	0.87182	0.00082	0.87346	0.93680
_1_7_1	0.5	3.0	2.641	1.0	7.613	0.85687	0.00097	0.85881	0.93680
_2_7_1	0.5	4.0	3.521	0.0	7.621	0.88508	0.00079	0.88666	0.93520

Table 6.9.6-13. Results for HEU product oxide content at 6.54 g/cm^3 in single-unit packaging calculation model

Case	Ox (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOIFR	k_{eff}	σ	k_{eff}+2σ	Case	k_{eff}	σ	k_{eff}+2σ
UO_2 content and 500 g polyethylene in flooded containment vessel, single package reflected													
NCT										**HAC**			
ncsrpoxt11_1_24_1	24000	21125	1477	5991	10.02	1.0E-20	0.72148	0.00120	0.72388				
ncsrpoxt11_1_24_2	24000	21125	1477	5991	10.02	1.0E-05	0.71942	0.00107	0.72156				
ncsrpoxt11_1_24_3	24000	21125	1477	5991	10.02	0.0E+00	0.71790	0.00122	0.72035				
ncsrpoxt11_1_24_4	24000	21125	1477	5991	10.02	1.0E-03	0.72072	0.00154	0.72380				
ncsrpoxt11_1_24_5	24000	21125	1477	5991	10.02	1.0E-02	0.71999	0.00123	0.72244				
ncsrpoxt11_1_24_6	24000	21125	1477	5991	10.02	1.0E-01	0.72828	0.00103	0.73035				
ncsrpoxt11_1_24_8	24000	21125	1477	5991	10.02	3.0E-01	0.74362	0.00123	0.74607				
ncsrpoxt11_1_24_15	24000	21125	1477	5991	10.02	1.0E+00	0.80222	0.00108	0.80438				

Table 6.9.6-13a. Results for HEU oxide content in single-unit packaging calculation model

Case ncsrpdoxt11*	Ox (g)	^{235}U (g)	Ox den. (g/cm^3)	Ox vol. (cm^3)	Sat. H_2O (g)	CV H_2O (g)	h/x	k_{eff}	σ	k_{eff}+2σ	Case (hcsrpdoxt12*)	k_{eff}	σ	k_{eff}+2σ
NCT											**HAC**			
UO_2 content and 500 g polyethylene in flooded containment vessel, flooded package														
_1_3_24	24000	21125	4.00	6000	3803	3665	10.02	0.81371	0.00144	0.81659	_1_3_24	0.81599	0.00133	0.81865
_1_4_24	24000	21125	5.00	4800	2606	4863	10.02	0.80666	0.00111	0.80887	_1_4_24	0.81112	0.00119	0.81350
_1_5_24	24000	21125	6.54	3670	1477	5991	10.02	0.80222	0.00108	0.80438	_1_5_24	0.80624	0.00114	0.80852
_1_2_20	20000	17604	3.00	6667	4833	3000	12.57	0.81352	0.00155	0.81662	_1_2_20	0.81200	0.00136	0.81472
_1_3_20	20000	17604	4.00	5000	3170	4663	12.57	0.80451	0.00124	0.80698	_1_3_20	0.80524	0.00118	0.80760

Table 6.9.6-13a. Results for HEU oxide content in single-unit packaging calculation model

Case ncsrpdoxt11*	Ox (g)	^{235}U (g)	Ox den. (g/cm^3)	Ox vol. (cm^3)	Sat. H_2O (g)	CV H_2O (g)	h/x	k_{eff}	σ	$k_{eff}+2\sigma$	Case (hcsrpdoxt12*)	k_{eff}	σ	$k_{eff}+2\sigma$
_1_4_20	20000	17604	5.00	4000	2171	5662	12.57	0.79655	0.00129	0.79914	_1_4_20	0.79813	0.00137	0.80087
_1_5_20	20000	17604	6.54	3058	1231	6602	12.57	0.78510	0.00133	0.78775	_1_5_20	0.78801	0.00121	0.79043
_1_2_15	15000	13203	3.00	5000	3625	4664	17.66	0.79666	0.00133	0.79933	_1_2_15	0.79891	0.00149	0.80189
_1_3_15	15000	13203	4.00	3750	2377	5911	17.66	0.78374	0.00123	0.78619	_1_3_15	0.78801	0.00130	0.79061
_1_4_15	15000	13203	5.00	3000	1629	6660	17.66	0.77585	0.00104	0.77794	_1_4_15	0.77767	0.00131	0.78028
_1_5_15	15000	13203	6.54	2294	923	7365	17.66	0.75988	0.00120	0.76228	_1_5_15	0.76047	0.00122	0.76291
UO_2, content and 500 g polyethylene in flooded containment vessel, flooded package														
_1_1_14	14000	12323	2.00	7000	5712	2667	19.11	0.81144	0.00130	0.81403	_1_1_14	0.80983	0.00147	0.81276
_1_2_14	14000	12323	3.00	4667	3383	4996	19.11	0.79632	0.00134	0.79900	_1_2_14	0.79412	0.00155	0.79722
_1_3_14	14000	12323	4.00	3500	2219	6161	19.11	0.78024	0.00138	0.78300	_1_3_14	0.78251	0.00141	0.78533
_1_4_14	14000	12323	5.00	2800	1520	6860	19.11	0.76867	0.00119	0.77106	_1_4_14	0.77186	0.00130	0.77446
_1_5_14	14000	12323	6.54	2141	862	7518	19.11	0.75106	0.00143	0.75393	_1_5_14	0.75712	0.00132	0.75975
UO_3 content and 500 g polyethylene in flooded containment vessel, flooded package														
_2_1_14	14000	11850	2.00	7000	5304	2667	18.97	0.77449	0.00162	0.77772	_2_1_14	0.77571	0.00138	0.77847
_2_2_14	14000	11850	3.00	4667	2975	4996	18.97	0.75132	0.00141	0.75415	_2_2_14	0.74985	0.00135	0.75256
_2_3_14	14000	11850	4.00	3500	1810	6161	18.97	0.72213	0.00119	0.72452	_2_3_14	0.72485	0.00112	0.72708
_2_4_14	14000	11850	5.00	2800	1111	6860	18.97	0.70025	0.00132	0.70289	_2_4_14	0.70229	0.00135	0.70498
_2_5_14	14000	11850	6.54	2141	453	7518	18.97	0.66897	0.00140	0.67177	_2_5_14	0.67431	0.00107	0.67645
U_3O_8 content and 500 g polyethylene in flooded containment vessel, flooded package														
_3_1_14	14000	11627	2.00	7000	5071	2667	18.81	0.75704	0.00138	0.75980	_3_1_14	0.75676	0.00139	0.75954
_3_2_14	14000	11627	3.00	4667	2741	4996	18.81	0.72097	0.00124	0.72345	_3_2_14	0.72300	0.00121	0.72542
_3_3_14	14000	11627	4.00	3500	1577	6161	18.81	0.69035	0.00114	0.69263	_3_3_14	0.69274	0.00112	0.69498
_3_4_14	14000	11627	5.00	2800	878	6860	18.81	0.66080	0.00123	0.66326	_3_4_14	0.66443	0.00115	0.66674
_3_5_14	14000	11627	6.54	2141	220	7518	18.81	0.62168	0.00129	0.62427	_3_5_14	0.62544	0.00118	0.62780

Table 6.9.6-13b. Results for HEU oxide content in array packaging calculation model

Case nciapdoxt11*	Ox (g)	^{235}U (g)	Ox den. (g/cm^3)	Ox vol. (cm^3)	Sat. H_2O (g)	CV H_2O (g)	h/x	k_{eff}	σ	$k_{eff}+2\sigma$	Case hciapdoxt12*	k_{eff}	σ	$k_{eff}+2\sigma$
UO_2 content and 500 g polyethylene in flooded containment vessel, array packaging model for CSI=0.0														
NCT											**HAC**			
_1_3_24_3	24000	21125	4.00	6000	3803	3665	10.02	0.96758	0.00121	0.97000	_1_3_24_3	0.96822	0.00124	0.97070
_1_4_24_3	24000	21125	5.00	4800	2606	4863	10.02	0.94340	0.00119	0.94578	_1_4_24_3	0.94131	0.00115	0.94360
_1_5_24_3	24000	21125	6.54	3670	1477	5991	10.02	0.91495	0.00134	0.91764	_1_5_24_3	0.91666	0.00106	0.91878
_1_2_20_3	20000	17604	3.00	6667	4833	3000	12.57	0.97118	0.00122	0.97363	_1_2_20_3	0.97255	0.00139	0.97532
_1_3_20_3	20000	17604	4.00	5000	3170	4663	12.57	0.93543	0.00122	0.93786	_1_3_20_3	0.93616	0.00141	0.93897
_1_4_20_3	20000	17604	5.00	4000	2171	5662	12.57	0.91167	0.00117	0.91401	_1_4_20_3	0.91202	0.00126	0.91453
_1_5_20_3	20000	17604	6.54	3058	1231	6602	12.57	0.88413	0.00124	0.88661	_1_5_20_3	0.88426	0.00137	0.88700
_1_2_15_3	15000	13203	3.00	5000	3625	4664	17.66	0.92181	0.00128	0.92438	_1_2_15_3	0.92129	0.00139	0.92407
_1_3_15_3	15000	13203	4.00	3750	2377	5911	17.66	0.88533	0.00117	0.88767	_1_3_15_3	0.88414	0.00125	0.88663
_1_4_15_3	15000	13203	5.00	3000	1628	6660	17.66	0.86168	0.00116	0.86400	_1_4_15_3	0.86039	0.00117	0.86273
_1_5_15_3	15000	13203	6.54	2294	923	7365	17.66	0.83434	0.00122	0.83678	_1_5_15_3	0.83140	0.00111	0.83363
_1_1_12_3	12000	10562	2.00	6000	4896	3665	22.74	0.93409	0.00140	0.93688	_1_1_12_3	0.93732	0.00137	0.94006
_1_2_12_3	12000	10562	3.00	4000	2900	5662	22.74	0.88391	0.00131	0.88652	_1_2_12_3	0.88387	0.00121	0.88630
_1_3_12_3	12000	10562	4.00	3000	1902	6660	22.74	0.85157	0.00111	0.85379	_1_3_12_3	0.84658	0.00133	0.84925
_1_4_12_3	12000	10562	5.00	2400	1303	7259	22.74	0.82574	0.00128	0.82831	_1_4_12_3	0.82349	0.00119	0.82587
_1_5_12_3	12000	10562	6.54	1835	739	7823	22.74	0.79328	0.00110	0.79548	_1_5_12_3	0.79233	0.00121	0.79475
_1_1_11_3	11000	9682	2.00	5500	4488	4164	25.06	0.91822	0.00129	0.92079	_1_1_11_3	0.92203	0.00134	0.92471
_1_2_11_3	11000	9682	3.00	3667	2658	5994	25.06	0.86689	0.00129	0.86946	_1_2_11_3	0.87093	0.00135	0.87364
_1_3_11_3	11000	9682	4.00	2750	1743	6909	25.06	0.83492	0.00133	0.83757	_1_3_11_3	0.83515	0.00124	0.83763
_1_4_11_3	11000	9682	5.00	2200	1194	7458	25.06	0.80930	0.00149	0.81227	_1_4_11_3	0.80948	0.00129	0.81205
_1_5_11_3	11000	9682	6.54	1682	677	7976	25.06	0.77906	0.00100	0.78106	_1_5_11_3	0.77935	0.00118	0.78171

Table 6.9.6-13b. Results for HEU oxide content in array packaging calculation model

Case nciapdoxt11*	Ox (g)	^{235}U (g)	Ox den. (g/cm^3)	Ox vol. (cm^3)	Sat. H_2O (g)	CV H_2O (g)	h/x	k_{eff}	σ	$k_{eff}+2\sigma$	Case hciapdoxt12*	k_{eff}	σ	$k_{eff}+2\sigma$
_1_1_10_3	10000	8802	2.00	5000	4080	4663	27.83	0.90471	0.00131	0.90733	_1_1_10_3	0.90600	0.00128	0.90856
_1_1_9_3	9000	7922	2.00	4500	3672	5163	31.23	0.88936	0.00137	0.89210	_1_1_9_3	0.88714	0.00123	0.88960
_1_1_8_3	8000	7042	2.00	4000	3264	5662	35.47	0.86854	0.00144	0.87141	_1_1_8_3	0.86980	0.00145	0.87270
_1_1_7_3	7000	6162	2.00	3500	2856	6161	40.92	0.84876	0.00125	0.85126	_1_1_7_3	0.84926	0.00133	0.85192
_1_1_6_3	6000	5281	2.00	3000	2448	6660	48.19	0.82546	0.00127	0.82800	_1_1_6_3	0.82275	0.00135	0.82544
UO_2, UO_3, or U_3O_8 content and 500 g polyethylene in flooded containment vessel, array packaging model for CSI=0.0														
_1_1_7_3	7000	6162	2.00	3500	2856	6161	40.92	0.84876	0.00125	0.85126	_1_1_7_3	0.84926	0.00133	0.85192
_2_1_7_3	7000	5925	2.00	3500	2652	6161	41.65	0.81721	0.00130	0.81980	_2_1_7_3	0.81943	0.00125	0.82194
_3_1_7_3	7000	5813	2.00	3500	2535	6161	41.93	0.80044	0.00129	0.80302	_3_1_7_3	0.80086	0.00134	0.80355

Table 6.9.6-13c. Results for low density HEU oxide content in single-unit packaging calculation model

Case ncsrldoxt11*	Ox (kg)	^{235}U (kg)	Ox den. (g/cm^3)	Ox vol. (cm^3)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	Case hcsrldoxt12*	k_{eff}	σ	$k_{eff}+2\sigma$	USL
NCT									**HAC**				
UO_2 content and 500 g polyethylene in flooded containment vessel, flooded package													
_1_20	16.0	14.083	1.75	9,143	7.669	0.80950	0.00140	0.81230	_1_20	0.81080	0.00120	0.81320	0.9350
_1_19	15.0	13.203	1.75	8,571	7.190	0.80810	0.00120	0.81050	_1_19	0.80740	0.00140	0.81020	0.9350
_1_18	14.0	12.323	1.75	8,000	6.711	0.80470	0.00180	0.80830	_1_18	0.80450	0.00110	0.80670	0.9350
_1_17	13.0	11.443	1.75	7,429	6.231	0.80500	0.00140	0.80780	_1_17	0.80480	0.00140	0.80760	0.9350
_1_16	12.0	10.562	1.75	6,857	5.752	0.79880	0.00140	0.80160	_1_16	0.80200	0.00160	0.80320	0.9350

Table 6.9.6-13c. Results for low density HEU oxide content in single-unit packaging calculation model

Case ncsrldoxt11*	Ox (kg)	^{235}U (kg)	Ox den. (g/cm^3)	Ox vol. (cm^3)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	Case hcsrldoxt12*	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_2_18	14.0	12.323	1.50	9,333	8.042	0.80800	0.00150	0.81100	_2_18	0.80700	0.00140	0.80980	0.9350
_2_17	13.0	11.443	1.50	8,667	7.467	0.80390	0.00140	0.80670	_2_17	0.80980	0.00150	0.81280	0.9350
_2_16	12.0	10.562	1.50	8,000	6.893	0.80250	0.00140	0.80530	_2_16	0.80630	0.00140	0.80910	0.9350
_2_15	11.0	9.682	1.50	7,333	6.318	0.80190	0.00130	0.80450	_2_15	0.80250	0.00120	0.80490	0.9350
_2_14	10.0	8.802	1.50	6,667	5.744	0.79690	0.00130	0.79950	_2_14	0.79780	0.00130	0.80040	0.9350
_3_16	12.0	10.562	1.25	9,600	8.490	0.80640	0.00140	0.80920	_3_16	0.80930	0.00120	0.81170	0.9350
_3_15	11.0	9.682	1.25	8,800	7.782	0.80670	0.00150	0.80970	_3_15	0.80550	0.00110	0.80770	0.9350
_3_14	10.0	8.802	1.25	8,000	7.075	0.80490	0.00140	0.80770	_3_14	0.80380	0.00120	0.80620	0.9350
_3_13	9.0	7.922	1.25	7,200	6.367	0.79830	0.00130	0.80090	_3_13	0.80250	0.00120	0.80490	0.9350
_3_12	8.0	7.042	1.25	6,400	5.660	0.79300	0.00140	0.79580	_3_12	0.79370	0.00120	0.79610	0.9350
_4_13	9.0	7.922	1.0	9,000	8.164	0.80240	0.00140	0.80520	_4_13	0.80290	0.00170	0.80630	0.9350
_4_12	8.0	7.042	1.0	8,000	7.257	0.79900	0.00150	0.80200	_4_12	0.80000	0.00130	0.80260	0.9350
_4_11	7.0	6.161	1.0	7,000	6.350	0.79500	0.00130	0.79760	_4_11	0.79520	0.00130	0.79780	0.9350
_4_10	6.0	5.281	1.0	6,000	5.443	0.78860	0.00120	0.79100	_4_10	0.78900	0.00140	0.79180	0.9350
_4_9	5.0	4.401	1.0	5,000	4.537	0.78100	0.00140	0.78380	_4_9	0.77910	0.00160	0.78230	0.9350
_5_11	7.0	6.161	0.75	9,333	8.679	0.79620	0.00110	0.79840	_5_11	0.79670	0.00150	0.79970	0.9350
_5_10	6.0	5.281	0.75	8,000	7.439	0.79600	0.00160	0.79920	_5_10	0.79380	0.00120	0.79620	0.9350
_5_9	5.0	4.401	0.75	6,667	6.199	0.78660	0.00130	0.78920	_5_9	0.78820	0.00130	0.79080	0.9350
_5_8	4.5	3.961	0.75	6,000	5.579	0.78270	0.00140	0.78550	_5_8	0.78360	0.00140	0.78640	0.9350
_5_7	4.0	6.521	0.75	5,333	4.959	0.77820	0.00140	0.78100	_5_7	0.77890	0.00170	0.78230	0.9350

Table 6.9.6-13c. Results for low density HEU oxide content in single-unit packaging calculation model

Case ncsrldoxt11*	Ox (kg)	^{235}U (kg)	Ox den. (g/cm^3)	Ox vol. (cm^3)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	Case hcsrldoxt12*	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_6_8	4.5	3.961	0.5	9,000	8.574	0.78450	0.00130	0.78710	_6_8	0.78560	0.00170	0.78900	0.9350
_6_7	4.0	3.521	0.5	8,000	7.621	0.78040	0.00170	0.78380	_6_7	0.78110	0.00140	0.78390	0.9350
_6_6	3.5	3.081	0.5	7,000	6.669	0.77620	0.00120	0.77860	_6_6	0.77710	0.00140	0.77990	0.9350
_6_5	3.0	2.641	0.5	6,000	5.716	0.76530	0.00160	0.76850	_6_5	0.77020	0.00130	0.77280	0.9350

Table 6.9.6-13d. Results for low density HEU oxide content in array packaging calculation model

Case ncialdoxt11*	MOIFR	Ox (kg)	^{235}U (kg)	Ox den. (g/cm^3)	Ox vol. (cm^3)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	Case hcialdoxt12*	k_{eff}	σ	$k_{eff}+2\sigma$	USL
NCT										HAC				
UO_2 content and 500 g polyethylene in flooded containment vessel, flooded package														
_1_21_1	1.0E-20	12.0	10.562	1.75	6.857	5.752	0.95010	0.00150	0.95310	_1_21_1	0.95030	0.00130	0.95290	0.9350
_1_20_1	1.0E-20	11.0	9.682	1.75	6.286	5.273	0.93580	0.00110	0.93700	_1_20_1	0.93400	0.00140	0.93680	0.9350
_1_19_1	1.0E-20	10.75	9.462	1.75	6.143	5.153	0.93200	0.00120	0.93440	_1_19_1	0.93240	0.00120	0.93480	0.9350
_1_19_2	1.0E-05	10.75	9.462	1.75	6.143	5.153	0.92900	0.00150	0.93200	_1_19_2	0.93240	0.00130	0.93500	0.9350
_1_19_3	1.0E-04	10.75	9.462	1.75	6.143	5.153	0.92920	0.00140	0.93200	_1_19_3	0.93090	0.00120	0.93330	0.9350
_1_19_4	1.0E-03	10.75	9.462	1.75	6.143	5.153	0.93040	0.00110	0.93260	_1_19_4	0.92950	0.00110	0.93170	0.9350
_1_19_5	1.0E-01	10.75	9.462	1.75	6.143	5.153	0.84340	0.00100	0.84540	_1_19_5	0.92560	0.00150	0.92860	0.9350
_1_18_1	1.0E-20	10.5	9.242	1.75	6.000	5.033	0.92820	0.00140	0.93100	_1_18_1				
_1_17_1	1.0E-20	10.0	8.802	1.75	5.714	4.793	0.91790	0.00200	0.92190	_1_17_1	0.92200	0.00130	0.92460	0.9350

Table 6.9.6-13d. Results for low density HEU oxide content in array packaging calculation model

Case ncialdoxt11*	MOIFR	Ox (kg)	^{235}U (kg)	Ox den. (g/cm^3)	Ox vol. (cm^3)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	Case hcialdoxt12*	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_2_17_1	1.0E-20	10.0	8.802	1.50	6.666	5.744	0.93870	0.00150	0.94270	_2_17_1	0.9419	0.0014	0.9447	0.9350
_2_16_1	1.0E-20	9.5	8.362	1.50	6.333	5.457	0.93000	0.00110	0.93220	_2_16_1	0.9323	0.0011	0.9345	0.9350
_2_16_2	1.0E-05	9.5	8.362	1.50	6.333	5.457	0.92990	0.00120	0.93230	_2_16_2	0.9321	0.0013	0.9347	0.9350
_2_16_3	1.0E-04	9.5	8.362	1.50	6.333	5.457	0.93130	0.00130	0.93390	_2_16_3	0.9285	0.0012	0.9309	0.9350
_2_16_4	1.0E-03	9.5	8.362	1.50	6.333	5.457	0.92800	0.00130	0.93060	_2_16_4	0.9292	0.0014	0.9320	0.9350
_2_15_1	1.0E-20	9.25	8.142	1.50	6.167	5.313	0.92820	0.00140	0.93100	_2_15_1	0.9262	0.0012	0.9286	0.9350
_2_14_1	1.0E-20	9.0	7.922	1.50	6.000	5.170	0.92020	0.00110	0.92240	_2_14_1	0.9215	0.0011	0.9237	0.9350
_3_14_1	1.0E-20	9.0	7.922	1.25	7.200	6.367	0.94740	0.00120	0.94980	_3_14_1	0.94520	0.00100	0.94820	0.9350
_3_13_1	1.0E-20	8.5	7.482	1.25	6.800	6.014	0.93790	0.00130	0.94050	_3_13_1	0.93470	0.00120	0.93710	0.9350
_3_12_1	1.0E-20	8.25	7.262	1.25	6.600	5.837	0.92930	0.00120	0.93170	_3_12_1	0.93110	0.00170	0.93450	0.9350
_3_12_2	1.0E-05	8.25	7.262	1.25	6.600	5.837	0.93210	0.00130	0.93470	_3_12_2	0.93160	0.00130	0.93420	0.9350
_3_12_3	1.0E-04	8.25	7.262	1.25	6.600	5.837	0.93090	0.00140	0.93370	_3_12_3	0.93340	0.00140	0.93620	0.9350
_3_12_4	1.0E-03	8.25	7.262	1.25	6.600	5.837	0.93070	0.00120	0.93310	_3_12_4	0.93150	0.00130	0.93410	0.9350
_3_11_1	1.0E-20	8.0	7.042	1.25	6.400	5.660	0.92600	0.00110	0.92820	_3_11_1	0.92420	0.00150	0.92720	0.9350
_4_11_1	1.0E-20	8.0	7.042	1.00	8.000	7.257	0.95980	0.00130	0.96240	_4_11_1	0.95840	0.00170	0.96180	0.9350
_4_10_1	1.0E-20	7.0	6.161	1.00	7.000	6.350	0.93540	0.00130	0.93800	_4_10_1	0.93400	0.00110	0.93620	0.9350
_4_9_1	1.0E-20	6.75	5.941	1.00	6.750	6.123	0.92900	0.00180	0.93260	_4_9_1	0.93010	0.00130	0.93270	0.9350
_4_9_2	1.0E-05	6.75	5.941	1.00	6.750	6.123	0.92750	0.00140	0.93030	_4_9_2	0.92710	0.00120	0.92950	0.9350
_4_9_3	1.0E-04	6.75	5.941	1.00	6.750	6.123	0.92870	0.00150	0.93170	_4_9_3	0.92910	0.00130	0.93170	0.9350
_4_9_4	1.0E-03	6.75	5.941	1.00	6.750	6.123	0.92740	0.00140	0.93020	_4_9_4	0.92630	0.00130	0.92890	0.9350
_4_8_1	1.0E-20	6.5	5.721	1.00	6.500	5.896	0.92040	0.00130	0.92300	_4_8_1	0.92120	0.00130	0.92380	0.9350
_4_7_1	1.0E-20	6.0	5.281	1.00	6.000	5.443	0.90810	0.00180	0.91170	_4_7_1	0.90980	0.00150	0.91280	0.9350

Table 6.9.6-13d. Results for low density HEU oxide content in array packaging calculation model

Case ncialdoxt11*	MOIFR	Ox (kg)	^{235}U (kg)	Ox den. (g/cm^3)	Ox vol. (cm^3)	Sat. H_2O (kg)	k_{eff}	σ	$k_{eff}+2\sigma$	Case hcialdoxt12*	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_5_7_1	1.0E-20	6.0	5.281	0.75	8.000	7.439	0.94450	0.00120	0.94690	_5_7_1	0.94920	0.00120	0.95160	0.9350
_5_6_1	1.0E-20	5.75	5.061	0.75	7.667	7.129	0.93770	0.00120	0.94010	_5_6_1	0.93720	0.00140	0.94000	0.9350
_5_5_1	1.0E-20	5.5	4.841	0.75	7.333	6.819	0.92950	0.00120	0.93190	_5_5_1	0.92670	0.00150	0.92970	0.9350
_5_5_2	1.0E-05	5.5	4.841	0.75	7.333	6.819	0.93060	0.00130	0.93320	_5_5_2	0.92900	0.00140	0.93180	0.9350
_5_5_3	1.0E-04	5.5	4.841	0.75	7.333	6.819	0.92920	0.00100	0.93120	_5_5_3	0.92890	0.00130	0.93150	0.9350
_5_5_4	1.0E-03	5.5	4.841	0.75	7.333	6.819	0.92610	0.00130	0.92870	_5_5_4	0.92890	0.00130	0.93150	0.9350
_5_4_1	1.0E-20	5.0	4.401	0.75	6.667	6.199	0.91220	0.00120	0.91460	_5_4_1	0.91180	0.00120	0.91420	0.9350
_5_3_1	1.0E-20	4.5	3.961	0.75	6.000	5.579	0.89580	0.00130	0.89840	_5_3_1	0.89460	0.00150	0.89760	0.9350
_6_3_1	1.0E-20	4.5	3.961	0.5	9.000	8.574	0.95280	0.00130	0.95540	_6_3_1	0.95070	0.00160	0.95390	0.9350
_6_2_1	1.0E-20	4.25	3.741	0.5	8.500	8.098	0.93450	0.00150	0.93750	_6_2_1	0.93470	0.00140	0.93750	0.9350
_6_1_1	1.0E-20	4.0	3.521	0.5	8.000	7.621	0.92180	0.00120	0.92420	_6_1_1	0.92340	0.00130	0.92600	0.9350
_6_1_2	1.0E-05	4.0	3.521	0.5	8.000	7.621	0.92470	0.00120	0.92710	_6_1_2	0.92190	0.00130	0.92450	0.9350
_6_1_3	1.0E-04	4.0	3.521	0.5	8.000	7.621	0.91960	0.00130	0.92220	_6_1_3	0.92260	0.00140	0.92540	0.9350
_6_1_4	1.0E-03	4.0	3.521	0.5	8.000	7.621	0.92120	0.00140	0.92400	_6_1_4	0.92280	0.00130	0.92540	0.9350

Table 6.9.6-13e. Results for HEU oxide/thorium oxide content in single-unit packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ThOx (kg)	Sat. H_2O (kg)	NCT ncsrldoxtho2t11*				HAC hcsrldoxtho2t12*			
					k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
UO_2-ThO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 2.0 g/cm^3												
_1_1_5	8.0	7.042	0.0	3.264	0.87360	0.00073	0.87506	0.93520	0.77554	0.00082	0.77718	0.93520
_3_1_5	8.0	7.042	2.0	4.063	0.85937	0.00076	0.86089	0.93520	0.75834	0.00081	0.75996	0.93520
_5_1_5	8.0	7.042	4.0	4.861	0.85252	0.00079	0.85410	0.93520	0.74590	0.00083	0.74756	0.93520
_7_1_5	8.0	7.042	6.0	5.660	0.84533	0.00087	0.84707	0.93520	0.73651	0.00075	0.73801	0.93520
_9_1_5	8.0	7.042	8.0	6.458	0.83790	0.00075	0.83940	0.93520	0.72648	0.00080	0.72808	0.93520
_1_1_6	10.0	8.802	0.0	4.080	0.88779	0.00075	0.88929	0.93520	0.78941	0.00076	0.79093	0.93520
_3_1_6	10.0	8.802	2.0	4.879	0.87409	0.00075	0.87559	0.93520	0.77033	0.00081	0.77195	0.93520
_5_1_6	10.0	8.802	4.0	5.677	0.86631	0.00077	0.86785	0.93520	0.75880	0.00072	0.76024	0.93520
_7_1_6	10.0	8.802	6.0	6.476	0.85847	0.00084	0.86015	0.93520	0.74830	0.00074	0.74978	0.93520
_1_1_7	11.0	9.682	0.0	4.488	0.89471	0.00081	0.89633	0.93520	0.79370	0.00073	0.79516	0.93520
_3_1_7	11.0	9.682	2.0	5.287	0.88092	0.00069	0.88230	0.93520	0.77622	0.00074	0.77770	0.93520
_5_1_7	11.0	9.682	4.0	6.085	0.87108	0.00084	0.87276	0.93520	0.76275	0.00074	0.76423	0.93520
_6_1_7	11.0	9.682	5.0	6.485	0.86617	0.00073	0.86763	0.93520	0.75880	0.00075	0.76030	0.93520
_7_1_7	11.0	9.682	6.0	6.884	0.86228	0.00078	0.86384	0.93520	0.79370	0.00073	0.79516	0.93520
UO_2-ThO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 1.75 g/cm^3												
_1_2_5	8.0	7.042	0.0	3.835	0.78015	0.00079	0.78173	0.93520	0.78218	0.00077	0.78372	0.93520
_3_2_5	8.0	7.042	2.0	4.776	0.76221	0.00072	0.76365	0.93520	0.76514	0.00072	0.76658	0.93520
_5_2_5	8.0	7.042	4.0	5.717	0.75208	0.00085	0.75378	0.93520	0.75227	0.00085	0.75397	0.93520
_7_2_5	8.0	7.042	6.0	6.658	0.74167	0.00073	0.74313	0.93520	0.74329	0.00078	0.74485	0.93520
_9_2_5	8.0	7.042	8.0	7.599	0.73234	0.00088	0.73410	0.93520	0.73409	0.00071	0.73551	0.93520
_1_2_6	10.0	8.802	0.0	4.793	0.79132	0.00099	0.79330	0.93520	0.79333	0.00081	0.79495	0.93520
_3_2_6	10.0	8.802	2.0	5.734	0.77313	0.00076	0.77465	0.93520	0.77516	0.00096	0.77708	0.93520
_5_2_6	10.0	8.802	4.0	6.676	0.76134	0.00079	0.76292	0.93520	0.76664	0.00096	0.76856	0.93520

Table 6.9.6-13e. Results for HEU oxide/thorium oxide content in single-unit packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ThOx (kg)	Sat. H_2O (kg)	NCT ncsrldoxtho2t11*				HAC hcsrldoxtho2t12*			
					k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_7_2_6	10.0	8.802	6.0	7.617	0.75281	0.00094	0.75469	0.93520	0.75441	0.00081	0.75603	0.93520
_1_2_7	11.0	9.682	0.0	5.273	0.79542	0.00081	0.79704	0.93520	0.79873	0.00072	0.80017	0.93520
_3_2_7	11.0	9.682	2.0	6.214	0.78050	0.00100	0.78250	0.93520	0.78122	0.00079	0.78280	0.93520
_5_2_7	11.0	9.682	4.0	7.155	0.76760	0.00072	0.76904	0.93520	0.76980	0.00092	0.77164	0.93520
_6_2_7	11.0	9.682	5.0	7.626	0.76193	0.00076	0.76345	0.93520	0.76536	0.00080	0.76696	0.93520
UO_2-ThO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 1.50 g/cm^3												
_1_3_5	8.0	7.042	0.0	4.595	0.78649	0.00077	0.78803	0.93520	0.79054	0.00077	0.79208	0.93520
_3_3_5	8.0	7.042	2.0	5.726	0.77036	0.00078	0.77192	0.93520	0.77209	0.00096	0.77401	0.93520
_5_3_5	8.0	7.042	4.0	6.858	0.75775	0.00079	0.75933	0.93520	0.75915	0.00084	0.76083	0.93520
_7_3_5	8.0	7.042	6.0	7.989	0.74744	0.00084	0.74912	0.93520	0.74972	0.00077	0.75126	0.93520
_1_3_6	10.0	8.802	0.0	5.744	0.79921	0.00079	0.80079	0.93520	0.79768	0.00086	0.79940	0.93520
_3_3_6	10.0	8.802	2.0	6.875	0.78071	0.00083	0.78237	0.93520	0.78216	0.00081	0.78378	0.93520
_5_3_6	10.0	8.802	4.0	8.007	0.77056	0.00076	0.77208	0.93520	0.76999	0.00082	0.77163	0.93520
_1_3_7	11.0	9.682	0.0	6.318	0.80191	0.00083	0.80357	0.93520	0.80238	0.00090	0.80418	0.93520
_3_3_7	11.0	9.682	2.0	7.450	0.78518	0.00076	0.78670	0.93520	0.78558	0.00079	0.78716	0.93520
_4_3_7	11.0	9.682	3.0	8.015	0.77791	0.00083	0.77957	0.93520	0.77966	0.00090	0.78146	0.93520
UO_2-ThO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 1.25 g/cm^3												
_1_4_5	8.0	7.042	0.0	5.660	0.79486	0.00080	0.79646	0.93520	0.79510	0.00082	0.79674	0.93520
_3_4_5	8.0	7.042	2.0	7.057	0.77683	0.00089	0.77861	0.93520	0.77868	0.00070	0.78008	0.93520
_5_4_5	8.0	7.042	4.0	8.455	0.76487	0.00079	0.76645	0.93680	0.76630	0.00087	0.76804	0.93680
_1_4_6	10.0	8.802	0.0	7.075	0.80231	0.00080	0.80391	0.93520	0.80273	0.00092	0.80457	0.93520
_3_4_6	10.0	8.802	2.0	8.472	0.78588	0.00079	0.78746	0.93520	0.78688	0.00081	0.78850	0.93520
_1_3_7	11.0	9.682	0.0	7.782	0.80523	0.00071	0.80665	0.93520	0.80606	0.00082	0.80770	0.93520
_2_3_7	11.0	9.682	1.0	8.481	0.79630	0.00079	0.79788	0.93520	0.79875	0.00097	0.80069	0.93520

Table 6.9.6-13e. Results for HEU oxide/thorium oxide content in single-unit packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ThOx (kg)	Sat. H_2O (kg)	NCT ncsrldoxtho2t11*				HAC hcsrldoxtho2t12*			
					k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
UO_2-ThO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 1.00 g/cm^3												
_1_5_3	5.0	4.401	0.0	4.537	0.77999	0.00078	0.78155	0.93520	0.78136	0.00090	0.78316	0.93520
_3_5_3	5.0	4.401	2.0	6.332	0.76077	0.00073	0.76223	0.93680	0.76322	0.00097	0.76516	0.93520
_5_5_3	5.0	4.401	4.0	8.129	0.74808	0.00083	0.74974	0.93520	0.74779	0.00074	0.74927	0.93680
_1_5_4	6.0	5.281	0.0	5.443	0.78765	0.00090	0.78945	0.93520	0.79073	0.00077	0.79227	0.93520
_3_5_4	6.0	5.281	2.0	7.240	0.76943	0.00080	0.77103	0.93520	0.77312	0.00088	0.77488	0.93520
_4_5_4	6.0	5.281	3.0	8.138	0.76302	0.00075	0.76452	0.93520	0.76485	0.00083	0.76651	0.93520
_1_5_5	8.0	7.042	0.0	7.257	0.79974	0.00081	0.80136	0.93520	0.80015	0.00090	0.80195	0.93520
_2_5_5	8.0	7.042	1.0	8.155	0.78997	0.00082	0.79161	0.93520	0.79152	0.00091	0.79334	0.93520
UO_2-ThO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 0.75 g/cm^3												
_1_6_2	4.0	3.521	0.0	4.959	0.77739	0.00084	0.77907	0.93680	0.77824	0.00083	0.77990	0.93680
_3_6_2	4.0	3.521	2.0	7.422	0.75638	0.00083	0.75804	0.93680	0.75661	0.00076	0.75813	0.93680
_4_6_2	4.0	3.521	3.0	8.653	0.74565	0.00084	0.74733	0.93680	0.74748	0.00091	0.74930	0.93680
_1_6_3	5.0	4.401	0.0	6.199	0.78770	0.00086	0.78942	0.93680	0.78817	0.00092	0.79001	0.93520
_2_6_3	5.0	4.401	1.0	7.430	0.77527	0.00088	0.77703	0.93680	0.77670	0.00100	0.77870	0.93680
_3_6_3	5.0	4.401	2.0	8.662	0.76703	0.00085	0.76873	0.93680	0.76845	0.00079	0.77003	0.93680
_1_6_4	6.0	5.281	0.0	7.439	0.79371	0.00082	0.79535	0.93520	0.79564	0.00080	0.79724	0.93520
_2_6_4	6.0	5.281	1.0	8.670	0.78175	0.00095	0.78365	0.93680	0.78630	0.00094	0.78818	0.93680
UO_2-ThO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 0.50 g/cm^3												
_1_7_1	3.0	2.641	0.0	5.716	0.77066	0.00090	0.77246	0.93680	0.77230	0.00100	0.77430	0.93680
_1_7_1	3.0	2.641	1.0	7.613	0.78148	0.00088	0.78324	0.93680	0.75530	0.00078	0.75686	0.93680
_2_7_1	4.0	3.521	0.0	7.621	0.75320	0.00100	0.75520	0.93680	0.78155	0.00085	0.78325	0.93680

Table 6.9.6-13f. Results for HEU oxide/zirconium oxide content in single-unit packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ZrOx (kg)	Sat. H_2O (kg)	NCT ncsrldoxzro2t11*				HAC hcsrldoxzro2t12*			
					k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
UO_2-ZrO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 2.0 g/cm^3												
_1_1_5	8.0	7.042	0.0	3.264	0.77520	0.00110	0.77740	0.93520	0.77697	0.00092	0.77881	0.93520
_3_1_5	8.0	7.042	2.0	3.911	0.75851	0.00082	0.76015	0.93520	0.75935	0.00086	0.76107	0.93520
_5_1_5	8.0	7.042	4.0	4.558	0.74342	0.00075	0.74492	0.93520	0.74689	0.00084	0.74857	0.93520
_7_1_5	8.0	7.042	6.0	5.204	0.73353	0.00070	0.73493	0.93520	0.73468	0.00073	0.73614	0.93520
_9_1_5	8.0	7.042	8.0	5.851	0.72326	0.00089	0.72504	0.93520	0.72483	0.00075	0.72633	0.93520
_1_1_6	10.0	8.802	0.0	4.080	0.78745	0.00073	0.78891	0.93520	0.78768	0.00073	0.78914	0.93520
_3_1_6	10.0	8.802	2.0	4.727	0.77179	0.00076	0.77331	0.93520	0.77190	0.00078	0.77346	0.93520
_5_1_6	10.0	8.802	4.0	5.374	0.75712	0.00075	0.75862	0.93520	0.75907	0.00089	0.76085	0.93520
_7_1_6	10.0	8.802	6.0	6.020	0.74543	0.00076	0.74695	0.93520	0.74752	0.00091	0.74934	0.93520
_1_1_7	11.0	9.682	0.0	4.488	0.79106	0.00092	0.79290	0.93520	0.79342	0.00083	0.79508	0.93520
_3_1_7	11.0	9.682	2.0	5.135	0.77691	0.00076	0.77843	0.93520	0.77847	0.00077	0.78001	0.93520
_5_1_7	11.0	9.682	4.0	5.782	0.76240	0.00081	0.76402	0.93520	0.76373	0.00070	0.76513	0.93520
_6_1_7	11.0	9.682	5.0	6.105	0.75690	0.00073	0.75836	0.93520	0.75826	0.00072	0.75970	0.93520
UO_2-ZrO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 1.75 g/cm^3												
_1_2_5	8.0	7.042	0.0	3.835	0.78122	0.00084	0.78290	0.93520	0.78157	0.00078	0.78313	0.93520
_3_2_5	8.0	7.042	2.0	4.624	0.76510	0.00100	0.76710	0.93520	0.76866	0.00081	0.77028	0.93520
_5_2_5	8.0	7.042	4.0	5.413	0.75444	0.00069	0.75582	0.93520	0.75581	0.00096	0.75773	0.93520
_7_2_5	8.0	7.042	6.0	6.203	0.74200	0.00096	0.74392	0.93520	0.74489	0.00098	0.74685	0.93520
_9_2_5	8.0	7.042	8.0	6.992	0.73285	0.00078	0.73441	0.93520	0.73342	0.00080	0.73502	0.93520
_1_2_6	10.0	8.802	0.0	4.793	0.79208	0.00075	0.79358	0.93520	0.79354	0.00077	0.79508	0.93520
_3_2_6	10.0	8.802	2.0	5.583	0.77840	0.00082	0.78004	0.93520	0.78041	0.00076	0.78193	0.93520
_5_2_6	10.0	8.802	4.0	6.372	0.76615	0.00090	0.76795	0.93520	0.76822	0.00088	0.76998	0.93520
_7_2_6	10.0	8.802	6.0	7.161	0.75556	0.00082	0.75720	0.93520	0.75617	0.00075	0.75767	0.93520

Table 6.9.6-13f. Results for HEU oxide/zirconium oxide content in single-unit packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ZrOx (kg)	Sat. H_2O (kg)	NCT ncsrldoxzro2t11*				HAC hcsrldoxzro2t12*			
					k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_1_2_7	11.0	9.682	0.0	5.273	0.79641	0.00079	0.79799	0.93520	0.79875	0.00091	0.80057	0.93520
_3_2_7	11.0	9.682	2.0	6.062	0.78201	0.00080	0.78361	0.93520	0.78195	0.00086	0.78367	0.93520
_5_2_7	11.0	9.682	4.0	6.821	0.77038	0.00077	0.77192	0.93520	0.77003	0.00085	0.77173	0.93520
_6_2_7	11.0	9.682	5.0	7.246	0.76351	0.00082	0.76515	0.93520	0.76673	0.00083	0.76839	0.93520
UO_2-ZrO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 1.50 g/cm^3												
_1_3_5	8.0	7.042	0.0	4.595	0.78548	0.00078	0.78704	0.93520	0.79130	0.00086	0.79302	0.93520
_3_3_5	8.0	7.042	2.0	5.575	0.77369	0.00074	0.77517	0.93520	0.77650	0.00078	0.77806	0.93520
_5_3_5	8.0	7.042	4.0	6.554	0.76357	0.00075	0.76507	0.93520	0.76411	0.00079	0.76569	0.93520
_7_3_5	8.0	7.042	6.0	7.534	0.75109	0.00099	0.75307	0.93520	0.75363	0.00085	0.75533	0.93520
_1_3_6	10.0	8.802	0.0	5.744	0.79599	0.00081	0.79761	0.93520	0.79966	0.00070	0.80106	0.93520
_3_3_6	10.0	8.802	2.0	6.723	0.78318	0.00071	0.78460	0.93520	0.78496	0.00083	0.78662	0.93520
_5_3_6	10.0	8.802	4.0	7.703	0.77321	0.00073	0.77467	0.93520	0.77477	0.00087	0.77651	0.93520
_1_3_7	11.0	9.682	0.0	6.318	0.80059	0.00079	0.80217	0.93520	0.80326	0.00070	0.80466	0.93520
_3_3_7	11.0	9.682	2.0	7.298	0.78980	0.00082	0.79144	0.93520	0.78854	0.00071	0.78996	0.93520
_4_3_7	11.0	9.682	3.0	7.788	0.78251	0.00075	0.78401	0.93520	0.78385	0.00077	0.78539	0.93520
UO_2-ZrO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 1.25 g/cm^3												
_1_4_5	8.0	7.042	0.0	7.042	0.79315	0.00082	0.79479	0.93520	0.79628	0.00082	0.79792	0.93520
_3_4_5	8.0	7.042	2.0	7.042	0.77964	0.00079	0.78122	0.93520	0.78164	0.00082	0.78328	0.93520
_5_4_5	8.0	7.042	4.0	7.042	0.76874	0.00074	0.77022	0.93520	0.77225	0.00070	0.77365	0.93520
_1_4_6	10.0	8.802	0.0	8.802	0.80010	0.00075	0.80160	0.93520	0.80447	0.00081	0.80609	0.93520
_3_4_6	10.0	8.802	2.0	8.802	0.78892	0.00090	0.79072	0.93520	0.79190	0.00074	0.79338	0.93520
_1_3_7	11.0	9.682	0.0	9.682	0.80466	0.00085	0.80636	0.93520	0.80576	0.00092	0.80760	0.93520
_2_3_7	11.0	9.682	1.0	9.682	0.79781	0.00074	0.79929	0.93520	0.80021	0.00091	0.80203	0.93520

Table 6.9.6-13f. Results for HEU oxide/zirconium oxide content in single-unit packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ZrOx (kg)	Sat. H_2O (kg)	NCT ncsrldoxzro2t11*				HAC hcsrldoxzro2t12*			
					k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
UO_2-ZrO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 1.00 g/cm^3												
_1_5_3	5.0	4.401	0.0	4.537	0.77902	0.00080	0.78062	0.93520	0.78140	0.00100	0.78340	0.93520
_3_5_3	5.0	4.401	2.0	6.181	0.76720	0.00100	0.76920	0.93520	0.76994	0.00099	0.77192	0.93520
_5_5_3	5.0	4.401	4.0	7.826	0.75378	0.00077	0.75532	0.93680	0.75660	0.00077	0.75814	0.93680
_1_5_4	6.0	5.281	0.0	5.443	0.78927	0.00074	0.79075	0.93520	0.78997	0.00063	0.79123	0.93520
_3_5_4	6.0	5.281	2.0	7.088	0.77551	0.00092	0.77735	0.93520	0.77710	0.00080	0.77870	0.93520
_4_5_4	6.0	5.281	3.0	7.910	0.76922	0.00093	0.77108	0.93680	0.77120	0.00081	0.77282	0.93680
_1_5_5	8.0	7.042	0.0	7.257	0.79889	0.00081	0.80051	0.93520	0.80073	0.00085	0.80243	0.93520
_2_5_5	8.0	7.042	1.0	8.079	0.79199	0.00090	0.79379	0.93520	0.79489	0.00081	0.79651	0.93520
UO_2-ZrO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 0.75 g/cm^3												
_1_6_2	4.0	3.521	0.0	4.959	0.77727	0.00077	0.77881	0.93680	0.77906	0.00079	0.78064	0.93680
_3_6_2	4.0	3.521	2.0	7.270	0.76349	0.00098	0.76545	0.93680	0.76540	0.00100	0.76740	0.93680
_4_6_2	4.0	3.521	3.0	8.425	0.75542	0.00081	0.75704	0.93680	0.75730	0.00080	0.75890	0.93680
_1_6_3	5.0	4.401	0.0	6.199	0.78595	0.00079	0.78753	0.93520	0.78882	0.00091	0.79064	0.93520
_2_6_3	5.0	4.401	1.0	7.355	0.78076	0.00089	0.78254	0.93680	0.78259	0.00086	0.78431	0.93680
_3_6_3	5.0	4.401	2.0	8.510	0.77282	0.00073	0.77428	0.93680	0.77318	0.00077	0.77472	0.93680
_1_6_4	6.0	5.281	0.0	7.439	0.79404	0.00093	0.79590	0.93520	0.79728	0.00084	0.79896	0.93520
_2_6_4	6.0	5.281	1.0	8.594	0.78660	0.00088	0.78836	0.93680	0.78790	0.00096	0.78982	0.93680
UO_2-ZrO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 0.50 g/cm^3												
_1_7_1	3.0	2.641	0.0	5.716	0.76963	0.00078	0.77119	0.93680	0.77072	0.00092	0.77256	0.93680
_1_7_1	3.0	2.641	1.0	7.537	0.75902	0.00088	0.76078	0.93680	0.76111	0.00078	0.76267	0.93680
_2_7_1	4.0	3.521	0.0	7.621	0.78143	0.00077	0.78297	0.93680	0.78241	0.00082	0.78405	0.93680

Table 6.9.6-13g. Results for HEU oxide/thorium metal content in single-unit packaging calculation model

Case	Ox (kg)	^{235}U (kg)	Th (kg)	Sat. H_2O (kg)	NCT ncsrldoxtht11*				HAC hcsrldoxtht12*			
					k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
UO_2-Th content and 500 g polyethylene in flooded containment vessel, flooded package at 2.0 g/cm^3												
_1_1_5	8.0	7.042	0.0	3.264	0.77330	0.00070	0.77470	0.93520	0.77493	0.00067	0.77627	0.93520
_3_1_5	8.0	7.042	2.0	4.063	0.75461	0.00076	0.75613	0.93520	0.75778	0.00072	0.75922	0.93520
_5_1_5	8.0	7.042	4.0	4.861	0.74279	0.00091	0.74461	0.93520	0.74646	0.00086	0.74818	0.93520
_7_1_5	8.0	7.042	6.0	5.660	0.73569	0.00080	0.73729	0.93520	0.73669	0.00079	0.73827	0.93520
_9_1_5	8.0	7.042	8.0	6.458	0.72505	0.00072	0.72649	0.93520	0.72743	0.00082	0.72907	0.93520
_1_1_6	10.0	8.802	0.0	4.080	0.78709	0.00084	0.78877	0.93520	0.78934	0.00068	0.79070	0.93520
_3_1_6	10.0	8.802	2.0	4.879	0.77002	0.00086	0.77174	0.93520	0.76953	0.00070	0.77093	0.93520
_5_1_6	10.0	8.802	4.0	5.677	0.75593	0.00085	0.75763	0.93520	0.75775	0.00069	0.75913	0.93520
_7_1_6	10.0	8.802	6.0	6.476	0.74660	0.00075	0.74810	0.93520	0.74774	0.00079	0.74932	0.93520
_1_1_7	11.0	9.682	0.0	4.488	0.79155	0.00076	0.79307	0.93520	0.79313	0.00080	0.79473	0.93520
_3_1_7	11.0	9.682	2.0	5.287	0.77452	0.00079	0.77610	0.93520	0.77484	0.00091	0.77666	0.93520
_5_1_7	11.0	9.682	4.0	6.085	0.76211	0.00074	0.76359	0.93520	0.76275	0.00071	0.76417	0.93520
_6_1_7	11.0	9.682	5.0	6.485	0.75633	0.00089	0.75811	0.93520	0.75811	0.00076	0.75963	0.93520
UO_2-Th content and 500 g polyethylene in flooded containment vessel, flooded package at 1.75 g/cm^3												
_1_2_5	8.0	7.042	0.0	3.835	0.77900	0.00075	0.78050	0.93520	0.78197	0.00074	0.78345	0.93520
_3_2_5	8.0	7.042	2.0	4.776	0.76304	0.00086	0.76476	0.93520	0.76378	0.00073	0.76524	0.93520
_5_2_5	8.0	7.042	4.0	5.717	0.75012	0.00072	0.75156	0.93520	0.75070	0.00100	0.75270	0.93520
_7_2_5	8.0	7.042	6.0	6.658	0.74148	0.00077	0.74302	0.93520	0.74293	0.00074	0.74441	0.93520
_9_2_5	8.0	7.042	8.0	7.599	0.73290	0.00110	0.73510	0.93520	0.73349	0.00073	0.73495	0.93520
_1_2_6	10.0	8.802	0.0	4.793	0.79324	0.00071	0.79466	0.93520	0.79450	0.00083	0.79616	0.93520
_3_2_6	10.0	8.802	2.0	5.734	0.77423	0.00070	0.77563	0.93520	0.77704	0.00073	0.77850	0.93520
_5_2_6	10.0	8.802	4.0	6.676	0.76267	0.00072	0.76411	0.93520	0.76441	0.00084	0.76609	0.93520
_7_2_6	10.0	8.802	6.0	7.617	0.75402	0.00078	0.75558	0.93520	0.75447	0.00076	0.75599	0.93520

Table 6.9.6-13g. Results for HEU oxide/thorium metal content in single-unit packaging calculation model

Case	Ox (kg)	^{235}U (kg)	Th (kg)	Sat. H_2O (kg)	NCT ncsrldoxtht11*				HAC hcsrldoxtht12*			
					k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_1_2_7	11.0	9.682	0.0	5.273	0.79778	0.00084	0.79946	0.93520	0.79751	0.00075	0.79901	0.93520
_3_2_7	11.0	9.682	2.0	6.214	0.77804	0.00070	0.77944	0.93520	0.77949	0.00085	0.78119	0.93520
_5_2_7	11.0	9.682	4.0	7.155	0.76812	0.00080	0.76972	0.93520	0.76845	0.00077	0.76999	0.93520
_6_2_7	11.0	9.682	5.0	7.626	0.76212	0.00082	0.76376	0.93520	0.76327	0.00072	0.76471	0.93520
UO_2-Th content and 500 g polyethylene in flooded containment vessel, flooded package at 1.50 g/cm^3												
_1_3_5	8.0	7.042	0.0	4.595	0.79778	0.00084	0.79946	0.93520	0.79009	0.00083	0.79175	0.93520
_3_3_5	8.0	7.042	2.0	5.726	0.77804	0.00070	0.77944	0.93520	0.77094	0.00066	0.77226	0.93520
_5_3_5	8.0	7.042	4.0	6.858	0.76812	0.00080	0.76972	0.93520	0.76011	0.00071	0.76153	0.93520
_7_3_5	8.0	7.042	6.0	7.989	0.76212	0.00082	0.76376	0.93520	0.75041	0.00079	0.75199	0.93520
_1_3_6	10.0	8.802	0.0	5.744	0.79746	0.00076	0.79898	0.93520	0.80047	0.00098	0.80243	0.93520
_3_3_6	10.0	8.802	2.0	6.875	0.78106	0.00075	0.78256	0.93520	0.78121	0.00089	0.78299	0.93520
_5_3_6	10.0	8.802	4.0	8.007	0.76871	0.00084	0.77039	0.93520	0.76833	0.00079	0.76991	0.93520
_1_3_7	11.0	9.682	0.0	6.318	0.80151	0.00081	0.80313	0.93520	0.80294	0.00082	0.80458	0.93520
_3_3_7	11.0	9.682	2.0	7.450	0.78369	0.00078	0.78525	0.93520	0.78521	0.00073	0.78667	0.93520
_4_3_7	11.0	9.682	3.0	8.015	0.77901	0.00084	0.78069	0.93520	0.77806	0.00071	0.77948	0.93520
UO_2-Th content and 500 g polyethylene in flooded containment vessel, flooded package at 1.25 g/cm^3												
_1_4_5	8.0	7.042	0.0	5.660	0.79327	0.00076	0.79479	0.93520	0.79755	0.00077	0.79909	0.93520
_3_4_5	8.0	7.042	2.0	7.057	0.77618	0.00082	0.77782	0.93520	0.77779	0.00092	0.77963	0.93520
_5_4_5	8.0	7.042	4.0	8.455	0.76379	0.00082	0.76543	0.93520	0.76560	0.00100	0.76760	0.93520
_1_4_6	10.0	8.802	0.0	7.075	0.80287	0.00076	0.80439	0.93520	0.80435	0.00080	0.80595	0.93520
_3_4_6	10.0	8.802	2.0	8.472	0.78548	0.00081	0.78710	0.93520	0.78617	0.00093	0.78803	0.93520
_1_3_7	11.0	9.682	0.0	7.782	0.80476	0.00077	0.80630	0.93520	0.80588	0.00082	0.80752	0.93520
_2_3_7	11.0	9.682	1.0	8.481	0.79570	0.00081	0.79732	0.93520	0.79599	0.00069	0.79737	0.93520

Table 6.9.6-13g. Results for HEU oxide/thorium metal content in single-unit packaging calculation model

Case	Ox (kg)	^{235}U (kg)	Th (kg)	Sat. H_2O (kg)	NCT ncsrldoxtht11*				HAC hcsrldoxtht12*			
					k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
UO_2-Th content and 500 g polyethylene in flooded containment vessel, flooded package at 1.00 g/cm^3												
_1_5_3	5.0	4.401	0.0	4.537	0.77880	0.00100	0.78080	0.93520	0.78150	0.00100	0.78350	0.93520
_3_5_3	5.0	4.401	2.0	6.332	0.76121	0.00079	0.76279	0.93680	0.76264	0.00088	0.76440	0.93520
_5_5_3	5.0	4.401	4.0	8.129	0.74728	0.00090	0.74908	0.93680	0.74704	0.00088	0.74880	0.93680
_1_5_4	6.0	5.281	0.0	5.443	0.78858	0.00078	0.79014	0.93520	0.79000	0.00083	0.79166	0.93520
_3_5_4	6.0	5.281	2.0	7.240	0.76951	0.00085	0.77121	0.93520	0.77217	0.00086	0.77389	0.93520
_4_5_4	6.0	5.281	3.0	8.138	0.76243	0.00081	0.76405	0.93520	0.76370	0.00075	0.76520	0.93680
_1_5_5	8.0	7.042	0.0	7.257	0.79909	0.00084	0.80077	0.93520	0.80006	0.00078	0.80162	0.93520
_2_5_5	8.0	7.042	1.0	8.155	0.78990	0.00081	0.79152	0.93520	0.79108	0.00083	0.79274	0.93520
UO_2-Th content and 500 g polyethylene in flooded containment vessel, flooded package at 0.75 g/cm^3												
_1_6_2	4.0	3.521	0.0	4.959	0.77894	0.00083	0.78060	0.93680	0.77878	0.00085	0.78048	0.93680
_3_6_2	4.0	3.521	2.0	7.422	0.75480	0.00100	0.75680	0.93680	0.75616	0.00075	0.75766	0.93680
_4_6_2	4.0	3.521	3.0	8.653	0.74535	0.00083	0.74701	0.93680	0.74629	0.00084	0.74797	0.93680
_1_6_3	5.0	4.401	0.0	6.199	0.78881	0.00088	0.79057	0.93520	0.78993	0.00099	0.79191	0.93520
_2_6_3	5.0	4.401	1.0	7.430	0.77608	0.00081	0.77770	0.93680	0.77679	0.00078	0.77835	0.93680
_3_6_3	5.0	4.401	2.0	8.662	0.76405	0.00078	0.76561	0.93680	0.76666	0.00078	0.76822	0.93680
_1_6_4	6.0	5.281	0.0	7.439	0.79470	0.00078	0.79626	0.93680	0.79480	0.00077	0.79634	0.93520
_2_6_4	6.0	5.281	1.0	8.670	0.78283	0.00087	0.78457	0.93680	0.78421	0.00080	0.78581	0.93680
UO_2-Th content and 500 g polyethylene in flooded containment vessel, flooded package at 0.50 g/cm^3												
_1_7_1	3.0	2.641	0.0	5.716	0.77070	0.00100	0.77270	0.93680	0.77088	0.00087	0.77262	0.93680
_1_7_1	3.0	2.641	1.0	7.613	0.75130	0.00082	0.75294	0.93680	0.75439	0.00071	0.75581	0.93680
_2_7_1	4.0	3.521	0.0	7.621	0.78136	0.00085	0.78306	0.93680	0.78294	0.00086	0.78466	0.93680

Table 6.9.6-13h. Results for HEU oxide/thorium oxide content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ThOx (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxtho2t11*				HAC hcialdoxtho2t12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
UO_2-ThO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 2.0 g/cm^3													
_1_1_13	9.0	7.922	0.00	1.0E-20	3.672	0.88331	0.00064	0.88459	0.93520	0.88266	0.00079	0.88424	0.93520
_5_1_13	9.0	7.922	2.00	1.0E-20	4.471	0.88000	0.00077	0.88154	0.93520	0.88012	0.00074	0.88160	0.93520
_9_1_13	9.0	7.922	4.00	1.0E-20	5.269	0.88267	0.00076	0.88419	0.93520	0.88300	0.00069	0.88438	0.93520
_19_1_13	9.0	7.922	6.00	1.0E-20	6.068	0.88734	0.00080	0.88894	0.93520	0.88817	0.00076	0.88969	0.93520
_21_1_13	9.0	7.922	7.00	1.0E-20	6.467	0.89205	0.00086	0.89377	0.93520	0.89174	0.00066	0.89306	0.93520
_1_1_14	10.0	8.802	0.00	1.0E-20	4.080	0.90062	0.00080	0.90222	0.93520	0.90098	0.00071	0.90240	0.93520
_5_1_14	10.0	8.802	2.00	1.0E-20	4.879	0.89813	0.00065	0.89943	0.93520	0.89691	0.00080	0.89851	0.93520
_9_1_14	10.0	8.802	4.00	1.0E-20	5.677	0.89834	0.00067	0.89968	0.93520	0.89864	0.00078	0.90020	0.93520
_19_1_14	10.0	8.802	6.00	1.0E-20	6.476	0.90552	0.00071	0.90694	0.93520	0.90560	0.00081	0.90722	0.93520
_1_1_16	11.0	9.682	0.00	1.0E-20	4.488	0.91596	0.00084	0.91764	0.93520	0.91695	0.00097	0.91889	0.93520
_5_1_16	11.0	9.682	2.00	1.0E-20	5.287	0.91250	0.00075	0.91400	0.93520	0.91380	0.00070	0.91520	0.93520
_9_1_16	11.0	9.682	4.00	1.0E-20	6.085	0.91592	0.00080	0.91752	0.93520	0.91445	0.00083	0.91611	0.93520
_13_1_16	11.0	9.682	5.00	1.0E-20	6.485	0.91956	0.00088	0.92132	0.93520	0.91816	0.00069	0.91954	0.93520
_13_1_16a	11.0	9.682	5.00	1.0E-05	6.485	0.91804	0.00088	0.91980	0.93520	0.91963	0.00074	0.92111	0.93520
_13_1_16b	11.0	9.682	5.00	1.0E-04	6.485	0.91989	0.00076	0.92141	0.93520	0.91837	0.00069	0.91975	0.93520
_13_1_16c	11.0	9.682	5.00	1.0E-03	6.485	0.91727	0.00071	0.91869	0.93520	0.91805	0.00071	0.91947	0.93520
UO_2-ThO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 1.75 g/cm^3													
_1_2_13	9.00	7.922	0.00	1.0E-20	4.314	0.90222	0.00085	0.90392	0.93520	0.90300	0.00092	0.90484	0.93520
_5_2_13	9.00	7.922	2.00	1.0E-20	5.255	0.89947	0.00066	0.90079	0.93520	0.90042	0.00074	0.90190	0.93520
_9_2_13	9.00	7.922	4.00	1.0E-20	6.196	0.90494	0.00079	0.90652	0.93520	0.90544	0.00073	0.90690	0.93520
_19_2_13	9.00	7.922	6.00	1.0E-20	7.137	0.91459	0.00072	0.91603	0.93520	0.91380	0.00073	0.91526	0.93520
_21_2_13	9.00	7.922	7.00	1.0E-20	7.608	0.92365	0.00071	0.92507	0.93520	0.92420	0.00075	0.92570	0.93520

Table 6.9.6-13h. Results for HEU oxide/thorium oxide content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ThOx (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxtho2t11*				HAC hcialdoxtho2t12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_1_2_14	10.0	8.802	0.00	1.0E-20	4.793	0.91913	0.00072	0.92057	0.93520	0.91954	0.00068	0.92090	0.93520
_2_2_14	10.0	8.802	1.00	1.0E-20	5.264	0.91614	0.00081	0.91776	0.93520	0.91790	0.00070	0.91930	0.93520
_5_2_14	10.0	8.802	2.00	1.0E-20	5.734	0.91803	0.00083	0.91969	0.93520	0.91775	0.00069	0.91913	0.93520
_9_2_14	10.0	8.802	4.00	1.0E-20	6.676	0.92387	0.00070	0.92527	0.93520	0.92290	0.00070	0.92430	0.93520
_15_2_14	10.0	8.802	5.35	1.0E-20	7.310	0.93244	0.00080	0.93404	0.93520	0.93272	0.00075	0.93422	0.93520
_1_2_15	10.1	8.890	0.00	1.0E-20	4.841	0.92096	0.00079	0.92254	0.93520	0.91992	0.00069	0.92130	0.93520
_5_2_15	10.1	8.890	2.00	1.0E-20	5.782	0.91747	0.00070	0.91887	0.93520	0.91942	0.00092	0.92126	0.93520
_9_2_15	10.1	8.890	4.00	1.0E-20	6.724	0.92564	0.00074	0.92712	0.93520	0.92586	0.00084	0.92754	0.93520
_13_2_15	10.1	8.890	5.00	1.0E-20	7.194	0.93114	0.00068	0.93250	0.93520	0.93035	0.00073	0.93181	0.93520
_14_2_15	10.1	8.890	5.10	1.0E-20	7.241	0.93268	0.00084	0.93436	0.93520	0.93186	0.00082	0.93350	0.93520
_14_2_15a	10.1	8.890	5.10	1.0E-05	7.241	0.93119	0.00077	0.93273	0.93520	0.93310	0.00100	0.93510	0.93520
_14_2_15b	10.1	8.890	5.10	1.0E-04	7.241	0.93025	0.00085	0.93195	0.93520	0.93143	0.00081	0.93305	0.93520
_14_2_15c	10.1	8.890	5.10	1.0E-03	7.241	0.93070	0.00075	0.93220	0.93520	0.92964	0.00076	0.93116	0.93520
UO_2-ThO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 1.50 g/cm^3													
_1_3_7	6.00	5.281	0.00	1.0E-20	3.446	0.85558	0.00074	0.85706	0.93520	0.85614	0.00071	0.85756	0.93520
_5_3_7	6.00	5.281	2.00	1.0E-20	4.578	0.85990	0.00064	0.86118	0.93520	0.85881	0.00074	0.86029	0.93520
_9_3_7	6.00	5.281	4.00	1.0E-20	5.709	0.86703	0.00074	0.86851	0.93520	0.86639	0.00074	0.86787	0.93520
_19_3_7	6.00	5.281	6.00	1.0E-20	6.840	0.87697	0.00069	0.87835	0.93520	0.87535	0.00077	0.87689	0.93520
_24_3_7	6.00	5.281	8.00	1.0E-20	7.971	0.89525	0.00081	0.89687	0.93520	0.89640	0.00073	0.89786	0.93520
_26_3_7	6.00	5.281	8.50	1.0E-20	8.254	0.89982	0.00084	0.90150	0.93520	0.90125	0.00081	0.90287	0.93520
_1_3_10	7.00	6.161	0.00	1.0E-20	4.021	0.88050	0.00071	0.88192	0.93520	0.88063	0.00072	0.88207	0.93520
_5_3_10	7.00	6.161	2.00	1.0E-20	5.152	0.88279	0.00078	0.88435	0.93520	0.88203	0.00086	0.88375	0.93520
_9_3_10	7.00	6.161	4.00	1.0E-20	6.283	0.89093	0.00086	0.89265	0.93520	0.89003	0.00069	0.89141	0.93520

Table 6.9.6-13h. Results for HEU oxide/thorium oxide content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ThOx (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxtho2t11*				HAC hcialdoxtho2t12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_19_3_10	7.00	6.161	6.00	1.0E-20	7.415	0.90239	0.00083	0.90405	0.93520	0.90376	0.00072	0.90520	0.93520
_21_3_10	7.00	6.161	7.00	1.0E-20	7.839	0.91515	0.00074	0.91663	0.93520	0.91501	0.00072	0.91645	0.93520
_22_3_10	7.00	6.161	7.40	1.0E-20	8.207	0.91970	0.00068	0.92106	0.93520	0.91977	0.00065	0.92107	0.93520
_1_3_11	7.75	6.822	0.00	1.0E-20	4.452	0.89855	0.00074	0.90003	0.93520	0.89676	0.00076	0.89828	0.93520
_5_3_11	7.75	6.822	2.00	1.0E-20	5.583	0.89808	0.00073	0.89954	0.93520	0.89794	0.00081	0.89956	0.93520
_9_3_11	7.75	6.822	4.00	1.0E-20	6.714	0.90598	0.00092	0.90782	0.93520	0.90777	0.00072	0.90921	0.93520
_19_3_11	7.75	6.822	6.00	1.0E-20	7.845	0.92390	0.00072	0.92534	0.93520	0.92355	0.00089	0.92533	0.93520
_20_3_11	7.75	6.822	6.75	1.0E-20	8.185	0.93307	0.00083	0.93473	0.93520	0.93276	0.00069	0.93414	0.93520
_20_3_11a	7.75	6.822	6.75	1.0E-05	8.185	0.93190	0.00086	0.93362	0.93520	0.93213	0.00073	0.93359	0.93520
_20_3_11b	7.75	6.822	6.75	1.0E-04	8.185	0.93227	0.00072	0.93371	0.93520	0.93173	0.00069	0.93311	0.93520
_20_3_11c	7.75	6.822	6.75	1.0E-03	8.185	0.93290	0.00072	0.93434	0.93520	0.93012	0.00071	0.93154	0.93520
UO_2-ThO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 1.25 g/cm^3													
_1_4_3	4.00	3.521	0.00	1.0E-20	2.830	0.81603	0.00070	0.81743	0.93520	0.81699	0.00083	0.81865	0.93520
_5_4_3	4.00	3.521	2.00	1.0E-20	4.227	0.82511	0.00075	0.82661	0.93520	0.82618	0.00077	0.82772	0.93520
_9_4_3	4.00	3.521	4.00	1.0E-20	5.625	0.83601	0.00071	0.83743	0.93520	0.83693	0.00075	0.83843	0.93520
_19_4_3	4.00	3.521	6.00	1.0E-20	7.022	0.84763	0.00067	0.84897	0.93680	0.84871	0.00065	0.85001	0.93680
_24_4_3	4.00	3.521	8.00	1.0E-20	8.420	0.86783	0.00072	0.86927	0.93680	0.86872	0.00073	0.87018	0.93680
_25_4_3	4.00	3.521	8.05	1.0E-20	8.490	0.86798	0.00079	0.86956	0.93680	0.86981	0.00073	0.87127	0.93680
_1_4_8	6.50	5.721	0.00	1.0E-20	4.599	0.89321	0.00081	0.89483	0.93520	0.89380	0.00084	0.89548	0.93520
_5_4_8	6.50	5.721	2.00	1.0E-20	5.996	0.89737	0.00080	0.89897	0.93520	0.89867	0.00075	0.90017	0.93520
_9_4_8	6.50	5.721	4.00	1.0E-20	7.394	0.91022	0.00080	0.91182	0.93520	0.91048	0.00070	0.91188	0.93520
_13_4_8	6.50	5.721	5.00	1.0E-20	8.092	0.92456	0.00074	0.92604	0.93520	0.91298	0.00080	0.91458	0.93520
_17_4_8	6.50	5.721	5.55	1.0E-20	8.477	0.93082	0.00081	0.93244	0.93520	0.93072	0.00070	0.93212	0.93520
_1_4_9	6.55	5.765	0.00	1.0E-20	4.634	0.89351	0.00074	0.89499	0.93520	0.89366	0.00073	0.89512	0.93520

Table 6.9.6-13h. Results for HEU oxide/thorium oxide content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ThOx (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxtho2t11*				HAC hcialdoxtho2t12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_5_4_9	6.55	5.765	2.00	1.0E-20	6.032	0.89875	0.00081	0.90037	0.93520	0.89835	0.00071	0.89977	0.93520
_9_4_9	6.55	5.765	4.00	1.0E-20	7.429	0.91252	0.00084	0.91420	0.93520	0.91078	0.00067	0.91212	0.93520
_13_4_9	6.55	5.765	5.00	1.0E-20	8.128	0.92452	0.00072	0.92596	0.93520	0.92452	0.00081	0.92614	0.93520
_16_4_9	6.55	5.765	5.50	1.0E-20	8.477	0.93277	0.00070	0.93417	0.93520	0.93294	0.00078	0.93450	0.93520
_16_4_9a	6.55	5.765	5.50	1.0E-05	8.477	0.93190	0.00074	0.93338	0.93520	0.93351	0.00068	0.93487	0.93520
_16_4_9b	6.55	5.765	5.50	1.0E-04	8.477	0.93299	0.00067	0.93433	0.93520	0.93280	0.00072	0.93424	0.93520
_16_4_9c	6.55	5.765	5.50	1.0E-03	8.477	0.92981	0.00069	0.93119	0.93520	0.93019	0.00085	0.93189	0.93520
UO_2-ThO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 1.00 g/cm^3													
_1_5_3	4.00	0.00	3.521	1.0E-20	3.629	0.84376	0.00076	0.84528	0.93520	0.84372	0.00073	0.84518	0.93520
_5_5_3	4.00	2.00	3.521	1.0E-20	5.425	0.85414	0.00073	0.85560	0.93520	0.85554	0.00076	0.85706	0.93520
_9_5_3	4.00	4.00	3.521	1.0E-20	7.222	0.86828	0.00075	0.86978	0.93680	0.86939	0.00074	0.87087	0.93680
_13_5_3	4.00	5.00	3.521	1.0E-20	8.120	0.88012	0.00069	0.88150	0.93680	0.88154	0.00079	0.88312	0.93680
_18_5_3	4.00	5.65	3.521	1.0E-20	8.704	0.88979	0.00083	0.89145	0.93680	0.89106	0.00075	0.89256	0.93680
_1_5_5	5.00	0.00	4.401	1.0E-20	4.536	0.87900	0.00100	0.88100	0.93520	0.87844	0.00079	0.88002	0.93520
_5_5_5	5.00	2.00	4.401	1.0E-20	6.332	0.88920	0.00080	0.89080	0.93520	0.88829	0.00070	0.88969	0.93520
_9_5_5	5.00	4.00	4.401	1.0E-20	8.129	0.90913	0.00080	0.91073	0.93680	0.90874	0.00078	0.91030	0.93680
_12_5_5	5.00	4.65	4.401	1.0E-20	8.713	0.91932	0.00078	0.92088	0.93680	0.92168	0.00081	0.92330	0.93680
_1_5_6	5.50	0.00	4.841	1.0E-20	4.989	0.89409	0.00077	0.89563	0.93520	0.89420	0.00072	0.89564	0.93520
_5_5_6	5.50	2.00	4.841	1.0E-20	6.786	0.90318	0.00074	0.90466	0.93520	0.90425	0.00074	0.90573	0.93520
_9_5_6	5.50	4.00	4.841	1.0E-20	8.583	0.93091	0.00075	0.93241	0.93680	0.93035	0.00089	0.93213	0.93680
_10_5_6	5.50	4.15	4.841	1.0E-20	8.718	0.93271	0.00069	0.93409	0.93680	0.93291	0.00069	0.93429	0.93680
_10_5_6a	5.50	4.15	4.841	1.0E-05	8.718	0.93193	0.00091	0.93375	0.93680	0.93322	0.00074	0.93470	0.93680
_10_5_6b	5.50	4.15	4.841	1.0E-04	8.718	0.93233	0.00078	0.93389	0.93680	0.93122	0.00073	0.93268	0.93680
_10_5_6c	5.50	4.15	4.841	1.0E-03	8.718	0.93057	0.00079	0.93215	0.93680	0.93098	0.00092	0.93282	0.93680

Table 6.9.6-13h. Results for HEU oxide/thorium oxide content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ThOx (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxtho2t11*				HAC hcialdoxtho2t12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
UO_2-ThO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 0.75 g/cm^3													
_1_6_1	3.00	0.00	2.641	1.0E-20	3.720	0.83119	0.00079	0.83277	0.93520	0.82963	0.00076	0.83115	0.93520
_5_6_1	3.00	2.00	2.641	1.0E-20	6.182	0.84821	0.00077	0.84975	0.93680	0.84754	0.00082	0.84918	0.93680
_7_6_1	3.00	3.00	2.641	1.0E-20	7.413	0.85752	0.00082	0.85916	0.93680	0.85897	0.00079	0.86055	0.93680
_9_6_1	3.00	4.00	2.641	1.0E-20	8.644	0.87130	0.00079	0.87288	0.93680	0.87270	0.00100	0.87470	0.93680
_11_6_1	3.00	4.25	2.641	1.0E-20	8.952	0.87677	0.00077	0.87831	0.93680	0.87644	0.00081	0.87806	0.93680
_1_6_3	4.00	0.00	5.281	1.0E-20	4.959	0.87706	0.00087	0.87880	0.93520	0.87747	0.00084	0.87915	0.93520
_5_6_3	4.00	2.00	5.281	1.0E-20	7.422	0.89209	0.00068	0.89345	0.93680	0.89195	0.00073	0.89341	0.93680
_7_6_3	4.00	3.00	5.281	1.0E-20	8.653	0.91088	0.00095	0.91278	0.93680	0.91164	0.00078	0.91320	0.93680
_8_6_3	4.00	3.25	5.281	1.0E-20	8.961	0.91633	0.00074	0.91781	0.93680	0.91684	0.00080	0.91844	0.93680
_1_6_4	4.60	0.00	4.049	1.0E-20	5.703	0.89990	0.00080	0.90150	0.93520	0.89972	0.00079	0.90130	0.93520
_2_6_4	4.60	1.00	4.049	1.0E-20	6.935	0.90574	0.00077	0.90728	0.93680	0.90730	0.00076	0.90882	0.93680
_5_6_4	4.60	2.00	4.049	1.0E-20	8.166	0.92076	0.00072	0.92220	0.93680	0.91900	0.00076	0.92052	0.93680
_6_6_4	4.60	2.65	4.049	1.0E-20	8.966	0.93468	0.00076	0.93620	0.93680	0.93294	0.00072	0.93438	0.93680
_6_6_4a	4.60	2.65	4.049	1.0E-05	8.966	0.93357	0.00074	0.93505	0.93680	0.93455	0.00073	0.93601	0.93680
_6_6_4b	4.60	2.65	4.049	1.0E-04	8.966	0.93426	0.00072	0.93570	0.93680	0.93453	0.00077	0.93607	0.93680
_6_6_4c	4.60	2.65	4.049	1.0E-03	8.966	0.93282	0.00077	0.93436	0.93680	0.93190	0.00073	0.93336	0.93680
UO_2-ThO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 0.50 g/cm^3													
_1_7_1	3.00	0.00	3.521	1.0E-20	5.716	0.87311	0.00081	0.87473	0.93680	0.87402	0.00095	0.87592	0.93680
_2_7_1	3.00	1.00	3.521	1.0E-20	7.613	0.88380	0.00100	0.88580	0.93680	0.88418	0.00080	0.88578	0.93680
_4_7_1	3.00	1.80	3.521	1.0E-20	9.130	0.90369	0.00078	0.90525	0.93680	0.90417	0.00073	0.90563	0.93680
_1_7_2	3.75	0.00	3.301	1.0E-20	7.145	0.90922	0.00080	0.91082	0.93680	0.91086	0.00088	0.91262	0.93680
_2_7_2	3.75	1.00	3.301	1.0E-20	9.042	0.93183	0.00082	0.93347	0.93680	0.93356	0.00078	0.93512	0.93680

Table 6.9.6-13h. Results for HEU oxide/thorium oxide content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ThOx (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxtho2t11*				HAC hcialdoxtho2t12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_3_7_2	3.75	1.05	3.301	1.0E-20	9.136	0.93447	0.00074	0.93595	0.93680	0.93519	0.00079	0.93677	0.93680
_3_7_2a	3.75	1.05	3.301	1.0E-05	9.136	0.93467	0.00087	0.93641	0.93680	0.93438	0.00082	0.93602	0.93680
_3_7_2b	3.75	1.05	3.301	1.0E-04	9.136	0.93451	0.00088	0.93627	0.93680	0.93342	0.00080	0.93502	0.93680
_3_7_2c	3.75	1.05	3.301	1.0E-03	9.136	0.93162	0.00085	0.93332	0.93680	0.93405	0.00094	0.93593	0.93680

Table 6.9.6-13i. Results for HEU oxide/zirconium oxide content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ZrOx (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxzro2t11*				HAC hcialdoxzro2t12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
UO_2-ZrO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 2.0 g/cm^3													
_1_1_14	9.0	7.922	0.00	1.0E-20	3.672	0.88456	0.00071	0.88598	0.93520	0.88509	0.00072	0.88653	0.93520
_5_1_14	9.0	7.922	2.00	1.0E-20	4.319	0.88479	0.00073	0.88625	0.93520	0.88541	0.00072	0.88685	0.93520
_9_1_14	9.0	7.922	4.00	1.0E-20	4.966	0.88680	0.00070	0.88820	0.93520	0.88648	0.00070	0.88788	0.93520
_14_1_14	9.0	7.922	6.00	1.0E-20	5.612	0.89311	0.00076	0.89463	0.93520	0.89181	0.00072	0.89325	0.93520
_17_1_14	9.0	7.922	7.00	1.0E-20	5.936	0.89577	0.00072	0.89721	0.93520	0.89710	0.00075	0.89860	0.93520
_1_1_16	10.0	8.802	0.00	1.0E-20	4.080	0.90175	0.00077	0.90329	0.93520	0.90132	0.00070	0.90272	0.93520
_5_1_16	10.0	8.802	2.00	1.0E-20	4.727	0.90152	0.00076	0.90304	0.93520	0.90186	0.00076	0.90338	0.93520
_9_1_16	10.0	8.802	4.00	1.0E-20	5.374	0.90514	0.00083	0.90680	0.93520	0.90446	0.00074	0.90594	0.93520
_14_1_16	10.0	8.802	6.00	1.0E-20	6.020	0.91127	0.00070	0.91267	0.93520	0.91144	0.00083	0.91310	0.93520
_1_1_17	11.0	9.682	0.00	1.0E-20	4.488	0.91705	0.00073	0.91851	0.93520	0.91608	0.00072	0.91752	0.93520

Table 6.9.6-13i. Results for HEU oxide/zirconium oxide content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ZrOx (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxzro2t11*				HAC hcialdoxzro2t12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_5_1_17	11.0	9.682	2.00	1.0E-20	5.135	0.91909	0.00086	0.92081	0.93520	0.91750	0.00077	0.91904	0.93520
_9_1_17	11.0	9.682	4.00	1.0E-20	5.782	0.92243	0.00069	0.92381	0.93520	0.92225	0.00074	0.92373	0.93520
_12_1_17	11.0	9.682	5.00	1.0E-20	6.105	0.92364	0.00083	0.92530	0.93520	0.92407	0.00069	0.92545	0.93520
_12_1_17a	11.0	9.682	5.00	1.0E-05	6.105	0.92528	0.00089	0.92706	0.93520	0.92606	0.00069	0.92744	0.93520
_12_1_17b	11.0	9.682	5.00	1.0E-04	6.105	0.92467	0.00081	0.92629	0.93520	0.92577	0.00074	0.92725	0.93520
_12_1_17c	11.0	9.682	5.00	1.0E-03	6.105	0.92451	0.00094	0.92639	0.93520	0.92288	0.00078	0.92444	0.93520
UO_2-ZrO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 1.75 g/cm^3													
_1_2_13	8.00	7.042	0.00	1.0E-20	3.835	0.88118	0.00080	0.88278	0.93520	0.88269	0.00080	0.88429	0.93520
_5_2_13	8.00	7.042	2.00	1.0E-20	4.624	0.88695	0.00075	0.88845	0.93520	0.88704	0.00077	0.88858	0.93520
_9_2_13	8.00	7.042	4.00	1.0E-20	5.413	0.89306	0.00074	0.89454	0.93520	0.89245	0.00094	0.89433	0.93520
_14_2_13	8.00	7.042	6.00	1.0E-20	6.206	0.90114	0.00087	0.90288	0.93520	0.90099	0.00072	0.90243	0.93520
_21_2_13	8.00	7.042	8.00	1.0E-20	6.992	0.91861	0.00071	0.92003	0.93520	0.91829	0.00070	0.91969	0.93520
_1_2_14	9.00	7.922	0.00	1.0E-20	4.314	0.90096	0.00070	0.90236	0.93520	0.90166	0.00072	0.90310	0.93520
_5_2_14	9.00	7.922	2.00	1.0E-20	5.103	0.90583	0.00073	0.90729	0.93520	0.90631	0.00071	0.90773	0.93520
_9_2_14	9.00	7.922	4.00	1.0E-20	5.893	0.91114	0.00082	0.91278	0.93520	0.91280	0.00072	0.91424	0.93520
_14_2_14	9.00	7.922	6.00	1.0E-20	6.682	0.92291	0.00070	0.92431	0.93520	0.92293	0.00075	0.92443	0.93520
_16_2_14	9.00	7.922	6.65	1.0E-20	6.938	0.92926	0.00080	0.93086	0.93520	0.92987	0.00066	0.93119	0.93520
_1_2_15	9.55	8.406	0.00	1.0E-20	4.578	0.91009	0.00076	0.91161	0.93520	0.91198	0.00068	0.91334	0.93520
_5_2_15	9.55	8.406	2.00	1.0E-20	5.367	0.91456	0.00073	0.91602	0.93520	0.91463	0.00073	0.91609	0.93520
_9_2_15	9.55	8.406	4.00	1.0E-20	6.156	0.92143	0.00082	0.92307	0.93520	0.92268	0.00073	0.92414	0.93520
_12_2_15	9.55	8.406	5.00	1.0E-20	6.551	0.92937	0.00076	0.93089	0.93520	0.92943	0.00090	0.93123	0.93520
_13_2_15	9.55	8.406	5.65	1.0E-20	6.807	0.93312	0.00073	0.93458	0.93520	0.93355	0.00075	0.93505	0.93520
_13_2_15a	9.55	8.406	5.65	1.0E-05	6.807	0.93231	0.00071	0.93373	0.93520	0.93327	0.00067	0.93461	0.93520
_13_2_15b	9.55	8.406	5.65	1.0E-04	6.807	0.93280	0.00076	0.93432	0.93520	0.93345	0.00071	0.93487	0.93520

Table 6.9.6-13i. Results for HEU oxide/zirconium oxide content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ZrOx (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxzro2t11*				HAC hcialdoxzro2t12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_13_2_15c	9.55	8.406	5.65	1.0E-03	6.807	0.92996	0.00071	0.93138	0.93520	0.93170	0.00100	0.93370	0.93520
UO_2-ZrO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 1.50 g/cm^3													
_1_3_6	5.00	4.401	0.00	1.0E-20	2.872	0.82779	0.00071	0.82921	0.93520	0.82823	0.00071	0.82965	0.93520
_5_3_6	5.00	4.401	2.00	1.0E-20	3.851	0.83959	0.00074	0.84107	0.93520	0.83806	0.00073	0.83952	0.93520
_9_3_6	5.00	4.401	4.00	1.0E-20	4.831	0.84967	0.00074	0.85115	0.93520	0.84854	0.00094	0.85042	0.93520
_14_3_6	5.00	4.401	6.00	1.0E-20	5.810	0.85935	0.00075	0.86085	0.93520	0.85911	0.00084	0.86079	0.93520
_21_3_6	5.00	4.401	8.00	1.0E-20	6.790	0.87429	0.00073	0.87575	0.93520	0.87543	0.00071	0.87685	0.93520
_24_3_6	5.00	4.401	9.00	1.0E-20	7.280	0.88673	0.00081	0.88835	0.93520	0.88800	0.00079	0.88958	0.93520
_25_3_6	5.00	4.401	9.50	1.0E-20	7.524	0.89315	0.00085	0.89485	0.93520	0.89278	0.00083	0.00000	0.93520
_1_3_8	6.00	5.281	0.00	1.0E-20	3.446	0.85797	0.00081	0.85959	0.93520	0.85607	0.00083	0.85773	0.93520
_5_3_8	6.00	5.281	2.00	1.0E-20	4.426	0.86573	0.00084	0.86741	0.93520	0.86543	0.00086	0.86715	0.93520
_9_3_8	6.00	5.281	4.00	1.0E-20	5.405	0.87596	0.00082	0.87760	0.93520	0.87575	0.00080	0.87735	0.93520
_14_3_8	6.00	5.281	6.00	1.0E-20	6.385	0.88613	0.00077	0.88767	0.93520	0.88728	0.00077	0.88882	0.93520
_21_3_10	6.00	5.281	8.00	1.0E-20	7.364	0.90927	0.00079	0.91085	0.93520	0.90955	0.00078	0.91111	0.93520
_23_3_10	6.00	5.281	8.50	1.0E-20	7.609	0.91360	0.00069	0.91498	0.93520	0.91554	0.00073	0.91700	0.93520
_1_3_11	6.90	6.073	0.00	1.0E-20	3.963	0.88021	0.00078	0.88177	0.93520	0.87826	0.00081	0.87988	0.93520
_5_3_11	6.90	6.073	2.00	1.0E-20	4.943	0.88707	0.00087	0.88881	0.93520	0.88724	0.00071	0.88866	0.93520
_9_3_11	6.90	6.073	4.00	1.0E-20	5.922	0.89723	0.00076	0.89875	0.93520	0.89704	0.00095	0.89894	0.93520
_14_3_11	6.90	6.073	6.00	1.0E-20	6.902	0.91250	0.00073	0.91396	0.93520	0.91181	0.00075	0.91331	0.93520
_17_3_11	6.90	6.073	7.00	1.0E-20	7.391	0.92382	0.00073	0.92528	0.93520	0.92393	0.00076	0.92545	0.93520
_20_3_11	6.90	6.073	7.55	1.0E-20	7.661	0.93218	0.00081	0.93380	0.93520	0.93121	0.00074	0.93269	0.93520
_20_3_11a	6.90	6.073	7.55	1.0E-05	7.661	0.93078	0.00073	0.93224	0.93520	0.93194	0.00069	0.93332	0.93520
_20_3_11b	6.90	6.073	7.55	1.0E-04	7.661	0.93214	0.00070	0.93354	0.93520	0.93174	0.00072	0.93318	0.93520
_20_3_11c	6.90	6.073	7.55	1.0E-03	7.661	0.92971	0.00081	0.93133	0.93520	0.92927	0.00079	0.93085	0.93520

Table 6.9.6-13i. Results for HEU oxide/zirconium oxide content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ZrOx (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxzro2t11*				HAC hcialdoxzro2t12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
UO_2-ZrO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 1.25 g/cm^3													
_1_4_3	4.00	3.521	0.00	1.0E-20	2.830	0.81629	0.00093	0.81815	0.93520	0.81660	0.00087	0.81834	0.93520
_5_4_3	4.00	3.521	2.00	1.0E-20	4.076	0.83307	0.00082	0.83471	0.93520	0.83359	0.00081	0.83521	0.93520
_9_4_3	4.00	3.521	4.00	1.0E-20	5.321	0.84703	0.00077	0.84857	0.93520	0.84717	0.00081	0.84879	0.93520
_19_4_3	4.00	3.521	6.00	1.0E-20	6.567	0.86193	0.00075	0.86343	0.93520	0.86328	0.00086	0.86500	0.93520
_21_4_3	4.00	3.521	8.00	1.0E-20	7.813	0.88845	0.00086	0.89017	0.93520	0.88670	0.00076	0.88822	0.93520
_22_4_3	4.00	3.521	8.05	1.0E-20	7.844	0.88734	0.00085	0.88904	0.93520	0.88954	0.00083	0.89120	0.93520
_1_4_6	5.00	4.401	0.00	1.0E-20	3.537	0.85240	0.00075	0.85390	0.93520	0.85065	0.00089	0.85243	0.93520
_5_4_6	5.00	4.401	2.00	1.0E-20	4.783	0.86545	0.00081	0.86707	0.93520	0.86567	0.00075	0.86717	0.93520
_9_4_6	5.00	4.401	4.00	1.0E-20	6.029	0.87819	0.00092	0.88003	0.93520	0.87870	0.00100	0.88070	0.93520
_14_4_6	5.00	4.401	6.00	1.0E-20	7.274	0.89861	0.00074	0.90009	0.93520	0.89822	0.00080	0.89982	0.93520
_18_4_6	5.00	4.401	7.05	1.0E-20	7.928	0.91505	0.00082	0.91669	0.93680	0.91581	0.00076	0.91733	0.93680
_1_4_7	5.80	5.105	0.00	1.0E-20	4.103	0.87321	0.00074	0.87469	0.93520	0.87522	0.00090	0.87702	0.93520
_5_4_7	5.80	5.105	2.00	1.0E-20	5.349	0.88822	0.00073	0.88968	0.93520	0.88787	0.00087	0.88961	0.93520
_9_4_7	5.80	5.105	4.00	1.0E-20	6.595	0.90103	0.00086	0.90275	0.93520	0.90284	0.00080	0.90444	0.93520
_14_4_7	5.80	5.105	6.00	1.0E-20	7.840	0.92885	0.00075	0.93035	0.93520	0.92789	0.00063	0.92915	0.93520
_15_4_7	5.80	5.105	6.25	1.0E-20	7.996	0.93291	0.00080	0.93451	0.93520	0.93128	0.00075	0.93278	0.93520
_15_4_7a	5.80	5.105	6.25	1.0E-05	7.996	0.93286	0.00084	0.93454	0.93520	0.93327	0.00072	0.93471	0.93520
_15_4_7b	5.80	5.105	6.25	1.0E-04	7.996	0.93117	0.00077	0.93271	0.93520	0.93222	0.00074	0.93370	0.93520
_15_4_7c	5.80	5.105	6.25	1.0E-03	7.996	0.92934	0.00083	0.93100	0.93520	0.93072	0.00084	0.93240	0.93520
UO_2-ZrO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 1.00 g/cm^3													
_1_5_1	3.00	3.521	0.00	1.0E-20	3.629	0.79783	0.00085	0.79953	0.93520	0.79985	0.00086	0.80157	0.93520
_5_5_1	3.00	3.521	2.00	1.0E-20	4.366	0.82620	0.00079	0.82778	0.93520	0.82596	0.00067	0.82730	0.93520
_9_5_1	3.00	3.521	4.00	1.0E-20	6.011	0.84211	0.00091	0.84393	0.93680	0.84292	0.00092	0.84476	0.93680

Table 6.9.6-13i. Results for HEU oxide/zirconium oxide content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ZrOx (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxzro2t11*				HAC hcialdoxzro2t12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_14_5_1	3.00	3.521	6.00	1.0E-20	7.656	0.86360	0.00076	0.86512	0.93680	0.86252	0.00080	0.86412	0.93680
_16_5_1	3.00	3.521	6.65	1.0E-20	8.704	0.87326	0.00092	0.87510	0.93680	0.87494	0.00085	0.87664	0.93680
_1_5_3	4.00	3.521	0.00	1.0E-20	3.629	0.83425	0.00073	0.83571	0.93520	0.84303	0.00074	0.84451	0.93520
_5_5_3	4.00	3.521	2.00	1.0E-20	5.273	0.86526	0.00078	0.86682	0.93520	0.86450	0.00080	0.86610	0.93520
_9_5_3	4.00	3.521	4.00	1.0E-20	6.918	0.88277	0.00081	0.88439	0.93680	0.88303	0.00073	0.88449	0.93680
_12_5_3	4.00	3.521	5.00	1.0E-20	7.741	0.89713	0.00077	0.89867	0.93680	0.89724	0.00083	0.89890	0.93680
_13_5_3	4.00	3.521	5.65	1.0E-20	8.704	0.90753	0.00078	0.90909	0.93680	0.90990	0.00100	0.91190	0.93680
_1_5_5	4.90	4.313	0.00	1.0E-20	4.445	0.87567	0.00069	0.87705	0.93520	0.87535	0.00082	0.87699	0.93520
_5_5_5	4.90	4.313	2.00	1.0E-20	6.090	0.89320	0.00100	0.89520	0.93520	0.89480	0.00072	0.89624	0.93520
_9_5_5	4.90	4.313	4.00	1.0E-20	7.735	0.91874	0.00075	0.92024	0.93680	0.91824	0.00092	0.92008	0.93680
_11_5_5	4.90	4.313	4.75	1.0E-20	8.352	0.93329	0.00085	0.93499	0.93680	0.93473	0.00094	0.93661	0.93680
_11_5_5a	4.90	4.313	4.75	1.0E-05	8.352	0.93400	0.00073	0.93546	0.93680	0.93452	0.00087	0.93626	0.93680
_11_5_5b	4.90	4.313	4.75	1.0E-04	8.352	0.93285	0.00071	0.93427	0.93680	0.93198	0.00074	0.93346	0.93680
_11_5_5c	4.90	4.313	4.75	1.0E-03	8.352	0.92994	0.00071	0.93136	0.93680	0.93062	0.00075	0.93212	0.93680
UO_2-ZrO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 0.75 g/cm^3													
_1_6_1	3.00	2.641	0.00	1.0E-20	3.720	0.83032	0.00076	0.83184	0.93520	0.83032	0.00074	0.83180	0.93520
_5_6_1	3.00	2.641	2.00	1.0E-20	6.030	0.85964	0.00076	0.86116	0.93680	0.86062	0.00083	0.86228	0.93680
_7_6_1	3.00	2.641	3.00	1.0E-20	7.185	0.87085	0.00091	0.87267	0.93680	0.87059	0.00079	0.87217	0.93680
_9_6_1	3.00	2.641	4.00	1.0E-20	8.340	0.88940	0.00084	0.89108	0.93680	0.89009	0.00082	0.89173	0.93680
_10_6_1	3.00	2.641	4.25	1.0E-20	8.629	0.89405	0.00083	0.89571	0.93680	0.89533	0.00081	0.89695	0.93680
_1_6_3	4.00	5.281	0.00	1.0E-20	4.959	0.87725	0.00077	0.87879	0.93520	0.87741	0.00082	0.87905	0.93520
_5_6_3	4.00	5.281	2.00	1.0E-20	7.270	0.90408	0.00082	0.90572	0.93680	0.90344	0.00074	0.90492	0.93680
_6_6_3	4.00	5.281	3.00	1.0E-20	8.425	0.92352	0.00079	0.92510	0.93680	0.92368	0.00075	0.92518	0.93680
_8_6_3	4.00	5.281	3.25	1.0E-20	8.714	0.92979	0.00074	0.93127	0.93680	0.93073	0.00075	0.93223	0.93680

Table 6.9.6-13i. Results for HEU oxide/zirconium oxide content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	ZrOx (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxzro2t11*				HAC hcialdoxzro2t12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_1_6_4	4.10	3.609	0.00	1.0E-20	5.083	0.88008	0.00088	0.88184	0.93520	0.87880	0.00100	0.88080	0.93520
_2_6_4	4.10	3.609	1.00	1.0E-20	6.239	0.89234	0.00088	0.89410	0.93680	0.89311	0.00088	0.89487	0.93680
_5_6_4	4.10	3.609	2.00	1.0E-20	7.394	0.90686	0.00074	0.90834	0.93680	0.90743	0.00076	0.90895	0.93680
_7_6_4	4.10	3.609	3.15	1.0E-20	8.722	0.93256	0.00078	0.93412	0.93680	0.93240	0.00077	0.93394	0.93680
_7_6_4a	4.10	3.609	3.15	1.0E-05	8.722	0.93290	0.00077	0.93444	0.93680	0.93297	0.00081	0.93459	0.93680
_7_6_4b	4.10	3.609	3.15	1.0E-04	8.722	0.93331	0.00077	0.93485	0.93680	0.93285	0.00079	0.93443	0.93680
_7_6_4c	4.10	3.609	3.15	1.0E-03	8.722	0.93081	0.00077	0.93235	0.93680	0.93281	0.00069	0.93419	0.93680
UO_2-ZrO_2 content and 500 g polyethylene in flooded containment vessel, flooded package at 0.50 g/cm^3													
_1_7_1	3.00	3.521	0.00	1.0E-20	5.716	0.87291	0.00084	0.87459	0.93680	0.87222	0.00076	0.87374	0.93680
_2_7_1	3.00	3.521	1.00	1.0E-20	7.537	0.89015	0.00072	0.89159	0.93680	0.89163	0.00079	0.89321	0.93680
_4_7_1	3.00	3.521	1.80	1.0E-20	9.130	0.91341	0.00089	0.91519	0.93680	0.91444	0.00073	0.91590	0.93680
_1_7_2	3.50	3.081	0.00	1.0E-20	6.669	0.89799	0.00084	0.89967	0.93680	0.89826	0.00082	0.89990	0.93680
_2_7_2	3.50	3.081	1.00	1.0E-20	8.489	0.92115	0.00073	0.92261	0.93680	0.92056	0.00079	0.92214	0.93680
_3_7_2	3.50	3.081	1.30	1.0E-20	9.036	0.93283	0.00090	0.93463	0.93680	0.93245	0.00082	0.93409	0.93680
_3_7_2a	3.50	3.081	1.30	1.0E-05	9.036	0.93275	0.00088	0.93451	0.93680	0.93286	0.00079	0.93444	0.93680
_3_7_2b	3.50	3.081	1.30	1.0E-04	9.036	0.93291	0.00087	0.93465	0.93680	0.93337	0.00082	0.93501	0.93680
_3_7_2c	3.50	3.081	1.30	1.0E-03	9.036	0.93155	0.00087	0.93329	0.93680	0.93325	0.00087	0.93499	0.93680

Table 6.9.6-13j. Results for HEU oxide/thorium metal content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	Th (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxthmt11*				HAC hcialdoxthmt12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
UO_2-Th content and 500 g polyethylene in flooded containment vessel, flooded package at 2.0 g/cm^3													
_1_1_13	9.0	7.922	0.00	1.0E-20	3.672	0.88364	0.00077	0.88518	0.93520	0.88260	0.00083	0.88426	0.93520
_5_1_13	9.0	7.922	2.00	1.0E-20	4.471	0.88040	0.00078	0.88196	0.93520	0.87907	0.00065	0.88037	0.93520
_9_1_13	9.0	7.922	4.00	1.0E-20	5.269	0.88086	0.00080	0.88246	0.93520	0.88234	0.00069	0.88372	0.93520
_19_1_13	9.0	7.922	6.00	1.0E-20	6.068	0.88799	0.00081	0.88961	0.93520	0.88581	0.00093	0.88767	0.93520
_21_1_13	9.0	7.922	7.00	1.0E-20	6.467	0.89132	0.00073	0.89278	0.93520	0.89100	0.00100	0.89300	0.93520
_1_1_14	10.0	8.802	0.00	1.0E-20	4.080	0.90090	0.00078	0.90246	0.93520	0.90067	0.00073	0.90213	0.93520
_5_1_14	10.0	8.802	2.00	1.0E-20	4.879	0.89667	0.00064	0.89795	0.93520	0.89671	0.00083	0.89837	0.93520
_9_1_14	10.0	8.802	4.00	1.0E-20	5.677	0.89813	0.00064	0.89941	0.93520	0.89898	0.00079	0.90056	0.93520
_19_1_14	10.0	8.802	6.00	1.0E-20	6.476	0.90574	0.00069	0.90712	0.93520	0.90464	0.00066	0.90596	0.93520
_1_1_16	11.0	9.682	0.00	1.0E-20	4.488	0.91869	0.00070	0.92009	0.93520	0.91768	0.00074	0.91916	0.93520
_5_1_16	11.0	9.682	2.00	1.0E-20	5.287	0.91310	0.00075	0.91460	0.93520	0.91365	0.00062	0.91489	0.93520
_9_1_16	11.0	9.682	4.00	1.0E-20	6.085	0.91538	0.00077	0.91692	0.93520	0.91595	0.00077	0.91749	0.93520
_13_1_16	11.0	9.682	5.00	1.0E-20	6.485	0.91902	0.00070	0.92042	0.93520	0.91916	0.00078	0.92072	0.93520
_13_1_16a	11.0	9.682	5.00	1.0E-05	6.485	0.91940	0.00076	0.92092	0.93520	0.91844	0.00072	0.91988	0.93520
_13_1_16b	11.0	9.682	5.00	1.0E-04	6.485	0.91835	0.00072	0.91979	0.93520	0.91866	0.00066	0.91998	0.93520
_13_1_16c	11.0	9.682	5.00	1.0E-03	6.485	0.91627	0.00067	0.91761	0.93520	0.91718	0.00073	0.91864	0.93520
UO_2-Th content and 500 g polyethylene in flooded containment vessel, flooded package at 1.75 g/cm^3													
_1_2_13	9.00	7.922	0.00	1.0E-20	4.314	0.90171	0.00073	0.90317	0.93520	0.90061	0.00083	0.90227	0.93520
_5_2_13	9.00	7.922	2.00	1.0E-20	5.255	0.90061	0.00077	0.90215	0.93520	0.89950	0.00068	0.90086	0.93520
_9_2_13	9.00	7.922	4.00	1.0E-20	6.196	0.90381	0.00076	0.90533	0.93520	0.90510	0.00070	0.90650	0.93520
_19_2_13	9.00	7.922	6.00	1.0E-20	7.137	0.91487	0.00074	0.91635	0.93520	0.91549	0.00074	0.91697	0.93520
_21_2_13	9.00	7.922	7.00	1.0E-20	7.608	0.92383	0.00075	0.92533	0.93520	0.92372	0.00070	0.92512	0.93520

Table 6.9.6-13j. Results for HEU oxide/thorium metal content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	Th (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxthmt11*				HAC hcialdoxthmt12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_1_2_14	10.0	8.802	0.00	1.0E-20	4.793	0.91976	0.00072	0.92120	0.93520	0.91950	0.00068	0.92086	0.93520
_2_2_14	10.0	8.802	1.00	1.0E-20	5.264	0.91633	0.00079	0.91791	0.93520	0.91588	0.00076	0.91740	0.93520
_5_2_14	10.0	8.802	2.00	1.0E-20	5.734	0.91678	0.00079	0.91836	0.93520	0.91680	0.00073	0.91826	0.93520
_9_2_14	10.0	8.802	4.00	1.0E-20	6.676	0.91270	0.00071	0.91412	0.93520	0.92374	0.00081	0.92536	0.93520
_15_2_14	10.0	8.802	5.35	1.0E-20	7.310	0.93158	0.00070	0.93298	0.93520	0.93143	0.00074	0.93291	0.93520
_1_2_15	10.1	8.890	0.00	1.0E-20	4.841	0.92193	0.00069	0.92331	0.93520	0.92032	0.00069	0.92170	0.93520
_5_2_15	10.1	8.890	2.00	1.0E-20	5.782	0.91840	0.00071	0.91982	0.93520	0.91843	0.00074	0.91991	0.93520
_9_2_15	10.1	8.890	4.00	1.0E-20	6.724	0.92443	0.00071	0.92585	0.93520	0.92509	0.00067	0.92643	0.93520
_13_2_15	10.1	8.890	5.00	1.0E-20	7.194	0.93048	0.00071	0.93190	0.93520	0.93250	0.00085	0.93420	0.93520
_14_2_15	10.1	8.890	5.10	1.0E-20	7.241	0.93229	0.00079	0.93387	0.93520	0.93212	0.00088	0.93388	0.93520
_14_2_15a	10.1	8.890	5.10	1.0E-05	7.241	0.93209	0.00074	0.93357	0.93520	0.93257	0.00071	0.93399	0.93520
_14_2_15b	10.1	8.890	5.10	1.0E-04	7.241	0.92974	0.00081	0.93136	0.93520	0.93119	0.00092	0.93303	0.93520
_14_2_15c	10.1	8.890	5.10	1.0E-03	7.241	0.92917	0.00069	0.93055	0.93520	0.93007	0.00074	0.93155	0.93520
UO_2-Th content and 500 g polyethylene in flooded containment vessel, flooded package at 1.50 g/cm^3													
_1_3_7	6.00	5.281	0.00	1.0E-20	3.446	0.85817	0.00074	0.85965	0.93520	0.85610	0.00072	0.85754	0.93520
_5_3_7	6.00	5.281	2.00	1.0E-20	4.578	0.85943	0.00090	0.86123	0.93520	0.85908	0.00080	0.86068	0.93520
_9_3_7	6.00	5.281	4.00	1.0E-20	5.709	0.86483	0.00075	0.86633	0.93520	0.86595	0.00071	0.86737	0.93520
_19_3_7	6.00	5.281	6.00	1.0E-20	6.840	0.87544	0.00074	0.87692	0.93520	0.87640	0.00074	0.87788	0.93520
_24_3_7	6.00	5.281	8.00	1.0E-20	7.971	0.89448	0.00080	0.89608	0.93520	0.89447	0.00072	0.89591	0.93520
_26_3_7	6.00	5.281	8.50	1.0E-20	8.254	0.90029	0.00073	0.90175	0.93520	0.90000	0.00071	0.90142	0.93520
_1_3_10	7.00	6.161	0.00	1.0E-20	4.021	0.88174	0.00081	0.88336	0.93520	0.88149	0.00069	0.88287	0.93520
_5_3_10	7.00	6.161	2.00	1.0E-20	5.152	0.88160	0.00076	0.88312	0.93520	0.88258	0.00082	0.88422	0.93520
_9_3_10	7.00	6.161	4.00	1.0E-20	6.283	0.88947	0.00076	0.89099	0.93520	0.89094	0.00072	0.89238	0.93520
_19_3_10	7.00	6.161	6.00	1.0E-20	7.415	0.90187	0.00070	0.90327	0.93520	0.90194	0.00064	0.90322	0.93520

Table 6.9.6-13j. Results for HEU oxide/thorium metal content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	Th (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxthmt11*				HAC hcialdoxthmt12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_21_3_10	7.00	6.161	7.00	1.0E-20	7.839	0.91325	0.00087	0.91499	0.93520	0.91406	0.00073	0.91552	0.93520
_22_3_10	7.00	6.161	7.40	1.0E-20	8.207	0.91889	0.00077	0.92043	0.93520	0.91847	0.00074	0.91995	0.93520
_1_3_11	7.75	6.821	0.00	1.0E-20	4.452	0.89695	0.00071	0.89837	0.93520	0.88149	0.00069	0.88287	0.93520
_5_3_11	7.75	6.821	2.00	1.0E-20	5.583	0.89833	0.00081	0.89995	0.93520	0.88258	0.00082	0.88422	0.93520
_9_3_11	7.75	6.821	4.00	1.0E-20	6.714	0.90599	0.00071	0.90741	0.93520	0.89094	0.00072	0.89238	0.93520
_19_3_11	7.75	6.821	6.00	1.0E-20	7.845	0.92338	0.00076	0.92490	0.93520	0.90194	0.00064	0.90322	0.93520
_20_3_11	7.75	6.821	6.80	1.0E-20	8.185	0.93325	0.00087	0.93499	0.93520	0.91406	0.00073	0.91552	0.93520
_20_3_11a	7.75	6.821	6.80	1.0E-05	8.185	0.93303	0.00076	0.93455	0.93520	0.91847	0.00074	0.91995	0.93520
_20_3_11b	7.75	6.821	6.80	1.0E-04	8.185	0.93278	0.00071	0.93420	0.93520	0.88149	0.00069	0.88287	0.93520
_20_3_11c	7.75	6.821	6.80	1.0E-03	8.185	0.92962	0.00072	0.93106	0.93520	0.88258	0.00082	0.88422	0.93520
UO_2-Th content and 500 g polyethylene in flooded containment vessel, flooded package at 1.25 g/cm^3													
_1_4_3	4.00	3.521	0.00	1.0E-20	2.830	0.81592	0.00076	0.81744	0.93520	0.81547	0.00069	0.81685	0.93520
_5_4_3	4.00	3.521	2.00	1.0E-20	4.227	0.82561	0.00078	0.82717	0.93520	0.82606	0.00075	0.82756	0.93520
_9_4_3	4.00	3.521	4.00	1.0E-20	5.625	0.83633	0.00069	0.83771	0.93520	0.83494	0.00074	0.83642	0.93520
_19_4_3	4.00	3.521	6.00	1.0E-20	7.022	0.84471	0.00082	0.84635	0.93680	0.84600	0.00083	0.84766	0.93680
_24_4_3	4.00	3.521	8.00	1.0E-20	8.420	0.86595	0.00073	0.86741	0.93680	0.86720	0.00068	0.86856	0.93680
_25_4_3	4.00	3.521	8.05	1.0E-20	8.490	0.86621	0.00087	0.86795	0.93680	0.86745	0.00074	0.86893	0.93680
_1_4_8	6.50	5.721	0.00	1.0E-20	4.599	0.89164	0.00074	0.89312	0.93520	0.89421	0.00090	0.89601	0.93520
_5_4_8	6.50	5.721	2.00	1.0E-20	5.996	0.89585	0.00076	0.89737	0.93520	0.89719	0.00090	0.89899	0.93520
_9_4_8	6.50	5.721	4.00	1.0E-20	7.394	0.91014	0.00066	0.91146	0.93520	0.91045	0.00092	0.91229	0.93520
_13_4_8	6.50	5.721	5.00	1.0E-20	8.092	0.92236	0.00072	0.92380	0.93520	0.92324	0.00073	0.92470	0.93520
_17_4_8	6.50	5.721	5.55	1.0E-20	8.477	0.92910	0.00110	0.93130	0.93520	0.93057	0.00076	0.93209	0.93520
_1_4_9	6.55	5.765	0.00	1.0E-20	4.634	0.89362	0.00079	0.89520	0.93520	0.89406	0.00070	0.89546	0.93520
_5_4_9	6.55	5.765	2.00	1.0E-20	6.032	0.89811	0.00075	0.89961	0.93520	0.89835	0.00067	0.89969	0.93520

Table 6.9.6-13j. Results for HEU oxide/thorium metal content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	Th (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxthmt11*				HAC hcialdoxthmt12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_9_4_9	6.55	5.765	4.00	1.0E-20	7.429	0.91121	0.00078	0.91277	0.93520	0.91113	0.00072	0.91257	0.93520
_13_4_9	6.55	5.765	5.00	1.0E-20	8.128	0.92310	0.00076	0.92462	0.93520	0.92310	0.00072	0.92454	0.93520
_16_4_9	6.55	5.765	5.50	1.0E-20	8.477	0.93128	0.00068	0.93264	0.93520	0.93037	0.00066	0.93169	0.93520
_16_4_9a	6.55	5.765	5.50	1.0E-05	8.477	0.93166	0.00070	0.93306	0.93520	0.93260	0.00100	0.93460	0.93520
_16_4_9b	6.55	5.765	5.50	1.0E-04	8.477	0.93133	0.00074	0.93281	0.93520	0.93217	0.00080	0.93377	0.93520
_16_4_9c	6.55	5.765	5.50	1.0E-03	8.477	0.92973	0.00071	0.93115	0.93520	0.92896	0.00075	0.93046	0.93520
UO_2-Th content and 500 g polyethylene in flooded containment vessel, flooded package at 1.00 g/cm^3													
_1_5_3	4.00	0.00	3.521	1.0E-20	3.629	0.84301	0.00072	0.84445	0.93520	0.84380	0.00085	0.84550	0.93520
_5_5_3	4.00	2.00	3.521	1.0E-20	5.425	0.85516	0.00079	0.85674	0.93520	0.85456	0.00085	0.85626	0.93520
_9_5_3	4.00	4.00	3.521	1.0E-20	7.222	0.86957	0.00079	0.87115	0.93680	0.86886	0.00079	0.87044	0.93680
_13_5_3	4.00	5.00	3.521	1.0E-20	8.120	0.87866	0.00082	0.88030	0.93680	0.87911	0.00073	0.88057	0.93680
_18_5_3	4.00	5.65	3.521	1.0E-20	8.704	0.89009	0.00077	0.89163	0.93680	0.89037	0.00074	0.89185	0.93680
_1_5_5	5.00	0.00	4.401	1.0E-20	4.536	0.87828	0.00082	0.87992	0.93520	0.87754	0.00089	0.87932	0.93520
_5_5_5	5.00	2.00	4.401	1.0E-20	6.332	0.88829	0.00072	0.88973	0.93520	0.88826	0.00076	0.88978	0.93520
_9_5_5	5.00	4.00	4.401	1.0E-20	8.129	0.90719	0.00081	0.90881	0.93680	0.90855	0.00077	0.91009	0.93680
_12_5_5	5.00	4.65	4.401	1.0E-20	8.713	0.91862	0.00086	0.92034	0.93680	0.91976	0.00082	0.92140	0.93680
_1_5_6	5.50	0.00	4.841	1.0E-20	4.989	0.89214	0.00085	0.89384	0.93520	0.89446	0.00075	0.89596	0.93520
_5_5_6	5.50	2.00	4.841	1.0E-20	6.786	0.90194	0.00072	0.90338	0.93520	0.90230	0.00080	0.90390	0.93520
_9_5_6	5.50	4.00	4.841	1.0E-20	8.583	0.92946	0.00083	0.93112	0.93680	0.92883	0.00080	0.93043	0.93680
_10_5_6	5.50	4.15	4.841	1.0E-20	8.718	0.93186	0.00084	0.93354	0.93680	0.93010	0.00067	0.93144	0.93680
_10_5_6a	5.50	4.15	4.841	1.0E-05	8.718	0.93115	0.00078	0.93271	0.93680	0.93149	0.00074	0.93297	0.93680
_10_5_6b	5.50	4.15	4.841	1.0E-04	8.718	0.92966	0.00072	0.93110	0.93680	0.93094	0.00075	0.93244	0.93680
_10_5_6c	5.50	4.15	4.841	1.0E-03	8.718	0.92833	0.00071	0.92975	0.93680	0.92997	0.00072	0.93141	0.93680

Table 6.9.6-13j. Results for HEU oxide/thorium metal content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	Th (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxthmt11*				HAC hcialdoxthmt12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
UO_2-Th content and 500 g polyethylene in flooded containment vessel, flooded package at 0.75 g/cm^3													
_1_6_1	3.00	0.00	2.641	1.0E-20	3.720	0.83090	0.00078	0.83246	0.93520	0.83169	0.00085	0.83339	0.93520
_5_6_1	3.00	2.00	2.641	1.0E-20	6.182	0.84682	0.00080	0.84842	0.93680	0.84772	0.00071	0.84914	0.93680
_7_6_1	3.00	3.00	2.641	1.0E-20	7.413	0.85493	0.00077	0.85647	0.93680	0.85465	0.00071	0.85607	0.93680
_9_6_1	3.00	4.00	2.641	1.0E-20	8.644	0.86971	0.00073	0.87117	0.93680	0.86867	0.00087	0.87041	0.93680
_11_6_1	3.00	4.25	2.641	1.0E-20	8.952	0.87297	0.00086	0.87469	0.93680	0.87392	0.00075	0.87542	0.93680
_1_6_3	4.00	0.00	5.281	1.0E-20	4.959	0.87667	0.00073	0.87813	0.93520	0.87704	0.00078	0.87860	0.93520
_5_6_3	4.00	2.00	5.281	1.0E-20	7.422	0.89288	0.00083	0.89454	0.93680	0.89375	0.00082	0.89539	0.93680
_7_6_3	4.00	3.00	5.281	1.0E-20	8.653	0.90826	0.00077	0.90980	0.93680	0.90988	0.00081	0.91150	0.93680
_8_6_3	4.00	3.25	5.281	1.0E-20	8.961	0.91364	0.00088	0.91540	0.93680	0.91351	0.00077	0.91505	0.93680
_1_6_4	4.60	0.00	4.049	1.0E-20	5.703	0.89826	0.00083	0.89992	0.93520	0.89837	0.00083	0.90003	0.93520
_2_6_4	4.60	1.00	4.049	1.0E-20	6.935	0.90516	0.00070	0.90656	0.93680	0.90474	0.00079	0.90632	0.93680
_5_6_4	4.60	2.00	4.049	1.0E-20	8.166	0.91797	0.00079	0.91955	0.93680	0.91782	0.00085	0.91952	0.93680
_6_6_4	4.60	2.65	4.049	1.0E-20	8.966	0.93176	0.00083	0.93342	0.93680	0.93315	0.00074	0.93463	0.93680
_6_6_4a	4.60	2.65	4.049	1.0E-05	8.966	0.93203	0.00074	0.93351	0.93680	0.93373	0.00076	0.93525	0.93680
_6_6_4b	4.60	2.65	4.049	1.0E-04	8.966	0.93312	0.00080	0.93472	0.93680	0.93137	0.00089	0.93315	0.93680
_6_6_4c	4.60	2.65	4.049	1.0E-03	8.966	0.92990	0.00076	0.93142	0.93680	0.93205	0.00077	0.93359	0.93680
UO_2-Th content and 500 g polyethylene in flooded containment vessel, flooded package at 0.50 g/cm^3													
_1_7_1	3.00	0.00	2.641	1.0E-20	5.716	0.87130	0.00083	0.87296	0.93680	0.87356	0.00095	0.87546	0.93680
_2_7_1	3.00	1.00	2.641	1.0E-20	7.613	0.88244	0.00076	0.88396	0.93680	0.88337	0.00069	0.88475	0.93680
_4_7_1	3.00	1.80	2.641	1.0E-20	9.130	0.90052	0.00084	0.90220	0.93680	0.90231	0.00078	0.90387	0.93680
_1_7_2	3.75	0.00	3.301	1.0E-20	7.145	0.90955	0.00076	0.91107	0.93680	0.91057	0.00079	0.91215	0.93680
_2_7_2	3.75	1.00	3.301	1.0E-20	9.042	0.93312	0.00083	0.93478	0.93680	0.93260	0.00100	0.93460	0.93680

Table 6.9.6-13j. Results for HEU oxide/thorium metal content in array packaging calculation model

Case	Ox (kg)	^{235}U (kg)	Th (kg)	MOIFR	Sat. H_2O (kg)	NCT ncialdoxthmt11*				HAC hcialdoxthmt12*			
						k_{eff}	σ	$k_{eff}+2\sigma$	USL	k_{eff}	σ	$k_{eff}+2\sigma$	USL
_3_7_2	3.75	1.05	3.301	1.0E-20	9.136	0.93434	0.00084	0.93602	0.93680	0.93310	0.00084	0.93478	0.93680
_3_7_2a	3.75	1.05	3.301	1.0E-05	9.136	0.93465	0.00089	0.93643	0.93680	0.93319	0.00071	0.93461	0.93680
_3_7_2b	3.75	1.05	3.301	1.0E-04	9.136	0.93426	0.00097	0.93620	0.93680	0.93407	0.00078	0.93563	0.93680
_3_7_2c	3.75	1.05	3.301	1.0E-03	9.136	0.93119	0.00068	0.93255	0.93680	0.93337	0.00076	0.93489	0.93680

Table 6.9.6-14. Results for UNX crystal content in CV calculation model

Case	UNH (g)	^{235}U (g)	UNH H_2O (g)	CV H_2O (g)	h/x	gU/l	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
UNH crystal content, 0 g polyethylene, flooded containment vessel, reflected										
cvcrunhct11_24_1	24000	11303	5197	1620	15.74	1106	1.0E+00	0.82007	0.00128	0.82262
cvcrunhct11_23_1	23000	10832	4980	1978	16.77	1060	1.0E+00	0.82120	0.00129	0.82378
cvcrunhct11_22_1	22000	10361	4764	2335	17.88	1014	1.0E+00	0.82675	0.00122	0.82919
cvcrunhct11_21_1	21000	9890	4547	2693	19.11	968	1.0E+00	0.82938	0.00118	0.83174
cvcrunhct11_20_1	20000	9419	4331	3050	20.45	922	1.0E+00	0.83221	0.00129	0.83480
cvcrunhct11_19_1	19000	8948	4114	3407	21.94	876	1.0E+00	0.83423	0.00152	0.83728
cvcrunhct11_18_1	18000	8477	3898	3765	23.59	830	1.0E+00	0.83622	0.00128	0.83878
cvcrunhct11_17_1	17000	8006	3681	4122	25.44	784	1.0E+00	0.84032	0.00167	0.84365
cvcrunhct11_16_1	16000	7536	3464	4479	27.51	738	1.0E+00	0.84509	0.00151	0.84811
cvcrunhct11_15_1	15000	7064	3248	4837	29.87	692	1.0E+00	0.84402	0.00133	0.84667
cvcrunhct11_14_1	14000	6594	3031	5194	32.56	645	1.0E+00	0.84915	0.00130	0.85175
cvcrunhct11_13_1	13000	6123	2815	5551	35.67	599	1.0E+00	0.84986	0.00127	0.85241

Table 6.9.6-14. Results for UNX crystal content in CV calculation model

Case	UNH (g)	^{235}U (g)	UNH H_2O (g)	CV H_2O (g)	h/x	gU/l	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrunhct11_12_1	12000	5652	2598	5909	39.29	553	1.0E+00	0.85138	0.00159	0.85456
cvcrunhct11_11_1	11000	5181	2382	6266	43.57	507	1.0E+00	0.85137	0.00136	0.85408
cvcrunhct11_10_1	10000	4710	2165	6623	48.71	461	1.0E+00	0.85062	0.00149	0.85359
cvcrunhct11_9_1	9000	4239	1949	6981	54.99	415	1.0E+00	0.85423	0.00147	0.85718
cvcrunhct11_8_1	8000	3768	1732	7338	62.83	369	1.0E+00	0.84783	0.00152	0.85088
cvcrunhct11_7_1	7000	3297	1516	7695	72.92	323	1.0E+00	0.84713	0.00166	0.85044
cvcrunhct11_6_1	6000	2826	1299	8053	86.38	277	1.0E+00	0.83915	0.00151	0.84218
cvcrunhct11_5_1	5000	2355	1083	8410	105.2	231	1.0E+00	0.82865	0.00177	0.83220
cvcrunhct11_4_1	4000	1884	866	8768	133.5	184	1.0E+00	0.81158	0.00162	0.81483
cvcrunhct11_3_1	3000	1413	650	9125	180.6	138	1.0E+00	0.78282	0.00120	0.78522
cvcrunhct11_2_1	2000	942	433	9482	274.7	92	1.0E+00	0.73150	0.00114	0.73377
cvcrunhct11_1_1	1000	471	217	9840	557.2	46	1.0E+00	0.60716	0.00106	0.60927
UNH crystal content, 500 g polyethylene, flooded containment vessel, reflected										
cvcrpunhct11_24_15	24000	11303	5197	1078	15.97	1106	1.0E+00	0.82422	0.00129	0.82681
cvcrpunhct11_23_15	23000	10832	4980	1435	17.01	1060	1.0E+00	0.82842	0.00146	0.83134
cvcrpunhct11_22_15	22000	10361	4764	1793	18.13	1014	1.0E+00	0.83462	0.00156	0.83773
cvcrpunhct11_21_15	21000	9890	4547	2150	19.37	968	1.0E+00	0.83608	0.00149	0.83906
cvcrpunhct11_20_15	20000	9419	4331	2507	20.73	922	1.0E+00	0.84111	0.00143	0.84397
cvcrpunhct11_19_15	19000	8948	4114	2865	22.23	876	1.0E+00	0.84084	0.00135	0.84355
cvcrpunhct11_18_15	18000	8477	3898	3222	23.90	830	1.0E+00	0.84379	0.00138	0.84654
cvcrpunhct11_17_15	17000	8006	3681	3579	25.76	784	1.0E+00	0.84513	0.00147	0.84807
cvcrpunhct11_16_15	16000	7536	3464	3937	27.86	738	1.0E+00	0.84809	0.00132	0.85072
cvcrpunhct11_15_15	15000	7064	3248	4294	30.24	692	1.0E+00	0.85178	0.00146	0.85470
cvcrpunhct11_14_15	14000	6594	3031	4652	32.96	645	1.0E+00	0.85473	0.00134	0.85741

Table 6.9.6-14. Results for UNX crystal content in CV calculation model

Case	UNH (g)	^{235}U (g)	UNH H_2O (g)	CV H_2O (g)	h/x	gU/l	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrpunhct11_13_15	13000	6123	2815	5009	36.09	599	1.0E+00	0.85544	0.00134	0.85812
cvcrpunhct11_12_15	12000	5652	2598	5366	39.75	553	1.0E+00	0.85658	0.00142	0.85941
cvcrpunhct11_11_15	11000	5181	2382	5724	44.07	507	1.0E+00	0.85830	0.00152	0.86133
cvcrpunhct11_10_15	10000	4710	2165	6081	49.26	461	1.0E+00	0.85943	0.00176	0.86296
cvcrpunhct11_9_15	9000	4239	1949	6438	55.60	415	1.0E+00	0.85882	0.00139	0.86161
cvcrpunhct11_8_15	8000	3768	1732	6796	63.53	369	1.0E+00	0.85472	0.00116	0.85705
cvcrpunhct11_7_15	7000	3297	1516	7153	73.72	323	1.0E+00	0.84975	0.00143	0.85261
cvcrpunhct11_6_15	6000	2826	1299	7510	87.31	277	1.0E+00	0.84484	0.00132	0.84748
cvcrpunhct11_5_15	5000	2355	1083	7868	106.33	231	1.0E+00	0.83459	0.00167	0.83793
cvcrpunhct11_4_15	4000	1884	866	8225	134.85	184	1.0E+00	0.82093	0.00142	0.82378
cvcrpunhct11_3_15	3000	1413	650	8582	182.42	138	1.0E+00	0.78968	0.00130	0.79228
cvcrpunhct11_2_15	2000	942	433	8940	277.51	92	1.0E+00	0.73500	0.00145	0.73791
cvcrpunhct11_1_15	1000	471	217	9297	562.74	46	1.0E+00	0.61053	0.00118	0.61289
UNH crystal content, 500 g polyethylene, dry containment vessel, reflected										
cvcrpunhct11_24_1	24000	11303	5197	0	13.48	1106.5	1.0E-20	0.76603	0.00145	0.76893
cvcrpunhct11_23_1	23000	10832	4980	0	13.55	1060.4	1.0E-20	0.75118	0.00132	0.75382
cvcrpunhct11_22_1	22000	10361	4764	0	13.62	1014.3	1.0E-20	0.73265	0.00133	0.73531
cvcrpunhct11_21_1	21000	9890	4547	0	13.70	968.2	1.0E-20	0.71276	0.00125	0.71527
cvcrpunhct11_20_1	20000	9419	4331	0	13.78	922.1	1.0E-20	0.69662	0.00146	0.69955
cvcrpunhct11_19_1	19000	8948	4114	0	13.87	876.0	1.0E-20	0.67992	0.00144	0.68279
cvcrpunhct11_18_1	18000	8477	3898	0	13.98	829.9	1.0E-20	0.66144	0.00115	0.66374
cvcrpunhct11_17_1	17000	8006	3681	0	14.09	783.8	1.0E-20	0.64482	0.00128	0.64738
cvcrpunhct11_16_1	16000	7536	3464	0	14.23	737.7	1.0E-20	0.62404	0.00110	0.62624
cvcrpunhct11_15_1	15000	7064	3248	0	14.37	691.5	1.0E-20	0.60835	0.00125	0.61085

Table 6.9.6-14. Results for UNX crystal content in CV calculation model

Case	UNH (g)	^{235}U (g)	UNH H_2O (g)	CV H_2O (g)	h/x	gU/l	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrpunhct11_14_1	14000	6594	3031	0	14.54	645.5	1.0E-20	0.58778	0.00113	0.59003
cvcrpunhct11_13_1	13000	6123	2815	0	14.74	599.4	1.0E-20	0.56892	0.00115	0.57123
cvcrpunhct11_12_1	12000	5652	2598	0	14.97	553.2	1.0E-20	0.55059	0.00129	0.55317
cvcrpunhct11_11_1	11000	5181	2382	0	15.24	507.1	1.0E-20	0.53268	0.00108	0.53485
cvcrpunhct11_10_1	10000	4710	2165	0	15.56	461.0	1.0E-20	0.51381	0.00135	0.51650
cvcrpunhct11_9_1	9000	4239	1949	0	15.96	414.9	1.0E-20	0.49374	0.00111	0.49596
cvcrpunhct11_8_1	8000	3768	1732	0	16.45	368.8	1.0E-20	0.47312	0.00106	0.47524
cvcrpunhct11_7_1	7000	3297	1516	0	17.09	322.7	1.0E-20	0.45221	0.00108	0.45437
cvcrpunhct11_6_1	6000	2826	1299	0	17.93	276.6	1.0E-20	0.43063	0.00114	0.43290
cvcrpunhct11_5_1	5000	2355	1083	0	19.12	230.5	1.0E-20	0.40936	0.00103	0.41141
cvcrpunhct11_4_1	4000	1884	866	0	20.90	184.4	1.0E-20	0.38394	0.00105	0.38603
cvcrpunhct11_3_1	3000	1413	650	0	23.87	138.3	1.0E-20	0.35655	0.00096	0.35846
cvcrpunhct11_2_1	2000	942	433	0	29.80	92.2	1.0E-20	0.31381	0.00093	0.31566
cvcrpunhct11_1_1	1000	471	217	0	47.60	46.1	1.0E-20	0.24974	0.00079	0.25132
500 g polyethylene and undissolved UNH crystals, flooded containment vessel, reflected										
cvcrbpunhct11_24_15	24000	11303	5197	1078	15.97	NA	1.0E+00	0.81439	0.00135	0.81710
cvcrbpunhct11_23_15	23000	10832	4980	1435	17.01	NA	1.0E+00	0.81243	0.00128	0.81498
cvcrbpunhct11_22_15	22000	10361	4764	1793	18.13	NA	1.0E+00	0.81092	0.00139	0.81369
cvcrbpunhct11_21_15	21000	9890	4547	2150	19.37	NA	1.0E+00	0.80901	0.00135	0.81172
cvcrbpunhct11_20_15	20000	9419	4331	2507	20.73	NA	1.0E+00	0.80864	0.00168	0.81200
cvcrbpunhct11_19_15	19000	8948	4114	2865	22.23	NA	1.0E+00	0.80344	0.00145	0.80635
cvcrbpunhct11_18_15	18000	8477	3898	3222	23.90	NA	1.0E+00	0.80646	0.00132	0.80911
cvcrbpunhct11_17_15	17000	8006	3681	3579	25.76	NA	1.0E+00	0.80294	0.00134	0.80563
cvcrbpunhct11_16_15	16000	7536	3465	3937	27.86	NA	1.0E+00	0.79909	0.00115	0.80139

Table 6.9.6-14. Results for UNX crystal content in CV calculation model

Case	UNH (g)	^{235}U (g)	UNH H_2O (g)	CV H_2O (g)	h/x	gU/l	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrbpunhct11_15_15	15000	7064	3248	4294	30.24	NA	1.0E+00	0.79593	0.00133	0.79858
cvcrbpunhct11_14_15	14000	6594	3031	4652	32.96	NA	1.0E+00	0.79487	0.00109	0.79705
cvcrbpunhct11_13_15	13000	6123	2815	5009	36.09	NA	1.0E+00	0.78728	0.00118	0.78964
cvcrbpunhct11_12_15	12000	5652	2598	5366	39.75	NA	1.0E+00	0.78337	0.00127	0.78592
cvcrbpunhct11_11_15	11000	5181	2382	5724	44.07	NA	1.0E+00	0.77773	0.00122	0.78017
cvcrbpunhct11_10_15	10000	4710	2165	6081	49.26	NA	1.0E+00	0.77009	0.00154	0.77317
cvcrbpunhct11_9_15	9000	4239	1949	6438	55.60	NA	1.0E+00	0.76494	0.00133	0.76760
cvcrbpunhct11_8_15	8000	3768	1732	6796	63.53	NA	1.0E+00	0.75339	0.00148	0.75635
cvcrbpunhct11_7_15	7000	3297	1516	7153	73.72	NA	1.0E+00	0.74139	0.00149	0.74437
cvcrbpunhct11_6_15	6000	2826	1299	7510	87.31	NA	1.0E+00	0.72740	0.00134	0.73009
cvcrbpunhct11_5_15	5000	2355	1083	7868	6.33	NA	1.0E+00	0.70988	0.00128	0.71244
cvcrbpunhct11_4_15	4000	1884	866	8225	34.85	NA	1.0E+00	0.68707	0.00137	0.68981
cvcrbpunhct11_3_15	3000	1413	650	8582	82.42	NA	1.0E+00	0.65613	0.00136	0.65885
cvcrbpunhct11_2_15	2000	942	433	8940	77.51	NA	1.0E+00	0.61167	0.00117	0.61402
cvcrbpunhct11_1_15	1000	471	217	9297	62.74	NA	1.0E+00	0.55043	0.00140	0.55324
500 g polyethylene and undissolved UNH crystals, dry containment vessel, reflected										
cvcrbpunhct11_24_1	24000	11303	5197	0	13.48	NA	1.0E-20	0.81264	0.00142	0.81548
cvcrbpunhct11_23_1	23000	10832	4980	0	13.55	NA	1.0E-20	0.81127	0.00129	0.81384
cvcrbpunhct11_22_1	22000	10361	4764	0	13.62	NA	1.0E-20	0.80828	0.00121	0.81069
cvcrbpunhct11_21_1	21000	9890	4547	0	13.70	NA	1.0E-20	0.80873	0.00122	0.81117
cvcrbpunhct11_20_1	20000	9419	4331	0	13.78	NA	1.0E-20	0.80508	0.00132	0.80773
cvcrbpunhct11_19_1	19000	8948	4114	0	13.87	NA	1.0E-20	0.80364	0.00150	0.80664
cvcrbpunhct11_18_1	18000	8477	3898	0	13.98	NA	1.0E-20	0.80002	0.00170	0.80343
cvcrbpunhct11_17_1	17000	8006	3681	0	14.09	NA	1.0E-20	0.79969	0.00165	0.80298

Table 6.9.6-14. Results for UNX crystal content in CV calculation model

Case	UNH (g)	^{235}U (g)	UNH H_2O (g)	CV H_2O (g)	h/x	gU/l	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrbpunhct11_16_1	16000	7536	3465	0	14.23	NA	1.0E-20	0.79458	0.00144	0.79746
cvcrbpunhct11_15_1	15000	7064	3248	0	14.37	NA	1.0E-20	0.79130	0.00141	0.79411
cvcrbpunhct11_14_1	14000	6594	3031	0	14.54	NA	1.0E-20	0.78794	0.00127	0.79048
cvcrbpunhct11_13_1	13000	6123	2815	0	14.74	NA	1.0E-20	0.78506	0.00137	0.78781
cvcrbpunhct11_12_1	12000	5652	2598	0	14.97	NA	1.0E-20	0.78061	0.00121	0.78303
cvcrbpunhct11_11_1	11000	5181	2382	0	15.24	NA	1.0E-20	0.77102	0.00125	0.77352
cvcrbpunhct11_10_1	10000	4710	2165	0	15.56	NA	1.0E-20	0.76415	0.00129	0.76673
cvcrbpunhct11_9_1	9000	4239	1949	0	15.96	NA	1.0E-20	0.75589	0.00141	0.75872
cvcrbpunhct11_8_1	8000	3768	1732	0	16.45	NA	1.0E-20	0.74147	0.00151	0.74449
cvcrbpunhct11_7_1	7000	3297	1516	0	17.09	NA	1.0E-20	0.72828	0.00125	0.73077
cvcrbpunhct11_6_1	6000	2826	1299	0	17.93	NA	1.0E-20	0.71077	0.00122	0.71321
cvcrbpunhct11_5_1	5000	2355	1083	0	19.12	NA	1.0E-20	0.68823	0.00137	0.69096
cvcrbpunhct11_4_1	4000	1884	866	0	20.90	NA	1.0E-20	0.66016	0.00146	0.66309
cvcrbpunhct11_3_1	3000	1413	650	0	23.87	NA	1.0E-20	0.61922	0.00144	0.62211
cvcrbpunhct11_2_1	2000	942	433	0	29.80	NA	1.0E-20	0.56205	0.00129	0.56462
cvcrbpunhct11_1_1	1000	471	217	0	47.60	NA	1.0E-20	0.47544	0.00110	0.47765

Table 6.9.6-15. Results for UNX crystal content in packaging calculation model

Case	UNH (g)	^{235}U (g)	UNH H_2O (g)	CV H_2O (g)	h/x	gU/l	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
UNH crystal content, 0 g polyethylene in flooded containment vessel, single package reflected														
NCT											**HAC**			
ncsrunhct11_24_1_1	24000	11303	5197	1620	15.74	1106	1.0E-20	0.60250	0.00130	0.60510	hcsrunhct12_24_1_1	0.60528	0.00129	0.60786
ncsrunhct11_24_1_2	24000	11303	5197	1620	15.74	1106	1.0E-05	0.59895	0.00119	0.60134	hcsrunhct12_24_1_2	0.60289	0.00142	0.60574
ncsrunhct11_24_1_3	24000	11303	5197	1620	15.74	1106	1.0E-04	0.59947	0.00124	0.60194	hcsrunhct12_24_1_3	0.60552	0.00130	0.60812
ncsrunhct11_24_1_4	24000	11303	5197	1620	15.74	1106	1.0E-03	0.60331	0.00132	0.60595	hcsrunhct12_24_1_4	0.60265	0.00112	0.60489
ncsrunhct11_24_1_5	24000	11303	5197	1620	15.74	1106	1.0E-02	0.60398	0.00118	0.60635	hcsrunhct12_24_1_5	0.60426	0.00152	0.60731
ncsrunhct11_24_1_6	24000	11303	5197	1620	15.74	1106	1.0E-01	0.61004	0.00142	0.61287	hcsrunhct12_24_1_6	0.61378	0.00127	0.61632
ncsrunhct11_24_1_8	24000	11303	5197	1620	15.74	1106	3.0E-01	0.63238	0.00143	0.63524	hcsrunhct12_24_1_8	0.63556	0.00128	0.63813
ncsrunhct11_24_1_15	24000	11303	5197	1620	15.74	1106	1.0E+00	0.69882	0.00142	0.70166	hcsrunhct12_24_1_15	0.70190	0.00129	0.70448
ncsrunhct11_24_1_15	24000	11303	5197	1620	15.74	1106	1.0E+00	0.69882	0.00142	0.70166	hcsrunhct12_24_1_15	0.70190	0.00129	0.70448
ncsrunhct11_23_1_15	23000	10832	4980	1978	16.77	1060	1.0E+00	0.70360	0.00134	0.70628	hcsrunhct12_23_1_15	0.70555	0.00129	0.70813
ncsrunhct11_22_1_15	22000	10361	4764	2335	17.88	1014	1.0E+00	0.70899	0.00132	0.71163	hcsrunhct12_22_1_15	0.70899	0.00136	0.71171
ncsrunhct11_21_1_15	21000	9890	4547	2693	19.11	968	1.0E+00	0.71172	0.00133	0.71438	hcsrunhct12_21_1_15	0.71348	0.00158	0.71664
ncsrunhct11_20_1_15	20000	9419	4331	3050	20.45	922	1.0E+00	0.71256	0.00123	0.71501	hcsrunhct12_20_1_15	0.71623	0.00117	0.71858
ncsrunhct11_19_1_15	19000	8948	4114	3407	21.94	876	1.0E+00	0.71780	0.00132	0.72045	hcsrunhct12_19_1_15	0.71798	0.00132	0.72063
ncsrunhct11_18_1_15	18000	8477	3898	3765	23.59	830	1.0E+00	0.72130	0.00139	0.72407	hcsrunhct12_18_1_15	0.72545	0.00149	0.72843
ncsrunhct11_17_1_15	17000	8006	3681	4122	25.44	784	1.0E+00	0.72340	0.00161	0.72663	hcsrunhct12_17_1_15	0.72589	0.00134	0.72856
ncsrunhct11_16_1_15	16000	7536	3464	4479	27.51	738	1.0E+00	0.72816	0.00141	0.73098	hcsrunhct12_16_1_15	0.73042	0.00147	0.73336
ncsrunhct11_15_1_15	15000	7064	3248	4837	29.87	692	1.0E+00	0.73150	0.00149	0.73449	hcsrunhct12_15_1_15	0.73525	0.00151	0.73827
ncsrunhct11_14_1_15	14000	6594	3031	5194	32.56	645	1.0E+00	0.73255	0.00135	0.73524	hcsrunhct12_14_1_15	0.73405	0.00150	0.73704
ncsrunhct11_13_1_15	13000	6123	2815	5551	35.67	599	1.0E+00	0.73488	0.00128	0.73745	hcsrunhct12_13_1_15	0.73722	0.00159	0.74040
ncsrunhct11_12_1_15	12000	5652	2598	5909	39.29	553	1.0E+00	0.73982	0.00146	0.74274	hcsrunhct12_12_1_15	0.74114	0.00126	0.74366

Table 6.9.6-15. Results for UNX crystal content in packaging calculation model

Case	UNH (g)	^{235}U (g)	UNH H_2O (g)	CV H_2O (g)	h/x	gU/l	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsrunhct11_11_1_15	11000	5181	2382	6266	43.57	507	1.0E+00	0.74059	0.00156	0.74370	hcsrunhct12_11_1_15	0.74104	0.00187	0.74477
ncsrunhct11_10_1_15	10000	4710	2165	6623	48.71	461	1.0E+00	0.74238	0.00148	0.74533	hcsrunhct12_10_1_15	0.74247	0.00134	0.74514
ncsrunhct11_9_1_15	9000	4239	1949	6981	54.99	415	1.0E+00	0.74214	0.00135	0.74484	hcsrunhct12_9_1_15	0.74537	0.00150	0.74836
ncsrunhct11_8_1_15	8000	3768	1732	7338	62.83	369	1.0E+00	0.74436	0.00146	0.74728	hcsrunhct12_8_1_15	0.74169	0.00176	0.74521
ncsrunhct11_7_1_15	7000	3297	1516	7695	72.92	323	1.0E+00	0.73972	0.00146	0.74265	hcsrunhct12_7_1_15	0.74201	0.00129	0.74459
ncsrunhct11_6_1_15	6000	2826	1299	8053	86.38	277	1.0E+00	0.73458	0.00147	0.73752	hcsrunhct12_6_1_15	0.73491	0.00155	0.73802
ncsrunhct11_5_1_15	5000	2355	1083	8410	105.22	231	1.0E+00	0.72880	0.00143	0.73166	hcsrunhct12_5_1_15	0.72804	0.00151	0.73107
ncsrunhct11_4_1_15	4000	1884	866	8768	133.47	184	1.0E+00	0.71269	0.00158	0.71585	hcsrunhct12_4_1_15	0.71463	0.00147	0.71758
ncsrunhct11_3_1_15	3000	1413	650	9125	180.57	138	1.0E+00	0.68768	0.00137	0.69042	hcsrunhct12_3_1_15	0.69065	0.00121	0.69306
ncsrunhct11_2_1_15	2000	942	433	9482	274.74	92	1.0E+00	0.64383	0.00118	0.64619	hcsrunhct12_2_1_15	0.64813	0.00131	0.65076
UNH crystal content, 500 g polyethylene in flooded containment vessel, single package reflected														
ncsrpunhct11_24_1	24000	11303	5197	1078	15.97	1106	1E-20	0.60653	0.00140	0.60932	hcsrpunhct12_24_1	0.60988	0.00142	0.61273
ncsrpunhct11_24_15	24000	11303	5197	1078	15.97	1106	1E+00	0.70571	0.00135	0.70841	hcsrpunhct12_24_15	0.70886	0.00133	0.71152
ncsrpunhct11_24_15	24000	11303	5197	1078	15.97	1106	1E+00	0.70571	0.00135	0.70841	hcsrpunhct12_24_15	0.70886	0.00133	0.71152
ncsrpunhct11_23_15	23000	10832	4980	1435	17.01	1060	1E+00	0.71244	0.00130	0.71504	hcsrpunhct12_23_15	0.71209	0.00121	0.71452
ncsrpunhct11_22_15	22000	10361	4764	1793	18.13	1014	1E+00	0.71524	0.00158	0.71841	hcsrpunhct12_22_15	0.71753	0.00126	0.72006
ncsrpunhct11_21_15	21000	9890	4547	2150	19.37	968	1E+00	0.71747	0.00154	0.72055	hcsrpunhct12_21_15	0.71997	0.00137	0.72270
ncsrpunhct11_20_15	20000	9419	4331	2507	20.73	922	1E+00	0.72176	0.00151	0.72479	hcsrpunhct12_20_15	0.72403	0.00130	0.72663
ncsrpunhct11_19_15	19000	8948	4114	2865	22.23	876	1E+00	0.72616	0.00138	0.72891	hcsrpunhct12_19_15	0.72647	0.00141	0.72929
ncsrpunhct11_18_15	18000	8477	3898	3222	23.90	830	1E+00	0.72901	0.00163	0.73227	hcsrpunhct12_18_15	0.73343	0.00131	0.73606
ncsrpunhct11_17_15	17000	8006	3681	3579	25.76	784	1E+00	0.73255	0.00127	0.73508	hcsrpunhct12_17_15	0.73387	0.00128	0.73643
ncsrpunhct11_16_15	16000	7536	3465	3937	27.86	738	1E+00	0.73515	0.00152	0.73818	hcsrpunhct12_16_15	0.73768	0.00152	0.74073
ncsrpunhct11_15_15	15000	7064	3248	4294	30.24	692	1E+00	0.74097	0.00126	0.74349	hcsrpunhct12_15_15	0.74006	0.00132	0.74270

Table 6.9.6-15. Results for UNX crystal content in packaging calculation model

Case	UNH (g)	^{235}U (g)	UNH H_2O (g)	CV H_2O (g)	h/x	gU/l	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsrpunhct11_14_15	14000	6594	3031	4652	32.96	645	1E+00	0.74169	0.00135	0.74438	hcsrpunhct12_14_15	0.74240	0.00141	0.74522
ncsrpunhct11_13_15	13000	6123	2815	5009	36.09	599	1E+00	0.74466	0.00139	0.74744	hcsrpunhct12_13_15	0.74534	0.00141	0.74815
ncsrpunhct11_12_15	12000	5652	2598	5366	39.75	553	1E+00	0.74381	0.00142	0.74666	hcsrpunhct12_12_15	0.74529	0.00132	0.74794
ncsrpunhct11_11_15	11000	5181	2382	5724	44.07	507	1E+00	0.74858	0.00146	0.75151	hcsrpunhct12_11_15	0.74980	0.00139	0.75259
ncsrpunhct11_10_15	10000	4710	2165	6081	49.26	461	1E+00	0.74595	0.00140	0.74875	hcsrpunhct12_10_15	0.74967	0.00141	0.75249
ncsrpunhct11_9_15	9000	4239	1949	6438	55.60	415	1E+00	0.74868	0.00167	0.75202	hcsrpunhct12_9_15	0.75260	0.00164	0.75587
ncsrpunhct11_8_15	8000	3768	1732	6796	63.53	369	1E+00	0.74978	0.00139	0.75255	hcsrpunhct12_8_15	0.74914	0.00120	0.75155
ncsrpunhct11_7_15	7000	3297	1516	7153	73.72	323	1E+00	0.74628	0.00147	0.74922	hcsrpunhct12_7_15	0.74708	0.00155	0.75018
ncsrpunhct11_6_15	6000	2826	1299	7510	87.31	277	1E+00	0.74259	0.00122	0.74503	hcsrpunhct12_6_15	0.74481	0.00150	0.74781
ncsrpunhct11_5_15	5000	2355	1083	7868	106.33	231	1E+00	0.73226	0.00133	0.73492	hcsrpunhct12_5_15	0.73303	0.00153	0.73609
ncsrpunhct11_4_15	4000	1884	866	8225	134.85	184	1E+00	0.72045	0.00145	0.72334	hcsrpunhct12_4_15	0.71942	0.00168	0.72279
ncsrpunhct11_3_15	3000	1413	650	8582	182.42	138	1E+00	0.69669	0.00167	0.70003	hcsrpunhct12_3_15	0.69613	0.00139	0.69891
ncsrpunhct11_2_15	2000	942	433	8940	277.51	92	1E+00	0.65100	0.00112	0.65324	hcsrpunhct12_2_15	0.65137	0.00149	0.65436
ncsrpunhct11_1_15	1000	471	217	9297	562.74	46	1E+00	0.54270	0.00116	0.54501	hcsrpunhct12_1_15	0.54296	0.00099	0.54494
UNH crystal content, 0 g polyethylene in flooded containment vessel, array packaging calculation model for CSI=0.0														
NCT											**HAC**			
nciaunhct11_8_24_1_1	24000	11303	5197	1620	15.74	1106	1.0E-20	0.91485	0.00136	0.91756	hciaunhct12_8_24_1_1	0.91665	0.00134	0.91933
nciaunhct11_8_24_1_2	24000	11303	5197	1620	15.74	1106	1.0E-05	0.91420	0.00120	0.91659	hciaunhct12_8_24_1_2	0.91708	0.00131	0.91969
nciaunhct11_8_24_1_3	24000	11303	5197	1620	15.74	1106	1.0E-04	0.91426	0.00123	0.91672	hciaunhct12_8_24_1_3	0.91632	0.00112	0.91856
nciaunhct11_8_24_1_4	24000	11303	5197	1620	15.74	1106	1.0E-03	0.91095	0.00119	0.91333	hciaunhct12_8_24_1_4	0.91159	0.00120	0.91399
nciaunhct11_8_24_1_5	24000	11303	5197	1620	15.74	1106	1.0E-02	0.88904	0.00117	0.89138	hciaunhct12_8_24_1_5	0.89357	0.00127	0.89610
nciaunhct11_8_24_1_6	24000	11303	5197	1620	15.74	1106	1.0E-01	0.77132	0.00109	0.77350	hciaunhct12_8_24_1_6	0.78417	0.00129	0.78676
nciaunhct11_8_24_1_8	24000	11303	5197	1620	15.74	1106	3.0E-01	0.71012	0.00130	0.71272	hciaunhct12_8_24_1_8	0.71917	0.00135	0.72188
nciaunhct11_8_24_1_15	24000	11303	5197	1620	15.74	1106	1.0E+00	0.71873	0.00134	0.72140	hciaunhct12_8_24_1_15	0.72598	0.00147	0.72892

Table 6.9.6-15. Results for UNX crystal content in packaging calculation model

Case	UNH (g)	^{235}U (g)	UNH H_2O (g)	CV H_2O (g)	h/x	gU/l	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciaunhct11_8_24_1_3	24000	11303	5197	1620	15.74	1106	1.0E-04	0.91426	0.00123	0.91672	hciaunhct12_8_24_1_3	0.91632	0.00112	0.91856
nciaunhct11_8_12_1_3	12000	5652	2598	5909	39.29	553	1.0E-04	0.93016	0.00130	0.93277	hciaunhct12_8_12_1_3	0.92942	0.00157	0.93256
nciaunhct11_8_11_1_3	11000	5181	2382	6266	43.57	507	1.0E-04	0.92825	0.00132	0.93090	hciaunhct12_8_11_1_3	0.92834	0.00152	0.93138
nciaunhct11_8_10_1_3	10000	4710	2165	6623	48.71	461	1.0E-04	0.92490	0.00152	0.92794	hciaunhct12_8_10_1_3	0.92555	0.00137	0.92828
nciaunhct11_8_9_1_3	9000	4239	1949	6981	54.99	415	1.0E-04	0.92044	0.00124	0.92293	hciaunhct12_8_9_1_3	0.92360	0.00136	0.92631
nciaunhct11_8_8_1_3	8000	3768	1732	7338	62.83	369	1.0E-04	0.91662	0.00121	0.91905	hciaunhct12_8_8_1_3	0.91875	0.00144	0.92163
nciaunhct11_8_7_1_3	7000	3297	1516	7695	72.92	323	1.0E-04	0.91132	0.00140	0.91411	hciaunhct12_8_7_1_3	0.90978	0.00135	0.91247
nciaunhct11_8_6_1_3	6000	2826	1299	8053	86.38	277	1.0E-04	0.90036	0.00128	0.90293	hciaunhct12_8_6_1_3	0.89938	0.00150	0.90238
nciaunhct11_8_5_1_3	5000	2355	1083	8410	105.22	231	1.0E-04	0.88578	0.00141	0.88860	hciaunhct12_8_5_1_3	0.88489	0.00149	0.88788
nciaunhct11_8_4_1_3	4000	1884	866	8768	133.47	184	1.0E-04	0.86530	0.00119	0.86769	hciaunhct12_8_4_1_3	0.86326	0.00139	0.86604
nciaunhct11_8_3_1_3	3000	1413	650	9125	180.57	138	1.0E-04	0.82655	0.00120	0.82895	hciaunhct12_8_3_1_3	0.83005	0.00118	0.83242
nciaunhct11_8_2_1_3	2000	942	433	9482	274.74	92	1.0E-04	0.76783	0.00123	0.77029	hciaunhct12_8_2_1_3	0.76545	0.00129	0.76804
nciaunhct11_8_1_1_3	1000	471	217	9840	557.20	46	1.0E-04	0.62610	0.00112	0.62834	hciaunhct12_8_1_1_3	0.62341	0.00104	0.62549
UNH crystal content, 500 g polyethylene in flooded containment vessel, array packaging calculation model for CSI=0.0														
nciapunhct11_24_1	24000	11303	5197	1078	15.97	1106	1E-20	0.92205	0.00118	0.92442	hciapunhct12_24_1	0.92136	0.00123	0.92383
nciapunhct11_24_15	24000	11303	5197	1078	15.97	1106	1E+00	0.72649	0.00128	0.72905	hciapunhct12_24_15	0.73087	0.00128	0.73343
nciapunhct11_24_3	24000	11303	5197	1078	15.97	1106	1E-04	0.92258	0.00141	0.92539	hciapunhct12_24_3	0.92172	0.00124	0.92419
nciapunhct11_16_3	16000	7536	3465	3937	27.86	738	1E-04	0.93498	0.00131	0.93759	hciapunhct12_16_3	0.93544	0.00130	0.93804
nciapunhct11_15_3	15000	7064	3248	4294	30.24	692	1E-04	0.93400	0.00139	0.93678	hciapunhct12_15_3	0.93500	0.00136	0.93771
nciapunhct11_14_3	14000	6594	3031	4652	32.96	645	1E-04	0.93374	0.00153	0.93680	hciapunhct12_14_3	0.93539	0.00135	0.93810
nciapunhct11_8_3	8000	3768	1732	6796	63.53	369	1E-04	0.92190	0.00144	0.92478	hciapunhct12_8_3	0.92270	0.00159	0.92589
nciapunhct11_7_3	7000	3297	1516	7153	73.72	323	1E-04	0.91677	0.00157	0.91991	hciapunhct12_7_3	0.91538	0.00132	0.91803

Table 6.9.6-15. Results for UNX crystal content in packaging calculation model

Case	UNH (g)	^{235}U (g)	UNH H_2O (g)	CV H_2O (g)	h/x	gU/l	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciapunhct11_1_3	1000	471	217	9297	562.74	46	1E-04	0.62819	0.00115	0.63049	hciapunhct12_1_3	0.62885	0.00109	0.63103
UNH crystal content, 0 g polyethylene in flooded containment vessel, array packaging calculation model for CSI=0.4														
NCT											**HAC**			
ncf1unhct11_8_24_1_3	24000	11303	5197	1620	15.74	1106	1.0E-04	0.86774	0.00127	0.87027	hcf2unhct12_8_24_1_3	0.82915	0.00145	0.83205
ncf1unhct11_8_12_1_3	12000	5652	2598	5909	39.29	553	1.0E-04	0.88287	0.00133	0.88554	hcf2unhct12_8_12_1_3	0.85267	0.00165	0.85597
ncf1unhct11_8_11_1_3	11000	5181	2382	6266	43.57	507	1.0E-04	0.88535	0.00133	0.88802	hcf2unhct12_8_11_1_3	0.85565	0.00134	0.85833
ncf1unhct11_8_10_1_3	10000	4710	2165	6623	48.71	461	1.0E-04	0.88182	0.00140	0.88461	hcf2unhct12_8_10_1_3	0.85153	0.00132	0.85416
ncf1unhct11_8_1_1_3	1000	471	217	9840	557.20	46	1.0E-04	0.60011	0.00143	0.60297	hcf2unhct12_8_1_1_3	0.58199	0.00107	0.58414
UNH crystal content, 500 g polyethylene in flooded containment vessel, array packaging calculation model for CSI=0.4														
ncf1punhct11_24_3	24000	11303	5197	1078	15.97	1106	1E-04	0.87035	0.00135	0.87304	hcf2punhct12_24_3	0.83958	0.00135	0.84227
ncf1punhct11_15_3	15000	7064	3248	4294	30.24	692	1E-04	0.89208	0.00154	0.89516	hcf2punhct12_15_3	0.86102	0.00149	0.86400
ncf1punhct11_14_3	14000	6594	3031	4652	32.96	645	1E-04	0.89354	0.00152	0.89658	hcf2punhct12_14_3	0.85954	0.00131	0.86216
ncf1punhct11_1_3	1000	471	217	9297	562.74	46	1E-04	0.60481	0.00118	0.60718	hcf2punhct12_1_3	0.58731	0.00119	0.58968

Table 6.9.6-16. Results for leakage of UNX crystal content out of containment vessel

Case	U (g)	^{235}U (g)	UNH H_2O (g)	CV H_2O (g)	h/x	CV gU/l	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
UNH crystal content, 0 g polyethylene in flooded containment vessel, out leakage, single package reflected										
HAC										
icsrunhct12_24_1_1	24000	11303	5197	4875	30.14	687	1.0E-20	0.78331	0.00139	0.78609
icsrunhct12_24_1_2	24000	11303	5197	4875	30.14	687	1.0E-05	0.78291	0.00159	0.78610
icsrunhct12_24_1_3	24000	11303	5197	4875	30.14	687	1.0E-04	0.78197	0.00153	0.78503
icsrunhct12_24_1_4	24000	11303	5197	4875	30.14	687	1.0E-03	0.78003	0.00145	0.78294
icsrunhct12_24_1_5	24000	11303	5197	4875	30.14	687	1.0E-02	0.78443	0.00140	0.78723
icsrunhct12_24_1_6	24000	11303	5197	4875	30.14	687	1.0E-01	0.78426	0.00151	0.78729
icsrunhct12_24_1_8	24000	11303	5197	4875	30.14	687	3.0E-01	0.78841	0.00153	0.79146
icsrunhct12_24_1_15	24000	11303	5197	4875	30.14	687	1.0E+00	0.79193	0.00164	0.79521
icsrunhct12_24_1_15	24000	11303	5197	4875	30.14	687	1.0E+00	0.79193	0.00164	0.79521
icsrunhct12_23_1_15	23000	10832	4980	5097	31.79	658	1.0E+00	0.79465	0.00130	0.79724
icsrunhct12_22_1_15	22000	10361	4764	5318	33.59	629	1.0E+00	0.79665	0.00145	0.79956
icsrunhct12_21_1_15	21000	9890	4547	5540	35.56	601	1.0E+00	0.79533	0.00156	0.79845
icsrunhct12_20_1_15	20000	9419	4331	5762	37.73	572	1.0E+00	0.79937	0.00179	0.80295
icsrunhct12_19_1_15	19000	8948	4114	5984	40.13	544	1.0E+00	0.80059	0.00135	0.80329
icsrunhct12_18_1_15	18000	8477	3898	6205	42.79	515	1.0E+00	0.79930	0.00144	0.80219
icsrunhct12_17_1_15	17000	8006	3681	6427	45.77	486	1.0E+00	0.80320	0.00153	0.80626
icsrunhct12_16_1_15	16000	7536	3464	6649	49.11	458	1.0E+00	0.80113	0.00142	0.80396
icsrunhct12_15_1_15	15000	7064	3248	6871	52.91	429	1.0E+00	0.80445	0.00148	0.80740
icsrunhct12_14_1_15	14000	6594	3031	7092	57.24	401	1.0E+00	0.79995	0.00124	0.80243
icsrunhct12_13_1_15	13000	6123	2815	7314	62.25	372	1.0E+00	0.80425	0.00139	0.80703
icsrunhct12_12_1_15	12000	5652	2598	7536	68.09	343	1.0E+00	0.79843	0.00129	0.80100

Table 6.9.6-16. Results for leakage of UNX crystal content out of containment vessel

Case	U (g)	^{235}U (g)	UNH H_2O (g)	CV H_2O (g)	h/x	CV gU/l	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
icsrunhct12_11_1_15	11000	5181	2382	7758	74.98	315	1.0E+00	0.80002	0.00147	0.80297
icsrunhct12_10_1_15	10000	4710	2165	7979	83.26	286	1.0E+00	0.79540	0.00162	0.79864
icsrunhct12_9_1_15	9000	4239	1949	8201	93.38	257	1.0E+00	0.79147	0.00156	0.79459
icsrunhct12_8_1_15	8000	3768	1732	8423	106.03	229	1.0E+00	0.78224	0.00165	0.78553
icsrunhct12_7_1_15	7000	3297	1516	8645	122.29	200	1.0E+00	0.77559	0.00131	0.77821
icsrunhct12_6_1_15	6000	2826	1299	8866	143.98	172	1.0E+00	0.76261	0.00136	0.76532
icsrunhct12_5_1_15	5000	2355	1083	9088	174.33	143	1.0E+00	0.74504	0.00138	0.74781
icsrunhct12_4_1_15	4000	1884	866	9310	219.86	114	1.0E+00	0.72070	0.00131	0.72333
icsrunhct12_3_1_15	3000	1413	650	9532	295.76	86	1.0E+00	0.68185	0.00131	0.68447
icsrunhct12_2_1_15	2000	942	433	9753	447.52	57	1.0E+00	0.61401	0.00117	0.61635
icsrunhct12_1_1_15	1000	471	217	9975	902.71	29	1.0E+00	0.47625	0.00103	0.47831
UNH crystal content, 500 g polyethylene in flooded containment vessel, out leakage, single package reflected										
icsrpunhct12_24_1	24000	11303	5197	4444	30.37	710	1E-20	0.79145	0.00146	0.79436
icsrpunhct12_24_15	24000	11303	5197	4444	30.37	710	1E+00	0.80433	0.00145	0.80723
icsrpunhct12_24_15	24000	11303	5197	4444	30.37	710	1E+00	0.80433	0.00145	0.80723
icsrpunhct12_23_15	23000	10832	4980	4661	32.03	680	1E+00	0.80343	0.00127	0.80597
icsrpunhct12_22_15	22000	10361	4764	4878	33.84	651	1E+00	0.80375	0.00125	0.80625
icsrpunhct12_21_15	21000	9890	4547	5095	35.83	621	1E+00	0.80639	0.00161	0.80961
icsrpunhct12_20_15	20000	9419	4331	5312	38.01	592	1E+00	0.80696	0.00144	0.80984
icsrpunhct12_19_15	19000	8948	4114	5529	40.42	562	1E+00	0.80928	0.00157	0.81242
icsrpunhct12_18_15	18000	8477	3898	5746	43.10	533	1E+00	0.80687	0.00138	0.80963
icsrpunhct12_17_15	17000	8006	3681	5963	46.09	503	1E+00	0.80989	0.00164	0.81317
icsrpunhct12_16_15	16000	7536	3464	6180	49.46	473	1E+00	0.80777	0.00162	0.81101

Table 6.9.6-16. Results for leakage of UNX crystal content out of containment vessel

Case	U (g)	^{235}U (g)	UNH H_2O (g)	CV H_2O (g)	h/x	CV gU/l	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
icsrpunhct12_15_15	15000	7064	3248	6398	53.28	444	1E+00	0.81131	0.00154	0.81439
icsrpunhct12_14_15	14000	6594	3031	6615	57.64	414	1E+00	0.80815	0.00162	0.81139
icsrpunhct12_13_15	13000	6123	2815	6832	62.67	385	1E+00	0.80680	0.00133	0.80947
icsrpunhct12_12_15	12000	5652	2598	7049	68.55	355	1E+00	0.80665	0.00151	0.80967
icsrpunhct12_11_15	11000	5181	2382	7266	75.49	325	1E+00	0.80422	0.00157	0.80736
icsrpunhct12_10_15	10000	4710	2165	7483	83.82	296	1E+00	0.80093	0.00148	0.80388
icsrpunhct12_9_15	9000	4239	1949	7700	94.00	266	1E+00	0.79650	0.00144	0.79937
icsrpunhct12_8_15	8000	3768	1732	7918	106.72	237	1E+00	0.79302	0.00182	0.79667
icsrpunhct12_7_15	7000	3297	1516	8135	123.08	207	1E+00	0.78234	0.00156	0.78546
icsrpunhct12_6_15	6000	2826	1299	8352	144.90	178	1E+00	0.76957	0.00175	0.77308
icsrpunhct12_5_15	5000	2355	1083	8569	175.44	148	1E+00	0.75295	0.00147	0.75588
icsrpunhct12_4_15	4000	1884	866	8786	221.24	118	1E+00	0.72610	0.00127	0.72864
icsrpunhct12_3_15	3000	1413	650	9003	297.61	89	1E+00	0.68788	0.00134	0.69055
icsrpunhct12_2_15	2000	942	433	9220	450.29	59	1E+00	0.61943	0.00119	0.62182
icsrpunhct12_1_15	1000	471	217	9437	908.25	30	1E+00	0.47924	0.00105	0.48134

Table 6.9.6-17. Results for skull oxide (SO) content in CV calculation model

Case	SO (g)	U_3O_8 (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	mg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)	k_{eff}	σ	$k_{eff}+2\sigma$
flooded containment vessel, reflected														
513 g polyethylene, no can spacers														
cvcrsk3cc_1_15_17	11589	8063	4468	28.09	6828	4765	417	87518	4105	50.58	2596	0.82806	0.00135	0.83075
cvcrsk3cc_2_15_17	14934	11665	4015	17.79	9879	6858	504	73492	4105	33.41	2252	0.81716	0.00136	0.81989
cvcrsk3cc_3_15_17	13821	11876	4893	20.62	10058	7028	372	52930	3233	32.62	1060	0.82909	0.00144	0.83197
cvcrsk3cc_4_15_17	15246	14900	4599	15.52	12619	8842	60	6786	3235	25.07	-227	0.82622	0.00154	0.82930
cvcrsk3cc_5_15_17	21216	21036	3869	9.49	17815	12455	27	2168	3235	16.27	-360	0.81061	0.00116	0.81293
cvcrsk3cc_6_15_17	15111	12933	3765	28.02	10960	4122	921	223432	4105	54.01	744	0.75711	0.00110	0.75932
cvcrsk3cc_7_15_17	13155	11666	3989	32.68	9886	3712	609	164054	4106	61.55	367	0.76196	0.00136	0.76469
cvcrsk3cc_8_15_17	13650	11689	4068	33.01	9906	3737	261	69834	4106	61.69	1187	0.76713	0.00137	0.76988
cvcrsk3cc_9_15_17	21300	19865	3801	7.43	16816	15673	921	58764	3235	12.82	1	0.84737	0.00114	0.84965
cvcrsk3cc_10_15_17	21300	20786	3905	7.27	17596	16399	0	0	3235	12.41	1	0.85155	0.00148	0.85451
cvcrsk3cc_4_1_1	15246	14900	0	1.95	12619	8842	0.00	0	0	1.95	-227	0.49030	0.00095	0.49220
cvcrsk3cc_4_1_2	15246	14900	0	1.95	12619	8842	3.75	424	0	1.95	-227	0.49148	0.00090	0.49328
cvcrsk3cc_4_1_3	15246	14900	0	1.95	12619	8842	7.50	848	0	1.95	-227	0.49081	0.00095	0.49270
cvcrsk3cc_4_1_4	15246	14900	0	1.95	12619	8842	11.25	1272	0	1.95	-227	0.49337	0.00123	0.49584
cvcrsk3cc_4_1_5	15246	14900	0	1.95	12619	8842	15.00	1696	0	1.95	-227	0.49100	0.00105	0.49309
cvcrsk3cc_4_1_6	15246	14900	0	1.95	12619	8842	18.75	2120	0	1.95	-227	0.49125	0.00112	0.49348
cvcrsk3cc_4_1_7	15246	14900	0	1.95	12619	8842	22.50	2545	0	1.95	-227	0.49155	0.00104	0.49363
cvcrsk3cc_4_1_8	15246	14900	0	1.95	12619	8842	26.25	2969	0	1.95	-227	0.49300	0.00105	0.49510
cvcrsk3cc_4_1_9	15246	14900	0	1.95	12619	8842	30.00	3393	0	1.95	-227	0.49295	0.00117	0.49530
cvcrsk3cc_4_1_10	15246	14900	0	1.95	12619	8842	33.75	3817	0	1.95	-227	0.49206	0.00092	0.49391
cvcrsk3cc_4_1_11	15246	14900	0	1.95	12619	8842	37.50	4241	0	1.95	-227	0.49004	0.00115	0.49233
cvcrsk3cc_4_1_12	15246	14900	0	1.95	12619	8842	41.25	4665	0	1.95	-227	0.49325	0.00116	0.49558

Table 6.9.6-17. Results for skull oxide (SO) content in CV calculation model

Case	SO (g)	U_3O_8 (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	mg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrsk3cc_4_1_13	15246	14900	0	1.95	12619	8842	45.00	5089	0	1.95	-227	0.49242	0.00093	0.49429
cvcrsk3cc_4_1_14	15246	14900	0	1.95	12619	8842	48.75	5513	0	1.95	-227	0.49328	0.00119	0.49566
cvcrsk3cc_4_1_15	15246	14900	0	1.95	12619	8842	52.50	5937	0	1.95	-227	0.49139	0.00117	0.49373
cvcrsk3cc_4_1_16	15246	14900	0	1.95	12619	8842	56.25	6362	0	1.95	-227	0.49068	0.00105	0.49278
cvcrsk3cc_4_1_17	15246	14900	0	1.95	12619	8842	60.00	6786	0	1.95	-227	0.49303	0.00100	0.49502
cvcrsk3cc_4_6_1	15246	14900	460	3.3	12619	8842	0.00	0	323.51	4.26	-227	0.52088	0.00109	0.52306
cvcrsk3cc_4_6_2	15246	14900	460	3.3	12619	8842	3.75	424	323.51	4.26	-227	0.52247	0.00114	0.52474
cvcrsk3cc_4_6_3	15246	14900	460	3.3	12619	8842	7.50	848	323.51	4.26	-227	0.52250	0.00116	0.52482
cvcrsk3cc_4_6_4	15246	14900	460	3.3	12619	8842	11.25	1272	323.51	4.26	-227	0.52325	0.00103	0.52531
cvcrsk3cc_4_6_5	15246	14900	460	3.3	12619	8842	15.00	1696	323.51	4.26	-227	0.52252	0.00116	0.52485
cvcrsk3cc_4_6_6	15246	14900	460	3.3	12619	8842	18.75	2120	323.51	4.26	-227	0.52123	0.00113	0.52348
cvcrsk3cc_4_6_7	15246	14900	460	3.3	12619	8842	22.50	2545	323.51	4.26	-227	0.52156	0.00098	0.52353
cvcrsk3cc_4_6_8	15246	14900	460	3.3	12619	8842	26.25	2969	323.51	4.26	-227	0.52048	0.00106	0.52260
cvcrsk3cc_4_6_9	15246	14900	460	3.3	12619	8842	30.00	3393	323.51	4.26	-227	0.52115	0.00100	0.52315
cvcrsk3cc_4_6_10	15246	14900	460	3.3	12619	8842	33.75	3817	323.51	4.26	-227	0.52271	0.00114	0.52500
cvcrsk3cc_4_6_11	15246	14900	460	3.3	12619	8842	37.50	4241	323.51	4.26	-227	0.52221	0.00127	0.52474
cvcrsk3cc_4_6_12	15246	14900	460	3.3	12619	8842	41.25	4665	323.51	4.26	-227	0.52079	0.00104	0.52287
cvcrsk3cc_4_6_13	15246	14900	460	3.3	12619	8842	45.00	5089	323.51	4.26	-227	0.52323	0.00110	0.52543
cvcrsk3cc_4_6_14	15246	14900	460	3.3	12619	8842	48.75	5513	323.51	4.26	-227	0.52202	0.00129	0.52459
cvcrsk3cc_4_6_15	15246	14900	460	3.3	12619	8842	52.50	5937	323.51	4.26	-227	0.52288	0.00094	0.52476
cvcrsk3cc_4_6_16	15246	14900	460	3.3	12619	8842	56.25	6362	323.51	4.26	-227	0.52179	0.00106	0.52391
cvcrsk3cc_4_6_17	15246	14900	460	3.3	12619	8842	60.00	6786	323.51	4.26	-227	0.52265	0.00108	0.52481
cvcrsk3cc_4_7_1	15246	14900	920	4.66	12619	8842	0.00	0	647.03	6.57	-227	0.55466	0.00117	0.55699
cvcrsk3cc_4_7_2	15246	14900	920	4.66	12619	8842	3.75	424	647.03	6.57	-227	0.55192	0.00105	0.55402

Table 6.9.6-17. Results for skull oxide (SO) content in CV calculation model

Case	SO (g)	U_3O_8 (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	mg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrsk3cc_4_7_3	15246	14900	920	4.66	12619	8842	7.50	848	647.03	6.57	-227	0.55432	0.00118	0.55668
cvcrsk3cc_4_7_4	15246	14900	920	4.66	12619	8842	11.25	1272	647.03	6.57	-227	0.55387	0.00107	0.55600
cvcrsk3cc_4_7_5	15246	14900	920	4.66	12619	8842	15.00	1696	647.03	6.57	-227	0.55390	0.00102	0.55595
cvcrsk3cc_4_7_6	15246	14900	920	4.66	12619	8842	18.75	2120	647.03	6.57	-227	0.55272	0.00112	0.55496
cvcrsk3cc_4_7_7	15246	14900	920	4.66	12619	8842	22.50	2545	647.03	6.57	-227	0.55292	0.00118	0.55529
cvcrsk3cc_4_7_8	15246	14900	920	4.66	12619	8842	26.25	2969	647.03	6.57	-227	0.55262	0.00111	0.55484
cvcrsk3cc_4_7_9	15246	14900	920	4.66	12619	8842	30.00	3393	647.03	6.57	-227	0.55242	0.00108	0.55457
cvcrsk3cc_4_7_10	15246	14900	920	4.66	12619	8842	33.75	3817	647.03	6.57	-227	0.55457	0.00137	0.55732
cvcrsk3cc_4_7_11	15246	14900	920	4.66	12619	8842	37.50	4241	647.03	6.57	-227	0.55376	0.00117	0.55610
cvcrsk3cc_4_7_12	15246	14900	920	4.66	12619	8842	41.25	4665	647.03	6.57	-227	0.55283	0.00131	0.55545
cvcrsk3cc_4_7_13	15246	14900	920	4.66	12619	8842	45.00	5089	647.03	6.57	-227	0.55393	0.00118	0.55630
cvcrsk3cc_4_7_14	15246	14900	920	4.66	12619	8842	48.75	5513	647.03	6.57	-227	0.55181	0.00107	0.55395
cvcrsk3cc_4_7_15	15246	14900	920	4.66	12619	8842	52.50	5937	647.03	6.57	-227	0.55425	0.00107	0.55640
cvcrsk3cc_4_7_16	15246	14900	920	4.66	12619	8842	56.25	6362	647.03	6.57	-227	0.55377	0.00105	0.55587
cvcrsk3cc_4_7_17	15246	14900	920	4.66	12619	8842	60.00	6786	647.03	6.57	-227	0.55425	0.00101	0.55628
cvcrsk3cc_4_8_1	15246	14900	1380	6.02	12619	8842	0.00	0	970.54	8.88	-227	0.58801	0.00133	0.59068
cvcrsk3cc_4_8_2	15246	14900	1380	6.02	12619	8842	3.75	424	970.54	8.88	-227	0.58867	0.00114	0.59095
cvcrsk3cc_4_8_3	15246	14900	1380	6.02	12619	8842	7.50	848	970.54	8.88	-227	0.58712	0.00112	0.58936
cvcrsk3cc_4_8_4	15246	14900	1380	6.02	12619	8842	11.25	1272	970.54	8.88	-227	0.58657	0.00115	0.58887
cvcrsk3cc_4_8_5	15246	14900	1380	6.02	12619	8842	15.00	1696	970.54	8.88	-227	0.58720	0.00105	0.58930
cvcrsk3cc_4_8_6	15246	14900	1380	6.02	12619	8842	18.75	2120	970.54	8.88	-227	0.58418	0.00122	0.58663
cvcrsk3cc_4_8_7	15246	14900	1380	6.02	12619	8842	22.50	2545	970.54	8.88	-227	0.58706	0.00118	0.58943
cvcrsk3cc_4_8_8	15246	14900	1380	6.02	12619	8842	26.25	2969	970.54	8.88	-227	0.58528	0.00110	0.58748
cvcrsk3cc_4_8_9	15246	14900	1380	6.02	12619	8842	30.00	3393	970.54	8.88	-227	0.58452	0.00119	0.58689
cvcrsk3cc_4_8_10	15246	14900	1380	6.02	12619	8842	33.75	3817	970.54	8.88	-227	0.58645	0.00113	0.58870

Table 6.9.6-17. Results for skull oxide (SO) content in CV calculation model

Case	SO (g)	U_3O_8 (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	mg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrsk3cc_4_8_11	15246	14900	1380	6.02	12619	8842	37.50	4241	970.54	8.88	-227	0.58475	0.00109	0.58694
cvcrsk3cc_4_8_12	15246	14900	1380	6.02	12619	8842	41.25	4665	970.54	8.88	-227	0.58633	0.00110	0.58853
cvcrsk3cc_4_8_13	15246	14900	1380	6.02	12619	8842	45.00	5089	970.54	8.88	-227	0.58553	0.00107	0.58766
cvcrsk3cc_4_8_14	15246	14900	1380	6.02	12619	8842	48.75	5513	970.54	8.88	-227	0.58632	0.00118	0.58869
cvcrsk3cc_4_8_15	15246	14900	1380	6.02	12619	8842	52.50	5937	970.54	8.88	-227	0.58543	0.00106	0.58756
cvcrsk3cc_4_8_16	15246	14900	1380	6.02	12619	8842	56.25	6362	970.54	8.88	-227	0.58716	0.00123	0.58962
cvcrsk3cc_4_8_17	15246	14900	1380	6.02	12619	8842	60.00	6786	970.54	8.88	-227	0.58845	0.00113	0.59071
cvcrsk3cc_4_9_1	15246	14900	1840	7.38	12619	8842	0.00	0	1294.06	11.2	-227	0.62013	0.00104	0.62220
cvcrsk3cc_4_9_2	15246	14900	1840	7.38	12619	8842	3.75	424	1294.06	11.2	-227	0.61947	0.00123	0.62193
cvcrsk3cc_4_9_3	15246	14900	1840	7.38	12619	8842	7.50	848	1294.06	11.2	-227	0.62178	0.00112	0.62402
cvcrsk3cc_4_9_4	15246	14900	1840	7.38	12619	8842	11.25	1272	1294.06	11.2	-227	0.62009	0.00108	0.62225
cvcrsk3cc_4_9_5	15246	14900	1840	7.38	12619	8842	15.00	1696	1294.06	11.2	-227	0.61950	0.00114	0.62178
cvcrsk3cc_4_9_6	15246	14900	1840	7.38	12619	8842	18.75	2120	1294.06	11.2	-227	0.62035	0.00102	0.62240
cvcrsk3cc_4_9_7	15246	14900	1840	7.38	12619	8842	22.50	2545	1294.06	11.2	-227	0.61820	0.00111	0.62042
cvcrsk3cc_4_9_8	15246	14900	1840	7.38	12619	8842	26.25	2969	1294.06	11.2	-227	0.62037	0.00127	0.62290
cvcrsk3cc_4_9_9	15246	14900	1840	7.38	12619	8842	30.00	3393	1294.06	11.2	-227	0.62084	0.00111	0.62306
cvcrsk3cc_4_9_10	15246	14900	1840	7.38	12619	8842	33.75	3817	1294.06	11.2	-227	0.61977	0.00114	0.62205
cvcrsk3cc_4_9_11	15246	14900	1840	7.38	12619	8842	37.50	4241	1294.06	11.2	-227	0.61997	0.00123	0.62243
cvcrsk3cc_4_9_12	15246	14900	1840	7.38	12619	8842	41.25	4665	1294.06	11.2	-227	0.62097	0.00112	0.62320
cvcrsk3cc_4_9_13	15246	14900	1840	7.38	12619	8842	45.00	5089	1294.06	11.2	-227	0.62013	0.00126	0.62266
cvcrsk3cc_4_9_14	15246	14900	1840	7.38	12619	8842	48.75	5513	1294.06	11.2	-227	0.62028	0.00109	0.62245
cvcrsk3cc_4_9_15	15246	14900	1840	7.38	12619	8842	52.50	5937	1294.06	11.2	-227	0.62003	0.00107	0.62216
cvcrsk3cc_4_9_16	15246	14900	1840	7.38	12619	8842	56.25	6362	1294.06	11.2	-227	0.62193	0.00107	0.62408
cvcrsk3cc_4_9_17	15246	14900	1840	7.38	12619	8842	60.00	6786	1294.06	11.2	-227	0.62122	0.00117	0.62356

Table 6.9.6-17. Results for skull oxide (SO) content in CV calculation model

Case	SO (g)	U_3O_8 (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	mg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrsk3cc_4_10_1	15246	14900	2300	8.73	12619	8842	0.00	0	1617.57	13.51	-227	0.65504	0.00131	0.65766
cvcrsk3cc_4_10_2	15246	14900	2300	8.73	12619	8842	3.75	424	1617.57	13.51	-227	0.65421	0.00099	0.65618
cvcrsk3cc_4_10_3	15246	14900	2300	8.73	12619	8842	7.50	848	1617.57	13.51	-227	0.65445	0.00123	0.65692
cvcrsk3cc_4_10_4	15246	14900	2300	8.73	12619	8842	11.25	1272	1617.57	13.51	-227	0.65392	0.00127	0.65646
cvcrsk3cc_4_10_5	15246	14900	2300	8.73	12619	8842	15.00	1696	1617.57	13.51	-227	0.65599	0.00134	0.65868
cvcrsk3cc_4_10_6	15246	14900	2300	8.73	12619	8842	18.75	2120	1617.57	13.51	-227	0.65239	0.00107	0.65454
cvcrsk3cc_4_10_7	15246	14900	2300	8.73	12619	8842	22.50	2545	1617.57	13.51	-227	0.65356	0.00101	0.65558
cvcrsk3cc_4_10_8	15246	14900	2300	8.73	12619	8842	26.25	2969	1617.57	13.51	-227	0.65451	0.00134	0.65719
cvcrsk3cc_4_10_9	15246	14900	2300	8.73	12619	8842	30.00	3393	1617.57	13.51	-227	0.65576	0.00140	0.65855
cvcrsk3cc_4_10_10	15246	14900	2300	8.73	12619	8842	33.75	3817	1617.57	13.51	-227	0.65386	0.00121	0.65629
cvcrsk3cc_4_10_11	15246	14900	2300	8.73	12619	8842	37.50	4241	1617.57	13.51	-227	0.65645	0.00113	0.65871
cvcrsk3cc_4_10_12	15246	14900	2300	8.73	12619	8842	41.25	4665	1617.57	13.51	-227	0.65406	0.00130	0.65666
cvcrsk3cc_4_10_13	15246	14900	2300	8.73	12619	8842	45.00	5089	1617.57	13.51	-227	0.65406	0.00120	0.65646
cvcrsk3cc_4_10_14	15246	14900	2300	8.73	12619	8842	48.75	5513	1617.57	13.51	-227	0.65484	0.00126	0.65736
cvcrsk3cc_4_10_15	15246	14900	2300	8.73	12619	8842	52.50	5937	1617.57	13.51	-227	0.65420	0.00128	0.65675
cvcrsk3cc_4_10_16	15246	14900	2300	8.73	12619	8842	56.25	6362	1617.57	13.51	-227	0.65433	0.00123	0.65679
cvcrsk3cc_4_10_17	15246	14900	2300	8.73	12619	8842	60.00	6786	1617.57	13.51	-227	0.65399	0.00123	0.65646
cvcrsk3cc_4_11_1	15246	14900	2760	10.09	12619	8842	0.00	0	1941.09	15.82	-227	0.68728	0.00114	0.68956
cvcrsk3cc_4_11_2	15246	14900	2760	10.09	12619	8842	3.75	424	1941.09	15.82	-227	0.68899	0.00121	0.69141
cvcrsk3cc_4_11_3	15246	14900	2760	10.09	12619	8842	7.50	848	1941.09	15.82	-227	0.68815	0.00113	0.69041
cvcrsk3cc_4_11_4	15246	14900	2760	10.09	12619	8842	11.25	1272	1941.09	15.82	-227	0.68967	0.00117	0.69200
cvcrsk3cc_4_11_5	15246	14900	2760	10.09	12619	8842	15.00	1696	1941.09	15.82	-227	0.68936	0.00133	0.69201
cvcrsk3cc_4_11_6	15246	14900	2760	10.09	12619	8842	18.75	2120	1941.09	15.82	-227	0.68713	0.00127	0.68966
cvcrsk3cc_4_11_7	15246	14900	2760	10.09	12619	8842	22.50	2545	1941.09	15.82	-227	0.68933	0.00141	0.69216
cvcrsk3cc_4_11_8	15246	14900	2760	10.09	12619	8842	26.25	2969	1941.09	15.82	-227	0.68808	0.00130	0.69068

Table 6.9.6-17. Results for skull oxide (SO) content in CV calculation model

Case	SO (g)	U_3O_8 (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	mg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrsk3cc_4_11_9	15246	14900	2760	10.09	12619	8842	30.00	3393	1941.09	15.82	-227	0.69012	0.00114	0.69239
cvcrsk3cc_4_11_10	15246	14900	2760	10.09	12619	8842	33.75	3817	1941.09	15.82	-227	0.68913	0.00148	0.69208
cvcrsk3cc_4_11_11	15246	14900	2760	10.09	12619	8842	37.50	4241	1941.09	15.82	-227	0.68961	0.00139	0.69239
cvcrsk3cc_4_11_12	15246	14900	2760	10.09	12619	8842	41.25	4665	1941.09	15.82	-227	0.68779	0.00113	0.69005
cvcrsk3cc_4_11_13	15246	14900	2760	10.09	12619	8842	45.00	5089	1941.09	15.82	-227	0.69197	0.00114	0.69425
cvcrsk3cc_4_11_14	15246	14900	2760	10.09	12619	8842	48.75	5513	1941.09	15.82	-227	0.68861	0.00114	0.69090
cvcrsk3cc_4_11_15	15246	14900	2760	10.09	12619	8842	52.50	5937	1941.09	15.82	-227	0.68815	0.00127	0.69069
cvcrsk3cc_4_11_16	15246	14900	2760	10.09	12619	8842	56.25	6362	1941.09	15.82	-227	0.69041	0.00131	0.69303
cvcrsk3cc_4_11_17	15246	14900	2760	10.09	12619	8842	60.00	6786	1941.09	15.82	-227	0.68744	0.00129	0.69003
cvcrsk3cc_4_12_1	15246	14900	3220	11.45	12619	8842	0.00	0	2264.6	18.13	-227	0.72168	0.00119	0.72405
cvcrsk3cc_4_12_2	15246	14900	3220	11.45	12619	8842	3.75	424	2264.6	18.13	-227	0.72398	0.00131	0.72660
cvcrsk3cc_4_12_3	15246	14900	3220	11.45	12619	8842	7.50	848	2264.6	18.13	-227	0.72501	0.00142	0.72786
cvcrsk3cc_4_12_4	15246	14900	3220	11.45	12619	8842	11.25	1272	2264.6	18.13	-227	0.72327	0.00132	0.72592
cvcrsk3cc_4_12_5	15246	14900	3220	11.45	12619	8842	15.00	1696	2264.6	18.13	-227	0.72278	0.00124	0.72526
cvcrsk3cc_4_12_6	15246	14900	3220	11.45	12619	8842	18.75	2120	2264.6	18.13	-227	0.72081	0.00142	0.72364
cvcrsk3cc_4_12_7	15246	14900	3220	11.45	12619	8842	22.50	2545	2264.6	18.13	-227	0.72286	0.00141	0.72568
cvcrsk3cc_4_12_8	15246	14900	3220	11.45	12619	8842	26.25	2969	2264.6	18.13	-227	0.72457	0.00118	0.72693
cvcrsk3cc_4_12_9	15246	14900	3220	11.45	12619	8842	30.00	3393	2264.6	18.13	-227	0.72295	0.00126	0.72547
cvcrsk3cc_4_12_10	15246	14900	3220	11.45	12619	8842	33.75	3817	2264.6	18.13	-227	0.71959	0.00131	0.72221
cvcrsk3cc_4_12_11	15246	14900	3220	11.45	12619	8842	37.50	4241	2264.6	18.13	-227	0.72351	0.00106	0.72563
cvcrsk3cc_4_12_12	15246	14900	3220	11.45	12619	8842	41.25	4665	2264.6	18.13	-227	0.72291	0.00139	0.72570
cvcrsk3cc_4_12_13	15246	14900	3220	11.45	12619	8842	45.00	5089	2264.6	18.13	-227	0.72324	0.00125	0.72574
cvcrsk3cc_4_12_14	15246	14900	3220	11.45	12619	8842	48.75	5513	2264.6	18.13	-227	0.72395	0.00143	0.72680
cvcrsk3cc_4_12_15	15246	14900	3220	11.45	12619	8842	52.50	5937	2264.6	18.13	-227	0.72591	0.00111	0.72814

Table 6.9.6-17. Results for skull oxide (SO) content in CV calculation model

Case	SO (g)	U_3O_8 (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	mg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrsk3cc_4_12_16	15246	14900	3220	11.45	12619	8842	56.25	6362	2264.6	18.13	-227	0.72242	0.00146	0.72535
cvcrsk3cc_4_12_17	15246	14900	3220	11.45	12619	8842	60.00	6786	2264.6	18.13	-227	0.72398	0.00117	0.72631
cvcrsk3cc_4_13_1	15246	14900	3679	12.81	12619	8842	0.00	0	2588.12	20.45	-227	0.75630	0.00133	0.75896
cvcrsk3cc_4_13_2	15246	14900	3679	12.81	12619	8842	3.75	424	2588.12	20.45	-227	0.75574	0.00132	0.75838
cvcrsk3cc_4_13_3	15246	14900	3679	12.81	12619	8842	7.50	848	2588.12	20.45	-227	0.75761	0.00136	0.76032
cvcrsk3cc_4_13_4	15246	14900	3679	12.81	12619	8842	11.25	1272	2588.12	20.45	-227	0.75747	0.00147	0.76042
cvcrsk3cc_4_13_5	15246	14900	3679	12.81	12619	8842	15.00	1696	2588.12	20.45	-227	0.75674	0.00120	0.75914
cvcrsk3cc_4_13_6	15246	14900	3679	12.81	12619	8842	18.75	2120	2588.12	20.45	-227	0.75883	0.00137	0.76157
cvcrsk3cc_4_13_7	15246	14900	3679	12.81	12619	8842	22.50	2545	2588.12	20.45	-227	0.75912	0.00125	0.76162
cvcrsk3cc_4_13_8	15246	14900	3679	12.81	12619	8842	26.25	2969	2588.12	20.45	-227	0.75690	0.00131	0.75952
cvcrsk3cc_4_13_9	15246	14900	3679	12.81	12619	8842	30.00	3393	2588.12	20.45	-227	0.75692	0.00123	0.75938
cvcrsk3cc_4_13_10	15246	14900	3679	12.81	12619	8842	33.75	3817	2588.12	20.45	-227	0.75676	0.00123	0.75923
cvcrsk3cc_4_13_11	15246	14900	3679	12.81	12619	8842	37.50	4241	2588.12	20.45	-227	0.75541	0.00134	0.75808
cvcrsk3cc_4_13_12	15246	14900	3679	12.81	12619	8842	41.25	4665	2588.12	20.45	-227	0.75894	0.00141	0.76176
cvcrsk3cc_4_13_13	15246	14900	3679	12.81	12619	8842	45.00	5089	2588.12	20.45	-227	0.75688	0.00137	0.75963
cvcrsk3cc_4_13_14	15246	14900	3679	12.81	12619	8842	48.75	5513	2588.12	20.45	-227	0.75618	0.00140	0.75898
cvcrsk3cc_4_13_15	15246	14900	3679	12.81	12619	8842	52.50	5937	2588.12	20.45	-227	0.75806	0.00143	0.76092
cvcrsk3cc_4_13_16	15246	14900	3679	12.81	12619	8842	56.25	6362	2588.12	20.45	-227	0.75838	0.00131	0.76100
cvcrsk3cc_4_13_17	15246	14900	3679	12.81	12619	8842	60.00	6786	2588.12	20.45	-227	0.75890	0.00130	0.76150
cvcrsk3cc_4_14_1	15246	14900	4139	14.16	12619	8842	0.00	0	2911.63	22.76	-227	0.78934	0.00142	0.79219
cvcrsk3cc_4_14_2	15246	14900	4139	14.16	12619	8842	3.75	424	2911.63	22.76	-227	0.79102	0.00153	0.79408
cvcrsk3cc_4_14_3	15246	14900	4139	14.16	12619	8842	7.50	848	2911.63	22.76	-227	0.78792	0.00140	0.79073
cvcrsk3cc_4_14_4	15246	14900	4139	14.16	12619	8842	11.25	1272	2911.63	22.76	-227	0.78817	0.00122	0.79061
cvcrsk3cc_4_14_5	15246	14900	4139	14.16	12619	8842	15.00	1696	2911.63	22.76	-227	0.79185	0.00133	0.79451

Table 6.9.6-17. Results for skull oxide (SO) content in CV calculation model

Case	SO (g)	U_3O_8 (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	mg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrsk3cc_4_14_6	15246	14900	4139	14.16	12619	8842	18.75	2120	2911.63	22.76	-227	0.78935	0.00155	0.79244
cvcrsk3cc_4_14_7	15246	14900	4139	14.16	12619	8842	22.50	2545	2911.63	22.76	-227	0.79031	0.00139	0.79310
cvcrsk3cc_4_14_8	15246	14900	4139	14.16	12619	8842	26.25	2969	2911.63	22.76	-227	0.79032	0.00119	0.79269
cvcrsk3cc_4_14_9	15246	14900	4139	14.16	12619	8842	30.00	3393	2911.63	22.76	-227	0.79075	0.00125	0.79326
cvcrsk3cc_4_14_10	15246	14900	4139	14.16	12619	8842	33.75	3817	2911.63	22.76	-227	0.78950	0.00127	0.79203
cvcrsk3cc_4_14_11	15246	14900	4139	14.16	12619	8842	37.50	4241	2911.63	22.76	-227	0.79226	0.00132	0.79490
cvcrsk3cc_4_14_12	15246	14900	4139	14.16	12619	8842	41.25	4665	2911.63	22.76	-227	0.79141	0.00129	0.79400
cvcrsk3cc_4_14_13	15246	14900	4139	14.16	12619	8842	45.00	5089	2911.63	22.76	-227	0.79226	0.00131	0.79488
cvcrsk3cc_4_14_14	15246	14900	4139	14.16	12619	8842	48.75	5513	2911.63	22.76	-227	0.79139	0.00140	0.79418
cvcrsk3cc_4_14_15	15246	14900	4139	14.16	12619	8842	52.50	5937	2911.63	22.76	-227	0.79157	0.00136	0.79429
cvcrsk3cc_4_14_16	15246	14900	4139	14.16	12619	8842	56.25	6362	2911.63	22.76	-227	0.78883	0.00118	0.79119
cvcrsk3cc_4_14_17	15246	14900	4139	14.16	12619	8842	60.00	6786	2911.63	22.76	-227	0.79251	0.00163	0.79576
cvcrsk3cc_4_15_1	15246	14900	4599	15.52	12619	8842	0.00	0	3235.15	25.07	-227	0.82370	0.00143	0.82655
cvcrsk3cc_4_15_2	15246	14900	4599	15.52	12619	8842	3.75	424	3235.15	25.07	-227	0.82249	0.00121	0.82491
cvcrsk3cc_4_15_3	15246	14900	4599	15.52	12619	8842	7.50	848	3235.15	25.07	-227	0.82289	0.00125	0.82539
cvcrsk3cc_4_15_4	15246	14900	4599	15.52	12619	8842	11.25	1272	3235.15	25.07	-227	0.82409	0.00117	0.82643
cvcrsk3cc_4_15_5	15246	14900	4599	15.52	12619	8842	15.00	1696	3235.15	25.07	-227	0.82541	0.00127	0.82794
cvcrsk3cc_4_15_6	15246	14900	4599	15.52	12619	8842	18.75	2120	3235.15	25.07	-227	0.82424	0.00123	0.82669
cvcrsk3cc_4_15_7	15246	14900	4599	15.52	12619	8842	22.50	2545	3235.15	25.07	-227	0.82476	0.00182	0.82841
cvcrsk3cc_4_15_8	15246	14900	4599	15.52	12619	8842	26.25	2969	3235.15	25.07	-227	0.82419	0.00142	0.82702
cvcrsk3cc_4_15_9	15246	14900	4599	15.52	12619	8842	30.00	3393	3235.15	25.07	-227	0.82530	0.00145	0.82820
cvcrsk3cc_4_15_10	15246	14900	4599	15.52	12619	8842	33.75	3817	3235.15	25.07	-227	0.82433	0.00155	0.82742
cvcrsk3cc_4_15_11	15246	14900	4599	15.52	12619	8842	37.50	4241	3235.15	25.07	-227	0.82379	0.00142	0.82663
cvcrsk3cc_4_15_12	15246	14900	4599	15.52	12619	8842	41.25	4665	3235.15	25.07	-227	0.82450	0.00146	0.82742
cvcrsk3cc_4_15_13	15246	14900	4599	15.52	12619	8842	45.00	5089	3235.15	25.07	-227	0.82666	0.00109	0.82883

Table 6.9.6-17. Results for skull oxide (SO) content in CV calculation model

Case	SO (g)	U_3O_8 (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	mg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrsk3cc_4_15_14	15246	14900	4599	15.52	12619	8842	48.75	5513	3235.15	25.07	-227	0.82521	0.00125	0.82772
cvcrsk3cc_4_15_15	15246	14900	4599	15.52	12619	8842	52.50	5937	3235.15	25.07	-227	0.82544	0.00120	0.82784
cvcrsk3cc_4_15_16	15246	14900	4599	15.52	12619	8842	56.25	6362	3235.15	25.07	-227	0.82578	0.00133	0.82844
cvcrsk3cc_4_15_17	15246	14900	4599	15.52	12619	8842	60.00	6786	3235.15	25.07	-227	0.82622	0.00154	0.82930
cvcrsk3cc_6_1_17	15111	12933	0	4.17	10960	4122	921	223432	0	4.17	744	0.44158	0.00098	0.44355
cvcrsk3cc_6_6_17	15111	12933	377	6.56	10960	4122	921	223432	410	9.16	744	0.46812	0.00103	0.47018
cvcrsk3cc_6_7_17	15111	12933	753	8.94	10960	4122	921	223432	821	14.14	744	0.49580	0.00108	0.49797
cvcrsk3cc_6_8_17	15111	12933	1130	11.33	10960	4122	921	223432	1231	19.12	744	0.52824	0.00111	0.53046
cvcrsk3cc_6_9_17	15111	12933	1506	13.71	10960	4122	921	223432	1642	24.11	744	0.55880	0.00129	0.56139
cvcrsk3cc_6_10_17	15111	12933	1883	16.09	10960	4122	921	223432	2052	29.09	744	0.58946	0.00103	0.59153
cvcrsk3cc_6_11_17	15111	12933	2259	18.48	10960	4122	921	223432	2463	34.07	744	0.62334	0.00130	0.62593
cvcrsk3cc_6_12_17	15111	12933	2636	20.86	10960	4122	921	223432	2873	39.06	744	0.65813	0.00115	0.66044
cvcrsk3cc_6_13_17	15111	12933	3012	23.25	10960	4122	921	223432	3284	44.04	744	0.69032	0.00104	0.69240
cvcrsk3cc_6_14_17	15111	12933	3389	25.63	10960	4122	921	223432	3694	49.02	744	0.72104	0.00142	0.72388
cvcrsk3cc_6_15_17	15111	12933	3765	28.02	10960	4122	921	223432	4105	54.01	744	0.75711	0.00110	0.75932

Table 6.9.6-18a. NCT results for skull oxide (SO) content in packaging calculation model

Case	SO (g)	U_3O_8 (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	mg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded CV, NCT single package, reflected														
513 g polyethylene, no can spacers														
ncsrsk_1_15	11589	8063	4468	28.09	6828	4765	417	87518	4105	50.58	2596	0.71933	0.00154	0.72241
ncsrsk_2_15	14934	11665	4015	17.79	9879	6858	504	73492	4105	33.41	2252	0.70319	0.00144	0.70606
ncsrsk_3_15	13821	11876	4893	20.62	10058	7028	372	52930	3233	32.62	1060	0.71916	0.00128	0.72172
ncsrsk_4_15	15246	14900	4599	15.52	12619	8842	60	6786	3235	25.07	-227	0.71123	0.00145	0.71413
ncsrsk_5_15	21216	21036	3869	9.49	17815	12455	27	2168	3235	16.27	-360	0.69577	0.00139	0.69855
ncsrsk_6_15	15111	12933	3765	28.02	10960	4122	921	223432	4105	54.01	744	0.63803	0.00171	0.64146
ncsrsk_7_15	13155	11666	3989	32.68	9886	3712	609	164054	4106	61.55	367	0.65018	0.00127	0.65271
ncsrsk_8_15	13650	11689	4068	33.01	9906	3737	261	69834	4106	61.69	1187	0.65349	0.00128	0.65604
ncsrsk_9_15	21300	19865	3801	7.43	16816	15673	921	58764	3235	12.82	1	0.73837	0.00130	0.74096
ncsrsk_10_15	21300	20786	3905	7.27	17596	16399	0	0	3235	12.41	1	0.74201	0.00149	0.74499
ncsrsk_9_1	21300	19865	0	1.10	16816	15673	921	58764	0	1.10	1	0.40142	0.00078	0.40297
ncsrsk_9_6	21300	19865	380	1.73	16816	15673	921	58764	324	2.27	1	0.43142	0.00096	0.43334
ncsrsk_9_7	21300	19865	760	2.36	16816	15673	921	58764	647	3.44	1	0.46578	0.00099	0.46776
ncsrsk_9_8	21300	19865	1140	3.00	16816	15673	921	58764	971	4.61	1	0.49839	0.00107	0.50053
ncsrsk_9_9	21300	19865	1521	3.63	16816	15673	921	58764	1294	5.79	1	0.53148	0.00124	0.53397
ncsrsk_9_10	21300	19865	1901	4.26	16816	15673	921	58764	1618	6.96	1	0.56633	0.00122	0.56877
ncsrsk_9_11	21300	19865	2281	4.90	16816	15673	921	58764	1941	8.13	1	0.60204	0.00118	0.60441
ncsrsk_9_12	21300	19865	2661	5.53	16816	15673	921	58764	2265	9.30	1	0.63600	0.00119	0.63839
ncsrsk_9_13	21300	19865	3041	6.16	16816	15673	921	58764	2588	10.47	1	0.67128	0.00130	0.67389
ncsrsk_9_14	21300	19865	3421	6.80	16816	15673	921	58764	2912	11.64	1	0.70363	0.00130	0.70623
ncsrsk_9_15	21300	19865	3801	7.43	16816	15673	921	58764	3235	12.82	1	0.73837	0.00130	0.74096

Table 6.9.6-18a. NCT results for skull oxide (SO) content in packaging calculation model

Case	SO (g)	U_3O_8 (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	mg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)	k_{eff}	σ	$k_{eff}+2\sigma$
ncsrsk_10_1	21300	20786	0	1.05	17596	16399	0	0	0	1.05	1	0.40278	0.00079	0.40436
ncsrsk_10_6	21300	20786	391	1.67	17596	16399	0	0	324	2.19	1	0.43497	0.00093	0.43683
ncsrsk_10_7	21300	20786	781	2.29	17596	16399	0	0	647	3.32	1	0.46764	0.00104	0.46971
ncsrsk_10_8	21300	20786	1172	2.91	17596	16399	0	0	971	4.46	1	0.50067	0.00103	0.50274
ncsrsk_10_9	21300	20786	1562	3.54	17596	16399	0	0	1294	5.60	1	0.53570	0.00129	0.53828
ncsrsk_10_10	21300	20786	1953	4.16	17596	16399	0	0	1618	6.73	1	0.57116	0.00119	0.57355
ncsrsk_10_11	21300	20786	2343	4.78	17596	16399	0	0	1941	7.87	1	0.60642	0.00131	0.60904
ncsrsk_10_12	21300	20786	2734	5.40	17596	16399	0	0	2265	9.00	1	0.63938	0.00118	0.64175
ncsrsk_10_13	21300	20786	3124	6.02	17596	16399	0	0	2588	10.14	1	0.67610	0.00123	0.67856
ncsrsk_10_14	21300	20786	3515	6.64	17596	16399	0	0	2912	11.28	1	0.70857	0.00115	0.71087
ncsrsk_10_15	21300	20786	3905	7.27	17596	16399	0	0	3235	12.41	1	0.74201	0.00149	0.74499
content in flooded containment vessel, NCT array packaging calculation model for CSI=0.0														
513 g polyethylene, no can spacers														
nciask_1_15	11589	8063	4468	28.09	6828	4765	417	87518	4105	50.58	2596	0.73555	0.00130	0.73814
nciask_2_15	14934	11665	4015	17.79	9879	6858	504	73492	4105	33.41	2252	0.72258	0.00122	0.72503
nciask_3_15	13821	11876	4893	20.62	10058	7028	372	52930	3233	32.62	1060	0.73483	0.00120	0.73724
nciask_4_15	15246	14900	4599	15.52	12619	8842	60	6786	3235	25.07	-227	0.72783	0.00122	0.73027
nciask_5_15	21216	21036	3869	9.49	17815	12455	27	2168	3235	16.27	-360	0.71163	0.00123	0.71409
nciask_6_15	15111	12933	3765	28.02	10960	4122	921	223432	4105	54.01	744	0.65333	0.00109	0.65551
nciask_7_15	13155	11666	3989	32.68	9886	3712	609	164054	4106	61.55	367	0.66124	0.00107	0.66339
nciask_8_15	13650	11689	4068	33.01	9906	3737	261	69834	4106	61.69	1187	0.66664	0.00124	0.66912
nciask_9_15	21300	19865	3801	7.43	16816	15673	921	58764	3235	12.82	1	0.75365	0.00127	0.75620
nciask_10_15	21300	20786	3905	7.27	17596	16399	0	0	3235	12.41	1	0.76141	0.00140	0.76422

Table 6.9.6-18a. NCT results for skull oxide (SO) content in packaging calculation model

Case	SO (g)	U_3O_8 (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	mg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)	k_{eff}	σ	$k_{eff}+2\sigma$
nciask_6_1	15111	12933	0	4.17	10960	4122	921	223432	0	4.17	744	0.26223	0.00069	0.26361
nciask_6_6	15111	12933	377	6.56	10960	4122	921	223432	410	9.16	744	0.29333	0.00078	0.29489
nciask_6_7	15111	12933	753	8.94	10960	4122	921	223432	821	14.14	744	0.32968	0.00084	0.33136
nciask_6_8	15111	12933	1130	11.33	10960	4122	921	223432	1231	19.12	744	0.36777	0.00088	0.36953
nciask_6_9	15111	12933	1506	13.71	10960	4122	921	223432	1642	24.11	744	0.40621	0.00127	0.40874
nciask_6_10	15111	12933	1883	16.09	10960	4122	921	223432	2052	29.09	744	0.44807	0.00116	0.45039
nciask_6_11	15111	12933	2259	18.48	10960	4122	921	223432	2463	34.07	744	0.49212	0.00111	0.49435
nciask_6_12	15111	12933	2636	20.86	10960	4122	921	223432	2873	39.06	744	0.53233	0.00122	0.53477
nciask_6_13	15111	12933	3012	23.25	10960	4122	921	223432	3284	44.04	744	0.57192	0.00123	0.57439
nciask_6_14	15111	12933	3389	25.63	10960	4122	921	223432	3694	49.02	744	0.61188	0.00136	0.61460
nciask_6_15	15111	12933	3765	28.02	10960	4122	921	223432	4105	54.01	744	0.65333	0.00109	0.65551
nciask_9_1	21300	19865	0	1.1	16816	15673	921	58764	0	1.10	1	0.41949	0.00093	0.42134
nciask_9_6	21300	19865	380	1.73	16816	15673	921	58764	324	2.27	1	0.45272	0.00092	0.45456
nciask_9_7	21300	19865	760	2.36	16816	15673	921	58764	647	3.44	1	0.48472	0.00116	0.48704
nciask_9_8	21300	19865	1140	3	16816	15673	921	58764	971	4.61	1	0.51805	0.00111	0.52027
nciask_9_9	21300	19865	1521	3.63	16816	15673	921	58764	1294	5.79	1	0.55105	0.00116	0.55336
nciask_9_10	21300	19865	1901	4.26	16816	15673	921	58764	1618	6.96	1	0.58571	0.00105	0.58780
nciask_9_11	21300	19865	2281	4.9	16816	15673	921	58764	1941	8.13	1	0.62158	0.00114	0.62386
nciask_9_12	21300	19865	2661	5.53	16816	15673	921	58764	2265	9.30	1	0.65700	0.00141	0.65983
nciask_9_13	21300	19865	3041	6.16	16816	15673	921	58764	2588	10.47	1	0.68964	0.00125	0.69214
nciask_9_14	21300	19865	3421	6.8	16816	15673	921	58764	2912	11.64	1	0.72169	0.00141	0.72451
nciask_9_15	21300	19865	3801	7.43	16816	15673	921	58764	3235	12.82	1	0.75365	0.00127	0.75620
nciask_10_1	21300	20786	0	1.05	17596	16399	0	0	0	1.05	1	0.42530	0.00082	0.42693
nciask_10_6	21300	20786	391	1.67	17596	16399	0	0	324	2.19	1	0.45517	0.00080	0.45677

Table 6.9.6-18a. NCT results for skull oxide (SO) content in packaging calculation model

Case	SO (g)	U_3O_8 (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	mg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)	k_{eff}	σ	$k_{eff}+2\sigma$
nciask_10_7	21300	20786	781	2.29	17596	16399	0	0	647	3.32	1	0.48754	0.00099	0.48952
nciask_10_8	21300	20786	1172	2.91	17596	16399	0	0	971	4.46	1	0.52247	0.00101	0.52448
nciask_10_9	21300	20786	1562	3.54	17596	16399	0	0	1294	5.60	1	0.55799	0.00107	0.56013
nciask_10_10	21300	20786	1953	4.16	17596	16399	0	0	1618	6.73	1	0.59209	0.00104	0.59416
nciask_10_11	21300	20786	2343	4.78	17596	16399	0	0	1941	7.87	1	0.62721	0.00107	0.62935
nciask_10_12	21300	20786	2734	5.4	17596	16399	0	0	2265	9.00	1	0.65769	0.00115	0.65999
nciask_10_13	21300	20786	3124	6.02	17596	16399	0	0	2588	10.14	1	0.69394	0.00131	0.69655
nciask_10_14	21300	20786	3515	6.64	17596	16399	0	0	2912	11.28	1	0.72808	0.00150	0.73109
nciask_10_15	21300	20786	3905	7.27	17596	16399	0	0	3235	12.41	1	0.76141	0.00140	0.76422

Table 6.9.6-18b. HAC results for skull oxide (SO) content in packaging calculation model

Case	SO (g)	U_3O_8 (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	mg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded CV, HAC single package, reflected														
513 g polyethylene, no can spacers														
hcsrsk_1_15	11589	8063	4468	28.09	6828	4765	417	87518	4105	50.58	2596	0.72049	0.00145	0.72339
hcsrsk_2_15	14934	11665	4015	17.79	9879	6858	504	73492	4105	33.41	2252	0.70717	0.00140	0.70997
hcsrsk_3_15	13821	11876	4893	20.62	10058	7028	372	52930	3233	32.62	1060	0.72081	0.00136	0.72353
hcsrsk_4_15	15246	14900	4599	15.52	12619	8842	60	6786	3235	25.07	-227	0.71449	0.00128	0.71706
hcsrsk_5_15	21216	21036	3869	9.49	17815	12455	27	2168	3235	16.27	-360	0.69845	0.00134	0.70113
hcsrsk_6_15	15111	12933	3765	28.02	10960	4122	921	223432	4105	54.01	744	0.63787	0.00140	0.64066
hcsrsk_7_15	13155	11666	3989	32.68	9886	3712	609	164054	4106	61.55	367	0.64910	0.00150	0.65210
hcsrsk_8_15	13650	11689	4068	33.01	9906	3737	261	69834	4106	61.69	1187	0.65332	0.00140	0.65613

Table 6.9.6-18b. HAC results for skull oxide (SO) content in packaging calculation model

Case	SO (g)	U_3O_8 (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	mg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)	k_{eff}	σ	$k_{eff}+2\sigma$
hcsrsk_9_15	21300	19865	3801	7.43	16816	15673	921	58764	3235	12.82	1	0.73855	0.00121	0.74096
hcsrsk_10_15	21300	20786	3905	7.27	17596	16399	0	0	3235	12.41	1	0.74359	0.00118	0.74595
hcsrsk_9_1	21300	19865	0	1.10	16816	15673	921	58764	0	1.10	1	0.40344	0.00080	0.40505
hcsrsk_9_6	21300	19865	380	1.73	16816	15673	921	58764	324	2.27	1	0.43432	0.00091	0.43614
hcsrsk_9_7	21300	19865	760	2.36	16816	15673	921	58764	647	3.44	1	0.46617	0.00090	0.46796
hcsrsk_9_8	21300	19865	1140	3.00	16816	15673	921	58764	971	4.61	1	0.49951	0.00104	0.50160
hcsrsk_9_9	21300	19865	1521	3.63	16816	15673	921	58764	1294	5.79	1	0.53428	0.00114	0.53656
hcsrsk_9_10	21300	19865	1901	4.26	16816	15673	921	58764	1618	6.96	1	0.57081	0.00102	0.57286
hcsrsk_9_11	21300	19865	2281	4.90	16816	15673	921	58764	1941	8.13	1	0.60569	0.00111	0.60792
hcsrsk_9_12	21300	19865	2661	5.53	16816	15673	921	58764	2265	9.30	1	0.63704	0.00125	0.63955
hcsrsk_9_13	21300	19865	3041	6.16	16816	15673	921	58764	2588	10.47	1	0.67153	0.00139	0.67431
hcsrsk_9_14	21300	19865	3421	6.80	16816	15673	921	58764	2912	11.64	1	0.70545	0.00113	0.70770
hcsrsk_9_15	21300	19865	3801	7.43	16816	15673	921	58764	3235	12.82	1	0.73855	0.00121	0.74096
hcsrsk_10_1	21300	20786	0	1.05	17596	16399	0	0	0	1.05	1	0.40569	0.00088	0.40745
hcsrsk_10_6	21300	20786	391	1.67	17596	16399	0	0	324	2.19	1	0.43659	0.00086	0.43832
hcsrsk_10_7	21300	20786	781	2.29	17596	16399	0	0	647	3.32	1	0.47008	0.00095	0.47198
hcsrsk_10_8	21300	20786	1172	2.91	17596	16399	0	0	971	4.46	1	0.50524	0.00097	0.50717
hcsrsk_10_9	21300	20786	1562	3.54	17596	16399	0	0	1294	5.60	1	0.53928	0.00102	0.54133
hcsrsk_10_10	21300	20786	1953	4.16	17596	16399	0	0	1618	6.73	1	0.57494	0.00115	0.57724
hcsrsk_10_11	21300	20786	2343	4.78	17596	16399	0	0	1941	7.87	1	0.60702	0.00111	0.60924
hcsrsk_10_12	21300	20786	2734	5.40	17596	16399	0	0	2265	9.00	1	0.64205	0.00132	0.64469
hcsrsk_10_13	21300	20786	3124	6.02	17596	16399	0	0	2588	10.14	1	0.67634	0.00138	0.67911
hcsrsk_10_14	21300	20786	3515	6.64	17596	16399	0	0	2912	11.28	1	0.71259	0.00144	0.71547
hcsrsk_10_15	21300	20786	3905	7.27	17596	16399	0	0	3235	12.41	1	0.74359	0.00118	0.74595

Table 6.9.6-18b. HAC results for skull oxide (SO) content in packaging calculation model

Case	SO (g)	U_3O_8 (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	mg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded containment vessel, HAC array packaging calculation model for CSI=0.0														
513 g polyethylene, no can spacers														
hciask_1_15	11589	8063	4468	28.09	6828	4765	417	87518	4105	50.58	2596	0.73896	0.00132	0.74159
hciask_2_15	14934	11665	4015	17.79	9879	6858	504	73492	4105	33.41	2252	0.72435	0.00127	0.72689
hciask_3_15	13821	11876	4893	20.62	10058	7028	372	52930	3233	32.62	1060	0.73900	0.00130	0.74160
hciask_4_15	15246	14900	4599	15.52	12619	8842	60	6786	3235	25.07	-227	0.73199	0.00123	0.73445
hciask_5_15	21216	21036	3869	9.49	17815	12455	27	2168	3235	16.27	-360	0.71601	0.00117	0.71835
hciask_6_15	15111	12933	3765	28.02	10960	4122	921	223432	4105	54.01	744	0.65587	0.00125	0.65837
hciask_7_15	13155	11666	3989	32.68	9886	3712	609	164054	4106	61.55	367	0.66608	0.00159	0.66925
hciask_8_15	13650	11689	4068	33.01	9906	3737	261	69834	4106	61.69	1187	0.66948	0.00153	0.67255
hciask_9_15	21300	19865	3801	7.43	16816	15673	921	58764	3235	12.82	1	0.75757	0.00116	0.75989
hciask_10_15	21300	20786	3905	7.27	17596	16399	0	0	3235	12.41	1	0.76462	0.00131	0.76725
hciask_6_1	15111	12933	0	4.17	10960	4122	921	223432	0	4.17	744	0.26620	0.00075	0.26769
hciask_6_6	15111	12933	377	6.56	10960	4122	921	223432	411	9.16	744	0.29787	0.00085	0.29957
hciask_6_7	15111	12933	753	8.94	10960	4122	921	223432	821	14.14	744	0.33370	0.00085	0.33539
hciask_6_8	15111	12933	1130	11.33	10960	4122	921	223432	1231	19.12	744	0.37226	0.00098	0.37422
hciask_6_9	15111	12933	1506	13.71	10960	4122	921	223432	1642	24.11	744	0.41300	0.00083	0.41465
hciask_6_10	15111	12933	1883	16.09	10960	4122	921	223432	2052	29.09	744	0.45192	0.00106	0.45403
hciask_6_11	15111	12933	2259	18.48	10960	4122	921	223432	2463	34.07	744	0.49341	0.00113	0.49566
hciask_6_12	15111	12933	2636	20.86	10960	4122	921	223432	2873	39.06	744	0.53469	0.00111	0.53691
hciask_6_13	15111	12933	3012	23.25	10960	4122	921	223432	3284	44.04	744	0.57324	0.00123	0.57571
hciask_6_14	15111	12933	3389	25.63	10960	4122	921	223432	3694	49.02	744	0.61596	0.00125	0.61847
hciask_6_15	15111	12933	3765	28.02	10960	4122	921	223432	4105	54.01	744	0.65587	0.00125	0.65837

Table 6.9.6-18b. HAC results for skull oxide (SO) content in packaging calculation model

Case	SO (g)	U_3O_8 (g)	Sat. H_2O (g)	SO h/x	U (g)	^{235}U (g)	C (g)	mg C/ g ^{235}U	CV H_2O (g)	CV h/x	Unident. (g)	k_{eff}	σ	$k_{eff}+2\sigma$
hciask_9_1	21300	19865	0	1.10	16816	15673	921	58764	0	1.10	1	0.42753	0.00091	0.42935
hciask_9_6	21300	19865	380	1.73	16816	15673	921	58764	324	2.27	1	0.45603	0.00103	0.45808
hciask_9_7	21300	19865	760	2.36	16816	15673	921	58764	647	3.44	1	0.48912	0.00101	0.49114
hciask_9_8	21300	19865	1140	3.00	16816	15673	921	58764	971	4.61	1	0.52104	0.00109	0.52322
hciask_9_9	21300	19865	1521	3.63	16816	15673	921	58764	1294	5.79	1	0.55643	0.00104	0.55851
hciask_9_10	21300	19865	1901	4.26	16816	15673	921	58764	1618	6.96	1	0.59193	0.00105	0.59403
hciask_9_11	21300	19865	2281	4.90	16816	15673	921	58764	1941	8.13	1	0.62726	0.00109	0.62945
hciask_9_12	21300	19865	2661	5.53	16816	15673	921	58764	2265	9.30	1	0.65952	0.00106	0.66163
hciask_9_13	21300	19865	3041	6.16	16816	15673	921	58764	2588	10.47	1	0.69094	0.00127	0.69348
hciask_9_14	21300	19865	3421	6.80	16816	15673	921	58764	2912	11.64	1	0.72863	0.00116	0.73095
hciask_9_15	21300	19865	3801	7.43	16816	15673	921	58764	3235	12.82	1	0.75757	0.00116	0.75989
hciask_10_1	21300	20786	0	1.05	17596	16399	0	0	0	1.05	1	0.43087	0.00111	0.43308
hciask_10_6	21300	20786	391	1.67	17596	16399	0	0	324	2.19	1	0.46066	0.00092	0.46250
hciask_10_7	21300	20786	781	2.29	17596	16399	0	0	647	3.32	1	0.49381	0.00097	0.49574
hciask_10_8	21300	20786	1172	2.91	17596	16399	0	0	971	4.46	1	0.52679	0.00113	0.52906
hciask_10_9	21300	20786	1562	3.54	17596	16399	0	0	1294	5.60	1	0.56200	0.00121	0.56442
hciask_10_10	21300	20786	1953	4.16	17596	16399	0	0	1618	6.73	1	0.59673	0.00118	0.59908
hciask_10_11	21300	20786	2343	4.78	17596	16399	0	0	1941	7.87	1	0.63042	0.00109	0.63260
hciask_10_12	21300	20786	2734	5.40	17596	16399	0	0	2265	9.00	1	0.66502	0.00116	0.66735
hciask_10_13	21300	20786	3124	6.02	17596	16399	0	0	2588	10.14	1	0.69780	0.00108	0.69997
hciask_10_14	21300	20786	3515	6.64	17596	16399	0	0	2912	11.28	1	0.73223	0.00123	0.73470
hciask_10_15	21300	20786	3905	7.27	17596	16399	0	0	3235	12.41	1	0.76462	0.00131	0.76725
nciask_10_14	21300	20786	3515	6.64	17596	16399	0	0	2912	11.28	1	0.72808	0.00150	0.73109
nciask_10_15	21300	20786	3905	7.27	17596	16399	0	0	3235	12.41	1	0.76141	0.00140	0.76422

Table 6.9.6-19a. Results for $UZrH_x$ content in CV calculation model

Case	np	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
TRIGA ($UZrH_x$) fuel content at 19.7 wt % ^{235}U, 500 g CH_2, containment vessel, reflected									
no can spacers (np thickness = 0.0 in.)									
cvcrtriga_1_1	0.0	10,400	921	0	0.00	1.0E-20	0.34219	0.00107	0.34432
cvcrtriga_1_6	0.0	10,400	921	900	25.50	1.0E-01	0.34704	0.00101	0.34905
cvcrtriga_1_7	0.0	10,400	921	1,800	51.00	2.0E-01	0.35869	0.00094	0.36057
cvcrtriga_1_8	0.0	10,400	921	2,700	76.50	3.0E-01	0.37291	0.00103	0.37496
cvcrtriga_1_9	0.0	10,400	921	3,599	102.00	4.0E-01	0.38978	0.00115	0.39209
cvcrtriga_1_10	0.0	10,400	921	4,499	127.50	5.0E-01	0.41521	0.00099	0.41719
cvcrtriga_1_11	0.0	10,400	921	5,399	153.00	6.0E-01	0.43399	0.00108	0.43616
cvcrtriga_1_12	0.0	10,400	921	6,299	178.50	7.0E-01	0.45681	0.00116	0.45914
cvcrtriga_1_13	0.0	10,400	921	7,199	204.00	8.0E-01	0.48121	0.00136	0.48393
cvcrtriga_1_14	0.0	10,400	921	8,098	229.51	9.0E-01	0.50284	0.00114	0.50511
cvcrtriga_1_15	0.0	10,400	921	8,998	255.01	1.0E+00	0.52494	0.00120	0.52735
cvcrtriga_1_15(n)	0.0	10,400	921	8,998	255.01	1.0E+00	0.52737	0.00065	0.52867
cvcrtrigap_1_15	0.0	10,400	921	8,998	255.01	1.0E+00	0.53581	0.00064	0.53709
can spacers (np thickness = 1.4 in.)									
cvcrtriga_2_15	1.4	10,400	921	8,385	237.62	1.0E+00	0.42157	0.00099	0.42354
TRIGA ($UZrH_x$) fuel content at 70.1 wt % ^{235}U, 500 g CH_2, containment vessel, reflected									
no can spacers (np thickness = 0.0 in.)									
cvcrtriga_70_1_1	0.0	6,847	408	0	0.00	1.0E+00	0.29196	0.00097	0.29391
cvcrtriga_70_1_6	0.0	6,847	408	900	57.56	1.0E+00	0.30096	0.00102	0.30300
cvcrtriga_70_1_7	0.0	6,847	408	1,800	115.13	1.0E+00	0.31496	0.00089	0.31674
cvcrtriga_70_1_8	0.0	6,847	408	2,700	172.69	1.0E+00	0.33376	0.00106	0.33588
cvcrtriga_70_1_9	0.0	6,847	408	3,599	230.26	1.0E+00	0.35363	0.00100	0.35564
cvcrtriga_70_1_10	0.0	6,847	408	4,499	287.82	1.0E+00	0.37761	0.00098	0.37956

Table 6.9.6-19a. Results for $UZrH_x$ content in CV calculation model

Case	np	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvcrtriga_70_1_11	0.0	6,847	408	5,399	345.38	1.0E+00	0.40017	0.00120	0.40257
cvcrtriga_70_1_12	0.0	6,847	408	6,299	402.95	1.0E+00	0.42263	0.00109	0.42481
cvcrtriga_70_1_13	0.0	6,847	408	7,199	460.51	1.0E+00	0.44607	0.00120	0.44848
cvcrtriga_70_1_14	0.0	6,847	408	8,098	518.07	1.0E+00	0.46618	0.00104	0.46827
cvcrtriga_70_1_15	0.0	6,847	408	8,998	575.64	1.0E+00	0.48847	0.00130	0.49107
cvcrtriga_70_1_15(n)	0.0	6,847	408	8,998	575.64	1.0E+00	0.49000	0.00065	0.49130
cvcrtrigap_70_1_15	0.0	6,847	408	8,998	575.64	1.0E+00	0.49726	0.00065	0.49856
can spacers (np thickness = 1.4 in.)									
cvcrtriga_70_2_15	1.4	6,847	408	8,385	536.39	1.0E+00	0.38372	0.00112	0.38596

Table 6.9.6-19b. Results for $UZrH_x$ content spacing in CV calculation model

Case	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	pitch (cm)	pitch (in.)	k_{eff}	σ	$k_{eff}+2\sigma$
TRIGA ($UZrH_x$) fuel content at 19.7 wt % ^{235}U, triangular pitch spacing from touching sections to sections touching convenience can									
500 g CH_2 in cc, no can spacers (np thickness = 0.0 in.), containment vessel, reflected									
MOCFR=1.0									
cvT20ptch_1_15_1	10,400	921	8,998	255.01	2.11201	1.440	0.48176	0.00106	0.48387
cvT20ptch_1_15_2	10,400	921	8,998	255.01	2.25466	1.537	0.49373	0.00119	0.49612
cvT20ptch_1_15_3	10,400	921	8,998	255.01	2.39731	1.635	0.50012	0.00131	0.50274
cvT20ptch_1_15_4	10,400	921	8,998	255.01	2.53996	1.732	0.50823	0.00110	0.51044
cvT20ptch_1_15_5	10,400	921	8,998	255.01	2.68261	1.829	0.51676	0.00126	0.51928
cvT20ptch_1_15_6	10,400	921	8,998	255.01	2.82526	1.927	0.52300	0.00115	0.52530
cvT20ptch_1_15_7	10,400	921	8,998	255.01	2.96791	2.024	0.52511	0.00127	0.52766

Table 6.9.6-19b. Results for $UZrH_x$ content spacing in CV calculation model

Case	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	pitch (cm)	pitch (in.)	k_{eff}	σ	$k_{eff}+2\sigma$
cvT20ptch_1_15_8	10,400	921	8,998	255.01	3.11056	2.121	0.52789	0.00116	0.53022
cvT20ptch_1_15_9	10,400	921	8,998	255.01	3.25321	2.218	0.52959	0.00109	0.53177
cvT20ptch_1_15_10	10,400	921	8,998	255.01	3.39586	2.316	0.52841	0.00115	0.53072
cvT20ptch_1_15_11	10,400	921	8,998	255.01	3.53851	2.413	0.52767	0.00109	0.52985
MOCFR=0.9									
cvT20ptch_1_14_1	10,400	921	8,098	229.51	2.11201	1.440	0.46727	0.00112	0.46951
cvT20ptch_1_14_6	10,400	921	8,098	229.51	2.82526	1.927	0.50042	0.00110	0.50263
cvT20ptch_1_14_11	10,400	921	8,098	229.51	3.53851	2.413	0.51015	0.00114	0.51244
MOCFR=0.8									
cvT20ptch_1_13_1	10,400	921	7,199	204.00	2.11201	1.440	0.44680	0.00107	0.44894
cvT20ptch_1_13_6	10,400	921	7,199	204.00	2.82526	1.927	0.47920	0.00102	0.48124
cvT20ptch_1_13_11	10,400	921	7,199	204.00	3.53851	2.413	0.49183	0.00115	0.49413
MOCFR=0.7									
cvT20ptch_1_12_1	10,400	921	6,299	178.50	2.11201	1.440	0.43179	0.00117	0.43413
cvT20ptch_1_12_6	10,400	921	6,299	178.50	2.82526	1.927	0.45630	0.00123	0.45875
cvT20ptch_1_12_11	10,400	921	6,299	178.50	3.53851	2.413	0.46790	0.00112	0.47014
MOCFR=0.6									
cvT20ptch_1_11_1	10,400	921	5,399	153.00	2.11201	1.440	0.41313	0.00109	0.41531
cvT20ptch_1_11_6	10,400	921	5,399	153.00	2.82526	1.927	0.43561	0.00115	0.43792
cvT20ptch_1_11_11	10,400	921	5,399	153.00	3.53851	2.413	0.44764	0.00100	0.44964
MOCFR=0.5									
cvT20ptch_1_10_1	10,400	921	4,499	127.50	2.11201	1.440	0.39451	0.00106	0.39664
cvT20ptch_1_10_6	10,400	921	4,499	127.50	2.82526	1.927	0.41120	0.00128	0.41376
cvT20ptch_1_10_11	10,400	921	4,499	127.50	3.53851	2.413	0.42438	0.00120	0.42678

Table 6.9.6-19b. Results for $UZrH_x$ content spacing in CV calculation model

Case	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	pitch (cm)	pitch (in.)	k_{eff}	σ	$k_{eff}+2\sigma$
MOCFR=0.4									
cvT20ptch_1_9_1	10,400	921	3,599	102.00	2.11201	1.440	0.38008	0.00097	0.38203
cvT20ptch_1_9_6	10,400	921	3,599	102.00	2.82526	1.927	0.39106	0.00098	0.39303
cvT20ptch_1_9_11	10,400	921	3,599	102.00	3.53851	2.413	0.40267	0.00126	0.40519
MOCFR=0.3									
cvT20ptch_1_8_1	10,400	921	2,700	76.50	2.11201	1.440	0.36348	0.00091	0.36531
cvT20ptch_1_8_6	10,400	921	2,700	76.50	2.82526	1.927	0.37106	0.00102	0.37309
cvT20ptch_1_8_11	10,400	921	2,700	76.50	3.53851	2.413	0.38210	0.00098	0.38406
MOCFR=0.2									
cvT20ptch_1_7_1	10,400	921	1,800	51.00	2.11201	1.440	0.35255	0.00094	0.35443
cvT20ptch_1_7_6	10,400	921	1,800	51.00	2.82526	1.927	0.35542	0.00089	0.35721
cvT20ptch_1_7_11	10,400	921	1,800	51.00	3.53851	2.413	0.36444	0.00091	0.36627
MOCFR=0.1									
cvT20ptch_1_6_1	10,400	921	900	25.50	2.11201	1.440	0.34383	0.00115	0.34612
cvT20ptch_1_6_6	10,400	921	900	25.50	2.82526	1.927	0.34516	0.00093	0.34703
cvT20ptch_1_6_11	10,400	921	900	25.50	3.53851	2.413	0.35189	0.00102	0.35394
MOCFR=1.0E-20									
cvT20ptch_1_1_1	10,400	921	0	0.00	2.11201	1.440	0.34314	0.00084	0.34482
cvT20ptch_1_1_6	10,400	921	0	0.00	2.82526	1.927	0.34273	0.00089	0.34452
cvT20ptch_1_1_11	10,400	921	0	0.00	3.53851	2.413	0.34291	0.00087	0.34466

Table 6.9.6-19c. Results for $UZrH_x$ content uranium weight fraction in CV calculation model

Case	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
TRIGA ($UZrH_x$) fuel content at 19.7 wt % ^{235}U, variation of uranium weight fraction in content								
500 g CH_2 in cc, no can spacers (np thickness = 0.0 in.), containment vessel, reflected								
45 wt % U								
cvTE20U45_1_15	10,400	921	8,998	255.01	1.0E+00	0.52494	0.00120	0.52735
cvTE20U45_1_14	10,400	921	8,098	229.51	9.0E-01	0.50284	0.00114	0.50511
cvTE20U45_1_13	10,400	921	7,199	204.00	8.0E-01	0.48121	0.00136	0.48393
cvTE20U45_1_12	10,400	921	6,299	178.50	7.0E-01	0.45681	0.00116	0.45914
cvTE20U45_1_11	10,400	921	5,399	153.00	6.0E-01	0.43399	0.00108	0.43616
cvTE20U45_1_10	10,400	921	4,499	127.50	5.0E-01	0.41521	0.00099	0.41719
cvTE20U45_1_9	10,400	921	3,599	102.00	4.0E-01	0.38978	0.00115	0.39209
cvTE20U45_1_8	10,400	921	2,700	76.50	3.0E-01	0.37291	0.00103	0.37496
cvTE20U45_1_7	10,400	921	1,800	51.00	2.0E-01	0.35869	0.00094	0.36057
cvTE20U45_1_6	10,400	921	900	25.50	1.0E-01	0.34704	0.00101	0.34905
cvTE20U45_1_1	10,400	921	0	0.00	1.0E-20	0.34219	0.00107	0.34432
30 wt % U								
cvTE20U30_1_15	8,250	489	8,998	480.29	1.0E+00	0.47671	0.00135	0.47942
cvTE20U30_1_14	8,250	489	8,098	432.26	9.0E-01	0.45562	0.00105	0.45772
cvTE20U30_1_13	8,250	489	7,199	384.23	8.0E-01	0.43218	0.00113	0.43445
cvTE20U30_1_12	8,250	489	6,299	336.20	7.0E-01	0.41165	0.00096	0.41356
cvTE20U30_1_11	8,250	489	5,399	288.17	6.0E-01	0.38706	0.00099	0.38903
cvTE20U30_1_10	8,250	489	4,499	240.14	5.0E-01	0.36759	0.00092	0.36944
cvTE20U30_1_9	8,250	489	3,599	192.11	4.0E-01	0.34766	0.00094	0.34954
cvTE20U30_1_8	8,250	489	2,700	144.09	3.0E-01	0.33073	0.00086	0.33245
cvTE20U30_1_7	8,250	489	1,800	96.06	2.0E-01	0.31555	0.00082	0.31720

Table 6.9.6-19c. Results for $UZrH_x$ content uranium weight fraction in CV calculation model

Case	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvTE20U30_1_6	8,250	489	900	48.03	1.0E-01	0.31018	0.00092	0.31202
cvTE20U30_1_01	8,250	489	0	0.00	1.0E-20	0.30488	0.00083	0.30654
20 wt % U								
cvTE20U20_1_15	7,545	297	8,998	790.78	1.0E+00	0.46046	0.00121	0.46289
cvTE20U20_1_14	7,545	297	8,098	711.70	9.0E-01	0.43928	0.00114	0.44156
cvTE20U20_1_13	7,545	297	7,199	632.62	8.0E-01	0.41486	0.00108	0.41702
cvTE20U20_1_12	7,545	297	6,299	553.54	7.0E-01	0.39584	0.00113	0.39809
cvTE20U20_1_11	7,545	297	5,399	474.47	6.0E-01	0.37399	0.00106	0.37612
cvTE20U20_1_10	7,545	297	4,499	395.39	5.0E-01	0.35345	0.00100	0.35545
cvTE20U20_1_9	7,545	297	3,599	316.31	4.0E-01	0.33290	0.00098	0.33486
cvTE20U20_1_8	7,545	297	2,700	237.23	3.0E-01	0.31513	0.00103	0.31719
cvTE20U20_1_7	7,545	297	1,800	158.16	2.0E-01	0.30148	0.00101	0.30350
cvTE20U20_1_6	7,545	297	900	79.08	1.0E-01	0.29354	0.00089	0.29532
cvTE20U20_1_1	7,545	297	0	0.00	1.0E-20	0.29227	0.00083	0.29392
12 wt % U								
cvTE20U12_1_15	7,125	168	8,998	1397.90	1.0E+00	0.44948	0.00108	0.45163
cvTE20U12_1_14	7,125	168	8,098	1258.10	9.0E-01	0.43067	0.00106	0.43280
cvTE20U12_1_13	7,125	168	7,199	1118.30	8.0E-01	0.40699	0.00098	0.40894
cvTE20U12_1_12	7,125	168	6,299	978.59	7.0E-01	0.38549	0.00098	0.38744
cvTE20U12_1_11	7,125	168	5,399	838.79	6.0E-01	0.36416	0.00089	0.36595
cvTE20U12_1_10	7,125	168	4,499	698.99	5.0E-01	0.34375	0.00106	0.34586
cvTE20U12_1_9	7,125	168	3,599	559.19	4.0E-01	0.32505	0.00108	0.32721
cvTE20U12_1_8	7,125	168	2,700	419.40	3.0E-01	0.30767	0.00087	0.30940
cvTE20U12_1_7	7,125	168	1,800	279.60	2.0E-01	0.29545	0.00076	0.29698

Table 6.9.6-19c. Results for $UZrH_x$ content uranium weight fraction in CV calculation model

Case	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
cvTE20U12_1_6	7,125	168	900	139.80	1.0E-01	0.28602	0.00086	0.28774
cvTE20U12_1_1	7,125	168	0	0.00	1.0E-20	0.28442	0.00079	0.28601
8.5 wt % U								
cvTE20U8p5_1_15	6,953	117	8,998	2007.30	1.0E+00	0.44412	0.00115	0.44643
cvTE20U8p5_1_14	6,953	117	8,098	1806.60	9.0E-01	0.42328	0.00110	0.42549
cvTE20U8p5_1_13	6,953	117	7,199	1605.80	8.0E-01	0.40452	0.00100	0.40652
cvTE20U8p5_1_12	6,953	117	6,299	1405.10	7.0E-01	0.38253	0.00122	0.38496
cvTE20U8p5_1_11	6,953	117	5,399	1204.40	6.0E-01	0.35988	0.00111	0.36209
cvTE20U8p5_1_10	6,953	117	4,499	1003.60	5.0E-01	0.33974	0.00099	0.34173
cvTE20U8p5_1_9	6,953	117	3,599	802.94	4.0E-01	0.31938	0.00090	0.32118
cvTE20U8p5_1_8	6,953	117	2,700	602.20	3.0E-01	0.30560	0.00084	0.30729
cvTE20U8p5_1_7	6,953	117	1,800	401.47	2.0E-01	0.29237	0.00085	0.29407
cvTE20U8p5_1_6	6,953	117	900	200.73	1.0E-01	0.28287	0.00104	0.28495
cvTE20U8p5_1_1	6,953	117	0	0.00	1.0E-20	0.28060	0.00080	0.28219
500 g CH_2 in cc, can spacers (np thickness = 1.4 in.), containment vessel, reflected								
cvTE20U45_02_15	10,400	921	8,385	237.62	1.0E+00	0.42157	0.00099	0.42354
cvTE20U30_02_15	8,250	489	8,385	447.54	1.0E+00	0.37862	0.00092	0.38046
cvTE20U20_02_15	7,545	297	8,385	736.86	1.0E+00	0.36052	0.00089	0.36229
cvTE20U12_02_15	7,125	168	8,385	1302.60	1.0E+00	0.35193	0.00100	0.35392
cvTE20U8p5_02_15	6,953	117	8,385	1870.40	1.0E+00	0.34847	0.00108	0.35064

Table 6.9.6-20a. Results for $UZrH_x$ content at 19.7 wt % ^{235}U in packaging calculation model

Case	np (in.)	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR/ MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded containment vessel, single package reflected													
NCT										**HAC**			
no can spacers (np thickness = 0.0 in.)													
						MOCFR							
ncsrtriga_1_1_15	0.0	10,400	921	0	0.00	1.0E-20	0.19699	0.00072	0.19844	hcsrtriga_1_1_15	0.19912	0.00071	0.20055
ncsrtriga_1_6_15	0.0	10,400	921	900	25.50	1.0E-01	0.22100	0.00077	0.22253	hcsrtriga_1_6_15	0.22405	0.00077	0.22559
ncsrtriga_1_7_15	0.0	10,400	921	1,800	51.00	2.0E-02	0.25006	0.00081	0.25167	hcsrtriga_1_7_15	0.25119	0.00075	0.25268
ncsrtriga_1_8_15	0.0	10,400	921	2,700	76.50	3.0E-01	0.27901	0.00083	0.28067	hcsrtriga_1_8_15	0.28071	0.00086	0.28243
ncsrtriga_1_9_15	0.0	10,400	921	3,599	102.00	4.0E-01	0.31206	0.00097	0.31399	hcsrtriga_1_9_15	0.31333	0.00093	0.31520
ncsrtriga_1_10_15	0.0	10,400	921	4,499	127.50	5.0E-01	0.34408	0.00096	0.34601	hcsrtriga_1_10_15	0.34576	0.00103	0.34781
ncsrtriga_1_11_15	0.0	10,400	921	5,399	153.00	6.0E-01	0.37488	0.00093	0.37674	hcsrtriga_1_11_15	0.37800	0.00111	0.38023
ncsrtriga_1_12_15	0.0	10,400	921	6,299	178.50	7.0E-01	0.40792	0.00107	0.41006	hcsrtriga_1_12_15	0.40683	0.00105	0.40893
ncsrtriga_1_13_15	0.0	10,400	921	7,199	204.00	8.0E-01	0.43782	0.00116	0.44013	hcsrtriga_1_13_15	0.43867	0.00123	0.44113
ncsrtriga_1_14_15	0.0	10,400	921	8,098	229.51	9.0E-01	0.46460	0.00106	0.46672	hcsrtriga_1_14_15	0.46627	0.00120	0.46867
ncsrtriga_1_15_15	0.0	10,400	921	8,998	255.01	1.0E+00	0.49295	0.00104	0.49503	hcsrtriga_1_15_15	0.49247	0.00103	0.49454
ncsrtriga_1_15_15(n)	0.0	10,400	921	8,998	255.01	1.0E+00	0.49330	0.00061	0.49452	hcsrtriga_1_15_15(n)	0.49431	0.00063	0.49557
ncsrtrigap_1_15_15	0.0	10,400	921	8,998	255.01	1.0E+00	0.50474	0.00057	0.50588	hcsrtrigap_1_15_15	0.50541	0.00074	0.50689
						MOIFR							
ncsrtriga_1_15_1	0.0	10,400	921	8,998	255.01	1.0E-20	0.44499	0.00100	0.44700	hcsrtriga_1_15_1	0.44706	0.00104	0.44914
ncsrtriga_1_15_2	0.0	10,400	921	8,998	255.01	1.0E-05	0.44282	0.00109	0.44500	hcsrtriga_1_15_2	0.44626	0.00100	0.44825
ncsrtriga_1_15_3	0.0	10,400	921	8,998	255.01	1.0E-04	0.44454	0.00120	0.44693	hcsrtriga_1_15_3	0.44469	0.00125	0.44719
ncsrtriga_1_15_4	0.0	10,400	921	8,998	255.01	1.0E-03	0.44553	0.00111	0.44774	hcsrtriga_1_15_4	0.44692	0.00113	0.44918
ncsrtriga_1_15_5	0.0	10,400	921	8,998	255.01	1.0E-02	0.44389	0.00121	0.44631	hcsrtriga_1_15_5	0.44565	0.00104	0.44773
ncsrtriga_1_15_6	0.0	10,400	921	8,998	255.01	1.0E-01	0.44801	0.00104	0.45008	hcsrtriga_1_15_6	0.45115	0.00120	0.45356
ncsrtriga_1_15_8	0.0	10,400	921	8,998	255.01	3.0E-01	0.45921	0.00143	0.46207	hcsrtriga_1_15_8	0.46090	0.00112	0.46314

Table 6.9.6-20a. Results for $UZrH_x$ content at 19.7 wt % ^{235}U in packaging calculation model

Case	np (in.)	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR/ MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsrtriga_1_15_15	0.0	10,400	921	8,998	255.01	1.0E+00	0.49295	0.00104	0.49503	hcsrtriga_1_15_15	0.49247	0.00103	0.49454
with can spacers (np thickness = 1.4 in.)													
						MOCFR							
ncsrtriga_2_1_15	1.4	10,400	921	0	0.00	1.0E-20	0.16519	0.00060	0.16640	hcsrtriga_2_1_15	0.16449	0.00062	0.16573
ncsrtriga_2_6_15	1.4	10,400	921	839	23.76	1.0E-01	0.18078	0.00063	0.18204	hcsrtriga_2_6_15	0.18163	0.00061	0.18284
ncsrtriga_2_7_15	1.4	10,400	921	1,677	47.52	2.0E-01	0.20001	0.00066	0.20133	hcsrtriga_2_7_15	0.20112	0.00072	0.20256
ncsrtriga_2_8_15	1.4	10,400	921	2,515	71.29	3.0E-01	0.22235	0.00085	0.22405	hcsrtriga_2_8_15	0.22446	0.00079	0.22603
ncsrtriga_2_9_15	1.4	10,400	921	3,354	95.05	4.0E-01	0.24785	0.00076	0.24936	hcsrtriga_2_9_15	0.24932	0.00079	0.25090
ncsrtriga_2_10_15	1.4	10,400	921	4,192	118.81	5.0E-01	0.27336	0.00091	0.27517	hcsrtriga_2_10_15	0.27427	0.00084	0.27595
ncsrtriga_2_11_15	1.4	10,400	921	5,031	142.57	6.0E-01	0.29864	0.00105	0.30075	hcsrtriga_2_11_15	0.30007	0.00090	0.30188
ncsrtriga_2_12_15	1.4	10,400	921	5,869	166.33	7.0E-01	0.32492	0.00094	0.32680	hcsrtriga_2_12_15	0.32594	0.00113	0.32820
ncsrtriga_2_13_15	1.4	10,400	921	6,708	190.09	8.0E-01	0.35137	0.00101	0.35339	hcsrtriga_2_13_15	0.35174	0.00101	0.35375
ncsrtriga_2_14_15	1.4	10,400	921	7,546	213.86	9.0E-01	0.37602	0.00105	0.37812	hcsrtriga_2_14_15	0.37666	0.00093	0.37852
ncsrtriga_2_15_15	1.4	10,400	921	8,385	237.62	1.0E+00	0.40040	0.00106	0.40252	hcsrtriga_2_15_15	0.40020	0.00112	0.40244
						MOIFR							
ncsrtriga_2_15_1	1.4	10,400	921	8,385	237.62	1.0E-20	0.36082	0.00102	0.36286	hcsrtriga_2_15_1	0.36370	0.00103	0.36576
ncsrtriga_2_15_2	1.4	10,400	921	8,385	237.62	1.0E-05	0.36163	0.00105	0.36373	hcsrtriga_2_15_2	0.36457	0.00097	0.36651
ncsrtriga_2_15_3	1.4	10,400	921	8,385	237.62	1.0E-04	0.36349	0.00115	0.36579	hcsrtriga_2_15_3	0.36369	0.00107	0.36584
ncsrtriga_2_15_4	1.4	10,400	921	8,385	237.62	1.0E-03	0.36368	0.00093	0.36554	hcsrtriga_2_15_4	0.36290	0.00107	0.36503
ncsrtriga_2_15_5	1.4	10,400	921	8,385	237.62	1.0E-02	0.36298	0.00111	0.36520	hcsrtriga_2_15_5	0.36275	0.00112	0.36498
ncsrtriga_2_15_6	1.4	10,400	921	8,385	237.62	1.0E-01	0.36587	0.00090	0.36766	hcsrtriga_2_15_6	0.37015	0.00095	0.37205
ncsrtriga_2_15_8	1.4	10,400	921	8,385	237.62	3.0E-01	0.37454	0.00104	0.37662	hcsrtriga_2_15_8	0.37482	0.00099	0.37680
ncsrtriga_2_15_15	1.4	10,400	921	8,385	237.62	1.0E+00	0.40040	0.00106	0.40252	hcsrtriga_2_15_15	0.40020	0.00112	0.40244

Table 6.9.6-20a. Results for $UZrH_x$ content at 19.7 wt % ^{235}U in packaging calculation model

Case	np (in.)	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR/ MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded containment vessel, array packaging model for CSI=0.0													
NCT										**HAC**			
no can spacers (np thickness = 0.0 in.)													
						MOIFR							
nciatriga_1_1_3	0.0	10,400	921	0	0.00	1.0E-04	0.21653	0.00055	0.21763	hciatriga_1_1_3	0.21640	0.00062	0.21763
nciatriga_1_6_3	0.0	10,400	921	900	25.50	1.0E-04	0.24325	0.00064	0.24453	hciatriga_1_6_3	0.24355	0.00069	0.24493
nciatriga_1_7_3	0.0	10,400	921	1,800	51.00	1.0E-04	0.27402	0.00079	0.27561	hciatriga_1_7_3	0.27398	0.00073	0.27544
nciatriga_1_8_3	0.0	10,400	921	2,700	76.50	1.0E-04	0.30790	0.00105	0.30999	hciatriga_1_8_3	0.30795	0.00081	0.30958
nciatriga_1_9_3	0.0	10,400	921	3,599	102.00	1.0E-04	0.34171	0.00109	0.34390	hciatriga_1_9_3	0.34285	0.00108	0.34500
nciatriga_1_10_3	0.0	10,400	921	4,499	127.50	1.0E-04	0.37614	0.00108	0.37830	hciatriga_1_10_3	0.37487	0.00101	0.37689
nciatriga_1_11_3	0.0	10,400	921	5,399	153.00	1.0E-04	0.40944	0.00101	0.41146	hciatriga_1_11_3	0.40922	0.00099	0.41120
nciatriga_1_12_3	0.0	10,400	921	6,299	178.50	1.0E-04	0.44034	0.00116	0.44267	hciatriga_1_12_3	0.44217	0.00104	0.44426
nciatriga_1_13_3	0.0	10,400	921	7,199	204.00	1.0E-04	0.46949	0.00102	0.47153	hciatriga_1_13_3	0.46841	0.00104	0.47049
nciatriga_1_14_3	0.0	10,400	921	8,098	229.51	1.0E-04	0.49678	0.00102	0.49881	hciatriga_1_14_3	0.49952	0.00113	0.50179
nciatriga_1_15_3	0.0	10,400	921	8,998	255.01	1.0E-04	0.52325	0.00109	0.52543	hciatriga_1_15_3	0.52373	0.00117	0.52606
nciatriga_1_15_3(n)	0.0	10,400	921	8,998	255.01	1.0E-04	0.54514	0.00064	0.54642	hciatriga_1_15_3(n)	0.52553	0.00061	0.52675
nciatrigap_1_15_3	0.0	10,400	921	8,998	255.01	1.0E-04	0.53671	0.00059	0.53789	hciatrigap_1_15_3	0.53602	0.00069	0.53740
with can spacers (np thickness = 1.4 in.)													
nciatriga_2_1_3	1.4	10,400	921	0	0.00	1.0E-04	0.19663	0.00056	0.19775	hciatriga_2_1_3	0.19533	0.00058	0.19648
nciatriga_2_6_3	1.4	10,400	921	839	23.76	1.0E-04	0.21458	0.00063	0.21583	hciatriga_2_6_3	0.21404	0.00062	0.21528
nciatriga_2_7_3	1.4	10,400	921	1,677	47.52	1.0E-04	0.23878	0.00069	0.24017	hciatriga_2_7_3	0.23939	0.00065	0.24068
nciatriga_2_8_3	1.4	10,400	921	2,515	71.29	1.0E-04	0.26268	0.00095	0.26458	hciatriga_2_8_3	0.26265	0.00073	0.26410
nciatriga_2_9_3	1.4	10,400	921	3,354	95.05	1.0E-04	0.28930	0.00075	0.29081	hciatriga_2_9_3	0.29016	0.00077	0.29169
nciatriga_2_10_3	1.4	10,400	921	4,192	118.81	1.0E-04	0.31695	0.00092	0.31879	hciatriga_2_10_3	0.31775	0.00088	0.31951
nciatriga_2_11_3	1.4	10,400	921	5,031	142.57	1.0E-04	0.34183	0.00090	0.34364	hciatriga_2_11_3	0.34164	0.00096	0.34355

Table 6.9.6-20a. Results for $UZrH_x$ content at 19.7 wt % ^{235}U in packaging calculation model

Case	np (in.)	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR/ MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciatriga_2_12_3	1.4	10,400	921	5,869	166.33	1.0E-04	0.36766	0.00092	0.36949	hciatriga_2_12_3	0.36733	0.00102	0.36937
nciatriga_2_13_3	1.4	10,400	921	6,708	190.09	1.0E-04	0.39176	0.00122	0.39420	hciatriga_2_13_3	0.39342	0.00103	0.39547
nciatriga_2_14_3	1.4	10,400	921	7,546	213.86	1.0E-04	0.41783	0.00101	0.41986	hciatriga_2_14_3	0.41760	0.00108	0.41976
nciatriga_2_15_3	1.4	10,400	921	8,385	237.62	1.0E-04	0.43993	0.00109	0.44211	hciatriga_2_15_3	0.44034	0.00119	0.44271
nciatriga_2_15_3(n)	1.4	10,400	921	8,385	237.62	1.0E-04	0.44062	0.00056	0.44174	hciatriga_2_15_3(n)	0.44070	0.00067	0.44204
nciatrigap_2_15_3	1.4	10,400	921	8,385	237.62	1.0E-04	0.45166	0.00057	0.45280	hciatrigap_2_15_3	0.45229	0.00054	0.45337

Table 6.9.6-20b. Results for $UZrH_x$ content at 70.1 wt % ^{235}U in packaging calculation model

Case	np (in.)	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR/ MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
content in flooded containment vessel, single package reflected													
NCT										**HAC**			
no can spacers (np thickness = 0.0 in.)													
						MOIFR							
ncsrtriga70_1_1_15	0.0	6,847	408	0	0.00	1.0E+00	0.15814	0.00073	0.15960	hcsrtriga70_1_1_15	0.15823	0.00062	0.15947
ncsrtriga70_1_6_15	0.0	6,847	408	900	57.56	1.0E+00	0.18268	0.00068	0.18403	hcsrtriga70_1_6_15	0.18526	0.00075	0.18676
ncsrtriga70_1_7_15	0.0	6,847	408	1,800	115.13	1.0E+00	0.21248	0.00074	0.21396	hcsrtriga70_1_7_15	0.21376	0.00082	0.21540
ncsrtriga70_1_8_15	0.0	6,847	408	2,700	172.69	1.0E+00	0.24596	0.00086	0.24769	hcsrtriga70_1_8_15	0.24666	0.00081	0.24829
ncsrtriga70_1_9_15	0.0	6,847	408	3,599	230.26	1.0E+00	0.27756	0.00103	0.27963	hcsrtriga70_1_9_15	0.27837	0.00085	0.28007
ncsrtriga70_1_10_15	0.0	6,847	408	4,499	287.82	1.0E+00	0.30903	0.00102	0.31107	hcsrtriga70_1_10_15	0.31172	0.00101	0.31374
ncsrtriga70_1_11_15	0.0	6,847	408	5,399	345.38	1.0E+00	0.34331	0.00121	0.34573	hcsrtriga70_1_11_15	0.34406	0.00110	0.34626
ncsrtriga70_1_12_15	0.0	6,847	408	6,299	402.95	1.0E+00	0.37320	0.00129	0.37578	hcsrtriga70_1_12_15	0.37419	0.00109	0.37637
ncsrtriga70_1_13_15	0.0	6,847	408	7,199	460.51	1.0E+00	0.40369	0.00106	0.40581	hcsrtriga70_1_13_15	0.40592	0.00110	0.40811

Table 6.9.6-20b. Results for $UZrH_x$ content at 70.1 wt % ^{235}U in packaging calculation model

Case	np (in.)	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR/ MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsrtriga70_1_14_15	0.0	6,847	408	8,098	518.07	1.0E+00	0.43096	0.00129	0.43353	hcsrtriga70_1_14_15	0.42993	0.00109	0.43212
ncsrtriga70_1_15_15	0.0	6,847	408	8,998	575.64	1.0E+00	0.45846	0.00117	0.46080	hcsrtriga70_1_15_15	0.45656	0.00108	0.45872
ncsrtriga70_1_15_15(n)	0.0	6,847	408	8,998	575.64	1.0E+00	0.45779	0.00068	0.45915	hcsrtriga70_1_15_15(n)	0.45831	0.00059	0.45949
ncsrtriga70p_1_15_15	0.0	6,847	408	8,998	575.64	1.0E+00	0.46768	0.00061	0.46890	hcsrtriga70p_1_15_15	0.46890	0.00060	0.47010
						MOIFR							
ncsrtriga70_1_15_1	0.0	6,847	408	8,998	575.64	1.0E-20	0.40894	0.00119	0.41131	hcsrtriga70_1_15_1_	0.41076	0.00122	0.41320
ncsrtriga70_1_15_2	0.0	6,847	408	8,998	575.64	1.0E-05	0.40806	0.00115	0.41036	hcsrtriga70_1_15_2	0.41073	0.00130	0.41332
ncsrtriga70_1_15_3	0.0	6,847	408	8,998	575.64	1.0E-04	0.40992	0.00118	0.41228	hcsrtriga70_1_15_3	0.41080	0.00120	0.41319
ncsrtriga70_1_15_4	0.0	6,847	408	8,998	575.64	1.0E-03	0.41084	0.00110	0.41304	hcsrtriga70_1_15_4	0.41181	0.00115	0.41412
ncsrtriga70_1_15_5	0.0	6,847	408	8,998	575.64	1.0E-02	0.41069	0.00116	0.41300	hcsrtriga70_1_15_5	0.41159	0.00124	0.41407
ncsrtriga70_1_15_6	0.0	6,847	408	8,998	575.64	1.0E-01	0.41431	0.00107	0.41644	hcsrtriga70_1_15_6	0.41621	0.00123	0.41868
ncsrtriga70_1_15_8	0.0	6,847	408	8,998	575.64	3.0E-01	0.42523	0.00129	0.42780	hcsrtriga70_1_15_8	0.42893	0.00120	0.43133
ncsrtriga70_1_15_15	0.0	6,847	408	8,998	575.64	1.0E+00	0.45846	0.00117	0.46080	hcsrtriga70_1_15_15	0.45656	0.00108	0.45872
with can spacers (np thickness = 1.4 in.)													
						MOIFR							
ncsrtriga70_2_1_15	1.4	6,847	408	0	0.00	1.0E+00	0.12174	0.00059	0.12291	hcsrtriga70_2_1_15	0.12413	0.00057	0.12528
ncsrtriga70_2_6_15	1.4	6,847	408	839	53.64	1.0E+00	0.14017	0.00063	0.14143	hcsrtriga70_2_6_15	0.14097	0.00061	0.14220
ncsrtriga70_2_7_15	1.4	6,847	408	1,677	107.28	1.0E+00	0.16109	0.00066	0.16241	hcsrtriga70_2_7_15	0.16260	0.00068	0.16396
ncsrtriga70_2_8_15	1.4	6,847	408	2,515	160.92	1.0E+00	0.18174	0.00080	0.18335	hcsrtriga70_2_8_15	0.18552	0.00067	0.18686
ncsrtriga70_2_9_15	1.4	6,847	408	3,354	214.55	1.0E+00	0.20707	0.00076	0.20859	hcsrtriga70_2_9_15	0.20911	0.00077	0.21064
ncsrtriga70_2_10_15	1.4	6,847	408	4,192	268.19	1.0E+00	0.23324	0.00089	0.23503	hcsrtriga70_2_10_15	0.23447	0.00074	0.23595
ncsrtriga70_2_11_15	1.4	6,847	408	5,031	321.83	1.0E+00	0.26093	0.00080	0.26254	hcsrtriga70_2_11_15	0.26039	0.00085	0.26209
ncsrtriga70_2_12_15	1.4	6,847	408	5,869	375.47	1.0E+00	0.28710	0.00084	0.28878	hcsrtriga70_2_12_15	0.28784	0.00093	0.28970
ncsrtriga70_2_13_15	1.4	6,847	408	6,708	429.11	1.0E+00	0.30929	0.00098	0.31124	hcsrtriga70_2_13_15	0.31105	0.00093	0.31291
ncsrtriga70_2_14_15	1.4	6,847	408	7,546	482.75	1.0E+00	0.33473	0.00114	0.33702	hcsrtriga70_2_14_15	0.33634	0.00094	0.33822

Table 6.9.6-20b. Results for $UZrH_x$ content at 70.1 wt % ^{235}U in packaging calculation model

Case	np (in.)	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR/ MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
ncsrtriga70_2_15_15	1.4	6,847	408	8,385	536.39	1.0E+00	0.35776	0.00116	0.36008	hcsrtriga70_2_15_15	0.35922	0.00110	0.36142
						MOIFR							
ncsrtriga70_2_15_1	1.4	6,847	408	8,385	536.39	1.0E-20	0.32321	0.00094	0.32508	hcsrtriga70_2_15_1	0.32561	0.00106	0.32774
ncsrtriga70_2_15_2	1.4	6,847	408	8,385	536.39	1.0E-05	0.32283	0.00092	0.32467	hcsrtriga70_2_15_2	0.32441	0.00099	0.32639
ncsrtriga70_2_15_3	1.4	6,847	408	8,385	536.39	1.0E-04	0.32432	0.00088	0.32608	hcsrtriga70_2_15_3	0.32423	0.00102	0.32628
ncsrtriga70_2_15_4	1.4	6,847	408	8,385	536.39	1.0E-03	0.32279	0.00104	0.32488	hcsrtriga70_2_15_4	0.32600	0.00111	0.32822
ncsrtriga70_2_15_5	1.4	6,847	408	8,385	536.39	1.0E-02	0.32448	0.00105	0.32658	hcsrtriga70_2_15_5	0.32622	0.00093	0.32808
ncsrtriga70_2_15_6	1.4	6,847	408	8,385	536.39	1.0E-01	0.32871	0.00097	0.33065	hcsrtriga70_2_15_6	0.32929	0.00110	0.33150
ncsrtriga70_2_15_8	1.4	6,847	408	8,385	536.39	3.0E-01	0.33627	0.00091	0.33809	hcsrtriga70_2_15_8	0.33709	0.00106	0.33920
ncsrtriga70_2_15_15	1.4	6,847	408	8,385	536.39	1.0E+00	0.35776	0.00116	0.36008	hcsrtriga70_2_15_15	0.35922	0.00110	0.36142
content in flooded containment vessel, array packaging model for CSI=0.0													
NCT										**HAC**			
no can spacers (np thickness = 0.0 in.)													
						MOIFR							
nciatriga70_1_1_3	0.0	6,847	408	0	0.00	1.0E-04	0.16525	0.00063	0.16651	hciatriga70_1_1_3	0.16514	0.00067	0.16648
nciatriga70_1_6_3	0.0	6,847	408	900	57.56	1.0E-04	0.19360	0.00070	0.19500	hciatriga70_1_6_3	0.19280	0.00066	0.19411
nciatriga70_1_7_3	0.0	6,847	408	1,800	115.13	1.0E-04	0.22946	0.00076	0.23099	hciatriga70_1_7_3	0.23027	0.00076	0.23179
nciatriga70_1_8_3	0.0	6,847	408	2,700	172.69	1.0E-04	0.26461	0.00087	0.26635	hciatriga70_1_8_3	0.26463	0.00074	0.26612
nciatriga70_1_9_3	0.0	6,847	408	3,599	230.26	1.0E-04	0.30186	0.00095	0.30375	hciatriga70_1_9_3	0.30020	0.00084	0.30187
nciatriga70_1_10_3	0.0	6,847	408	4,499	287.82	1.0E-04	0.33608	0.00095	0.33798	hciatriga70_1_10_3	0.33776	0.00089	0.33954
nciatriga70_1_11_3	0.0	6,847	408	5,399	345.38	1.0E-04	0.37069	0.00105	0.37279	hciatriga70_1_11_3	0.37191	0.00104	0.37400
nciatriga70_1_12_3	0.0	6,847	408	6,299	402.95	1.0E-04	0.40431	0.00110	0.40651	hciatriga70_1_12_3	0.40368	0.00099	0.40567
nciatriga70_1_13_3	0.0	6,847	408	7,199	460.51	1.0E-04	0.43185	0.00143	0.43472	hciatriga70_1_13_3	0.43386	0.00141	0.43668
nciatriga70_1_14_3	0.0	6,847	408	8,098	518.07	1.0E-04	0.46029	0.00122	0.46272	hciatriga70_1_14_3	0.46036	0.00120	0.46277
nciatriga70_1_15_3	0.0	6,847	408	8,998	575.64	1.0E-04	0.48628	0.00123	0.48875	hciatriga70_1_15_3	0.48653	0.00107	0.48868

Table 6.9.6-20b. Results for $UZrH_x$ content at 70.1 wt % ^{235}U in packaging calculation model

Case	np (in.)	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR/ MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
nciatriga70_1_15_3(n)	0.0	6,847	408	8,998	575.64	1.0E-04	0.48635	0.00061	0.48757	hciatriga70_1_15_3(n)	0.48713	0.00058	0.48829
nciatriga70p_1_15_3	0.0	6,847	408	8,998	575.64	1.0E-04	0.49667	0.00062	0.49791	hciatriga70p_1_15_3	0.49812	0.00070	0.49952
with can spacers (np thickness = 1.4 in.)													
nciatriga70_2_1_3	1.4	6,847	408	0	0.00	1.0E-04	0.14342	0.00054	0.14450	hciatriga70_2_1_3	0.14299	0.00055	0.14410
nciatriga70_2_6_3	1.4	6,847	408	839	53.64	1.0E-04	0.16333	0.00057	0.16446	hciatriga70_2_6_3	0.16444	0.00071	0.16586
nciatriga70_2_7_3	1.4	6,847	408	1,677	107.28	1.0E-04	0.18886	0.00069	0.19024	hciatriga70_2_7_3	0.18870	0.00075	0.19020
nciatriga70_2_8_3	1.4	6,847	408	2,515	160.92	1.0E-04	0.21548	0.00077	0.21703	hciatriga70_2_8_3	0.21709	0.00079	0.21867
nciatriga70_2_9_3	1.4	6,847	408	3,354	214.55	1.0E-04	0.24403	0.00092	0.24587	hciatriga70_2_9_3	0.24443	0.00082	0.24606
nciatriga70_2_10_3	1.4	6,847	408	4,192	268.19	1.0E-04	0.27230	0.00090	0.27410	hciatriga70_2_10_3	0.27167	0.00077	0.27321
nciatriga70_2_11_3	1.4	6,847	408	5,031	321.83	1.0E-04	0.29818	0.00092	0.30003	hciatriga70_2_11_3	0.29902	0.00096	0.30093
nciatriga70_2_12_3	1.4	6,847	408	5,869	375.47	1.0E-04	0.32583	0.00081	0.32745	hciatriga70_2_12_3	0.32607	0.00087	0.32781
nciatriga70_2_13_3	1.4	6,847	408	6,708	429.11	1.0E-04	0.35008	0.00102	0.35212	hciatriga70_2_13_3	0.34964	0.00088	0.35140
nciatriga70_2_14_3	1.4	6,847	408	7,546	482.75	1.0E-04	0.37201	0.00116	0.37434	hciatriga70_2_14_3	0.37167	0.00099	0.37364
nciatriga70_2_15_3	1.4	6,847	408	8,385	536.39	1.0E-04	0.39529	0.00120	0.39769	hciatriga70_2_15_3	0.39403	0.00109	0.39622

Table 6.9.6-20c. Results for 1.31 in. smaller diameter $UZrH_x$ content at 70.1 wt % ^{235}U in packaging calculation model

Case	np (in.)	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR/ MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
1.31 in. diam content in flooded containment vessel, single package reflected									
NCT									
no can spacers (np thickness = 0.0 in.)									
						MOCFR			
ncsrT70_131_1_1_15	0.0	5,667	338	0	0.00	1.0E+00	0.12864	0.00055	0.12974
ncsrT70_131_1_6_15	0.0	5,667	338	920	71.15	1.0E+00	0.15144	0.00066	0.15276
ncsrT70_131_1_7_15	0.0	5,667	338	1,841	142.31	1.0E+00	0.18245	0.00065	0.18375
ncsrT70_131_1_8_15	0.0	5,667	338	2,762	213.46	1.0E+00	0.21360	0.00085	0.21530
ncsrT70_131_1_9_15	0.0	5,667	338	3,682	284.61	1.0E+00	0.24688	0.00096	0.24880
ncsrT70_131_1_10_15	0.0	5,667	338	4,602	355.77	1.0E+00	0.28138	0.00101	0.28340
ncsrT70_131_1_11_15	0.0	5,667	338	5,523	426.92	1.0E+00	0.31377	0.00098	0.31574
ncsrT70_131_1_12_15	0.0	5,667	338	6,443	498.07	1.0E+00	0.34582	0.00107	0.34797
ncsrT70_131_1_13_15	0.0	5,667	338	7,364	569.23	1.0E+00	0.37661	0.00103	0.37867
ncsrT70_131_1_14_15	0.0	5,667	338	8,284	640.38	1.0E+00	0.40376	0.00110	0.40597
ncsrT70_131_1_15_15	0.0	5,667	338	9,205	711.53	1.0E+00	0.43000	0.00103	0.43206
						MOIFR			
ncsrT70_131_1_15_1	0.0	5,667	338	9,205	711.53	1.0E-20	0.38521	0.00136	0.38793
ncsrT70_131_1_15_2	0.0	5,667	338	9,205	711.53	1.0E-05	0.38339	0.00098	0.38536
ncsrT70_131_1_15_3	0.0	5,667	338	9,205	711.53	1.0E-04	0.38633	0.00100	0.38834
ncsrT70_131_1_15_4	0.0	5,667	338	9,205	711.53	1.0E-03	0.38417	0.00096	0.38610
ncsrT70_131_1_15_5	0.0	5,667	338	9,205	711.53	1.0E-02	0.38613	0.00108	0.38829
ncsrT70_131_1_15_6	0.0	5,667	338	9,205	711.53	1.0E-01	0.39026	0.00098	0.39222
ncsrT70_131_1_15_8	0.0	5,667	338	9,205	711.53	3.0E-01	0.40187	0.00122	0.40430
ncsrT70_131_1_15_15	0.0	5,667	338	9,205	711.53	1.0E+00	0.43000	0.00103	0.43206

Table 6.9.6-20c. Results for 1.31 in. smaller diameter $UZrH_x$ content at 70.1 wt % ^{235}U in packaging calculation model

Case	np (in.)	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR/ MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
1.31 in. diam content content in flooded containment vessel, array packaging model for CSI=0.0									
NCT									
no can spacers (np thickness = 0.0 in.)									
						MOIFR			
nciaT70_131_1_1_3	0.0	5,667	338	0	0.00	1.0E-04	0.12954	0.00047	0.13048
nciaT70_131_1_6_3	0.0	5,667	338	920	71.15	1.0E-04	0.15804	0.00057	0.15918
nciaT70_131_1_7_3	0.0	5,667	338	1,841	142.31	1.0E-04	0.19290	0.00064	0.19417
nciaT70_131_1_8_3	0.0	5,667	338	2,762	213.46	1.0E-04	0.22844	0.00085	0.23015
nciaT70_131_1_9_3	0.0	5,667	338	3,682	284.61	1.0E-04	0.26752	0.00081	0.26914
nciaT70_131_1_10_3	0.0	5,667	338	4,602	355.77	1.0E-04	0.30500	0.00096	0.30692
nciaT70_131_1_11_3	0.0	5,667	338	5,523	426.92	1.0E-04	0.33850	0.00107	0.34064
nciaT70_131_1_12_3	0.0	5,667	338	6,443	498.07	1.0E-04	0.37139	0.00102	0.37342
nciaT70_131_1_13_3	0.0	5,667	338	7,364	569.23	1.0E-04	0.40245	0.00098	0.40441
nciaT70_131_1_14_3	0.0	5,667	338	8,284	640.38	1.0E-04	0.43010	0.00115	0.43241
nciaT70_131_1_15_3	0.0	5,667	338	9,205	711.53	1.0E-04	0.45804	0.00122	0.46047

Table 6.9.6-20d. Results for 1.31 in. smaller diameter $UZrH_x$ content at 19.7 wt % ^{235}U in packaging calculation model

Case	np (in.)	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR/ MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
homogenized content in flooded containment vessel, single package reflected [10 CFR 71.55(d)(2)]									
NCT									
no can spacers (np thickness = 0.0 in.)									
						MOCFR			
ncsrt55d2_1_1_15	0.0	10,400	921	0	0.00	1.0E+00	0.11370	0.00054	0.11477
ncsrt55d2_1_6_15	0.0	10,400	921	900	25.50	1.0E+00	0.15074	0.00061	0.15196
ncsrt55d2_1_7_15	0.0	10,400	921	1,800	51.00	1.0E+00	0.19298	0.00070	0.19439
ncsrt55d2_1_8_15	0.0	10,400	921	2,700	76.50	1.0E+00	0.24182	0.00082	0.24346
ncsrt55d2_1_9_15	0.0	10,400	921	3,599	102.00	1.0E+00	0.29424	0.00084	0.29591
ncsrt55d2_1_10_15	0.0	10,400	921	4,499	127.50	1.0E+00	0.34858	0.00100	0.35059
ncsrt55d2_1_11_15	0.0	10,400	921	5,399	153.00	1.0E+00	0.40341	0.00119	0.40579
ncsrt55d2_1_12_15	0.0	10,400	921	6,299	178.50	1.0E+00	0.45802	0.00109	0.46020
ncsrt55d2_1_13_15	0.0	10,400	921	7,199	204.00	1.0E+00	0.51163	0.00121	0.51404
ncsrt55d2_1_14_15	0.0	10,400	921	8,098	229.51	1.0E+00	0.56264	0.00129	0.56521
ncsrt55d2_1_15_15	0.0	10,400	921	8,998	255.01	1.0E+00	0.60824	0.00136	0.61095
						MOIFR			
ncsrt55d2_1_15_15	0.0	10,400	921	8,998	255.01	1.0E+00	0.60824	0.00136	0.61095
ncsrt55d2_1_15_8	0.0	10,400	921	8,998	255.01	3.0E-01	0.55284	0.00122	0.55528
ncsrt55d2_1_15_6	0.0	10,400	921	8,998	255.01	1.0E-01	0.53397	0.00114	0.53626
ncsrt55d2_1_15_5	0.0	10,400	921	8,998	255.01	1.0E-02	0.52373	0.00115	0.52604
ncsrt55d2_1_15_4	0.0	10,400	921	8,998	255.01	1.0E-03	0.52361	0.00124	0.52609
ncsrt55d2_1_15_3	0.0	10,400	921	8,998	255.01	1.0E-04	0.52050	0.00116	0.52283
ncsrt55d2_1_15_2	0.0	10,400	921	8,998	255.01	1.0E-05	0.52366	0.00123	0.52611
ncsrt55d2_1_15_1	0.0	10,400	921	8,998	255.01	1.0E-20	0.52390	0.00120	0.52631

Table 6.9.6-20d. Results for 1.31 in. smaller diameter $UZrH_x$ content at 19.7 wt % ^{235}U in packaging calculation model

Case	np (in.)	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR/ MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
with can spacers (np thickness = 1.4 in.)									
						MOCFR			
ncsrt55d2_2_1_15	1.4	10,400	921	0	0.00	1.0E+00	0.10877	0.00048	0.10972
ncsrt55d2_2_6_15	1.4	10,400	921	839	23.76	1.0E+00	0.14519	0.00062	0.14643
ncsrt55d2_2_7_15	1.4	10,400	921	1,677	47.52	1.0E+00	0.18564	0.00082	0.18729
ncsrt55d2_2_8_15	1.4	10,400	921	2,515	71.29	1.0E+00	0.23269	0.00095	0.23459
ncsrt55d2_2_9_15	1.4	10,400	921	3,354	95.05	1.0E+00	0.28305	0.00082	0.28469
ncsrt55d2_2_10_15	1.4	10,400	921	4,192	118.81	1.0E+00	0.33734	0.00105	0.33944
ncsrt55d2_2_11_15	1.4	10,400	921	5,031	142.57	1.0E+00	0.39111	0.00128	0.39367
ncsrt55d2_2_12_15	1.4	10,400	921	5,869	166.33	1.0E+00	0.44324	0.00114	0.44553
ncsrt55d2_2_13_15	1.4	10,400	921	6,708	190.09	1.0E+00	0.49696	0.00128	0.49951
ncsrt55d2_2_14_15	1.4	10,400	921	7,546	213.86	1.0E+00	0.54756	0.00093	0.54942
ncsrt55d2_2_15_15	1.4	10,400	921	8,385	237.62	1.0E+00	0.59538	0.00144	0.59825
						MOIFR			
ncsrt55d2_2_15_15	1.4	10,400	921	8,385	237.62	1.0E+00	0.59538	0.00144	0.59825
ncsrt55d2_2_15_8	1.4	10,400	921	8,385	237.62	3.0E-01	0.53671	0.00112	0.53895
ncsrt55d2_2_15_6	1.4	10,400	921	8,385	237.62	1.0E-01	0.52002	0.00107	0.52217
ncsrt55d2_2_15_5	1.4	10,400	921	8,385	237.62	1.0E-02	0.50958	0.00123	0.51204
ncsrt55d2_2_15_4	1.4	10,400	921	8,385	237.62	1.0E-03	0.50803	0.00111	0.51024
ncsrt55d2_2_15_3	1.4	10,400	921	8,385	237.62	1.0E-04	0.50785	0.00116	0.51018
ncsrt55d2_2_15_2	1.4	10,400	921	8,385	237.62	1.0E-05	0.50851	0.00117	0.51086
ncsrt55d2_2_15_1	1.4	10,400	921	8,385	237.62	1.0E-20	0.50763	0.00113	0.50989

Table 6.9.6-20d. Results for 1.31 in. smaller diameter $UZrH_x$ content at 19.7 wt % ^{235}U in packaging calculation model

Case	np (in.)	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR/ MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
homogenized content in flooded containment vessel, array packaging model for CSI=0.0 [10 CFR 71.55(d)(2)]									
NCT									
no can spacers (np thickness = 0.0 in.)									
						MOIFR			
nciat55d2_1_1_3	0.0	10400	921	0	0.00	1.0E-04	0.13090	0.00039	0.13168
nciat55d2_1_6_3	0.0	10400	921	900	25.50	1.0E-04	0.18600	0.00056	0.18713
nciat55d2_1_7_3	0.0	10400	921	1,800	51.00	1.0E-04	0.24841	0.00078	0.24997
nciat55d2_1_8_3	0.0	10400	921	2,700	76.50	1.0E-04	0.31679	0.00074	0.31826
nciat55d2_1_9_3	0.0	10400	921	3,599	102.00	1.0E-04	0.38338	0.00097	0.38531
nciat55d2_1_10_3	0.0	10400	921	4,499	127.50	1.0E-04	0.44808	0.00093	0.44993
nciat55d2_1_11_3	0.0	10400	921	5,399	153.00	1.0E-04	0.51062	0.00096	0.51254
nciat55d2_1_12_3	0.0	10400	921	6,299	178.50	1.0E-04	0.56869	0.00104	0.57076
nciat55d2_1_13_3	0.0	10400	921	7,198	204.00	1.0E-04	0.62259	0.00112	0.62484
nciat55d2_1_14_3	0.0	10400	921	8,098	229.51	1.0E-04	0.67077	0.00100	0.67276
nciat55d2_1_15_3	0.0	10400	921	8,998	255.01	1.0E-04	0.71379	0.00131	0.71641
with can spacers (np thickness = 1.4 in.)									
nciat55d2_02_1_3	1.4	10400	921	0	0.00	1.0E-04	0.12620	0.00039	0.12697
nciat55d2_02_6_3	1.4	10400	921	838	23.76	1.0E-04	0.17224	0.00043	0.17310
nciat55d2_02_7_3	1.4	10400	921	1,677	47.52	1.0E-04	0.22779	0.00057	0.22894
nciat55d2_02_8_3	1.4	10400	921	2,515	71.29	1.0E-04	0.28723	0.00081	0.28884
nciat55d2_02_9_3	1.4	10400	921	3,354	95.05	1.0E-04	0.34934	0.00079	0.35091
nciat55d2_02_10_3	1.4	10400	921	4,192	118.81	1.0E-04	0.40899	0.00097	0.41094

Table 6.9.6-20d. Results for 1.31 in. smaller diameter $UZrH_x$ content at 19.7 wt % ^{235}U in packaging calculation model

Case	np (in.)	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR/ MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
nciat55d2_02_11_3	1.4	10400	921	5,031	142.57	1.0E-04	0.46775	0.00101	0.46977
nciat55d2_02_12_3	1.4	10400	921	5,869	166.33	1.0E-04	0.52454	0.00105	0.52664
nciat55d2_02_13_3	1.4	10400	921	6,708	190.09	1.0E-04	0.57561	0.00105	0.57771
nciat55d2_02_14_3	1.4	10400	921	7,546	213.86	1.0E-04	0.62437	0.00100	0.62637
nciat55d2_02_15_3	1.4	10400	921	8,385	237.62	1.0E-04	0.66968	0.00118	0.67203

Table 6.9.6-21. Results for solid HEU metal content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	Kaolite (g)	H_2O (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff}+2\sigma$
	core						shell							
compromised package, HEU-poly core in spherical configuration, 20.0 cm water reflector														
10,000 g HEU														
atdmr_10_8	10,000	500	na	na	1.68	6.3550	na	na	na	na	0.0703	0.84682	0.00132	0.84946
atdmr_10_7	9,500	500	na	na	1.77	6.3544	na	na	na	na	0.0708	0.82979	0.00121	0.83220
atdmr_10_6	9,000	500	na	na	1.86	6.3537	na	na	na	na	0.0704	0.81840	0.00105	0.82051
atdmr_10_5	8,000	500	na	na	2.10	6.3524	na	na	na	na	0.0705	0.79201	0.00116	0.79433
atdmr_10_4	7,000	500	na	na	2.40	6.3511	na	na	na	na	0.0706	0.76698	0.00108	0.76915
atdmr_10_3	6,000	500	na	na	2.80	6.3497	na	na	na	na	0.0713	0.73619	0.00111	0.73841
atdmr_10_2	4,000	500	na	na	4.19	6.3471	na	na	na	na	0.0715	0.67188	0.00126	0.67440
atdmr_10_1	1,900	500	na	na	8.83	6.3443	na	na	na	na	0.0718	0.58417	0.00103	0.58623
9,000 g HEU														
atdmr_9_8	9,000	500	na	na	1.86	6.2485	na	na	na	na	0.0710	0.82672	0.00113	0.82898
atdmr_9_7	8,550	500	na	na	1.96	6.2479	na	na	na	na	0.0716	0.81253	0.00143	0.81540
atdmr_9_6	8,100	500	na	na	2.07	6.2473	na	na	na	na	0.0712	0.80165	0.00110	0.80385

Table 6.9.6-21. Results for solid HEU metal content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	Kaolite (g)	H_2O (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
atdmr_9_5	7,200	500	na	na	2.33	6.2460	na	na	na	na	0.0710	0.77728	0.00120	0.77967
atdmr_9_4	6,300	500	na	na	2.66	6.2448	na	na	na	na	0.0716	0.75139	0.00124	0.75387
atdmr_9_3	5,400	500	na	na	3.11	6.2436	na	na	na	na	0.0724	0.72346	0.00126	0.72598
atdmr_9_2	3,600	500	na	na	4.66	6.2411	na	na	na	na	0.0724	0.65951	0.00101	0.66152
atdmr_9_1	1,710	500	na	na	9.81	6.2385	na	na	na	na	0.0734	0.57813	0.00106	0.58024
8,000 g HEU														
atdmr_8_8	8,000	500	na	na	2.10	6.1382	na	na	na	na	0.0718	0.80824	0.00110	0.81045
atdmr_8_7	7,600	500	na	na	2.21	6.1377	na	na	na	na	0.0724	0.79414	0.00125	0.79663
atdmr_8_6	7,200	500	na	na	2.33	6.1371	na	na	na	na	0.0722	0.78358	0.00124	0.78606
atdmr_8_5	6,400	500	na	na	2.62	6.1360	na	na	na	na	0.0723	0.76006	0.00119	0.76244
atdmr_8_4	5,600	500	na	na	2.99	6.1348	na	na	na	na	0.0719	0.73542	0.00116	0.73773
atdmr_8_3	4,800	500	na	na	3.49	6.1337	na	na	na	na	0.0726	0.70911	0.00113	0.71138
atdmr_8_2	3,200	500	na	na	5.24	6.1314	na	na	na	na	0.0733	0.65087	0.00120	0.65326
atdmr_8_1	1,520	500	na	na	11.03	6.1290	na	na	na	na	0.0731	0.57072	0.00116	0.57304
7,000 g HEU														
atdmr_7_8	7,000	500	na	na	2.40	6.0238	na	na	na	na	0.0732	0.78837	0.00130	0.79098
atdmr_7_7	6,650	500	na	na	2.52	6.0233	na	na	na	na	0.0727	0.77467	0.00108	0.77683
atdmr_7_6	6,300	500	na	na	2.66	6.0228	na	na	na	na	0.0735	0.76362	0.00120	0.76603
atdmr_7_5	5,600	500	na	na	2.99	6.0218	na	na	na	na	0.0735	0.74073	0.00115	0.74302
atdmr_7_4	4,900	500	na	na	3.42	6.0207	na	na	na	na	0.0731	0.71741	0.00120	0.71982
atdmr_7_3	4,200	500	na	na	3.99	6.0197	na	na	na	na	0.0740	0.69409	0.00108	0.69624
atdmr_7_2	2,800	500	na	na	5.99	6.0176	na	na	na	na	0.0735	0.63885	0.00113	0.64111
atdmr_7_1	1,330	500	na	na	12.61	6.0155	na	na	na	na	0.0745	0.56445	0.00108	0.56660

Table 6.9.6-21. Results for solid HEU metal content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	Kaolite (g)	H_2O (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
compromised package, HEU-poly core in spherical configuration, stainless steel shell, 20.0 cm water reflector														
7,000 g HEU 100% enrichment														
atdmsr_7_8_11	7,000	500	na	na	2.40	6.0238	na	na	66,133.1	13.0198	0.0297	0.76607	0.00120	0.76847
atdmsr_7_8_10	7,000	500	na	na	2.40	6.0238	na	na	59,519.8	12.6164	0.0313	0.76407	0.00104	0.76615
atdmsr_7_8_9	7,000	500	na	na	2.40	6.0238	na	na	52,906.5	12.1855	0.0329	0.76034	0.00112	0.76259
atdmsr_7_8_8	7,000	500	na	na	2.40	6.0238	na	na	46,293.2	11.7217	0.0348	0.75468	0.00126	0.75720
atdmsr_7_8_7	7,000	500	na	na	2.40	6.0238	na	na	39,679.9	11.2179	0.0370	0.75125	0.00130	0.75384
atdmsr_7_8_6	7,000	500	na	na	2.40	6.0238	na	na	33,066.6	10.6643	0.0396	0.74580	0.00123	0.74827
atdmsr_7_8_5	7,000	500	na	na	2.40	6.0238	na	na	26,453.3	10.0464	0.0428	0.73992	0.00122	0.74235
atdmsr_7_8_4	7,000	500	na	na	2.40	6.0238	na	na	19,839.9	9.3414	0.0464	0.73585	0.00164	0.73913
atdmsr_7_8_3	7,000	500	na	na	2.40	6.0238	na	na	13,226.6	8.5100	0.0517	0.73131	0.00121	0.73373
atdmsr_7_8_2	7,000	500	na	na	2.40	6.0238	na	na	6,613.3	7.4736	0.0594	0.73612	0.00125	0.73863
atdmsr_7_8_1	7,000	500	na	na	2.40	6.0238	na	na	0.0	6.0239	0.0730	0.78843	0.00113	0.79069
7,000 g HEU 95% enrichment														
atdmsr_7_7_11	6,650	500	na	na	2.52	6.0233	na	na	66,133.1	13.0197	0.0297	0.75217	0.00105	0.75427
atdmsr_7_7_10	6,650	500	na	na	2.52	6.0233	na	na	59,519.8	12.6163	0.0311	0.74832	0.00120	0.75072
atdmsr_7_7_9	6,650	500	na	na	2.52	6.0233	na	na	52,906.5	12.1854	0.0330	0.74504	0.00122	0.74749
atdmsr_7_7_8	6,650	500	na	na	2.52	6.0233	na	na	46,293.2	11.7215	0.0350	0.74113	0.00139	0.74391
atdmsr_7_7_7	6,650	500	na	na	2.52	6.0233	na	na	39,679.9	11.2178	0.0367	0.73518	0.00113	0.73745
atdmsr_7_7_6	6,650	500	na	na	2.52	6.0233	na	na	33,066.6	10.6642	0.0398	0.73061	0.00114	0.73289
atdmsr_7_7_5	6,650	500	na	na	2.52	6.0233	na	na	26,453.3	10.0462	0.0424	0.72581	0.00115	0.72811
atdmsr_7_7_4	6,650	500	na	na	2.52	6.0233	na	na	19,839.9	9.3412	0.0465	0.72114	0.00114	0.72341
atdmsr_7_7_3	6,650	500	na	na	2.52	6.0233	na	na	13,226.6	8.5097	0.0513	0.71750	0.00128	0.72006
atdmsr_7_7_2	6,650	500	na	na	2.52	6.0233	na	na	6,613.3	7.4733	0.0595	0.72179	0.00125	0.72429
atdmsr_7_7_1	6,650	500	na	na	2.52	6.0233	na	na	0.0	6.0234	0.0731	0.77710	0.00130	0.77970

Table 6.9.6-21. Results for solid HEU metal content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	Kaolite (g)	H_2O (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
7,000 g HEU 90% enrichment														
atdmsr_7_6_11	6,300	500	na	na	2.66	6.0228	na	na	66,133.1	13.0196	0.0300	0.73788	0.00105	0.73999
atdmsr_7_6_10	6,300	500	na	na	2.66	6.0228	na	na	59,519.8	12.6162	0.0308	0.73548	0.00108	0.73763
atdmsr_7_6_9	6,300	500	na	na	2.66	6.0228	na	na	52,906.5	12.1852	0.0327	0.73014	0.00125	0.73263
atdmsr_7_6_8	6,300	500	na	na	2.66	6.0228	na	na	46,293.2	11.7214	0.0349	0.72624	0.00124	0.72873
atdmsr_7_6_7	6,300	500	na	na	2.66	6.0228	na	na	39,679.9	11.2176	0.0371	0.72341	0.00126	0.72594
atdmsr_7_6_6	6,300	500	na	na	2.66	6.0228	na	na	33,066.6	10.6640	0.0393	0.71807	0.00109	0.72025
atdmsr_7_6_5	6,300	500	na	na	2.66	6.0228	na	na	26,453.3	10.0460	0.0423	0.71292	0.00108	0.71507
atdmsr_7_6_4	6,300	500	na	na	2.66	6.0228	na	na	19,839.9	9.3409	0.0462	0.70851	0.00126	0.71103
atdmsr_7_6_3	6,300	500	na	na	2.66	6.0228	na	na	13,226.6	8.5095	0.0515	0.70125	0.00118	0.70361
atdmsr_7_6_2	6,300	500	na	na	2.66	6.0228	na	na	6,613.3	7.4730	0.0595	0.70829	0.00122	0.71074
atdmsr_7_6_1	6,300	500	na	na	2.66	6.0228	na	na	0.0	6.0229	0.0731	0.76522	0.00130	0.76782
7,000 g HEU 80% enrichment														
atdmsr_7_5_11	5,600	500	na	na	2.99	6.0218	na	na	66,133.1	13.0194	0.0300	0.70826	0.00130	0.71086
atdmsr_7_5_10	5,600	500	na	na	2.99	6.0218	na	na	59,519.8	12.6160	0.0313	0.70615	0.00122	0.70860
atdmsr_7_5_9	5,600	500	na	na	2.99	6.0218	na	na	52,906.5	12.1850	0.0332	0.70259	0.00104	0.70468
atdmsr_7_5_8	5,600	500	na	na	2.99	6.0218	na	na	46,293.2	11.7211	0.0351	0.69758	0.00113	0.69985
atdmsr_7_5_7	5,600	500	na	na	2.99	6.0218	na	na	39,679.9	11.2173	0.0371	0.69312	0.00126	0.69564
atdmsr_7_5_6	5,600	500	na	na	2.99	6.0218	na	na	33,066.6	10.6637	0.0394	0.69094	0.00100	0.69295
atdmsr_7_5_5	5,600	500	na	na	2.99	6.0218	na	na	26,453.3	10.0457	0.0430	0.68484	0.00109	0.68701
atdmsr_7_5_4	5,600	500	na	na	2.99	6.0218	na	na	19,839.9	9.3405	0.0467	0.67851	0.00126	0.68102
atdmsr_7_5_3	5,600	500	na	na	2.99	6.0218	na	na	13,226.6	8.5089	0.0520	0.67622	0.00128	0.67878
atdmsr_7_5_2	5,600	500	na	na	2.99	6.0218	na	na	6,613.3	7.4723	0.0596	0.68260	0.00122	0.68505
atdmsr_7_5_1	5,600	500	na	na	2.99	6.0218	na	na	0.0	6.0219	0.0729	0.74067	0.00120	0.74307

Table 6.9.6-21. Results for solid HEU metal content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	Kaolite (g)	H_2O (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
7,000 g HEU 70% enrichment														
atdmsr_7_4_11	4,900	500	na	na	3.42	6.0207	na	na	66,133.1	13.0192	0.0298	0.67942	0.00111	0.68164
atdmsr_7_4_10	4,900	500	na	na	3.42	6.0207	na	na	59,519.8	12.6157	0.0315	0.67468	0.00108	0.67683
atdmsr_7_4_9	4,900	500	na	na	3.42	6.0207	na	na	52,906.5	12.1847	0.0329	0.67332	0.00107	0.67547
atdmsr_7_4_8	4,900	500	na	na	3.42	6.0207	na	na	46,293.2	11.7208	0.0344	0.66696	0.00109	0.66915
atdmsr_7_4_7	4,900	500	na	na	3.42	6.0207	na	na	39,679.9	11.2170	0.0371	0.66405	0.00102	0.66610
atdmsr_7_4_6	4,900	500	na	na	3.42	6.0207	na	na	33,066.6	10.6633	0.0396	0.65978	0.00133	0.66244
atdmsr_7_4_5	4,900	500	na	na	3.42	6.0207	na	na	26,453.3	10.0453	0.0430	0.65491	0.00111	0.65714
atdmsr_7_4_4	4,900	500	na	na	3.42	6.0207	na	na	19,839.9	9.3401	0.0461	0.65283	0.00115	0.65513
atdmsr_7_4_3	4,900	500	na	na	3.42	6.0207	na	na	13,226.6	8.5084	0.0519	0.64816	0.00119	0.65053
atdmsr_7_4_2	4,900	500	na	na	3.42	6.0207	na	na	6,613.3	7.4716	0.0592	0.65866	0.00129	0.66124
atdmsr_7_4_1	4,900	500	na	na	3.42	6.0207	na	na	0.0	6.0208	0.0735	0.71618	0.00119	0.71855
7,000 g HEU 60% enrichment														
atdmsr_7_3_11	4,200	500	na	na	3.99	6.0197	na	na	66,133.1	13.0189	0.0301	0.64937	0.00120	0.65177
atdmsr_7_3_10	4,200	500	na	na	3.99	6.0197	na	na	59,519.8	12.6155	0.0314	0.64512	0.00109	0.64731
atdmsr_7_3_9	4,200	500	na	na	3.99	6.0197	na	na	52,906.5	12.1845	0.0331	0.64112	0.00108	0.64328
atdmsr_7_3_8	4,200	500	na	na	3.99	6.0197	na	na	46,293.2	11.7206	0.0347	0.63750	0.00100	0.63951
atdmsr_7_3_7	4,200	500	na	na	3.99	6.0197	na	na	39,679.9	11.2167	0.0378	0.63266	0.00109	0.63483
atdmsr_7_3_6	4,200	500	na	na	3.99	6.0197	na	na	33,066.6	10.6630	0.0400	0.62892	0.00118	0.63129
atdmsr_7_3_5	4,200	500	na	na	3.99	6.0197	na	na	26,453.3	10.0449	0.0432	0.62395	0.00111	0.62617
atdmsr_7_3_4	4,200	500	na	na	3.99	6.0197	na	na	19,839.9	9.3397	0.0468	0.62020	0.00121	0.62262
atdmsr_7_3_3	4,200	500	na	na	3.99	6.0197	na	na	13,226.6	8.5079	0.0521	0.61780	0.00100	0.61980
atdmsr_7_3_2	4,200	500	na	na	3.99	6.0197	na	na	6,613.3	7.4710	0.0597	0.62719	0.00106	0.62931
atdmsr_7_3_1	4,200	500	na	na	3.99	6.0197	na	na	0.0	6.0198	0.0734	0.69368	0.00104	0.69575

Table 6.9.6-21. Results for solid HEU metal content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	Kaolite (g)	H_2O (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
7,000 g HEU 40% enrichment														
atdmsr_7_2_11	2,800	500	na	na	5.99	6.0176	na	na	66,133.1	13.0185	0.0298	0.57617	0.00095	0.57807
atdmsr_7_2_10	2,800	500	na	na	5.99	6.0176	na	na	59,519.8	12.6150	0.0319	0.57141	0.00113	0.57367
atdmsr_7_2_9	2,800	500	na	na	5.99	6.0176	na	na	52,906.5	12.1840	0.0329	0.56944	0.00094	0.57132
atdmsr_7_2_8	2,800	500	na	na	5.99	6.0176	na	na	46,293.2	11.7200	0.0351	0.56671	0.00107	0.56885
atdmsr_7_2_7	2,800	500	na	na	5.99	6.0176	na	na	39,679.9	11.2161	0.0373	0.56408	0.00108	0.56623
atdmsr_7_2_6	2,800	500	na	na	5.99	6.0176	na	na	33,066.6	10.6624	0.0400	0.56030	0.00098	0.56225
atdmsr_7_2_5	2,800	500	na	na	5.99	6.0176	na	na	26,453.3	10.0442	0.0427	0.55427	0.00096	0.55618
atdmsr_7_2_4	2,800	500	na	na	5.99	6.0176	na	na	19,839.9	9.3388	0.0468	0.55088	0.00103	0.55294
atdmsr_7_2_3	2,800	500	na	na	5.99	6.0176	na	na	13,226.6	8.5069	0.0518	0.55147	0.00094	0.55335
atdmsr_7_2_2	2,800	500	na	na	5.99	6.0176	na	na	6,613.3	7.4696	0.0598	0.56246	0.00099	0.56444
atdmsr_7_2_1	2,800	500	na	na	5.99	6.0176	na	na	0.0	6.0177	0.0741	0.63782	0.00112	0.64006
7,000 g HEU 19% enrichment														
atdmsr_7_1_11	1,330	500	na	na	12.61	6.0155	na	na	66,133.1	13.0180	0.0303	0.47486	0.00104	0.47693
atdmsr_7_1_10	1,330	500	na	na	12.61	6.0155	na	na	59,519.8	12.6145	0.0319	0.47397	0.00122	0.47641
atdmsr_7_1_9	1,330	500	na	na	12.61	6.0155	na	na	52,906.5	12.1834	0.0332	0.47151	0.00104	0.47360
atdmsr_7_1_8	1,330	500	na	na	12.61	6.0155	na	na	46,293.2	11.7195	0.0349	0.46786	0.00095	0.46975
atdmsr_7_1_7	1,330	500	na	na	12.61	6.0155	na	na	39,679.9	11.2155	0.0376	0.46514	0.00108	0.46730
atdmsr_7_1_6	1,330	500	na	na	12.61	6.0155	na	na	33,066.6	10.6617	0.0398	0.46144	0.00102	0.46347
atdmsr_7_1_5	1,330	500	na	na	12.61	6.0155	na	na	26,453.3	10.0434	0.0428	0.45904	0.00094	0.46093
atdmsr_7_1_4	1,330	500	na	na	12.61	6.0155	na	na	19,839.9	9.3379	0.0465	0.45553	0.00100	0.45753
atdmsr_7_1_3	1,330	500	na	na	12.61	6.0155	na	na	13,226.6	8.5058	0.0528	0.45536	0.00100	0.45737
atdmsr_7_1_2	1,330	500	na	na	12.61	6.0155	na	na	6,613.3	7.4682	0.0598	0.46993	0.00112	0.47216
atdmsr_7_1_1	1,330	500	na	na	12.61	6.0155	na	na	0.0	6.0156	0.0742	0.56352	0.00123	0.56598

Table 6.9.6-21. Results for solid HEU metal content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	Kaolite (g)	H_2O (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
compromised package, HEU-poly core in spherical configuration, dry (bound water) Kaolite shell, 20.0 cm water reflector														
7,000 g HEU 100% enrichment														
atdmdkr_7_8_6	7,000	500	na	na	2.40	6.0238	51,214.9	2,204.2	53,419.1	31.0802	0.0493	0.58882	0.00117	0.59116
atdmdkr_7_8_5	7,000	500	na	na	2.40	6.0238	40,971.9	1,763.4	42,735.3	28.8698	0.0508	0.59271	0.00122	0.59516
atdmdkr_7_8_4	7,000	500	na	na	2.40	6.0238	30,729.0	1,322.5	32,051.5	26.2565	0.0530	0.59911	0.00118	0.60147
atdmdkr_7_8_3	7,000	500	na	na	2.40	6.0238	20,485.9	881.7	21,367.6	22.9832	0.0559	0.60599	0.00101	0.60801
atdmdkr_7_8_2	7,000	500	na	na	2.40	6.0238	10,243.0	440.8	10,683.8	18.3506	0.0604	0.62729	0.00116	0.62962
atdmdkr_7_8_1	7,000	500	na	na	2.40	6.0238	0.0	0.0	0.0	6.0239	0.0733	0.78590	0.00118	0.78826
compromised package, HEU-poly core in spherical configuration, wet (bound plus 15 lb free water) Kaolite shell, 20.0 cm water reflector														
7,000 g HEU 100% enrichment														
atdm15kr_7_8_6	7,000	500	na	na	2.40	6.0238	51,214.9	9,008.1	60,223.0	31.0802	0.0402	0.59780	0.00113	0.60006
atdm15kr_7_8_5	7,000	500	na	na	2.40	6.0238	40,971.9	7,206.5	48,178.4	28.8698	0.0425	0.60257	0.00108	0.60473
atdm15kr_7_8_4	7,000	500	na	na	2.40	6.0238	30,728.9	5,404.9	36,133.8	26.2565	0.0452	0.60526	0.00112	0.60750
atdm15kr_7_8_3	7,000	500	na	na	2.40	6.0238	20,486.0	3,603.2	24,089.2	22.9832	0.0487	0.61255	0.00103	0.61461
atdm15kr_7_8_2	7,000	500	na	na	2.40	6.0238	10,243.0	1,801.6	12,044.6	18.3506	0.0546	0.63083	0.00104	0.63292
atdm15kr_7_8_1	7,000	500	na	na	2.40	6.0238	0.0	0.0	0.0	6.0239	0.0735	0.78760	0.00130	0.79020
7,000 g HEU 95% enrichment														
atdm15kr_7_7_6	6,650	500	na	na	2.52	6.0233	51,214.9	9,008.1	60,223.0	31.0802	0.0405	0.58499	0.00117	0.58733
atdm15kr_7_7_5	6,650	500	na	na	2.52	6.0233	40,971.8	7,206.6	48,178.4	28.8698	0.0427	0.58888	0.00102	0.59093
atdm15kr_7_7_4	6,650	500	na	na	2.52	6.0233	30,728.9	5,404.9	36,133.8	26.2564	0.0451	0.59189	0.00101	0.59391
atdm15kr_7_7_3	6,650	500	na	na	2.52	6.0233	20,485.9	3,603.3	24,089.2	22.9832	0.0490	0.59837	0.00098	0.60034
atdm15kr_7_7_2	6,650	500	na	na	2.52	6.0233	10,243.0	1,801.6	12,044.6	18.3506	0.0553	0.61938	0.00126	0.62190
atdm15kr_7_7_1	6,650	500	na	na	2.52	6.0233	0.0	0.0	0.0	6.0234	0.0727	0.77397	0.00119	0.77636

Table 6.9.6-21. Results for solid HEU metal content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	Kaolite (g)	H_2O (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
7,000 g HEU 90% enrichment														
atdm15kr_7_6_6	6,300	500	na	na	2.66	6.0228	51,214.9	9,008.1	60,223.0	31.0802	0.0404	0.57465	0.00119	0.57703
atdm15kr_7_6_5	6,300	500	na	na	2.66	6.0228	40,971.8	7,206.6	48,178.4	28.8698	0.0425	0.57735	0.00128	0.57991
atdm15kr_7_6_4	6,300	500	na	na	2.66	6.0228	30,728.9	5,404.9	36,133.8	26.2564	0.0450	0.57926	0.00117	0.58159
atdm15kr_7_6_3	6,300	500	na	na	2.66	6.0228	20,485.9	3,603.3	24,089.2	22.9831	0.0487	0.58806	0.00114	0.59034
atdm15kr_7_6_2	6,300	500	na	na	2.66	6.0228	10,243.0	1,801.6	12,044.6	18.3505	0.0554	0.60486	0.00116	0.60718
atdm15kr_7_6_1	6,300	500	na	na	2.66	6.0228	0.0	0.0	0.0	6.0229	0.0730	0.76331	0.00116	0.76563
7,000 g HEU 80% enrichment														
atdm15kr_7_5_6	5,600	500	na	na	2.99	6.0218	51,214.9	9,008.1	60,223.0	31.0802	0.0408	0.54645	0.00099	0.54842
atdm15kr_7_5_5	5,600	500	na	na	2.99	6.0218	40,971.8	7,206.6	48,178.4	28.8698	0.0423	0.54984	0.00093	0.55170
atdm15kr_7_5_4	5,600	500	na	na	2.99	6.0218	30,728.9	5,404.9	36,133.8	26.2563	0.0446	0.55606	0.00114	0.55834
atdm15kr_7_5_3	5,600	500	na	na	2.99	6.0218	20,485.9	3,603.3	24,089.2	22.9831	0.0487	0.56202	0.00110	0.56422
atdm15kr_7_5_2	5,600	500	na	na	2.99	6.0218	10,243.0	1,801.6	12,044.6	18.3504	0.0552	0.58092	0.00102	0.58295
atdm15kr_7_5_1	5,600	500	na	na	2.99	6.0218	0.0	0.0	0.0	6.0219	0.0730	0.74103	0.00130	0.74363
7,000 g HEU 70% enrichment														
atdm15kr_7_4_6	4,900	500	na	na	3.42	6.0207	51,214.9	9,008.1	60,223.0	31.0801	0.0409	0.52118	0.00095	0.52308
atdm15kr_7_4_5	4,900	500	na	na	3.42	6.0207	40,971.8	7,206.6	48,178.4	28.8697	0.0426	0.52194	0.00095	0.52385
atdm15kr_7_4_4	4,900	500	na	na	3.42	6.0207	30,728.9	5,404.9	36,133.8	26.2563	0.0452	0.52781	0.00096	0.52973
atdm15kr_7_4_3	4,900	500	na	na	3.42	6.0207	20,485.9	3,603.3	24,089.2	22.9830	0.0487	0.53753	0.00090	0.53933
atdm15kr_7_4_2	4,900	500	na	na	3.42	6.0207	10,243.0	1,801.6	12,044.6	18.3503	0.0550	0.55570	0.00095	0.55760
atdm15kr_7_4_1	4,900	500	na	na	3.42	6.0207	0.0	0.0	0.0	6.0208	0.0732	0.71662	0.00127	0.71916

Table 6.9.6-21. Results for solid HEU metal content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	Kaolite (g)	H_2O (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
7,000 g HEU 60% enrichment														
atdm15kr_7_3_6	4,200	500	na	na	3.99	6.0197	51,214.9	9,008.1	60,223.0	31.0801	0.0403	0.49438	0.00093	0.49623
atdm15kr_7_3_5	4,200	500	na	na	3.99	6.0197	40,971.8	7,206.6	48,178.4	28.8697	0.0424	0.49599	0.00119	0.49837
atdm15kr_7_3_4	4,200	500	na	na	3.99	6.0197	30,728.9	5,404.9	36,133.8	26.2562	0.0455	0.50053	0.00097	0.50248
atdm15kr_7_3_3	4,200	500	na	na	3.99	6.0197	20,485.9	3,603.3	24,089.2	22.9829	0.0495	0.50936	0.00114	0.51163
atdm15kr_7_3_2	4,200	500	na	na	3.99	6.0197	10,243.0	1,801.6	12,044.6	18.3502	0.0557	0.52826	0.00099	0.53024
atdm15kr_7_3_1	4,200	500	na	na	3.99	6.0197	0.0	0.0	0.0	6.0198	0.0735	0.69521	0.00106	0.69734
7,000 g HEU 40% enrichment														
atdm15kr_7_2_6	2,800	500	na	na	5.99	6.0176	51,214.9	9,008.1	60,223.0	31.0800	0.0409	0.43125	0.00093	0.43312
atdm15kr_7_2_5	2,800	500	na	na	5.99	6.0176	40,971.8	7,206.6	48,178.4	28.8696	0.0430	0.43173	0.00091	0.43356
atdm15kr_7_2_4	2,800	500	na	na	5.99	6.0176	30,728.9	5,404.9	36,133.8	26.2561	0.0454	0.43686	0.00096	0.43879
atdm15kr_7_2_3	2,800	500	na	na	5.99	6.0176	20,485.9	3,603.3	24,089.2	22.9828	0.0498	0.44558	0.00085	0.44727
atdm15kr_7_2_2	2,800	500	na	na	5.99	6.0176	10,243.0	1,801.6	12,044.6	18.3500	0.0559	0.46589	0.00105	0.46800
atdm15kr_7_2_1	2,800	500	na	na	5.99	6.0176	0.0	0.0	0.0	6.0177	0.0738	0.63718	0.00107	0.63932
7,000 g HEU 19% enrichment														
atdm15kr_7_1_6	1,330	500	na	na	12.61	6.0155	51,214.9	9,008.1	60,223.0	31.0799	0.0410	0.34386	0.00104	0.34594
atdm15kr_7_1_5	1,330	500	na	na	12.61	6.0155	40,971.8	7,206.6	48,178.4	28.8695	0.0430	0.34663	0.00078	0.34819
atdm15kr_7_1_4	1,330	500	na	na	12.61	6.0155	30,728.9	5,404.9	36,133.8	26.2560	0.0458	0.35247	0.00090	0.35428
atdm15kr_7_1_3	1,330	500	na	na	12.61	6.0155	20,485.9	3,603.3	24,089.2	22.9826	0.0495	0.36066	0.00085	0.36236
atdm15kr_7_1_2	1,330	500	na	na	12.61	6.0155	10,243.0	1,801.6	12,044.6	18.3497	0.0559	0.38250	0.00092	0.38433
atdm15kr_7_1_1	1,330	500	na	na	12.61	6.0155	0.0	0.0	0.0	6.0156	0.0743	0.56556	0.00123	0.56802

Table 6.9.6-22a. Results for TRIGA ($UZrH_x$) fuel element content at 19.7 wt % ^{235}U for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	Kaolite (g)	H_2O (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
compromised package, 10,400 g $UZrH_x$ plus poly in spherical configuration, 20.0 cm water reflector														
atdzr	921	500	na	na	43.37	7.4677	na	na	na	na	0.0617	0.67633	0.00116	0.67906
compromised package, spherical core (10,400 g $UZrH_x$ plus poly), stainless steel shell, 20.0 cm water reflector														
atdzsr_11	921	500	na	na	43.37	7.4677	na	na	66,133.0	13.3978	0.0271	0.61692	0.00121	0.61933
atdzsr_10	921	500	na	na	43.37	7.4677	na	na	59,520.0	13.0179	0.0285	0.61377	0.00109	0.61595
atdzsr_9	921	500	na	na	43.37	7.4677	na	na	52,907.0	12.6144	0.0301	0.60931	0.00156	0.61243
atdzsr_8	921	500	na	na	43.37	7.4677	na	na	46,293.0	12.1833	0.0315	0.60602	0.00132	0.60867
atdzsr_7	921	500	na	na	43.37	7.4677	na	na	39,680.0	11.7193	0.0332	0.60256	0.00138	0.60533
atdzsr_6	921	500	na	na	43.37	7.4677	na	na	33,067.0	11.2153	0.0356	0.59752	0.00129	0.60010
atdzsr_5	921	500	na	na	43.37	7.4677	na	na	26,453.0	10.6615	0.0379	0.59162	0.00109	0.59381
atdzsr_4	921	500	na	na	43.37	7.4677	na	na	19,840.0	10.0432	0.0407	0.59012	0.00116	0.59243
atdzsr_3	921	500	na	na	43.37	7.4677	na	na	13,227.0	9.3377	0.0458	0.58978	0.00116	0.59210
atdzsr_2	921	500	na	na	43.37	7.4677	na	na	6,613.0	8.5055	0.0515	0.60131	0.00135	0.60401
atdzsr_1	921	500	na	na	43.37	7.4677	na	na	0.0	7.4677	0.0614	0.67521	0.00128	0.67777
compromised package, spherical core (10,400 g $UZrH_x$ plus poly), wet (bound plus 15 lb free water) Kaolite shell, 20.0 cm water reflector														
atdz15kr_6	921	500	na	na	43.37	7.4677	51214.9	9008.1	60,223.0	31.1484	0.0352	0.46526	0.00113	0.46752
atdz15kr_5	921	500	na	na	43.37	7.4677	40971.9	7206.5	48,178.4	28.9488	0.0369	0.47017	0.00113	0.47243
atdz15kr_4	921	500	na	na	43.37	7.4677	30728.9	5404.9	36,133.8	26.3518	0.0393	0.47656	0.00109	0.47875
atdz15kr_3	921	500	na	na	43.37	7.4677	20486.0	3603.2	24,089.2	23.1074	0.0424	0.48601	0.00119	0.48839
atdz15kr_2	921	500	na	na	43.37	7.4677	10243.0	1801.6	12,044.6	18.5444	0.0476	0.50839	0.00112	0.51063
atdz15kr_1	921	500	na	na	43.37	7.4677	0.0	0.0	0.0	7.4678	0.0610	0.67612	0.00136	0.67885

Table 6.9.6-22a. Results for TRIGA ($UZrH_x$) fuel element content at 19.7 wt % ^{235}U for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	Kaolite (g)	H_2O (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
compromised package, homogenous core (10,400 g $UZrH_x$, poly, and wet Kaolite) in spherical configuration, 20.0 cm water reflector														
athzp15kr_5	921	500	9,008.5	51,214.9	298.60	31.1484	na	na	na	na	0.0583	0.35614	0.00079	0.35772
athzp15kr_4	921	500	7,307.6	51,214.9	250.40	31.1484	na	na	na	na	0.0600	0.34337	0.00084	0.34504
athzp15kr_3	921	500	5,606.6	51,214.9	202.20	31.1484	na	na	na	na	0.0619	0.33243	0.00085	0.33414
athzp15kr_2	921	500	3,905.7	51,214.9	154.00	31.1484	na	na	na	na	0.0646	0.31864	0.00079	0.32022
athzp15kr_1	921	500	2,204.7	51,214.9	105.80	31.1484	na	na	na	na	0.0666	0.30842	0.00079	0.31000
compromised package, homogenous core ($UZrH_x$, poly, and water from wet Kaolite shell), wet Kaolite shell, 20.0 cm water reflector														
9 fuel segments (10,400 g $UZrH_x$)														
athzpw15kr_5	921	500	6,803.8	na	236.10	12.6903	2,204.7	51,214.9	53,419.6	31.6977	0.0308	0.80474	0.00154	0.80781
athzpw15kr_4	921	500	5,102.9	na	187.90	11.7852	3,905.7	51,214.9	55,120.5	31.5622	0.0316	0.76177	0.00142	0.76460
athzpw15kr_3	921	500	3,401.9	na	139.70	10.7146	5,606.6	51,214.9	56,821.5	31.4254	0.0325	0.70349	0.00145	0.70638
athzpw15kr_2	921	500	1,701.0	na	91.57	9.3723	7,307.6	51,214.9	58,522.4	31.2875	0.0334	0.61344	0.00132	0.61608
athzpw15kr_1	921	500	0.0	na	43.37	7.4677	9,008.5	51,214.9	60,223.4	31.1484	0.0351	0.46733	0.00103	0.46938

Table 6.9.6-22b. Results for TRIGA ($UZrH_x$) fuel element content at 70.1 wt % ^{235}U for air transportation

case name	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	H_2O (g)	Kaolite (g)	Shell (g)	Rs (cm)	nlf	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
compromised package, 6847 g $UZrH_x$ plus poly in spherical configuration, 20.0 cm water reflector														
atdzr_70	408	500	na	na	103.30	7.4677	na	na	na	na	0.0624	0.67908	0.00139	0.68187
compromised package, spherical core (6,847 g $UZrH_x$ plus poly), stainless steel shell, 20.0 cm water reflector														
atdzsr_70_11	408	500	na	na	103.30	7.4677	na	na	66,133.1	13.3978	0.0280	0.62618	0.00125	0.62868
atdzsr_70_10	408	500	na	na	103.30	7.4677	na	na	59,519.8	13.0179	0.0296	0.62153	0.00132	0.62417
atdzsr_70_9	408	500	na	na	103.30	7.4677	na	na	52,906.5	12.6144	0.0306	0.61874	0.00131	0.62135
atdzsr_70_8	408	500	na	na	103.30	7.4677	na	na	46,293.2	12.1833	0.0323	0.61302	0.00159	0.61619
atdzsr_70_7	408	500	na	na	103.30	7.4677	na	na	39,679.9	11.7193	0.0343	0.60579	0.00123	0.60825
atdzsr_70_6	408	500	na	na	103.30	7.4677	na	na	33,066.6	11.2153	0.0368	0.60315	0.00128	0.60571
atdzsr_70_5	408	500	na	na	103.30	7.4677	na	na	26,453.3	10.6615	0.0392	0.59802	0.00120	0.60043
atdzsr_70_4	408	500	na	na	103.30	7.4677	na	na	19,839.9	10.0432	0.0427	0.58654	0.00123	0.58900
atdzsr_70_3	408	500	na	na	103.30	7.4677	na	na	13,226.6	9.3377	0.0470	0.58790	0.00125	0.59040
atdzsr_70_2	408	500	na	na	103.30	7.4677	na	na	6,613.3	8.5055	0.0529	0.59739	0.00132	0.60003
atdzsr_70_1	408	500	na	na	103.30	7.4677	na	na	0.0	7.4677	0.0627	0.67646	0.00125	0.67896
compromised package, spherical core (6,847 g $UZrH_x$ plus poly), wet (bound plus 15 lb free water) Kaolite shell, 20.0 cm water reflector														
atdz15kr70_6	408	500	na	na	103.30	7.4677	na	na	60,223.0	31.1484	0.0362	0.45220	0.00122	0.45465
atdz15kr70_5	408	500	na	na	103.30	7.4677	na	na	48,178.4	28.9488	0.0381	0.45455	0.00142	0.45740
atdz15kr70_4	408	500	na	na	103.30	7.4677	na	na	36,133.8	26.3518	0.0404	0.46170	0.00131	0.46431
atdz15kr70_3	408	500	na	na	103.30	7.4677	na	na	24,089.2	23.1074	0.0437	0.47236	0.00111	0.47459
atdz15kr70_2	408	500	na	na	103.30	7.4677	na	na	12,044.6	18.5444	0.0490	0.49052	0.00132	0.49316
atdz15kr70_1	408	500	na	na	103.30	7.4677	na	na	0.0	7.4678	0.0626	0.67525	0.00131	0.67787

Table 6.9.6-22b. Results for TRIGA ($UZrH_x$) fuel element content at 70.1 wt % ^{235}U for air transportation

case name	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	H_2O (g)	Kaolite (g)	Shell (g)	Rs (cm)	nlf	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
compromised package, homogenous core (6,847 g $UZrH_x$, poly, and wet Kaolite) in spherical configuration, 20.0 cm water reflector														
athzp15kr70_5	408	500	9,008.5	51,214.9	679.60	31.1484	na	na	na	na	0.0581	0.24018	0.00055	0.24128
athzp15kr70_4	408	500	7,307.6	51,214.9	570.80	31.1484	na	na	na	na	0.0598	0.23208	0.00050	0.23308
athzp15kr70_3	408	500	5,606.6	51,214.9	461.90	31.1484	na	na	na	na	0.0623	0.22392	0.00052	0.22495
athzp15kr70_2	408	500	3,905.7	51,214.9	353.10	31.1484	na	na	na	na	0.0650	0.21594	0.00064	0.21722
athzp15kr70_1	408	500	2,204.7	51,214.9	244.30	31.1484	na	na	na	na	0.0672	0.20933	0.00057	0.21047
compromised package, homogenous core (6,847 g $UZrH_x$, poly, and water from wet Kaolite), wet Kaolite shell, 20.0 cm water reflector														
9 fuel segments (6,847 g $UZrH_x$)														
athzpw15kr70_5	408	500	6,803.8	na	538.50	12.6903	2,204.7	51,214.9	53,419.6	31.6977	0.0310	0.71851	0.00148	0.72147
athzpw15kr70_4	408	500	5,102.9	na	429.70	11.7852	3,905.7	51,214.9	55,120.5	31.5622	0.0317	0.69647	0.00123	0.69894
athzpw15kr70_3	408	500	3,401.9	na	320.90	10.7146	5,606.6	51,214.9	56,821.5	31.4254	0.0326	0.66072	0.00122	0.66315
athzpw15kr70_2	408	500	1,701.0	na	212.10	9.3723	7,307.6	51,214.9	58,522.4	31.2875	0.0341	0.59094	0.00118	0.59330
athzpw15kr70_1	408	500	0.0	na	103.30	7.4677	9,008.5	51,214.9	60,223.4	31.1484	0.0354	0.45119	0.00118	0.45355

Table 6.9.6-22c. Results for research reactor fuel (U_3O_8-Al) content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	H_2O (g)	Kaolite (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
compromised package, homogenous core ($UZrH_x$, poly, and water from wet Kaolite shell), wet Kaolite shell, 20.0 cm water reflector														
TRIGA content, 10,400 g $UZrH_x$ at 19.7 wt % ^{235}U (Reference Table 6.9.6-22a)														
athzpw15kr_5	921	500	6,803.8	na	236.10	12.6903	2,204.7	51,214.9	53,419.6	31.6977	0.0308	0.80474	0.00154	0.80781
athzpw15kr_4	921	500	5,102.9	na	187.90	11.7852	3,905.7	51,214.9	55,120.5	31.5622	0.0316	0.76177	0.00142	0.76460
athzpw15kr_3	921	500	3,401.9	na	139.70	10.7146	5,606.6	51,214.9	56,821.5	31.4254	0.0325	0.70349	0.00145	0.70638
athzpw15kr_2	921	500	1,701.0	na	91.57	9.3723	7,307.6	51,214.9	58,522.4	31.2875	0.0334	0.61344	0.00132	0.61608
athzpw15kr_1	921	500	0.0	na	43.37	7.4677	9,008.5	51,214.9	60,223.4	31.1484	0.0351	0.46733	0.00103	0.46938
compromised package, homogenous core ($UZrH_x$, poly, and water from wet Kaolite shell), wet Kaolite shell, 20.0 cm water reflector														
TRIGA content, 6,847 g $UZrH_x$ at 70.1 wt % ^{235}U (Reference Table 6.9.6-22b)														
athzpw15kr70_5	408	500	6,803.8	na	538.50	12.6903	2,204.7	51,214.9	53,419.6	31.6977	0.0310	0.71851	0.00148	0.72147
athzpw15kr70_4	408	500	5,102.9	na	429.70	11.7852	3,905.7	51,214.9	55,120.5	31.5622	0.0317	0.69647	0.00123	0.69894
athzpw15kr70_3	408	500	3,401.9	na	320.90	10.7146	5,606.6	51,214.9	56,821.5	31.4254	0.0326	0.66072	0.00122	0.66315
athzpw15kr70_2	408	500	1,701.0	na	212.10	9.3723	7,307.6	51,214.9	58,522.4	31.2875	0.0341	0.59094	0.00118	0.59330
athzpw15kr70_1	408	500	0.0	na	103.30	7.4677	9,008.5	51,214.9	60,223.4	31.1484	0.0354	0.45119	0.00118	0.45355
compromised package, homogenous core (U_3O_8-Al, poly, and water from wet Kaolite shell), wet Kaolite shell, 20.0 cm water reflector														
THAR content, 15,763 g U_3O_8-Al at 20 wt % ^{235}U														
athopw15kr20_5	921	500	6,803.8	na	211.00	14.1381	2,204.7	51,214.9	53,419.6	31.9552	0.0370	0.62212	0.00133	0.62478
athopw15kr20_4	921	500	5,102.9	na	162.80	13.4243	3,905.7	51,214.9	55,120.5	31.8218	0.0386	0.54443	0.00136	0.54715
athopw15kr20_3	921	500	3,401.9	na	114.60	12.6252	5,606.6	51,214.9	56,821.5	31.6873	0.0412	0.43966	0.00106	0.44178
athopw15kr20_2	921	500	1,701.0	na	66.42	11.7097	7,307.6	51,214.9	58,522.4	31.5517	0.0453	0.29892	0.00105	0.30102
athopw15kr20_1	921	500	0.0	na	18.21	10.6230	9,008.5	51,214.9	60,223.4	31.4149	0.0515	0.16214	0.00052	0.16317

Table 6.9.6-22c. Results for research reactor fuel (U_3O_8-Al) content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	H_2O (g)	Kaolite (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
THAR content, 1,996 g U_3O_8-Al at 70 wt % ^{235}U														
athopw15kr70_5	408	500	6,803.8	na	476.30	12.3688	2,204.7	51,214.9	53,419.6	31.6474	0.0340	0.67791	0.00146	0.68084
athopw15kr70_4	408	500	5,102.9	na	367.50	11.4101	3,905.7	51,214.9	55,120.5	31.5114	0.0348	0.64009	0.00130	0.64269
athopw15kr70_3	408	500	3,401.9	na	258.70	10.2557	5,606.6	51,214.9	56,821.5	31.3743	0.0369	0.57400	0.00118	0.57635
athopw15kr70_2	408	500	1,701.0	na	149.90	8.7585	7,307.6	51,214.9	58,522.4	31.2359	0.0400	0.44909	0.00120	0.45150
athopw15kr70_1	408	500	0.0	na	41.10	6.4237	9,008.5	51,214.9	60,223.4	31.0963	0.0479	0.18508	0.00083	0.18674
THAR content, 1,505 g U_3O_8-Al at 93 wt % ^{235}U														
athopw15kr93_5	408	500	6,803.8	na	476.30	12.2959	2,204.7	51,214.9	53,419.6	31.6363	0.0338	0.69183	0.00144	0.69471
athopw15kr93_4	408	500	5,102.9	na	367.50	11.3242	3,905.7	51,214.9	55,120.5	31.5002	0.0348	0.65724	0.00123	0.65970
athopw15kr93_3	408	500	3,401.9	na	258.70	10.1491	5,606.6	51,214.9	56,821.5	31.3630	0.0365	0.59543	0.00147	0.59838
athopw15kr93_2	408	500	1,701.0	na	149.90	8.6114	7,307.6	51,214.9	58,522.4	31.2245	0.0395	0.47503	0.00134	0.47771
athopw15kr93_1	408	500	0.0	na	41.10	6.1427	9,008.5	51,214.9	60,223.4	31.0848	0.0471	0.20615	0.00083	0.20780

Table 6.9.6-22d. Results for research reactor fuel (UO_2-Mg) content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	H_2O (g)	Kaolite (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
compromised package, homogenous core ($UZrH_x$, poly, and water from wet Kaolite shell), wet Kaolite shell, 20.0 cm water reflector														
TRIGA content, 10,400 g $UZrH_x$ at 19.7 wt % ^{235}U (Reference Table 6.9.6-22a)														
athzpw15kr_5	921	500	6,803.8	na	236.10	12.6903	2,204.7	51,214.9	53,419.6	31.6977	0.0308	0.80474	0.00154	0.80781
compromised package, homogenous core (6,847 g $UZrH_x$, poly, and water from wet Kaolite shell), wet Kaolite shell, 20.0 cm water reflector														
TRIGA content, 6,847 g $UZrH_x$ at 70.1 wt % ^{235}U (Reference Table 6.9.6-22b)														
athzpw15kr70_5	408	500	6,803.8	na	538.50	12.6903	2,204.7	51,214.9	53,419.6	31.6977	0.0310	0.71851	0.00148	0.72147
compromised package, homogenous core (UO_2-Mg Al clad, poly, and water from wet Kaolite shell), wet Kaolite shell, 20.0 cm water reflector														
EK10 content, 19,592 g UO_2-Mg Al clad at 9.89 wt % ^{235}U														
athupw15kr09_5	921	500	6,803.8	na	210.70	14.3227	2,204.7	51,214.9	53,419.6	31.9917	0.0370	0.59466	0.00133	0.59731
athupw15kr09_4	921	500	5,102.9	na	162.60	13.6286	3,905.7	51,214.9	55,120.5	31.8587	0.0382	0.51941	0.00125	0.52191
athupw15kr09_3	921	500	3,401.9	na	114.40	12.8555	5,606.6	51,214.9	56,821.5	31.7245	0.0413	0.41977	0.00109	0.42195
athupw15kr09_2	921	500	1,701.0	na	66.34	11.9762	7,307.6	51,214.9	58,522.4	31.5892	0.0452	0.29437	0.00087	0.29611
athupw15kr09_1	921	500	0.0	na	18.19	10.9444	9,008.5	51,214.9	60,223.4	31.4527	0.0512	0.17226	0.00061	0.17348
EK10 content, 9,678 g UO_2-Mg Al clad at 20 wt % ^{235}U														
athupw15kr20_5	921	500	6,803.8	na	211.00	13.2769	2,204.7	51,214.9	53,419.6	31.7958	0.0356	0.68552	0.00138	0.68828
athupw15kr20_4	921	500	5,102.9	na	162.80	12.4581	3,905.7	51,214.9	55,120.5	31.6611	0.0371	0.61477	0.00137	0.61752
athupw15kr20_3	921	500	3,401.9	na	114.60	11.5148	5,606.6	51,214.9	56,821.5	31.5253	0.0394	0.51363	0.00128	0.51620
athupw15kr20_2	921	500	1,701.0	na	66.41	10.3849	7,307.6	51,214.9	58,522.4	31.3882	0.0435	0.36126	0.00110	0.36346
athupw15kr20_1	921	500	0.0	na	18.21	8.9343	9,008.5	51,214.9	60,223.4	31.2500	0.0514	0.16764	0.00069	0.16901

Table 6.9.6-22d. Results for research reactor fuel (UO_2-Mg) content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	H_2O (g)	Kaolite (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
EK10 content, 921 g UO_2-Mg Al clad at 93.2 wt % ^{235}U														
athupw15kr93_5	408	500	6,803.8	na	476.30	12.2567	2,204.7	51,214.9	53,419.6	31.6304	0.0338	0.69466	0.00138	0.69741
athupw15kr93_4	408	500	5,102.9	na	367.50	11.2780	3,905.7	51,214.9	55,120.5	31.4943	0.0348	0.65939	0.00125	0.66189
athupw15kr93_3	408	500	3,401.9	na	258.70	10.0914	5,606.6	51,214.9	56,821.5	31.3570	0.0365	0.59641	0.00153	0.59947
athupw15kr93_2	408	500	1,701.0	na	149.90	8.5310	7,307.6	51,214.9	58,522.4	31.2185	0.0395	0.47695	0.00113	0.47921
athupw15kr93_1	408	500	0.0	na	41.10	5.9820	9,008.5	51,214.9	60,223.4	31.0787	0.0471	0.21220	0.00082	0.21384
497 g UO_2 at 93.2 wt % ^{235}U														
athbpw15kr93_5	408	500	6,803.8	na	476.30	12.1057	2,204.7	51,214.9	53,419.6	31.6080	0.0329	0.70973	0.00139	0.71252
athbpw15kr93_4	408	500	5,102.9	na	367.50	11.0990	3,905.7	51,214.9	55,120.5	31.4717	0.0341	0.67992	0.00137	0.68266
athbpw15kr93_3	408	500	3,401.9	na	258.70	9.8664	5,606.6	51,214.9	56,821.5	31.3342	0.0360	0.62656	0.00139	0.62935
athbpw15kr93_2	408	500	1,701.0	na	149.90	8.2112	7,307.6	51,214.9	58,522.4	31.1954	0.0384	0.52289	0.00131	0.52550
athbpw15kr93_1	408	500	0.0	na	41.10	5.2756	9,008.5	51,214.9	60,223.4	31.0555	0.0437	0.30087	0.00123	0.30334

Table 6.9.6-23. Results for HEU broken metal content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	H_2O (g)	Kaolite (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
compromised package, HEU in spherical configuration, 20.0 cm water reflector (See Table 6.9.6-21)														
compromised package, HEU in spherical configuration, stainless steel, 20.0 cm water reflector (See Table 6.9.6-21)														
compromised package, HEU in spherical configuration, Kaolite shell, 20.0 cm water reflector (See Table 6.9.6-21)														
compromised package, homogenous core (HEU broken metal, poly, and wet Kaolite) in spherical configuration, 20.0 cm water reflector														
7,000 g HEU 100% enrichment														
athmp15kr_12_8_5	7,000	500	9008.5	51,214.9	35.99	31.0803	na	na	na	na	0.0579	0.58855	0.00115	0.59085
athmp15kr_12_8_4	7,000	500	7307.6	51,214.9	29.64	31.0803	na	na	na	na	0.0600	0.56644	0.00118	0.56880
athmp15kr_12_8_3	7,000	500	5606.6	51,214.9	23.30	31.0803	na	na	na	na	0.0617	0.54431	0.00107	0.54644
athmp15kr_12_8_2	7,000	500	3905.7	51,214.9	16.96	31.0803	na	na	na	na	0.0640	0.51987	0.00112	0.52211
athmp15kr_12_8_1	7,000	500	2204.7	51,214.9	10.62	31.0803	na	na	na	na	0.0658	0.50016	0.00111	0.50238
35,000 g HEU 20% enrichment														
athmp15kr_12_1_5	7,000	500	9008.5	51,214.9	7.20	31.2009	na	na	na	na	0.0558	0.56801	0.00109	0.57020
athmp15kr_12_1_4	7,000	500	7307.6	51,214.9	5.93	31.2009	na	na	na	na	0.0579	0.54764	0.00104	0.54972
athmp15kr_12_1_3	7,000	500	5606.6	51,214.9	4.66	31.2009	na	na	na	na	0.0603	0.52686	0.00109	0.52904
athmp15kr_12_1_2	7,000	500	3905.7	51,214.9	3.39	31.2009	na	na	na	na	0.0621	0.50549	0.00104	0.50757
athmp15kr_12_1_1	7,000	500	2204.7	51,214.9	2.12	31.2009	na	na	na	na	0.0645	0.48986	0.00121	0.49227
compromised package, homogenous core (HEU broken metal, poly, and water from wet Kaolite shell), wet Kaolite shell, 20.0 cm water reflector														
free water limited to 15 lb														
athmpw15kr_12_8_5	7,000	500	6803.8	na	27.77	12.2667	2,204.7	51,214.9	53,419.6	31.6319	0.0344	0.95651	0.00153	0.95956
athmpw15kr_12_8_4	7,000	500	5102.9	na	21.42	11.2898	3,905.7	51,214.9	55,120.5	31.4958	0.0345	0.89106	0.00148	0.89402
athmpw15kr_12_8_3	7,000	500	3401.9	na	15.08	10.1062	5,606.6	51,214.9	56,821.5	31.3585	0.0358	0.81175	0.00129	0.81433
athmpw15kr_12_8_2	7,000	500	1701.0	na	8.74	8.5517	7,307.6	51,214.9	58,522.4	31.2200	0.0377	0.70771	0.00118	0.71008
athmpw15kr_12_8_1	7,000	500	0.0	na	2.40	6.0238	9,008.5	51,214.9	60,223.4	31.0802	0.0401	0.60135	0.00123	0.60381

Table 6.9.6-23. Results for HEU broken metal content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	H_2O (g)	Kaolite (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
free water limited to 13 lb														
athmpw13kr_12_8_5	7,000	500	5896.7	na	24.38	11.7659	2,204.7	51,214.9	53,419.6	31.5595	0.0353	0.92418	0.00152	0.92721
athmpw13kr_12_8_4	7,000	500	4422.5	na	18.89	10.8471	3,678.9	51,214.9	54,893.7	31.4410	0.0359	0.85851	0.00141	0.86133
athmpw13kr_12_8_3	7,000	500	2948.3	na	13.39	9.7390	5,153.0	51,214.9	56,367.9	31.3217	0.0371	0.78403	0.00138	0.78680
athmpw13kr_12_8_2	7,000	500	1474.2	na	7.89	8.2969	6,627.2	51,214.9	57,842.0	31.2014	0.0388	0.69268	0.00133	0.69535
athmpw13kr_12_8_1	7,000	500	0.0	na	2.40	6.0238	8,101.3	51,214.9	59,316.2	31.0802	0.0413	0.59728	0.00111	0.59950
free water limited to 12 lb														
athmpw12kr_12_8_5	7,000	500	5443.1	na	22.69	11.4987	2,204.7	51,214.9	53,419.6	31.5231	0.0358	0.90261	0.00179	0.90618
athmpw12kr_12_8_4	7,000	500	4082.3	na	17.62	10.6116	3,565.5	51,214.9	54,780.3	31.4136	0.0363	0.84275	0.00146	0.84568
athmpw12kr_12_8_3	7,000	500	2721.5	na	12.54	9.5445	4,926.2	51,214.9	56,141.1	31.3033	0.0377	0.77003	0.00157	0.77317
athmpw12kr_12_8_2	7,000	500	1360.8	na	7.47	8.1635	6,287.0	51,214.9	57,501.8	31.1921	0.0397	0.68336	0.00123	0.68583
athmpw12kr_12_8_1	7,000	500	0.0	na	2.40	6.0238	7,647.8	51,214.9	58,862.6	31.0802	0.0420	0.59769	0.00093	0.59955
5,000 g HEU 100% enrichment														
compromised package, homogenous core (HEU broken metal, poly, and wet Kaolite), HEU shell, 20.0 cm water reflector														
7,000 g HEU total at 100% enrichment														
athmp15kmr_														
13_1_8_5	6,500	500	9,008.5	51,214.9	38.75	31.0781	na	na	500	31.0804	0.0574	0.60317	0.00119	0.60556
13_1_8_4	6,500	500	7,307.6	51,214.9	31.92	31.0781	na	na	500	31.0804	0.0591	0.57747	0.00116	0.57980
13_1_8_3	6,500	500	5,606.6	51,214.9	25.09	31.0781	na	na	500	31.0804	0.0599	0.55460	0.00118	0.55695
13_1_8_2	6,500	500	3,905.7	51,214.9	18.26	31.0781	na	na	500	31.0804	0.0628	0.52945	0.00111	0.53166
13_1_8_1	6,500	500	2,204.7	51,214.9	11.43	31.0781	na	na	500	31.0804	0.0653	0.50475	0.00103	0.50680
athmp15kmr_														
12_2_8_5	6,000	500	9,008.5	51,214.9	41.98	31.0759	na	na	1,000	31.0804	0.0570	0.61042	0.00108	0.61259
12_2_8_4	6,000	500	7,307.6	51,214.9	34.58	31.0759	na	na	1,000	31.0804	0.0584	0.58402	0.00116	0.58635
12_2_8_3	6,000	500	5,606.6	51,214.9	27.18	31.0759	na	na	1,000	31.0804	0.0597	0.56023	0.00112	0.56247

Table 6.9.6-23. Results for HEU broken metal content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	H_2O (g)	Kaolite (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
12_2_8_2	6,000	500	3,905.7	51,214.9	19.79	31.0759	na	na	1,000	31.0804	0.0622	0.53546	0.00120	0.53785
12_2_8_1	6,000	500	2,204.7	51,214.9	12.39	31.0759	na	na	1,000	31.0804	0.0641	0.51198	0.00121	0.51440
athmp15kmr_														
11_3_8_5	5,500	500	9,008.5	51,214.9	45.80	31.0737	na	na	1,500	31.0804	0.0562	0.61411	0.00105	0.61622
11_3_8_4	5,500	500	7,307.6	51,214.9	37.73	31.0737	na	na	1,500	31.0804	0.0580	0.58816	0.00119	0.59055
11_3_8_3	5,500	500	5,606.6	51,214.9	29.66	31.0737	na	na	1,500	31.0804	0.0596	0.56400	0.00110	0.56619
11_3_8_2	5,500	500	3,905.7	51,214.9	21.58	31.0737	na	na	1,500	31.0804	0.0620	0.53899	0.00140	0.54180
11_3_8_1	5,500	500	2,204.7	51,214.9	13.51	31.0737	na	na	1,500	31.0804	0.0643	0.51766	0.00116	0.51999
athmp15kmr_														
10_4_8_5	5,000	500	9,008.5	51,214.9	50.38	31.0715	na	na	2,000	31.0804	0.0561	0.61900	0.00118	0.62136
10_4_8_4	5,000	500	7,307.6	51,214.9	41.50	31.0715	na	na	2,000	31.0804	0.0575	0.59390	0.00121	0.59633
10_4_8_3	5,000	500	5,606.6	51,214.9	32.62	31.0715	na	na	2,000	31.0804	0.0594	0.57154	0.00119	0.57393
10_4_8_2	5,000	500	3,905.7	51,214.9	23.74	31.0715	na	na	2,000	31.0804	0.0609	0.54282	0.00127	0.54536
10_4_8_1	5,000	500	2,204.7	51,214.9	14.86	31.0715	na	na	2,000	31.0804	0.0634	0.52061	0.00121	0.52302
athmp15kmr_														
9_5_8_5	4,500	500	9,008.5	51,214.9	55.98	31.0693	na	na	2,500	31.0804	0.0554	0.62058	0.00116	0.62290
9_5_8_4	4,500	500	7,307.6	51,214.9	46.11	31.0693	na	na	2,500	31.0804	0.0575	0.59711	0.00124	0.59959
9_5_8_3	4,500	500	5,606.6	51,214.9	36.25	31.0693	na	na	2,500	31.0804	0.0590	0.57410	0.00120	0.57651
9_5_8_2	4,500	500	3,905.7	51,214.9	26.38	31.0693	na	na	2,500	31.0804	0.0602	0.54863	0.00137	0.55137
9_5_8_1	4,500	500	2,204.7	51,214.9	16.51	31.0693	na	na	2,500	31.0804	0.0626	0.52393	0.00109	0.52612
athmp15kmr_														
8_6_8_5	4,000	500	9,008.5	51,214.9	62.98	31.0671	na	na	3,000	31.0804	0.0550	0.62552	0.00127	0.62807
8_6_8_4	4,000	500	7,307.6	51,214.9	51.88	31.0671	na	na	3,000	31.0804	0.0567	0.59946	0.00102	0.60150
8_6_8_3	4,000	500	5,606.6	51,214.9	40.78	31.0671	na	na	3,000	31.0804	0.0586	0.57673	0.00115	0.57902

Table 6.9.6-23. Results for HEU broken metal content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	H_2O (g)	Kaolite (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
8_6_8_2	4,000	500	3,905.7	51,214.9	29.68	31.0671	na	na	3,000	31.0804	0.0600	0.54941	0.00110	0.55162
8_6_8_1	4,000	500	2,204.7	51,214.9	18.58	31.0671	na	na	3,000	31.0804	0.0618	0.52536	0.00112	0.52759
athmp15kmr_														
7_7_8_5	3,500	500	9,008.5	51,214.9	71.97	31.0649	na	na	3,500	31.0804	0.0549	0.62911	0.00118	0.63147
7_7_8_4	3,500	500	7,307.6	51,214.9	59.29	31.0649	na	na	3,500	31.0804	0.0559	0.60301	0.00111	0.60524
7_7_8_3	3,500	500	5,606.6	51,214.9	46.60	31.0649	na	na	3,500	31.0804	0.0585	0.58073	0.00114	0.58300
7_7_8_2	3,500	500	3,905.7	51,214.9	33.92	31.0649	na	na	3,500	31.0804	0.0595	0.55359	0.00105	0.55569
7_7_8_1	3,500	500	2,204.7	51,214.9	21.23	31.0649	na	na	3,500	31.0804	0.0616	0.52699	0.00109	0.52917
athmp15kmr_														
6_8_8_5	3,000	500	9,008.5	51,214.9	83.97	31.0627	na	na	4,000	31.0804	0.0546	0.62838	0.00151	0.63139
6_8_8_4	3,000	500	7,307.6	51,214.9	69.17	31.0627	na	na	4,000	31.0804	0.0555	0.60625	0.00125	0.60875
6_8_8_3	3,000	500	5,606.6	51,214.9	54.37	31.0627	na	na	4,000	31.0804	0.0578	0.58134	0.00125	0.58383
6_8_8_2	3,000	500	3,905.7	51,214.9	39.57	31.0627	na	na	4,000	31.0804	0.0594	0.55515	0.00127	0.55768
6_8_8_1	3,000	500	2,204.7	51,214.9	24.77	31.0627	na	na	4,000	31.0804	0.0610	0.53102	0.00108	0.53319
athmp15kmr_														
5_9_8_5	2,500	500	9,008.5	51,214.9	100.76	31.0605	na	na	4,500	31.0804	0.0538	0.63099	0.00114	0.63327
5_9_8_4	2,500	500	7,307.6	51,214.9	83.00	31.0605	na	na	4,500	31.0804	0.0558	0.60575	0.00136	0.60847
5_9_8_3	2,500	500	5,606.6	51,214.9	65.24	31.0605	na	na	4,500	31.0804	0.0567	0.58348	0.00109	0.58565
5_9_8_2	2,500	500	3,905.7	51,214.9	47.48	31.0605	na	na	4,500	31.0804	0.0589	0.55833	0.00117	0.56068
5_9_8_1	2,500	500	2,204.7	51,214.9	29.73	31.0605	na	na	4,500	31.0804	0.0603	0.53262	0.00106	0.53475
athmp15kmr_														
4_10_8_5	2,000	500	9,008.5	51,214.9	125.95	31.0583	na	na	5,000	31.0804	0.0543	0.62891	0.00114	0.63120
4_10_8_4	2,000	500	7,307.6	51,214.9	103.75	31.0583	na	na	5,000	31.0804	0.0550	0.60731	0.00134	0.60999
4_10_8_3	2,000	500	5,606.6	51,214.9	81.55	31.0583	na	na	5,000	31.0804	0.0571	0.58296	0.00114	0.58524

Table 6.9.6-23. Results for HEU broken metal content for air transportation

Case	^{235}U (g)	CH_2 (g)	H_2O (g)	Kaolite (g)	h/x	Rc (cm)	H_2O (g)	Kaolite (g)	Shell (g)	Rs (cm)	NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	core						shell							
4_10_8_2	2,000	500	3,905.7	51,214.9	59.36	31.0583	na	na	5,000	31.0804	0.0585	0.55876	0.00107	0.56090
4_10_8_1	2,000	500	2,204.7	51,214.9	37.16	31.0583	na	na	5,000	31.0804	0.0595	0.53467	0.00107	0.53680
athmp15kmr_														
3_11_8_5	1,500	500	9,008.5	51,214.9	167.93	31.0562	na	na	5,500	31.0804	0.0537	0.62987	0.00112	0.63211
3_11_8_4	1,500	500	7,307.6	51,214.9	138.34	31.0562	na	na	5,500	31.0804	0.0548	0.60668	0.00123	0.60914
3_11_8_3	1,500	500	5,606.6	51,214.9	108.74	31.0562	na	na	5,500	31.0804	0.0562	0.58487	0.00114	0.58715
3_11_8_2	1,500	500	3,905.7	51,214.9	79.14	31.0562	na	na	5,500	31.0804	0.0576	0.56087	0.00115	0.56318
3_11_8_1	1,500	500	2,204.7	51,214.9	49.54	31.0562	na	na	5,500	31.0804	0.0591	0.53887	0.00135	0.54156
athmp15kmr_														
2_12_8_5	1,000	500	9,008.5	51,214.9	251.90	31.0540	na	na	6,000	31.0804	0.0533	0.62727	0.00121	0.62970
2_12_8_4	1,000	500	7,307.6	51,214.9	207.50	31.0540	na	na	6,000	31.0804	0.0544	0.60687	0.00128	0.60942
2_12_8_3	1,000	500	5,606.6	51,214.9	163.11	31.0540	na	na	6,000	31.0804	0.0559	0.58520	0.00134	0.58788
2_12_8_2	1,000	500	3,905.7	51,214.9	118.71	31.0540	na	na	6,000	31.0804	0.0571	0.56092	0.00109	0.56310
2_12_8_1	1,000	500	2,204.7	51,214.9	74.32	31.0540	na	na	6,000	31.0804	0.0587	0.54206	0.00105	0.54415
athmp15kmr_														
1_13_8_5	500	500	9,008.5	51,214.9	503.80	31.0518	na	na	6,500	31.0804	0.0526	0.62145	0.00093	0.62332
1_13_8_4	500	500	7,307.6	51,214.9	415.01	31.0518	na	na	6,500	31.0804	0.0534	0.60274	0.00132	0.60537
1_13_8_3	500	500	5,606.6	51,214.9	326.22	31.0518	na	na	6,500	31.0804	0.0552	0.58252	0.00115	0.58482
1_13_8_2	500	500	3,905.7	51,214.9	237.42	31.0518	na	na	6,500	31.0804	0.0567	0.56327	0.00121	0.56570
1_13_8_1	500	500	2,204.7	51,214.9	148.63	31.0518	na	na	6,500	31.0804	0.0579	0.54039	0.00112	0.54263

Table 6.9.6-24a. Results for compounds for air transportation (Models 1–5)

Case	Core					Shell						
	Compound (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Compromised package, HEU-poly core in spherical configuration, 20.0-cm water reflector (Model 1)												
					UF_4							
atduf4r_1	5.0	3.778	none	na	6.76509	na	na	na	0.64118	0.00068	0.64254	0.93520
atduf4r_2	10.0	7.556	none	na	7.88096	na	na	na	0.69840	0.00063	0.69966	0.93520
atduf4r_3	12.0	9.068	none	na	8.24958	na	na	na	0.71720	0.00065	0.71850	0.93520
atduf4r_4	14.0	10.579	none	na	8.58791	na	na	na	0.73522	0.00060	0.73642	0.93520
atduf4r_5	16.0	12.090	none	na	8.90150	na	na	na	0.75006	0.00075	0.75156	0.93520
atduf4r_6	18.0	13.602	none	na	9.19442	na	na	na	0.76452	0.00065	0.76582	0.93520
atduf4r_7	20.0	15.113	none	na	9.46978	na	na	na	0.77934	0.00065	0.78064	0.93520
atduf4r_8	22.0	16.624	none	na	9.73000	na	na	na	0.79234	0.00066	0.79366	0.93520
atduf4r_9	23.0	17.380	none	na	9.85505	na	na	na	0.79897	0.00059	0.80015	0.93520
atduf4r_10	24.0	18.136	none	na	9.97700	na	na	na	0.80502	0.00086	0.80674	0.93520
					UO_2F_2							
atduo2f2r_1	1.0	0.689	0.105	na	5.64976	na	na	na	0.60199	0.00068	0.60335	0.93680
atduo2f2r_2	2.0	1.378	0.211	na	6.13519	na	na	na	0.64455	0.00077	0.64609	0.93520
atduo2f2r_3	3.0	2.067	0.317	na	6.55398	na	na	na	0.67637	0.00067	0.67771	0.93520
					UC saturated at 2.0 g/cm^3							
atducr_1	0.5	0.476	0.213	na	5.74313	na	na	na	0.61244	0.00077	0.61398	0.93680
atducr_2	1.0	0.951	0.426	na	6.29214	na	na	na	0.67423	0.00073	0.67569	0.93680
atducr_3	1.5	1.427	0.639	na	6.75912	na	na	na	0.71989	0.00081	0.72151	0.93520
atducr_4	2.0	1.902	0.852	na	7.16920	na	na	na	0.75457	0.00067	0.75591	0.93520

Table 6.9.6-24a. Results for compounds for air transportation (Models 1–5)

Case	Core					Shell						
	Compound (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
UN saturated at 2.0 g/cm^3												
atdunr_1	0.5	0.472	0.215	na	5.74313	na	na	na	0.61135	0.00072	0.61279	0.93680
atdunr_2	1.0	0.944	0.429	na	6.29214	na	na	na	0.67413	0.00076	0.67565	0.93680
atdunr_3	1.5	1.415	0.644	na	6.75912	na	na	na	0.71740	0.00074	0.71888	0.93520
atdunr_4	2.0	1.887	0.859	na	7.16920	na	na	na	0.75304	0.00072	0.75448	0.93520
U_3Si_2 saturated at 2.0 g/cm^3, 40% enriched												
atdu3si2r40_1	1.0	0.371	0.422	na	6.29214	na	na	na	0.59809	0.00064	0.59937	0.93680
atdu3si2r40_2	3.0	1.112	1.267	na	7.87216	na	na	na	0.72653	0.00083	0.72819	0.93680
atdu3si2r40_3	5.0	1.853	2.112	na	8.99002	na	na	na	0.80212	0.00074	0.80360	0.93680
atdu3si2r40_4	7.0	2.594	2.956	na	9.88300	na	na	na	0.85815	0.00080	0.85975	0.93680
atdu3si2r40_5	9.0	3.336	3.801	na	10.63850	na	na	na	0.90055	0.00084	0.90223	0.93680
atdu3si2r40_6	10.0	3.706	4.223	na	10.97905	na	na	na	0.91893	0.00081	0.92055	0.93520
atdu3si2r40_7	10.5	3.892	4.434	na	11.14167	na	na	na	0.92864	0.00069	0.93002	0.93520
atdu3si2r40_8	11.0	4.077	4.646	na	11.29968	na	na	na	0.93700	0.00072	0.93844	0.93520
U_3Si_2 saturated at 2.0 g/cm^3, 60% enriched												
atdu3si2r60_1	1.0	0.556	0.422	na	6.29214	na	na	na	0.62682	0.00095	0.62872	0.93680
atdu3si2r60_2	3.0	1.667	1.267	na	7.87216	na	na	na	0.75444	0.00076	0.75596	0.93520
atdu3si2r60_3	5.0	2.779	2.112	na	8.99002	na	na	na	0.83037	0.00070	0.83177	0.93520
atdu3si2r60_4	7.0	3.891	2.956	na	9.88300	na	na	na	0.88575	0.00082	0.88793	0.93520
U_3Si saturated at 2.0 g/cm^3, 40% enriched												
atdu3sir40_1	1.0	0.385	0.428	na	6.29214	na	na	na	0.60113	0.00064	0.60241	0.93680
atdu3sir40_2	3.0	1.154	1.283	na	7.87216	na	na	na	0.72914	0.00066	0.73046	0.93680
atdu3sir40_3	5.0	1.923	2.139	na	8.99002	na	na	na	0.80727	0.00082	0.80891	0.93680

Table 6.9.6-24a. Results for compounds for air transportation (Models 1–5)

Case	Core					Shell						
	Compound (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdu3sir40_4	7.0	2.693	2.995	na	9.88300	na	na	na	0.86294	0.00081	0.86456	0.93680
atdu3sir40_5	9.0	3.463	3.850	na	10.36850	na	na	na	0.90587	0.00067	0.90721	0.93520
atdu3sir40_6	10.0	3.847	4.278	na	10.97905	na	na	na	0.92488	0.00076	0.92640	0.93520
atdu3sir40_7	10.5	4.040	4.492	na	11.14167	na	na	na	0.93474	0.00079	0.93632	0.93520
U_3Si saturated at 2.0 g/cm^3, 60% enriched												
atdu3sir60_1	1.0	0.577	0.428	na	6.29214	na	na	na	0.62816	0.00063	0.62942	0.93680
atdu3sir60_2	3.0	1.731	1.283	na	7.87216	na	na	na	0.75810	0.00068	0.75946	0.93520
atdu3si260_3	5.0	2.885	2.139	na	8.99002	na	na	na	0.83662	0.00068	0.83798	0.93520
atdu3si260_4	7.0	4.039	2.995	na	9.88300	na	na	na	0.89133	0.00077	0.89287	0.93520
atdu3si260_5	8.5	4.905	3.636	na	10.45974	na	na	na	0.92257	0.00075	0.92407	0.93520
Compromised package, HEU-poly core in spherical configuration, stainless-steel shell, 20.0-cm water reflector (Model 2)												
UF_4												
atduf4sr_1	24.0	18.136	none	na	9.97700	na	na	9.9771	0.80338	0.00060	0.80458	0.93520
atduf4sr_2	24.0	18.136	none	na	9.97700	na	na	10.6029	0.75768	0.00063	0.75894	0.93520
atduf4sr_3	24.0	18.136	none	na	9.97700	na	na	11.1624	0.72881	0.00057	0.72995	0.93520
atduf4sr_4	24.0	18.136	none	na	9.97700	na	na	11.6709	0.71286	0.00059	0.71404	0.93520
atduf4sr_5	24.0	18.136	none	na	9.97700	na	na	12.1385	0.70681	0.00078	0.70837	0.93520
atduf4sr_6	24.0	18.136	none	na	9.97700	na	na	12.5726	0.70573	0.00062	0.70697	0.93520
atduf4sr_7	24.0	18.136	none	na	9.97700	na	na	12.9787	0.70525	0.00056	0.70637	0.93520
atduf4sr_8	24.0	18.136	none	na	9.97700	na	na	13.3608	0.70670	0.00055	0.70780	0.93520
atduf4sr_9	24.0	18.136	none	na	9.97700	na	na	13.7223	0.70880	0.00065	0.71010	0.93520
atduf4sr_10	24.0	18.136	none	na	9.97700	na	na	14.0656	0.71128	0.00059	0.71246	0.93520
atduf4sr_11	24.0	18.136	none	na	9.97700	na	na	14.3930	0.71542	0.00064	0.71670	0.93520

Table 6.9.6-24a. Results for compounds for air transportation (Models 1–5)

Case	Core					Shell						
	Compound (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
					UO_2F_2							
atduo2f2sr_1	3.0	2.067	0.317	na	6.55398	na	na	6.5541	0.67683	0.00070	0.67823	0.93520
atduo2f2sr_2	3.0	2.067	0.317	na	6.55398	na	na	7.8318	0.60466	0.00065	0.60596	0.93520
atduo2f2sr_3	3.0	2.067	0.317	na	6.55398	na	na	8.7904	0.59062	0.00065	0.59152	0.93520
atduo2f2sr_4	3.0	2.067	0.317	na	6.55398	na	na	9.5759	0.59410	0.00067	0.59544	0.93520
atduo2f2sr_5	3.0	2.067	0.317	na	6.55398	na	na	10.2501	0.59781	0.00069	0.59919	0.93520
atduo2f2sr_6	3.0	2.067	0.317	na	6.55398	na	na	10.8457	0.60384	0.00064	0.60512	0.93520
atduo2f2sr_7	3.0	2.067	0.317	na	6.55398	na	na	11.3822	0.60890	0.00077	0.61044	0.93520
atduo2f2sr_8	3.0	2.067	0.317	na	6.55398	na	na	11.8724	0.61270	0.00073	0.61416	0.93520
atduo2f2sr_9	3.0	2.067	0.317	na	6.55398	na	na	12.3252	0.61748	0.00078	0.61904	0.93520
atduo2f2sr_10	3.0	2.067	0.317	na	6.55398	na	na	12.7469	0.62102	0.00059	0.62220	0.93520
atduo2f2sr_11	3.0	2.067	0.317	na	6.55398	na	na	13.1424	0.62477	0.00068	0.62613	0.93520
					UC saturated at 2.0 g/cm^3							
atducsr_11	2.0	1.902	0.852	na	7.16920	na	na	13.3081	0.72067	0.00086	0.72239	0.93520
atducsr_10	2.0	1.902	0.852	na	7.16920	na	na	12.9228	0.71551	0.00072	0.71695	0.93520
atducsr_9	2.0	1.902	0.852	na	7.16920	na	na	12.5131	0.71137	0.00069	0.71275	0.93520
atducsr_8	2.0	1.902	0.852	na	7.16920	na	na	12.0746	0.70655	0.00089	0.70833	0.93520
atducsr_7	2.0	1.902	0.852	na	7.16920	na	na	11.6017	0.70102	0.00068	0.70238	0.93520
atducsr_6	2.0	1.902	0.852	na	7.16920	na	na	11.0867	0.69397	0.00086	0.69569	0.93520
atducsr_5	2.0	1.902	0.852	na	7.16920	na	na	10.5189	0.68946	0.00074	0.69094	0.93520
atducsr_4	2.0	1.902	0.852	na	7.16920	na	na	9.8821	0.68349	0.00064	0.68477	0.93520
atducsr_3	2.0	1.902	0.852	na	7.16920	na	na	9.1505	0.68310	0.00067	0.68444	0.93520
atducsr_2	2.0	1.902	0.852	na	7.16920	na	na	8.2784	0.69389	0.00066	0.69521	0.93520
atducsr_1	2.0	1.902	0.852	na	7.16920	na	na	7.1693	0.75499	0.00076	0.75651	0.93520

Table 6.9.6-24a. Results for compounds for air transportation (Models 1–5)

Case	Core					Shell						
	Compound (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
UN saturated at 2.0 g/cm^3												
atdunsr_11	2.0	1.887	0.859	na	7.16920	na	na	13.3081	0.72034	0.00074	0.72182	0.93520
atdunsr_10	2.0	1.887	0.859	na	7.16920	na	na	12.9228	0.71534	0.00075	0.71684	0.93520
atdunsr_9	2.0	1.887	0.859	na	7.16920	na	na	12.5131	0.71075	0.00075	0.71225	0.93520
atdunsr_8	2.0	1.887	0.859	na	7.16920	na	na	12.0746	0.70621	0.00070	0.70761	0.93520
atdunsr_7	2.0	1.887	0.859	na	7.16920	na	na	11.6017	0.70080	0.00068	0.70216	0.93520
atdunsr_6	2.0	1.887	0.859	na	7.16920	na	na	11.0867	0.69526	0.00082	0.69690	0.93520
atdunsr_5	2.0	1.887	0.859	na	7.16920	na	na	10.5189	0.69009	0.00067	0.69143	0.93520
atdunsr_4	2.0	1.887	0.859	na	7.16920	na	na	9.8821	0.68484	0.00083	0.68650	0.93520
atdunsr_3	2.0	1.887	0.859	na	7.16920	na	na	9.1505	0.68252	0.00072	0.68396	0.93520
atdunsr_2	2.0	1.887	0.859	na	7.16920	na	na	8.2784	0.69235	0.00080	0.69395	0.93520
atdunsr_1	2.0	1.887	0.859	na	7.16920	na	na	7.1693	0.75410	0.00070	0.75550	0.93520
U_3Si_2 saturated at 2.0 g/cm^3, 40% enriched												
atdu3si2sr40_11	10.5	3.892	4.434	na	11.14167	na	na	14.9949	0.88922	0.00080	0.89082	0.93520
atdu3si2sr40_10	10.5	3.892	4.434	na	11.14167	na	na	14.6942	0.88574	0.00076	0.88726	0.93520
atdu3si2sr40_9	10.5	3.892	4.434	na	11.14167	na	na	14.3805	0.88495	0.00077	0.88649	0.93520
atdu3si2sr40_8	10.5	3.892	4.434	na	11.14167	na	na	14.0526	0.87966	0.00070	0.88106	0.93520
atdu3si2sr40_7	10.5	3.892	4.434	na	11.14167	na	na	13.7086	0.87607	0.00079	0.87765	0.93520
atdu3si2sr40_6	10.5	3.892	4.434	na	11.14167	na	na	13.3464	0.87299	0.00078	0.87455	0.93520
atdu3si2sr40_5	10.5	3.892	4.434	na	11.14167	na	na	12.9634	0.87220	0.00073	0.87366	0.93520
atdu3si2sr40_4	10.5	3.892	4.434	na	11.14167	na	na	12.5564	0.87390	0.00074	0.87538	0.93520
atdu3si2sr40_3	10.5	3.892	4.434	na	11.14167	na	na	12.1210	0.87926	0.00083	0.88092	0.93520
atdu3si2sr40_2	10.5	3.892	4.434	na	11.14167	na	na	11.6520	0.89451	0.00075	0.89601	0.93520
atdu3si2sr40_1	10.5	3.892	4.434	na	11.14167	na	na	11.14167	0.92864	0.00069	0.93002	0.93520

Table 6.9.6-24a. Results for compounds for air transportation (Models 1–5)

Case	Core					Shell						
	Compound (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
U_3Si_2 saturated at 2.0 g/cm^3, 60% enriched												
atdu3si2sr60_11	7.0	3.891	2.956	na	9.88300	na	na	14.3481	0.84917	0.00071	0.85059	0.93520
atdu3si2sr60_10	7.0	3.891	2.956	na	9.88300	na	na	14.0186	0.84653	0.00078	0.84809	0.93520
atdu3si2sr60_9	7.0	3.891	2.956	na	9.88300	na	na	13.6729	0.84128	0.00083	0.84294	0.93520
atdu3si2sr60_8	7.0	3.891	2.956	na	9.88300	na	na	13.3087	0.83740	0.00071	0.83882	0.93520
atdu3si2sr60_7	7.0	3.891	2.956	na	9.88300	na	na	12.9234	0.83410	0.00071	0.83552	0.93520
atdu3si2sr60_6	7.0	3.891	2.956	na	9.88300	na	na	12.5137	0.82858	0.00071	0.83000	0.93520
atdu3si2sr60_5	7.0	3.891	2.956	na	9.88300	na	na	12.0753	0.82726	0.00069	0.82864	0.93520
atdu3si2sr60_4	7.0	3.891	2.956	na	9.88300	na	na	11.6024	0.82537	0.00073	0.82683	0.93520
atdu3si2sr60_3	7.0	3.891	2.956	na	9.88300	na	na	11.0875	0.83054	0.00094	0.83242	0.93520
atdu3si2sr60_2	7.0	3.891	2.956	na	9.88300	na	na	10.5198	0.84590	0.00076	0.84742	0.93520
atdu3si2sr60_1	7.0	3.891	2.956	na	9.88300	na	na	9.8831	0.88594	0.00087	0.88768	0.93520
U_3Si saturated at 2.0 g/cm^3, 40% enriched												
atdu3sisr40_11	10.0	3.847	4.278	na	10.97905	na	na	14.90594	0.88643	0.00088	0.88819	0.93520
atdu3sisr40_10	10.0	3.847	4.278	na	10.97905	na	na	14.60144	0.88446	0.00079	0.88604	0.93520
atdu3sisr40_9	10.0	3.847	4.278	na	10.97905	na	na	14.28370	0.88020	0.00082	0.88184	0.93520
atdu3sisr40_8	10.0	3.847	4.278	na	10.97905	na	na	13.95113	0.87651	0.00074	0.87799	0.93520
atdu3sisr40_7	10.0	3.847	4.278	na	10.97905	na	na	13.6019	0.87312	0.00067	0.87446	0.93520
atdu3sisr40_6	10.0	3.847	4.278	na	10.97905	na	na	13.2338	0.87111	0.00070	0.87251	0.93520
atdu3sisr40_5	10.0	3.847	4.278	na	10.97905	na	na	12.8440	0.86826	0.00078	0.86982	0.93520
atdu3sisr40_4	10.0	3.847	4.278	na	10.97905	na	na	12.4289	0.86972	0.00076	0.87124	0.93520
atdu3sisr40_3	10.0	3.847	4.278	na	10.97905	na	na	11.9841	0.87530	0.00100	0.87730	0.93520
atdu3sisr40_2	10.0	3.847	4.278	na	10.97905	na	na	11.5036	0.89108	0.00071	0.89250	0.93520
atdu3sisr40_1	10.0	3.847	4.278	na	10.97905	na	na	10.9791	0.92488	0.00076	0.92640	0.93520

Table 6.9.6-24a. Results for compounds for air transportation (Models 1–5)

Case	Core					Shell						
	Compound (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
U_3Si saturated at 2.0 g/cm^3, 60% enriched												
atdu3sisr60_11	8.5	4.905	3.636	na	10.45974	na	na	14.6323	0.88987	0.00071	0.89129	0.93520
atdu3sisr60_10	8.5	4.905	3.636	na	10.45974	na	na	14.3160	0.88594	0.00069	0.88732	0.93520
atdu3sisr60_9	8.5	4.905	3.636	na	10.45974	na	na	13.9850	0.88160	0.00081	0.88322	0.93520
atdu3sisr60_8	8.5	4.905	3.636	na	10.45974	na	na	13.6375	0.87975	0.00075	0.88125	0.93520
atdu3sisr60_7	8.5	4.905	3.636	na	10.45974	na	na	13.2714	0.87606	0.00091	0.87788	0.93520
atdu3sisr60_6	8.5	4.905	3.636	na	10.45974	na	na	12.8838	0.87204	0.00092	0.87388	0.93520
atdu3sisr60_5	8.5	4.905	3.636	na	10.45974	na	na	12.4715	0.87096	0.00091	0.87278	0.93520
atdu3sisr60_4	8.5	4.905	3.636	na	10.45974	na	na	12.0299	0.87092	0.00069	0.87230	0.93520
atdu3sisr60_3	8.5	4.905	3.636	na	10.45974	na	na	11.5532	0.87739	0.00087	0.87913	0.93520
atdu3sisr60_2	8.5	4.905	3.636	na	10.45974	na	na	11.0336	0.89161	0.00080	0.89321	0.93520
atdu3sisr60_1	8.5	4.905	3.636	na	10.45974	na	na	10.45974	0.92509	0.00094	0.92697	0.93520
Compromised package, HEU-poly core in spherical configuration, dry (bound water) Kaolite shell, 20.0-cm water reflector (Model 3)												
UF_4, Kaolite from full amount in the packaging (53,419.1 g) to none												
atduf4dkr_6	24.0	18.136	none	na	9.97700	51.215	2.204	31.3452	0.59392	0.00059	0.59510	0.93520
atduf4dkr_5	24.0	18.136	none	na	9.97700	40.972	1.763	29.1763	0.60238	0.00059	0.60359	0.93520
atduf4dkr_4	24.0	18.136	none	na	9.97700	30.727	1.322	26.6257	0.61342	0.00060	0.61462	0.93520
atduf4dkr_3	24.0	18.136	none	na	9.97700	20.486	0.881	23.4619	0.63142	0.00054	0.63250	0.93520
atduf4dkr_2	24.0	18.136	none	na	9.97700	10.243	0.440	19.0874	0.66716	0.00058	0.66832	0.93520
atduf4dkr_1	24.0	18.136	none	na	9.97700	0	0.0	9.9770	0.80502	0.00086	0.80674	0.93520
UO_2F_2, Kaolite from full amount in the packaging (53,419.1 g) to none												
atduo2f2dkr_6	3.0	2.067	0.317	na	6.55398	51.215	2.204	31.1020	0.43213	0.00055	0.43323	0.93520
atduo2f2dkr_5	3.0	2.067	0.317	na	6.55398	40.972	1.763	28.8950	0.43745	0.00062	0.43869	0.93520
atduo2f2dkr_4	3.0	2.067	0.317	na	6.55398	30.727	1.322	26.2869	0.44434	0.00058	0.44550	0.93520

Table 6.9.6-24a. Results for compounds for air transportation (Models 1–5)

Case	Core					Shell						
	Compound (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atduo2f2dkr_3	3.0	2.067	0.317	na	6.55398	20.486	0.881	23.0229	0.45678	0.00055	0.45788	0.93520
atduo2f2dkr_2	3.0	2.067	0.317	na	6.55398	10.243	0.440	18.4127	0.48192	0.00058	0.48308	0.93520
atduo2f2dkr_1	3.0	2.067	0.317	na	6.55398	0	0.0	6.5541	0.67752	0.00069	0.67890	0.93520
UC saturated at 2.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none												
atducdkr_6	2.0	1.902	0.852	na	7.16920	51.215	2.204	31.1319	0.51606	0.00071	0.51748	0.93520
atducdkr_5	2.0	1.902	0.852	na	7.16920	40.972	1.763	28.9297	0.52260	0.00075	0.52410	0.93520
atducdkr_4	2.0	1.902	0.852	na	7.16920	30.727	1.322	26.3287	0.52773	0.00066	0.52905	0.93520
atducdkr_3	2.0	1.902	0.852	na	7.16920	20.486	0.881	23.0774	0.54165	0.00071	0.54307	0.93520
atducdkr_2	2.0	1.902	0.852	na	7.16920	10.243	0.440	18.4978	0.56826	0.00061	0.56948	0.93520
atducdkr_1	2.0	1.902	0.852	na	7.16920	0	0.0	7.1693	0.75461	0.00074	0.75609	0.93520
UN saturated at 2.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none												
atdundkr_6	2.0	1.887	0.859	na	7.16920	51.215	2.204	31.1319	0.51747	0.00076	0.51899	0.93520
atdundkr_5	2.0	1.887	0.859	na	7.16920	40.972	1.763	28.9297	0.52314	0.00074	0.52462	0.93520
atdundkr_4	2.0	1.887	0.859	na	7.16920	30.727	1.322	26.3287	0.53142	0.00077	0.53296	0.93520
atdundkr_3	2.0	1.887	0.859	na	7.16920	20.486	0.881	23.0774	0.54135	0.00068	0.54271	0.93520
atdundkr_2	2.0	1.887	0.859	na	7.16920	10.243	0.440	18.4978	0.56863	0.00066	0.56995	0.93520
atdundkr_1	2.0	1.887	0.859	na	7.16920	0	0.0	7.1693	0.75446	0.00087	0.75620	0.93520
U_3Si_2 saturated at 2.0 g/cm^3, 40% enriched, Kaolite from full amount in the packaging (53,419.1 g) to none												
atdu3si2dkr40_6	10.5	3.892	4.434	na	11.14167	51.215	2.204	31.4770	0.75740	0.00079	0.75898	0.93520
atdu3si2dkr40_5	10.5	3.892	4.434	na	11.14167	40.972	1.763	29.3283	0.76375	0.00085	0.76545	0.93520
atdu3si2dkr40_4	10.5	3.892	4.434	na	11.14167	30.727	1.322	26.8078	0.77397	0.00075	0.77547	0.93520
atdu3si2dkr40_3	10.5	3.892	4.434	na	11.14167	20.486	0.881	23.6957	0.78824	0.00083	0.78990	0.93520
atdu3si2dkr40_2	10.5	3.892	4.434	na	11.14167	10.243	0.440	19.4377	0.81730	0.00073	0.81876	0.93520
atdu3si2dkr40_1	10.5	3.892	4.434	na	11.14167	0	0.0	11.1417	0.92864	0.00069	0.93002	0.93520

Table 6.9.6-24a. Results for compounds for air transportation (Models 1–5)

Case	Core					Shell						
	Compound (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
U_3Si_2 saturated at 2.0 g/cm^3, 60% enriched, Kaolite from full amount in the packaging (53,419.1 g) to none												
atdu3si2dkr60_6	7.0	3.891	2.956	na	9.88300	51.215	2.204	31.3358	0.69256	0.00086	0.69428	0.93520
atdu3si2dkr60_5	7.0	3.891	2.956	na	9.88300	40.972	1.763	29.1655	0.70034	0.00070	0.70174	0.93520
atdu3si2dkr60_4	7.0	3.891	2.956	na	9.88300	30.727	1.322	26.6127	0.70951	0.00063	0.71077	0.93520
atdu3si2dkr60_3	7.0	3.891	2.956	na	9.88300	20.486	0.881	23.4451	0.72537	0.00067	0.72671	0.93520
atdu3si2dkr60_2	7.0	3.891	2.956	na	9.88300	10.243	0.440	19.0619	0.75480	0.00100	0.74680	0.93520
atdu3si2dkr60_1	7.0	3.891	2.956	na	9.88300	0	0.0	9.8831	0.88539	0.00082	0.88703	0.93520
U_3Si saturated at 2.0 g/cm^3, 40% enriched, Kaolite from full amount in the packaging (53,419.1 g) to none												
atdu3sidkr40_6	10.00	3.847	4.278	na	10.97905	51.215	2.204	31.45691	0.75265	0.00069	0.75403	0.93520
atdu3sidkr40_5	10.00	3.847	4.278	na	10.97905	40.972	1.763	29.30511	0.75838	0.00077	0.75992	0.93520
atdu3sidkr40_4	10.00	3.847	4.278	na	10.97905	30.727	1.322	26.78014	0.76912	0.00071	0.77054	0.93520
atdu3sidkr40_3	10.00	3.847	4.278	na	10.97905	20.486	0.881	23.66026	0.78263	0.00083	0.78429	0.93520
atdu3sidkr40_2	10.00	3.847	4.278	na	10.97905	10.243	0.440	19.38489	0.81114	0.00073	0.81260	0.93520
atdu3sidkr40_1	10.00	3.847	4.278	na	10.97905	0	0.0	10.97905	0.92488	0.00076	0.92640	0.93520
U_3Si saturated at 2.0 g/cm^3, 60% enriched, Kaolite from full amount in the packaging (53,419.1 g) to none												
atdu3sidkr60_6	8.5	4.905	3.636	na	10.45974	51.215	2.204	31.39648	0.74636	0.00067	0.74770	0.93520
atdu3sidkr60_5	8.5	4.905	3.636	na	10.45974	40.972	1.763	29.23545	0.75161	0.00078	0.75319	0.93520
atdu3sidkr60_4	8.5	4.905	3.636	na	10.45974	30.727	1.322	26.69666	0.76114	0.00089	0.76292	0.93520
atdu3sidkr60_3	8.5	4.905	3.636	na	10.45974	20.486	0.881	23.55316	0.77576	0.00080	0.77736	0.93520
atdu3sidkr60_2	8.5	4.905	3.636	na	10.45974	10.243	0.440	19.22474	0.80559	0.00070	0.80699	0.93520
atdu3sidkr60_1	8.5	4.905	3.636	na	10.45974	0	0.0	10.45974	0.92509	0.00094	0.92697	0.93520
Compromised package, HEU-poly core in sph. config., wet (bound plus 15-lb free water) Kaolite shell, 20.0-cm water reflector (Model 3)												
UF_4, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none												
atduf415kr_6	24.0	18.136	none	na	9.97700	51.215	9.009	31.3452	0.60231	0.00054	0.60339	0.93520
atduf415kr_5	24.0	18.136	none	na	9.97700	40.971	7.207	29.1763	0.60824	0.00058	0.60940	0.93520

Table 6.9.6-24a. Results for compounds for air transportation (Models 1–5)

Case	Core					Shell						
	Compound (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atduf415kr_4	24.0	18.136	none	na	9.97700	30.728	5.405	26.6257	0.61868	0.00053	0.61974	0.93520
atduf415kr_3	24.0	18.136	none	na	9.97700	20.485	3.604	23.4619	0.63367	0.00054	0.63475	0.93520
atduf415kr_2	24.0	18.136	none	na	9.97700	10.242	1.801	19.0874	0.66658	0.00058	0.66774	0.93520
atduf415kr_1	24.0	18.136	none	na	9.97700	0	0	9.97700	0.80472	0.00057	0.80586	0.93520
UO_2F_2, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none												
atduo2f215kr_6	3.0	2.067	0.317	na	6.55398	51.215	9.009	31.1019	0.44452	0.00058	0.44568	0.93520
atduo2f215kr_5	3.0	2.067	0.317	na	6.55398	40.971	7.207	28.8950	0.44680	0.00065	0.44810	0.93520
atduo2f215kr_4	3.0	2.067	0.317	na	6.55398	30.728	5.405	26.2869	0.45310	0.00065	0.45440	0.93520
atduo2f215kr_3	3.0	2.067	0.317	na	6.55398	20.485	3.604	23.0229	0.46302	0.00058	0.46418	0.93520
atduo2f215kr_2	3.0	2.067	0.317	na	6.55398	10.242	1.802	18.4127	0.48668	0.00059	0.48786	0.93520
atduo2f215kr_1	3.0	2.067	0.317	na	6.55398	0	0	6.5541	0.67673	0.00074	0.67821	0.93520
UC saturated at 2.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none												
atduc15kr_6	2.0	1.902	0.852	na	7.16920	51.215	9.009	31.1319	0.52976	0.00069	0.53114	0.93520
atduc15kr_5	2.0	1.902	0.852	na	7.16920	40.971	7.207	28.9297	0.53179	0.00077	0.53333	0.93520
atduc15kr_4	2.0	1.902	0.852	na	7.16920	30.728	5.405	26.3287	0.53956	0.00066	0.54088	0.93520
atduc15kr_3	2.0	1.902	0.852	na	7.16920	20.485	3.604	23.0774	0.54849	0.00059	0.54967	0.93520
atduc15kr_2	2.0	1.902	0.852	na	7.16920	10.242	1.802	18.4978	0.57317	0.00065	0.57447	0.93520
atduc15kr_1	2.0	1.902	0.852	na	7.16920	0	0	7.1693	0.75516	0.00072	0.75660	0.93520
UN saturated at 2.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none												
atdun15kr_6	2.0	1.887	0.859	na	7.16920	51.215	9.009	31.1319	0.52926	0.00075	0.53076	0.93520
atdun15kr_5	2.0	1.887	0.859	na	7.16920	40.971	7.207	28.9297	0.53431	0.00064	0.53559	0.93520
atdun15kr_4	2.0	1.887	0.859	na	7.16920	30.728	5.405	26.3287	0.53910	0.00067	0.54044	0.93520
atdun15kr_3	2.0	1.887	0.859	na	7.16920	20.485	3.604	23.0774	0.54974	0.00071	0.55116	0.93520
atdun15kr_2	2.0	1.887	0.859	na	7.16920	10.242	1.802	18.4978	0.57336	0.00069	0.57474	0.93520
atdun15kr_1	2.0	1.887	0.859	na	7.16920	0	0	7.1693	0.75428	0.00079	0.75586	0.93520

Table 6.9.6-24a. Results for compounds for air transportation (Models 1–5)

Case	Core					Shell						
	Compound (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
U_3Si_2 saturated at 2.0 g/cm^3, 40% enriched, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none												
atdu3si215kr40_6	10.5	3.892	4.434	na	11.14167	51.215	9.009	31.4770	0.76699	0.00087	0.76873	0.93520
atdu3si215kr40_5	10.5	3.892	4.434	na	11.14167	40.971	7.207	29.3283	0.77260	0.00100	0.77460	0.93520
atdu3si215kr40_4	10.5	3.892	4.434	na	11.14167	30.728	5.405	26.8078	0.77930	0.00089	0.78108	0.93520
atdu3si215kr40_3	10.5	3.892	4.434	na	11.14167	20.485	3.604	23.6957	0.79340	0.00073	0.79486	0.93520
atdu3si215kr40_2	10.5	3.892	4.434	na	11.14167	10.242	1.802	19.4377	0.81983	0.00075	0.82133	0.93520
atdu3si215kr40_1	10.5	3.892	4.434	na	11.14167	0	0	11.1417	0.92864	0.00069	0.93002	0.93520
U_3Si_2 saturated at 2.0 g/cm^3, 60% enriched, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none												
atdu3si215kr60_6	7.0	3.891	2.956	na	9.88300	51.215	9.009	31.3358	0.70659	0.00078	0.70815	0.93520
atdu3si215kr60_5	7.0	3.891	2.956	na	9.88300	40.971	7.207	29.1655	0.70991	0.00079	0.71149	0.93520
atdu3si215kr60_4	7.0	3.891	2.956	na	9.88300	30.728	5.405	26.6127	0.71638	0.00087	0.71812	0.93520
atdu3si215kr60_3	7.0	3.891	2.956	na	9.88300	20.485	3.604	23.4451	0.73071	0.00082	0.73235	0.93520
atdu3si215kr60_2	7.0	3.891	2.956	na	9.88300	10.242	1.802	19.0619	0.75667	0.00081	0.75829	0.93520
atdu3si215kr60_1	7.0	3.891	2.956	na	9.88300	0	0	9.8831	0.88544	0.00074	0.88692	0.93520
U_3Si saturated at 2.0 g/cm^3, 40% enriched, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none												
atdu3si15kr40_6	10.00	3.847	4.278	na	10.97905	51.215	9.009	31.45691	0.76191	0.00088	0.76367	0.93520
atdu3sid15r40_5	10.00	3.847	4.278	na	10.97905	40.971	7.207	29.30511	0.76763	0.00087	0.76937	0.93520
atdu3si15kr40_4	10.00	3.847	4.278	na	10.97905	30.728	5.405	26.78014	0.77568	0.00072	0.77712	0.93520
atdu3si15kr40_3	10.00	3.847	4.278	na	10.97905	20.485	3.604	23.66026	0.78906	0.00067	0.79040	0.93520
atdu3si15kr40_2	10.00	3.847	4.278	na	10.97905	10.242	1.802	19.38489	0.81484	0.00074	0.81632	0.93520
atdu3si15kr40_1	10.00	3.847	4.278	na	10.97905	0	0	10.97905	0.92488	0.00076	0.92640	0.93520
U_3Si saturated at 2.0 g/cm^3, 60% enriched, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none												
atdu3si15kr60_6	8.5	4.905	3.636	na	10.45974	51.215	9.009	31.45974	0.75626	0.00080	0.75786	0.93520
atdu3sid15r60_5	8.5	4.905	3.636	na	10.45974	40.972	7.207	29.23545	0.76098	0.00077	0.76252	0.93520
atdu3si15kr60_4	8.5	4.905	3.636	na	10.45974	30.727	5.405	26.69666	0.76922	0.00077	0.77076	0.93520

Table 6.9.6-24a. Results for compounds for air transportation (Models 1–5)

Case	Core					Shell						
	Compound (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdu3si15kr60_3	8.5	4.905	3.636	na	10.45974	20.486	3.604	23.55316	0.78210	0.00081	0.78372	0.93520
atdu3si15kr60_2	8.5	4.905	3.636	na	10.45974	10.243	1.802	19.22474	0.80786	0.00074	0.80934	0.93520
atdu3si15kr60_1	8.5	4.905	3.636	na	10.45974	0	0	10.45974	0.92509	0.00094	0.92697	0.93520
Compromised package, homogeneous fixed-radius core [HEU, poly, wet Kaolite], 20.0-cm water reflector (Model 4)												
UF_4												
athuf4p15kr_5	24.0	18.136	9.009	51.215	31.34526	na	na	na	0.66012	0.00066	0.66144	0.93680
athuf4p15kr_4	24.0	18.136	7.308	51.215	31.34526	na	na	na	0.63631	0.00067	0.63765	0.93680
athuf4p15kr_3	24.0	18.136	5.607	51.215	31.34526	na	na	na	0.61210	0.00071	0.61352	0.93680
athuf4p15kr_2	24.0	18.136	3.905	51.215	31.34526	na	na	na	0.58940	0.00100	0.59140	0.93680
athuf4p15kr_1	24.0	18.136	2.205	51.215	31.34526	na	na	na	0.56642	0.00067	0.56776	0.93680
UO_2F_2												
athuo2f2p15kr_5	3.0	2.067	9.325	51.215	31.10196	na	na	na	0.47687	0.00055	0.47797	0.93680
athuo2f2p15kr_4	3.0	2.067	7.624	51.215	31.10196	na	na	na	0.45723	0.00056	0.45835	0.93680
athuo2f2p15kr_3	3.0	2.067	5.924	51.215	31.10196	na	na	na	0.43908	0.00054	0.44016	0.93680
athuo2f2p15kr_2	3.0	2.067	4.223	51.215	31.10196	na	na	na	0.42089	0.00059	0.42207	0.93680
athuo2f2p15kr_1	3.0	2.067	2.522	51.215	31.10196	na	na	na	0.40347	0.00061	0.40469	0.93680
UC saturated at 2.0 g/cm^3												
athucp15kr_5	2.0	1.902	9.860	51.215	31.13189	na	na	na	0.47139	0.00055	0.47249	0.93680
athucp15kr_4	2.0	1.902	8.159	51.215	31.13189	na	na	na	0.45275	0.00057	0.45389	0.93680
athucp15kr_3	2.0	1.902	6.458	51.215	31.13189	na	na	na	0.43487	0.00053	0.43593	0.93680
athucp15kr_2	2.0	1.902	4.757	51.215	31.13189	na	na	na	0.41648	0.00056	0.41760	0.93680
athucp15kr_1	2.0	1.902	3.056	51.215	31.13189	na	na	na	0.39962	0.00049	0.40060	0.93680
UN saturated at 2.0 g/cm^3												
athunp15kr_5	2.0	1.887	9.867	51.215	31.13189	na	na	na	0.46882	0.00056	0.46994	0.93680
athunp15kr_4	2.0	1.887	8.166	51.215	31.13189	na	na	na	0.45081	0.00058	0.45197	0.93680

Table 6.9.6-24a. Results for compounds for air transportation (Models 1–5)

Case	Core					Shell						
	Compound (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athunp15kr_3	2.0	1.887	6.465	51.215	31.13189	na	na	na	0.43228	0.00061	0.53350	0.93680
athunp15kr_2	2.0	1.887	4.765	51.215	31.13189	na	na	na	0.41452	0.00057	0.41566	0.93680
athunp15kr_1	2.0	1.887	3.064	51.215	31.13189	na	na	na	0.39808	0.00053	0.39914	0.93680
U_3Si_2 saturated at 2.0 g/cm^3, 40% enriched												
athu3si2p15kr40_5	10.5	3.892	13.443	51.215	31.47701	na	na	na	0.58115	0.00061	0.58237	0.93680
athu3si2p15kr40_4	10.5	3.892	11.742	51.215	31.47701	na	na	na	0.55793	0.00066	0.55925	0.93680
athu3si2p15kr40_3	10.5	3.892	10.041	51.215	31.47701	na	na	na	0.53958	0.00057	0.54072	0.93680
athu3si2p15kr40_2	10.5	3.892	8.340	51.215	31.47701	na	na	na	0.51775	0.00060	0.51895	0.93680
athu3si2p15kr40_1	10.5	3.892	6.639	51.215	31.47701	na	na	na	0.49908	0.00060	0.50028	0.93680
U_3Si_2 saturated at 2.0 g/cm^3, 60% enriched												
athu3si2p15kr60_5	7.0	3.891	11.965	51.215	31.33582	na	na	na	0.56790	0.00060	0.56910	0.93680
athu3si2p15kr60_4	7.0	3.891	10.264	51.215	31.33582	na	na	na	0.54688	0.00068	0.54824	0.93680
athu3si2p15kr60_3	7.0	3.891	8.563	51.215	31.33582	na	na	na	0.52643	0.00061	0.52765	0.93680
athu3si2p15kr60_2	7.0	3.891	6.862	51.215	31.33582	na	na	na	0.50475	0.00059	0.50593	0.93680
athu3si2p15kr60_1	7.0	3.891	5.161	51.215	31.33582	na	na	na	0.48560	0.00057	0.48674	0.93680
U_3Si saturated at 2.0 g/cm^3, 40% enriched												
athu3sip15kr40_5	10.00	3.847	13.287	51.215	31.47701	na	na	na	0.58115	0.00061	0.58237	0.93680
athu3sip15kr40_4	10.00	3.847	11.586	51.215	31.47701	na	na	na	0.55793	0.00066	0.55925	0.93680
athu3sip15kr40_3	10.00	3.847	9.885	51.215	31.47701	na	na	na	0.53958	0.00057	0.54072	0.93680
athu3sip15kr40_2	10.00	3.847	8.184	51.215	31.47701	na	na	na	0.51775	0.00060	0.51895	0.93680
athu3sip15kr40_1	10.00	3.847	6.483	51.215	31.47701	na	na	na	0.49908	0.00060	0.50028	0.93680
U_3Si saturated at 2.0 g/cm^3, 60% enriched												
athu3sip15kr60_5	8.5	4.905	12.645	51.215	31.39648	na	na	na	0.59821	0.00064	0.59949	0.93680
athu3sip15kr60_4	8.5	4.905	10.944	51.215	31.39648	na	na	na	0.57559	0.00072	0.57703	0.93680
athu3sip15kr60_3	8.5	4.905	9.243	51.215	31.39648	na	na	na	0.55353	0.00064	0.55481	0.93680

Table 6.9.6-24a. Results for compounds for air transportation (Models 1–5)

Case	Core					Shell						
	Compound (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athu3sip15kr60_2	8.5	4.905	7.542	51.215	31.39648	na	na	na	0.53236	0.00060	0.53356	0.93680
athu3sip15kr60_1	8.5	4.905	5.841	51.215	31.39648	na	na	na	0.51201	0.00057	0.51315	0.93680
Compromised package, homogeneous core [HEU, poly, free water from wet Kaolite], wet Kaolite shell, 20.0-cm water reflector (Model 5)												
UF_4, maximum free water in wet Kaolite limited to 12 lb												
athuf4pw12kr_5_1	5.0	3.778	5.442	na	11.72323	51.215	2.205	31.5536	0.86424	0.00084	0.86592	0.93520
athuf4pw12kr_5_2	10.0	7.556	5.442	na	12.14418	51.215	2.205	31.6137	0.87850	0.00080	0.88010	0.93680
athuf4pw12kr_5_3	15.0	11.335	5.442	na	12.53782	51.215	2.205	31.6735	0.88757	0.00074	0.88905	0.93680
athuf4pw12kr_5_4	20.0	15.113	5.442	na	12.90818	51.215	2.205	31.7332	0.89756	0.00073	0.89902	0.93680
athuf4pw12kr_5_5	22.0	16.624	5.442	na	13.05054	51.215	2.205	31.7570	0.90109	0.00079	0.90267	0.93680
athuf4pw12kr_5_6	23.0	17.380	5.442	na	13.12057	51.215	2.205	31.7689	0.90393	0.00092	0.90577	0.93680
athuf4pw12kr_5_7	24.0	18.136	5.442	na	13.18986	51.215	2.205	31.7807	0.90642	0.00078	0.90798	0.96820
athuf4pw12kr_4_7	24.0	18.136	4.082	na	12.53437	51.215	3.565	31.6730	0.85179	0.00067	0.85313	0.93520
athuf4pw12kr_3_7	24.0	18.136	2.721	na	11.80206	51.215	4.926	31.5645	0.78532	0.00066	0.78664	0.93520
athuf4pw12kr_2_7	24.0	18.136	1.361	na	10.96547	51.215	6.286	31.4553	0.70597	0.00059	0.70715	0.93520
athuf4pw12kr_1_7	24.0	18.136	0.0	na	9.97700	51.215	7.647	31.34525	0.60010	0.00054	0.60118	0.93520
UO_2F_2, maximum free water in wet Kaolite limited to 12 lb												
athuo2f2pw12kr_5_1	1.0	0.689	5.548	na	11.40090	51.215	2.205	31.5102	0.76491	0.00085	0.76661	0.93680
athuo2f2pw12kr_5_2	2.0	1.378	5.653	na	11.52919	51.215	2.205	31.5272	0.83229	0.00085	0.83399	0.93680
athuo2f2pw12kr_5_3	3.0	2.067	5.759	na	11.65470	51.215	2.205	31.5441	0.86240	0.00100	0.86440	0.93680
athuo2f2pw12kr_4_3	3.0	2.067	4.399	na	10.79422	51.215	3.565	31.4348	0.80180	0.00086	0.80352	0.93680
athuo2f2pw12kr_3_3	3.0	2.067	3.038	na	9.76905	51.215	4.926	31.3246	0.71957	0.00086	0.72129	0.93680
athuo2f2pw12kr_2_3	3.0	2.067	1.677	na	8.46660	51.215	6.286	31.2137	0.60749	0.00070	0.60889	0.93520
athuo2f2pw12kr_1_3	3.0	2.067	0.317	na	6.55398	51.215	7.647	31.1020	0.44010	0.00067	0.44144	0.93520

Table 6.9.6-24a. Results for compounds for air transportation (Models 1–5)

Case	Core					Shell						
	Compound (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
UC saturated at 2.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb												
athucpw12kr_1_5	0.5	0.476	5.655	na	11.42416	51.215	2.205	31.5133	0.71790	0.00074	0.71938	0.93680
athucpw12kr_2_5	1.0	0.951	5.868	na	11.57461	51.215	2.205	31.5333	0.81290	0.00079	0.81448	0.93680
athucpw12kr_3_5	1.5	1.427	6.081	na	11.72124	51.215	2.205	31.5533	0.85368	0.00089	0.85546	0.93680
athucpw12kr_4_5	2.0	1.902	6.294	na	11.86429	51.215	2.205	31.5732	0.88037	0.00097	0.88231	0.93680
athucpw12kr_4_4	2.0	1.902	4.933	na	11.03746	51.215	3.565	31.4641	0.82699	0.00084	0.82867	0.93680
athucpw12kr_4_3	2.0	1.902	3.573	na	10.06378	51.215	4.926	31.3541	0.75643	0.00079	0.75801	0.93680
athucpw12kr_4_2	2.0	1.902	2.212	na	8.85303	51.215	6.286	31.2434	0.66216	0.00070	0.66356	0.93520
athucpw12kr_4_1	2.0	1.902	0.852	na	7.16920	51.215	7.647	31.1319	0.52690	0.00068	0.52826	0.93520
UN saturated at 2.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb												
athunpw12kr_1_5	0.5	0.472	5.657	na	11.42416	51.215	2.205	31.5133	0.71537	0.00080	0.71697	0.93680
athunpw12kr_2_5	1.0	0.944	5.872	na	11.57461	51.215	2.205	31.5333	0.80940	0.00100	0.81140	0.93680
athunpw12kr_3_5	1.5	1.415	6.086	na	11.72124	51.215	2.205	31.5533	0.85298	0.00081	0.85460	0.93680
athunpw12kr_4_5	2.0	1.887	6.301	na	11.86429	51.215	2.205	31.5732	0.88047	0.00098	0.88243	0.93680
athunpw12kr_4_4	2.0	1.887	4.940	na	11.03746	51.215	3.565	31.4641	0.82660	0.00080	0.82820	0.93680
athunpw12kr_4_3	2.0	1.887	3.580	na	10.06378	51.215	4.926	31.3541	0.75566	0.00083	0.75732	0.93680
athunpw12kr_4_2	2.0	1.887	2.219	na	8.85303	51.215	6.286	31.2434	0.66214	0.00085	0.66384	0.93520
athunpw12kr_4_1	2.0	1.887	0.859	na	7.16920	51.215	7.647	31.1319	0.52659	0.00060	0.52779	0.93520
U_3Si_2 saturated at 2.0 g/cm^3, 40% enriched, maximum free water in wet Kaolite limited to 12 lb												
athu3si2pw12kr40_1_5	1.0	0.371	5.865	na	11.57461	51.215	2.205	31.5333	0.66315	0.00083	0.66481	0.93680
athu3si2pw12kr40_2_5	3.0	1.112	6.709	na	12.14048	51.215	2.205	31.6131	0.81291	0.00080	0.81451	0.93680
athu3si2pw12kr40_3_5	5.0	1.853	7.554	na	12.65801	51.215	2.205	31.6925	0.86821	0.00088	0.86997	0.93680
athu3si2pw12kr40_4_5	7.0	2.594	8.398	na	13.13637	51.215	2.205	31.7716	0.90531	0.00082	0.90695	0.93680
athu3si2pw12kr40_5_5	8.0	2.965	8.821	na	13.36301	51.215	2.205	31.8109	0.92284	0.00080	0.92444	0.93680
athu3si2pw12kr40_6_5	8.5	3.150	9.032	na	13.47350	51.215	2.205	31.8306	0.92942	0.00079	0.93100	0.93680

Table 6.9.6-24a. Results for compounds for air transportation (Models 1–5)

Case	Core					Shell						
	Compound (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athu3si2pw12kr40_6_4	8.5	3.150	7.671	na	12.84738	51.215	3.565	31.7232	0.88982	0.00084	0.89150	0.93680
athu3si2pw12kr40_6_3	8.5	3.150	6.311	na	12.15344	51.215	4.926	31.6150	0.84326	0.00074	0.84474	0.93680
athu3si2pw12kr40_6_2	8.5	3.150	4.950	na	11.36966	51.215	6.286	31.5061	0.78727	0.00078	0.78883	0.93680
athu3si2pw12kr40_6_1	8.5	3.150	3.590	na	10.45974	51.215	7.647	31.3965	0.71569	0.00070	0.71709	0.93520
athu3si2pw12kr40_7_5	9.0	3.336	9.243	na	13.58221	51.215	2.205	31.8502	0.93655	0.00076	0.93807	0.93680
U_3Si_2 saturated at 2.0 g/cm^3, 60% enriched, maximum free water in wet Kaolite limited to 12 lb												
athu3si2pw12kr60_1_5	1.0	0.556	5.865	na	11.57461	51.215	2.205	31.5333	0.73126	0.00071	0.73268	0.93680
athu3si2pw12kr60_2_5	3.0	1.667	6.709	na	12.14048	51.215	2.205	31.6131	0.85562	0.00083	0.85728	0.93680
athu3si2pw12kr60_3_5	5.0	2.779	7.554	na	12.65801	51.215	2.205	31.6925	0.90578	0.00088	0.90754	0.93680
athu3si2pw12kr60_4_5	6.0	3.335	7.976	na	12.90162	51.215	2.205	31.7321	0.92388	0.00091	0.92570	0.93680
athu3si2pw12kr60_5_5	6.5	3.613	8.187	na	13.02005	51.215	2.205	31.7518	0.93264	0.00085	0.93434	0.93680
athu3si2pw12kr60_5_4	6.5	3.613	6.827	na	12.34593	51.215	3.565	31.6439	0.88628	0.00079	0.88786	0.93680
athu3si2pw12kr60_5_3	6.5	3.613	5.466	na	11.58886	51.215	4.926	31.5352	0.83480	0.00085	0.83650	0.93680
athu3si2pw12kr60_5_2	6.5	3.613	4.106	na	10.71736	51.215	6.286	31.4258	0.76746	0.00073	0.76892	0.93520
athu3si2pw12kr60_5_1	6.5	3.613	2.745	na	9.67497	51.215	7.647	31.3155	0.68740	0.00075	0.68890	0.93520
athu3si2pw12kr60_6_5	7.0	3.891	8.398	na	13.13637	51.215	2.205	31.7716	0.93848	0.00099	0.94046	0.93680
U_3Si saturated at 2.0 g/cm^3, 40% enriched, maximum free water in wet Kaolite limited to 12 lb												
athu3sipw12kr40_1_5	1.0	0.385	5.870	na	11.57461	51.215	2.205	31.53328	0.66818	0.00089	0.66996	0.93680
athu3sipw12kr40_2_5	3.0	1.154	6.726	na	12.14048	51.215	2.205	31.61311	0.81678	0.00081	0.81840	0.93680
athu3sipw12kr40_3_5	5.0	1.923	7.581	na	12.65801	51.215	2.205	31.69253	0.86971	0.00082	0.87135	0.93680
athu3sipw12kr40_4_5	7.0	2.693	8.437	na	13.13637	51.215	2.205	31.77156	0.91059	0.00094	0.91247	0.93680
athu3sipw12kr40_5_5	8.0	3.078	8.865	na	13.36301	51.215	2.205	31.81093	0.92346	0.00094	0.92534	0.93680
athu3sipw12kr40_6_5	8.5	3.270	9.078	na	13.47350	51.215	2.205	31.83058	0.93352	0.00090	0.93532	0.93680
athu3sipw12kr40_6_4	8.5	3.270	7.718	na	12.84738	51.215	3.565	31.72316	0.89389	0.00097	0.89583	0.93680
athu3sipw12kr40_6_3	8.5	3.270	6.357	na	12.15344	51.215	4.926	31.61502	0.84680	0.00077	0.84834	0.93680

Table 6.9.6-24a. Results for compounds for air transportation (Models 1–5)

Case	Core					Shell						
	Compound (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athu3sipw12kr40_6_2	8.5	3.270	4.997	na	11.36966	51.215	6.286	31.50613	0.79210	0.00099	0.79408	0.93680
athu3sipw12kr40_6_1	8.5	3.270	3.636	na	10.45974	51.215	7.647	31.39648	0.72241	0.00080	0.72401	0.93520
athu3sipw12kr40_7_5	8.75	3.366	9.186	na	13.52807	51.215	2.205	31.84039	0.93683	0.00087	0.93857	0.93680
U_3Si saturated at 2.0 g/cm^3, 60% enriched, maximum free water in wet Kaolite limited to 12 lb												
athu3sipw12kr60_1_5	1.0	0.577	5.870	na	11.57461	51.215	2.205	31.53328	0.73626	0.00072	0.73770	0.93680
athu3sipw12kr60_2_5	3.0	1.731	6.726	na	12.14048	51.215	2.205	31.61311	0.85926	0.00096	0.86118	0.93680
athu3sipw12kr60_3_5	5.0	2.885	7.581	na	12.65801	51.215	2.205	31.69253	0.90903	0.00076	0.91055	0.93680
athu3sipw12kr60_4_5	6.0	3.462	8.009	na	12.90162	51.215	2.205	31.73210	0.92709	0.00074	0.92857	0.93680
athu3sipw12kr60_5_5	6.5	3.751	8.223	na	13.02005	51.215	2.205	31.75184	0.93388	0.00082	0.93552	0.93680
athu3sipw12kr60_5_4	6.5	3.751	6.862	na	12.34593	51.215	3.565	31.64389	0.88970	0.00074	0.89118	0.93680
athu3sipw12kr60_5_3	6.5	3.751	5.502	na	11.58886	51.215	4.926	31.53520	0.83841	0.00077	0.83995	0.93680
athu3sipw12kr60_5_2	6.5	3.751	4.141	na	10.71736	51.215	6.286	31.42575	0.77459	0.00095	0.77649	0.93520
athu3sipw12kr60_5_1	6.5	3.751	2.781	na	9.67497	51.215	7.647	31.31554	0.69282	0.00072	0.69426	0.93520
athu3sipw12kr60_6_5	7.0	4.039	8.437	na	13.13637	51.215	2.205	31.77156	0.94422	0.00085	0.94592	0.93680

Table 6.9.6-24b. Results for compounds for air transportation (Model 6)

Case	Core					Shell						
	Oxide (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Compromised package, homogeneous core [HEU, poly, wet Kaolite, sat moisture from oxide], dry oxide shell, 20.0-cm water reflector UF_4, maximum free water in wet Kaolite limited to 15 lb												
athop15kor_5_6_6	22.0	16.625	9.009	51.215	32.03399	2.0	1.511	32.05745	0.66275	0.00070	0.66415	0.93680
athop15kor_4_6_6	22.0	16.625	7.308	51.215	31.90130	2.0	1.511	31.92495	0.64127	0.00064	0.64255	0.93680
athop15kor_3_6_6	22.0	16.625	5.607	51.215	31.76750	2.0	1.511	31.79134	0.61752	0.00066	0.61884	0.93680
athop15kor_2_6_6	22.0	16.625	3.906	51.215	31.63256	2.0	1.511	31.65660	0.59582	0.00070	0.59722	0.93680
athop15kor_1_6_6	22.0	16.625	2.205	51.215	31.49645	2.0	1.511	31.52071	0.57378	0.00082	0.57542	0.93680
athop15kor_5_5_5	18.0	13.602	9.009	51.215	31.98763	6.0	4.534	32.05789	0.67412	0.00060	0.67412	0.93680
athop15kor_4_5_5	18.0	13.602	7.308	51.215	31.85455	6.0	4.534	31.92540	0.64977	0.00065	0.65107	0.93680
athop15kor_3_5_5	18.0	13.602	5.607	51.215	31.72035	6.0	4.534	31.79179	0.62904	0.00060	0.63024	0.93680
athop15kor_2_5_5	18.0	13.602	3.906	51.215	31.58500	6.0	4.534	31.65706	0.60515	0.00059	0.60633	0.93680
athop15kor_1_5_5	18.0	13.602	2.205	51.215	31.44849	6.0	4.534	31.52117	0.58248	0.00059	0.58366	0.93680
athop15kor_5_4_4	14.0	10.580	9.009	51.215	31.94113	10.0	7.557	32.05833	0.67968	0.00068	0.68104	0.93680
athop15kor_4_4_4	14.0	10.580	7.308	51.215	31.80766	10.0	7.557	31.92584	0.65852	0.00063	0.65978	0.93680
athop15kor_3_4_4	14.0	10.580	5.607	51.215	31.67306	10.0	7.557	31.79225	0.63530	0.00064	0.63658	0.93680
athop15kor_2_4_4	14.0	10.580	3.906	51.215	31.53731	10.0	7.557	31.65751	0.61301	0.00063	0.61427	0.93680
athop15kor_1_4_4	14.0	10.580	2.205	51.215	31.40038	10.0	7.557	31.52163	0.58992	0.00060	0.59112	0.93680
athop15kor_5_3_3	10.0	7.557	9.009	51.215	31.89450	14.0	10.580	32.05878	0.68448	0.00073	0.68594	0.93680
athop15kor_4_3_3	10.0	7.557	7.308	51.215	31.76063	14.0	10.580	31.92629	0.66238	0.00069	0.66376	0.93680
athop15kor_3_3_3	10.0	7.557	5.607	51.215	31.62563	14.0	10.580	31.79270	0.64018	0.00064	0.64146	0.93680
athop15kor_2_3_3	10.0	7.557	3.906	51.215	31.48947	14.0	10.580	31.65797	0.61756	0.00063	0.61882	0.93680
athop15kor_1_3_3	10.0	7.557	2.205	51.215	31.35212	14.0	10.580	31.52209	0.59524	0.00061	0.59646	0.93680
athop15kor_5_2_2	6.0	4.534	9.009	51.215	31.84772	18.0	13.602	32.05922	0.68841	0.00066	0.68973	0.93680
athop15kor_4_2_2	6.0	4.534	7.308	51.215	31.71347	18.0	13.602	31.92674	0.66737	0.00063	0.66863	0.93680
athop15kor_3_2_2	6.0	4.534	5.607	51.215	31.57806	18.0	13.602	31.79315	0.64367	0.00072	0.64511	0.93680

Table 6.9.6-24b. Results for compounds for air transportation (Model 6)

Case	Core					Shell						
	Oxide (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athop15kor_2_2_2	6.0	4.534	3.906	51.215	31.44149	18.0	13.602	31.65842	0.62144	0.00066	0.62276	0.93680
athop15kor_1_2_2	6.0	4.534	2.205	51.215	31.30371	18.0	13.602	31.52254	0.59939	0.00057	0.60053	0.93680
athop15kor_5_1_1	2.0	1.511	9.009	51.215	31.80082	22.0	16.625	32.05967	0.68671	0.00070	0.68811	0.93680
athop15kor_4_1_1	2.0	1.511	7.308	51.215	31.66616	22.0	16.625	32.92719	0.66794	0.00064	0.66922	0.93680
athop15kor_3_1_1	2.0	1.511	5.607	51.215	31.53035	22.0	16.625	31.79360	0.64539	0.00070	0.64679	0.93680
athop15kor_2_1_1	2.0	1.511	3.906	51.215	31.39335	22.0	16.625	31.65888	0.62492	0.00060	0.62612	0.93680
athop15kor_1_1_1	2.0	1.511	2.205	51.215	31.25515	22.0	16.625	31.52300	0.60364	0.00056	0.60476	0.93680
UO_2F_2, maximum free water in wet Kaolite limited to 15 lb												
athuo2f2p15kor_5_5_5	2.5	1.723	9.325	51.215	31.81864	0.5	0.345	31.8271	0.48409	0.00056	0.48521	0.93680
athuo2f2p15kor_4_5_5	2.5	1.723	7.624	51.215	31.68414	0.5	0.345	31.6926	0.46839	0.00054	0.46947	0.93680
athuo2f2p15kor_3_5_5	2.5	1.723	5.924	51.215	31.54848	0.5	0.345	31.5571	0.44959	0.00063	0.45085	0.93680
athuo2f2p15kor_2_5_5	2.5	1.723	4.223	51.215	31.41165	0.5	0.345	31.4203	0.43184	0.00054	0.43292	0.93680
athuo2f2p15kor_1_5_5	2.5	1.723	2.522	51.215	31.27361	0.5	0.345	31.2823	0.41458	0.00051	0.41560	0.93680
athuo2f2p15kor_5_4_4	2.0	1.378	9.325	51.215	31.81039	1.0	0.689	31.8271	0.49426	0.00050	0.49526	0.93680
athuo2f2p15kor_4_4_4	2.0	1.378	7.624	51.215	31.67581	1.0	0.689	31.6927	0.47765	0.00053	0.47871	0.93680
athuo2f2p15kor_3_4_4	2.0	1.378	5.924	51.215	31.54008	1.0	0.689	31.5571	0.45965	0.00062	0.46089	0.93680
athuo2f2p15kor_2_4_4	2.0	1.378	4.223	51.215	31.40317	1.0	0.689	31.4204	0.44078	0.00056	0.44190	0.93680
athuo2f2p15kor_1_4_4	2.0	1.378	2.522	51.215	31.26506	1.0	0.689	31.2824	0.42339	0.00050	0.42439	0.93680
athuo2f2p15kor_5_3_3	1.5	1.034	9.325	51.215	31.80212	1.5	1.034	31.8272	0.49739	0.00059	0.49857	0.93680
athuo2f2p15kor_4_3_3	1.5	1.034	7.624	51.215	31.66748	1.5	1.034	31.6928	0.48104	0.00058	0.48220	0.93680
athuo2f2p15kor_3_3_3	1.5	1.034	5.924	51.215	31.53168	1.5	1.034	31.5572	0.46482	0.00056	0.46594	0.93680
athuo2f2p15kor_2_3_3	1.5	1.034	4.223	51.215	31.39469	1.5	1.034	31.4204	0.44693	0.00050	0.44793	0.93680
athuo2f2p15kor_1_3_3	1.5	1.034	2.522	51.215	31.25651	1.5	1.034	31.2825	0.42889	0.00056	0.43001	0.93680
athuo2f2p15kor_5_2_2	1.0	0.689	9.325	51.215	31.97386	2.0	1.378	31.8273	0.49754	0.00061	0.49876	0.93680
athuo2f2p15kor_4_2_2	1.0	0.689	7.624	51.215	31.65914	2.0	1.378	31.6929	0.48300	0.00054	0.48408	0.93680

Table 6.9.6-24b. Results for compounds for air transportation (Model 6)

Case	Core					Shell						
	Oxide (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athuo2f2p15kor_3_2_2	1.0	0.689	5.924	51.215	31.52327	2.0	1.378	31.5573	0.46667	0.00063	0.46793	0.93680
athuo2f2p15kor_2_2_2	1.0	0.689	4.223	51.215	31.38621	2.0	1.378	31.4205	0.45011	0.00057	0.45125	0.93680
athuo2f2p15kor_1_2_2	1.0	0.689	2.522	51.215	31.24795	2.0	1.378	31.2826	0.43101	0.00058	0.43217	0.93680
athuo2f2p15kor_5_1_1	0.5	0.345	9.325	51.215	31.78558	2.5	1.723	31.8274	0.49264	0.00057	0.49378	0.93680
athuo2f2p15kor_4_1_1	0.5	0.345	7.624	51.215	31.65080	2.5	1.723	31.6929	0.47980	0.00059	0.48098	0.93680
athuo2f2p15kor_3_1_1	0.5	0.345	5.924	51.215	31.51485	2.5	1.723	31.5573	0.46493	0.00082	0.46657	0.93680
athuo2f2p15kor_2_1_1	0.5	0.345	4.223	51.215	31.37772	2.5	1.723	31.4206	0.45038	0.00051	0.45140	0.93680
athuo2f2p15kor_1_1_1	0.5	0.345	2.522	51.215	31.23939	2.5	1.723	31.2826	0.43292	0.00057	0.43406	0.93680
UC saturated at 2.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb												
athucp15kor_5_3_3	1.5	1.427	9.860	51.215	31.83630	0.5	0.476	31.8560	0.48450	0.00058	0.48566	0.93680
athucp15kor_4_3_3	1.5	1.427	8.160	51.215	31.70195	0.5	0.476	31.7218	0.46738	0.00055	0.46848	0.93680
athucp15kor_3_3_3	1.5	1.427	6.458	51.215	31.56644	0.5	0.476	31.5865	0.45085	0.00051	0.45187	0.93680
athucp15kor_2_3_3	1.5	1.427	4.757	51.215	31.42977	0.5	0.476	31.4500	0.43370	0.00055	0.43480	0.93680
athucp15kor_1_3_3	1.5	1.427	3.056	51.215	31.29189	0.5	0.476	31.3123	0.41716	0.00052	0.41820	0.93680
athucp15kor_5_2_2	1.0	0.951	9.860	51.215	31.81666	1.0	0.951	31.8560	0.49103	0.00056	0.49215	0.93680
athucp15kor_4_2_2	1.0	0.951	8.160	51.215	31.68214	1.0	0.951	31.7218	0.47480	0.00056	0.47592	0.93680
athucp15kor_3_2_2	1.0	0.951	6.458	51.215	31.54647	1.0	0.951	31.5865	0.45839	0.00062	0.45963	0.93680
athucp15kor_2_2_2	1.0	0.951	4.757	51.215	31.40961	1.0	0.951	31.4500	0.44236	0.00051	0.44338	0.93680
athucp15kor_1_2_2	1.0	0.951	3.056	51.215	31.27156	1.0	0.951	31.3123	0.42410	0.00050	0.42510	0.93680
athucp15kor_5_1_1	0.5	0.476	9.860	51.215	31.79700	1.5	1.427	31.8560	0.48603	0.00048	0.48699	0.93680
athucp15kor_4_1_1	0.5	0.476	8.160	51.215	31.66231	1.5	1.427	31.7218	0.47290	0.00051	0.48022	0.93680
athucp15kor_3_1_1	0.5	0.476	6.458	51.215	31.52646	1.5	1.427	31.5865	0.45846	0.00053	0.45952	0.93680
athucp15kor_2_1_1	0.5	0.476	4.757	51.215	31.38944	1.5	1.427	31.4500	0.44235	0.00050	0.44335	0.93680
athucp15kor_1_1_1	0.5	0.476	3.056	51.215	31.25120	1.5	1.427	31.3123	0.42642	0.00047	0.42736	0.93680

Table 6.9.6-24b. Results for compounds for air transportation (Model 6)

Case	Core					Shell						
	Oxide (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
UN saturated at 2.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb												
athunp15kor_5_3_3	1.5	1.415	9.867	51.215	31.83630	0.5	0.472	31.8560	0.48154	0.00053	0.48260	0.93680
athunp15kor_4_3_3	1.5	1.415	8.166	51.215	31.70195	0.5	0.472	31.7218	0.46619	0.00054	0.46727	0.93680
athunp15kor_3_3_3	1.5	1.415	6.465	51.215	31.56644	0.5	0.472	31.5870	0.44838	0.00056	0.44950	0.93680
athunp15kor_2_3_3	1.5	1.415	4.765	51.215	31.42977	0.5	0.472	31.4500	0.43124	0.00053	0.43230	0.93680
athunp15kor_1_3_3	1.5	1.415	3.064	51.215	31.29189	0.5	0.472	31.3123	0.41346	0.00053	0.41452	0.93680
athunp15kor_5_2_2	1.0	0.944	9.867	51.215	31.81666	1.0	0.944	31.8560	0.48870	0.00056	0.48982	0.93680
athunp15kor_4_2_2	1.0	0.944	8.166	51.215	31.68214	1.0	0.944	31.7218	0.47343	0.00057	0.47454	0.93680
athunp15kor_3_2_2	1.0	0.944	6.465	51.215	31.54647	1.0	0.944	31.5870	0.45809	0.00058	0.45925	0.93680
athunp15kor_2_2_2	1.0	0.944	4.765	51.215	31.40961	1.0	0.944	31.4500	0.43944	0.00050	0.44044	0.93680
athunp15kor_1_2_2	1.0	0.944	3.064	51.215	31.27156	1.0	0.944	31.3123	0.42213	0.00051	0.42315	0.93680
athunp15kor_5_1_1	0.5	0.472	9.867	51.215	31.79700	1.5	1.415	31.8560	0.48342	0.00050	0.48442	0.93680
athunp15kor_4_1_1	0.5	0.472	8.166	51.215	31.66231	1.5	1.415	31.7218	0.47187	0.00065	0.47317	0.93680
athunp15kor_3_1_1	0.5	0.472	6.465	51.215	31.52646	1.5	1.415	31.5870	0.45572	0.00052	0.45676	0.93680
athunp15kor_2_1_1	0.5	0.472	4.765	51.215	31.38944	1.5	1.415	31.4500	0.44087	0.00047	0.44181	0.93680
athunp15kor_1_1_1	0.5	0.472	3.064	51.215	31.25120	1.5	1.415	31.3123	0.42460	0.00053	0.42566	0.93680
U_3Si_2 saturated at 2.0 g/cm^3, 40% enriched, maximum free water in wet Kaolite limited to 15 lb												
athu3si2p15kor40_5_6_6	7.5	2.780	12.598	51.215	32.07012	1.0	0.371	32.1089	0.55418	0.00058	0.55534	0.93680
athu3si2p15kor40_4_6_6	7.5	2.780	10.897	51.215	31.93773	1.0	0.371	31.9768	0.53635	0.00059	0.53753	0.93680
athu3si2p15kor40_3_6_6	7.5	2.780	9.196	51.215	31.80423	1.0	0.371	31.8436	0.51804	0.00061	0.51926	0.93680
athu3si2p15kor40_2_6_6	7.5	2.780	7.495	51.215	31.66961	1.0	0.371	31.7093	0.49958	0.00063	0.50048	0.93680
athu3si2p15kor40_1_6_6	7.5	2.780	5.794	51.215	31.53382	1.0	0.371	31.5739	0.48208	0.00057	0.43822	0.93680
athu3si2p15kor40_5_5_5	5.5	2.039	12.598	51.215	31.99256	3.0	1.112	32.1089	0.56919	0.00059	0.57037	0.93680
athu3si2p15kor40_4_5_5	5.5	2.039	10.897	51.215	31.85952	3.0	1.112	31.9768	0.55001	0.00062	0.55125	0.93680

Table 6.9.6-24b. Results for compounds for air transportation (Model 6)

Case	Core					Shell						
	Oxide (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athu3si2p15kor40_3_5_5	5.5	2.039	9.196	51.215	31.72537	3.0	1.112	31.8436	0.53242	0.00056	0.53354	0.93680
athu3si2p15kor40_2_5_5	5.5	2.039	7.495	51.215	31.59006	3.0	1.112	31.7093	0.51394	0.00062	0.51518	0.93680
athu3si2p15kor40_1_5_5	5.5	2.039	5.794	51.215	31.45359	3.0	1.112	31.5739	0.49529	0.00053	0.49635	0.93680
athu3si2p15kor40_5_4_4	4.5	1.668	12.598	51.215	31.95364	4.0	1.483	32.1089	0.57189	0.00055	0.57599	0.93680
athu3si2p15kor40_4_4_4	4.5	1.668	10.897	51.215	31.82028	4.0	1.483	31.9768	0.55525	0.00062	0.55649	0.93680
athu3si2p15kor40_3_4_4	4.5	1.668	9.196	51.215	31.68578	4.0	1.483	31.8436	0.53631	0.00061	0.53753	0.93680
athu3si2p15kor40_2_4_4	4.5	1.668	7.495	51.215	31.55014	4.0	1.483	31.7093	0.51771	0.00055	0.51881	0.93680
athu3si2p15kor40_1_4_4	4.5	1.668	5.794	51.215	31.41332	4.0	1.483	31.5739	0.49952	0.00067	0.50086	0.93680
athu3si2p15kor40_5_3_3	4.0	1.483	12.598	51.215	31.93414	4.5	1.668	32.1089	0.57263	0.00067	0.57397	0.93680
athu3si2p15kor40_4_3_3	4.0	1.483	10.897	51.215	31.80062	4.5	1.668	31.9768	0.55459	0.00067	0.55593	0.93680
athu3si2p15kor40_3_3_3	4.0	1.483	9.196	51.215	31.66596	4.5	1.668	31.8436	0.53838	0.00055	0.53948	0.93680
athu3si2p15kor40_2_3_3	4.0	1.483	7.495	51.215	31.53014	4.5	1.668	31.7093	0.51984	0.00054	0.52092	0.93680
athu3si2p15kor40_1_3_3	4.0	1.483	5.794	51.215	31.39315	4.5	1.668	31.5739	0.50181	0.00066	0.50313	0.93680
athu3si2p15kor40_5_2_2	3.0	1.112	12.598	51.215	31.89508	5.5	2.039	32.1089	0.57084	0.00055	0.57194	0.93680
athu3si2p15kor40_4_2_2	3.0	1.112	10.897	51.215	31.76122	5.5	2.039	31.9768	0.55543	0.00057	0.55657	0.93680
athu3si2p15kor40_3_2_2	3.0	1.112	9.196	51.215	31.62623	5.5	2.039	31.8436	0.53720	0.00053	0.53826	0.93680
athu3si2p15kor40_2_2_2	3.0	1.112	7.495	51.215	31.49007	5.5	2.039	31.7093	0.52111	0.00053	0.52217	0.93680
athu3si2p15kor40_1_2_2	3.0	1.112	5.794	51.215	31.35272	5.5	2.039	31.5739	0.50217	0.00061	0.50339	0.93680
athu3si2p15kor40_5_1_1	1.0	0.371	12.598	51.215	31.81666	7.5	2.780	32.1089	0.55453	0.00056	0.55565	0.93680
athu3si2p15kor40_4_1_1	1.0	0.371	10.897	51.215	31.68214	7.5	2.780	31.9768	0.54286	0.00053	0.54392	0.93680
athu3si2p15kor40_3_1_1	1.0	0.371	9.196	51.215	31.54657	7.5	2.780	31.8436	0.52952	0.00062	0.50366	0.93680
athu3si2p15kor40_2_1_1	1.0	0.371	7.495	51.215	31.40961	7.5	2.780	31.7093	0.51520	0.00056	0.51632	0.93680
athu3si2p15kor40_1_1_1	1.0	0.371	5.794	51.215	31.27156	7.5	2.780	31.5739	0.50002	0.00072	0.50146	0.93680

Table 6.9.6-24b. Results for compounds for air transportation (Model 6)

Case	Core					Shell						
	Oxide (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
U_3Si_2 saturated at 2.0 g/cm^3, 60% enriched, maximum free water in wet Kaolite limited to 15 lb												
athu3si2p15kor60_5_6_6	5.5	3.058	11.754	51.215	31.99256	1.0	0.556	32.0315	0.56832	0.00067	0.56966	0.93680
athu3si2p15kor60_4_6_6	5.5	3.058	10.053	51.215	31.85952	1.0	0.556	31.8988	0.54987	0.00053	0.55093	0.93680
athu3si2p15kor60_3_6_6	5.5	3.058	8.352	51.215	31.72537	1.0	0.556	31.7650	0.52979	0.00069	0.53117	0.93680
athu3si2p15kor60_2_6_6	5.5	3.058	6.651	51.215	31.59006	1.0	0.556	31.6300	0.51062	0.00061	0.51184	0.93680
athu3si2p15kor60_1_6_6	5.5	3.058	4.950	51.215	31.45359	1.0	0.556	31.4939	0.49054	0.00058	0.49170	0.93680
athu3si2p15kor60_5_5_5	4.5	2.502	11.754	51.215	31.95364	2.0	1.112	32.0315	0.57759	0.00064	0.57887	0.93680
athu3si2p15kor60_4_5_5	4.5	2.502	10.053	51.215	31.82028	2.0	1.112	31.8988	0.55936	0.00059	0.56054	0.93680
athu3si2p15kor60_3_5_5	4.5	2.502	8.352	51.215	31.68578	2.0	1.112	31.7650	0.53950	0.00056	0.54062	0.93680
athu3si2p15kor60_2_5_5	4.5	2.502	6.651	51.215	31.55014	2.0	1.112	31.6300	0.51895	0.00070	0.52035	0.93680
athu3si2p15kor60_1_5_5	4.5	2.502	4.950	51.215	31.41332	2.0	1.112	31.4939	0.49973	0.00052	0.50077	0.93680
athu3si2p15kor60_5_4_4	3.5	1.946	11.754	51.215	31.91462	3.0	1.668	32.0315	0.58231	0.00068	0.58367	0.93680
athu3si2p15kor60_4_4_4	3.5	1.946	10.053	51.215	31.78093	3.0	1.668	31.8988	0.56451	0.00064	0.56579	0.93680
athu3si2p15kor60_3_4_4	3.5	1.946	8.352	51.215	31.64610	3.0	1.668	31.7650	0.54552	0.00062	0.54676	0.93680
athu3si2p15kor60_2_4_4	3.5	1.946	6.651	51.215	31.51012	3.0	1.668	31.6300	0.52560	0.00062	0.52684	0.93680
athu3si2p15kor60_1_4_4	3.5	1.946	4.950	51.215	31.37295	3.0	1.668	31.4939	0.50523	0.00062	0.50647	0.93680
athu3si2p15kor60_5_3_3	3.0	1.668	11.754	51.215	31.89508	3.5	1.946	32.0315	0.58440	0.00059	0.58558	0.93680
athu3si2p15kor60_4_3_3	3.0	1.668	10.053	51.215	31.76122	3.5	1.946	31.8988	0.56511	0.00067	0.56645	0.93680
athu3si2p15kor60_3_3_3	3.0	1.668	8.352	51.215	31.62623	3.5	1.946	31.7650	0.54682	0.00060	0.54802	0.93680
athu3si2p15kor60_2_3_3	3.0	1.668	6.651	51.215	31.49007	3.5	1.946	31.6300	0.52752	0.00063	0.52878	0.93680
athu3si2p15kor60_1_3_3	3.0	1.668	4.950	51.215	31.35272	3.5	1.946	31.4939	0.50764	0.00052	0.50868	0.93680
athu3si2p15kor60_5_2_2	2.0	1.112	11.754	51.215	31.85592	4.5	2.502	32.0315	0.58142	0.00062	0.58266	0.93680
athu3si2p15kor60_4_2_2	2.0	1.112	10.053	51.215	31.72173	4.5	2.502	31.8988	0.56551	0.00058	0.56667	0.93680
athu3si2p15kor60_3_2_2	2.0	1.112	8.352	51.215	31.58640	4.5	2.502	31.7650	0.54760	0.00062	0.54884	0.93680
athu3si2p15kor60_2_2_2	2.0	1.112	6.651	51.215	31.44989	4.5	2.502	31.6300	0.52969	0.00062	0.53093	0.93680

Table 6.9.6-24b. Results for compounds for air transportation (Model 6)

Case	Core					Shell						
	Oxide (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athu3si2p15kor60_1_2_2	2.0	1.112	4.950	51.215	31.31219	4.5	2.502	31.4939	0.51032	0.00058	0.51148	0.93680
athu3si2p15kor60_5_1_1	1.0	0.556	11.754	51.215	31.81666	5.5	3.058	32.0315	0.57211	0.00070	0.57351	0.93680
athu3si2p15kor60_4_1_1	1.0	0.556	10.053	51.215	31.68214	5.5	3.058	31.8988	0.55870	0.00057	0.55984	0.93680
athu3si2p15kor60_3_1_1	1.0	0.556	8.352	51.215	31.54647	5.5	3.058	31.7650	0.54337	0.00061	0.54459	0.93680
athu3si2p15kor60_2_1_1	1.0	0.556	6.651	51.215	31.40961	5.5	3.058	31.6300	0.52728	0.00056	0.52840	0.93680
athu3si2p15kor60_1_1_1	1.0	0.556	4.950	51.215	31.27156	5.5	3.058	31.4939	0.50795	0.00050	0.50895	0.93680
U_3Si saturated at 2.0 g/cm^3, 40% enriched, maximum free water in wet Kaolite limited to 15 lb												
athu3sip15kor40_5_6_6	7.5	2.886	12.645	51.215	32.07012	1.0	0.385	32.10886	0.55801	0.00059	0.55919	0.93680
athu3sip15kor40_4_6_6	7.5	2.886	10.944	51.215	31.93773	1.0	0.385	31.97679	0.53986	0.00072	0.54130	0.93680
athu3sip15kor40_3_6_6	7.5	2.886	9.243	51.215	31.80423	1.0	0.385	31.84362	0.52188	0.00061	0.52310	0.93680
athu3sip15kor40_2_6_6	7.5	2.886	7.542	51.215	31.66961	1.0	0.385	31.70933	0.50380	0.00053	0.50486	0.93680
athu3sip15kor40_1_6_6	7.5	2.886	5.841	51.215	31.53382	1.0	0.385	31.57389	0.48581	0.00053	0.48687	0.93680
athu3sip15kor40_5_5_5	5.5	2.116	12.645	51.215	31.99256	3.0	1.154	32.10886	0.57371	0.00066	0.57503	0.93680
athu3sip15kor40_4_5_5	5.5	2.116	10.944	51.215	31.85952	3.0	1.154	31.97679	0.55453	0.00060	0.55573	0.93680
athu3sip15kor40_3_5_5	5.5	2.116	9.243	51.215	31.72537	3.0	1.154	31.84362	0.53673	0.00063	0.53799	0.93680
athu3sip15kor40_2_5_5	5.5	2.116	7.542	51.215	31.59006	3.0	1.154	31.70933	0.51942	0.00057	0.52056	0.93680
athu3sip15kor40_1_5_5	5.5	2.116	5.841	51.215	31.45359	3.0	1.154	31.57389	0.49975	0.00057	0.50089	0.93680
athu3sip15kor40_5_4_4	4.5	1.732	12.645	51.215	31.95364	4.0	1.539	32.10886	0.57633	0.00067	0.57767	0.93680
athu3sip15kor40_4_4_4	4.5	1.732	10.944	51.215	31.82028	4.0	1.539	31.97679	0.55817	0.00058	0.55933	0.93680
athu3sip15kor40_3_4_4	4.5	1.732	9.243	51.215	31.68578	4.0	1.539	31.84362	0.54117	0.00061	0.54239	0.93680
athu3sip15kor40_2_4_4	4.5	1.732	7.542	51.215	31.55014	4.0	1.539	31.70933	0.52346	0.00056	0.52458	0.93680
athu3sip15kor40_1_4_4	4.5	1.732	5.841	51.215	31.41332	4.0	1.539	31.57389	0.50265	0.00064	0.50393	0.93680
athu3sip15kor40_5_3_3	4.0	1.539	12.645	51.215	31.93414	4.5	1.732	32.10886	0.57779	0.00057	0.57893	0.93680
athu3sip15kor40_4_3_3	4.0	1.539	10.944	51.215	31.80062	4.5	1.732	31.97679	0.55995	0.00060	0.56115	0.93680
athu3sip15kor40_3_3_3	4.0	1.539	9.243	51.215	31.66596	4.5	1.732	31.84362	0.54234	0.00057	0.54348	0.93680

Table 6.9.6-24b. Results for compounds for air transportation (Model 6)

Case	Core					Shell						
	Oxide (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athu3sip15kor40_2_3_3	4.0	1.539	7.542	51.215	31.53014	4.5	1.732	31.70933	0.52352	0.00056	0.52464	0.93680
athu3sip15kor40_1_3_3	4.0	1.539	5.841	51.215	31.39315	4.5	1.732	31.57389	0.50464	0.00053	0.50570	0.93680
athu3sip15kor40_5_2_2	3.0	1.154	12.645	51.215	31.89508	5.5	2.116	32.10886	0.57641	0.00063	0.57767	0.93680
athu3sip15kor40_4_2_2	3.0	1.154	10.944	51.215	31.76122	5.5	2.116	31.97679	0.55880	0.00077	0.56034	0.93680
athu3sip15kor40_3_2_2	3.0	1.154	9.243	51.215	31.62623	5.5	2.116	31.84362	0.54203	0.00061	0.54325	0.93680
athu3sip15kor40_2_2_2	3.0	1.154	7.542	51.215	31.49007	5.5	2.116	31.70933	0.52466	0.00058	0.52582	0.93680
athu3sip15kor40_1_2_2	3.0	1.154	5.841	51.215	31.35272	5.5	2.116	31.57389	0.50726	0.00059	0.50844	0.93680
athu3sip15kor40_5_1_1	1.0	0.385	12.645	51.215	31.81666	7.5	2.886	32.10886	0.55969	0.00056	0.56081	0.93680
athu3sip15kor40_4_1_1	1.0	0.385	10.944	51.215	31.68214	7.5	2.886	31.97679	0.54848	0.00063	0.54974	0.93680
athu3sip15kor40_3_1_1	1.0	0.385	9.243	51.215	31.54647	7.5	2.886	31.84362	0.53468	0.00053	0.53574	0.93680
athu3sip15kor40_2_1_1	1.0	0.385	7.542	51.215	31.40961	7.5	2.886	31.70933	0.52059	0.00063	0.52185	0.93680
athu3sip15kor40_1_1_1	1.0	0.385	5.841	51.215	31.27156	7.5	2.886	31.57389	0.50458	0.00054	0.50566	0.93680
U_3Si saturated at 2.0 g/cm^3, 60% enriched, maximum free water in wet Kaolite limited to 15 lb												
athu3sip15kor60_5_6_6	5.5	3.174	11.789	51.215	31.99256	1.0	0.577	32.03149	0.57164	0.00060	0.57284	0.93680
athu3sip15kor60_4_6_6	5.5	3.174	10.088	51.215	31.85952	1.0	0.577	31.89878	0.55302	0.00067	0.55436	0.93680
athu3sip15kor60_3_6_6	5.5	3.174	8.387	51.215	31.72537	1.0	0.577	31.76495	0.53331	0.00058	0.53447	0.93680
athu3sip15kor60_2_6_6	5.5	3.174	6.686	51.215	31.59006	1.0	0.577	31.62998	0.51489	0.00063	0.51615	0.93680
athu3sip15kor60_1_6_6	5.5	3.174	4.985	51.215	31.45359	1.0	0.577	31.49386	0.49334	0.00053	0.49440	0.93680
athu3sip15kor60_5_5_5	4.5	2.597	11.789	51.215	31.95364	2.0	1.154	32.03149	0.58223	0.00070	0.58363	0.93680
athu3sip15kor60_4_5_5	4.5	2.597	10.088	51.215	31.82028	2.0	1.154	31.89878	0.56273	0.00061	0.56395	0.93680
athu3sip15kor60_3_5_5	4.5	2.597	8.387	51.215	31.68578	2.0	1.154	31.76495	0.54314	0.00057	0.54428	0.93680
athu3sip15kor60_2_5_5	4.5	2.597	6.686	51.215	31.55014	2.0	1.154	31.62998	0.52339	0.00055	0.52449	0.93680
athu3sip15kor60_1_5_5	4.5	2.597	4.985	51.215	31.41332	2.0	1.154	31.49386	0.50351	0.00068	0.50487	0.93680

Table 6.9.6-24b. Results for compounds for air transportation (Model 6)

Case	Core					Shell						
	Oxide (kg)	^{235}U (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athu3sip15kor60_5_4_4	3.5	2.020	11.789	51.215	31.91462	3.0	1.731	32.03149	0.58810	0.00061	0.58932	0.93680
athu3sip15kor60_4_4_4	3.5	2.020	10.088	51.215	31.78093	3.0	1.731	31.89878	0.56728	0.00064	0.56856	0.93680
athu3sip15kor60_3_4_4	3.5	2.020	8.387	51.215	31.64610	3.0	1.731	31.76495	0.54888	0.00064	0.55016	0.93680
athu3sip15kor60_2_4_4	3.5	2.020	6.686	51.215	31.51012	3.0	1.731	31.62998	0.52945	0.00055	0.53055	0.93680
athu3sip15kor60_1_4_4	3.5	2.020	4.985	51.215	31.37295	3.0	1.731	31.49386	0.50955	0.00054	0.51063	0.93680
athu3sip15kor60_5_3_3	3.0	1.731	11.789	51.215	31.89508	3.5	2.020	32.03149	0.58727	0.00064	0.58855	0.93680
athu3sip15kor60_4_3_3	3.0	1.731	10.088	51.215	31.76122	3.5	2.020	31.89878	0.57086	0.00060	0.57206	0.93680
athu3sip15kor60_3_3_3	3.0	1.731	8.387	51.215	31.62623	3.5	2.020	31.76495	0.55192	0.00060	0.55312	0.93680
athu3sip15kor60_2_3_3	3.0	1.731	6.686	51.215	31.49007	3.5	2.020	31.62998	0.53184	0.00059	0.53302	0.93680
athu3sip15kor60_1_3_3	3.0	1.731	4.985	51.215	31.35272	3.5	2.020	31.49386	0.51129	0.00061	0.51251	0.93680
athu3sip15kor60_5_2_2	2.0	1.154	11.789	51.215	31.85592	4.5	2.597	32.03149	0.58582	0.00059	0.58700	0.93680
athu3sip15kor60_4_2_2	2.0	1.154	10.088	51.215	31.72173	4.5	2.597	31.89878	0.56889	0.00055	0.56999	0.93680
athu3sip15kor60_3_2_2	2.0	1.154	8.387	51.215	31.58640	4.5	2.597	31.76495	0.55148	0.00055	0.55258	0.93680
athu3sip15kor60_2_2_2	2.0	1.154	6.686	51.215	31.44989	4.5	2.597	31.62998	0.53289	0.00061	0.53411	0.93680
athu3sip15kor60_1_2_2	2.0	1.154	4.985	51.215	31.31219	4.5	2.597	31.49386	0.51430	0.00056	0.51542	0.93680
athu3sip15kor60_5_1_1	1.0	0.577	11.789	51.215	31.81666	5.5	3.174	32.03149	0.57696	0.00056	0.57808	0.93680
athu3sip15kor60_4_1_1	1.0	0.577	10.088	51.215	31.68214	5.5	3.174	31.89878	0.56341	0.00057	0.56455	0.93680
athu3sip15kor60_3_1_1	1.0	0.577	8.387	51.215	31.76495	5.5	3.174	31.76495	0.54718	0.00064	0.54846	0.93680
athu3sip15kor60_2_1_1	1.0	0.577	6.686	51.215	31.40961	5.5	3.174	31.62998	0.53155	0.00063	0.53281	0.93680
athu3sip15kor60_1_1_1	1.0	0.577	4.985	51.215	31.27156	5.5	3.174	31.49386	0.51360	0.00057	0.51474	0.93680

Appendix 6.9.7
Input Listings of ES-3100 Calculation Models for Select Cases

This appendix contains selected input files for calculations identified in Tables 6.1a–6.1f and Sects. 6.4– 6.7.

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ES-3100 Input file - Results table crosswalk

Section	Case	Description	Results table
6.9.7.1	cvcrcyt11_21_1	3 cyl, 0.0 in. np, 21000 g U (21000 g ^{235}U, 9082.6 g H_2O, h/x=11.29)	6.9.6-1
6.9.7.2	cvcrcyt11_36_2	3 cyl, 1.4 in. np, 36000 g U (36000 g ^{235}U, 7673.1 g H_2O, h/x=5.56)	6.9.6-1
6.9.7.3	cvcrsqt11_36_1	3 bar, 0.0 in. np, 36000 g U (36000 g ^{235}U, 8286.7 g H_2O, h/x=6.01)	6.9.6-4
6.9.7.4	cvcrcyct11_17_1	3 cyl, 0.0 in. np, 17000 gU (17000 g ^{235}U, 9294.9 g H_2O, h/x=14.27)	6.9.6-6
6.9.7.5	cvcrcyct11_32_2	3 cyl, 1.4 in. np, 32000 g U (32000 g ^{235}U, 7885.3 g H_2O, h/x= 6.43)	6.9.6-6
6.9.7.6	cvcr5est11_1_1	0.0 in. np, 18286.5 g U (18286.5 g ^{235}U, 9226.6 g H_2O, h/x=13.75)	6.9.6-8
6.9.7.7	cvcr6e4st11_1	1.4 in. np, 36573.0 g U (36573.0 g ^{235}U, 7642.7 g H_2O, h/x= 5.45)	6.9.6-8
6.9.7.8	cvcr70st11_2	1.4 in. np, 25588.2 g U (25588.2 g ^{235}U, 8225.3 g H_2O, h/x= 8.39)	6.9.6-8
6.9.7.9	cvr3sqa_26_1_8_15	0.0 in. np, 25893.7 g U (25893.7 g ^{235}U, 8822.9 g H_2O, h/x= 8.89)	N/A[a]
6.9.7.10	cvr3lha_26_1_8_15	0.0 in. np, 25893.7 g U (25893.7 g ^{235}U, 8822.9 g H_2O, h/x= 8.89)	6.9.6-10
6.9.7.11	cvr3cha_26_1_8_15	0.0 in. np, 25893.7 g U (25893.7 g ^{235}U, 8822.9 g H_2O, h/x= 8.89)	N/A[a]
6.9.7.12	cvcrpdoxt11_1_5_24_15	0.0 in. np, disp. 24,000 g UO_2 (21,124.9 g ^{235}U, 1,477.3 g Sat.H_2O), 4 g H_2O CV, h/x= 10.02)	6.9.6-12
6.9.7.13	cvcrsk3cc_9_15_17	0.0 in. np, 21300 g SOC (19865.3 g UOx, 15672.8 g ^{235}U, 921.0 g C, h/x=12.82)	6.9.6-17
6.9.7.14	cvcrunhct11_9_1	0.0 in. np, disp. 9000 g UNHc (4238.7 g ^{235}U, 6980.8 g H_2O, h/x=54.99)	6.9.6-14
6.9.7.15	cvcrtriga_1_15	0.0 in. np, 10400.0 g UZrHx (921.0 g ^{235}U, 8998.2 g H_2O, h/x=255.01)	6.9.6-19a
6.9.7.16	ncsrcyt11_21_1_15	3 cyl, 0.0 in. np, 21000 g U (21000 g ^{235}U, 9082.6 g H_2O, h/x=11.29)	6.9.6-2
6.9.7.17	nciacyct11_25_2_3	3 cyl, 1.4 in. np, 25000 g U (25000 g ^{235}U, 8256.8 g H_2O, h/x= 8.62)	6.9.6-7
6.9.7.18	hciacyct12_25_2_3	3 cyl, 1.4 in. np, 25000 g U (25000 g ^{235}U, 8256.8 g H_2O, h/x= 8.62)	6.9.6-7
6.9.7.19	ncia70st11_2_8_3	1.4 in. np, 25588.2 g U (25588.2 g ^{235}U, 8224.9 g H_2O, h/x= 8.39)	6.9.6-9
6.9.7.20	ncia5est11_2_2_5_3	1.4 in. np, 36647 g U (29318 g ^{235}U, 7642.7 g H_2O, h/x= 6.80)	6.9.6-9
6.9.7.21	nciabmt11_4_1_5_3	0.0 in. np, 3708.5 g U (2966.8 g ^{235}U, 10000.7 g H_2O, h/x=87.98)	6.9.6-11
6.9.7.22	hctf5bmt12_25_2_8_3	1.4 in. np, 24968.9 g U (24968.9 g ^{235}U, 8258.4 g H_2O, h/x= 8.63)	6.9.6-11
6.9.7.23	nciaoxt11_1_24_1_3	0.0 in. np, disp. 24000 g UO_2 (21124.9 g ^{235}U, 6533.9 g H_2O, h/x= 9.90)	N/A [a]
6.9.7.24	nciask_9_15	0.0 in. np, 21300 g SOC (19865.3 g UOx, 15672.8 g ^{235}U, 921.0 g C, h/x=12.82)	6.9.6-18a
6.9.7.25	ncsrunhct11_9_1_15	0.0 in. np, disp. 9000 g UNHc (4238.7 g ^{235}U, 6980.8 g H_2O, h/x=54.99)	6.9.6-15
6.9.7.26	icsrunhct12_15_1_15	0.0 in. np, disp. 15,000.0 g UNHc (7064.4 g ^{235}U, 6870.7 g H_2O, h/x=52.91)	6.9.6-16

ES-3100 Input file - Results table crosswalk

Section	Case	Description	Results table
6.9.7.27	ncsrtriga_1_15_15	0.0 in. np, 10400.0 g UZrHx (921.0 g ^{235}U, 8998.2 g H_2O, h/x=255.01)	6.9.6-20a
6.9.7.28	nciatriga_1_15_3	0.0 in. np, 10400.0 g UZrHx (921.0 g ^{235}U, 8998.2 g H_2O, h/x=255.01)	6.9.6-20a
6.9.7.29	atdmr_7_8	7000 g U, 7000 g ^{235}U, 500.0 g CH_2, h/x=2.40, Rc=6.02382 cm	6.9.6-21
6.9.7.30	atdmsr_7_8_11	7000 g U, 7000 g ^{235}U, 500.0 g CH_2, h/x=2.40, Rc=6.02382 cm, 66133.1 g SS, Rs=13.0198 cm	6.9.6-21
6.9.7.31	atdmdkr_7_8_6	7000 g U, 7000 g ^{235}U, 500.0 g CH_2, h/x=2.40, Rc=6.02382 cm, 53419.1 g Kao, Rk=31.0802 cm	6.9.6-21
6.9.7.32	atdzr	10400.0 g $UZrH_x$ (921.0 g ^{235}U, 500.0 g CH_2, h/x=43.37), Rc=7.4677 cm	6.9.6-22a
6.9.7.33	athzp15kr_5	10400.0 g $UZrH_x$ (921.0 g ^{235}U, 500.0 g CH_2, 9008.5 g H_2O, h/x=298.6), Rc=31.14838 cm	6.9.6-22a
6.9.7.34	athzpw15kr_5	10400 g $UZrH_x$, 921.0 g ^{235}U, 500.0 g CH_2, 6803.8 g H_2O, h/x=236.1, Rc=12.69027 cm, Rs=31.69769 cm	6.9.6-22a
6.9.7.35	athmp15kr_12_8_5	7000 g U, 7000 g ^{235}U, 500.0 g CH_2, 9008.3 g H_2O, h/x=35.99, Rc=31.08025 cm	6.9.6-23
6.9.7.36	athmpw15kr_12_8_5	7000 g U, 7000 g ^{235}U, 500.0 g CH_2, 6803.8 g H_2O, h/x=27.77, Rc=12.26673 cm, 53419.6 g Kao, Rs=31.63191 cm	6.9.6-23
6.9.7.37	athmpw13kr_12_8_5	7000 g U, 7000 g ^{235}U, 500.0 g CH_2, 5896.6 g H_2O, h/x=24.38, Rc=11.76592 cm, 53419.6 g Kao, Rs=31.55946 cm	6.9.6-23
6.9.7.38	athmp15kmr_7_7_8_5	7000 g U,(3500 g ^{235}U, 500 g CH_2, 9008.5 g H_2O, h/x=71.97, Rc=31.06492 cm, 3500 g ^{235}U, Rs=31.08035 cm	6.9.6-23
6.9.7.39	cvcrtriga_1_1	0.0 in. np, 10400.0 g $UZrH_x$ (921.0 g ^{235}U, 0.0 g H_2O, hx = 0.00)	6.9.6-19a
6.9.7.40	cvcrtriga_1_15	0.0 in. np, 10400.0 g $UZrH_x$ (921.0 g ^{235}U, 8998.2 g H_2O, hx = 255.01)	6.9.6-19a
6.9.7.41	cvcrtriga_2_15	1.4 in. np, 10400.0 g $UZrH_x$ (921.0 g ^{235}U, 8384.6 g H_2O, h/x = 237.62)	6.9.6-19a
6.9.7.42	cvcrtriga_70_1_1	0.0 in. np, 6847.1 g $UZrH_x$ (408.0 g ^{235}U, 0.0 g H_2O, h/x = 0.0)	6.9.6-19a
6.9.7.43	cvcrtriga_70_1_15	0.0 in. np, 6847.1 g $UZrH_x$ (408.0 g ^{235}U, 8998.2 g H_2O, h/x = 575.64)	6.9.6-19a
6.9.7.44	cvcrtriga_70_2_15	1.4 in. np, 6847.1 g $UZrH_x$ (408.0 g ^{235}U, 8384.6 g H_2O, h/x = 536.39)	6.9.6-19a
6.9.7.45	ncsrtriga_1_15_15	0.0 in. np, 10400.0 g $UZrH_x$ (921.0 g ^{235}U, 8998.2 g H_2O, h/x = 255.01)	6.9.6-20a
6.9.7.46	ncsrtriga70_1_15_15	0.0 in. np, 6847.1 g UZrHx (408.0 g ^{235}U, 8998.2 g H_2O, h/x = 575.64)	6.9.6-20b
6.9.7.47	ncsrt55d2_1_15_15	0.0 in. np, 10400.0 g $UZrH_x$ (921.0 g ^{235}U, 8998.2 g H_2O, h/x = 255.01)	6.9.6-20d
6.9.7.48	hcsrtriga_1_15_15	0.0 in. np, 10400.0 g $UZrH_x$ (921.0 g ^{235}U, 8998.2 g H_2O, h/x = 255.01)	6.9.6-20a
6.9.7.49	hcsrtriga70_1_15_15	0.0 in. np, 6847.1 g $UZrH_x$ (408.0 g ^{235}U, 8998.2 g H_2O, h/x = 575.64)	6.9.6-20b
6.9.7.50	nciatriga_1_15_3	0.0 in. np, 10400.0 g $UZrH_x$ (921.0 g ^{235}U, 8998.2 g H_2O, h/x = 255.01)	6.9.6-20a
6.9.7.51	nciatriga70_1_15_3	0.0 in. np, 6847.1 g $UZrH_x$ (408.0 g ^{235}U, 8998.2 g H_2O, h/x = 575.64)	6.9.6-20b
6.9.7.52	hciatriga_1_15_3	0.0 in. np, 10400.0 g $UZrH_x$ (921.0 g ^{235}U, 8998.2 g H_2O, h/x = 255.01)	6.9.6-20a

ES-3100 Input file - Results table crosswalk

Section	Case	Description	Results table
6.9.7.53	hciatriga70_1_15_3	0.0 in. np, 6847.1 g $UZrH_x$ (408.0 g ^{235}U, 8998.2 g H_2O, h/x = 575.64)	6.9.6-20b
6.9.7.54	ncsrT70_131_1_15_15	0.0in. np, 5666.6 g $UZrH_x$ (337.7 g ^{235}U, 9204.9 g H_2O, hx = 711.53), fr=1.0E+00	6.9.6-20c
6.9.7.55	nciaT70_131_1_15_3	0.0in. np, 5666.6 g $UZrH_x$ (337.7 g ^{235}U, 9204.9 g H_2O, hx = 711.53), fr=1.0E-04	6.9.6-20c
6.9.7.56	athopw15kr20_5	15763.0 g U_3O_8-Al (921.0 g ^{235}U, 500.0 g CH_2, 6803.8 g H_2O, h/x = 211.0, Rc=14.13813 cm, 53419.6 g Kao, Rs=31.95515 cm	6.9.6-22c
6.9.7.57	athopw15kr70_5	1995.7 g U_3O_8-Al (408.0 g ^{235}U, 500.0 g CH_2, 6803.8 g H_2O, h/x = 476.3, Rc=12.36884 cm, 53419.6 g Kao, Rs=31.64738 cm	6.9.6-22c
6.9.7.58	athopw15kr93_5	1505.0 g U_3O_8-Al (408.0 g ^{235}U, 500.0 g CH_2, 6803.8 g H_2O, h/x=476.3, Rc=12.29589 cm, 53419.6 g Kao, Rs=31.63630 cm	6.9.6-22c
6.9.7.59	athupw15kr93_5	920.5 g UO_2 Mg-Al (408.0 g ^{235}U, 500.0 g CH_2, 6803.8 g H_2O, g htox=476.3, Rc=12.25670 cm, 53419.6 g Kao, Rs=31.63040 cm	6.9.6-22d
6.9.7.60	athupw15kr20_5	9677.7 g UO Mg-Al (921.0 g ^{235}U, 500.0 g CH_2, 6803.8 g H_2O, g htox=211.0, Rc=13.27685 cm, 53419.6 g Kao, Rs=31.79582 cm	6.9.6-22d
6.9.7.61	athupw15kr09_5	19592.0 g UO_2 Mg-Al (921.0 g ^{235}U, 500.0 g CH_2, 6803.8 g H_2O, g htox=210.7, Rc=14.32268 cm, 53419.6 g Kao, Rs=31.99170 cm	6.9.6-22d
6.9.7.62	athbpw15kr93_5	497.30 g UO_2 (408.0 g ^{235}U, 500.0 g CH_2, 6803.8 g H_2O, htox=476.3, Rc=12.10567 cm, 53419.6 g Kao, Rs=31.60798 cm	6.9.6-22d
6.9.7.63	cvcrcyat11_2_2	3 cyl, 1.4 in. np, 30,000 g U (30,000 g ^{235}U, 7,991.5 g H_2O, hx=6.95), sep=0.254	6.9.6-3b
6.9.7.64	cvcrcyat11_11_2	3 cyl, 1.4 in. np, 30,000 g U (30,000 g ^{235}U, 7,991.5 g H_2O, hx=6.95), sep=4.826	6.9.6-3b
6.9.7.65	cvcrpunhct11_10_15	10,000.2 g UNHc (4,709.7 g ^{235}U, 2,165.3 g H_2O) 6,081 g H_2O CV, hx=49.26	6.9.6-14
6.9.7.66	cvcrbpunhct11_24_15	24,000.0 g UNHc (11,303.1 g ^{235}U, 5,196.7 g H_2O) 1,077.9 g H_2O CV, hx=15.97	6.9.6-14
6.9.7.67	nciapbmflt11_1_6_4_5	0.0 in. np, 4,000.2 g U (3,200.2 g ^{235}U), 9,442.7 g H_2O CV, hx=82.26, fr=0.0001	6.9.6-11b
6.9.7.68	nciapbmfdt11_1_6_4_5	0.0 in. np, 4,000.2 g U (3,200.2 g ^{235}U), 9,442.7 g H_2O CV, hx=82.26, fr=0.0001	6.9.6-11b
6.9.7.69	ncsrpunhct11_8_15	8,000.1 g UNHc (3,767.7 g ^{235}U, 1,732.2 g H_2O) 6,795.6 g H_2O CV, hx= 63.53	6.9.6-15
6.9.7.70	icsrpunhct12_15_15	15,000.0 g UNHc (7,064.4 g ^{235}U, 3,247.9 g H_2O) 6,397.6 g H_2O CV, hx=53.28	6.9.6-16

[a] N/A = not applicable. Input files included in appendix for comparison with bounding model but not recorded in results tables.

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6.9.7.1 Case cvcrcyt11_21_1

```
=csas25    parm=size=3000000
cvcrcyt11 3cyl,0.0in thk np,21000.0gU(21000.0g235, 9082.6gH2O hx= 11.29),fr=1.0e+00
238groupndf5 infhommedium
'HEU volume =1116.36286, SPACER volume    0.00000'
'HEU wrapped dry content can hx=0.80, CV void volume 9098.99908'
uranium  1 den=18.81109 1.0 293      92235  100.00
                                     92238   0.000               end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
cvcrcyt11 3cyl,0.0in thk np,21000.0gU(21000.0g235, 9082.6gH2O,hx= 11.29),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                        end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1006
'content (collapsed) [Elev= 7.675 in.]'
 cylinder  1  1    4.114800     6.99579   0.0     com='cylindrical content'
 cylinder  3  1    6.426200    6.99629  -0.0005  com='cv well cavity'
 cylinder  8  1    6.680200    6.99629  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200    6.99629  -0.0005  com='drum chine outer radius'
```

```
unit 1007
'np277_4 spacer [Elev= 7.675 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'20.99097             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   56.09803   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   56.09803   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   56.09803   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
```

```
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.2 Case cvcrcyt11_36_2

```
=csas25    parm=size=3000000
cvcrcyt11 3cyl,1.4in thk np,36000.0gU(36000.0g235, 7673.1gH2O hx=  5.56),fr=1.0e+00
238groupndf5 infhommedium
'HEU volume =1913.76490, SPACER volume  614.68012'
'HEU wrapped dry content can hx=0.47, CV void volume 7686.91692'
uranium  1 den=18.81109 1.0 293      92235  100.00
                                     92238   0.000               end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
cvcrcyt11 3cyl,1.4in thk np,36000.0gU(36000.0g235, 7673.1gH2O,hx=  5.56),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                         end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
```

```
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1006
'content (collapsed) [Elev= 9.642 in.]'
 cylinder  1  1    4.114800    11.99278   0.0     com='cylindrical content'
 cylinder  3  1    6.426200   11.99328  -0.0005  com='cv well cavity'
 cylinder  8  1    6.680200   11.99328  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200   11.99328  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev=11.042 in.]'
 cylinder  2  1    5.24510     3.55610   0.0     com='np spacer'
 cylinder  3  1    6.426200    3.55620  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    3.55620  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    3.55620  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'43.09395             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   33.99505   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   33.99505   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   33.99505   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
```

```
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.3 Case cvcrsqt11_36_1

```
=csas25    parm=size=3000000
cvcrsqt11 3bar,0.0in thk np,36000.0gU(36000.0g235, 8286.7gH2O hx=  6.01),fr=1.0e+00
238groupndf5 infhommedium
'HEU volume =1913.76490, SPACER volume    0.00000'
'HEU wrapped dry content can hx=0.47, CV void volume 8301.59704'
uranium  1 den=18.81109 1.0 293      92235  100.00
                                     92238   0.000               end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'reflective water'
```

```
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   21  1.0     293  end
end comp
cvcrsqt11 3bar,0.0in thk np,36000.0gU(36000.0g235, 8286.7gH2O,hx=  6.01),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                         end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1006
'content (collapsed) [Elev=12.337 in.]'
 cuboid    1  1  4p2.909600    18.83826   0.0     com='block content'
 cylinder  3  1    6.426200   18.83876  -0.0005  com='cv well cavity'
 cylinder  8  1    6.680200   18.83876  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200   18.83876  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev=12.337 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'56.51838             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   20.57062   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   20.57062   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   20.57062   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
```

```
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.4 Case cvcrcyct11_17_1

```
=csas25    parm=size=3000000
cvcrcyct11 3cyl,0.0in thk np,17000.1gU(17000.1g235, 9294.9gH2O hx= 14.27),fr=1.0e+00
238groupndf5 infhommedium
'HEU volume = 903.72763, SPACER volume    0.00000'
'HEU wrapped dry content can hx=0.99, CV void volume 9311.63431'
uranium  1 den=18.81109 1.0 293      92235  100.00
                                     92238   0.000               end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
```

```
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                  8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                                  8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                              8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                              9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                             10  0.94348 293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                                  8016   88.8087   21  1.0     293  end
end comp
cvcrcyct11 3cyl,0.0in thk np,17000.1gU(17000.1g235, 9294.9gH2O,hx= 14.27),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                           end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1006
'content (collapsed) [Elev= 6.216 in.]'
 cylinder  1  1    5.397500     3.29140   0.0     com='cylindrical content'
 cylinder  3  1    6.426200    3.29190  -0.0005  com='cv well cavity'
 cylinder  8  1    6.680200    3.29190  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200    3.29190  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 6.216 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
' 9.87781             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   67.21119   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   67.21119   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   67.21119   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
```

```
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.5 Case cvcrcyct11_32_2

```
=csas25    parm=size=3000000
cvcrcyct11 3cyl,1.4in thk np,32000.1gU(32000.1g235, 7885.3gH2O hx=  6.43),fr=1.0e+00
238groupndf5 infhommedium
'HEU volume =1701.12968, SPACER volume  614.68012'
'HEU wrapped dry content can hx=0.52, CV void volume 7899.55215'
uranium  1 den=18.81109 1.0 293      92235  100.00
                                     92238   0.000               end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
```

```
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                  5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                  7014    0.0141
                                  8016   43.4251
                                 11023    0.1174
                                 12000    0.3378
                                 13027   39.0479
                                 14000    2.4672
                                 16000    0.3083
                                 20000   11.8336
                                 26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                  8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
cvcrcyct11 3cyl,1.4in thk np,32000.1gU(32000.1g235, 7885.3gH2O,hx=  6.43),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                         end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1006
'content (collapsed) [Elev= 7.360 in.]'
 cylinder  1  1    5.397500     6.19557   0.0     com='cylindrical content'
 cylinder  3  1    6.426200    6.19607  -0.0005  com='cv well cavity'
 cylinder  8  1    6.680200    6.19607  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200    6.19607  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 8.760 in.]'
 cylinder  2  1    5.24510     3.55610   0.0     com='np spacer'
 cylinder  3  1    6.426200    3.55620  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    3.55620  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    3.55620  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'25.70230             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   51.38670   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   51.38670   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   51.38670   0.0     com='drum chine outer radius'
unit 1010
```

```
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.6 Case cvcr5est11_1_1

```
=csas25    parm=size=3000000
cvcr5est11,0.0in np,18277.3gU(18277.3g235, 9226.9gH2O hx= 13.18),fr=1.0e+00
238groupndf5 infhommedium
'HEU volume = 971.62217, SPACER volume    0.01729'
'HEU wrapped dry content can hx=0.92, CV void volume 9243.50194'
uranium  1 den=18.81109 1.0 293      92235  100.00
                                     92238   0.000               end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.31846e4 cm3 = (8.0457422e2 in3)(16.387064)'
'den.multiplier = 1.31846e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.518047 = (den.mult)(np277-4 min.den.) = 0.9935052*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.26267e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.06375e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.81674e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
```

```
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                              8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                              8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                              8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                              8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                              8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                              8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                              8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                              8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
```

```
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                              8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
cvcr5est11,0.0in np,18277.3gU(18277.3g235, 9226.9gH2O,hx= 13.18),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                         end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1004
'1st content can (collapsed) [Elev= 6.983 in.]'
'Reference CRC 29 Ed. pg 105'
'side of pentagon denoted spent'
'radius of inscribed circle in pentagon denoted icrpent'
'radius of circumscribed circle outside pentagon denoted ccrpent'
'ccrpent equals 0.85065 times spent'
'icrpent equals 0.68819 times spent'
'side of pentagon equals diameter of a cylinder fit into cc'
'radius of cc equals ccrpent plus radius of cylinder fit into cc'
'radius of ccrpent equal diamater of slug'
' 3.96875 radius of circumscribed circle'
' 2.33277 half of side of pentagon'
' 3.21078 radius of inscribed circle'
' 3.77452 x axis location of 2nd cyl in cc'
' 1.22642 y axis location of 2nd cyl in cc'
 cylinder  3  1    6.426200    5.23925  -0.0005  com='cv well cavity'
 hole  1020    0.0       3.96875 0.0        com='cy1 (0,ccrpent)'
 hole  1020    3.77452   1.22642 0.0        com='cy2 (xtwo,ytwo)'
 hole  1020    2.33277  -3.21078 0.0        com='cy3 (hspent,-icrpent)'
 hole  1020   -2.33277  -3.21078 0.0        com='cy4 (-hspent,-icrpent)'
 hole  1020   -3.77452   1.22642 0.0        com='cy5 (-xtwo,ytwo)'
 cylinder  8  1    6.680200    5.23925  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200    5.23925  -0.0005  com='drum chine outer radius'
unit 1005
'np277_4 spacer [Elev= 6.983 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1006
'2nd content can (collapsed) [Elev= 9.046 in.]'
 cylinder  3  1    6.426200    5.23925  -0.0005  com='cv well cavity'
 hole  1021    0.0       3.96875 0.0        com='cy1 (0,ccrpent)'
 hole  1021    3.77452   1.22642 0.0        com='cy2 (xtwo,ytwo)'
 hole  1021    2.33277  -3.21078 0.0        com='cy3 (hspent,-icrpent)'
 hole  1021   -2.33277  -3.21078 0.0        com='cy4 (-hspent,-icrpent)'
 hole  1021   -3.77452   1.22642 0.0        com='cy5 (-xtwo,ytwo)'
 cylinder  8  1    6.680200    5.23925  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200    5.23925  -0.0005  com='drum chine outer radius'
```

```
unit 1007
'np277_4 spacer [Elev= 9.046 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'3rd content can (collapsed) [Elev= 9.046 in.]'
 cylinder  3  1    6.426200    5.23925  -0.0005  com='cv well cavity'
 hole  1022    0.0       3.96875 0.0        com='cy1 (0,ccrpent)'
 hole  1022    3.77452   1.22642 0.0        com='cy2 (xtwo,ytwo)'
 hole  1022    2.33277  -3.21078 0.0        com='cy3 (hspent,-icrpent)'
 hole  1022   -2.33277  -3.21078 0.0        com='cy4 (-hspent,-icrpent)'
 hole  1022   -3.77452   1.22642 0.0        com='cy5 (-xtwo,ytwo)'
 cylinder  8  1    6.680200    5.23925  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200    5.23925  -0.0005  com='drum chine outer radius'
unit 1009
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'15.72155             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   61.36745   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   61.36745   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   61.36745   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
unit 1020
'HEU cylinder content, 3.96875cm diameter by  5.23875cm height'
```

```
'  64.77481cm3 single slug volume'
 cylinder  1  1    1.983875  5.23875   0.0       com='cyl'
unit 1021
'HEU cylinder content, 3.96875cm diameter by  5.23875cm height'
'  64.77481cm3 single slug volume'
 cylinder  1  1    1.983875  5.23875   0.0       com='cyl'
unit 1022
'HEU cylinder content, 3.96875cm diameter by  5.23875cm height'
'  64.77481cm3 single slug volume'
 cylinder  1  1    1.983875  5.23875   0.0       com='cyl'
global
unit 1023
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1025
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1004 1005 1006 1007 1008 1009 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1023               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.7 Case cvcr6e4st11_1

```
=csas25    parm=size=3000000
cvcr6e4st11,0.0in np,36554.5gU(36554.5g235, 8257.0gH2O hx=  5.90),fr=1.0e+00
238groupndf5 infhommedium
'HEU volume =1943.24434, SPACER volume    0.01729'
'HEU wrapped dry content can hx=0.46, CV void volume 8271.87977'
uranium  1 den=18.81109 1.0 293      92235  100.00
                                     92238   0.000               end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
```

```
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.31846e4 cm3 = (8.0457422e2 in3)(16.387064)'
'den.multiplier = 1.31846e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.518047 = (den.mult)(np277-4 min.den.) = 0.9935052*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.26267e-2  2 0 0 0    5010   18.1479
                               5011   81.8520   11  0.7500  293  end
arbmnpmx  1.06375e+0 10 0 0 0    6012    1.9189
                               7014    0.0141
                               8016   43.4251
                              11023    0.1174
                              12000    0.3378
                              13027   39.0479
                              14000    2.4672
                              16000    0.3083
                              20000   11.8336
                              26000    0.5298   11  1.0000  293  end
arbmnph2o 3.81674e-1  2 0 0 0    1001   11.1913
                               8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                              8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                              8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                              8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                              8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                              8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                              8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                              8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                              8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430   13  0.367   293  end
```

```
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                               8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
cvcr6e4st11,0.0in np,36554.5gU(36554.5g235, 8257.0gH2O,hx=  5.90),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                       end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1004
'1st content can (collapsed) [Elev= 9.045 in.]'
'Reference CRC 29 Ed. pg 105'
'side of pentagon denoted spent'
'radius of inscribed circle in pentagon denoted icrpent'
'radius of circumscribed circle outside pentagon denoted ccrpent'
```

```
'ccrpent equals 0.85065 times spent'
'icrpent equals 0.68819 times spent'
'side of pentagon equals diameter of a cylinder fit into cc'
'radius of cc equals ccrpent plus radius of cylinder fit into cc'
'radius of ccrpent equal diamater of slug'
' 3.96925 radius of circumscribed circle'
' 2.33307 half of side of pentagon'
' 3.21119 radius of inscribed circle'
' 3.77499 x axis location of 2nd cyl in cc'
' 1.22658 y axis location of 2nd cyl in cc'
 cylinder  3  1    6.426200   10.47800  -0.0005  com='cv well cavity'
 hole  1020    0.0       3.96925 0.0        com='cy1 (0,ccrpent)'
 hole  1020    3.77499   1.22658 0.0        com='cy2 (xtwo,ytwo)'
 hole  1020    2.33307  -3.21119 0.0        com='cy3 (hspent,-icrpent)'
 hole  1020   -2.33307  -3.21119 0.0        com='cy4 (-hspent,-icrpent)'
 hole  1020   -3.77499   1.22658 0.0        com='cy5 (-xtwo,ytwo)'
 hole  1020    0.0       0.0    0.0        com='cy6 (0,0)'
 hole  1020    2.80704   0.0 5.23875      com='cy7'
 hole  1020   -2.80704   0.0 5.23875      com='cy8'
 hole  1020    0.0     2.80704 5.23875      com='cy9'
 hole  1020    0.0    -2.80704 5.23875      com='cy10'
 cylinder  8  1    6.680200   10.47800  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200   10.47800  -0.0005  com='drum chine outer radius'
unit 1005
'np277_4 spacer [Elev= 9.046 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1006
'2nd content can (collapsed) [Elev=13.171 in.]'
 cylinder  3  1    6.426200   10.47800  -0.0005  com='cv well cavity'
 hole  1021    0.0       3.96925 0.0        com='cy1 (0,ccrpent)'
 hole  1021    3.77499   1.22658 0.0        com='cy2 (xtwo,ytwo)'
 hole  1021    2.33307  -3.21119 0.0        com='cy3 (hspent,-icrpent)'
 hole  1021   -2.33307  -3.21119 0.0        com='cy4 (-hspent,-icrpent)'
 hole  1021   -3.77499   1.22658 0.0        com='cy5 (-xtwo,ytwo)'
 hole  1021    0.0       0.0    0.0        com='cy6 (0,0)'
 hole  1021    2.80704   0.0 5.23875      com='cy7'
 hole  1021   -2.80704   0.0 5.23875      com='cy8'
 hole  1021    0.0     2.80704 5.23875      com='cy9'
 hole  1021    0.0    -2.80704 5.23875      com='cy10'
 cylinder  8  1    6.680200   10.47800  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200   10.47800  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev=13.171 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'3rd content can (collapsed) [Elev=13.171 in.]'
 cylinder  3  1    6.426200   10.47800  -0.0005  com='cv well cavity'
 hole  1022    0.0       3.96925 0.0        com='cy1 (0,ccrpent)'
 hole  1022    3.77499   1.22658 0.0        com='cy2 (xtwo,ytwo)'
 hole  1022    2.33307  -3.21119 0.0        com='cy3 (hspent,-icrpent)'
 hole  1022   -2.33307  -3.21119 0.0        com='cy4 (-hspent,-icrpent)'
 hole  1022   -3.77499   1.22658 0.0        com='cy5 (-xtwo,ytwo)'
 hole  1022    0.0       0.0    0.0        com='cy6 (0,0)'
 hole  1022    2.80704   0.0 5.23875      com='cy7'
 hole  1022   -2.80704   0.0 5.23875      com='cy8'
```

```
 hole  1022    0.0     2.80704 5.23875      com='cy9'
 hole  1022    0.0    -2.80704 5.23875      com='cy10'
 cylinder  8  1    6.680200   10.47800  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200   10.47800  -0.0005  com='drum chine outer radius'
unit 1009
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'31.43780             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   45.65120   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   45.65120   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   45.65120   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
unit 1020
'HEU cylinder content, 3.96875cm diameter by  5.23875cm height'
'  64.77481cm3 single slug volume'
 cylinder  1  1    1.983875  5.23875   0.0       com='cyl'
unit 1021
'HEU cylinder content, 3.96875cm diameter by  5.23875cm height'
'  64.77481cm3 single slug volume'
 cylinder  1  1    1.983875  5.23875   0.0       com='cyl'
unit 1022
'HEU cylinder content, 3.96875cm diameter by  5.23875cm height'
'  64.77481cm3 single slug volume'
 cylinder  1  1    1.983875  5.23875   0.0       com='cyl'
global
unit 1023
```

```
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1025
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1004 1005 1006 1007 1008 1009 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1023               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.8 Case cvcr70st11_2

```
=csas25    parm=size=3000000
cvcr70st11,1.4in np,25588.2gU(25588.2g235, 8225.3gH2O hx=  8.39),fr=1.0e+00
238groupndf5 infhommedium
'HEU volume =1360.27104, SPACER volume  614.69740'
'HEU wrapped dry content can hx=0.66, CV void volume 8240.17295'
uranium  1 den=18.81109 1.0 293      92235  100.00
                                     92238   0.000               end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                          8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                          9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                         10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.31846e4 cm3 = (8.0457422e2 in3)(16.387064)'
'den.multiplier = 1.31846e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
```

```
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.518047 = (den.mult)(np277-4 min.den.) = 0.9935052*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.26267e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.06375e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.81674e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                               8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
```

```
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  1       293  end
'steel: liner'
ss304                                          16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                          17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                          18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                          18  1.25705 293  end
'steel: drum steel for single units'
ss304                                          19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                          19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                               8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   21  1.0     293  end
end comp
cvcr70st11,1.4in np,25588.2gU(25588.2g235, 8225.3gH2O,hx=  8.39),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                        end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1004
'1st content can (collapsed) [Elev= 6.983 in.]'
'3.437212   plus-y location cylinders'
'-3.437212  minus-y location cylinders'
'1.984375   plus-x location cylinders'
'-1.984375  minus-x location cylinders'
 cylinder  3  1    6.426200    5.23925  -0.0005  com='cv well cavity'
 hole  1020   -3.968750   0.0       0.0     com='cy1 (2cymx,0)'
 hole  1020   -1.984375   3.437212  0.0     com='cy2 (cymx,cypy)'
 hole  1020    1.984375   3.437212  0.0     com='cy3 (cypx,cypy)'
 hole  1020    3.968750   0.0       0.0     com='cy4 (2cypx,0)'
 hole  1020    1.984375  -3.437212  0.0     com='cy5 (cypx,cymx)'
 hole  1020   -1.984375  -3.437212  0.0     com='cy6 (cymx,cymy)'
 hole  1020    0.0        0.0       0.0     com='cy7 (0,0)'
 cylinder  8  1    6.680200    5.23925  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200    5.23925  -0.0005  com='drum chine outer radius'
unit 1005
'np277_4 spacer [Elev= 8.383 in.]'
```

```
 cylinder  2  1    5.24510     3.55610   0.0     com='np spacer'
 cylinder  3  1    6.426200    3.55620  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    3.55620  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    3.55620  -0.0001  com='drum chine outer radius'
unit 1006
'2nd content can (collapsed) [Elev=10.446 in.]'
 cylinder  3  1    6.426200    5.23925  -0.0005  com='cv well cavity'
 hole  1021   -3.968750   0.0       0.0     com='cy1 (2cymx,0)'
 hole  1021   -1.984375   3.437212  0.0     com='cy2 (cymx,cypy)'
 hole  1021    1.984375   3.437212  0.0     com='cy3 (cypx,cypy)'
 hole  1021    3.968750   0.0       0.0     com='cy4 (2cypx,0)'
 hole  1021    1.984375  -3.437212  0.0     com='cy5 (cypx,cymx)'
 hole  1021   -1.984375  -3.437212  0.0     com='cy6 (cymx,cymy)'
 hole  1021    0.0        0.0       0.0     com='cy7 (0,0)'
 cylinder  8  1    6.680200    5.23925  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200    5.23925  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev=11.846 in.]'
 cylinder  2  1    5.24510     3.55610   0.0     com='np spacer'
 cylinder  3  1    6.426200    3.55620  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    3.55620  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    3.55620  -0.0001  com='drum chine outer radius'
unit 1008
'3rd content can (collapsed) [Elev=10.446 in.]'
 cylinder  3  1    6.426200    5.23925  -0.0005  com='cv well cavity'
 hole  1022   -3.968750   0.0       0.0     com='cy1 (2cymx,0)'
 hole  1022   -1.984375   3.437212  0.0     com='cy2 (cymx,cypy)'
 hole  1022    1.984375   3.437212  0.0     com='cy3 (cypx,cypy)'
 hole  1022    3.968750   0.0       0.0     com='cy4 (2cypx,0)'
 hole  1022    1.984375  -3.437212  0.0     com='cy5 (cypx,cymx)'
 hole  1022   -1.984375  -3.437212  0.0     com='cy6 (cymx,cymy)'
 hole  1022    0.0        0.0       0.0     com='cy7 (0,0)'
 cylinder  8  1    6.680200    5.23925  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200    5.23925  -0.0005  com='drum chine outer radius'
unit 1009
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'22.83355             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   54.25545   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   54.25545   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   54.25545   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
```

```
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
unit 1020
'HEU cylinder content, 3.96875cm diameter by  5.23875cm height'
'  64.77481cm3 single slug volume'
 cylinder  1  1    1.983875  5.23875   0.0       com='cyl'
unit 1021
'HEU cylinder content, 3.96875cm diameter by  5.23875cm height'
'  64.77481cm3 single slug volume'
 cylinder  1  1    1.983875  5.23875   0.0       com='cyl'
unit 1022
'HEU cylinder content, 3.96875cm diameter by  5.23875cm height'
'  64.77481cm3 single slug volume'
 cylinder  1  1    1.983875  5.23875   0.0       com='cyl'
global
unit 1023
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1025
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1004 1005 1006 1007 1008 1009 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1023               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.9 Case cvr3sqa_26_1_8_15

```
=csas25    parm=size=3000000
cvr 3x3sqa,0.0in thk np,25893.7gU(25893.7g235, 8822.9gH2O hx=  8.89),fr=1.0e+00
238groupndf5 infhommedium
'HEU volume =1376.51338, SPACER volume    0.00000'
'HEU wrapped dry content can hx=0.65, CV void volume 8838.84856'
uranium  1 den=18.81109 1.0 293      92235  100.00
                                     92238   0.000               end
```

```
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07072e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4264
                                11023    0.1174
                                12000    0.3378
                                13027   39.0470
                                14000    2.4671
                                16000    0.3083
                                20000   11.8333
                                26000    0.5297    2  1.0000  293  end
arbmnph2o 3.84144e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'void space internal to containmment vessel -- including content cans'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
cvr 3x3sqa,0.0in thk np,25893.7gU(25893.7g235, 8822.9gH2O,hx=  8.89),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                         end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1004
'cubical content, stacked per cc'
'    9.08802     3.57796 lattice width-depth'
'    2.54000     1.00000 cube dimension'
'    1.27000     0.50000 cube half-dimension'
'   16.38706     1.00000 volume of HEU cube in unit cell'
'  308.25850             HEU mass one cube'
'   28                   number of HEU cubes per can'
' 8631.23808             HEU mass of cubes in cc'
'    3           3       number of cubes in -x direction'
'    3           3       number of cubes in -y direction'
'    9           9       number of HEU cubes in a layer'
'    4    VARIABLE       number of HEU layers in z-axis'
'    1    VARIABLE       number of HEU cubes in top layer modulus(Z%N)'
'    8    VARIABLE       number of HEU voids in top layer'
'    ara=1 nux=3 nuy=3 nuz=4   fill 28r1004  8r1005      end fill'
```

```
'    0.48924     0.19261 gap dimension                        CALCULATED
'    3.02924     1.19261 unit cell dimension                  CALCULATED
'    1.51462     0.59631 unit cell half-dimension             CALCULATED
'   27.79719     1.69629 volume of unit cell                  CALCULATED
'   11.41013     0.69629 volume of water gap in unit cell     CALCULATED
 cuboid    1  1  6p1.26990                       com='content cube'
 cuboid    3  1  6p1.51452                       com='unit cell'
unit 1005
'cubical void, filler for layers'
 cuboid    3  1  6p1.51452                       com='unit cell'
unit 1006
'content (collapsed) [Elev= 9.691 in.]'
' 4.54386     1.78892 half width-depth lattice            CALCULATED'
'12.11696             height lattice                      CALCULATED'
 array 1         2r-4.54386      0.0
 cuboid    3  1  4p4.54386     12.1169   0.0     com='content-array'
 cylinder  3  1    6.426200   12.11746  -0.0005  com='cv well cavity'
 cylinder  8  1    6.680200   12.11746  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200   12.11746  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.691 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'36.35448             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   40.73452   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   40.73452   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   40.73452   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
```

```
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
 array 3   2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=1 nux=3 nuy=3 nuz=4   fill 28r1004  8r1005      end fill
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.10 Case cvr3lha_26_1_8_15

```
=csas25    parm=size=3000000
cvr 3x3lha,0.0in thk np,25893.7gU(25893.7g235, 8822.9gH2O hx=  8.89),fr=1.0e+00
238groupndf5 infhommedium
'HEU volume =1376.51338, SPACER volume    0.00000'
'HEU wrapped dry content can hx=0.65, CV void volume 8838.84856'
uranium  1 den=18.81109 0.45852 293      92235  100.00
                                      92238   0.000               end
arbmh20i   0.54051  2 0 0 0    1001   11.1913
                                8016   88.8087    1  1       293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07072e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4264
                                11023    0.1174
                                12000    0.3378
                                13027   39.0470
                                14000    2.4671
                                16000    0.3083
                                20000   11.8333
                                26000    0.5297    2  1.0000  293  end
arbmnph2o 3.84144e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
```

```
'void space internal to containmment vessel -- including content cans'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
cvr 3x3lha,0.0in thk np,25893.7gU(25893.7g235, 8822.9gH2O,hx=  8.89),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                         end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1004
'cubical content, stacked per cc'
'    9.08802     3.57796 lattice width-depth'
'    2.54000     1.00000 cube dimension'
'    1.27000     0.50000 cube half-dimension'
'   16.38706     1.00000 volume of HEU cube in unit cell'
'  308.25850             HEU mass one cube'
'   28                   number of HEU cubes per can'
' 8631.23808             HEU mass of cubes in cc'
'    3           3       number of cubes in -x direction'
'    3           3       number of cubes in -y direction'
'    9           9       number of HEU cubes in a layer'
'    4    VARIABLE       number of HEU layers in z-axis'
'    1    VARIABLE       number of HEU cubes in top layer modulus(Z%N)'
'    8    VARIABLE       number of HEU voids in top layer'
'    ara=1 nux=3 nuy=3 nuz=4   fill 28r1004  8r1005      end fill'
'    0.48924     0.19261 gap dimension                       CALCULATED
'    3.02924     1.19261 unit cell dimension                 CALCULATED
'    1.51462     0.59631 unit cell half-dimension            CALCULATED
'   27.79719     1.69629 volume of unit cell                 CALCULATED
'   11.41013     0.69629 volume of water gap in unit cell    CALCULATED
' 1000.69893             lattice volume in cc                CALCULATED
'  541.86113             moderator volume in lattice in cc   CALCULATED
'  458.83779             HEU volume in lattice in cc         CALCULATED
'    0.45852             volume fraction of HEU in lattice'  CALCULATED
'    0.54051             bulk dens of water in lattice in cc CALCULATED
 cuboid    1  1  6p1.51452                      com='unit cell'
unit 1005
'cubical void, filler for layers'
 cuboid    1  1  6p1.51452                      com='unit cell'
unit 1006
'content (collapsed) [Elev= 9.691 in.]'
' 4.54386     1.78892 half width-depth lattice            CALCULATED'
'12.11696             height lattice                      CALCULATED'
```

```
'array 1         2r-4.54386      0.0'
 cuboid    1  1  4p4.54386     12.1169   0.0     com='homog. content-array'
 cylinder  3  1    6.426200   12.11746  -0.0005  com='cv well cavity'
 cylinder  8  1    6.680200   12.11746  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200   12.11746  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.691 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'36.35448             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   40.73452   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   40.73452   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   40.73452   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
 array 3   2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
```

```
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=1 nux=3 nuy=3 nuz=4   fill 28r1004  8r1005      end fill
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.11 Case cvr3cha_26_1_8_15

```
=csas25    parm=size=3000000
cvr 3x3cha,0.0in thk np,25893.7gU(25893.7g235, 8822.9gH2O hx=  8.89),fr=1.0e+00
238groupndf5 infhommedium
'HEU volume =1376.51338, SPACER volume    0.00000'
'HEU wrapped dry content can hx=0.65, CV void volume 8838.84856'
uranium  1 den=18.81109 0.13475 293      92235  100.00
                                      92238   0.000               end
arbmh20i   0.86369  2 0 0 0    1001   11.1913
                               8016   88.8087    1  1       293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07072e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4264
                                11023    0.1174
                                12000    0.3378
                                13027   39.0470
                                14000    2.4671
                                16000    0.3083
                                20000   11.8333
                                26000    0.5297    2  1.0000  293  end
arbmnph2o 3.84144e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'void space internal to containmment vessel -- including content cans'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
cvr 3x3cha,0.0in thk np,25893.7gU(25893.7g235, 8822.9gH2O,hx=  8.89),fr=1.0e+00
```

```
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                          end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1004
'cubical content, stacked per cc'
'    9.08802     3.57796 lattice width-depth'
'    2.54000     1.00000 cube dimension'
'    1.27000     0.50000 cube half-dimension'
'   16.38706     1.00000 volume of HEU cube in unit cell'
'  308.25850             HEU mass one cube'
'   28                   number of HEU cubes per can'
' 8631.23808             HEU mass of cubes in cc'
'    3           3       number of cubes in -x direction'
'    3           3       number of cubes in -y direction'
'    9           9       number of HEU cubes in a layer'
'    4    VARIABLE       number of HEU layers in z-axis'
'    1    VARIABLE       number of HEU cubes in top layer modulus(Z%N)'
'    8    VARIABLE       number of HEU voids in top layer'
'    ara=1 nux=3 nuy=3 nuz=4   fill 28r1004  8r1005      end fill'
'    0.48924     0.19261 gap dimension                        CALCULATED
'    3.02924     1.19261 unit cell dimension                  CALCULATED
'    1.51462     0.59631 unit cell half-dimension             CALCULATED
'   27.79719     1.69629 volume of unit cell                  CALCULATED
'   11.41013     0.69629 volume of water gap in unit cell     CALCULATED
' 1000.69893             lattice volume in cc                 CALCULATED
'  541.86113             moderator volume in lattice in cc    CALCULATED
'  458.83779             HEU volume in lattice in cc          CALCULATED
'    0.13475             volume fraction of HEU in CV         CALCULATED
'    0.86369             bulk dens of water in CV             CALCULATED
 cuboid    1  1  6p1.51452                       com='unit cell'
unit 1005
'cubical void, filler for layers'
 cuboid    1  1  6p1.51452                       com='unit cell'
unit 1006
'content (collapsed) [Elev= 9.691 in.]'
' 4.54386     1.78892 half width-depth lattice            CALCULATED'
'12.11696             height lattice                      CALCULATED'
'array 1         2r-4.54386      0.0'
 cuboid    1  1  4p4.54386     12.1169   0.0     com='homog. content-array'
 cylinder  1  1    6.426200   12.11746  -0.0005  com='cv well cavity'
 cylinder  8  1    6.680200   12.11746  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200   12.11746  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.691 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  1  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'36.35448             stack height (content spacers)       CALCULATED
```

```
 cylinder  1  1    6.426200   40.73452   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   40.73452   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   40.73452   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  1  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  1  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  1  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
 array 3   2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=1 nux=3 nuy=3 nuz=4   fill 28r1004  8r1005      end fill
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
```

```
end start
end data
end
```

6.9.7.12 Case cvcrpdoxt11_1_5_24_15

```
(This case name is actually cvcrpdoxt11_1_5_24_15.)
=csas25    parm=size=3000000
cvcrpoxt11,24000.0gUO2 (21124.9g235)1477.3gSH2O 5991.4gH2Ocv hx= 10.02 fr=1
238groupndf5 infhommedium
'HEU volume =3669.72477 HEU oxide, bulk density of oxide in cans=  6.54000 g/cm3'
'oxide= 24000.0 g, sat.h2o in HEU oxide=1477.3 g, oxide h/x= 1.83'
'poly (packed or wrapped) dry content h/x=0.79, CV void volume 6002.15891'
arbmuox    5.69638   2 0 0 0  92235   88.0203
                              8016   11.9797    1  1.0000  293  end
arbmastm  3.5063e-01  2 0 0 0  1001   11.1913
                              8016   88.8087    1  1.0000  293  end
arbmpoly  1.1867e-01  2 0 0 0  1001   14.3798
                              6012   85.6202    1  1.0000  293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  9.9820e-01  2 0 0 0   1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.31846e4 cm3 = (8.0457422e2 in3)(16.387064)'
'den.multiplier = 1.31846e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.518047 = (den.mult)(np277-4 min.den.) = 0.9935052*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.26267e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.06375e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
```

```
                              16000    0.3083
                              20000   11.8336
                              26000    0.5298   11  1.0000  293  end
arbmnph2o 3.81674e-1  2 0 0 0    1001   11.1913
                               8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                               8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
steel: angle iron (ai) for single units'
ss304                                         18  1.0     293  end
```

```
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                          18  1.25705 293  end
'steel: drum steel for single units'
ss304                                          19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                          19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                               8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
cvcrpoxt11,24000.0gUO2 (21124.9g235)1477.3gSH2O 5991.4gH2Ocv,hx= 10.02 fr=1
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                         end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.270 in.]'
 cylinder  3  1    6.426200   77.72400  33.11036 com='cavity abv HEU'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200   77.72400   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
```

```
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.13 Case cvcrsk3cc_9_15_17

```
csas25    parm=size=3000000
cvcrsk3cc,0.0,21300.0g soc(19865.3uox,15672.8u235,  921.0c),hx= 12.82,fr=1.0e+00
238groupndf5 infhommedium
'  cm3: Skull oxide content 6974.5, SPACER    0.0, CV void 3240.9; CV htox=12.82'
'g/cm3: Skull oxide content  3.05400'
'U3O8   (19865.33gUOX,16816.3gU,15672.8g235U, 3801.4g.sat.H2O, HX=  7.43)'
'Carbon (  921.00gC,   58764.1mgC/g235U)'
'Poly   (  513.00gCH2)'
'Other  (    0.67gUnident (assumed H2O)'
''
'Increm (  921.0gC,15672.8g235U,   58764.1mgC/g235U)'
'GREP1:21300.00 19865.33 3.8014e+03    7.43 16816.35 15672.84   921.00  58764.1
'GREP2: 3235.07   513.00      12.82    0.67  1.0e+00
''
arbmuox    2.84830    3 0 0 0  92235   78.8954
                               92238    5.7563
                                8016   15.3483    1  1.0000  293  end
arbmc     1.3205e-01  1 0 0 0   6012  100.0000    1  1.0000  293  end
arbmastm  5.4505e-01  2 0 0 0   1001   11.1913
                                8016   88.8087    1  1.0000  293  end
arbmpoly   0.07355    2 0 0 0   1001   14.3798
                                6012   85.6202    1  1.0000  293  end
'np277-4: spacer (NCT_MD&H)'
```

```
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  9.9820e-01  2 0 0 0   1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
cvcrsk3cc,0.0,21300.0g soc(19865.3uox,15672.8u235,  921.0c),hx= 12.82 fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                         end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.270 in.]'
 cylinder  3  1    6.426200   77.72400  54.39413 com='cavity abv HEU'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200   77.72400   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.00000 com='cavity abv HEU'
```

```
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.14 Case cvcrunhct11_9_1

```
=csas25    parm=size=3000000
cvcrunhct11 0.0innp,disp. 9000.0gUNHc( 4238.7g235, 6980.8gH2O hx= 54.99),fr=1.0e+00
238groupndf5 infhommedium
'U(enr)O2(NO3)2+6H2O [2.81 g/cc for U(nat)], gU/L= 414.9296'
'UNH crystals in cans  2.79329 g/cm3. wrapped dry content can hx=3.96'
arbmunh    2.79329  5 0 0 0   92235   47.0962
                              92238    0.0000
                               1001    2.4232
                               7014    5.6116
                               8016   44.8690    1  0.31541 293  end
```

```
arbmh2oc  6.8336e-01  2 0 0 0  1001   11.1913
                               8016   88.8087    1  1.0000  293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  6.8336e-01  2 0 0 0   1001   11.1913
                                8016   88.8087     3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                            8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                            9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                           10  0.94348 293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
cvcrunhct11 0.0innp,disp. 9000.0gUNHc( 4238.7g235, 6980.8gH2O,hx= 54.99),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                          end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.270 in.]'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200   77.72400   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
```

```
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.15 Case cvcrtriga_1_15

```
=csas25    parm=size=3000000
cvcrtriga 0.0in thk np,10400.0gUZrHx(  921.0g235, 8998.2gH2O hx=255.01),fr=1.0e+00
238groupndf5 infhommedium
'TRIGA volume =1200.95996, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=18.2, CV void volume 9014.40198'
arbmtriga  8.65974  4 0 0 0    1001    0.9554
                              40000   54.0446
                              92235    8.8558
                              92238   36.1442    1  1.0     293  end
'np277-4: spacer (NCT_MD&H)'
```

```
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
cvcrtriga 0.0in thk np,10400.0gUZrHx(  921.0g235, 8998.2gH2O,hx=255.01),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                         end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.828800   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.920 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.921 in.]'
```

```
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   38.98540   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   38.98540   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
```

```
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.16 Case ncsrcyt11_21_1_15

```
=csas25    parm=size=3000000
ncsrcyt11 3cyl,0.0in thk np,21000.0gU(21000.0g235, 9082.6gH2O hx= 11.29),fr=1.0e+00
238groupndf5 infhommedium
'HEU volume =1116.36286, SPACER volume    0.00000'
'HEU wrapped dry content can hx=0.80, CV void volume 9098.99908'
uranium  1 den=18.81109 1.0 293      92235  100.00
                                     92238   0.000               end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
```

```
                              16000    0.3083
                              20000   11.8336
                              26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                               8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                               8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                         18  1.0     293  end
```

```
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                          18  1.25705 293  end
'steel: drum steel for single units'
ss304                                          19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                          19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                               8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
ncsrcyt11 3cyl,0.0in thk np,21000.0gU(21000.0g235, 9082.6gH2O,hx= 11.29),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                         end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   23.329900    0.26670   0.0     com='drum bottom flat cover'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   23.177500   11.59510   0.0     com='kaolite'
 cylinder  19 1   23.329900   11.59510   0.0     com='drum'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   23.177500    0.63500   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.63500   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1006
'content (collapsed) [Elev= 7.675 in.]'
 cylinder  1  1    4.114800     6.99579   0.0     com='cylindrical content'
 cylinder  3  1    6.426200    6.99629  -0.0005  com='cv well cavity'
 cylinder  8  1    6.680200    6.99629  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800    6.99629  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200    6.99629  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000    6.99629  -0.0005  com='np277_4'
 cylinder  16 1   11.074400    6.99629  -0.0005  com='kaolite liner'
 cylinder  12 1   23.177500    6.99629  -0.0005  com='kaolite'
 cylinder  19 1   23.329900    6.99629  -0.0005  com='drum'
 cuboid    21 1 4p24.587200    6.99629  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 7.675 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
```

```
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   23.177500    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   23.329900    0.00020  -0.0001  com='drum'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'20.99097             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   56.09803   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   56.09803   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   56.09803   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   56.09803   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   56.09803   0.0     com='np277_4'
 cylinder  16 1   11.074400   56.09803   0.0     com='kaolite liner'
 cylinder  12 1   23.177500   56.09803   0.0     com='kaolite'
 cylinder  19 1   23.329900   56.09803   0.0     com='drum'
 cuboid    21 1 4p24.587200   56.09803   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   23.177500    0.22860   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.22860   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   23.177500    1.27000   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.27000   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   23.177500    2.92100   0.0     com='kaolite'
 cylinder  19 1   23.329900    2.92100   0.0     com='drum'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
```

```
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   23.177500    1.01600   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.01600   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   23.177500    8.17880   0.0     com='kaolite'
 cylinder  19 1   23.329900    8.17880   0.0     com='drum'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   23.177500    4.44500   0.0     com='kaolite'
 cylinder  19 1   23.329900    4.44500   0.0     com='drum'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   23.177500    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   23.329900    0.63500   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  21 1   22.961600    1.90500   0.15240 com='void above lid'
 cylinder  19 1   23.114000    1.90500   0.0     com='drum lid'
 cylinder  21 1   23.177500    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   23.329900    1.90500   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
```

```
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.17 Case nciacyct11_25_2_3

```
=csas25    parm=size=3000000
nciacyct11 3cyl,1.4in thk np,25000.2gU(25000.2g235, 8256.8gH2O hx=  8.62),fr=1.0e-04
238groupndf5 infhommedium
'HEU volume =1329.01404, SPACER volume  614.68012'
'HEU wrapped dry content can hx=0.67, CV void volume 8271.66778'
uranium  1 den=18.81109 1.0 293      92235  100.00
                                     92238   0.000               end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
```

```
                              14000    2.4672
                              16000    0.3083
                              20000   11.8336
                              26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                               8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'nct array densities are s.u.dens. multiplied by volume ratio 1.34888/1.10336'
arbmh2ok   0.63931  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.42622  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.42622  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.42622  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.42622  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.42622  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.42622  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.42622  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
```

```
'steel: angle iron (ai) for single units'
'ss304                                          18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
ss304                                          18  1.25705 293  end
'steel: drum steel for single units'
'ss304                                          19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
ss304                                          19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
arbmwed    1.16026  2 0 0 0    1001   11.1913
                               8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                              8016   88.8087   21  1.0     293  end
end comp
nciacyct11 3cyl,1.4in thk np,25000.2gU(25000.2g235, 8256.8gH2O,hx=  8.62),fr=1.0e-04
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                   end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.111 in. at top of unit]'
'cylinder  19 1   22.866096    0.28150   0.0     com='extended radius not used'
 cylinder  19 1   21.722275    0.28150   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p22.866096    0.28150   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.676 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.555075   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.722275   11.59510   0.0     com='drum'
 cuboid    20 1 4p22.866096   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.926 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   21.555075    0.63500   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1006
'content (collapsed) [Elev= 6.832 in.]'
 cylinder  1  1    5.397500     4.84031   0.0     com='cylindrical content'
 cylinder  3  1    6.426200    4.84081  -0.0005  com='cv well cavity'
 cylinder  8  1    6.680200    4.84081  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800    4.84081  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200    4.84081  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000    4.84081  -0.0005  com='np277_4'
 cylinder  16 1   11.074400    4.84081  -0.0005  com='kaolite liner'
 cylinder  12 1   21.555075    4.84081  -0.0005  com='kaolite'
 cylinder  19 1   21.722275    4.84081  -0.0005  com='drum'
 cuboid    20 1 4p22.866096    4.84081  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 8.232 in.]'
```

```
 cylinder  2  1    5.24510     3.55610   0.0     com='np spacer'
 cylinder  3  1    6.426200    3.55620  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    3.55620  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    3.55620  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    3.55620  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    3.55620  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    3.55620  -0.0001  com='kaolite liner'
 cylinder  12 1   21.555075    3.55620  -0.0001  com='kaolite'
 cylinder  19 1   21.722275    3.55620  -0.0001  com='drum'
 cuboid    20 1 4p22.866096    3.55620  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.276 in.]'
'21.63653             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   55.45247   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   55.45247   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   55.45247   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   55.45247   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   55.45247   0.0     com='np277_4'
 cylinder  16 1   11.074400   55.45247   0.0     com='kaolite liner'
 cylinder  12 1   21.555075   55.45247   0.0     com='kaolite'
 cylinder  19 1   21.722275   55.45247   0.0     com='drum'
 cuboid    20 1 4p22.866096   55.45247   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.336 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.426 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.555075    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.22860   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.926 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.27000   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.076 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.555075    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.722275    2.92100   0.0     com='drum'
 cuboid    20 1 4p22.866096    2.92100   0.0     com='drum chine outer radius'
```

```
unit 1014
'plugpad2 below liner 2nd step [Elev=37.476 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.01600   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.536 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.756 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.555075    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.722275    8.17880   0.0     com='drum'
 cuboid    20 1 4p22.866096    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.506 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.555075    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.722275    4.44500   0.0     com='drum'
 cuboid    20 1 4p22.866096    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.756 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.555075    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.512 in.]'
 cylinder  20 1   21.330090    1.91973   0.16720 com='void above lid'
 cylinder  19 1   21.497290    1.91973   0.0     com='drum lid'
 cylinder  20 1   21.555075    1.91973   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.722275    1.91973   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.91973   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.512 in.]'
array 3         2r-22.866096     0.0
'cuboid     0  1 4p24.587200    110.4900  0.0    com='bare package'
'cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
 cuboid    20  1 4p22.866096    110.5197  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
```

```
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.18 Case hciacyct12_25_2_3

```
=csas25    parm=size=3000000
hciacyct12 3cyl,1.4in thk np,25000.2gU(25000.2g235, 8256.8gH2O hx=  8.62),fr=1.0e-04
238groupndf5 infhommedium
'HEU wrapped dry content can hx=0.67, CV void volume 8271.66778'
uranium  1 den=18.81109 1.0 293      92235  100.00
                                     92238   0.000               end
'np277-4: spacer (HAC_MD&H)'
'HAC min.den.(95.3157 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07071e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.82995e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (HAC_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.476265 = (den.mult)(np277-4 min.den.) = 0.9668933*1.526803'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
```

```
                              13027   39.0477
                              14000    2.4671
                              16000    0.3083
                              20000   11.8335
                              26000    0.5298   11  1.0000  293  end
arbmnph2o 3.70316e-1  2 0 0 0    1001   11.1913
                               8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  0.0001  293  end
```

```
'steel: liner'
ss304                                          16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                          17  1.06388 293  end
'steel: angle iron (ai) for HAC'
'nct density is multiplied by volume fraction 7.08030/5.74516'
ss304                                          18  1.23239 293  end
'steel: drum steel for HAC'
'nct density is multiplied by volume fraction 3.20482/2.95645'
ss304                                          19  1.08401 293  end
'void space external to drum'
'array density is assumed not reduced by hac'
arbmwed    0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                              8016   88.8087   21  1.0     293  end
end comp
hciacyct12 3cyl,1.4in thk np,25000.2gU(25000.2g235, 8256.8gH2O,hx=  8.62),fr=1.0e-04
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                   end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   21.838092    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   21.838092    0.26670   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p21.838092    0.26670   0.0     com='drum(chine)outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.685692   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.838092   11.59510   0.0     com='drum'
 cuboid    20 1 4p21.838092   11.59510   0.0     com='drum(chine)outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   21.685692    0.63500   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.63500   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.63500   0.0     com='drum(chine)outer radius'
unit 1006
'content (collapsed) [Elev= 6.826 in.]'
 cylinder  1  1    5.397500     4.84031   0.0     com='cylindrical content'
 cylinder  3  1    6.426200    4.84081  -0.0005  com='cv well cavity'
 cylinder  8  1    6.680200    4.84081  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800    4.84081  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200    4.84081  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000    4.84081  -0.0005  com='np277_4'
 cylinder  16 1   11.074400    4.84081  -0.0005  com='kaolite liner'
 cylinder  12 1   21.685692    4.84081  -0.0005  com='kaolite'
 cylinder  19 1   21.838092    4.84081  -0.0005  com='drum'
 cuboid    20 1 4p21.838092    4.84081  -0.0005  com='drum(chine)outer radius'
unit 1007
'np277_4 spacer [Elev= 8.226 in.]'
```

```
 cylinder  2  1    5.24510     3.55610   0.0     com='np spacer'
 cylinder  3  1    6.426200    3.55620  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    3.55620  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    3.55620  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    3.55620  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    3.55620  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    3.55620  -0.0001  com='kaolite liner'
 cylinder  12 1   21.685692    3.55620  -0.0001  com='kaolite'
 cylinder  19 1   21.838092    3.55620  -0.0001  com='drum'
 cuboid    20 1 4p21.838092    3.55620  -0.0001  com='drum(chine)outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'21.63653             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   55.45247   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   55.45247   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   55.45247   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   55.45247   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   55.45247   0.0     com='np277_4'
 cylinder  16 1   11.074400   55.45247   0.0     com='kaolite liner'
 cylinder  12 1   21.685692   55.45247   0.0     com='kaolite'
 cylinder  19 1   21.838092   55.45247   0.0     com='drum'
 cuboid    20 1 4p21.838092   55.45247   0.0     com='drum(chine)outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.685692    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.22860   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.22860   0.0     com='drum(chine)outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.27000   0.0     com='drum'
 cuboid    20 1 4p21.838092    1.27000   0.0     com='drum(chine)outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.685692    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.838092    2.92100   0.0     com='drum'
 cuboid    20 1 4p21.838092    2.92100   0.0     com='drum(chine)outer radius'
```

```
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.01600   0.0     com='drum'
 cuboid    20 1 4p21.838092    1.01600   0.0     com='drum(chine)outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.685692    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.838092    8.17880   0.0     com='drum'
 cuboid    20 1 4p21.838092    8.17880   0.0     com='drum(chine)outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.685692    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.838092    4.44500   0.0     com='drum'
 cuboid    20 1 4p21.838092    4.44500   0.0     com='drum(chine)outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.685692    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.838092    0.63500   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.63500   0.0     com='drum(chine)outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  20 1   21.469792    1.90500   0.15240 com='void above lid'
 cylinder  19 1   21.622192    1.90500   0.0     com='drum lid'
 cylinder  20 1   21.685692    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.838092    1.90500   0.0     com='drum'
 cuboid    20 1 4p21.838092    1.90500   0.0     com='drum(chine)outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-21.838092     0.0
'cuboid     0  1 4p21.838092    110.4905  0.0    com='bare package'
'cuboid    21  1 4p52.318092   140.9700 -30.48   com='reflected package'
 cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
```

```
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.19 Case ncia70st11_2_8_3

```
=csas25    parm=size=3000000
ncia70st11,1.4in np,25588.2gU(25588.2g235, 8225.3gH2O hx=  8.39),fr=1.0e-04
238groupndf5 infhommedium
'HEU volume =1360.27104, SPACER volume  614.69740'
'HEU wrapped dry content can hx=0.66, CV void volume 8240.17295'
uranium  1 den=18.81109 1.0 293      92235  100.00
                                     92238   0.000               end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
```

```
                              12000    0.3378
                              13027   39.0479
                              14000    2.4672
                              16000    0.3083
                              20000   11.8336
                              26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                               8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.63931  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.42622  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.42622  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.42622  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.42622  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.42622  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.42622  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.42622  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
```

```
ss304                                              17  1.06388 293  end
'steel: angle iron (ai) for single units'
'ss304                                              18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
ss304                                              18  1.25705 293  end
'steel: drum steel for single units'
'ss304                                              19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
ss304                                              19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
arbmwed    1.16026  2 0 0 0    1001   11.1913
                               8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                              8016   88.8087   21  1.0     293  end
end comp
ncia70st11,1.4in np,25588.2gU(25588.2g235, 8225.3gH2O,hx=  8.39),fr=1.0e-04
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                       end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.111 in. at top of unit]'
'cylinder  19 1   22.866096    0.28150   0.0     com='extended radius not used'
 cylinder  19 1   21.722275    0.28150   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p22.866096    0.28150   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.676 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.555075   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.722275   11.59510   0.0     com='drum'
 cuboid    20 1 4p22.866096   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.926 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   21.555075    0.63500   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1004
'1st content can (collapsed) [Elev= 6.989 in.]'
'3.437212   plus-y location cylinders'
'-3.437212  minus-y location cylinders'
'1.984375   plus-x location cylinders'
'-1.984375  minus-x location cylinders'
 cylinder  3  1    6.426200    5.23925  -0.0005  com='cv well cavity'
 hole  1020   -3.968750   0.0       0.0     com='cy1 (2cymx,0)'
 hole  1020   -1.984375   3.437212  0.0     com='cy2 (cymx,cypy)'
 hole  1020    1.984375   3.437212  0.0     com='cy3 (cypx,cypy)'
 hole  1020    3.968750   0.0       0.0     com='cy4 (2cypx,0)'
 hole  1020    1.984375  -3.437212  0.0     com='cy5 (cypx,cymx)'
 hole  1020   -1.984375  -3.437212  0.0     com='cy6 (cymx,cymy)'
```

```
 hole  1020    0.0        0.0       0.0     com='cy7 (0,0)'
 cylinder  8  1    6.680200    5.23925  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800    5.23925  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200    5.23925  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000    5.23925  -0.0005  com='np277_4'
 cylinder  16 1   11.074400    5.23925  -0.0005  com='kaolite liner'
 cylinder  12 1   21.555075    5.23925  -0.0005  com='kaolite'
 cylinder  19 1   21.722275    5.23925  -0.0005  com='drum'
 cuboid    20 1 4p22.866096    5.23925  -0.0005  com='drum chine outer radius'
unit 1005
'np277_4 spacer [Elev= 8.389 in.]'
 cylinder  2  1    5.24510     3.55610   0.0     com='np spacer'
 cylinder  3  1    6.426200    3.55620  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    3.55620  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    3.55620  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    3.55620  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    3.55620  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    3.55620  -0.0001  com='kaolite liner'
 cylinder  12 1   21.555075    3.55620  -0.0001  com='kaolite'
 cylinder  19 1   21.722275    3.55620  -0.0001  com='drum'
 cuboid    20 1 4p22.866096    3.55620  -0.0001  com='drum chine outer radius'
unit 1006
'2nd content can (collapsed) [Elev=10.452 in.]'
 cylinder  3  1    6.426200    5.23925  -0.0005  com='cv well cavity'
 hole  1021   -3.968750   0.0       0.0     com='cy1 (2cymx,0)'
 hole  1021   -1.984375   3.437212  0.0     com='cy2 (cymx,cypy)'
 hole  1021    1.984375   3.437212  0.0     com='cy3 (cypx,cypy)'
 hole  1021    3.968750   0.0       0.0     com='cy4 (2cypx,0)'
 hole  1021    1.984375  -3.437212  0.0     com='cy5 (cypx,cymx)'
 hole  1021   -1.984375  -3.437212  0.0     com='cy6 (cymx,cymy)'
 hole  1021    0.0        0.0       0.0     com='cy7 (0,0)'
 cylinder  8  1    6.680200    5.23925  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800    5.23925  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200    5.23925  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000    5.23925  -0.0005  com='np277_4'
 cylinder  16 1   11.074400    5.23925  -0.0005  com='kaolite liner'
 cylinder  12 1   21.555075    5.23925  -0.0005  com='kaolite'
 cylinder  19 1   21.722275    5.23925  -0.0005  com='drum'
 cuboid    20 1 4p22.866096    5.23925  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev=11.852 in.]'
 cylinder  2  1    5.24510     3.55610   0.0     com='np spacer'
 cylinder  3  1    6.426200    3.55620  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    3.55620  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    3.55620  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    3.55620  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    3.55620  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    3.55620  -0.0001  com='kaolite liner'
 cylinder  12 1   21.555075    3.55620  -0.0001  com='kaolite'
 cylinder  19 1   21.722275    3.55620  -0.0001  com='drum'
 cuboid    20 1 4p22.866096    3.55620  -0.0001  com='drum chine outer radius'
unit 1008
'3rd content can (collapsed) [Elev=10.452 in.]'
 cylinder  3  1    6.426200    5.23925  -0.0005  com='cv well cavity'
 hole  1022   -3.968750   0.0       0.0     com='cy1 (2cymx,0)'
 hole  1022   -1.984375   3.437212  0.0     com='cy2 (cymx,cypy)'
 hole  1022    1.984375   3.437212  0.0     com='cy3 (cypx,cypy)'
 hole  1022    3.968750   0.0       0.0     com='cy4 (2cypx,0)'
 hole  1022    1.984375  -3.437212  0.0     com='cy5 (cypx,cymx)'
 hole  1022   -1.984375  -3.437212  0.0     com='cy6 (cymx,cymy)'
 hole  1022    0.0        0.0       0.0     com='cy7 (0,0)'
```

```
 cylinder  8  1    6.680200    5.23925  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800    5.23925  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200    5.23925  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000    5.23925  -0.0005  com='np277_4'
 cylinder  16 1   11.074400    5.23925  -0.0005  com='kaolite liner'
 cylinder  12 1   21.555075    5.23925  -0.0005  com='kaolite'
 cylinder  19 1   21.722275    5.23925  -0.0005  com='drum'
 cuboid    20 1 4p22.866096    5.23925  -0.0005  com='drum chine outer radius'
unit 1009
'top of content stack to bottom of 1st step [Elev=35.276 in.]'
'22.83355             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   54.25545   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   54.25545   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   54.25545   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   54.25545   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   54.25545   0.0     com='np277_4'
 cylinder  16 1   11.074400   54.25545   0.0     com='kaolite liner'
 cylinder  12 1   21.555075   54.25545   0.0     com='kaolite'
 cylinder  19 1   21.722275   54.25545   0.0     com='drum'
 cuboid    20 1 4p22.866096   54.25545   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.336 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.426 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.555075    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.22860   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.926 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.27000   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.076 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.555075    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.722275    2.92100   0.0     com='drum'
 cuboid    20 1 4p22.866096    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.476 in.]'
```

```
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.01600   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.536 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.756 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.555075    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.722275    8.17880   0.0     com='drum'
 cuboid    20 1 4p22.866096    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.506 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.555075    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.722275    4.44500   0.0     com='drum'
 cuboid    20 1 4p22.866096    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.756 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.555075    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.512 in.]'
 cylinder  20 1   21.330090    1.91973   0.16720 com='void above lid'
 cylinder  19 1   21.497290    1.91973   0.0     com='drum lid'
 cylinder  20 1   21.555075    1.91973   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.722275    1.91973   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.91973   0.0     com='drum chine outer radius'
unit 1020
'HEU cylinder content, 3.96875cm diameter by  5.23875cm height'
'  64.77481cm3 single slug volume'
 cylinder  1  1    1.983875  5.23875   0.0       com='cyl'
unit 1021
'HEU cylinder content, 3.96875cm diameter by  5.23875cm height'
'  64.77481cm3 single slug volume'
 cylinder  1  1    1.983875  5.23875   0.0       com='cyl'
unit 1022
'HEU cylinder content, 3.96875cm diameter by  5.23875cm height'
'  64.77481cm3 single slug volume'
 cylinder  1  1    1.983875  5.23875   0.0       com='cyl'
global
```

```
unit 1023
'es3100 drum [Elev=43.512 in.]'
array 3         2r-22.866096     0.0
'cuboid     0  1 4p24.587200    110.4900  0.0    com='bare package'
'cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
 cuboid    20  1 4p22.866096    110.5197  0.0    com='interstital array space'
'global
'unit 1025
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1004 1005 1006 1007 1008 1009 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1023               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.20 Case ncia5est11_2_2_5_3

*(This case name is actually **ncia5est11_2_2_5_3**.)*

```
=csas25    parm=size=3000000
ncia5est11,0.0in np,73294.2gU(58635.4g235, 6317.2gH2O hx=  2.81),fr=1.0e-04
238groupndf5 infhommedium
'HEU volume =3886.48867, SPACER volume    0.01729'
'HEU wrapped dry content can hx=0.57, CV void volume 6328.63543'
uranium  1 den=18.85873 1.0 293      92235  80.000
                                     92238  20.000               end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                          8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                          9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                         10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
```

```
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.63931  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.42622  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.42622  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.42622  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.42622  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.42622  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.42622  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.42622  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
```

```
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                           16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                           17  1.06388 293  end
'steel: angle iron (ai) for single units'
'ss304                                           18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
ss304                                           18  1.25705 293  end
'steel: drum steel for single units'
'ss304                                           19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
ss304                                           19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
arbmwed    1.16026  2 0 0 0    1001   11.1913
                               8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                              8016   88.8087   21  1.0     293  end
end comp
ncia5est11,0.0in np,73294.2gU(58635.4g235, 6317.2gH2O,hx=  2.81),fr=1.0e-04
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                    end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.111 in. at top of unit]'
'cylinder  19 1   22.866096    0.28150   0.0     com='extended radius not used'
 cylinder  19 1   21.722275    0.28150   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p22.866096    0.28150   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.676 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.555075   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.722275   11.59510   0.0     com='drum'
 cuboid    20 1 4p22.866096   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.926 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   21.555075    0.63500   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1004
'1st content can (collapsed) [Elev= 9.051 in.]'
```

```
'Reference CRC 29 Ed. pg 105'
'side of pentagon denoted spent'
'radius of inscribed circle in pentagon denoted icrpent'
'radius of circumscribed circle outside pentagon denoted ccrpent'
'ccrpent equals 0.85065 times spent'
'icrpent equals 0.68819 times spent'
'side of pentagon equals diameter of a cylinder fit into cc'
'radius of cc equals ccrpent plus radius of cylinder fit into cc'
'radius of ccrpent equal diamater of slug'
' 3.96875 radius of circumscribed circle'
' 2.33277 half of side of pentagon'
' 3.21078 radius of inscribed circle'
' 3.77452 x axis location of 2nd cyl in cc'
' 1.22642 y axis location of 2nd cyl in cc'
 cylinder  3  1    6.426200   10.47800  -0.0005  com='cv well cavity'
 hole  1020    0.0       3.96875 0.0        com='cy1 (0,ccrpent)'
 hole  1020    3.77452   1.22642 0.0        com='cy2 (xtwo,ytwo)'
 hole  1020    2.33277  -3.21078 0.0        com='cy3 (hspent,-icrpent)'
 hole  1020   -2.33277  -3.21078 0.0        com='cy4 (-hspent,-icrpent)'
 hole  1020   -3.77452   1.22642 0.0        com='cy5 (-xtwo,ytwo)'
 cylinder  8  1    6.680200   10.47800  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800   10.47800  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200   10.47800  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000   10.47800  -0.0005  com='np277_4'
 cylinder  16 1   11.074400   10.47800  -0.0005  com='kaolite liner'
 cylinder  12 1   21.555075   10.47800  -0.0005  com='kaolite'
 cylinder  19 1   21.722275   10.47800  -0.0005  com='drum'
 cuboid    20 1 4p22.866096   10.47800  -0.0005  com='drum chine outer radius'
unit 1005
'np277_4 spacer [Elev= 9.051 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   21.555075    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   21.722275    0.00020  -0.0001  com='drum'
 cuboid    20 1 4p22.866096    0.00020  -0.0001  com='drum chine outer radius'
unit 1006
'2nd content can (collapsed) [Elev=13.177 in.]'
 cylinder  3  1    6.426200   10.47800  -0.0005  com='cv well cavity'
 hole  1021    0.0       3.96875 0.0        com='cy1 (0,ccrpent)'
 hole  1021    3.77452   1.22642 0.0        com='cy2 (xtwo,ytwo)'
 hole  1021    2.33277  -3.21078 0.0        com='cy3 (hspent,-icrpent)'
 hole  1021   -2.33277  -3.21078 0.0        com='cy4 (-hspent,-icrpent)'
 hole  1021   -3.77452   1.22642 0.0        com='cy5 (-xtwo,ytwo)'
 cylinder  8  1    6.680200   10.47800  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800   10.47800  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200   10.47800  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000   10.47800  -0.0005  com='np277_4'
 cylinder  16 1   11.074400   10.47800  -0.0005  com='kaolite liner'
 cylinder  12 1   21.555075   10.47800  -0.0005  com='kaolite'
 cylinder  19 1   21.722275   10.47800  -0.0005  com='drum'
 cuboid    20 1 4p22.866096   10.47800  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev=13.177 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
```

```
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   21.555075    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   21.722275    0.00020  -0.0001  com='drum'
 cuboid    20 1 4p22.866096    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'3rd content can (collapsed) [Elev=13.177 in.]'
 cylinder  3  1    6.426200   10.47800  -0.0005  com='cv well cavity'
 hole  1022    0.0       3.96875 0.0        com='cy1 (0,ccrpent)'
 hole  1022    3.77452   1.22642 0.0        com='cy2 (xtwo,ytwo)'
 hole  1022    2.33277  -3.21078 0.0        com='cy3 (hspent,-icrpent)'
 hole  1022   -2.33277  -3.21078 0.0        com='cy4 (-hspent,-icrpent)'
 hole  1022   -3.77452   1.22642 0.0        com='cy5 (-xtwo,ytwo)'
 cylinder  8  1    6.680200   10.47800  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800   10.47800  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200   10.47800  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000   10.47800  -0.0005  com='np277_4'
 cylinder  16 1   11.074400   10.47800  -0.0005  com='kaolite liner'
 cylinder  12 1   21.555075   10.47800  -0.0005  com='kaolite'
 cylinder  19 1   21.722275   10.47800  -0.0005  com='drum'
 cuboid    20 1 4p22.866096   10.47800  -0.0005  com='drum chine outer radius'
unit 1009
'top of content stack to bottom of 1st step [Elev=35.276 in.]'
'31.43780             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   45.65120   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   45.65120   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   45.65120   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   45.65120   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   45.65120   0.0     com='np277_4'
 cylinder  16 1   11.074400   45.65120   0.0     com='kaolite liner'
 cylinder  12 1   21.555075   45.65120   0.0     com='kaolite'
 cylinder  19 1   21.722275   45.65120   0.0     com='drum'
 cuboid    20 1 4p22.866096   45.65120   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.336 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.426 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.555075    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.22860   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.926 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
```

```
 cylinder  12 1   21.555075    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.27000   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.076 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.555075    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.722275    2.92100   0.0     com='drum'
 cuboid    20 1 4p22.866096    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.476 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.01600   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.536 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.756 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.555075    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.722275    8.17880   0.0     com='drum'
 cuboid    20 1 4p22.866096    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.506 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.555075    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.722275    4.44500   0.0     com='drum'
 cuboid    20 1 4p22.866096    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.756 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.555075    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.512 in.]'
 cylinder  20 1   21.330090    1.91973   0.16720 com='void above lid'
 cylinder  19 1   21.497290    1.91973   0.0     com='drum lid'
 cylinder  20 1   21.555075    1.91973   0.0     com='void btw lid - drum wall'
```

```
 cylinder  19 1   21.722275    1.91973   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.91973   0.0     com='drum chine outer radius'
unit 1020
'HEU cylinder content, 3.96875cm diameter by 10.47750cm height'
' 129.54962cm3 single slug volume'
 cylinder  1  1    1.983875  10.4775   0.0       com='cyl'
unit 1021
'HEU cylinder content, 3.96875cm diameter by 10.47750cm height'
' 129.54962cm3 single slug volume'
 cylinder  1  1    1.983875  10.4775   0.0       com='cyl'
unit 1022
'HEU cylinder content, 3.96875cm diameter by 10.47750cm height'
' 129.54962cm3 single slug volume'
 cylinder  1  1    1.983875  10.4775   0.0       com='cyl'
global
unit 1023
'es3100 drum [Elev=43.512 in.]'
array 3         2r-22.866096     0.0
'cuboid     0  1 4p24.587200    110.4900  0.0    com='bare package'
'cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
 cuboid    20  1 4p22.866096    110.5197  0.0    com='interstital array space'
'global
'unit 1025
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1004 1005 1006 1007 1008 1009 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1023               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.21 Case nciabmt11_4_1_5_3

```
=csas25    parm=size=3000000
nciabmt11,0.0in thk np, 3708.5gU( 2966.8g235,10000.7gH2O hx= 87.98),fr=1.0e-04
238groupndf5 infhommedium
'HEU volume = 196.64477, SPACER volume    0.00000'
'HEU wrapped dry content can hx=5.65, CV void volume 10018.7171'
uranium  1 den=18.85873 0.01925 293      92235  80.000
                                      92238  20.000               end
arbmh20i   0.97898  2 0 0 0    1001   11.1913
                               8016   88.8087    1  1.0000  293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
```

```
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'nct array densities are s.u.dens. multiplied by volume ratio 1.34888/1.10336'
arbmh2ok   0.63931  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.42622  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.42622  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.42622  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.42622  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.42622  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.42622  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.42622  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
```

```
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
'ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
'ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
arbmwed    1.16026  2 0 0 0    1001   11.1913
                               8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                               8016   88.8087   21  1.0     293  end
end comp
nciabmt11,0.0in thk np, 3708.5gU( 2966.8g235,10000.7gH2O,hx= 87.98),fr=1.0e-04
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                  end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.111 in. at top of unit]'
'cylinder  19 1   22.866096    0.28150   0.0     com='extended radius not used'
 cylinder  19 1   21.722275    0.28150   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p22.866096    0.28150   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.676 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
```

```
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.555075   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.722275   11.59510   0.0     com='drum'
 cuboid    20 1 4p22.866096   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.926 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   21.555075    0.63500   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1004
'cubical content, stacked per cc'
'    9.08802     3.57796 lattice width-depth'
'    2.54000     1.00000 cube dimension'
'    1.27000     0.50000 cube half-dimension'
'   16.38706     1.00000 volume of HEU cube in unit cell'
'  309.03922             HEU mass one cube'
'   4                    number of HEU cubes per can'
' 1236.15687             HEU mass of cubes in cc'
'    3           3       number of cubes in -x direction'
'    3           3       number of cubes in -y direction'
'    9           9       number of HEU cubes in a layer'
'    1    VARIABLE       number of HEU layers in z-axis'
'    4    VARIABLE       number of HEU cubes in top layer modulus(Z%N)'
'    5    VARIABLE       number of HEU voids in top layer'
'    ara=1 nux=3 nuy=3 nuz=1   fill  4r1004  5r1005      end fill'
'    0.48924     0.19261 gap dimension                       CALCULATED
'    3.02924     1.19261 unit cell dimension                 CALCULATED
'    1.51462     0.59631 unit cell half-dimension            CALCULATED
'   27.79719     1.69629 volume of unit cell                 CALCULATED
'   11.41013     0.69629 volume of water gap in unit cell    CALCULATED
'  250.17473             lattice volume in cc                CALCULATED
'  184.62648             moderator volume in lattice in cc   CALCULATED
'   65.54826             HEU volume in lattice in cc         CALCULATED
'    0.01925             volume fraction of HEU in CV        CALCULATED
'    0.97898             bulk dens of water in CV            CALCULATED
 cuboid    1  1  6p1.51452                      com='unit cell'
unit 1005
'cubical void, filler for layers'
 cuboid    1  1  6p1.51452                      com='unit cell'
unit 1006
'content (collapsed) [Elev= 6.119 in.]'
' 4.54386     1.78892 half width-depth lattice            CALCULATED'
' 3.02924             height lattice                      CALCULATED'
'array 1         2r-4.54386      0.0'
 cuboid    1  1  4p4.54386     3.02924   0.0     com='homog. content-array'
 cylinder  1  1    6.426200    3.02974  -0.0005  com='cv well cavity'
 cylinder  8  1    6.680200    3.02974  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800    3.02974  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200    3.02974  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000    3.02974  -0.0005  com='np277_4'
 cylinder  16 1   11.074400    3.02974  -0.0005  com='kaolite liner'
 cylinder  12 1   21.555075    3.02974  -0.0005  com='kaolite'
 cylinder  19 1   21.722275    3.02974  -0.0005  com='drum'
 cuboid    20 1 4p22.866096    3.02974  -0.0005  com='drum chine outer radius'
unit 1007
```

```
'np277_4 spacer [Elev= 6.119 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  1  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   21.555075    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   21.722275    0.00020  -0.0001  com='drum'
 cuboid    20 1 4p22.866096    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.276 in.]'
' 9.09132             stack height (content spacers)       CALCULATED
 cylinder  1  1    6.426200   67.99768   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   67.99768   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   67.99768   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   67.99768   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   67.99768   0.0     com='np277_4'
 cylinder  16 1   11.074400   67.99768   0.0     com='kaolite liner'
 cylinder  12 1   21.555075   67.99768   0.0     com='kaolite'
 cylinder  19 1   21.722275   67.99768   0.0     com='drum'
 cuboid    20 1 4p22.866096   67.99768   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.336 in.]'
 cylinder  1  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.426 in.]'
 cylinder  1  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.555075    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.22860   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.926 in.]'
 cylinder  1  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.27000   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.076 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.555075    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.722275    2.92100   0.0     com='drum'
```

```
 cuboid    20 1 4p22.866096    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.476 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.01600   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.536 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.756 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.555075    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.722275    8.17880   0.0     com='drum'
 cuboid    20 1 4p22.866096    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.506 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.555075    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.722275    4.44500   0.0     com='drum'
 cuboid    20 1 4p22.866096    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.756 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.555075    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.512 in.]'
 cylinder  20 1   21.330090    1.91973   0.16720 com='void above lid'
 cylinder  19 1   21.497290    1.91973   0.0     com='drum lid'
 cylinder  20 1   21.555075    1.91973   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.722275    1.91973   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.91973   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.512 in.]'
array 3         2r-22.866096     0.0
'cuboid     0  1 4p24.587200    110.4900  0.0    com='bare package'
'cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
 cuboid    20  1 4p22.866096    110.5197  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
```

```
'reflector  21 2  6r3.0  10
end geometry
read array
ara=1 nux=3 nuy=3 nuz=1   fill  4r1004  5r1005      end fill
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.22 Case hctf5bmt12_25_2_8_3

```
=csas25    parm=size=4000000
hctf5bmt12,1.4in thk np,24968.9gU(24968.9g235, 8258.4gH2O hx=  8.63),fr=1.0e-04
238groupndf5 infhommedium
'HEU wrapped dry content can hx=0.67, CV void volume 8273.32964'
uranium  1 den=18.81109 0.13826 293      92235  100.00
                                      92238   0.000               end
arbmh20i   0.86019  2 0 0 0    1001   11.1913
                               8016   88.8087    1  1.0000  293  end
'np277-4: spacer (HAC_MD&H)'
'HAC min.den.(95.3157 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07071e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.82995e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (HAC_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.476265 = (den.mult)(np277-4 min.den.) = 0.9668933*1.526803'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9188
```

```
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.70316e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                                 8016   88.8087   12  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                                 8016   47.0610   12  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                                 8016   53.2430   12  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                                 8016   30.0460   12  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                                 8016   40.0465   12  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                                 8016   28.5185   12  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                                 8016   39.6831   12  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                                 8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                                 8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                                 8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                                 8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                                 8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                                 8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                                 8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                                 8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                                 8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                                 1001    8.1573
                                 8016   21.5782
```

```
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                          16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                          17  1.06388 293  end
'steel: angle iron (ai) for HAC'
'nct density is multiplied by volume fraction 7.08030/5.74516 for HAC'
ss304                                          18  1.23239 293  end
'steel: drum steel for HAC'
'nct density is multiplied by volume fraction 3.20482/2.95645 for HAC'
ss304                                          19  1.08401 293  end
'void space external to drum'
arbmwed    0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   20  0.0001  293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
more data dab=400 end
hctf5bmt12,1.4in thk np,24968.9gU(24968.9g235, 8258.4gH2O,hx=  8.63),fr=1.0e-04
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 nb8=400 end parameters
read boun       all=specular                   end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'zhemicyl-y  19 1   21.838092    0.26620   0.00050 com='extend radius not used'
 zhemicyl-y  19 1   21.838092    0.26620   0.00050 com='drum bottom flat cover'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 zhemicyl-y  15 1    3.175000   11.59460  11.16330 com='void in pad-1'
 zhemicyl-y  14 1    7.924800   11.59460  11.16330 com='pad-1'
 zhemicyl-y  16 1    8.077200   11.59460  11.16330 com='np277_4 liner'
 zhemicyl-y  11 1   10.922000   11.59460  11.16330 com='np277_4'
 zhemicyl-y  16 1   11.074400   11.59460  10.85850 com='kaolite liner bottom'
 zhemicyl-y  12 1   21.685692   11.59460   0.00050 com='kaolite'
 zhemicyl-y  19 1   21.838092   11.59460   0.00050 com='drum'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 zhemicyl-y  8  1    6.680200    0.63450   0.00050 com='cv bottom'
 zhemicyl-y  15 1    7.924800    0.63450   0.00050 com='void btw cv-np liner'
 zhemicyl-y  16 1    8.077200    0.63450   0.00050 com='np277_4 liner'
 zhemicyl-y  11 1   10.922000    0.63450   0.00050 com='np277_4'
 zhemicyl-y  16 1   11.074400    0.63450   0.00050 com='kaolite liner'
 zhemicyl-y  12 1   21.685692    0.63450   0.00050 com='kaolite'
 zhemicyl-y  19 1   21.838092    0.63450   0.00050 com='drum'
unit 1004
'cubical content, stacked per cc'
'    9.08802     3.57796 lattice width-depth'
'    2.54000     1.00000 cube dimension'
'    1.27000     0.50000 cube half-dimension'
'   16.38706     1.00000 volume of HEU cube in unit cell'
'  308.25850             HEU mass one cube'
'   27                   number of HEU cubes per can'
' 8322.97957             HEU mass of cubes in cc'
'    3           3       number of cubes in -x direction'
'    3           3       number of cubes in -y direction'
'    9           9       number of HEU cubes in a layer'
'    4    VARIABLE       number of HEU layers in z-axis'
```

```
'    0    VARIABLE       number of HEU cubes in top layer modulus(Z%N)'
'    9    VARIABLE       number of HEU voids in top layer'
'    ara=1 nux=3 nuy=3 nuz=4   fill 27r1004  9r1005      end fill'
'    0.48924     0.19261 gap dimension                        CALCULATED
'    3.02924     1.19261 unit cell dimension                  CALCULATED
'    1.51462     0.59631 unit cell half-dimension             CALCULATED
'   27.79719     1.69629 volume of unit cell                  CALCULATED
'   11.41013     0.69629 volume of water gap in unit cell     CALCULATED
' 1000.69893             lattice volume in cc                 CALCULATED
'  558.24820             moderator volume in lattice in cc    CALCULATED
'  442.45073             HEU volume in lattice in cc          CALCULATED
'    0.13826             volume fraction of HEU in CV         CALCULATED
'    0.86019             bulk dens of water in CV             CALCULATED
 cuboid    1  1  6p1.51452                       com='unit cell'
unit 1005
'cubical void, filler for layers'
 cuboid    1  1  6p1.51452                       com='unit cell'
unit 1006
'content (collapsed) [Elev= 9.691 in.]'
' 4.54386     1.78892 half width-depth lattice            CALCULATED'
'12.11696             height lattice                       CALCULATED'
'array 1         2r-4.54386      0.0'
 cuboid  1  1  2p4.54386 0.0 -4.54386 12.1169 0.0005 com='homog. content-array'
 zhemicyl-y  1  1    6.426200   12.11696   0.00050 com='cv well cavity'
 zhemicyl-y  8  1    6.680200   12.11696   0.00050 com='cv below 1st step'
 zhemicyl-y  15 1    7.924800   12.11696   0.00050 com='void btw cv-np liner'
 zhemicyl-y  16 1    8.077200   12.11696   0.00050 com='np277_4 liner'
 zhemicyl-y  11 1   10.922000   12.11696   0.00050 com='np277_4'
 zhemicyl-y  16 1   11.074400   12.11696   0.00050 com='kaolite liner'
 zhemicyl-y  12 1   21.685692   12.11696   0.00050 com='kaolite'
 zhemicyl-y  19 1   21.838092   12.11696   0.00050 com='drum'
unit 1007
'np277_4 spacer [Elev=11.091 in.]'
 zhemicyl-y  2  1    5.24510     3.55660   0.00050 com='np spacer'
 zhemicyl-y  1  1    6.426200    3.55660   0.00050 com='cv well cavity'
 zhemicyl-y  8  1    6.680200    3.55660   0.00050 com='cv below 1st step'
 zhemicyl-y  15 1    7.924800    3.55660   0.00050 com='void btw cv-np liner'
 zhemicyl-y  16 1    8.077200    3.55660   0.00050 com='np277_4 liner'
 zhemicyl-y  11 1   10.922000    3.55660   0.00050 com='np277_4'
 zhemicyl-y  16 1   11.074400    3.55660   0.00050 com='kaolite liner'
 zhemicyl-y  12 1   21.685692    3.55660   0.00050 com='kaolite'
 zhemicyl-y  19 1   21.838092    3.55660   0.00050 com='drum'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'43.46828             stack height (content spacers)       CALCULATED
 zhemicyl-y  1  1    6.426200   33.62022   0.00050 com='cv well cavity'
 zhemicyl-y  8  1    6.680200   33.62022   0.00050 com='cv below 1st step'
 zhemicyl-y  15 1    7.924800   33.62022   0.00050 com='void btw cv-np liner'
 zhemicyl-y  16 1    8.077200   33.62022   0.00050 com='np277_4 liner'
 zhemicyl-y  11 1   10.922000   33.62022   0.00050 com='np277_4'
 zhemicyl-y  16 1   11.074400   33.62022   0.00050 com='kaolite liner'
 zhemicyl-y  12 1   21.685692   33.62022   0.00050 com='kaolite'
 zhemicyl-y  19 1   21.838092   33.62022   0.00050 com='drum'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 zhemicyl-y  1  1    6.426200    0.15190   0.00050 com='cv well cavity'
 zhemicyl-y  8  1    6.680200    0.15190   0.00050 com='cv at 1st step'
 zhemicyl-y  15 1    7.924800    0.15190   0.00050 com='void btw cv and liner'
 zhemicyl-y  16 1   11.074400    0.15190   0.00050 com='liner 1st step'
 zhemicyl-y  12 1   21.685692    0.15190   0.00050 com='kaolite'
 zhemicyl-y  19 1   21.838092    0.15190   0.00050 com='drum'
```

```
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 zhemicyl-y  1  1    6.426200    0.22810   0.00050 com='cv well cavity'
 zhemicyl-y  8  1    6.680200    0.22810   0.00050 com='cv gap btw step-flng'
 zhemicyl-y  15 1   10.922000    0.22810   0.00050 com='void btw cv and liner'
 zhemicyl-y  16 1   11.074400    0.22810   0.00050 com='liner wall'
 zhemicyl-y  12 1   21.685692    0.22810   0.00050 com='kaolite'
 zhemicyl-y  19 1   21.838092    0.22810   0.00050 com='drum'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 zhemicyl-y  1  1    6.426200    1.26950   0.00050 com='cavity'
 zhemicyl-y  9  1    9.525000    1.26950   0.00050 com='flange to top of well'
 zhemicyl-y  15 1    9.525000    1.26950   0.00050 com='void btw cv and pad-2'
 zhemicyl-y  14 1   10.033000    1.26950   0.00050 com='pad-2'
 zhemicyl-y  15 1   10.922000    1.26950   0.00050 com='void btw cv and liner'
 zhemicyl-y  16 1   11.074400    1.26950   0.00050 com='liner wall'
 zhemicyl-y  12 1   21.685692    1.26950   0.00050 com='kaolite'
 zhemicyl-y  19 1   21.838092    1.26950   0.00050 com='drum'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 zhemicyl-y  10 1    9.525000    2.92050   0.00050 com='flange above cv well'
 zhemicyl-y  15 1    9.525000    2.92050   0.00050 com='void btw cv and pad-2'
 zhemicyl-y  14 1   10.033000    2.92050   0.00050 com='pad-2'
 zhemicyl-y  15 1   10.922000    2.92050   0.00050 com='void btw pad2-liner'
 zhemicyl-y  16 1   11.074400    2.92050   0.00050 com='liner wall'
 zhemicyl-y  12 1   21.685692    2.92050   0.00050 com='kaolite'
 zhemicyl-y  19 1   21.838092    2.92050   0.00050 com='drum'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 zhemicyl-y  14 1   10.033000    0.76150   0.00050 com='pad-2'
 zhemicyl-y  15 1   10.922000    1.01550   0.00050 com='void btw pad2-liner'
 zhemicyl-y  16 1   11.074400    1.01550   0.00050 com='liner wall'
 zhemicyl-y  12 1   21.685692    1.01550   0.00050 com='kaolite'
 zhemicyl-y  19 1   21.838092    1.01550   0.00050 com='drum'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 zhemicyl-y  15 1   10.922000    0.15190   0.00050 com='void abv pad2'
 zhemicyl-y  16 1   18.757900    0.15190   0.00050 com='liner 2nd step'
 zhemicyl-y  12 1   21.685692    0.15190   0.00050 com='kaolite'
 zhemicyl-y  19 1   21.838092    0.15190   0.00050 com='drum'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 zhemicyl-y  13 1   18.097500    8.17830   0.49276 com='plug kaolite'
 zhemicyl-y  17 1   18.249900    8.17830   0.34036 com='sides of plug case'
 zhemicyl-y  15 1   18.605500    8.17830   0.00050 com='void: plug to liner'
 zhemicyl-y  16 1   18.757900    8.17830   0.00050 com='liner wall'
 zhemicyl-y  12 1   21.685692    8.17830   0.00050 com='kaolite'
 zhemicyl-y  19 1   21.838092    8.17830   0.00050 com='drum'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 zhemicyl-y  13 1   18.097500    4.44450   0.00050 com='plug kaolite'
 zhemicyl-y  17 1   18.249900    4.44450   0.00050 com='sides of plug case'
 zhemicyl-y  15 1   18.605500    4.44450   0.00050 com='void: plug to liner'
 zhemicyl-y  16 1   18.757900    4.44450   0.00050 com='liner wall'
 zhemicyl-y  18 1   19.392900    4.44450   0.00050 com='lower angle iron'
 zhemicyl-y  12 1   21.685692    4.44450   0.00050 com='kaolite'
 zhemicyl-y  19 1   21.838092    4.44450   0.00050 com='drum'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 zhemicyl-y  13 1   18.097500    0.11126   0.00050 com='plug kaolite'
 zhemicyl-y  17 1   18.249900    0.26366   0.00050 com='sides of plug case'
```

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 zhemicyl-y  15 1   18.605500    0.63450   0.00050 com='void: plug to liner'
 zhemicyl-y  16 1   18.757900    0.63450   0.00050 com='liner wall'
 zhemicyl-y  18 1   21.685692    0.63450   0.00050 com='bend section of ai'
 zhemicyl-y  19 1   21.838092    0.63450   0.00050 com='drum'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 zhemicyl-y  20 1   21.469792    1.90450   0.15240 com='void above lid'
 zhemicyl-y  19 1   21.622192    1.90450   0.00050 com='drum lid'
 zhemicyl-y  20 1   21.685692    1.90450   0.00050 com='void btw lid-drumwall'
 zhemicyl-y  19 1   21.838092    1.90450   0.00050 com='drum'
unit 2001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'zhemicyl+y  19 1   21.838092    0.26620   0.00050 com='extended radius not used'
 zhemicyl+y  19 1   21.838092    0.26620   0.00050 com='drum bottom flat cover'
unit 2002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 zhemicyl+y  15 1    3.175000   11.59460  11.16330 com='void in pad-1'
 zhemicyl+y  14 1    7.924800   11.59460  11.16330 com='pad-1'
 zhemicyl+y  16 1    8.077200   11.59460  11.16330 com='np277_4 liner'
 zhemicyl+y  11 1   10.922000   11.59460  11.16330 com='np277_4'
 zhemicyl+y  16 1   11.074400   11.59460  10.85850 com='kaolite liner bottom'
 zhemicyl+y  12 1   21.685692   11.59460   0.00050 com='kaolite'
 zhemicyl+y  19 1   21.838092   11.59460   0.00050 com='drum'
unit 2003
'cv bottom [Elev= 4.920 in.]'
 zhemicyl+y  8  1    6.680200    0.63450   0.00050 com='cv bottom'
 zhemicyl+y  15 1    7.924800    0.63450   0.00050 com='void btw cv-np liner'
 zhemicyl+y  16 1    8.077200    0.63450   0.00050 com='np277_4 liner'
 zhemicyl+y  11 1   10.922000    0.63450   0.00050 com='np277_4'
 zhemicyl+y  16 1   11.074400    0.63450   0.00050 com='kaolite liner'
 zhemicyl+y  12 1   21.685692    0.63450   0.00050 com='kaolite'
 zhemicyl+y  19 1   21.838092    0.63450   0.00050 com='drum'
unit 2006
'content (collapsed) [Elev= 9.691 in.]'
 zhemicyl+y  1  1    6.426200   12.11696   0.00050 com='cv well cavity'
 zhemicyl+y  8  1    6.680200   12.11696   0.00050 com='cv below 1st step'
 zhemicyl+y  15 1    7.924800   12.11696   0.00050 com='void btw cv-np liner'
 zhemicyl+y  16 1    8.077200   12.11696   0.00050 com='np277_4 liner'
 zhemicyl+y  11 1   10.922000   12.11696   0.00050 com='np277_4'
 zhemicyl+y  16 1   11.074400   12.11696   0.00050 com='kaolite liner'
 zhemicyl+y  12 1   21.685692   12.11696   0.00050 com='kaolite'
 zhemicyl+y  19 1   21.838092   12.11696   0.00050 com='drum'
unit 2007
'np277_4 spacer [Elev=11.091 in.]'
 zhemicyl+y  2  1    5.24510     3.55660   0.00050 com='np spacer'
 zhemicyl+y  1  1    6.426200    3.55660   0.00050 com='cv well cavity'
 zhemicyl+y  8  1    6.680200    3.55660   0.00050 com='cv below 1st step'
 zhemicyl+y  15 1    7.924800    3.55660   0.00050 com='void btw cv-np liner'
 zhemicyl+y  16 1    8.077200    3.55660   0.00050 com='np277_4 liner'
 zhemicyl+y  11 1   10.922000    3.55660   0.00050 com='np277_4'
 zhemicyl+y  16 1   11.074400    3.55660   0.00050 com='kaolite liner'
 zhemicyl+y  12 1   21.685692    3.55660   0.00050 com='kaolite'
 zhemicyl+y  19 1   21.838092    3.55660   0.00050 com='drum'
unit 2008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
 zhemicyl+y  1  1    6.426200   33.62022   0.00050 com='cv well cavity'
 zhemicyl+y  8  1    6.680200   33.62022   0.00050 com='cv below 1st step'
 zhemicyl+y  15 1    7.924800   33.62022   0.00050 com='void btw cv-np liner'
 zhemicyl+y  16 1    8.077200   33.62022   0.00050 com='np277_4 liner'
 zhemicyl+y  11 1   10.922000   33.62022   0.00050 com='np277_4'
 zhemicyl+y  16 1   11.074400   33.62022   0.00050 com='kaolite liner'
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 zhemicyl+y  12 1   21.685692   33.62022   0.00050 com='kaolite'
 zhemicyl+y  19 1   21.838092   33.62022   0.00050 com='drum'
unit 2010
'cv at 1st step in liner [Elev=35.330 in.]'
 zhemicyl+y  1  1    6.426200    0.15190   0.00050 com='cv well cavity'
 zhemicyl+y  8  1    6.680200    0.15190   0.00050 com='cv at 1st step'
 zhemicyl+y  15 1    7.924800    0.15190   0.00050 com='void btw cv and liner'
 zhemicyl+y  16 1   11.074400    0.15190   0.00050 com='liner 1st step'
 zhemicyl+y  12 1   21.685692    0.15190   0.00050 com='kaolite'
 zhemicyl+y  19 1   21.838092    0.15190   0.00050 com='drum'
unit 2011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 zhemicyl+y  1  1    6.426200    0.22810   0.00050 com='cv well cavity'
 zhemicyl+y  8  1    6.680200    0.22810   0.00050 com='cv gap btw step-flng'
 zhemicyl+y  15 1   10.922000    0.22810   0.00050 com='void btw cv and liner'
 zhemicyl+y  16 1   11.074400    0.22810   0.00050 com='liner wall'
 zhemicyl+y  12 1   21.685692    0.22810   0.00050 com='kaolite'
 zhemicyl+y  19 1   21.838092    0.22810   0.00050 com='drum'
unit 2012
'cv flange to top of cv well [Elev=35.920 in.]'
 zhemicyl+y  1  1    6.426200    1.26950   0.00050 com='cavity'
 zhemicyl+y  9  1    9.525000    1.26950   0.00050 com='flange to top of well'
 zhemicyl+y  15 1    9.525000    1.26950   0.00050 com='void btw cv and pad-2'
 zhemicyl+y  14 1   10.033000    1.26950   0.00050 com='pad-2'
 zhemicyl+y  15 1   10.922000    1.26950   0.00050 com='void btw cv and liner'
 zhemicyl+y  16 1   11.074400    1.26950   0.00050 com='liner wall'
 zhemicyl+y  12 1   21.685692    1.26950   0.00050 com='kaolite'
 zhemicyl+y  19 1   21.838092    1.26950   0.00050 com='drum'
unit 2013
'cv flange above cv well [Elev=37.070 in.]'
 zhemicyl+y  10 1    9.525000    2.92050   0.00050 com='flange above cv well'
 zhemicyl+y  15 1    9.525000    2.92050   0.00050 com='void btw cv and pad-2'
 zhemicyl+y  14 1   10.033000    2.92050   0.00050 com='pad-2'
 zhemicyl+y  15 1   10.922000    2.92050   0.00050 com='void btw pad2-liner'
 zhemicyl+y  16 1   11.074400    2.92050   0.00050 com='liner wall'
 zhemicyl+y  12 1   21.685692    2.92050   0.00050 com='kaolite'
 zhemicyl+y  19 1   21.838092    2.92050   0.00050 com='drum'
unit 2014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 zhemicyl+y  14 1   10.033000    0.76150   0.00050 com='pad-2'
 zhemicyl+y  15 1   10.922000    1.01550   0.00050 com='void btw pad2-liner'
 zhemicyl+y  16 1   11.074400    1.01550   0.00050 com='liner wall'
 zhemicyl+y  12 1   21.685692    1.01550   0.00050 com='kaolite'
 zhemicyl+y  19 1   21.838092    1.01550   0.00050 com='drum'
unit 2015
'2nd step in liner [Elev=37.530 in.]'
 zhemicyl+y  15 1   10.922000    0.15190   0.00050 com='void abv pad2'
 zhemicyl+y  16 1   18.757900    0.15190   0.00050 com='liner 2nd step'
 zhemicyl+y  12 1   21.685692    0.15190   0.00050 com='kaolite'
 zhemicyl+y  19 1   21.838092    0.15190   0.00050 com='drum'
unit 2016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 zhemicyl+y  13 1   18.097500    8.17830   0.49276 com='plug kaolite'
 zhemicyl+y  17 1   18.249900    8.17830   0.34036 com='sides of plug case'
 zhemicyl+y  15 1   18.605500    8.17830   0.00050 com='void: plug to liner'
 zhemicyl+y  16 1   18.757900    8.17830   0.00050 com='liner wall'
 zhemicyl+y  12 1   21.685692    8.17830   0.00050 com='kaolite'
 zhemicyl+y  19 1   21.838092    8.17830   0.00050 com='drum'
unit 2017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 zhemicyl+y  13 1   18.097500    4.44450   0.00050 com='plug kaolite'
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 zhemicyl+y  17 1   18.249900    4.44450   0.00050 com='sides of plug case'
 zhemicyl+y  15 1   18.605500    4.44450   0.00050 com='void: plug to liner'
 zhemicyl+y  16 1   18.757900    4.44450   0.00050 com='liner wall'
 zhemicyl+y  18 1   19.392900    4.44450   0.00050 com='lower angle iron'
 zhemicyl+y  12 1   21.685692    4.44450   0.00050 com='kaolite'
 zhemicyl+y  19 1   21.838092    4.44450   0.00050 com='drum'
unit 2018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 zhemicyl+y  13 1   18.097500    0.11126   0.00050 com='plug kaolite'
 zhemicyl+y  17 1   18.249900    0.26366   0.00050 com='sides of plug case'
 zhemicyl+y  15 1   18.605500    0.63450   0.00050 com='void: plug to liner'
 zhemicyl+y  16 1   18.757900    0.63450   0.00050 com='liner wall'
 zhemicyl+y  18 1   21.685692    0.63450   0.00050 com='bend section of ai'
 zhemicyl+y  19 1   21.838092    0.63450   0.00050 com='drum'
unit 2019
'drum lid and lip [Elev=43.500 in.]'
 zhemicyl+y  20 1   21.469792    1.90450   0.15240 com='void above lid'
 zhemicyl+y  19 1   21.622192    1.90450   0.00050 com='drum lid'
 zhemicyl+y  20 1   21.685692    1.90450   0.00050 com='void btw lid-drumwall'
 zhemicyl+y  19 1   21.838092    1.90450   0.00050 com='drum'
unit 3001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'zhemicyl-x  19 1   21.838092    0.26620   0.00050 com='extended radius not used'
 zhemicyl-x  19 1   21.838092    0.26620   0.00050 com='drum bottom flat cover'
unit 3002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 zhemicyl-x  15 1    3.175000   11.59460  11.16330 com='void in pad-1'
 zhemicyl-x  14 1    7.924800   11.59460  11.16330 com='pad-1'
 zhemicyl-x  16 1    8.077200   11.59460  11.16330 com='np277_4 liner'
 zhemicyl-x  11 1   10.922000   11.59460  11.16330 com='np277_4'
 zhemicyl-x  16 1   11.074400   11.59460  10.85850 com='kaolite liner bottom'
 zhemicyl-x  12 1   21.685692   11.59460   0.00050 com='kaolite'
 zhemicyl-x  19 1   21.838092   11.59460   0.00050 com='drum'
unit 3003
'cv bottom [Elev= 4.920 in.]'
 zhemicyl-x  8  1    6.680200    0.63450   0.00050 com='cv bottom'
 zhemicyl-x  15 1    7.924800    0.63450   0.00050 com='void btw cv-np liner'
 zhemicyl-x  16 1    8.077200    0.63450   0.00050 com='np277_4 liner'
 zhemicyl-x  11 1   10.922000    0.63450   0.00050 com='np277_4'
 zhemicyl-x  16 1   11.074400    0.63450   0.00050 com='kaolite liner'
 zhemicyl-x  12 1   21.685692    0.63450   0.00050 com='kaolite'
 zhemicyl-x  19 1   21.838092    0.63450   0.00050 com='drum'
unit 3006
'content (collapsed) [Elev= 9.691 in.]'
 zhemicyl-x  1  1    6.426200   12.11696   0.00050 com='cv well cavity'
 zhemicyl-x  8  1    6.680200   12.11696   0.00050 com='cv below 1st step'
 zhemicyl-x  15 1    7.924800   12.11696   0.00050 com='void btw cv-np liner'
 zhemicyl-x  16 1    8.077200   12.11696   0.00050 com='np277_4 liner'
 zhemicyl-x  11 1   10.922000   12.11696   0.00050 com='np277_4'
 zhemicyl-x  16 1   11.074400   12.11696   0.00050 com='kaolite liner'
 zhemicyl-x  12 1   21.685692   12.11696   0.00050 com='kaolite'
 zhemicyl-x  19 1   21.838092   12.11696   0.00050 com='drum'
unit 3007
'np277_4 spacer [Elev=11.091 in.]'
 zhemicyl-x  2  1    5.24510     3.55660   0.00050 com='np spacer'
 zhemicyl-x  1  1    6.426200    3.55660   0.00050 com='cv well cavity'
 zhemicyl-x  8  1    6.680200    3.55660   0.00050 com='cv below 1st step'
 zhemicyl-x  15 1    7.924800    3.55660   0.00050 com='void btw cv-np liner'
 zhemicyl-x  16 1    8.077200    3.55660   0.00050 com='np277_4 liner'
 zhemicyl-x  11 1   10.922000    3.55660   0.00050 com='np277_4'
 zhemicyl-x  16 1   11.074400    3.55660   0.00050 com='kaolite liner'
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 zhemicyl-x  12 1   21.685692    3.55660   0.00050 com='kaolite'
 zhemicyl-x  19 1   21.838092    3.55660   0.00050 com='drum'
unit 3008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
 zhemicyl-x  1  1    6.426200   33.62022   0.00050 com='cv well cavity'
 zhemicyl-x  8  1    6.680200   33.62022   0.00050 com='cv below 1st step'
 zhemicyl-x  15 1    7.924800   33.62022   0.00050 com='void btw cv-np liner'
 zhemicyl-x  16 1    8.077200   33.62022   0.00050 com='np277_4 liner'
 zhemicyl-x  11 1   10.922000   33.62022   0.00050 com='np277_4'
 zhemicyl-x  16 1   11.074400   33.62022   0.00050 com='kaolite liner'
 zhemicyl-x  12 1   21.685692   33.62022   0.00050 com='kaolite'
 zhemicyl-x  19 1   21.838092   33.62022   0.00050 com='drum'
unit 3010
'cv at 1st step in liner [Elev=35.330 in.]'
 zhemicyl-x  1  1    6.426200    0.15190   0.00050 com='cv well cavity'
 zhemicyl-x  8  1    6.680200    0.15190   0.00050 com='cv at 1st step'
 zhemicyl-x  15 1    7.924800    0.15190   0.00050 com='void btw cv and liner'
 zhemicyl-x  16 1   11.074400    0.15190   0.00050 com='liner 1st step'
 zhemicyl-x  12 1   21.685692    0.15190   0.00050 com='kaolite'
 zhemicyl-x  19 1   21.838092    0.15190   0.00050 com='drum'
unit 3011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 zhemicyl-x  1  1    6.426200    0.22810   0.00050 com='cv well cavity'
 zhemicyl-x  8  1    6.680200    0.22810   0.00050 com='cv gap btw step-flng'
 zhemicyl-x  15 1   10.922000    0.22810   0.00050 com='void btw cv and liner'
 zhemicyl-x  16 1   11.074400    0.22810   0.00050 com='liner wall'
 zhemicyl-x  12 1   21.685692    0.22810   0.00050 com='kaolite'
 zhemicyl-x  19 1   21.838092    0.22810   0.00050 com='drum'
unit 3012
'cv flange to top of cv well [Elev=35.920 in.]'
 zhemicyl-x  1  1    6.426200    1.26950   0.00050 com='cavity'
 zhemicyl-x  9  1    9.525000    1.26950   0.00050 com='flange to top of well'
 zhemicyl-x  15 1    9.525000    1.26950   0.00050 com='void btw cv and pad-2'
 zhemicyl-x  14 1   10.033000    1.26950   0.00050 com='pad-2'
 zhemicyl-x  15 1   10.922000    1.26950   0.00050 com='void btw cv and liner'
 zhemicyl-x  16 1   11.074400    1.26950   0.00050 com='liner wall'
 zhemicyl-x  12 1   21.685692    1.26950   0.00050 com='kaolite'
 zhemicyl-x  19 1   21.838092    1.26950   0.00050 com='drum'
unit 3013
'cv flange above cv well [Elev=37.070 in.]'
 zhemicyl-x  10 1    9.525000    2.92050   0.00050 com='flange above cv well'
 zhemicyl-x  15 1    9.525000    2.92050   0.00050 com='void btw cv and pad-2'
 zhemicyl-x  14 1   10.033000    2.92050   0.00050 com='pad-2'
 zhemicyl-x  15 1   10.922000    2.92050   0.00050 com='void btw pad2-liner'
 zhemicyl-x  16 1   11.074400    2.92050   0.00050 com='liner wall'
 zhemicyl-x  12 1   21.685692    2.92050   0.00050 com='kaolite'
 zhemicyl-x  19 1   21.838092    2.92050   0.00050 com='drum'
unit 3014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 zhemicyl-x  14 1   10.033000    0.76150   0.00050 com='pad-2'
 zhemicyl-x  15 1   10.922000    1.01550   0.00050 com='void btw pad2-liner'
 zhemicyl-x  16 1   11.074400    1.01550   0.00050 com='liner wall'
 zhemicyl-x  12 1   21.685692    1.01550   0.00050 com='kaolite'
 zhemicyl-x  19 1   21.838092    1.01550   0.00050 com='drum'
unit 3015
'2nd step in liner [Elev=37.530 in.]'
 zhemicyl-x  15 1   10.922000    0.15190   0.00050 com='void abv pad2'
 zhemicyl-x  16 1   18.757900    0.15190   0.00050 com='liner 2nd step'
 zhemicyl-x  12 1   21.685692    0.15190   0.00050 com='kaolite'
 zhemicyl-x  19 1   21.838092    0.15190   0.00050 com='drum'
unit 3016
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'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 zhemicyl-x  13 1   18.097500    8.17830   0.49276 com='plug kaolite'
 zhemicyl-x  17 1   18.249900    8.17830   0.34036 com='sides of plug case'
 zhemicyl-x  15 1   18.605500    8.17830   0.00050 com='void: plug to liner'
 zhemicyl-x  16 1   18.757900    8.17830   0.00050 com='liner wall'
 zhemicyl-x  12 1   21.685692    8.17830   0.00050 com='kaolite'
 zhemicyl-x  19 1   21.838092    8.17830   0.00050 com='drum'
unit 3017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 zhemicyl-x  13 1   18.097500    4.44450   0.00050 com='plug kaolite'
 zhemicyl-x  17 1   18.249900    4.44450   0.00050 com='sides of plug case'
 zhemicyl-x  15 1   18.605500    4.44450   0.00050 com='void: plug to liner'
 zhemicyl-x  16 1   18.757900    4.44450   0.00050 com='liner wall'
 zhemicyl-x  18 1   19.392900    4.44450   0.00050 com='lower angle iron'
 zhemicyl-x  12 1   21.685692    4.44450   0.00050 com='kaolite'
 zhemicyl-x  19 1   21.838092    4.44450   0.00050 com='drum'
unit 3018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 zhemicyl-x  13 1   18.097500    0.11126   0.00050 com='plug kaolite'
 zhemicyl-x  17 1   18.249900    0.26366   0.00050 com='sides of plug case'
 zhemicyl-x  15 1   18.605500    0.63450   0.00050 com='void: plug to liner'
 zhemicyl-x  16 1   18.757900    0.63450   0.00050 com='liner wall'
 zhemicyl-x  18 1   21.685692    0.63450   0.00050 com='bend section of ai'
 zhemicyl-x  19 1   21.838092    0.63450   0.00050 com='drum'
unit 3019
'drum lid and lip [Elev=43.500 in.]'
 zhemicyl-x  20 1   21.469792    1.90450   0.15240 com='void above lid'
 zhemicyl-x  19 1   21.622192    1.90450   0.00050 com='drum lid'
 zhemicyl-x  20 1   21.685692    1.90450   0.00050 com='void btw lid-drumwall'
 zhemicyl-x  19 1   21.838092    1.90450   0.00050 com='drum'
unit 4001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'zhemicyl+x  19 1   21.838092    0.26620   0.00050 com='extended radius not used'
 zhemicyl+x  19 1   21.838092    0.26620   0.00050 com='drum bottom flat cover'
unit 4002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 zhemicyl+x  15 1    3.175000   11.59460  11.16330 com='void in pad-1'
 zhemicyl+x  14 1    7.924800   11.59460  11.16330 com='pad-1'
 zhemicyl+x  16 1    8.077200   11.59460  11.16330 com='np277_4 liner'
 zhemicyl+x  11 1   10.922000   11.59460  11.16330 com='np277_4'
 zhemicyl+x  16 1   11.074400   11.59460  10.85850 com='kaolite liner bottom'
 zhemicyl+x  12 1   21.685692   11.59460   0.00050 com='kaolite'
 zhemicyl+x  19 1   21.838092   11.59460   0.00050 com='drum'
unit 4003
'cv bottom [Elev= 4.920 in.]'
 zhemicyl+x  8  1    6.680200    0.63450   0.00050 com='cv bottom'
 zhemicyl+x  15 1    7.924800    0.63450   0.00050 com='void btw cv-np liner'
 zhemicyl+x  16 1    8.077200    0.63450   0.00050 com='np277_4 liner'
 zhemicyl+x  11 1   10.922000    0.63450   0.00050 com='np277_4'
 zhemicyl+x  16 1   11.074400    0.63450   0.00050 com='kaolite liner'
 zhemicyl+x  12 1   21.685692    0.63450   0.00050 com='kaolite'
 zhemicyl+x  19 1   21.838092    0.63450   0.00050 com='drum'
unit 4006
'content (collapsed) [Elev= 9.691 in.]'
 zhemicyl+x  1  1    6.426200   12.11696   0.00050 com='cv well cavity'
 zhemicyl+x  8  1    6.680200   12.11696   0.00050 com='cv below 1st step'
 zhemicyl+x  15 1    7.924800   12.11696   0.00050 com='void btw cv-np liner'
 zhemicyl+x  16 1    8.077200   12.11696   0.00050 com='np277_4 liner'
 zhemicyl+x  11 1   10.922000   12.11696   0.00050 com='np277_4'
 zhemicyl+x  16 1   11.074400   12.11696   0.00050 com='kaolite liner'
 zhemicyl+x  12 1   21.685692   12.11696   0.00050 com='kaolite'
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 zhemicyl+x  19 1   21.838092   12.11696   0.00050 com='drum'
unit 4007
'np277_4 spacer [Elev=11.091 in.]'
 zhemicyl+x  2  1    5.24510     3.55660   0.00050 com='np spacer'
 zhemicyl+x  1  1    6.426200    3.55660   0.00050 com='cv well cavity'
 zhemicyl+x  8  1    6.680200    3.55660   0.00050 com='cv below 1st step'
 zhemicyl+x  15 1    7.924800    3.55660   0.00050 com='void btw cv-np liner'
 zhemicyl+x  16 1    8.077200    3.55660   0.00050 com='np277_4 liner'
 zhemicyl+x  11 1   10.922000    3.55660   0.00050 com='np277_4'
 zhemicyl+x  16 1   11.074400    3.55660   0.00050 com='kaolite liner'
 zhemicyl+x  12 1   21.685692    3.55660   0.00050 com='kaolite'
 zhemicyl+x  19 1   21.838092    3.55660   0.00050 com='drum'
unit 4008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
 zhemicyl+x  1  1    6.426200   33.62022   0.00050 com='cv well cavity'
 zhemicyl+x  8  1    6.680200   33.62022   0.00050 com='cv below 1st step'
 zhemicyl+x  15 1    7.924800   33.62022   0.00050 com='void btw cv-np liner'
 zhemicyl+x  16 1    8.077200   33.62022   0.00050 com='np277_4 liner'
 zhemicyl+x  11 1   10.922000   33.62022   0.00050 com='np277_4'
 zhemicyl+x  16 1   11.074400   33.62022   0.00050 com='kaolite liner'
 zhemicyl+x  12 1   21.685692   33.62022   0.00050 com='kaolite'
 zhemicyl+x  19 1   21.838092   33.62022   0.00050 com='drum'
unit 4010
'cv at 1st step in liner [Elev=35.330 in.]'
 zhemicyl+x  1  1    6.426200    0.15190   0.00050 com='cv well cavity'
 zhemicyl+x  8  1    6.680200    0.15190   0.00050 com='cv at 1st step'
 zhemicyl+x  15 1    7.924800    0.15190   0.00050 com='void btw cv and liner'
 zhemicyl+x  16 1   11.074400    0.15190   0.00050 com='liner 1st step'
 zhemicyl+x  12 1   21.685692    0.15190   0.00050 com='kaolite'
 zhemicyl+x  19 1   21.838092    0.15190   0.00050 com='drum'
unit 4011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 zhemicyl+x  1  1    6.426200    0.22810   0.00050 com='cv well cavity'
 zhemicyl+x  8  1    6.680200    0.22810   0.00050 com='cv gap btw step-flng'
 zhemicyl+x  15 1   10.922000    0.22810   0.00050 com='void btw cv and liner'
 zhemicyl+x  16 1   11.074400    0.22810   0.00050 com='liner wall'
 zhemicyl+x  12 1   21.685692    0.22810   0.00050 com='kaolite'
 zhemicyl+x  19 1   21.838092    0.22810   0.00050 com='drum'
unit 4012
'cv flange to top of cv well [Elev=35.920 in.]'
 zhemicyl+x  1  1    6.426200    1.26950   0.00050 com='cavity'
 zhemicyl+x  9  1    9.525000    1.26950   0.00050 com='flange to top of well'
 zhemicyl+x  15 1    9.525000    1.26950   0.00050 com='void btw cv and pad-2'
 zhemicyl+x  14 1   10.033000    1.26950   0.00050 com='pad-2'
 zhemicyl+x  15 1   10.922000    1.26950   0.00050 com='void btw cv and liner'
 zhemicyl+x  16 1   11.074400    1.26950   0.00050 com='liner wall'
 zhemicyl+x  12 1   21.685692    1.26950   0.00050 com='kaolite'
 zhemicyl+x  19 1   21.838092    1.26950   0.00050 com='drum'
unit 4013
'cv flange above cv well [Elev=37.070 in.]'
 zhemicyl+x  10 1    9.525000    2.92050   0.00050 com='flange above cv well'
 zhemicyl+x  15 1    9.525000    2.92050   0.00050 com='void btw cv and pad-2'
 zhemicyl+x  14 1   10.033000    2.92050   0.00050 com='pad-2'
 zhemicyl+x  15 1   10.922000    2.92050   0.00050 com='void btw pad2-liner'
 zhemicyl+x  16 1   11.074400    2.92050   0.00050 com='liner wall'
 zhemicyl+x  12 1   21.685692    2.92050   0.00050 com='kaolite'
 zhemicyl+x  19 1   21.838092    2.92050   0.00050 com='drum'
unit 4014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 zhemicyl+x  14 1   10.033000    0.76150   0.00050 com='pad-2'
 zhemicyl+x  15 1   10.922000    1.01550   0.00050 com='void btw pad2-liner'
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 zhemicyl+x  16 1   11.074400    1.01550   0.00050 com='liner wall'
 zhemicyl+x  12 1   21.685692    1.01550   0.00050 com='kaolite'
 zhemicyl+x  19 1   21.838092    1.01550   0.00050 com='drum'
unit 4015
'2nd step in liner [Elev=37.530 in.]'
 zhemicyl+x  15 1   10.922000    0.15190   0.00050 com='void abv pad2'
 zhemicyl+x  16 1   18.757900    0.15190   0.00050 com='liner 2nd step'
 zhemicyl+x  12 1   21.685692    0.15190   0.00050 com='kaolite'
 zhemicyl+x  19 1   21.838092    0.15190   0.00050 com='drum'
unit 4016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 zhemicyl+x  13 1   18.097500    8.17830   0.49276 com='plug kaolite'
 zhemicyl+x  17 1   18.249900    8.17830   0.34036 com='sides of plug case'
 zhemicyl+x  15 1   18.605500    8.17830   0.00050 com='void: plug to liner'
 zhemicyl+x  16 1   18.757900    8.17830   0.00050 com='liner wall'
 zhemicyl+x  12 1   21.685692    8.17830   0.00050 com='kaolite'
 zhemicyl+x  19 1   21.838092    8.17830   0.00050 com='drum'
unit 4017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 zhemicyl+x  13 1   18.097500    4.44450   0.00050 com='plug kaolite'
 zhemicyl+x  17 1   18.249900    4.44450   0.00050 com='sides of plug case'
 zhemicyl+x  15 1   18.605500    4.44450   0.00050 com='void: plug to liner'
 zhemicyl+x  16 1   18.757900    4.44450   0.00050 com='liner wall'
 zhemicyl+x  18 1   19.392900    4.44450   0.00050 com='lower angle iron'
 zhemicyl+x  12 1   21.685692    4.44450   0.00050 com='kaolite'
 zhemicyl+x  19 1   21.838092    4.44450   0.00050 com='drum'
unit 4018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 zhemicyl+x  13 1   18.097500    0.11126   0.00050 com='plug kaolite'
 zhemicyl+x  17 1   18.249900    0.26366   0.00050 com='sides of plug case'
 zhemicyl+x  15 1   18.605500    0.63450   0.00050 com='void: plug to liner'
 zhemicyl+x  16 1   18.757900    0.63450   0.00050 com='liner wall'
 zhemicyl+x  18 1   21.685692    0.63450   0.00050 com='bend section of ai'
 zhemicyl+x  19 1   21.838092    0.63450   0.00050 com='drum'
unit 4019
'drum lid and lip [Elev=43.500 in.]'
 zhemicyl+x  20 1   21.469792    1.90450   0.15240 com='void above lid'
 zhemicyl+x  19 1   21.622192    1.90450   0.00050 com='drum lid'
 zhemicyl+x  20 1   21.685692    1.90450   0.00050 com='void btw lid-drumwall'
 zhemicyl+x  19 1   21.838092    1.90450   0.00050 com='drum'
unit 5001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
 cuboid    20 1 2p21.839092  2p37.826417   0.26670   0.0
 hole 1001 0.0   37.826417   0.0
 hole 2001 0.0  -37.826417   0.0
 hole 3001  21.839092   0.0   0.0
 hole 4001 -21.839092   0.0   0.0
unit 5002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    20 1 2p21.839092  2p37.826417  11.59510   0.0
 hole 1002 0.0   37.826417   0.0
 hole 2002 0.0  -37.826417   0.0
 hole 3002  21.839092   0.0   0.0
 hole 4002 -21.839092   0.0   0.0
unit 5003
'cv bottom [Elev= 4.920 in.]'
 cuboid    20 1 2p21.839092  2p37.826417   0.63500   0.0
 hole 1003 0.0   37.826417   0.0
 hole 2003 0.0  -37.826417   0.0
 hole 3003  21.839092   0.0   0.0
 hole 4003 -21.839092   0.0   0.0
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unit 5006
'content (collapsed) [Elev= 9.691 in.]'
 cuboid    20 1 2p21.839092  2p37.826417  12.11746   0.0
 hole 1006 0.0   37.826417   0.0
 hole 2006 0.0  -37.826417   0.0
 hole 3006  21.839092   0.0   0.0
 hole 4006 -21.839092   0.0   0.0
unit 5007
'np277_4 spacer [Elev=11.091 in.]'
 cuboid    20 1 2p21.839092  2p37.826417   3.55710   0.0
 hole 1007 0.0   37.826417   0.0
 hole 2007 0.0  -37.826417   0.0
 hole 3007  21.839092   0.0   0.0
 hole 4007 -21.839092   0.0   0.0
unit 5008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
 cuboid    20 1 2p21.839092  2p37.826417  33.62072   0.0
 hole 1008 0.0   37.826417   0.0
 hole 2008 0.0  -37.826417   0.0
 hole 3008  21.839092   0.0   0.0
 hole 4008 -21.839092   0.0   0.0
unit 5010
'cv at 1st step in liner [Elev=35.330 in.]'
 cuboid    20 1 2p21.839092  2p37.826417   0.15240   0.0
 hole 1010 0.0   37.826417   0.0
 hole 2010 0.0  -37.826417   0.0
 hole 3010  21.839092   0.0   0.0
 hole 4010 -21.839092   0.0   0.0
unit 5011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cuboid    20 1 2p21.839092  2p37.826417   0.22860   0.0
 hole 1011 0.0   37.826417   0.0
 hole 2011 0.0  -37.826417   0.0
 hole 3011  21.839092   0.0   0.0
 hole 4011 -21.839092   0.0   0.0
unit 5012
'cv flange to top of cv well [Elev=35.920 in.]'
 cuboid    20 1 2p21.839092  2p37.826417   1.27000   0.0
 hole 1012 0.0   37.826417   0.0
 hole 2012 0.0  -37.826417   0.0
 hole 3012  21.839092   0.0   0.0
 hole 4012 -21.839092   0.0   0.0
unit 5013
'cv flange above cv well [Elev=37.070 in.]'
 cuboid    20 1 2p21.839092  2p37.826417   2.92100   0.0
 hole 1013 0.0   37.826417   0.0
 hole 2013 0.0  -37.826417   0.0
 hole 3013  21.839092   0.0   0.0
 hole 4013 -21.839092   0.0   0.0
unit 5014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    20 1 2p21.839092  2p37.826417   1.01600   0.0
 hole 1014 0.0   37.826417   0.0
 hole 2014 0.0  -37.826417   0.0
 hole 3014  21.839092   0.0   0.0
 hole 4014 -21.839092   0.0   0.0
unit 5015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    20 1 2p21.839092  2p37.826417   0.15240   0.0
 hole 1015 0.0   37.826417   0.0
 hole 2015 0.0  -37.826417   0.0
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 hole 3015  21.839092   0.0   0.0
 hole 4015 -21.839092   0.0   0.0
unit 5016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    20 1 2p21.839092  2p37.826417   8.17880   0.0
 hole 1016 0.0   37.826417   0.0
 hole 2016 0.0  -37.826417   0.0
 hole 3016  21.839092   0.0   0.0
 hole 4016 -21.839092   0.0   0.0
unit 5017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    20 1 2p21.839092  2p37.826417   4.44500   0.0
 hole 1017 0.0   37.826417   0.0
 hole 2017 0.0  -37.826417   0.0
 hole 3017  21.839092   0.0   0.0
 hole 4017 -21.839092   0.0   0.0
unit 5018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    20 1 2p21.839092  2p37.826417   0.63500   0.0
 hole 1018 0.0   37.826417   0.0
 hole 2018 0.0  -37.826417   0.0
 hole 3018  21.839092   0.0   0.0
 hole 4018 -21.839092   0.0   0.0
unit 5019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    20 1 2p21.839092  2p37.826417   1.90500   0.0
 hole 1019 0.0   37.826417   0.0
 hole 2019 0.0  -37.826417   0.0
 hole 3019  21.839092   0.0   0.0
 hole 4019 -21.839092   0.0   0.0
unit 5020
'es3100 drum [Elev=43.500 in.]'
array 3         -21.839092   -37.826417    0.0
 cuboid    20  1 2p21.839592 2p37.826917 110.4905 0.0 com='interst. array space'
unit 6001
'drum bottom flat cover'
 cuboid    20  1 2p21.839092 0.0 -21.839092  0.26670 0.0
 hole 1001 0.0   0.0   0.0
unit 6002
'above drum bottom flat cover and below containment vessel'
 cuboid    20  1 2p21.839092 0.0 -21.839092 11.59510 0.0
 hole 1002 0.0   0.0   0.0
unit 6003
'cv bottom'
 cuboid    20  1 2p21.839092 0.0 -21.839092  0.63500 0.0
 hole 1003 0.0   0.0   0.0
unit 6006
'drum stand'
'content (collapsed)'
 cuboid    20  1 2p21.839092 0.0 -21.839092 12.11746 0.0
 hole 1006 0.0   0.0   0.0
unit 6007
'np277_4 spacer'
 cuboid    20  1 2p21.839092 0.0 -21.839092  3.55710 0.0
 hole 1007 0.0   0.0   0.0
unit 6008
'top of content stack to bottom of 1st step'
 cuboid    20  1 2p21.839092 0.0 -21.839092 33.62072 0.0
 hole 1008 0.0   0.0   0.0
unit 6010
'cv at 1st step in liner'
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 cuboid    20  1 2p21.839092 0.0 -21.839092  0.15240 0.0
 hole 1010 0.0   0.0   0.0
unit 6011
'vertical gap between 1st step in liner and cv flange'
 cuboid    20  1 2p21.839092 0.0 -21.839092  0.22860 0.0
 hole 1011 0.0   0.0   0.0
unit 6012
'cv flange to top of cv well'
 cuboid    20  1 2p21.839092 0.0 -21.839092  1.27000 0.0
 hole 1012 0.0   0.0   0.0
unit 6013
'cv flange above cv well'
 cuboid    20  1 2p21.839092 0.0 -21.839092  2.92100 0.0
 hole 1013 0.0   0.0   0.0
unit 6014
'plugpad2 below liner 2nd step'
 cuboid    20  1 2p21.839092 0.0 -21.839092  1.01600 0.0
 hole 1014 0.0   0.0   0.0
unit 6015
'2nd step in liner'
 cuboid    20  1 2p21.839092 0.0 -21.839092  0.15240 0.0
 hole 1015 0.0   0.0   0.0
unit 6016
'abv 2nd step in liner to bottom of angle iron'
 cuboid    20  1 2p21.839092 0.0 -21.839092  8.17880 0.0
 hole 1016 0.0   0.0   0.0
unit 6017
'bottom of angle iron to bend in angle iron'
 cuboid    20  1 2p21.839092 0.0 -21.839092  4.44500 0.0
 hole 1017 0.0   0.0   0.0
unit 6018
'bend in angle iron to top of angle iron'
 cuboid    20  1 2p21.839092 0.0 -21.839092  0.63500 0.0
 hole 1018 0.0   0.0   0.0
unit 6019
'drum lid and lip'
 cuboid    20  1 2p21.839092 0.0 -21.839092  1.90500 0.0
 hole 1019 0.0   0.0   0.0
unit 6020
'es3100 drum'
array 4         2r-21.839092     0.0
 cuboid    20  1 2p21.839592 0.0005 -21.839592 110.4905 0.0
unit 7001
 cuboid    20  1 2p21.839092 21.839092 0.0  0.26670 0.0
 hole 2001 0.0   0.0   0.0
unit 7002
 cuboid    20  1 2p21.839092 21.839092 0.0 11.59510 0.0
 hole 2002 0.0   0.0   0.0
unit 7003
 cuboid    20  1 2p21.839092 21.839092 0.0  0.63500 0.0
 hole 2003 0.0   0.0   0.0
unit 7006
 cuboid    20  1 2p21.839092 21.839092 0.0 12.11746 0.0
 hole 2006 0.0   0.0   0.0
unit 7007
 cuboid    20  1 2p21.839092 21.839092 0.0  3.55710 0.0
 hole 2007 0.0   0.0   0.0
unit 7008
 cuboid    20  1 2p21.839092 21.839092 0.0 33.62072 0.0
 hole 2008 0.0   0.0   0.0
unit 7010
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 cuboid    20  1 2p21.839092 21.839092 0.0  0.15240 0.0
 hole 2010 0.0   0.0   0.0
unit 7011
 cuboid    20  1 2p21.839092 21.839092 0.0  0.22860 0.0
 hole 2011 0.0   0.0   0.0
unit 7012
 cuboid    20  1 2p21.839092 21.839092 0.0  1.27000 0.0
 hole 2012 0.0   0.0   0.0
unit 7013
 cuboid    20  1 2p21.839092 21.839092 0.0  2.92100 0.0
 hole 2013 0.0   0.0   0.0
unit 7014
 cuboid    20  1 2p21.839092 21.839092 0.0  1.01600 0.0
 hole 2014 0.0   0.0   0.0
unit 7015
 cuboid    20  1 2p21.839092 21.839092 0.0  0.15240 0.0
 hole 2015 0.0   0.0   0.0
unit 7016
 cuboid    20  1 2p21.839092 21.839092 0.0  8.17880 0.0
 hole 2016 0.0   0.0   0.0
unit 7017
 cuboid    20  1 2p21.839092 21.839092 0.0  4.44500 0.0
 hole 2017 0.0   0.0   0.0
unit 7018
 cuboid    20  1 2p21.839092 21.839092 0.0  0.63500 0.0
 hole 2018 0.0   0.0   0.0
unit 7019
 cuboid    20  1 2p21.839092 21.839092 0.0  1.90500 0.0
 hole 2019 0.0   0.0   0.0
unit 7020
'es3100 drum'
array 5         -21.839092     0.0     0.0
 cuboid    20  1 2p21.839592 21.839592 -0.0005 110.4905 0.0
unit 8001
 cuboid    20  1 0.0 -21.839092 2p37.826417  0.26670 0.0
 hole 3001 0.0   0.0   0.0
unit 8002
 cuboid    20  1 0.0 -21.839092 2p37.826417 11.59510 0.0
 hole 3002 0.0   0.0   0.0
unit 8003
 cuboid    20  1 0.0 -21.839092 2p37.826417  0.63500 0.0
 hole 3003 0.0   0.0   0.0
unit 8006
 cuboid    20  1 0.0 -21.839092 2p37.826417 12.11746 0.0
 hole 3006 0.0   0.0   0.0
unit 8007
 cuboid    20  1 0.0 -21.839092 2p37.826417  3.55710 0.0
 hole 3007 0.0   0.0   0.0
unit 8008
 cuboid    20  1 0.0 -21.839092 2p37.826417 33.62072 0.0
 hole 3008 0.0   0.0   0.0
unit 8010
 cuboid    20  1 0.0 -21.839092 2p37.826417  0.15240 0.0
 hole 3010 0.0   0.0   0.0
unit 8011
 cuboid    20  1 0.0 -21.839092 2p37.826417  0.22860 0.0
 hole 3011 0.0   0.0   0.0
unit 8012
 cuboid    20  1 0.0 -21.839092 2p37.826417  1.27000 0.0
 hole 3012 0.0   0.0   0.0
unit 8013
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 cuboid    20  1 0.0 -21.839092 2p37.826417  2.92100 0.0
 hole 3013 0.0   0.0   0.0
unit 8014
 cuboid    20  1 0.0 -21.839092 2p37.826417  1.01600 0.0
 hole 3014 0.0   0.0   0.0
unit 8015
 cuboid    20  1 0.0 -21.839092 2p37.826417  0.15240 0.0
 hole 3015 0.0   0.0   0.0
unit 8016
 cuboid    20  1 0.0 -21.839092 2p37.826417  8.17880 0.0
 hole 3016 0.0   0.0   0.0
unit 8017
 cuboid    20  1 0.0 -21.839092 2p37.826417  4.44500 0.0
 hole 3017 0.0   0.0   0.0
unit 8018
 cuboid    20  1 0.0 -21.839092 2p37.826417  0.63500 0.0
 hole 3018 0.0   0.0   0.0
unit 8019
 cuboid    20  1 0.0 -21.839092 2p37.826417  1.90500 0.0
 hole 3019 0.0   0.0   0.0
unit 8020
'es3100 drum'
array 6         -21.839092    -37.826417    0.0
 cuboid    20  1 0.0005 -21.839592 2p37.826917 110.4905 0.0
unit 9001
 cuboid    20  1 21.839092 0.0 2p37.826417  0.26670 0.0
 hole 4001 0.0   0.0   0.0
unit 9002
 cuboid    20  1 21.839092 0.0 2p37.826417 11.59510 0.0
 hole 4002 0.0   0.0   0.0
unit 9003
 cuboid    20  1 21.839092 0.0 2p37.826417  0.63500 0.0
 hole 4003 0.0   0.0   0.0
unit 9006
 cuboid    20  1 21.839092 0.0 2p37.826417 12.11746 0.0
 hole 4006 0.0   0.0   0.0
unit 9007
 cuboid    20  1 21.839092 0.0 2p37.826417  3.55710 0.0
 hole 4007 0.0   0.0   0.0
unit 9008
 cuboid    20  1 21.839092 0.0 2p37.826417 33.62072 0.0
 hole 4008 0.0   0.0   0.0
unit 9010
 cuboid    20  1 21.839092 0.0 2p37.826417  0.15240 0.0
 hole 4010 0.0   0.0   0.0
unit 9011
 cuboid    20  1 21.839092 0.0 2p37.826417  0.22860 0.0
 hole 4011 0.0   0.0   0.0
unit 9012
 cuboid    20  1 21.839092 0.0 2p37.826417  1.27000 0.0
 hole 4012 0.0   0.0   0.0
unit 9013
 cuboid    20  1 21.839092 0.0 2p37.826417  2.92100 0.0
 hole 4013 0.0   0.0   0.0
unit 9014
 cuboid    20  1 21.839092 0.0 2p37.826417  1.01600 0.0
 hole 4014 0.0   0.0   0.0
unit 9015
 cuboid    20  1 21.839092 0.0 2p37.826417  0.15240 0.0
 hole 4015 0.0   0.0   0.0
unit 9016
```

```
 cuboid    20  1 21.839092 0.0 2p37.826417  8.17880 0.0
 hole 4016 0.0   0.0   0.0
unit 9017
 cuboid    20  1 21.839092 0.0 2p37.826417  4.44500 0.0
 hole 4017 0.0   0.0   0.0
unit 9018
 cuboid    20  1 21.839092 0.0 2p37.826417  0.63500 0.0
 hole 4018 0.0   0.0   0.0
unit 9019
 cuboid    20  1 21.839092 0.0 2p37.826417  1.90500 0.0
 hole 4019 0.0   0.0   0.0
unit 9020
'es3100 drum'
array 7         0.0    -37.826417    0.0
 cuboid    20  1 21.839592 -0.0005 2p37.826917 110.4905 0.0
unit 9021
 cuboid    20  1 21.839092 0.0 21.839092 0.0  0.26670 0.0
unit 9022
 cuboid    20  1 21.839092 0.0 21.839092 0.0 11.59510 0.0
unit 9023
 cuboid    20  1 21.839092 0.0 21.839092 0.0  0.63500 0.0
unit 9026
 cuboid    20  1 21.839092 0.0 21.839092 0.0 12.11746 0.0
unit 9027
 cuboid    20  1 21.839092 0.0 21.839092 0.0  3.55710 0.0
unit 9028
 cuboid    20  1 21.839092 0.0 21.839092 0.0 33.62072 0.0
unit 9030
 cuboid    20  1 21.839092 0.0 21.839092 0.0  0.15240 0.0
unit 9031
 cuboid    20  1 21.839092 0.0 21.839092 0.0  0.22860 0.0
unit 9032
 cuboid    20  1 21.839092 0.0 21.839092 0.0  1.27000 0.0
unit 9033
 cuboid    20  1 21.839092 0.0 21.839092 0.0  2.92100 0.0
unit 9034
 cuboid    20  1 21.839092 0.0 21.839092 0.0  1.01600 0.0
unit 9035
 cuboid    20  1 21.839092 0.0 21.839092 0.0  0.15240 0.0
unit 9036
 cuboid    20  1 21.839092 0.0 21.839092 0.0  8.17880 0.0
unit 9037
 cuboid    20  1 21.839092 0.0 21.839092 0.0  4.44500 0.0
unit 9038
 cuboid    20  1 21.839092 0.0 21.839092 0.0  0.63500 0.0
unit 9039
 cuboid    20  1 21.839092 0.0 21.839092 0.0  1.90500 0.0
unit 9040
'array end space'
array 8         0.0    0.0    0.0
 cuboid    20  1 21.839592 -0.0005 21.839592 -0.0005 110.4905 0.0
global
unit 9050
array 9    3r0.0
reflector  21 2  6r3.0  10
end geometry
read array
ara=1 nux=3 nuy=3 nuz=4   fill 27r1004  9r1005      end fill
ara=3 nux=1 nuy=1 nuz=19 fill
5001 5002 5003 5006 5007 5006 5007 5006 5008 5010
5011 5012 5013 5014 5015 5016 5017 5018 5019       end fill
```

```
ara=4 nux=1 nuy=1 nuz=19                                fill
6001 6002 6003 6006 6007 6006 6007 6006 6008 6010
6011 6012 6013 6014 6015 6016 6017 6018 6019       end fill
ara=5 nux=1 nuy=1 nuz=19                                fill
7001 7002 7003 7006 7007 7006 7007 7006 7008 7010
7011 7012 7013 7014 7015 7016 7017 7018 7019       end fill
ara=6 nux=1 nuy=1 nuz=19                                fill
8001 8002 8003 8006 8007 8006 8007 8006 8008 8010
8011 8012 8013 8014 8015 8016 8017 8018 8019       end fill
ara=7 nux=1 nuy=1 nuz=19                                fill
9001 9002 9003 9006 9007 9006 9007 9006 9008 9010
9011 9012 9013 9014 9015 9016 9017 9018 9019       end fill
ara=8 nux=1 nuy=1 nuz=19                                fill
9021 9022 9023 9026 9027 9026 9027 9026 9028 9030
9031 9032 9033 9034 9035 9036 9037 9038 9039       end fill
ara=9 nux=7 nuy=3 nuz=3                                 fill
9040 5r6020 9040 8020 5r5020 9020 9040 5r7020 9040 2q21 end fill
end array
read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.23 Case nciaoxt11_1_24_1_3

```
=csas25    parm=size=3000000
nciaoxt11,0.0in np,disp.24000.0gUO2 (21124.9g235, 6533.9gH2O hx=  9.90),fr=1.0e-04
238groupndf5 infhommedium
'HEU volume =3669.72477, SPACER volume    0.00000'
'HEU oxide, bulk density of oxide in cans=  6.54000 g/cm3'
'wrapped dry content can hx=0.79, CV void volume 6545.63717'
'oxide= 24000.0 g, sat. moisture in HEU oxide=1477.3 g, oxide htox= 1.83'
arbmuox    6.54000   2 0 0 0  92235   88.0203
                              8016   11.9797    1  1.0000  293  end
arbmastm  4.0256e-01  2 0 0 0   1001   11.1913
                              8016   88.8087    1  1.0000  293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  9.9820e-01  2 0 0 0   1001   11.1913
                              8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                         8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
```

```
ss304                                              9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                             10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'nct array densities are s.u.dens. multiplied by volume ratio 1.34888/1.10336'
arbmh2ok   0.63931  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.42622  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.42622  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.42622  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.42622  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.42622  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.42622  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.42622  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
```

```
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                          16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                          17  1.06388 293  end
'steel: angle iron (ai) for single units'
'ss304                                          18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
ss304                                          18  1.25705 293  end
'steel: drum steel for single units'
'ss304                                          19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
ss304                                          19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
arbmwed    1.16026  2 0 0 0    1001   11.1913
                               8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                               8016   88.8087   21  1.0     293  end
end comp
nciaoxt11,0.0in np,disp.24000.0gUO2 (21124.9g235, 6533.9gH2O,hx=  9.90),fr=1.0e-04
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                   end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.111 in. at top of unit]'
'cylinder  19 1   22.866096    0.28150   0.0     com='extended radius not used'
 cylinder  19 1   21.722275    0.28150   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p22.866096    0.28150   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.676 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.555075   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.722275   11.59510   0.0     com='drum'
 cuboid    20 1 4p22.866096   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.276 in.]'
 cylinder  3  1    6.426200   77.72400  28.92123 com='cavity abv HEU'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cylinder  15 1    7.924800   77.72400   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   77.72400   0.0     com='np277_4 liner'
```

```
 cylinder  11 1   10.922000   77.72400   0.0     com='np277_4'
 cylinder  16 1   11.074400   77.72400   0.0     com='kaolite liner'
 cylinder  12 1   21.555075   77.72400   0.0     com='kaolite'
 cylinder  19 1   21.722275   77.72400   0.0     com='drum'
 cuboid    20 1 4p22.866096   77.72400   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.336 in.]'
 cylinder  3  1    6.426200    0.15240   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.426 in.]'
 cylinder  3  1    6.426200    0.22860   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.555075    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.22860   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.926 in.]'
 cylinder  3  1    6.426200    1.27000   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.27000   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.076 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.555075    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.722275    2.92100   0.0     com='drum'
 cuboid    20 1 4p22.866096    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.476 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.01600   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.536 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
```

```
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.756 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.555075    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.722275    8.17880   0.0     com='drum'
 cuboid    20 1 4p22.866096    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.506 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.555075    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.722275    4.44500   0.0     com='drum'
 cuboid    20 1 4p22.866096    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.756 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.555075    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.512 in.]'
 cylinder  20 1   21.330090    1.91973   0.16720 com='void above lid'
 cylinder  19 1   21.497290    1.91973   0.0     com='drum lid'
 cylinder  20 1   21.555075    1.91973   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.722275    1.91973   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.91973   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.512 in.]'
array 3         2r-22.866096     0.0
'cuboid     0  1 4p24.587200    1120.337  0.0    com='bare package'
'cuboid    21  1 4p55.067200   1150.817 -30.48   com='reflected package'
 cuboid    20  1 4p22.866096    110.5197  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.24 Case nciask_9_15

```
=csas25    parm=size=3000000
nciask,0.0 21300.0g soc(19865.3uox,15672.8u235,  921.0c),hx= 12.82,fr=1.0e+00
238groupndf5 infhommedium
'  cm3: Skull oxide content 6974.5, SPACER    0.0, CV void 3240.9; CV htox=12.82'
'g/cm3: Skull oxide content  3.05400'
'U3O8   (19865.33gUOX,16816.3gU,15672.8g235U, 3801.4g.sat.H2O, HX=  7.43)'
'Carbon (  921.00gC,   58764.1mgC/g235U)'
'Poly   (  513.00gCH2)'
'Other  (    0.67gUnident (assumed H2O)'
''
'Increm (  921.0gC,15672.8g235U,   58764.1mgC/g235U)'
'GREP1:21300.00 19865.33 3.8014e+03    7.43 16816.35 15672.84   921.00  58764.1
'GREP2: 3235.07   513.00      12.82    0.67  1.0e+00
''
arbmuox    2.84830    3 0 0 0  92235   78.8954
                               92238    5.7563
                                8016   15.3483    1  1.0000  293  end
arbmc     1.3205e-01  1 0 0 0   6012  100.0000    1  1.0000  293  end
arbmastm  5.4505e-01  2 0 0 0   1001   11.1913
                                8016   88.8087    1  1.0000  293  end
arbmpoly   0.07355    2 0 0 0   1001   14.3798
                                6012   85.6202    1  1.0000  293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  9.9820e-01  2 0 0 0   1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
```

```
                                8016   43.4251
                               11023    0.1174
                               12000    0.3378
                               13027   39.0479
                               14000    2.4672
                               16000    0.3083
                               20000   11.8336
                               26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'nct array densities are s.u.dens. multiplied by volume ratio 1.34888/1.10336'
arbmh2ok   0.63931  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.42622  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.42622  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.42622  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.42622  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.42622  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.42622  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.42622  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  1       293  end
```

```
'steel: liner'
ss304                                          16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                          17  1.06388 293  end
'steel: angle iron (ai) for single units'
'ss304                                          18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
ss304                                          18  1.25705 293  end
'steel: drum steel for single units'
'ss304                                          19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
ss304                                          19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
arbmwed    1.16026  2 0 0 0    1001   11.1913
                               8016   88.8087   20  1       293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                               8016   88.8087   21  1.0     293  end
end comp
nciask,0.0,21300.0g soc(19865.3uox,15672.8u235,  921.0c),hx= 12.82 fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                   end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.111 in. at top of unit]'
'cylinder  19 1   22.866096    0.28150   0.0     com='extended radius not used'
 cylinder  19 1   21.722275    0.28150   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p22.866096    0.28150   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.676 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.555075   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.722275   11.59510   0.0     com='drum'
 cuboid    20 1 4p22.866096   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.276 in.]'
 cylinder  3  1    6.426200   77.72400  54.39413 com='cavity abv HEU'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cylinder  15 1    7.924800   77.72400   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   77.72400   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   77.72400   0.0     com='np277_4'
 cylinder  16 1   11.074400   77.72400   0.0     com='kaolite liner'
 cylinder  12 1   21.555075   77.72400   0.0     com='kaolite'
 cylinder  19 1   21.722275   77.72400   0.0     com='drum'
 cuboid    20 1 4p22.866096   77.72400   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.336 in.]'
 cylinder  3  1    6.426200    0.15240   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
```

```
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.426 in.]'
 cylinder  3  1    6.426200    0.22860   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.555075    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.22860   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.926 in.]'
 cylinder  3  1    6.426200    1.27000   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.27000   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.076 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.555075    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.722275    2.92100   0.0     com='drum'
 cuboid    20 1 4p22.866096    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.476 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.01600   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.536 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.756 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.555075    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.722275    8.17880   0.0     com='drum'
 cuboid    20 1 4p22.866096    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.506 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
```

```
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.555075    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.722275    4.44500   0.0     com='drum'
 cuboid    20 1 4p22.866096    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.756 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.555075    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.512 in.]'
 cylinder  20 1   21.330090    1.91973   0.16720 com='void above lid'
 cylinder  19 1   21.497290    1.91973   0.0     com='drum lid'
 cylinder  20 1   21.555075    1.91973   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.722275    1.91973   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.91973   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.512 in.]'
array 3         2r-22.866096     0.0
'cuboid     0  1 4p24.587200    1120.337  0.0    com='bare package'
'cuboid    21  1 4p55.067200   1150.817 -30.48   com='reflected package'
 cuboid    20  1 4p22.866096    110.5197  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.25 Case ncsrunhct11_9_1_15

```
=csas25    parm=size=3000000
ncsrunhct11 0.0innp,disp. 9000.0gUNHc( 4238.7g235, 6980.8gH2O hx= 54.99),fr=1.0e+00
238groupndf5 infhommedium
'U(enr)O2(NO3)2+6H2O [2.81 g/cc for U(nat)], gU/L= 414.9296'
'UNH crystals in cans  2.79329 g/cm3. wrapped dry content can hx=3.96'
arbmunh    2.79329  5 0 0 0   92235   47.0962
                              92238    0.0000
                               1001    2.4232
                               7014    5.6116
                               8016   44.8690    1  0.31541 293  end
arbmh2oc  6.8336e-01  2 0 0 0  1001   11.1913
                               8016   88.8087    1  1.0000  293  end
```

```
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  6.8336e-01  2 0 0 0   1001   11.1913
                                8016   88.8087     3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                            8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                            9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                           10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                               8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
```

```
                              8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                              8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                              8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                              8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                              8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   21  1.0     293  end
end comp
ncsrunhct11 0.0innp,disp. 9000.0gUNHc( 4238.7g235, 6980.8gH2O,hx= 54.99),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                       end boun
```

```
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   23.329900    0.26670   0.0     com='drum bottom flat cover'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   23.177500   11.59510   0.0     com='kaolite'
 cylinder  19 1   23.329900   11.59510   0.0     com='drum'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.270 in.]'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cylinder  15 1    7.924800   77.72400   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   77.72400   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   77.72400   0.0     com='np277_4'
 cylinder  16 1   11.074400   77.72400   0.0     com='kaolite liner'
 cylinder  12 1   23.177500   77.72400   0.0     com='kaolite'
 cylinder  19 1   23.329900   77.72400   0.0     com='drum'
 cuboid    21 1 4p24.587200   77.72400   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   23.177500    0.22860   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.22860   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   23.177500    1.27000   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.27000   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
```

```
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   23.177500    2.92100   0.0     com='kaolite'
 cylinder  19 1   23.329900    2.92100   0.0     com='drum'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   23.177500    1.01600   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.01600   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   23.177500    8.17880   0.0     com='kaolite'
 cylinder  19 1   23.329900    8.17880   0.0     com='drum'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   23.177500    4.44500   0.0     com='kaolite'
 cylinder  19 1   23.329900    4.44500   0.0     com='drum'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   23.177500    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   23.329900    0.63500   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  21 1   22.961600    1.90500   0.15240 com='void above lid'
 cylinder  19 1   23.114000    1.90500   0.0     com='drum lid'
 cylinder  21 1   23.177500    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   23.329900    1.90500   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
```

```
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.26 Case icsrunhct12_15_1_15

```
=csas25    parm=size=3000000
icsrunhct12 0.0innp,disp.15000.0gUNHc( 7064.4g235, 6870.7gH2O hx= 52.91),fr=1.0e+00
238groupndf5 infhommedium
'U(enr)O2(NO3)2+6H2O [2.81 g/cc for U(nat)], gU/L= 429.1329 dispersed'
'UNH crystals in cans  2.79329 g/cm3. wrapped dry content can hx=2.37'
'UNHc in cv   9308.07449 g.'
'water in cv  6870.67680 g.'
arbmunh    2.79329  5 0 0 0   92235   47.0962
                              92238    0.0000
                               1001    2.4232
                               7014    5.6116
                               8016   44.8690    1  0.32620 293  end
arbmh2oc   0.99820  2 0 0 0    1001   11.1913
                               8016   88.8087    1  0.67380 293  end
'np277-4: spacer (HAC_MD&H)'
'HAC min.den.(95.3157 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07071e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.82995e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  9.9820e-01  2 0 0 0    1001   11.1913
                                 8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                            8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                            9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                           10  0.94348 293  end
```

```
'np277-4: confinement -- neutron poison inner liner (HAC_MD&H)'
'actual vol.= 1.31846e4 cm3 = (8.0457422e2 in3)(16.387064)'
'den.multiplier = 1.31846e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.516887 = (den.mult)(np277-4 min.den.) = 0.9935052*1.526803'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.26267e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.06375e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.80508e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                                 8016   88.8087   12  1       293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                                 8016   47.0610   12  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                                 8016   53.2430   12  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                                 8016   30.0460   12  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                                 8016   40.0465   12  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                                 8016   28.5185   12  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                                 8016   39.6831   12  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                                 8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                                 8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                                 8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                                 8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                                 8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                                 8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                                 8016   28.5185   13  0.307   293  end
```

```
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
'UNHc in cv well   5691.92551 g.'
'water in cv well  4201.44688 g.'
arbmunh    2.79329  5 0 0 0   92235   47.0962
                             92238    0.0000
                              1001    2.4232
                              7014    5.6116
                              8016   44.8690   15  0.32620 293  end
arbmh2oc   0.99820  2 0 0 0    1001   11.1913
                              8016   88.8087   15  0.67380 293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for HAC'
'nct density is multiplied by volume fraction 7.08030/5.74516'
ss304                                         18  1.23239 293  end
'steel: drum steel for HAC'
'nct density is multiplied by volume fraction 3.20482/2.95645'
ss304                                         19  1.08401 293  end
'void space external to drum'
'array density is assumed not reduced by hac'
'arbmwed    0.9982   2 0 0 0    1001   11.1913
'                              8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   21  1.0     293  end
end comp
icsrunhct12 0.0innp,disp.15000.0gUNHc( 7064.4g235, 6870.7gH2O,hx= 52.91),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                       end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   21.838092    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   21.838092    0.26670   0.0     com='drum bottom flat cover'
 cuboid    21 1 4p21.838092    0.26670   0.0     com='drum(chine)outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
'v1002=1.36748e+01  '
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.685692   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.838092   11.59510   0.0     com='drum'
 cuboid    21 1 4p21.838092   11.59510   0.0     com='drum(chine)outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.270 in.]'
'v1003=4.43850e+03  '
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
```

```
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cylinder  15 1    7.924800   77.72400   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   77.72400   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   77.72400   0.0     com='np277_4'
 cylinder  16 1   11.074400   77.72400   0.0     com='kaolite liner'
 cylinder  12 1   21.685692   77.72400   0.0     com='kaolite'
 cylinder  19 1   21.838092   77.72400   0.0     com='drum'
 cuboid    21 1 4p21.838092   77.72400   0.0     com='drum(chine)outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
'v1010=8.70294e+00  '
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
'v1011=5.36220e+01  '
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.685692    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.22860   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.22860   0.0     com='drum(chine)outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
'v1012=7.43264e+01  '
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.27000   0.0     com='drum'
 cuboid    21 1 4p21.838092    1.27000   0.0     com='drum(chine)outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
'v1013=1.70951e+02  '
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.685692    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.838092    2.92100   0.0     com='drum'
 cuboid    21 1 4p21.838092    2.92100   0.0     com='drum(chine)outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
'v1014=1.39785e+02  '
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.01600   0.0     com='drum'
 cuboid    21 1 4p21.838092    1.01600   0.0     com='drum(chine)outer radius'
unit 1015
```

```
'2nd step in liner [Elev=37.530 in.]'
'v1015=5.71136e+01  '
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
'v1016=6.92877e+02  '
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.685692    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.838092    8.17880   0.0     com='drum'
 cuboid    21 1 4p21.838092    8.17880   0.0     com='drum(chine)outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
'v1017=1.83014e+02  '
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.685692    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.838092    4.44500   0.0     com='drum'
 cuboid    21 1 4p21.838092    4.44500   0.0     com='drum(chine)outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
'v1018=4.14168e+02  '
'Volume cv well=6.24674e+03  '
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.685692    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.838092    0.63500   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.63500   0.0     com='drum(chine)outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  21 1   21.469792    1.90500   0.15240 com='void above lid'
 cylinder  19 1   21.622192    1.90500   0.0     com='drum lid'
 cylinder  21 1   21.685692    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.838092    1.90500   0.0     com='drum'
 cuboid    21 1 4p21.838092    1.90500   0.0     com='drum(chine)outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-21.838092     0.0
'cuboid     0  1 4p21.838092    110.4905  0.0    com='bare package'
 cuboid    21  1 4p52.318092   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
```

```
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.27 Case ncsrtriga_1_15_15

```
=csas25    parm=size=3000000
ncsrtriga 0.0in thk np,10400.0gUZrHx(  921.0g235, 8998.2gH2O hx=255.01),fr=1.0e+00
238groupndf5 infhommedium
'TRIGA volume =1200.95996, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=18.2, CV void volume 9014.40198'
arbmtriga  8.65974  4 0 0 0    1001    0.9554
                              40000   54.0446
                              92235    8.8558
                              92238   36.1442    1  1.0     293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
```

```
                              14000    2.4672
                              16000    0.3083
                              20000   11.8336
                              26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                               8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                               8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
```

```
ss304                                          18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                          18  1.25705 293  end
'steel: drum steel for single units'
ss304                                          19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                          19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                               8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
ncsrtriga 0.0in thk np,10400.0gUZrHx(  921.0g235, 8998.2gH2O,hx=255.01),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                        end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   23.329900    0.26670   0.0     com='drum bottom flat cover'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   23.177500   11.59510   0.0     com='kaolite'
 cylinder  19 1   23.329900   11.59510   0.0     com='drum'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   23.177500    0.63500   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.63500   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.828800   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.920 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800   12.70050  -0.0005  com='void btw cv-np liner'
```

```
 cylinder  16 1    8.077200   12.70050  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000   12.70050  -0.0005  com='np277_4'
 cylinder  16 1   11.074400   12.70050  -0.0005  com='kaolite liner'
 cylinder  12 1   23.177500   12.70050  -0.0005  com='kaolite'
 cylinder  19 1   23.329900   12.70050  -0.0005  com='drum'
 cuboid    21 1 4p24.587200   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.921 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   23.177500    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   23.329900    0.00020  -0.0001  com='drum'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   38.98540   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   38.98540   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   38.98540   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   38.98540   0.0     com='np277_4'
 cylinder  16 1   11.074400   38.98540   0.0     com='kaolite liner'
 cylinder  12 1   23.177500   38.98540   0.0     com='kaolite'
 cylinder  19 1   23.329900   38.98540   0.0     com='drum'
 cuboid    21 1 4p24.587200   38.98540   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   23.177500    0.22860   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.22860   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   23.177500    1.27000   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.27000   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
```

```
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   23.177500    2.92100   0.0     com='kaolite'
 cylinder  19 1   23.329900    2.92100   0.0     com='drum'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   23.177500    1.01600   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.01600   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   23.177500    8.17880   0.0     com='kaolite'
 cylinder  19 1   23.329900    8.17880   0.0     com='drum'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   23.177500    4.44500   0.0     com='kaolite'
 cylinder  19 1   23.329900    4.44500   0.0     com='drum'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   23.177500    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   23.329900    0.63500   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  21 1   22.961600    1.90500   0.15240 com='void above lid'
 cylinder  19 1   23.114000    1.90500   0.0     com='drum lid'
 cylinder  21 1   23.177500    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   23.329900    1.90500   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
```

```
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.28 Case nciatriga_1_15_3

```
=csas25    parm=size=3000000
nciatriga 0.0in thk np,10400.0gUZrHx(  921.0g235, 8998.2gH2O hx=255.01),fr=1.0e-04
238groupndf5 infhommedium
'TRIGA volume =1200.95996, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=18.2, CV void volume 9014.40198'
arbmtriga  8.65974  4 0 0 0    1001    0.9554
                              40000   54.0446
                              92235    8.8558
                              92238   36.1442    1  1.0     293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                          8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                          9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                         10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
```

```
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'nct array densities are s.u.dens. multiplied by volume ratio 1.34888/1.10336'
arbmh2ok   0.63931  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.42622  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.42622  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.42622  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.42622  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.42622  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.42622  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.42622  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
```

```
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                           16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                           17  1.06388 293  end
'steel: angle iron (ai) for single units'
'ss304                                           18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
ss304                                           18  1.25705 293  end
'steel: drum steel for single units'
'ss304                                           19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
ss304                                           19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
arbmwed    1.16026  2 0 0 0    1001   11.1913
                               8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                               8016   88.8087   21  1.0     293  end
end comp
nciatriga 0.0in thk np,10400.0gUZrHx(  921.0g235, 8998.2gH2O,hx=255.01),fr=1.0e-04
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                    end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.111 in. at top of unit]'
'cylinder  19 1   22.866096    0.28150   0.0     com='extended radius not used'
 cylinder  19 1   21.722275    0.28150   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p22.866096    0.28150   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.676 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.555075   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.722275   11.59510   0.0     com='drum'
 cuboid    20 1 4p22.866096   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.926 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   21.555075    0.63500   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1004
'UZrHx fuel element'
```

```
 cylinder  1  1    1.828800   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.926 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800   12.70050  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200   12.70050  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000   12.70050  -0.0005  com='np277_4'
 cylinder  16 1   11.074400   12.70050  -0.0005  com='kaolite liner'
 cylinder  12 1   21.555075   12.70050  -0.0005  com='kaolite'
 cylinder  19 1   21.722275   12.70050  -0.0005  com='drum'
 cuboid    20 1 4p22.866096   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.926 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   21.555075    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   21.722275    0.00020  -0.0001  com='drum'
 cuboid    20 1 4p22.866096    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.276 in.]'
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   38.98540   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   38.98540   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   38.98540   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   38.98540   0.0     com='np277_4'
 cylinder  16 1   11.074400   38.98540   0.0     com='kaolite liner'
 cylinder  12 1   21.555075   38.98540   0.0     com='kaolite'
 cylinder  19 1   21.722275   38.98540   0.0     com='drum'
 cuboid    20 1 4p22.866096   38.98540   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.336 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.426 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.555075    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.22860   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.22860   0.0     com='drum chine outer radius'
```

```
unit 1012
'cv flange to top of cv well [Elev=35.926 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.27000   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.076 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.555075    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.722275    2.92100   0.0     com='drum'
 cuboid    20 1 4p22.866096    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.476 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.01600   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.536 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.756 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.555075    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.722275    8.17880   0.0     com='drum'
 cuboid    20 1 4p22.866096    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.506 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.555075    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.722275    4.44500   0.0     com='drum'
 cuboid    20 1 4p22.866096    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.756 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
```

```
 cylinder  18 1   21.555075    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.512 in.]'
 cylinder  20 1   21.330090    1.91973   0.16720 com='void above lid'
 cylinder  19 1   21.497290    1.91973   0.0     com='drum lid'
 cylinder  20 1   21.555075    1.91973   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.722275    1.91973   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.91973   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.512 in.]'
array 3         2r-22.866096     0.0
'cuboid     0  1 4p24.587200    110.4900  0.0    com='bare package'
'cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
 cuboid    20  1 4p22.866096    110.5197  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.29 Case atdmr_7_8

```
=csas25    parm=size=300000
atdmr,[ 7000.0U, 7000.0U235,500.0CH2]g htox= 2.40,Rc= 6.02382cm
238groupndf5 multiregion
'U= 7000.0g, poly=500.0g, content hx=2.40'
'core htox= 2.40'
uranium  1 den=18.81109 0.4064 293  92235  100.00
                                    92238   0.000                end
arbmpoly   0.92000   2 0 0 0   1001   14.3798
                               6012   85.6202    1  0.5936  293  end
'flooded containment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv    0.9982   2 0 0 0   1001   11.1913
                               8016   88.8087    2  1.0     293  end
'steel: cv, drum liner, plug liner, angle iron, drum'
ss304                                          3  1.0     293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                               8016   88.8087    4  0.0287  293  end
```

```
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                               8016   47.0610    4  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                               8016   53.2430    4  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                               8016   30.0460    4  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                               8016   40.0465    4  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                               8016   28.5185    4  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                               8016   39.6831    4  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                               8016   25.8039    4  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087    5  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610    5  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430    5  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460    5  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465    5  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185    5  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831    5  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039    5  0.020   293  end
'kaolite 1600 combined'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.191224*0.51655,  for rest = 1.191224*0.34438'
'den.mult= 1.48716e5 cm3 (actual vol.) / 1.24843e5 cm3 (model vol.)'
'actual body vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'actual plug vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
'total Kaolite volume=1.48716e5 cm3 =  1.36557e5 + 1.21592e4 cm3'
'model body vol.= 1.12246e5 cm3'
'model plug vol.= 1.25970e4 cm3'
'total model volume=1.24843e5 cm3 =  1.12246e5 + 1.25970e4 cm3'
arbmh2ok   0.61533  2 0 0 0    1001   11.1913
                               8016   88.8087    6  1.0e+00  293  end
arbmal2o3  0.41023  2 0 0 0   13027   52.9390
                               8016   47.0610    6  0.096   293  end
arbmsio2   0.41023  2 0 0 0   14000   46.7570
                               8016   53.2430    6  0.367   293  end
arbmfe2o3  0.41023  2 0 0 0   26000   69.9540
                               8016   30.0460    6  0.067   293  end
arbmtio2   0.41023  2 0 0 0   22000   59.9535
                               8016   40.0465    6  0.012   293  end
arbmcao    0.41023  2 0 0 0   20000   71.4815
                               8016   28.5185    6  0.307   293  end
arbmmgo    0.41023  2 0 0 0   12000   60.3169
                               8016   39.6831    6  0.131   293  end
arbmna2o   0.41023  2 0 0 0   11023   74.1961
                               8016   25.8039    6  0.020   293  end
```

```
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    7  1.0000  293  end
end comp
spherical end
1   6.02382
7  26.02382
end zone
atdmr,[ 7000.0U, 7000.0U235,500.0CH2]g htox= 2.40 Rc= 6.02382cm
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
'Mass of fm in core region   = 7000.00000 g'
'Mass of poly in core region =  500.00000 g'
'Mass of core region         = 7500.00000 g'
'Vol of fm                   =  372.12095 cm3'
'Vol of poly                 =  543.47826 cm3'
'Volume of core region       =  915.59921 cm3'
'Calculate HTOX ratio for use of 500.0 grams can pads,vinyl tape, polyethylene in CV'
'hydrogen to fissile uranium ratio  =   2.3957'
read geometry
global
unit 1001
'uranium metal/poly dry core with 20.0 cm water reflection'
sphere  1  1   6.02382  com='uranium metal/poly core'
sphere  7  1  26.02382  com='20.0 cm water reflector'
end geometry
end data
end
```

6.9.7.30 Case atdmsr_7_8_11

```
=csas25    parm=size=300000
atdmsr,[ 7000.0U, 7000.0U235,500.0CH2]g htox= 2.40,Rc= 6.02382cm, 33066.6gSS,Rs=10.6643cm
238groupndf5 multiregion
'U= 7000.0g, poly=500.0g, content hx=2.40'
'core htox= 2.40'
uranium  1 den=18.81109 0.4064 293  92235  100.00
                                    92238   0.000               end
arbmpoly   0.92000   2 0 0 0   1001   14.3798
                              6012   85.6202    1  0.5936  293  end
'flooded containment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv    0.9982   2 0 0 0   1001   11.1913
                              8016   88.8087    2  1.0     293  end
'steel: cv, drum liner, plug liner, angle iron, drum'
ss304                                         3  1.0     293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                              8016   88.8087    4  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                              8016   47.0610    4  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                              8016   53.2430    4  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                              8016   30.0460    4  0.067   293  end
```

```
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                              8016   40.0465    4  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                              8016   28.5185    4  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                              8016   39.6831    4  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                              8016   25.8039    4  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087    5  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610    5  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430    5  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460    5  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465    5  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185    5  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831    5  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039    5  0.020   293  end
'kaolite 1600 combined'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.191224*0.51655,  for rest = 1.191224*0.34438'
'den.mult= 1.48716e5 cm3 (actual vol.) / 1.24843e5 cm3 (model vol.)'
'actual body vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'actual plug vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
'total Kaolite volume=1.48716e5 cm3 =  1.36557e5 + 1.21592e4 cm3'
'model body vol.= 1.12246e5 cm3'
'model plug vol.= 1.25970e4 cm3'
'total model volume=1.24843e5 cm3 =  1.12246e5 + 1.25970e4 cm3'
arbmh2ok   0.61533  2 0 0 0    1001   11.1913
                              8016   88.8087    6  1.0e+00  293  end
arbmal2o3  0.41023  2 0 0 0   13027   52.9390
                              8016   47.0610    6  0.096   293  end
arbmsio2   0.41023  2 0 0 0   14000   46.7570
                              8016   53.2430    6  0.367   293  end
arbmfe2o3  0.41023  2 0 0 0   26000   69.9540
                              8016   30.0460    6  0.067   293  end
arbmtio2   0.41023  2 0 0 0   22000   59.9535
                              8016   40.0465    6  0.012   293  end
arbmcao    0.41023  2 0 0 0   20000   71.4815
                              8016   28.5185    6  0.307   293  end
arbmmgo    0.41023  2 0 0 0   12000   60.3169
                              8016   39.6831    6  0.131   293  end
arbmna2o   0.41023  2 0 0 0   11023   74.1961
                              8016   25.8039    6  0.020   293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    7  1.0000  293  end
end comp
spherical end
1   6.02382
```

```
3  10.66433
7  30.66433
end zone
atdmsr,[ 7000.0U, 7000.0U235,500.0CH2]g htox= 2.40 Rc= 6.02382cm, 33066.6gSS,Rs=10.6643cm
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
'Mass of fm in core region   = 7000.00000 g'
'Mass of poly in core region =  500.00000 g'
'Mass of core region         = 7500.00000 g'
'Vol of fm                   =  372.12095 cm3'
'Vol of poly                 =  543.47826 cm3'
'Volume of core region       =  915.59921 cm3'
'Calculate HTOX ratio for use of 500.0 grams can pads,vinyl tape, polyethylene in CV'
'hydrogen to fissile uranium ratio  =   2.3957'
' '
'Mass of steel is derived from the mass of the steel in the CV,'
'steel liner, plug liner, angle iron and drum.  The mass of each'
'was taken directly from Case hciabmt12_36_1_8_1_in.output'
'Model volume taken as stainless steel mass divided by ss density'
'total mass of ss304=  66133.15000'
'total volume of ss304= 8329.1'
'maximum ss304 radius = 13.01972'
read geometry
global
unit 1001
'uranium metal/poly dry core, ss304 shell, 20.0 cm h2o reflector'
'increase ss304 shell by equal volume increments'
'8.32911e+02  cm3  volume of increment'
'5080.155 cm3               accumulative volume of core and ss304'
'10.66433 cm                accumulative radius of ss304 shell'
'3.30666e+04  g             accumulative mass of ss304 shell'
sphere  1  1   6.02382  com='uranium metal/poly core'
sphere  3  1  10.66433  com='ss304 shell around core'
sphere  7  1  30.66433  com='20cm h2o reflector around ss304 shell'
end geometry
end data
end
```

6.9.7.31 Case atdmdkr_7_8_6

```
=csas25    parm=size=300000
atdmdkr,[ 7000.0U, 7000.0U235,500.0CH2]g htox= 2.40,Rc= 6.02382cm, 53419.1gKao,Rk=31.0802cm
238groupndf5 multiregion
'U= 7000.0g, poly=500.0g, content hx=2.40'
'core htox= 2.40'
uranium  1 den=18.81109 0.4064 293  92235  100.00
                                    92238   0.000               end
arbmpoly   0.92000   2 0 0 0   1001   14.3798
                               6012   85.6202    1  0.5936  293  end
'flooded containment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv    0.9982   2 0 0 0   1001   11.1913
                               8016   88.8087    2  1.0     293  end
'steel: cv, drum liner, plug liner, angle iron, drum'
ss304                                          3  1.0     293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
```

```
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                               8016   88.8087    4  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                               8016   47.0610    4  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                               8016   53.2430    4  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                               8016   30.0460    4  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                               8016   40.0465    4  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                               8016   28.5185    4  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                               8016   39.6831    4  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                               8016   25.8039    4  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087    5  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610    5  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430    5  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460    5  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465    5  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185    5  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831    5  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039    5  0.020   293  end
'kaolite 1600 combined'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.191224*0.51655,  for rest = 1.191224*0.34438'
'den.mult= 1.48716e5 cm3 (actual vol.) / 1.24843e5 cm3 (model vol.)'
'actual body vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'actual plug vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
'total Kaolite volume=1.48716e5 cm3 =  1.36557e5 + 1.21592e4 cm3'
'model body vol.= 1.12246e5 cm3'
'model plug vol.= 1.25970e4 cm3'
'total model volume=1.24843e5 cm3 =  1.12246e5 + 1.25970e4 cm3'
'grams water in 15lb free h2o-Kaolite = 9008.5737 = 6803.85 + 2204.7237 g'
'density of water in 15lb free h2o-Kaolite = 0.07216 g/cm3 = 9008.5737/1.24843e5'
'grams water in baked-dry Kaolite = 2204.7237 g'
'density of water in baked-dry Kaolite = 0.01766 = 2204.7237/1.24843e5'
'VF for water in baked-dry Kaolite = 0.244736 = 2204.7237/9008.5737'
arbmh2ok   0.07216  2 0 0 0    1001   11.1913
                               8016   88.8087    6 0.244736 293  end
arbmal2o3  0.41023  2 0 0 0   13027   52.9390
                               8016   47.0610    6  0.096   293  end
arbmsio2   0.41023  2 0 0 0   14000   46.7570
                               8016   53.2430    6  0.367   293  end
arbmfe2o3  0.41023  2 0 0 0   26000   69.9540
                               8016   30.0460    6  0.067   293  end
```

```
arbmtio2   0.41023  2 0 0 0   22000   59.9535
                              8016   40.0465    6  0.012   293  end
arbmcao    0.41023  2 0 0 0   20000   71.4815
                              8016   28.5185    6  0.307   293  end
arbmmgo    0.41023  2 0 0 0   12000   60.3169
                              8016   39.6831    6  0.131   293  end
arbmna2o   0.41023  2 0 0 0   11023   74.1961
                              8016   25.8039    6  0.020   293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    7  1.0000  293  end
end comp
spherical end
1   6.02382
6  31.08024
7  51.08024
end zone
atdmdkr,[ 7000.0U, 7000.0U235,500.0CH2]g htox= 2.40 Rc= 6.02382cm, 53419.1gKao,Rk=31.0802cm
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
'Mass of fm in core region   = 7000.00000 g'
'Mass of poly in core region =  500.00000 g'
'Mass of core region         = 7500.00000 g'
'Vol of fm                   =  372.12095 cm3'
'Vol of poly                 =  543.47826 cm3'
'Volume of core region       =  915.59921 cm3'
'Calculate HTOX ratio for use of 500.0 grams can pads,vinyl tape, polyethylene in CV'
'hydrogen to fissile uranium ratio  =   2.3957'
read geometry
global
unit 1001
'uranium metal/poly dry core, 15lb free h2o-kaolite shell, 20.0 cm water reflection'
'maximum kaolite radius =  31.08014 cm'
'increase kaolite shell by equal volume increments'
'2.49686e+04  cm3 volume of increment'
'125758.5 cm3 accumulative volume of core and kaolite'
'31.08024 cm accumulative radius of kaolite shell'
'5.34191e+04  g accumulative mass of kaolite shell'
sphere  1  1   6.02382  com='uranium metal/poly core'
sphere  6  1  31.08024  com='dry-kaolite shell around core'
sphere  7  1  51.08024  com='20cm h2o reflector around kaolite shell'
end geometry
end data
end
```

6.9.7.32 Case atdzr

```
=csas25    parm=size=300000
atdzr,[10400.UZrHx, 921.0U235,500.0CH2]g htox=43.37,Rc= 7.46774cm
238groupndf5 multiregion
'UZrHx=10400.0g, poly=500.0g, content hx=18.2'
'core htox=43.37'
arbmtriga  8.65974  4 0 0 0    1001    0.9554
                              40000   54.0446
                              92235    8.8558
                              92238   36.1442    1  0.6885 293  end
arbmpoly   0.92000   2 0 0 0   1001   14.3798
                               6012   85.6202    1  0.3115  293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    7  1.0000  293  end
end comp
```

```
spherical end
1   7.46774
7  27.46774
end zone
atdzr,[10400.UZrHx, 921.0U235,500.0CH2]g htox=43.37 Rc= 7.46774cm
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
'Mass of fm in core region   = 10400.0010 g'
'Mass of poly in core region =  500.00000 g'
'Mass of core region         = 10900.0010 g'
'Vol of fm                   = 1200.95996 cm3'
'Vol of poly                 =  543.47826 cm3'
'Volume of core region       = 1744.43822 cm3'
'Calculate HTOX ratio for use of 500.0 grams can pads,vinyl tape, polyethylene in CV'
'hydrogen to fissile uranium ratio  =  43.3700'
read geometry
global
unit 1001
'fissile material dry core with 20.0 cm water reflection'
sphere  1  1   7.46774  com='HEU core'
sphere  7  1  27.46774  com='20.0 cm water reflector'
end geometry
end data
end
```

6.9.7.33 Case athzp15kr_5

```
=csas25    parm=size=300000
athzp15kr,[10400.UZrHx, 921.0U235,500.0CH2,9008.5H2O]g htox=298.6,Rc=31.14838cm
238groupndf5 multiregion
'UZrHx=10400.0g poly=500.0g cont.hx=18.2, H2O in Kaolite=  9008.5g, homgcore hx=298.6'
arbmtriga  8.65974  4 0 0 0    1001    0.9554
                              40000   54.0446
                              92235    8.8558
                              92238   36.1442    1  0.0095 293  end
arbmpoly   0.92000   2 0 0 0   1001   14.3798
                               6012   85.6202    1  0.0043  293  end
arbmh2ok   0.07216   2 0 0 0    1001   11.1913
                               8016   88.8087    1  9.8620e-01    293  end
arbmal2o3  0.40458   2 0 0 0   13027   52.9390
                               8016   47.0610    1  0.096   293  end
arbmsio2   0.40458   2 0 0 0   14000   46.7570
                               8016   53.2430    1  0.367   293  end
arbmfe2o3  0.40458   2 0 0 0   26000   69.9540
                               8016   30.0460    1  0.067   293  end
arbmtio2   0.40458   2 0 0 0   22000   59.9535
                               8016   40.0465    1  0.012   293  end
arbmcao    0.40458   2 0 0 0   20000   71.4815
                               8016   28.5185    1  0.307   293  end
arbmmgo    0.40458   2 0 0 0   12000   60.3169
                               8016   39.6831    1  0.131   293  end
arbmna2o   0.40458   2 0 0 0   11023   74.1961
                               8016   25.8039    1  0.020   293  end
'flooded containment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    2  1.0     293  end
'steel: cv body, lower flange, upper flange, drum liner'
ss304                                          3  1.0     293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
```

```
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                               8016   88.8087    4  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                               8016   47.0610    4  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                               8016   53.2430    4  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                               8016   30.0460    4  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                               8016   40.0465    4  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                               8016   28.5185    4  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                               8016   39.6831    4  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                               8016   25.8039    4  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087    5  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610    5  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430    5  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460    5  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465    5  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185    5  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831    5  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039    5  0.020   293  end
'kaolite 1600 combined'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.191224*0.51655,  for rest = 1.191224*0.34438'
'den.mult= 1.48716e5 cm3 (actual vol.) / 1.24843e5 cm3 (model vol.)'
'actual body vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'actual plug vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
'total Kaolite volume=1.48716e5 cm3 =  1.36557e5 + 1.21592e4 cm3'
'model body vol.= 1.12246e5 cm3'
'model plug vol.= 1.25970e4 cm3'
'total model volume=1.24843e5 cm3 =  1.12246e5 + 1.25970e4 cm3'
'grams water in 15lb free h2o-Kaolite = 9008.5737 = 6803.85 + 2204.7237 g'
'density of water in 15lb free h2o-Kaolite = 0.07216 g/cm3 = 9008.5737/1.24843e5'
'grams water in baked-dry Kaolite = 2204.7237 g'
'density of water in baked-dry Kaolite = 0.01766 = 2204.7237/1.24843e5'
'VF for water in baked-dry Kaolite = 0.244736 = 2204.7237/9008.5737'
arbmh2ok   0.07216  2 0 0 0    1001   11.1913
                               8016   88.8087    6  1.0e+00  293  end
arbmal2o3  0.41023  2 0 0 0   13027   52.9390
                               8016   47.0610    6  0.096   293  end
```

```
arbmsio2   0.41023  2 0 0 0   14000   46.7570
                              8016   53.2430    6  0.367   293  end
arbmfe2o3  0.41023  2 0 0 0   26000   69.9540
                              8016   30.0460    6  0.067   293  end
arbmtio2   0.41023  2 0 0 0   22000   59.9535
                              8016   40.0465    6  0.012   293  end
arbmcao    0.41023  2 0 0 0   20000   71.4815
                              8016   28.5185    6  0.307   293  end
arbmmgo    0.41023  2 0 0 0   12000   60.3169
                              8016   39.6831    6  0.131   293  end
arbmna2o   0.41023  2 0 0 0   11023   74.1961
                              8016   25.8039    6  0.020   293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    7  1.0000  293  end
end comp
spherical end
1  31.14838
7  51.14838
end zone
athzp15kr,[10400.UZrHx, 921.0U235,500.0CH2,9008.5H2O]g htox=298.6 Rc=31.14838cm
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
'Maximum mass of water from Kaolite = 9008.546 g'
'                             CHECK=> 9008.671 g'
'Minimum mass of water from Kaolite = 2204.715 g'
'                             CHECK=> 2204.746 g'
'Mass of kao from Kaolite = 51214.88 g'
'                             CHECK=> 51214.34 g'
' '
'Calculate the mass of water contained in the homogenized region'
'Mass of homogenized fm             = 10400.0010 g'
'Mass of poly in homogenized region =  500.00000 g'
'Mass of h2o in homogenized region  = 9008.54567 g'
'Mass of kao in homogenized region  = 51214.8849 g'
'Mass of homogenized region         = 71123.4316 g'
'Vol of homogenized fm              = 1200.95996 cm3'
'Vol of poly                        =  543.47826 cm3'
'Vol of h2o                         = 124841.264 cm3'
'Vol of kao                         = 124844.318 cm3'
'Volume of homogenized region       = 126588.757 cm3'
'Calculate HTOX ratio for use of 500.0 grams can pads,vinyl tape, polyethylene in CV'
'hydrogen to fissile uranium ratio  = 298.6696'
read geometry
global
unit 1001
'homogenized UZrHx/poly/15lb free h2o-Kaolite, 20.0 cm refl'
sphere  1  1  31.14838  com='HEU core/water mixture'
sphere  7  1  51.14838  com='20.0 cm water reflector'
end geometry
end data
end
```

6.9.7.34 Case athzpw15kr_5

```
=csas25    parm=size=300000
athzpw15kr,[10400.UZrHx, 921.0U235,500.0CH2,6803.8H2O]g
htox=236.1,Rc=12.69027cm,53419.6,Rs=31.69769cm
238groupndf5 multiregion
'UZrHx=10400.0g poly=500.0g cont.hx=18.2, H2O in Kaolite=  6803.8g, homgcore hx=236.1'
arbmtriga  8.65974  4 0 0 0    1001    0.9554
                              40000   54.0446
```

```
                              92235    8.8558
                              92238   36.1442    1  0.1403 293  end
arbmpoly   0.92000   2 0 0 0   1001   14.3798
                              6012   85.6202    1  0.0635  293  end
arbmkh2o   0.9982    2 0 0 0   1001   11.1913
                              8016   88.8087    1  7.9622e-01    293  end
'kaolite 1600 shell'
arbmh2ok 1.7660e-02  2 0 0 0   1001   11.1913
                              8016   88.8087    2  1.000   293  end
arbmal2o3  0.41023   2 0 0 0   13027   52.9390
                              8016   47.0610    2  0.096   293  end
arbmsio2   0.41023   2 0 0 0   14000   46.7570
                              8016   53.2430    2  0.367   293  end
arbmfe2o3  0.41023   2 0 0 0   26000   69.9540
                              8016   30.0460    2  0.067   293  end
arbmtio2   0.41023   2 0 0 0   22000   59.9535
                              8016   40.0465    2  0.012   293  end
arbmcao    0.41023   2 0 0 0   20000   71.4815
                              8016   28.5185    2  0.307   293  end
arbmmgo    0.41023   2 0 0 0   12000   60.3169
                              8016   39.6831    2  0.131   293  end
arbmna2o   0.41023   2 0 0 0   11023   74.1961
                              8016   25.8039    2  0.020   293  end
'flooded containment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    3  1.0     293  end
'steel: cv body, lower flange, upper flange, drum liner'
ss304                                          4  1.0     293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                              8016   88.8087    5  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                              8016   47.0610    5  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                              8016   53.2430    5  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                              8016   30.0460    5  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                              8016   40.0465    5  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                              8016   28.5185    5  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                              8016   39.6831    5  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                              8016   25.8039    5  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087    6  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
```

```
                              8016   47.0610    6  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430    6  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460    6  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465    6  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185    6  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831    6  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039    6  0.020   293  end
'kaolite 1600 combined'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.191224*0.51655,  for rest = 1.191224*0.34438'
'den.mult= 1.48716e5 cm3 (actual vol.) / 1.24843e5 cm3 (model vol.)'
'actual body vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'actual plug vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
'total Kaolite volume=1.48716e5 cm3 =  1.36557e5 + 1.21592e4 cm3'
'model body vol.= 1.12246e5 cm3'
'model plug vol.= 1.25970e4 cm3'
'total model volume=1.24843e5 cm3 =  1.12246e5 + 1.25970e4 cm3'
'grams water in wet-Kaolite = 9008.5737 = 6803.85 + 2204.7237 g'
'density of water in wet-Kaolite = 0.07216 g/cm3 = 9008.5737/1.24843e5'
'grams water in baked-dry Kaolite = 2204.7237 g'
'density of water in baked-dry Kaolite = 0.01766 = 2204.7237/1.24843e5'
'VF for water in baked-dry Kaolite = 0.244736 = 2204.7237/9008.5737'
arbmh2ok   0.07216  2 0 0 0    1001   11.1913
                              8016   88.8087    7  1.000   293  end
arbmal2o3  0.41023  2 0 0 0   13027   52.9390
                              8016   47.0610    7  0.096   293  end
arbmsio2   0.41023  2 0 0 0   14000   46.7570
                              8016   53.2430    7  0.367   293  end
arbmfe2o3  0.41023  2 0 0 0   26000   69.9540
                              8016   30.0460    7  0.067   293  end
arbmtio2   0.41023  2 0 0 0   22000   59.9535
                              8016   40.0465    7  0.012   293  end
arbmcao    0.41023  2 0 0 0   20000   71.4815
                              8016   28.5185    7  0.307   293  end
arbmmgo    0.41023  2 0 0 0   12000   60.3169
                              8016   39.6831    7  0.131   293  end
arbmna2o   0.41023  2 0 0 0   11023   74.1961
                              8016   25.8039    7  0.020   293  end
'reflective water'
arbmh2or   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    8  1.0000  293  end
end comp
spherical end
1  12.69027
2  31.69769
8  51.69769
end zone
athzpw15kr,[10400.UZrHx, 921.0U235,500.0CH2,6803.8H2O]g htox=236.1
Rc=12.69027cm,53419.6,Rs=31.69769cm
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
'Maximum mass of water from Kaolite = 9008.546 g'
'                            CHECK=> 9008.671 g'
'Minimum mass of water from Kaolite = 2204.715 g'
'                            CHECK=> 2204.746 g'
'Mass of kao from Kaolite = 51214.88 g'
```

```
'                            CHECK=> 51214.34 g'
' '
'Calculate the mass of water contained in the homogenized region'
'Mass of homogenized fm             = 10400.0010 g'
'Mass of poly in homogenized region =  500.00000 g'
'Mass of h2o in homogenized region  = 6803.83024 g'
'Mass of homogenized region         = 17703.8312 g'
'Vol of homogenized fm              = 1200.95996 cm3'
'Vol of poly                        =  543.47826 cm3'
'Vol of h2o                         = 6816.09922 cm3'
'Volume of homogenized region       = 8560.53744 cm3'
'Calculate HTOX ratio for use of 500.0 grams can pads,vinyl tape, polyethylene in CV'
'hydrogen to fissile uranium ratio  = 236.1886'
' '
'Mass of h2o in shell region        = 2204.71543 g'
'Mass of kao in shell region        = 51214.8849 g'
'Mass of kaolite in shell           = 53419.6003 g'
'Volume of kaolite in shell region  = 124843.000 cm3'
read geometry
global
unit 1001
'homogenized UZrHx/poly/excess water, wet-Kaolite shell, 20.0 cm refl'
sphere  1  1  12.69027  com='HEU core/water mixture'
sphere  2  1  31.69769  com='radius of kaolite shell'
sphere  8  1  51.69769  com='20.0 cm water reflector'
end geometry
end data
end
```

6.9.7.35 Case athmp15kr_12_8_5

```
=csas25    parm=size=300000
athmp15kr,[ 7000.0U, 7000.0U235,500.0CH2,9008.5H2O]g htox=35.99,Rc=31.08025cm
238groupndf5 multiregion
'U= 7000.0g poly=500.0g cont.hx=2.40, H2O in Kaolite=  9008.5g, core hx=35.99'
uranium  1 den=18.81109 2.9590e-03   293   92235  100.00
                                           92238    0.000               end
arbmpoly   0.92000   2 0 0 0    1001   14.3798
                                6012   85.6202    1  4.3216e-03    293  end
arbmh2ok   0.07216   2 0 0 0    1001   11.1913
                                8016   88.8087    1  9.9270e-01    293  end
arbmal2o3  0.40724   2 0 0 0   13027   52.9390
                                8016   47.0610    1  0.096   293  end
arbmsio2   0.40724   2 0 0 0   14000   46.7570
                                8016   53.2430    1  0.367   293  end
arbmfe2o3  0.40724   2 0 0 0   26000   69.9540
                                8016   30.0460    1  0.067   293  end
arbmtio2   0.40724   2 0 0 0   22000   59.9535
                                8016   40.0465    1  0.012   293  end
arbmcao    0.40724   2 0 0 0   20000   71.4815
                                8016   28.5185    1  0.307   293  end
arbmmgo    0.40724   2 0 0 0   12000   60.3169
                                8016   39.6831    1  0.131   293  end
arbmna2o   0.40724   2 0 0 0   11023   74.1961
                                8016   25.8039    1  0.020   293  end
'flooded containment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    2  1.0     293  end
'steel: cv body, lower flange, upper flange, drum liner'
ss304                                          3  1.0     293  end
'kaolite 1600 body'
```

```
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                               8016   88.8087    4  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                               8016   47.0610    4  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                               8016   53.2430    4  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                               8016   30.0460    4  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                               8016   40.0465    4  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                               8016   28.5185    4  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                               8016   39.6831    4  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                               8016   25.8039    4  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087    5  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610    5  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430    5  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460    5  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465    5  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185    5  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831    5  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039    5  0.020   293  end
'kaolite 1600 combined'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.191224*0.51655,  for rest = 1.191224*0.34438'
'den.mult= 1.48716e5 cm3 (actual vol.) / 1.24843e5 cm3 (model vol.)'
'actual body vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'actual plug vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
'total Kaolite volume=1.48716e5 cm3 =  1.36557e5 + 1.21592e4 cm3'
'model body vol.= 1.12246e5 cm3'
'model plug vol.= 1.25970e4 cm3'
'total model volume=1.24843e5 cm3 =  1.12246e5 + 1.25970e4 cm3'
'grams water in 15lb free h2o-Kaolite = 9008.5737 = 6803.85 + 2204.7237 g'
'density of water in 15lb free h2o-Kaolite = 0.07216 g/cm3 = 9008.5737/1.24843e5'
'grams water in baked-dry Kaolite = 2204.7237 g'
'density of water in baked-dry Kaolite = 0.01766 = 2204.7237/1.24843e5'
'VF for water in baked-dry Kaolite = 0.244736 = 2204.7237/9008.5737'
arbmh2ok   0.07216  2 0 0 0    1001   11.1913
```

```
                                8016   88.8087    6  1.0e+00  293  end
arbmal2o3  0.41023  2 0 0 0   13027   52.9390
                                8016   47.0610    6  0.096   293  end
arbmsio2   0.41023  2 0 0 0   14000   46.7570
                                8016   53.2430    6  0.367   293  end
arbmfe2o3  0.41023  2 0 0 0   26000   69.9540
                                8016   30.0460    6  0.067   293  end
arbmtio2   0.41023  2 0 0 0   22000   59.9535
                                8016   40.0465    6  0.012   293  end
arbmcao    0.41023  2 0 0 0   20000   71.4815
                                8016   28.5185    6  0.307   293  end
arbmmgo    0.41023  2 0 0 0   12000   60.3169
                                8016   39.6831    6  0.131   293  end
arbmna2o   0.41023  2 0 0 0   11023   74.1961
                                8016   25.8039    6  0.020   293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                                8016   88.8087    7  1.0000  293  end
end comp
spherical end
1  31.08025
7  51.08025
end zone
athmp15kr,[ 7000.0U, 7000.0U235,500.0CH2,9008.5H2O]g htox=35.99 Rc=31.08025cm
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
'Maximum mass of water from Kaolite = 9008.546 g'
'                           CHECK=> 9008.671 g'
'Minimum mass of water from Kaolite = 2204.715 g'
'                           CHECK=> 2204.746 g'
'Mass of kao from Kaolite = 51214.88 g'
'                           CHECK=> 51214.34 g'
' '
'Calculate the mass of water contained in the homogenized region'
'Mass of homogenized fm             = 7000.00000 g'
'Mass of poly in homogenized region =  500.00000 g'
'Mass of h2o in homogenized region  = 9008.54567 g'
'Mass of kao in homogenized region  = 51214.8849 g'
'Mass of homogenized region         = 67723.4306 g'
'Vol of homogenized fm              =  372.12095 cm3'
'Vol of poly                        =  543.47826 cm3'
'Vol of h2o                         = 124841.264 cm3'
'Vol of kao                         = 124844.318 cm3'
'Volume of homogenized region       = 125759.918 cm3'
'Calculate HTOX ratio for use of 500.0 grams can pads,vinyl tape, polyethylene in CV'
'hydrogen to fissile uranium ratio  =  35.9859'
read geometry
global
unit 1001
'homogenized uranium/poly/15lb free h2o-Kaolite, 20.0 cm refl'
sphere  1  1  31.08025  com='HEU core/water mixture'
sphere  7  1  51.08025  com='20.0 cm water reflector'
end geometry
end data
end
```

6.9.7.36 Case athmpw15kr_12_8_5

```
=csas25    parm=size=300000
athmpw15kr,[ 7000.0U, 7000.0U235,500.0CH2,6803.8H2O]g
htox=27.77,Rc=12.26673cm,53419.6,Rs=31.63191cm
238groupndf5 multiregion
```

```
'U= 7000.0g poly=500.0g cont.hx=2.40, H2O in Kaolite=  6803.8g, core hx=27.77'
uranium  1 den=18.81109 4.8129e-02   293   92235  100.00
                                           92238    0.000              end
arbmpoly   0.92000   2 0 0 0   1001   14.3798
                               6012   85.6202    1  7.0292e-02    293  end
arbmkh2o   0.9982    2 0 0 0   1001   11.1913
                               8016   88.8087    1  8.8158e-01    293  end
'kaolite 1600 shell'
arbmh2ok 1.7660e-02  2 0 0 0   1001   11.1913
                               8016   88.8087    2  1.000   293  end
arbmal2o3  0.41023   2 0 0 0   13027   52.9390
                               8016   47.0610    2  0.096   293  end
arbmsio2   0.41023   2 0 0 0   14000   46.7570
                               8016   53.2430    2  0.367   293  end
arbmfe2o3  0.41023   2 0 0 0   26000   69.9540
                               8016   30.0460    2  0.067   293  end
arbmtio2   0.41023   2 0 0 0   22000   59.9535
                               8016   40.0465    2  0.012   293  end
arbmcao    0.41023   2 0 0 0   20000   71.4815
                               8016   28.5185    2  0.307   293  end
arbmmgo    0.41023   2 0 0 0   12000   60.3169
                               8016   39.6831    2  0.131   293  end
arbmna2o   0.41023   2 0 0 0   11023   74.1961
                               8016   25.8039    2  0.020   293  end
'flooded containment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: cv body, lower flange, upper flange, drum liner'
ss304                                           4  1.0     293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                               8016   88.8087    5  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                               8016   47.0610    5  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                               8016   53.2430    5  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                               8016   30.0460    5  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                               8016   40.0465    5  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                               8016   28.5185    5  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                               8016   39.6831    5  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                               8016   25.8039    5  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087    6  0.0287  293  end
```

```
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610    6  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430    6  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460    6  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465    6  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185    6  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831    6  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039    6  0.020   293  end
'kaolite 1600 combined'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.191224*0.51655,  for rest = 1.191224*0.34438'
'den.mult= 1.48716e5 cm3 (actual vol.) / 1.24843e5 cm3 (model vol.)'
'actual body vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'actual plug vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
'total Kaolite volume=1.48716e5 cm3 =  1.36557e5 + 1.21592e4 cm3'
'model body vol.= 1.12246e5 cm3'
'model plug vol.= 1.25970e4 cm3'
'total model volume=1.24843e5 cm3 =  1.12246e5 + 1.25970e4 cm3'
'grams water in 15lb free h2o-Kaolite = 9008.5737 = 6803.85 + 2204.7237 g'
'density of water in 15lb free h2o-Kaolite = 0.07216 g/cm3 = 9008.5737/1.24843e5'
'grams water in baked-dry Kaolite = 2204.7237 g'
'density of water in baked-dry Kaolite = 0.01766 = 2204.7237/1.24843e5'
'VF for water in baked-dry Kaolite = 0.244736 = 2204.7237/9008.5737'
arbmh2ok   0.07216  2 0 0 0    1001   11.1913
                              8016   88.8087    7  1.000   293  end
arbmal2o3  0.41023  2 0 0 0   13027   52.9390
                              8016   47.0610    7  0.096   293  end
arbmsio2   0.41023  2 0 0 0   14000   46.7570
                              8016   53.2430    7  0.367   293  end
arbmfe2o3  0.41023  2 0 0 0   26000   69.9540
                              8016   30.0460    7  0.067   293  end
arbmtio2   0.41023  2 0 0 0   22000   59.9535
                              8016   40.0465    7  0.012   293  end
arbmcao    0.41023  2 0 0 0   20000   71.4815
                              8016   28.5185    7  0.307   293  end
arbmmgo    0.41023  2 0 0 0   12000   60.3169
                              8016   39.6831    7  0.131   293  end
arbmna2o   0.41023  2 0 0 0   11023   74.1961
                              8016   25.8039    7  0.020   293  end
'reflective water'
arbmh2or   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    8  1.0000  293  end
end comp
spherical end
1  12.26673
2  31.63191
8  51.63191
end zone
athmpw15kr,[ 7000.0U, 7000.0U235,500.0CH2,6803.8H2O]g htox=27.77
Rc=12.26673cm,53419.6,Rs=31.63191cm
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
'Maximum mass of water from Kaolite = 9008.546 g'
'                             CHECK=> 9008.671 g'
'Minimum mass of water from Kaolite = 2204.715 g'
'                             CHECK=> 2204.746 g'
```

```
'Mass of kao from Kaolite = 51214.88 g'
'                           CHECK=> 51214.34 g'
' '
'Calculate the mass of water contained in the homogenized region'
'Mass of homogenized fm             = 7000.00000 g'
'Mass of poly in homogenized region =  500.00000 g'
'Mass of h2o in homogenized region  = 6803.83024 g'
'Mass of homogenized region         = 14303.8302 g'
'Vol of homogenized fm              =  372.12095 cm3'
'Vol of poly                        =  543.47826 cm3'
'Vol of h2o                         = 6816.09922 cm3'
'Volume of homogenized region       = 7731.69843 cm3'
'Calculate HTOX ratio for use of 500.0 grams can pads,vinyl tape, polyethylene in CV'
'hydrogen to fissile uranium ratio  =  27.7652'
' '
'Mass of h2o in shell region        = 2204.71543 g'
'Mass of kao in shell region        = 51214.8849 g'
'Mass of kaolite in shell           = 53419.6003 g'
'Volume of kaolite in shell region  = 124843.000 cm3'
read geometry
global
unit 1001
'homogenized uranium/poly/excess water, 15lb free h2o-Kaolite shell, 20.0 cm refl'
sphere  1  1  12.26673  com='HEU core/water mixture'
sphere  2  1  31.63191  com='radius of kaolite shell'
sphere  8  1  51.63191  com='20.0 cm water reflector'
end geometry
end data
end
```

6.9.7.37 Case athmpw13kr_12_8_5

```
=csas25    parm=size=300000
athmpw13kr,[ 7000.0U, 7000.0U235,500.0CH2,5896.6H2O]g
htox=24.38,Rc=11.76592cm,53419.6,Rs=31.55946cm
238groupndf5 multiregion
'U= 7000.0g poly=500.0g cont.hx=2.40, H2O in Kaolite=  5896.6g, core hx=24.38'
uranium  1 den=18.81109 5.4540e-02   293   92235  100.00
                                           92238    0.000              end
arbmpoly   0.92000   2 0 0 0   1001   14.3798
                               6012   85.6202    1  7.9656e-02    293  end
arbmkh2o   0.9982    2 0 0 0   1001   11.1913
                               8016   88.8087    1  8.6580e-01    293  end
'kaolite 1600 shell'
arbmh2ok 1.7660e-02  2 0 0 0   1001   11.1913
                               8016   88.8087    2  1.000   293  end
arbmal2o3  0.41023   2 0 0 0   13027   52.9390
                               8016   47.0610    2  0.096   293  end
arbmsio2   0.41023   2 0 0 0   14000   46.7570
                               8016   53.2430    2  0.367   293  end
arbmfe2o3  0.41023   2 0 0 0   26000   69.9540
                               8016   30.0460    2  0.067   293  end
arbmtio2   0.41023   2 0 0 0   22000   59.9535
                               8016   40.0465    2  0.012   293  end
arbmcao    0.41023   2 0 0 0   20000   71.4815
                               8016   28.5185    2  0.307   293  end
arbmmgo    0.41023   2 0 0 0   12000   60.3169
                               8016   39.6831    2  0.131   293  end
arbmna2o   0.41023   2 0 0 0   11023   74.1961
                               8016   25.8039    2  0.020   293  end
'flooded containment vessel and content cans -- 10 CFR 71.55(d)(3)'
```

```
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: cv body, lower flange, upper flange, drum liner'
ss304                                           4  1.0     293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                               8016   88.8087    5  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                               8016   47.0610    5  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                               8016   53.2430    5  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                               8016   30.0460    5  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                               8016   40.0465    5  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                               8016   28.5185    5  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                               8016   39.6831    5  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                               8016   25.8039    5  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087    6  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610    6  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430    6  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460    6  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465    6  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185    6  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831    6  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039    6  0.020   293  end
'kaolite 1600 combined'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.191224*0.51655,  for rest = 1.191224*0.34438'
'den.mult= 1.48716e5 cm3 (actual vol.) / 1.24843e5 cm3 (model vol.)'
'actual body vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'actual plug vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
'total Kaolite volume=1.48716e5 cm3 =  1.36557e5 + 1.21592e4 cm3'
'model body vol.= 1.12246e5 cm3'
'model plug vol.= 1.25970e4 cm3'
'total model volume=1.24843e5 cm3 =  1.12246e5 + 1.25970e4 cm3'
'grams water in 13lb free h2o-Kaolite = 8101.3937 = 5896.67 + 2204.7237 g'
```

```
'density of water in 13lb free h2o-Kaolite = 0.06489 g/cm3 = 8101.3937/1.24843e5'
'grams water in baked-dry Kaolite = 2204.7237 g'
'density of water in baked-dry Kaolite = 0.01766 = 2204.7237/1.24843e5'
'VF for water in baked-dry Kaolite = 0.272142 = 2204.7237/8101.3937'
arbmh2ok   0.06489  2 0 0 0    1001   11.1913
                               8016   88.8087    7  1.000   293  end
arbmal2o3  0.41023  2 0 0 0   13027   52.9390
                               8016   47.0610    7  0.096   293  end
arbmsio2   0.41023  2 0 0 0   14000   46.7570
                               8016   53.2430    7  0.367   293  end
arbmfe2o3  0.41023  2 0 0 0   26000   69.9540
                               8016   30.0460    7  0.067   293  end
arbmtio2   0.41023  2 0 0 0   22000   59.9535
                               8016   40.0465    7  0.012   293  end
arbmcao    0.41023  2 0 0 0   20000   71.4815
                               8016   28.5185    7  0.307   293  end
arbmmgo    0.41023  2 0 0 0   12000   60.3169
                               8016   39.6831    7  0.131   293  end
arbmna2o   0.41023  2 0 0 0   11023   74.1961
                               8016   25.8039    7  0.020   293  end
'reflective water'
arbmh2or   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    8  1.0000  293  end
end comp
spherical end
1  11.76592
2  31.55946
8  51.55946
end zone
athmpw13kr,[ 7000.0U, 7000.0U235,500.0CH2,5896.6H2O]g htox=24.38
Rc=11.76592cm,53419.6,Rs=31.55946cm
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
'Maximum mass of water from Kaolite = 8101.342 g'
'                           CHECK=> 8101.062 g'
'Minimum mass of water from Kaolite = 2204.715 g'
'                           CHECK=> 2204.639 g'
'Mass of kao from Kaolite = 51214.88 g'
'                           CHECK=> 51214.34 g'
' '
'Calculate the mass of water contained in the homogenized region'
'Mass of homogenized fm             = 7000.00000 g'
'Mass of poly in homogenized region =  500.00000 g'
'Mass of h2o in homogenized region  = 5896.62664 g'
'Mass of homogenized region         = 13396.6266 g'
'Vol of homogenized fm              =  372.12095 cm3'
'Vol of poly                        =  543.47826 cm3'
'Vol of h2o                         = 5907.25971 cm3'
'Volume of homogenized region       = 6822.85892 cm3'
'Calculate HTOX ratio for use of 500.0 grams can pads,vinyl tape, polyethylene in CV'
'hydrogen to fissile uranium ratio  =  24.3825'
' '
'Mass of h2o in shell region        = 2204.71543 g'
'Mass of kao in shell region        = 51214.8849 g'
'Mass of kaolite in shell           = 53419.6003 g'
'Volume of kaolite in shell region  = 124843.000 cm3'
read geometry
global
unit 1001
'homogenized uranium/poly/excess water, 13lb free h2o-Kaolite shell, 20.0 cm refl'
sphere  1  1  11.76592  com='HEU core/water mixture'
sphere  2  1  31.55946  com='radius of kaolite shell'
```

```
sphere  8  1  51.55946  com='20.0 cm water reflector'
end geometry
end data
end
```

6.9.7.38 Case athmp15kmr_7_7_8_5

```
=csas25    parm=size=300000
athmp15kmr, 7.0kgU,[3500.0U235,500.0CH2, 9008.5H2O]g htox=
71.97,Rc=31.06492cm,3500.0U235,Rs=31.08035cm
238groupndf5 multiregion
'dry CV hx=2.40 for  7.0 kilograms HEU metal wrapped content'
'Core  3500.0g235U,500.0g Poly,  9008.5gH2O in Kaolite.  htox=71.97'
uranium  1 den=18.81109 1.4817e-03   293   92235  100.00
                                           92238    0.00                end
arbmpoly   0.92000   2 0 0 0    1001   14.3798
                                6012   85.6202    1  4.3280e-03    293  end
arbmh2ok   0.07216   2 0 0 0    1001   11.1913
                                8016   88.8087    1  9.9417e-01    293  end
arbmal2o3  0.40785   2 0 0 0   13027   52.9390
                                8016   47.0610    1  0.096   293  end
arbmsio2   0.40785   2 0 0 0   14000   46.7570
                                8016   53.2430    1  0.367   293  end
arbmfe2o3  0.40785   2 0 0 0   26000   69.9540
                                8016   30.0460    1  0.067   293  end
arbmtio2   0.40785   2 0 0 0   22000   59.9535
                                8016   40.0465    1  0.012   293  end
arbmcao    0.40785   2 0 0 0   20000   71.4815
                                8016   28.5185    1  0.307   293  end
arbmmgo    0.40785   2 0 0 0   12000   60.3169
                                8016   39.6831    1  0.131   293  end
arbmna2o   0.40785   2 0 0 0   11023   74.1961
                                8016   25.8039    1  0.020   293  end
uranium  2 den=18.81109  1.0   293   92235  100.00
                                      92238    0.00              end
'flooded containment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: cv body, lower flange, upper flange, drum liner'
ss304                                          4  1.0     293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                               8016   88.8087    5  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                               8016   47.0610    5  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                               8016   53.2430    5  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                               8016   30.0460    5  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                               8016   40.0465    5  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                               8016   28.5185    5  0.307   293  end
```

```
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                              8016   39.6831    5  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                              8016   25.8039    5  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087    6  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610    6  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430    6  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460    6  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465    6  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185    6  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831    6  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039    6  0.020   293  end
'kaolite 1600 combined'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.191224*0.51655,  for rest = 1.191224*0.34438'
'den.mult= 1.48716e5 cm3 (actual vol.) / 1.24843e5 cm3 (model vol.)'
'actual body vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'actual plug vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
'total Kaolite volume=1.48716e5 cm3 =  1.36557e5 + 1.21592e4 cm3'
'model body vol.= 1.12246e5 cm3'
'model plug vol.= 1.25970e4 cm3'
'total model volume=1.24843e5 cm3 =  1.12246e5 + 1.25970e4 cm3'
'grams water in 15lb free h2o-Kaolite = 9008.5737 = 6803.85 + 2204.7237 g'
'density of water in 15lb free h2o-Kaolite = 0.07216 g/cm3 = 9008.5737/1.24843e5'
'grams water in baked-dry Kaolite = 2204.7237 g'
'density of water in baked-dry Kaolite = 0.01766 = 2204.7237/1.24843e5'
'VF for water in baked-dry Kaolite = 0.244736 = 2204.7237/9008.5737'
arbmh2ok   0.07216  2 0 0 0    1001   11.1913
                              8016   88.8087    7  0.0287  293  end
arbmal2o3  0.41023  2 0 0 0   13027   52.9390
                              8016   47.0610    7  0.096   293  end
arbmsio2   0.41023  2 0 0 0   14000   46.7570
                              8016   53.2430    7  0.367   293  end
arbmfe2o3  0.41023  2 0 0 0   26000   69.9540
                              8016   30.0460    7  0.067   293  end
arbmtio2   0.41023  2 0 0 0   22000   59.9535
                              8016   40.0465    7  0.012   293  end
arbmcao    0.41023  2 0 0 0   20000   71.4815
                              8016   28.5185    7  0.307   293  end
arbmmgo    0.41023  2 0 0 0   12000   60.3169
                              8016   39.6831    7  0.131   293  end
arbmna2o   0.41023  2 0 0 0   11023   74.1961
                              8016   25.8039    7  0.020   293  end
'reflective water'
arbmh2or   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    8  1.0000  293  end
end comp
spherical end
```

```
1  31.06492
2  31.08035
8  51.08035
end zone
athmp15kmr, 7.0kgU,[3500.0U235,500.0CH2, 9008.5H2O]g htox= 71.97
Rc=31.06492cm,3500.0U235,Rs=31.08035cm
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
'Maximum mass of water from Kaolite = 9008.546 g'
'                           CHECK=> 9008.671 g'
'Minimum mass of water from Kaolite = 2204.715 g'
'                           CHECK=> 2204.746 g'
'Mass of kao from Kaolite = 51214.88 g'
'                           CHECK=> 51214.34 g'
' '
'Calculate the mass of water contained in the homogenized region'
'Mass of homogenized fissile U     = 3500.00000 g'
'Mass of poly in homogenized region=  500.00000 g'
'Mass of h2o in homogenized region = 9008.54567 g'
'Mass of kao in homogenized region = 51214.8849 g'
'Mass of homogenized core region   = 64223.4306 g'
'Vol of homogenized fissile U      =  186.06048 cm3'
'Vol of poly                       =  543.47826 cm3'
'Vol of h2o                        = 124841.264 cm3'
'Vol of kao                        = 124844.318 cm3'
'Volume of homogenized core region = 125573.857 cm3'
'Calculate HTOX ratio for use of 500.0 grams can pads,vinyl tape, polyethylene in CV'
'Core hydrogen to fissile U ratio  =  71.9718'
' '
read geometry
global
unit 1001
'fissile material, homog, remaining fm as shell around mixture, 20.0 cm refl'
'Radius of homogenized core         =   31.06492 cm'
'Mass of fm shell                   = 3500.00000 g'
'Vol of fm shell                    =  186.06048 cm3'
'Radius of fm shell                 =   31.08035 cm'
sphere  1  1  31.06492  com='HEU core/water mixture'
sphere  2  1  31.08035  com='radius of fissile material shell'
sphere  8  1  51.08035  com='20.0 cm water reflector'
end geometry
end data
end
```

6.9.7.39 Case cvcrtriga_1_1

```
=csas25    parm=size=3000000
cvcrtriga 0.0in thk np,10400.0gUZrHx(  921.0g235,    0.0gH2O hx=  0.00),fr=1.0e+00
238groupndf5 infhommedium
'TRIGA volume =1200.95996, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=18.2, CV void volume 9014.40198'
arbmtriga  8.65974  4 0 0 0    1001    0.9554
                               40000   54.0446
                               92235    8.8558
                               92238   36.1442    1  1.0     293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
```

```
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1e-20   293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.31846e4 cm3 = (8.0457422e2 in3)(16.387064)'
'den.multiplier = 1.31846e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.518047 = (den.mult)(np277-4 min.den.) = 0.9935052*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.26267e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.06375e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.81674e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                               8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                                8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                                8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                                8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                                8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                                8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                                8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                                8016   25.8039   12  0.020   293  end
```

```
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                               8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
cvcrtriga 0.0in thk np,10400.0gUZrHx(  921.0g235,    0.0gH2O,hx=  0.00),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                       end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
```

```
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.828800   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.920 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.921 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   38.98540   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   38.98540   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
```

```
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.40 Case cvcrtriga_1_15

```
=csas25    parm=size=3000000
cvcrtriga 0.0in thk np,10400.0gUZrHx(  921.0g235, 8998.2gH2O hx=255.01),fr=1.0e+00
238groupndf5 infhommedium
'TRIGA volume =1200.95996, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=18.2, CV void volume 9014.40198'
arbmtriga  8.65974  4 0 0 0    1001    0.9554
                              40000   54.0446
                              92235    8.8558
                              92238   36.1442    1  1.0     293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
```

```
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.31846e4 cm3 = (8.0457422e2 in3)(16.387064)'
'den.multiplier = 1.31846e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.518047 = (den.mult)(np277-4 min.den.) = 0.9935052*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.26267e-2  2 0 0 0    5010   18.1479
                              5011   81.8520   11  0.7500  293  end
arbmnpmx  1.06375e+0 10 0 0 0    6012    1.9189
                              7014    0.0141
                              8016   43.4251
                             11023    0.1174
                             12000    0.3378
                             13027   39.0479
                             14000    2.4672
                             16000    0.3083
                             20000   11.8336
                             26000    0.5298   11  1.0000  293  end
arbmnph2o 3.81674e-1  2 0 0 0    1001   11.1913
                              8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                              8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                              8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                              8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                              8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                              8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                              8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                              8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                              8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
```

```
                              8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                              8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   21  1.0     293  end
end comp
cvcrtriga 0.0in thk np,10400.0gUZrHx(  921.0g235, 8998.2gH2O,hx=255.01),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                       end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.828800   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.920 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
```

```
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.921 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   38.98540   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   38.98540   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
```

```
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.41 Case cvcrtriga_2_15

```
=csas25    parm=size=3000000
cvcrtriga 1.4in thk np,10400.0gUZrHx(  921.0g235, 8384.6gH2O hx=237.62),fr=1.0e+00
238groupndf5 infhommedium
'TRIGA volume =1200.95996, SPACER volume  614.68012'
'TRIGA wrapped dry content can hx=18.2, CV void volume 8399.72186'
arbmtriga  8.65974  4 0 0 0    1001    0.9554
                              40000   54.0446
                              92235    8.8558
                              92238   36.1442    1  1.0     293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                          8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                          9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                         10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.31846e4 cm3 = (8.0457422e2 in3)(16.387064)'
'den.multiplier = 1.31846e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
```

```
'density = 1.518047 = (den.mult)(np277-4 min.den.) = 0.9935052*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.26267e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.06375e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.81674e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                               8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
```

```
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  1       293  end
'steel: liner'
ss304                                          16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                          17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                          18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                          18  1.25705 293  end
'steel: drum steel for single units'
ss304                                          19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                          19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                              8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   21  1.0     293  end
end comp
cvcrtriga 1.4in thk np,10400.0gUZrHx(  921.0g235, 8384.6gH2O,hx=237.62),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                        end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.828800   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.920 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev=11.321 in.]'
 cylinder  2  1    5.24510     3.55610   0.0     com='np spacer'
 cylinder  3  1    6.426200    3.55620  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    3.55620  -0.0001  com='cv below 1st step'
```

```
 cuboid    21 1 4p24.587200    3.55620  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'45.21560             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   31.87340   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   31.87340   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   31.87340   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
```

```
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.42 Case cvcrtriga_70_1_1

```
=csas25    parm=size=3000000
cvcrtriga_70 0.0in thk np, 6847.1gUZrHx(  408.0g235,    0.0gH2O hx=  0.00),fr=1.0e+00
238groupndf5 infhommedium
'TRIGA volume =1200.95996, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=41.1, CV void volume 9014.40198'
arbmtriga  5.70132  4 0 0 0    1001    1.5894
                              40000   89.9107
                              92235    5.9587
                              92238    2.5412    1  1.0     293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1e-20   293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.31846e4 cm3 = (8.0457422e2 in3)(16.387064)'
'den.multiplier = 1.31846e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.518047 = (den.mult)(np277-4 min.den.) = 0.9935052*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.26267e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.06375e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
```

```
                              20000   11.8336
                              26000    0.5298   11  1.0000  293  end
arbmnph2o 3.81674e-1  2 0 0 0    1001   11.1913
                               8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                               8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
```

```
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                          18  1.25705 293  end
'steel: drum steel for single units'
ss304                                          19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                          19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                               8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
cvcrtriga_70 0.0in thk np, 6847.1gUZrHx(  408.0g235,    0.0gH2O,hx=  0.00),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                         end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.828800   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.920 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.921 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   38.98540   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   38.98540   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
```

```
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.43 Case cvcrtriga_70_1_15

```
=csas25    parm=size=3000000
cvcrtriga_70 0.0in thk np, 6847.1gUZrHx(  408.0g235, 8998.2gH2O hx=575.64),fr=1.0e+00
238groupndf5 infhommedium
```

```
'TRIGA volume =1200.95996, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=41.1, CV void volume 9014.40198'
arbmtriga  5.70132  4 0 0 0    1001    1.5894
                              40000   89.9107
                              92235    5.9587
                              92238    2.5412    1  1.0     293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.31846e4 cm3 = (8.0457422e2 in3)(16.387064)'
'den.multiplier = 1.31846e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.518047 = (den.mult)(np277-4 min.den.) = 0.9935052*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.26267e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.06375e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.81674e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                               8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
```

```
                              8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                              8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                              8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                              8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                              8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                              8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                              8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                              8016   88.8087   20  1       293  end
'reflective water'
```

```
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   21  1.0     293  end
end comp
cvcrtriga_70 0.0in thk np, 6847.1gUZrHx(  408.0g235, 8998.2gH2O,hx=575.64),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                         end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.828800   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.920 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.921 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   38.98540   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   38.98540   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
```

```
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.44 Case cvcrtriga_70_2_15

```
=csas25    parm=size=3000000
cvcrtriga_70 1.4in thk np, 6847.1gUZrHx(  408.0g235, 8384.6gH2O hx=536.39),fr=1.0e+00
238groupndf5 infhommedium
'TRIGA volume =1200.95996, SPACER volume  614.68012'
'TRIGA wrapped dry content can hx=41.1, CV void volume 8399.72186'
arbmtriga  5.70132  4 0 0 0    1001    1.5894
                              40000   89.9107
                              92235    5.9587
                              92238    2.5412    1  1.0     293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
```

```
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.31846e4 cm3 = (8.0457422e2 in3)(16.387064)'
'den.multiplier = 1.31846e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.518047 = (den.mult)(np277-4 min.den.) = 0.9935052*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.26267e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.06375e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.81674e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                               8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
```

```
                              8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                              8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   21  1.0     293  end
end comp
cvcrtriga_70 1.4in thk np, 6847.1gUZrHx(  408.0g235, 8384.6gH2O,hx=536.39),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                       end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
```

```
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.828800   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.920 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev=11.321 in.]'
 cylinder  2  1    5.24510     3.55610   0.0     com='np spacer'
 cylinder  3  1    6.426200    3.55620  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    3.55620  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    3.55620  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'45.21560             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   31.87340   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   31.87340   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   31.87340   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
```

```
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.45 Case ncsrtriga_1_15_15

```
=csas25    parm=size=3000000
ncsrtriga 0.0in thk np,10400.0gUZrHx(  921.0g235, 8998.2gH2O hx=255.01),fr=1.0e+00
238groupndf5 infhommedium
'TRIGA volume =1200.95996, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=18.2, CV void volume 9014.40198'
arbmtriga  8.65974  4 0 0 0    1001    0.9554
                              40000   54.0446
                              92235    8.8558
                              92238   36.1442    1  1.0     293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
```

```
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                               5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                               7014    0.0141
                               8016   43.4251
                              11023    0.1174
                              12000    0.3378
                              13027   39.0479
                              14000    2.4672
                              16000    0.3083
                              20000   11.8336
                              26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                               8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                              8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                              8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                              8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                              8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                              8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                              8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                              8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                              8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430   13  0.367   293  end
```

```
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  1       293  end
'steel: liner'
ss304                                          16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                          17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                          18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                          18  1.25705 293  end
'steel: drum steel for single units'
ss304                                          19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                          19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                               8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
ncsrtriga 0.0in thk np,10400.0gUZrHx(  921.0g235, 8998.2gH2O,hx=255.01),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                        end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   23.329900    0.26670   0.0     com='drum bottom flat cover'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   23.177500   11.59510   0.0     com='kaolite'
 cylinder  19 1   23.329900   11.59510   0.0     com='drum'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
```

```
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   23.177500    0.63500   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.63500   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.828800   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.920 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800   12.70050  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200   12.70050  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000   12.70050  -0.0005  com='np277_4'
 cylinder  16 1   11.074400   12.70050  -0.0005  com='kaolite liner'
 cylinder  12 1   23.177500   12.70050  -0.0005  com='kaolite'
 cylinder  19 1   23.329900   12.70050  -0.0005  com='drum'
 cuboid    21 1 4p24.587200   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.921 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   23.177500    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   23.329900    0.00020  -0.0001  com='drum'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   38.98540   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   38.98540   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   38.98540   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   38.98540   0.0     com='np277_4'
 cylinder  16 1   11.074400   38.98540   0.0     com='kaolite liner'
 cylinder  12 1   23.177500   38.98540   0.0     com='kaolite'
 cylinder  19 1   23.329900   38.98540   0.0     com='drum'
 cuboid    21 1 4p24.587200   38.98540   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
```

```
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   23.177500    0.22860   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.22860   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   23.177500    1.27000   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.27000   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   23.177500    2.92100   0.0     com='kaolite'
 cylinder  19 1   23.329900    2.92100   0.0     com='drum'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   23.177500    1.01600   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.01600   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   23.177500    8.17880   0.0     com='kaolite'
 cylinder  19 1   23.329900    8.17880   0.0     com='drum'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
```

```
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   23.177500    4.44500   0.0     com='kaolite'
 cylinder  19 1   23.329900    4.44500   0.0     com='drum'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   23.177500    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   23.329900    0.63500   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  21 1   22.961600    1.90500   0.15240 com='void above lid'
 cylinder  19 1   23.114000    1.90500   0.0     com='drum lid'
 cylinder  21 1   23.177500    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   23.329900    1.90500   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.46 Case ncsrtriga70_1_15_15

```
=csas25    parm=size=3000000
ncsrtriga_70 0.0in thk np, 6847.1gUZrHx(  408.0g235, 8998.2gH2O hx=575.64),fr=1.0e+00
238groupndf5 infhommedium
'TRIGA volume =1200.95996, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=41.1, CV void volume 9014.40198'
arbmtriga  5.70132  4 0 0 0    1001    1.5894
                              40000   89.9107
                              92235    5.9587
                              92238    2.5412    1  1.0     293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
```

```
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                               8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
```

```
                              8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                              8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   21  1.0     293  end
end comp
ncsrtriga_70 0.0in thk np, 6847.1gUZrHx(  408.0g235, 8998.2gH2O,hx=575.64),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                       end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   23.329900    0.26670   0.0     com='drum bottom flat cover'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
```

```
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   23.177500   11.59510   0.0     com='kaolite'
 cylinder  19 1   23.329900   11.59510   0.0     com='drum'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   23.177500    0.63500   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.63500   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.828800   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.920 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800   12.70050  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200   12.70050  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000   12.70050  -0.0005  com='np277_4'
 cylinder  16 1   11.074400   12.70050  -0.0005  com='kaolite liner'
 cylinder  12 1   23.177500   12.70050  -0.0005  com='kaolite'
 cylinder  19 1   23.329900   12.70050  -0.0005  com='drum'
 cuboid    21 1 4p24.587200   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.921 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   23.177500    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   23.329900    0.00020  -0.0001  com='drum'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   38.98540   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   38.98540   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   38.98540   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   38.98540   0.0     com='np277_4'
```

```
 cylinder  16 1   11.074400   38.98540   0.0     com='kaolite liner'
 cylinder  12 1   23.177500   38.98540   0.0     com='kaolite'
 cylinder  19 1   23.329900   38.98540   0.0     com='drum'
 cuboid    21 1 4p24.587200   38.98540   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   23.177500    0.22860   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.22860   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   23.177500    1.27000   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.27000   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   23.177500    2.92100   0.0     com='kaolite'
 cylinder  19 1   23.329900    2.92100   0.0     com='drum'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   23.177500    1.01600   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.01600   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
```

```
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   23.177500    8.17880   0.0     com='kaolite'
 cylinder  19 1   23.329900    8.17880   0.0     com='drum'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   23.177500    4.44500   0.0     com='kaolite'
 cylinder  19 1   23.329900    4.44500   0.0     com='drum'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   23.177500    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   23.329900    0.63500   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  21 1   22.961600    1.90500   0.15240 com='void above lid'
 cylinder  19 1   23.114000    1.90500   0.0     com='drum lid'
 cylinder  21 1   23.177500    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   23.329900    1.90500   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.47 Case ncsrt55d2_1_15_15

```
=csas25    parm=size=3000000
ncsrt55d2 0.0in thk np,10400.0gUZrHx(  921.0g235, 8998.2gH2O hx=255.01),fr=1.0e+00
238groupndf5 infhommedium
```

```
'TRIGA volume =1200.95996, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=18.2, CV void volume 9014.40198'
arbmtriga  8.65974  4 0 0 0    1001    0.9554
                              40000   54.0446
                              92235    8.8558
                              92238   36.1442    1   0.11756  293  end
arbmwicv 9.9820e-01  2 0 0 0   1001   11.1913
                               8016   88.8087    1   0.88244  293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
```

```
                              8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                              8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                              8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                              8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                              8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                              8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                              8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                              8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
```

```
'                               8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   21  1.0     293  end
end comp
ncsrt55d2 0.0in thk np,10400.0gUZrHx(  921.0g235, 8998.2gH2O,hx=255.01),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                         end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   23.329900    0.26670   0.0     com='drum bottom flat cover'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   23.177500   11.59510   0.0     com='kaolite'
 cylinder  19 1   23.329900   11.59510   0.0     com='drum'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   23.177500    0.63500   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.63500   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1006
'content (collapsed) [Elev= 9.920 in.]'
 cylinder  1  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800   12.70050  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200   12.70050  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000   12.70050  -0.0005  com='np277_4'
 cylinder  16 1   11.074400   12.70050  -0.0005  com='kaolite liner'
 cylinder  12 1   23.177500   12.70050  -0.0005  com='kaolite'
 cylinder  19 1   23.329900   12.70050  -0.0005  com='drum'
 cuboid    21 1 4p24.587200   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.921 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  1  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   23.177500    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   23.329900    0.00020  -0.0001  com='drum'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  1  1    6.426200   38.98540   0.0     com='cv well cavity'
```

```
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   38.98540   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   38.98540   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   38.98540   0.0     com='np277_4'
 cylinder  16 1   11.074400   38.98540   0.0     com='kaolite liner'
 cylinder  12 1   23.177500   38.98540   0.0     com='kaolite'
 cylinder  19 1   23.329900   38.98540   0.0     com='drum'
 cuboid    21 1 4p24.587200   38.98540   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  1  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  1  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   23.177500    0.22860   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.22860   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  1  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   23.177500    1.27000   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.27000   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   23.177500    2.92100   0.0     com='kaolite'
 cylinder  19 1   23.329900    2.92100   0.0     com='drum'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   23.177500    1.01600   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.01600   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
```

```
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   23.177500    8.17880   0.0     com='kaolite'
 cylinder  19 1   23.329900    8.17880   0.0     com='drum'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   23.177500    4.44500   0.0     com='kaolite'
 cylinder  19 1   23.329900    4.44500   0.0     com='drum'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   23.177500    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   23.329900    0.63500   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  21 1   22.961600    1.90500   0.15240 com='void above lid'
 cylinder  19 1   23.114000    1.90500   0.0     com='drum lid'
 cylinder  21 1   23.177500    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   23.329900    1.90500   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.48 Case hcsrtriga_1_15_15

```
=csas25    parm=size=3000000
hcsrtriga 0.0in thk np,10400.0gUZrHx(  921.0g235, 8998.2gH2O hx=255.01),fr=1.0e+00
238groupndf5 infhommedium
'TRIGA volume =1200.95996, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=18.2, CV void volume 9014.40198'
arbmtriga  8.65974  4 0 0 0    1001    0.9554
                              40000   54.0446
                              92235    8.8558
                              92238   36.1442    1  1.0     293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
'np277-4: spacer (HAC_MD&H)'
'HAC min.den.(95.3157 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07071e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.82995e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (HAC_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.476265 = (den.mult)(np277-4 min.den.) = 0.9668933*1.526803'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.70316e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
```

```
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                                8016   88.8087   12  1       293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                                8016   47.0610   12  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                                8016   53.2430   12  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                                8016   30.0460   12  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                                8016   40.0465   12  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                                8016   28.5185   12  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                                8016   39.6831   12  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                                8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                                8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                                8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                                8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                                8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                                8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                                8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                                8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                                8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                                1001    8.1573
                                8016   21.5782
                               14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                                8016   88.8087   15  1       293  end
'steel: liner'
ss304                                           16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                           17  1.06388 293  end
'steel: angle iron (ai) for HAC'
'nct density is multiplied by volume fraction 7.08030/5.74516'
ss304                                           18  1.23239 293  end
'steel: drum steel for HAC'
'nct density is multiplied by volume fraction 3.20482/2.95645'
ss304                                           19  1.08401 293  end
```

```
'void space external to drum'
'array density is assumed not reduced by hac'
'arbmwed    0.9982   2 0 0 0    1001   11.1913
'                              8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
hcsrtriga 0.0in thk np,10400.0gU(  921.0g235, 8998.2gH2O,hx=255.01),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                          end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   21.838092    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   21.838092    0.26670   0.0     com='drum bottom flat cover'
 cuboid    21 1 4p21.838092    0.26670   0.0     com='drum(chine)outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.685692   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.838092   11.59510   0.0     com='drum'
 cuboid    21 1 4p21.838092   11.59510   0.0     com='drum(chine)outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   21.685692    0.63500   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.63500   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.63500   0.0     com='drum(chine)outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.828800   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.920 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800   12.70050  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200   12.70050  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000   12.70050  -0.0005  com='np277_4'
 cylinder  16 1   11.074400   12.70050  -0.0005  com='kaolite liner'
 cylinder  12 1   21.685692   12.70050  -0.0005  com='kaolite'
 cylinder  19 1   21.838092   12.70050  -0.0005  com='drum'
 cuboid    21 1 4p21.838092   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.921 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
```

```
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   21.685692    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   21.838092    0.00020  -0.0001  com='drum'
 cuboid    21 1 4p21.838092    0.00020  -0.0001  com='drum(chine)outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   38.98540   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   38.98540   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   38.98540   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   38.98540   0.0     com='np277_4'
 cylinder  16 1   11.074400   38.98540   0.0     com='kaolite liner'
 cylinder  12 1   21.685692   38.98540   0.0     com='kaolite'
 cylinder  19 1   21.838092   38.98540   0.0     com='drum'
 cuboid    21 1 4p21.838092   38.98540   0.0     com='drum(chine)outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.685692    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.22860   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.22860   0.0     com='drum(chine)outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.27000   0.0     com='drum'
 cuboid    21 1 4p21.838092    1.27000   0.0     com='drum(chine)outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.685692    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.838092    2.92100   0.0     com='drum'
 cuboid    21 1 4p21.838092    2.92100   0.0     com='drum(chine)outer radius'
unit 1014
```

```
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.01600   0.0     com='drum'
 cuboid    21 1 4p21.838092    1.01600   0.0     com='drum(chine)outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.685692    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.838092    8.17880   0.0     com='drum'
 cuboid    21 1 4p21.838092    8.17880   0.0     com='drum(chine)outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.685692    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.838092    4.44500   0.0     com='drum'
 cuboid    21 1 4p21.838092    4.44500   0.0     com='drum(chine)outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.685692    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.838092    0.63500   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.63500   0.0     com='drum(chine)outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  21 1   21.469792    1.90500   0.15240 com='void above lid'
 cylinder  19 1   21.622192    1.90500   0.0     com='drum lid'
 cylinder  21 1   21.685692    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.838092    1.90500   0.0     com='drum'
 cuboid    21 1 4p21.838092    1.90500   0.0     com='drum(chine)outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-21.838092     0.0
'cuboid     0  1 4p21.838092    110.4905  0.0    com='bare package'
 cuboid    21  1 4p52.318092   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
```

```
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.49 Case hcsrtriga70_1_15_15

```
=csas25    parm=size=3000000
hcsrtriag_70 0.0in thk np, 6847.1gUZrHx(  408.0g235, 8998.2gH2O hx=575.64),fr=1.0e+00
238groupndf5 infhommedium
'TRIGA volume =1200.95996, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=41.1, CV void volume 9014.40198'
arbmtriga  5.70132  4 0 0 0    1001    1.5894
                              40000   89.9107
                              92235    5.9587
                              92238    2.5412    1  1.0     293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
'np277-4: spacer (HAC_MD&H)'
'HAC min.den.(95.3157 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07071e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.82995e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (HAC_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.476265 = (den.mult)(np277-4 min.den.) = 0.9668933*1.526803'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
```

```
                                8016   43.4254
                               11023    0.1174
                               12000    0.3378
                               13027   39.0477
                               14000    2.4671
                               16000    0.3083
                               20000   11.8335
                               26000    0.5298   11  1.0000  293  end
arbmnph2o 3.70316e-1  2 0 0 0    1001   11.1913
                                8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                                8016   88.8087   12  1       293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                                8016   47.0610   12  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                                8016   53.2430   12  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                                8016   30.0460   12  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                                8016   40.0465   12  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                                8016   28.5185   12  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                                8016   39.6831   12  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                                8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                                8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                                8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                                8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                                8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                                8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                                8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                                8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                                8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                                1001    8.1573
                                8016   21.5782
                               14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
```

```
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  1       293  end
'steel: liner'
ss304                                          16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                          17  1.06388 293  end
'steel: angle iron (ai) for HAC'
'nct density is multiplied by volume fraction 7.08030/5.74516'
ss304                                          18  1.23239 293  end
'steel: drum steel for HAC'
'nct density is multiplied by volume fraction 3.20482/2.95645'
ss304                                          19  1.08401 293  end
'void space external to drum'
'array density is assumed not reduced by hac'
'arbmwed    0.9982   2 0 0 0    1001   11.1913
'                               8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
hcsrtriag_70 0.0in thk np, 6847.1gU(  408.0g235, 8998.2gH2O,hx=575.64),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                        end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   21.838092    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   21.838092    0.26670   0.0     com='drum bottom flat cover'
 cuboid    21 1 4p21.838092    0.26670   0.0     com='drum(chine)outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.685692   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.838092   11.59510   0.0     com='drum'
 cuboid    21 1 4p21.838092   11.59510   0.0     com='drum(chine)outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   21.685692    0.63500   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.63500   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.63500   0.0     com='drum(chine)outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.828800   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.920 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
```

```
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800   12.70050  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200   12.70050  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000   12.70050  -0.0005  com='np277_4'
 cylinder  16 1   11.074400   12.70050  -0.0005  com='kaolite liner'
 cylinder  12 1   21.685692   12.70050  -0.0005  com='kaolite'
 cylinder  19 1   21.838092   12.70050  -0.0005  com='drum'
 cuboid    21 1 4p21.838092   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.921 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   21.685692    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   21.838092    0.00020  -0.0001  com='drum'
 cuboid    21 1 4p21.838092    0.00020  -0.0001  com='drum(chine)outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   38.98540   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   38.98540   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   38.98540   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   38.98540   0.0     com='np277_4'
 cylinder  16 1   11.074400   38.98540   0.0     com='kaolite liner'
 cylinder  12 1   21.685692   38.98540   0.0     com='kaolite'
 cylinder  19 1   21.838092   38.98540   0.0     com='drum'
 cuboid    21 1 4p21.838092   38.98540   0.0     com='drum(chine)outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.685692    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.22860   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.22860   0.0     com='drum(chine)outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.27000   0.0     com='drum'
```

```
 cuboid    21 1 4p21.838092    1.27000   0.0     com='drum(chine)outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.685692    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.838092    2.92100   0.0     com='drum'
 cuboid    21 1 4p21.838092    2.92100   0.0     com='drum(chine)outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.01600   0.0     com='drum'
 cuboid    21 1 4p21.838092    1.01600   0.0     com='drum(chine)outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.685692    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.838092    8.17880   0.0     com='drum'
 cuboid    21 1 4p21.838092    8.17880   0.0     com='drum(chine)outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.685692    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.838092    4.44500   0.0     com='drum'
 cuboid    21 1 4p21.838092    4.44500   0.0     com='drum(chine)outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.685692    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.838092    0.63500   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.63500   0.0     com='drum(chine)outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  21 1   21.469792    1.90500   0.15240 com='void above lid'
 cylinder  19 1   21.622192    1.90500   0.0     com='drum lid'
 cylinder  21 1   21.685692    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.838092    1.90500   0.0     com='drum'
 cuboid    21 1 4p21.838092    1.90500   0.0     com='drum(chine)outer radius'
```

```
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-21.838092     0.0
'cuboid     0  1 4p21.838092    110.4905  0.0    com='bare package'
 cuboid    21  1 4p52.318092   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.50 Case nciatriga_1_15_3

```
=csas25    parm=size=3000000
nciatriga 0.0in thk np,10400.0gUZrHx(  921.0g235, 8998.2gH2O hx=255.01),fr=1.0e-04
238groupndf5 infhommedium
'TRIGA volume =1200.95996, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=18.2, CV void volume 9014.40198'
arbmtriga  8.65974  4 0 0 0    1001    0.9554
                              40000   54.0446
                              92235    8.8558
                              92238   36.1442    1  1.0     293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                          8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                          9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
```

```
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'nct array densities are s.u.dens. multiplied by volume ratio 1.34888/1.10336'
arbmh2ok   0.63931  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.42622  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.42622  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.42622  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.42622  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.42622  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.42622  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.42622  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
```

```
                              8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                          16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                          17  1.06388 293  end
'steel: angle iron (ai) for single units'
'ss304                                          18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
ss304                                          18  1.25705 293  end
'steel: drum steel for single units'
'ss304                                          19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
ss304                                          19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
arbmwed    1.16026  2 0 0 0    1001   11.1913
                              8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                              8016   88.8087   21  1.0     293  end
end comp
nciatriga 0.0in thk np,10400.0gUZrHx(  921.0g235, 8998.2gH2O,hx=255.01),fr=1.0e-04
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                   end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.111 in. at top of unit]'
'cylinder  19 1   22.866096    0.28150   0.0     com='extended radius not used'
 cylinder  19 1   21.722275    0.28150   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p22.866096    0.28150   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.676 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.555075   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.722275   11.59510   0.0     com='drum'
 cuboid    20 1 4p22.866096   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.926 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   21.555075    0.63500   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
```

```
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.828800   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.926 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800   12.70050  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200   12.70050  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000   12.70050  -0.0005  com='np277_4'
 cylinder  16 1   11.074400   12.70050  -0.0005  com='kaolite liner'
 cylinder  12 1   21.555075   12.70050  -0.0005  com='kaolite'
 cylinder  19 1   21.722275   12.70050  -0.0005  com='drum'
 cuboid    20 1 4p22.866096   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.926 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   21.555075    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   21.722275    0.00020  -0.0001  com='drum'
 cuboid    20 1 4p22.866096    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.276 in.]'
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   38.98540   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   38.98540   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   38.98540   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   38.98540   0.0     com='np277_4'
 cylinder  16 1   11.074400   38.98540   0.0     com='kaolite liner'
 cylinder  12 1   21.555075   38.98540   0.0     com='kaolite'
 cylinder  19 1   21.722275   38.98540   0.0     com='drum'
 cuboid    20 1 4p22.866096   38.98540   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.336 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.426 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
```

```
 cylinder  12 1   21.555075    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.22860   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.926 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.27000   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.076 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.555075    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.722275    2.92100   0.0     com='drum'
 cuboid    20 1 4p22.866096    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.476 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.01600   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.536 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.756 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.555075    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.722275    8.17880   0.0     com='drum'
 cuboid    20 1 4p22.866096    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.506 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.555075    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.722275    4.44500   0.0     com='drum'
 cuboid    20 1 4p22.866096    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.756 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
```

```
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.555075    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.512 in.]'
 cylinder  20 1   21.330090    1.91973   0.16720 com='void above lid'
 cylinder  19 1   21.497290    1.91973   0.0     com='drum lid'
 cylinder  20 1   21.555075    1.91973   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.722275    1.91973   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.91973   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.512 in.]'
array 3         2r-22.866096     0.0
'cuboid     0  1 4p24.587200    110.4900  0.0    com='bare package'
'cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
 cuboid    20  1 4p22.866096    110.5197  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.51 Case nciatriga70_1_15_3

```
=csas25    parm=size=3000000
nciatriga_70 0.0in thk np, 6847.1gUZrHx(  408.0g235, 8998.2gH2O hx=575.64),fr=1.0e-04
238groupndf5 infhommedium
'TRIGA volume =1200.95996, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=41.1, CV void volume 9014.40198'
arbmtriga  5.70132  4 0 0 0    1001    1.5894
                              40000   89.9107
                              92235    5.9587
                              92238    2.5412    1  1.0     293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
```

```
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'nct array densities are s.u.dens. multiplied by volume ratio 1.34888/1.10336'
arbmh2ok   0.63931  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.42622  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.42622  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.42622  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.42622  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.42622  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.42622  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.42622  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
```

```
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
'ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
'ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
arbmwed    1.16026  2 0 0 0    1001   11.1913
                              8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                              8016   88.8087   21  1.0     293  end
end comp
nciatriga_70 0.0in thk np, 6847.1gUZrHx(  408.0g235, 8998.2gH2O,hx=575.64),fr=1.0e-04
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                  end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.111 in. at top of unit]'
'cylinder  19 1   22.866096    0.28150   0.0     com='extended radius not used'
 cylinder  19 1   21.722275    0.28150   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p22.866096    0.28150   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.676 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
```

```
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.555075   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.722275   11.59510   0.0     com='drum'
 cuboid    20 1 4p22.866096   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.926 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   21.555075    0.63500   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.828800   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.926 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800   12.70050  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200   12.70050  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000   12.70050  -0.0005  com='np277_4'
 cylinder  16 1   11.074400   12.70050  -0.0005  com='kaolite liner'
 cylinder  12 1   21.555075   12.70050  -0.0005  com='kaolite'
 cylinder  19 1   21.722275   12.70050  -0.0005  com='drum'
 cuboid    20 1 4p22.866096   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.926 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   21.555075    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   21.722275    0.00020  -0.0001  com='drum'
 cuboid    20 1 4p22.866096    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.276 in.]'
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   38.98540   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   38.98540   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   38.98540   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   38.98540   0.0     com='np277_4'
 cylinder  16 1   11.074400   38.98540   0.0     com='kaolite liner'
 cylinder  12 1   21.555075   38.98540   0.0     com='kaolite'
 cylinder  19 1   21.722275   38.98540   0.0     com='drum'
 cuboid    20 1 4p22.866096   38.98540   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.336 in.]'
```

```
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.426 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.555075    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.22860   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.926 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.27000   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.076 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.555075    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.722275    2.92100   0.0     com='drum'
 cuboid    20 1 4p22.866096    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.476 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.01600   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.536 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.756 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.555075    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.722275    8.17880   0.0     com='drum'
 cuboid    20 1 4p22.866096    8.17880   0.0     com='drum chine outer radius'
```

```
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.506 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.555075    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.722275    4.44500   0.0     com='drum'
 cuboid    20 1 4p22.866096    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.756 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.555075    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.512 in.]'
 cylinder  20 1   21.330090    1.91973   0.16720 com='void above lid'
 cylinder  19 1   21.497290    1.91973   0.0     com='drum lid'
 cylinder  20 1   21.555075    1.91973   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.722275    1.91973   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.91973   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.512 in.]'
array 3         2r-22.866096     0.0
'cuboid     0  1 4p24.587200    110.4900  0.0    com='bare package'
'cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
 cuboid    20  1 4p22.866096    110.5197  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.52 Case hciatriga_1_15_3

```
=csas25    parm=size=3000000
hciatriga 0.0in thk np,10400.0gUZrHx(  921.0g235, 8998.2gH2O hx=255.01),fr=1.0e-04
238groupndf5 infhommedium
'TRIGA volume =1200.95996, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=18.2, CV void volume 9014.40198'
arbmtriga  8.65974  4 0 0 0    1001    0.9554
                              40000   54.0446
                              92235    8.8558
                              92238   36.1442    1  1.0     293  end
```

```
'np277-4: spacer (HAC_MD&H)'
'HAC min.den.(95.3157 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07071e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.82995e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (HAC_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.476265 = (den.mult)(np277-4 min.den.) = 0.9668933*1.526803'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.70316e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
```

```
                              8016   53.2430   12  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                              8016   30.0460   12  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                              8016   40.0465   12  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                              8016   28.5185   12  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                              8016   39.6831   12  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                              8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for HAC'
'nct density is multiplied by volume fraction 7.08030/5.74516'
ss304                                         18  1.23239 293  end
'steel: drum steel for HAC'
'nct density is multiplied by volume fraction 3.20482/2.95645'
ss304                                         19  1.08401 293  end
'void space external to drum'
'array density is assumed not reduced by hac'
arbmwed    0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                             8016   88.8087   21  1.0     293  end
end comp
hciatriga 0.0in thk np,10400.0gUZrHx(  921.0g235, 8998.2gH2O,hx=255.01),fr=1.0e-04
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                  end boun
```

```
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   21.838092    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   21.838092    0.26670   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p21.838092    0.26670   0.0     com='drum(chine)outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.685692   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.838092   11.59510   0.0     com='drum'
 cuboid    20 1 4p21.838092   11.59510   0.0     com='drum(chine)outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   21.685692    0.63500   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.63500   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.63500   0.0     com='drum(chine)outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.828800   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.920 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800   12.70050  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200   12.70050  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000   12.70050  -0.0005  com='np277_4'
 cylinder  16 1   11.074400   12.70050  -0.0005  com='kaolite liner'
 cylinder  12 1   21.685692   12.70050  -0.0005  com='kaolite'
 cylinder  19 1   21.838092   12.70050  -0.0005  com='drum'
 cuboid    20 1 4p21.838092   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.921 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   21.685692    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   21.838092    0.00020  -0.0001  com='drum'
 cuboid    20 1 4p21.838092    0.00020  -0.0001  com='drum(chine)outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
```

```
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   38.98540   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   38.98540   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   38.98540   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   38.98540   0.0     com='np277_4'
 cylinder  16 1   11.074400   38.98540   0.0     com='kaolite liner'
 cylinder  12 1   21.685692   38.98540   0.0     com='kaolite'
 cylinder  19 1   21.838092   38.98540   0.0     com='drum'
 cuboid    20 1 4p21.838092   38.98540   0.0     com='drum(chine)outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.685692    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.22860   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.22860   0.0     com='drum(chine)outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.27000   0.0     com='drum'
 cuboid    20 1 4p21.838092    1.27000   0.0     com='drum(chine)outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.685692    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.838092    2.92100   0.0     com='drum'
 cuboid    20 1 4p21.838092    2.92100   0.0     com='drum(chine)outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.01600   0.0     com='drum'
 cuboid    20 1 4p21.838092    1.01600   0.0     com='drum(chine)outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
```

```
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.685692    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.838092    8.17880   0.0     com='drum'
 cuboid    20 1 4p21.838092    8.17880   0.0     com='drum(chine)outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.685692    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.838092    4.44500   0.0     com='drum'
 cuboid    20 1 4p21.838092    4.44500   0.0     com='drum(chine)outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.685692    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.838092    0.63500   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.63500   0.0     com='drum(chine)outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  20 1   21.469792    1.90500   0.15240 com='void above lid'
 cylinder  19 1   21.622192    1.90500   0.0     com='drum lid'
 cylinder  20 1   21.685692    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.838092    1.90500   0.0     com='drum'
 cuboid    20 1 4p21.838092    1.90500   0.0     com='drum(chine)outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-21.838092     0.0
'cuboid     0  1 4p21.838092    110.4905  0.0    com='bare package'
'cuboid    21  1 4p52.318092   140.9700 -30.48   com='reflected package'
 cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.53 Case hciatriga70_1_15_3

```
=csas25    parm=size=3000000
hciatriga_70 0.0in thk np, 6847.1gUZrHx(  408.0g235, 8998.2gH2O hx=575.64),fr=1.0e-04
238groupndf5 infhommedium
'TRIGA volume =1200.95996, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=41.1, CV void volume 9014.40198'
arbmtriga  5.70132  4 0 0 0    1001    1.5894
                              40000   89.9107
                              92235    5.9587
                              92238    2.5412    1  1.0     293  end
'np277-4: spacer (HAC_MD&H)'
'HAC min.den.(95.3157 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07071e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.82995e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (HAC_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.476265 = (den.mult)(np277-4 min.den.) = 0.9668933*1.526803'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.70316e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
```

```
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for HAC'
'nct density is multiplied by volume fraction 7.08030/5.74516'
ss304                                         18  1.23239 293  end
'steel: drum steel for HAC'
'nct density is multiplied by volume fraction 3.20482/2.95645'
ss304                                         19  1.08401 293  end
```

```
'void space external to drum'
'array density is assumed not reduced by hac'
arbmwed    0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                              8016   88.8087   21  1.0     293  end
end comp
hciatriga_70 0.0in thk np, 6847.1gUZrHx(  408.0g235, 8998.2gH2O,hx=575.64),fr=1.0e-04
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                    end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   21.838092    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   21.838092    0.26670   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p21.838092    0.26670   0.0     com='drum(chine)outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.685692   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.838092   11.59510   0.0     com='drum'
 cuboid    20 1 4p21.838092   11.59510   0.0     com='drum(chine)outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   21.685692    0.63500   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.63500   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.63500   0.0     com='drum(chine)outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.828800   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.920 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800   12.70050  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200   12.70050  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000   12.70050  -0.0005  com='np277_4'
 cylinder  16 1   11.074400   12.70050  -0.0005  com='kaolite liner'
 cylinder  12 1   21.685692   12.70050  -0.0005  com='kaolite'
 cylinder  19 1   21.838092   12.70050  -0.0005  com='drum'
 cuboid    20 1 4p21.838092   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.921 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
```

```
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   21.685692    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   21.838092    0.00020  -0.0001  com='drum'
 cuboid    20 1 4p21.838092    0.00020  -0.0001  com='drum(chine)outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   38.98540   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   38.98540   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   38.98540   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   38.98540   0.0     com='np277_4'
 cylinder  16 1   11.074400   38.98540   0.0     com='kaolite liner'
 cylinder  12 1   21.685692   38.98540   0.0     com='kaolite'
 cylinder  19 1   21.838092   38.98540   0.0     com='drum'
 cuboid    20 1 4p21.838092   38.98540   0.0     com='drum(chine)outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.685692    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.22860   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.22860   0.0     com='drum(chine)outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.27000   0.0     com='drum'
 cuboid    20 1 4p21.838092    1.27000   0.0     com='drum(chine)outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.685692    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.838092    2.92100   0.0     com='drum'
 cuboid    20 1 4p21.838092    2.92100   0.0     com='drum(chine)outer radius'
unit 1014
```

```
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.01600   0.0     com='drum'
 cuboid    20 1 4p21.838092    1.01600   0.0     com='drum(chine)outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.685692    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.838092    8.17880   0.0     com='drum'
 cuboid    20 1 4p21.838092    8.17880   0.0     com='drum(chine)outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.685692    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.838092    4.44500   0.0     com='drum'
 cuboid    20 1 4p21.838092    4.44500   0.0     com='drum(chine)outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.685692    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.838092    0.63500   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.63500   0.0     com='drum(chine)outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  20 1   21.469792    1.90500   0.15240 com='void above lid'
 cylinder  19 1   21.622192    1.90500   0.0     com='drum lid'
 cylinder  20 1   21.685692    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.838092    1.90500   0.0     com='drum'
 cuboid    20 1 4p21.838092    1.90500   0.0     com='drum(chine)outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-21.838092     0.0
'cuboid     0  1 4p21.838092    110.4905  0.0    com='bare package'
'cuboid    21  1 4p52.318092   140.9700 -30.48   com='reflected package'
 cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
```

```
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.54 Case ncsrT70_131_1_15_15

```
=csas25    parm=size=3000000
ncsrT70131 0.0in thk np, 5666.6gUZrHx(  337.7g235, 9204.9gH2O hx=711.53),fr=1.0e+00
238groupndf5 infhommedium
'TRIGA volume = 993.90789, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=49.6, CV void volume 9221.45406'
arbmtriga  5.70132  4 0 0 0    1001    1.5894
                              40000   89.9107
                              92235    5.9587
                              92238    2.5412    1  1.0     293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
```

```
                              11023    0.1174
                              12000    0.3378
                              13027   39.0479
                              14000    2.4672
                              16000    0.3083
                              20000   11.8336
                              26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                               8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                               8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
```

```
'steel: plug cover (pc) use 9.907 lb'
ss304                                          17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                          18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                          18  1.25705 293  end
'steel: drum steel for single units'
ss304                                          19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                          19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                               8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
ncsrT70131 0.0in thk np, 5666.6gUZrHx(  337.7g235, 9204.9gH2O,hx=711.53),fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                        end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   23.329900    0.26670   0.0     com='drum bottom flat cover'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   23.177500   11.59510   0.0     com='kaolite'
 cylinder  19 1   23.329900   11.59510   0.0     com='drum'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   23.177500    0.63500   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.63500   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.663700   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.920 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
```

```
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800   12.70050  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200   12.70050  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000   12.70050  -0.0005  com='np277_4'
 cylinder  16 1   11.074400   12.70050  -0.0005  com='kaolite liner'
 cylinder  12 1   23.177500   12.70050  -0.0005  com='kaolite'
 cylinder  19 1   23.329900   12.70050  -0.0005  com='drum'
 cuboid    21 1 4p24.587200   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.921 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   23.177500    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   23.329900    0.00020  -0.0001  com='drum'
 cuboid    21 1 4p24.587200    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   38.98540   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   38.98540   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   38.98540   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   38.98540   0.0     com='np277_4'
 cylinder  16 1   11.074400   38.98540   0.0     com='kaolite liner'
 cylinder  12 1   23.177500   38.98540   0.0     com='kaolite'
 cylinder  19 1   23.329900   38.98540   0.0     com='drum'
 cuboid    21 1 4p24.587200   38.98540   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   23.177500    0.22860   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.22860   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   23.177500    1.27000   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.27000   0.0     com='drum'
```

```
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   23.177500    2.92100   0.0     com='kaolite'
 cylinder  19 1   23.329900    2.92100   0.0     com='drum'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   23.177500    1.01600   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.01600   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   23.177500    8.17880   0.0     com='kaolite'
 cylinder  19 1   23.329900    8.17880   0.0     com='drum'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   23.177500    4.44500   0.0     com='kaolite'
 cylinder  19 1   23.329900    4.44500   0.0     com='drum'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   23.177500    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   23.329900    0.63500   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  21 1   22.961600    1.90500   0.15240 com='void above lid'
 cylinder  19 1   23.114000    1.90500   0.0     com='drum lid'
 cylinder  21 1   23.177500    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   23.329900    1.90500   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
```

```
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.55 Case nciaT70_131_1_15_3

```
=csas25    parm=size=3000000
nciaT70131 0.0in thk np, 5666.6gUZrHx(  337.7g235, 9204.9gH2O hx=711.53),fr=1.0e-04
238groupndf5 infhommedium
'TRIGA volume = 993.90789, SPACER volume    0.00000'
'TRIGA wrapped dry content can hx=49.6, CV void volume 9221.45406'
arbmtriga  5.70132  4 0 0 0    1001    1.5894
                              40000   89.9107
                              92235    5.9587
                              92238    2.5412    1  1.0     293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                          8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                          9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
```

```
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'nct array densities are s.u.dens. multiplied by volume ratio 1.34888/1.10336'
arbmh2ok   0.63931  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.42622  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.42622  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.42622  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.42622  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.42622  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.42622  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.42622  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
```

```
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                           16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                           17  1.06388 293  end
'steel: angle iron (ai) for single units'
'ss304                                           18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
ss304                                           18  1.25705 293  end
'steel: drum steel for single units'
'ss304                                           19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
ss304                                           19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
arbmwed    1.16026  2 0 0 0    1001   11.1913
                               8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                               8016   88.8087   21  1.0     293  end
end comp
nciaT70131 0.0in thk np, 5666.6gUZrHx(  337.7g235, 9204.9gH2O,hx=711.53),fr=1.0e-04
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                    end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.111 in. at top of unit]'
'cylinder  19 1   22.866096    0.28150   0.0     com='extended radius not used'
 cylinder  19 1   21.722275    0.28150   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p22.866096    0.28150   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.676 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.555075   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.722275   11.59510   0.0     com='drum'
 cuboid    20 1 4p22.866096   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.926 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   21.555075    0.63500   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
```

```
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1004
'UZrHx fuel element'
 cylinder  1  1    1.663700   12.70000   0.0     com='cylindrical content'
unit 1006
'content (collapsed) [Elev= 9.926 in.]'
'1.437900   plus-y location upper cylinders'
'-2.875700  minus-y location lower cylinder'
'2.490443   plus-x location upper cylinder'
'-2.490443  minus-x location upper cylinder'
 cylinder  3  1    6.426200   12.70050  -0.0005  com='cv well cavity'
 hole  1004   -2.490443  1.437900  0.0     com='cyl1'
 hole  1004    2.490443  1.437900  0.0     com='cyl2'
 hole  1004    0.0      -2.875700  0.0     com='cyl3'
 cylinder  8  1    6.680200   12.70050  -0.0005  com='cv below 1st step'
 cylinder  15 1    7.924800   12.70050  -0.0005  com='void btw cv-np liner'
 cylinder  16 1    8.077200   12.70050  -0.0005  com='np277_4 liner'
 cylinder  11 1   10.922000   12.70050  -0.0005  com='np277_4'
 cylinder  16 1   11.074400   12.70050  -0.0005  com='kaolite liner'
 cylinder  12 1   21.555075   12.70050  -0.0005  com='kaolite'
 cylinder  19 1   21.722275   12.70050  -0.0005  com='drum'
 cuboid    20 1 4p22.866096   12.70050  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 9.926 in.]'
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   21.555075    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   21.722275    0.00020  -0.0001  com='drum'
 cuboid    20 1 4p22.866096    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.276 in.]'
'38.10360             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   38.98540   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   38.98540   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   38.98540   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   38.98540   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   38.98540   0.0     com='np277_4'
 cylinder  16 1   11.074400   38.98540   0.0     com='kaolite liner'
 cylinder  12 1   21.555075   38.98540   0.0     com='kaolite'
 cylinder  19 1   21.722275   38.98540   0.0     com='drum'
 cuboid    20 1 4p22.866096   38.98540   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.336 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.426 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
```

```
 cylinder  12 1   21.555075    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.22860   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.926 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.27000   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.076 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.555075    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.722275    2.92100   0.0     com='drum'
 cuboid    20 1 4p22.866096    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.476 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.01600   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.536 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.756 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.555075    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.722275    8.17880   0.0     com='drum'
 cuboid    20 1 4p22.866096    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.506 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.555075    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.722275    4.44500   0.0     com='drum'
 cuboid    20 1 4p22.866096    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.756 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
```

```
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.555075    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.512 in.]'
 cylinder  20 1   21.330090    1.91973   0.16720 com='void above lid'
 cylinder  19 1   21.497290    1.91973   0.0     com='drum lid'
 cylinder  20 1   21.555075    1.91973   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.722275    1.91973   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.91973   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.512 in.]'
array 3         2r-22.866096     0.0
'cuboid     0  1 4p24.587200    110.4900  0.0    com='bare package'
'cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
 cuboid    20  1 4p22.866096    110.5197  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.56 Case athopw15kr20_5

```
=csas25    parm=size=300000
athopw15kr20,[15763.u3o8al, 921.0U235,500.0CH2,6803.8H2O]g
htox=211.0,Rc=14.13813cm,53419.6,Rs=31.95515cm
238groupndf5 multiregion
'U3O8Al=15763.4g poly=500.0g cont.hx=18.2 Kao H2O=  6803.8g, homgcore hx=211.0'
'Rc=14.13813cm,53419.6,Rs=31.95515cm'
arbmTHAR   3.52015   4 0 0 0   8016    5.24773
                              13027   65.53981
                              92235    5.84249
                              92238   23.36997   1  0.3783  293  end
arbmpoly   0.92000   2 0 0 0   1001   14.3798
                               6012   85.6202    1  0.0459  293  end
arbmkh2o   0.9982    2 0 0 0   1001   11.1913
                               8016   88.8087    1  5.7580e-01    293  end
'kaolite 1600 shell'
arbmh2ok 1.7660e-02  2 0 0 0   1001   11.1913
                               8016   88.8087    2  1.000   293  end
arbmal2o3  0.41023   2 0 0 0   13027   52.9390
                               8016   47.0610    2  0.096   293  end
arbmsio2   0.41023   2 0 0 0   14000   46.7570
                               8016   53.2430    2  0.367   293  end
arbmfe2o3  0.41023   2 0 0 0   26000   69.9540
```

```
                              8016   30.0460    2  0.067   293  end
arbmtio2   0.41023   2 0 0 0   22000   59.9535
                              8016   40.0465    2  0.012   293  end
arbmcao    0.41023   2 0 0 0   20000   71.4815
                              8016   28.5185    2  0.307   293  end
arbmmgo    0.41023   2 0 0 0   12000   60.3169
                              8016   39.6831    2  0.131   293  end
arbmna2o   0.41023   2 0 0 0   11023   74.1961
                              8016   25.8039    2  0.020   293  end
'flooded containment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    3  1.0     293  end
'steel: cv body, lower flange, upper flange, drum liner'
ss304                                           4  1.0     293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                              8016   88.8087    5  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                              8016   47.0610    5  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                              8016   53.2430    5  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                              8016   30.0460    5  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                              8016   40.0465    5  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                              8016   28.5185    5  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                              8016   39.6831    5  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                              8016   25.8039    5  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087    6  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610    6  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430    6  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460    6  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465    6  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185    6  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831    6  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039    6  0.020   293  end
'kaolite 1600 combined'
```

```
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.191224*0.51655,  for rest = 1.191224*0.34438'
'den.mult= 1.48716e5 cm3 (actual vol.) / 1.24843e5 cm3 (model vol.)'
'actual body vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'actual plug vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
'total Kaolite volume=1.48716e5 cm3 =  1.36557e5 + 1.21592e4 cm3'
'model body vol.= 1.12246e5 cm3'
'model plug vol.= 1.25970e4 cm3'
'total model volume=1.24843e5 cm3 =  1.12246e5 + 1.25970e4 cm3'
'grams water in wet-Kaolite = 9008.5737 = 6803.85 + 2204.7237 g'
'density of water in wet-Kaolite = 0.07216 g/cm3 = 9008.5737/1.24843e5'
'grams water in baked-dry Kaolite = 2204.7237 g'
'density of water in baked-dry Kaolite = 0.01766 = 2204.7237/1.24843e5'
'VF for water in baked-dry Kaolite = 0.244736 = 2204.7237/9008.5737'
arbmh2ok   0.07216  2 0 0 0    1001   11.1913
                               8016   88.8087    7  1.000   293  end
arbmal2o3  0.41023  2 0 0 0   13027   52.9390
                               8016   47.0610    7  0.096   293  end
arbmsio2   0.41023  2 0 0 0   14000   46.7570
                               8016   53.2430    7  0.367   293  end
arbmfe2o3  0.41023  2 0 0 0   26000   69.9540
                               8016   30.0460    7  0.067   293  end
arbmtio2   0.41023  2 0 0 0   22000   59.9535
                               8016   40.0465    7  0.012   293  end
arbmcao    0.41023  2 0 0 0   20000   71.4815
                               8016   28.5185    7  0.307   293  end
arbmmgo    0.41023  2 0 0 0   12000   60.3169
                               8016   39.6831    7  0.131   293  end
arbmna2o   0.41023  2 0 0 0   11023   74.1961
                               8016   25.8039    7  0.020   293  end
'reflective water'
arbmh2or   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    8  1.0000  293  end
end comp
spherical end
1  14.13813
2  31.95515
8  51.95515
end zone
athopw15kr20,[15763.u3o8al, 921.0U235,500.0CH2,6803.8H2O]g htox=211.0
Rc=14.13813cm,53419.6,Rs=31.95515cm
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
'Maximum mass of water from Kaolite = 9008.546 g'
'                             CHECK=> 9008.671 g'
'Minimum mass of water from Kaolite = 2204.715 g'
'                             CHECK=> 2204.746 g'
'Mass of kao from Kaolite = 51214.88 g'
'                             CHECK=> 51214.34 g'
' '
'Calculate the mass of water contained in the homogenized region'
'Mass of fm in homogenized region   = 15763.3703 g'
'Mass of poly in homogenized region =  500.00000 g'
'Mass of h2o in homogenized region  = 6803.83024 g'
'Mass of homogenized region         = 23067.2006 g'
'Vol of homogenized fm              = 4478.03940 cm3'
'Vol of poly                        =  543.47826 cm3'
'Vol of h2o                         = 6816.09922 cm3'
'Volume of homogenized region       = 11837.6168 cm3'
'Calculate HTOX ratio for use of 500.0 grams can pads,vinyl tape, polyethylene in CV'
'hydrogen to fissile uranium ratio  = 211.0335'
' '
```

```
'Mass of h2o in shell region        = 2204.71543 g'
'Mass of kao in shell region        = 51214.8849 g'
'Mass of kaolite in shell           = 53419.6003 g'
'Volume of kaolite in shell region  = 124843.000 cm3'
read geometry
global
unit 1001
'homogenized UZrHx/poly/excess water, wet-Kaolite shell, 20.0 cm refl'
sphere  1  1  14.13813  com='HEU core/water mixture'
sphere  2  1  31.95515  com='radius of kaolite shell'
sphere  8  1  51.95515  com='20.0 cm water reflector'
end geometry
end data
end
```

6.9.7.57 Case athopw15kr70_5

```
=csas25    parm=size=300000
athopw15kr70,[1995.7u3o8al, 408.0U235,500.0CH2,6803.8H2O]g
htox=476.3,Rc=12.36884cm,53419.6,Rs=31.64738cm
238groupndf5 multiregion
'U3O8Al= 1995.7g poly=500.0g cont.hx=41.1 Kao H2O=  6803.8g, homgcore hx=476.3'
'Rc=12.36884cm,53419.6,Rs=31.64738cm'
arbmTHAR   3.52095   4 0 0 0   8016    5.28002
                              13027   65.51412
                              92235   20.44410
                              92238    8.76176   1  0.0715  293  end
arbmpoly   0.92000   2 0 0 0   1001   14.3798
                               6012   85.6202    1  0.0686  293  end
arbmkh2o   0.9982    2 0 0 0   1001   11.1913
                               8016   88.8087    1  8.5993e-01    293  end
'kaolite 1600 shell'
arbmh2ok 1.7660e-02  2 0 0 0   1001   11.1913
                               8016   88.8087    2  1.000   293  end
arbmal2o3  0.41023   2 0 0 0   13027   52.9390
                               8016   47.0610    2  0.096   293  end
arbmsio2   0.41023   2 0 0 0   14000   46.7570
                               8016   53.2430    2  0.367   293  end
arbmfe2o3  0.41023   2 0 0 0   26000   69.9540
                               8016   30.0460    2  0.067   293  end
arbmtio2   0.41023   2 0 0 0   22000   59.9535
                               8016   40.0465    2  0.012   293  end
arbmcao    0.41023   2 0 0 0   20000   71.4815
                               8016   28.5185    2  0.307   293  end
arbmmgo    0.41023   2 0 0 0   12000   60.3169
                               8016   39.6831    2  0.131   293  end
arbmna2o   0.41023   2 0 0 0   11023   74.1961
                               8016   25.8039    2  0.020   293  end
'flooded containment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: cv body, lower flange, upper flange, drum liner'
ss304                                          4  1.0     293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
```

```
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                               8016   88.8087    5  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                               8016   47.0610    5  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                               8016   53.2430    5  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                               8016   30.0460    5  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                               8016   40.0465    5  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                               8016   28.5185    5  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                               8016   39.6831    5  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                               8016   25.8039    5  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087    6  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610    6  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430    6  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460    6  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465    6  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185    6  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831    6  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039    6  0.020   293  end
'kaolite 1600 combined'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.191224*0.51655,  for rest = 1.191224*0.34438'
'den.mult= 1.48716e5 cm3 (actual vol.) / 1.24843e5 cm3 (model vol.)'
'actual body vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'actual plug vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
'total Kaolite volume=1.48716e5 cm3 =  1.36557e5 + 1.21592e4 cm3'
'model body vol.= 1.12246e5 cm3'
'model plug vol.= 1.25970e4 cm3'
'total model volume=1.24843e5 cm3 =  1.12246e5 + 1.25970e4 cm3'
'grams water in wet-Kaolite = 9008.5737 = 6803.85 + 2204.7237 g'
'density of water in wet-Kaolite = 0.07216 g/cm3 = 9008.5737/1.24843e5'
'grams water in baked-dry Kaolite = 2204.7237 g'
'density of water in baked-dry Kaolite = 0.01766 = 2204.7237/1.24843e5'
'VF for water in baked-dry Kaolite = 0.244736 = 2204.7237/9008.5737'
arbmh2ok   0.07216  2 0 0 0    1001   11.1913
                               8016   88.8087    7  1.000   293  end
arbmal2o3  0.41023  2 0 0 0   13027   52.9390
                               8016   47.0610    7  0.096   293  end
arbmsio2   0.41023  2 0 0 0   14000   46.7570
                               8016   53.2430    7  0.367   293  end
arbmfe2o3  0.41023  2 0 0 0   26000   69.9540
                               8016   30.0460    7  0.067   293  end
```

```
arbmtio2   0.41023  2 0 0 0   22000   59.9535
                              8016   40.0465    7  0.012   293  end
arbmcao    0.41023  2 0 0 0   20000   71.4815
                              8016   28.5185    7  0.307   293  end
arbmmgo    0.41023  2 0 0 0   12000   60.3169
                              8016   39.6831    7  0.131   293  end
arbmna2o   0.41023  2 0 0 0   11023   74.1961
                              8016   25.8039    7  0.020   293  end
'reflective water'
arbmh2or   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    8  1.0000  293  end
end comp
spherical end
1  12.36884
2  31.64738
8  51.64738
end zone
athopw15kr70,[1995.7u3o8al, 408.0U235,500.0CH2,6803.8H2O]g htox=476.3
Rc=12.36884cm,53419.6,Rs=31.64738cm
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
'Maximum mass of water from Kaolite = 9008.546 g'
'                             CHECK=> 9008.671 g'
'Minimum mass of water from Kaolite = 2204.715 g'
'                             CHECK=> 2204.746 g'
'Mass of kao from Kaolite = 51214.88 g'
'                             CHECK=> 51214.34 g'
' '
'Calculate the mass of water contained in the homogenized region'
'Mass of fm in homogenized region   = 1995.70127 g'
'Mass of poly in homogenized region =  500.00000 g'
'Mass of h2o in homogenized region  = 6803.83024 g'
'Mass of homogenized region         = 9299.53151 g'
'Vol of homogenized fm              =  566.80762 cm3'
'Vol of poly                        =  543.47826 cm3'
'Vol of h2o                         = 6816.09922 cm3'
'Volume of homogenized region       = 7926.38510 cm3'
'Calculate HTOX ratio for use of 500.0 grams can pads,vinyl tape, polyethylene in CV'
'hydrogen to fissile uranium ratio  = 476.3597'
' '
'Mass of h2o in shell region        = 2204.71543 g'
'Mass of kao in shell region        = 51214.8849 g'
'Mass of kaolite in shell           = 53419.6003 g'
'Volume of kaolite in shell region  = 124843.000 cm3'
read geometry
global
unit 1001
'homogenized UZrHx/poly/excess water, wet-Kaolite shell, 20.0 cm refl'
sphere  1  1  12.36884  com='HEU core/water mixture'
sphere  2  1  31.64738  com='radius of kaolite shell'
sphere  8  1  51.64738  com='20.0 cm water reflector'
end geometry
end data
end
```

6.9.7.58 Case athopw15kr93_5

```
=csas25    parm=size=300000
athopw15kr93,[1505.0u3o8al, 408.0U235,500.0CH2,6803.8H2O]g
htox=476.3,Rc=12.29589cm,53419.6,Rs=31.63630cm
238groupndf5 multiregion
'U3O8Al= 1505.0g poly=500.0g cont.hx=41.1 Kao H2O=  6803.8g, homgcore hx=476.3'
```

```
'Rc=12.29589cm,53419.6,Rs=31.63630cm'
arbmTHAR   3.52132   4 0 0 0   8016    5.29500
                              13027   65.50220
                              92235   27.21701
                              92238    1.98579   1  0.0549  293  end
arbmpoly   0.92000   2 0 0 0   1001   14.3798
                               6012   85.6202    1  0.0698  293  end
arbmkh2o   0.9982    2 0 0 0   1001   11.1913
                               8016   88.8087    1  8.7532e-01    293  end
'kaolite 1600 shell'
arbmh2ok 1.7660e-02  2 0 0 0   1001   11.1913
                               8016   88.8087    2  1.000   293  end
arbmal2o3  0.41023   2 0 0 0   13027   52.9390
                               8016   47.0610    2  0.096   293  end
arbmsio2   0.41023   2 0 0 0   14000   46.7570
                               8016   53.2430    2  0.367   293  end
arbmfe2o3  0.41023   2 0 0 0   26000   69.9540
                               8016   30.0460    2  0.067   293  end
arbmtio2   0.41023   2 0 0 0   22000   59.9535
                               8016   40.0465    2  0.012   293  end
arbmcao    0.41023   2 0 0 0   20000   71.4815
                               8016   28.5185    2  0.307   293  end
arbmmgo    0.41023   2 0 0 0   12000   60.3169
                               8016   39.6831    2  0.131   293  end
arbmna2o   0.41023   2 0 0 0   11023   74.1961
                               8016   25.8039    2  0.020   293  end
'flooded containment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: cv body, lower flange, upper flange, drum liner'
ss304                                             4  1.0     293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                               8016   88.8087    5  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                               8016   47.0610    5  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                               8016   53.2430    5  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                               8016   30.0460    5  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                               8016   40.0465    5  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                               8016   28.5185    5  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                               8016   39.6831    5  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                               8016   25.8039    5  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
```

```
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087    6  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610    6  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430    6  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460    6  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465    6  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185    6  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831    6  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039    6  0.020   293  end
'kaolite 1600 combined'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.191224*0.51655,  for rest = 1.191224*0.34438'
'den.mult= 1.48716e5 cm3 (actual vol.) / 1.24843e5 cm3 (model vol.)'
'actual body vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'actual plug vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
'total Kaolite volume=1.48716e5 cm3 =  1.36557e5 + 1.21592e4 cm3'
'model body vol.= 1.12246e5 cm3'
'model plug vol.= 1.25970e4 cm3'
'total model volume=1.24843e5 cm3 =  1.12246e5 + 1.25970e4 cm3'
'grams water in wet-Kaolite = 9008.5737 = 6803.85 + 2204.7237 g'
'density of water in wet-Kaolite = 0.07216 g/cm3 = 9008.5737/1.24843e5'
'grams water in baked-dry Kaolite = 2204.7237 g'
'density of water in baked-dry Kaolite = 0.01766 = 2204.7237/1.24843e5'
'VF for water in baked-dry Kaolite = 0.244736 = 2204.7237/9008.5737'
arbmh2ok   0.07216  2 0 0 0    1001   11.1913
                              8016   88.8087    7  1.000   293  end
arbmal2o3  0.41023  2 0 0 0   13027   52.9390
                              8016   47.0610    7  0.096   293  end
arbmsio2   0.41023  2 0 0 0   14000   46.7570
                              8016   53.2430    7  0.367   293  end
arbmfe2o3  0.41023  2 0 0 0   26000   69.9540
                              8016   30.0460    7  0.067   293  end
arbmtio2   0.41023  2 0 0 0   22000   59.9535
                              8016   40.0465    7  0.012   293  end
arbmcao    0.41023  2 0 0 0   20000   71.4815
                              8016   28.5185    7  0.307   293  end
arbmmgo    0.41023  2 0 0 0   12000   60.3169
                              8016   39.6831    7  0.131   293  end
arbmna2o   0.41023  2 0 0 0   11023   74.1961
                              8016   25.8039    7  0.020   293  end
'reflective water'
arbmh2or   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    8  1.0000  293  end
end comp
spherical end
1  12.29589
2  31.63630
8  51.63630
end zone
athopw15kr93,[1505.0u3o8al, 408.0U235,500.0CH2,6803.8H2O]g htox=476.3
Rc=12.29589cm,53419.6,Rs=31.63630cm
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
'Maximum mass of water from Kaolite = 9008.546 g'
'                           CHECK=> 9008.671 g'
```

```
'Minimum mass of water from Kaolite = 2204.715 g'
'                            CHECK=> 2204.746 g'
'Mass of kao from Kaolite = 51214.88 g'
'                            CHECK=> 51214.34 g'
' '
'Calculate the mass of water contained in the homogenized region'
'Mass of fm in homogenized region   = 1505.00732 g'
'Mass of poly in homogenized region =  500.00000 g'
'Mass of h2o in homogenized region  = 6803.83024 g'
'Mass of homogenized region         = 8808.83756 g'
'Vol of homogenized fm              =  427.39862 cm3'
'Vol of poly                        =  543.47826 cm3'
'Vol of h2o                         = 6816.09922 cm3'
'Volume of homogenized region       = 7786.97610 cm3'
'Calculate HTOX ratio for use of 500.0 grams can pads,vinyl tape, polyethylene in CV'
'hydrogen to fissile uranium ratio  = 476.3681'
' '
'Mass of h2o in shell region        = 2204.71543 g'
'Mass of kao in shell region        = 51214.8849 g'
'Mass of kaolite in shell           = 53419.6003 g'
'Volume of kaolite in shell region  = 124843.000 cm3'
read geometry
global
unit 1001
'homogenized UZrHx/poly/excess water, wet-Kaolite shell, 20.0 cm refl'
sphere  1  1  12.29589  com='HEU core/water mixture'
sphere  2  1  31.63630  com='radius of kaolite shell'
sphere  8  1  51.63630  com='20.0 cm water reflector'
end geometry
end data
end
```

6.9.7.59 Case athupw15kr93_5

```
=csas25    parm=size=300000
athupw15kr93,[ 920.5UO2MgAl, 408.0U235,500.0CH2,6803.8H2O]g
htox=476.3,Rc=12.25670cm,53419.6,Rs=31.63040cm
238groupndf5 multiregion
'UO2MgAl=  920.5g, poly=500.0g cont.hx=41.1 Kao H2O=  6803.8g, homgcore hx=476.3'
'Rc=12.25670cm,53419.6,Rs=31.63040cm'
arbmuo2mgal  2.60651  5 0 0 0  8016    6.46696
                              12000    7.61234
                              13027   38.36549
                              92235   44.32146
                              92238    3.23375   1  0.0458  293  end
arbmpoly   0.92000   2 0 0 0   1001   14.3798
                               6012   85.6202    1  0.0705  293  end
arbmkh2o   0.9982    2 0 0 0   1001   11.1913
                               8016   88.8087    1  8.8374e-01    293  end
'kaolite 1600 shell'
arbmh2ok 1.7660e-02  2 0 0 0   1001   11.1913
                               8016   88.8087    2  1.000   293  end
arbmal2o3  0.41023   2 0 0 0   13027   52.9390
                               8016   47.0610    2  0.096   293  end
arbmsio2   0.41023   2 0 0 0   14000   46.7570
                               8016   53.2430    2  0.367   293  end
arbmfe2o3  0.41023   2 0 0 0   26000   69.9540
                               8016   30.0460    2  0.067   293  end
arbmtio2   0.41023   2 0 0 0   22000   59.9535
                               8016   40.0465    2  0.012   293  end
arbmcao    0.41023   2 0 0 0   20000   71.4815
```

```
                              8016   28.5185    2  0.307   293  end
arbmmgo    0.41023   2 0 0 0   12000   60.3169
                              8016   39.6831    2  0.131   293  end
arbmna2o   0.41023   2 0 0 0   11023   74.1961
                              8016   25.8039    2  0.020   293  end
'flooded containment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    3  1.0     293  end
'steel: cv body, lower flange, upper flange, drum liner'
ss304                                           4  1.0     293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                              8016   88.8087    5  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                              8016   47.0610    5  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                              8016   53.2430    5  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                              8016   30.0460    5  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                              8016   40.0465    5  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                              8016   28.5185    5  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                              8016   39.6831    5  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                              8016   25.8039    5  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087    6  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610    6  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430    6  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460    6  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465    6  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185    6  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831    6  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039    6  0.020   293  end
'kaolite 1600 combined'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.191224*0.51655,  for rest = 1.191224*0.34438'
'den.mult= 1.48716e5 cm3 (actual vol.) / 1.24843e5 cm3 (model vol.)'
'actual body vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
```

```
'actual plug vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
'total Kaolite volume=1.48716e5 cm3 =  1.36557e5 + 1.21592e4 cm3'
'model body vol.= 1.12246e5 cm3'
'model plug vol.= 1.25970e4 cm3'
'total model volume=1.24843e5 cm3 =  1.12246e5 + 1.25970e4 cm3'
'grams water in wet-Kaolite = 9008.5737 = 6803.85 + 2204.7237 g'
'density of water in wet-Kaolite = 0.07216 g/cm3 = 9008.5737/1.24843e5'
'grams water in baked-dry Kaolite = 2204.7237 g'
'density of water in baked-dry Kaolite = 0.01766 = 2204.7237/1.24843e5'
'VF for water in baked-dry Kaolite = 0.244736 = 2204.7237/9008.5737'
arbmh2ok   0.07216  2 0 0 0    1001   11.1913
                               8016   88.8087    7  1.000   293  end
arbmal2o3  0.41023  2 0 0 0   13027   52.9390
                               8016   47.0610    7  0.096   293  end
arbmsio2   0.41023  2 0 0 0   14000   46.7570
                               8016   53.2430    7  0.367   293  end
arbmfe2o3  0.41023  2 0 0 0   26000   69.9540
                               8016   30.0460    7  0.067   293  end
arbmtio2   0.41023  2 0 0 0   22000   59.9535
                               8016   40.0465    7  0.012   293  end
arbmcao    0.41023  2 0 0 0   20000   71.4815
                               8016   28.5185    7  0.307   293  end
arbmmgo    0.41023  2 0 0 0   12000   60.3169
                               8016   39.6831    7  0.131   293  end
arbmna2o   0.41023  2 0 0 0   11023   74.1961
                               8016   25.8039    7  0.020   293  end
'reflective water'
arbmh2or   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    8  1.0000  293  end
end comp
spherical end
1  12.25670
2  31.63040
8  51.63040
end zone
athupw15kr93,[ 920.5UO2MgAl, 408.0U235,500.0CH2,6803.8H2O]g htox=476.3
Rc=12.25670cm,53419.6,Rs=31.63040cm
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
'Maximum mass of water from Kaolite = 9008.546 g'
'                             CHECK=> 9008.671 g'
'Minimum mass of water from Kaolite = 2204.715 g'
'                             CHECK=> 2204.746 g'
'Mass of kao from Kaolite = 51214.88 g'
'                             CHECK=> 51214.34 g'
' '
'Calculate the mass of water contained in the homogenized region'
'Mass of fm in homogenized region   =  920.54928 g'
'Mass of poly in homogenized region =  500.00000 g'
'Mass of h2o in homogenized region  = 6803.83024 g'
'Mass of homogenized region         = 8224.37952 g'
'Vol of homogenized fm              =  353.17312 cm3'
'Vol of poly                        =  543.47826 cm3'
'Vol of h2o                         = 6816.09922 cm3'
'Volume of homogenized region       = 7712.75060 cm3'
'Calculate HTOX ratio for use of 500.0 grams can pads,vinyl tape, polyethylene in CV'
'hydrogen to fissile uranium ratio  = 476.3624'
' '
'Mass of h2o in shell region        = 2204.71543 g'
'Mass of kao in shell region        = 51214.8849 g'
'Mass of kaolite in shell           = 53419.6003 g'
'Volume of kaolite in shell region  = 124843.000 cm3'
```

```
read geometry
global
unit 1001
'homogenized UZrHx/poly/excess water, wet-Kaolite shell, 20.0 cm refl'
sphere  1  1  12.25670  com='HEU core/water mixture'
sphere  2  1  31.63040  com='radius of kaolite shell'
sphere  8  1  51.63040  com='20.0 cm water reflector'
end geometry
end data
end
```

6.9.7.60 Case athupw15kr20_5

```
=csas25    parm=size=300000
athupw15kr20,[9677.7UO2MgAl, 921.0U235,500.0CH2,6803.8H2O]g
htox=211.0,Rc=13.27685cm,53419.6,Rs=31.79582cm
238groupndf5 multiregion
'UO2MgAl= 9677.7g, poly=500.0g cont.hx=18.2 Kao H2O=  6803.8g, homgcore hx=211.0'
'Rc=13.27685cm,53419.6,Rs=31.79582cm'
arbmuo2mgal  3.96017  5 0 0 0  8016    6.41096
                              12000    7.61690
                              13027   38.38846
                              92235    9.51674
                              92238   38.06695   1  0.2493  293  end
arbmpoly   0.92000   2 0 0 0   1001   14.3798
                               6012   85.6202    1  0.0554  293  end
arbmkh2o   0.9982    2 0 0 0   1001   11.1913
                               8016   88.8087    1  6.9528e-01    293  end
'kaolite 1600 shell'
arbmh2ok 1.7660e-02  2 0 0 0   1001   11.1913
                               8016   88.8087    2  1.000   293  end
arbmal2o3  0.41023   2 0 0 0   13027   52.9390
                               8016   47.0610    2  0.096   293  end
arbmsio2   0.41023   2 0 0 0   14000   46.7570
                               8016   53.2430    2  0.367   293  end
arbmfe2o3  0.41023   2 0 0 0   26000   69.9540
                               8016   30.0460    2  0.067   293  end
arbmtio2   0.41023   2 0 0 0   22000   59.9535
                               8016   40.0465    2  0.012   293  end
arbmcao    0.41023   2 0 0 0   20000   71.4815
                               8016   28.5185    2  0.307   293  end
arbmmgo    0.41023   2 0 0 0   12000   60.3169
                               8016   39.6831    2  0.131   293  end
arbmna2o   0.41023   2 0 0 0   11023   74.1961
                               8016   25.8039    2  0.020   293  end
'flooded containment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1.0     293  end
'steel: cv body, lower flange, upper flange, drum liner'
ss304                                          4  1.0     293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                               8016   88.8087    5  0.0287  293  end
```

```
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                               8016   47.0610    5  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                               8016   53.2430    5  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                               8016   30.0460    5  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                               8016   40.0465    5  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                               8016   28.5185    5  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                               8016   39.6831    5  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                               8016   25.8039    5  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087    6  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610    6  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430    6  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460    6  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465    6  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185    6  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831    6  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039    6  0.020   293  end
'kaolite 1600 combined'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.191224*0.51655,  for rest = 1.191224*0.34438'
'den.mult= 1.48716e5 cm3 (actual vol.) / 1.24843e5 cm3 (model vol.)'
'actual body vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'actual plug vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
'total Kaolite volume=1.48716e5 cm3 =  1.36557e5 + 1.21592e4 cm3'
'model body vol.= 1.12246e5 cm3'
'model plug vol.= 1.25970e4 cm3'
'total model volume=1.24843e5 cm3 =  1.12246e5 + 1.25970e4 cm3'
'grams water in wet-Kaolite = 9008.5737 = 6803.85 + 2204.7237 g'
'density of water in wet-Kaolite = 0.07216 g/cm3 = 9008.5737/1.24843e5'
'grams water in baked-dry Kaolite = 2204.7237 g'
'density of water in baked-dry Kaolite = 0.01766 = 2204.7237/1.24843e5'
'VF for water in baked-dry Kaolite = 0.244736 = 2204.7237/9008.5737'
arbmh2ok   0.07216  2 0 0 0    1001   11.1913
                               8016   88.8087    7  1.000   293  end
arbmal2o3  0.41023  2 0 0 0   13027   52.9390
                               8016   47.0610    7  0.096   293  end
arbmsio2   0.41023  2 0 0 0   14000   46.7570
                               8016   53.2430    7  0.367   293  end
arbmfe2o3  0.41023  2 0 0 0   26000   69.9540
                               8016   30.0460    7  0.067   293  end
arbmtio2   0.41023  2 0 0 0   22000   59.9535
                               8016   40.0465    7  0.012   293  end
arbmcao    0.41023  2 0 0 0   20000   71.4815
```

```
                              8016   28.5185    7  0.307   293  end
arbmmgo    0.41023  2 0 0 0   12000   60.3169
                              8016   39.6831    7  0.131   293  end
arbmna2o   0.41023  2 0 0 0   11023   74.1961
                              8016   25.8039    7  0.020   293  end
'reflective water'
arbmh2or   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    8  1.0000  293  end
end comp
spherical end
1  13.27685
2  31.79582
8  51.79582
end zone
athupw15kr20,[9677.7UO2MgAl, 921.0U235,500.0CH2,6803.8H2O]g htox=211.0
Rc=13.27685cm,53419.6,Rs=31.79582cm
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
'Maximum mass of water from Kaolite = 9008.546 g'
'                             CHECK=> 9008.671 g'
'Minimum mass of water from Kaolite = 2204.715 g'
'                             CHECK=> 2204.746 g'
'Mass of kao from Kaolite = 51214.88 g'
'                             CHECK=> 51214.34 g'
' '
'Calculate the mass of water contained in the homogenized region'
'Mass of fm in homogenized region   = 9677.70171 g'
'Mass of poly in homogenized region =  500.00000 g'
'Mass of h2o in homogenized region  = 6803.83024 g'
'Mass of homogenized region         = 16981.5319 g'
'Vol of homogenized fm              = 2443.75916 cm3'
'Vol of poly                        =  543.47826 cm3'
'Vol of h2o                         = 6816.09922 cm3'
'Volume of homogenized region       = 9803.33664 cm3'
'Calculate HTOX ratio for use of 500.0 grams can pads,vinyl tape, polyethylene in CV'
'hydrogen to fissile uranium ratio  = 211.0271'
' '
'Mass of h2o in shell region        = 2204.71543 g'
'Mass of kao in shell region        = 51214.8849 g'
'Mass of kaolite in shell           = 53419.6003 g'
'Volume of kaolite in shell region  = 124843.000 cm3'
read geometry
global
unit 1001
'homogenized UZrHx/poly/excess water, wet-Kaolite shell, 20.0 cm refl'
sphere  1  1  13.27685  com='HEU core/water mixture'
sphere  2  1  31.79582  com='radius of kaolite shell'
sphere  8  1  51.79582  com='20.0 cm water reflector'
end geometry
end data
end
```

6.9.7.61 Case athupw15kr09_5

```
=csas25    parm=size=300000
athupw15kr09,[19592.UO2MgAl, 922.0U235,500.0CH2,6803.8H2O]g
htox=210.7,Rc=14.32268cm,53419.6,Rs=31.99170cm
238groupndf5 multiregion
'UO2MgAl=19592.0g, poly=500.0g cont.hx=18.1 Kao H2O=  6803.8g, homgcore hx=210.7'
'Rc=14.32268cm,53419.6,Rs=31.99170cm'
arbmuo2mgal  3.95984  5 0 0 0  8016    6.40322
                              12000    7.61753
```

```
                              13027   38.39164
                              92235    4.70615
                              92238   42.88147   1  0.4020  293  end
arbmpoly   0.92000   2 0 0 0   1001   14.3798
                              6012   85.6202    1  0.0442  293  end
arbmkh2o   0.9982    2 0 0 0   1001   11.1913
                              8016   88.8087    1  5.5383e-01    293  end
'kaolite 1600 shell'
arbmh2ok 1.7660e-02  2 0 0 0   1001   11.1913
                              8016   88.8087    2  1.000   293  end
arbmal2o3  0.41023   2 0 0 0   13027   52.9390
                              8016   47.0610    2  0.096   293  end
arbmsio2   0.41023   2 0 0 0   14000   46.7570
                              8016   53.2430    2  0.367   293  end
arbmfe2o3  0.41023   2 0 0 0   26000   69.9540
                              8016   30.0460    2  0.067   293  end
arbmtio2   0.41023   2 0 0 0   22000   59.9535
                              8016   40.0465    2  0.012   293  end
arbmcao    0.41023   2 0 0 0   20000   71.4815
                              8016   28.5185    2  0.307   293  end
arbmmgo    0.41023   2 0 0 0   12000   60.3169
                              8016   39.6831    2  0.131   293  end
arbmna2o   0.41023   2 0 0 0   11023   74.1961
                              8016   25.8039    2  0.020   293  end
'flooded containment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    3  1.0     293  end
'steel: cv body, lower flange, upper flange, drum liner'
ss304                                           4  1.0     293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                              8016   88.8087    5  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                              8016   47.0610    5  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                              8016   53.2430    5  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                              8016   30.0460    5  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                              8016   40.0465    5  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                              8016   28.5185    5  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                              8016   39.6831    5  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                              8016   25.8039    5  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087    6  0.0287  293  end
```

```
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610    6  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430    6  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460    6  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465    6  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185    6  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831    6  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039    6  0.020   293  end
'kaolite 1600 combined'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.191224*0.51655,  for rest = 1.191224*0.34438'
'den.mult= 1.48716e5 cm3 (actual vol.) / 1.24843e5 cm3 (model vol.)'
'actual body vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'actual plug vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
'total Kaolite volume=1.48716e5 cm3 =  1.36557e5 + 1.21592e4 cm3'
'model body vol.= 1.12246e5 cm3'
'model plug vol.= 1.25970e4 cm3'
'total model volume=1.24843e5 cm3 =  1.12246e5 + 1.25970e4 cm3'
'grams water in wet-Kaolite = 9008.5737 = 6803.85 + 2204.7237 g'
'density of water in wet-Kaolite = 0.07216 g/cm3 = 9008.5737/1.24843e5'
'grams water in baked-dry Kaolite = 2204.7237 g'
'density of water in baked-dry Kaolite = 0.01766 = 2204.7237/1.24843e5'
'VF for water in baked-dry Kaolite = 0.244736 = 2204.7237/9008.5737'
arbmh2ok   0.07216  2 0 0 0    1001   11.1913
                              8016   88.8087    7  1.000   293  end
arbmal2o3  0.41023  2 0 0 0   13027   52.9390
                              8016   47.0610    7  0.096   293  end
arbmsio2   0.41023  2 0 0 0   14000   46.7570
                              8016   53.2430    7  0.367   293  end
arbmfe2o3  0.41023  2 0 0 0   26000   69.9540
                              8016   30.0460    7  0.067   293  end
arbmtio2   0.41023  2 0 0 0   22000   59.9535
                              8016   40.0465    7  0.012   293  end
arbmcao    0.41023  2 0 0 0   20000   71.4815
                              8016   28.5185    7  0.307   293  end
arbmmgo    0.41023  2 0 0 0   12000   60.3169
                              8016   39.6831    7  0.131   293  end
arbmna2o   0.41023  2 0 0 0   11023   74.1961
                              8016   25.8039    7  0.020   293  end
'reflective water'
arbmh2or   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    8  1.0000  293  end
end comp
spherical end
1  14.32268
2  31.99170
8  51.99170
end zone
athupw15kr09,[19592.UO2MgAl, 922.0U235,500.0CH2,6803.8H2O]g htox=210.7
Rc=14.32268cm,53419.6,Rs=31.99170cm
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
'Maximum mass of water from Kaolite = 9008.546 g'
'                             CHECK=> 9008.671 g'
'Minimum mass of water from Kaolite = 2204.715 g'
'                             CHECK=> 2204.746 g'
```

```
'Mass of kao from Kaolite = 51214.88 g'
'                            CHECK=> 51214.34 g'
' '
'Calculate the mass of water contained in the homogenized region'
'Mass of fm in homogenized region   = 19592.0397 g'
'Mass of poly in homogenized region =  500.00000 g'
'Mass of h2o in homogenized region  = 6803.83024 g'
'Mass of homogenized region         = 26895.8699 g'
'Vol of homogenized fm              = 4947.68469 cm3'
'Vol of poly                        =  543.47826 cm3'
'Vol of h2o                         = 6816.09922 cm3'
'Volume of homogenized region       = 12307.2621 cm3'
'Calculate HTOX ratio for use of 500.0 grams can pads,vinyl tape, polyethylene in CV'
'hydrogen to fissile uranium ratio  = 210.7918'
' '
'Mass of h2o in shell region        = 2204.71543 g'
'Mass of kao in shell region        = 51214.8849 g'
'Mass of kaolite in shell           = 53419.6003 g'
'Volume of kaolite in shell region  = 124843.000 cm3'
read geometry
global
unit 1001
'homogenized UZrHx/poly/excess water, wet-Kaolite shell, 20.0 cm refl'
sphere  1  1  14.32268  com='HEU core/water mixture'
sphere  2  1  31.99170  com='radius of kaolite shell'
sphere  8  1  51.99170  com='20.0 cm water reflector'
end geometry
end data
end
```

6.9.7.62 Case athbpw15kr93_5

```
=csas25    parm=size=300000
athbpw15kr93,[ 497.3uo2, 408.0U235,500.0CH2,6803.8H2O]g
htox=476.3,Rc=12.10567cm,53419.6,Rs=31.60798cm
238groupndf5 multiregion
'UO2=  497.3g poly=500.0g cont.hx=41.1 Kao H2O=  6803.8g, homgcore hx=476.3'
'Rc=12.10567cm,53419.6,Rs=31.60798cm'
arbmUO2   6.95000   3 0 0 0   8016   11.97094
                              92235   82.04308
                              92238    5.98598   1  9.6289e-03    293  end
arbmpoly   0.92000   2 0 0 0   1001   14.3798
                               6012   85.6202    1  7.3135e-02    293  end
arbmkh2o   0.9982    2 0 0 0   1001   11.1913
                               8016   88.8087    1  9.1724e-01    293  end
'kaolite 1600 shell'
arbmh2ok 1.7660e-02  2 0 0 0   1001   11.1913
                               8016   88.8087    2  1.000   293  end
arbmal2o3  0.41023   2 0 0 0   13027   52.9390
                               8016   47.0610    2  0.096   293  end
arbmsio2   0.41023   2 0 0 0   14000   46.7570
                               8016   53.2430    2  0.367   293  end
arbmfe2o3  0.41023   2 0 0 0   26000   69.9540
                               8016   30.0460    2  0.067   293  end
arbmtio2   0.41023   2 0 0 0   22000   59.9535
                               8016   40.0465    2  0.012   293  end
arbmcao    0.41023   2 0 0 0   20000   71.4815
                               8016   28.5185    2  0.307   293  end
arbmmgo    0.41023   2 0 0 0   12000   60.3169
                               8016   39.6831    2  0.131   293  end
arbmna2o   0.41023   2 0 0 0   11023   74.1961
```

```
                              8016   25.8039    2  0.020   293  end
'flooded containment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087    3  1.0     293  end
'steel: cv body, lower flange, upper flange, drum liner'
ss304                                           4  1.0     293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                              8016   88.8087    5  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                              8016   47.0610    5  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                              8016   53.2430    5  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                              8016   30.0460    5  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                              8016   40.0465    5  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                              8016   28.5185    5  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                              8016   39.6831    5  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                              8016   25.8039    5  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087    6  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610    6  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430    6  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460    6  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465    6  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185    6  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831    6  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039    6  0.020   293  end
'kaolite 1600 combined'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.191224*0.51655,  for rest = 1.191224*0.34438'
'den.mult= 1.48716e5 cm3 (actual vol.) / 1.24843e5 cm3 (model vol.)'
'actual body vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'actual plug vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
'total Kaolite volume=1.48716e5 cm3 =  1.36557e5 + 1.21592e4 cm3'
'model body vol.= 1.12246e5 cm3'
'model plug vol.= 1.25970e4 cm3'
```

```
'total model volume=1.24843e5 cm3 =  1.12246e5 + 1.25970e4 cm3'
'grams water in wet-Kaolite = 9008.5737 = 6803.85 + 2204.7237 g'
'density of water in wet-Kaolite = 0.07216 g/cm3 = 9008.5737/1.24843e5'
'grams water in baked-dry Kaolite = 2204.7237 g'
'density of water in baked-dry Kaolite = 0.01766 = 2204.7237/1.24843e5'
'VF for water in baked-dry Kaolite = 0.244736 = 2204.7237/9008.5737'
arbmh2ok   0.07216  2 0 0 0    1001   11.1913
                               8016   88.8087    7  1.000   293  end
arbmal2o3  0.41023  2 0 0 0   13027   52.9390
                               8016   47.0610    7  0.096   293  end
arbmsio2   0.41023  2 0 0 0   14000   46.7570
                               8016   53.2430    7  0.367   293  end
arbmfe2o3  0.41023  2 0 0 0   26000   69.9540
                               8016   30.0460    7  0.067   293  end
arbmtio2   0.41023  2 0 0 0   22000   59.9535
                               8016   40.0465    7  0.012   293  end
arbmcao    0.41023  2 0 0 0   20000   71.4815
                               8016   28.5185    7  0.307   293  end
arbmmgo    0.41023  2 0 0 0   12000   60.3169
                               8016   39.6831    7  0.131   293  end
arbmna2o   0.41023  2 0 0 0   11023   74.1961
                               8016   25.8039    7  0.020   293  end
'reflective water'
arbmh2or   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    8  1.0000  293  end
end comp
spherical end
1  12.10567
2  31.60798
8  51.60798
end zone
athbpw15kr93,[ 497.3uo2, 408.0U235,500.0CH2,6803.8H2O]g htox=476.3
Rc=12.10567cm,53419.6,Rs=31.60798cm
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
'Maximum mass of water from Kaolite = 9008.546 g'
'                             CHECK=> 9008.671 g'
'Minimum mass of water from Kaolite = 2204.715 g'
'                             CHECK=> 2204.746 g'
'Mass of kao from Kaolite = 51214.88 g'
'                             CHECK=> 51214.34 g'
' '
'Calculate the mass of water contained in the homogenized region'
'Mass of fm in homogenized region   =  497.29842 g'
'Mass of poly in homogenized region =  500.00000 g'
'Mass of h2o in homogenized region  = 6803.83024 g'
'Mass of homogenized region         = 7801.12866 g'
'Vol of homogenized fm              =   71.55373 cm3'
'Vol of poly                        =  543.47826 cm3'
'Vol of h2o                         = 6816.09922 cm3'
'Volume of homogenized region       = 7431.13121 cm3'
'Calculate HTOX ratio for use of 500.0 grams can pads,vinyl tape, polyethylene in CV'
'hydrogen to fissile uranium ratio  = 476.3646'
' '
'Mass of h2o in shell region        = 2204.71543 g'
'Mass of kao in shell region        = 51214.8849 g'
'Mass of kaolite in shell           = 53419.6003 g'
'Volume of kaolite in shell region  = 124843.000 cm3'
read geometry
global
unit 1001
'homogenized UO2/poly/excess water, wet-Kaolite shell, 20.0 cm refl'
```

```
sphere  1  1  12.10567  com='HEU core/water mixture'
sphere  2  1  31.60798  com='radius of kaolite shell'
sphere  8  1  51.60798  com='20.0 cm water reflector'
end geometry
end data
end
```

6.9.7.63 Case cvcrcyat11_2_2

```
=csas25    parm=size=3000000
cvcrcyat11 3cyl,1.4in thk np,(30000.0g235, 7991.5gH2O hx=  6.95),sep=0.254,fr=1.0e+00
238groupndf5 infhommedium
'HEU volume =1594.80409, SPACER volume  614.68012'
'HEU wrapped dry content can hx=0.56, CV void volume 8005.87774'
uranium  1 den=18.81109 1.0 293      92235  100.00
                                     92238   0.000               end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.31846e4 cm3 = (8.0457422e2 in3)(16.387064)'
'den.multiplier = 1.31846e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.518047 = (den.mult)(np277-4 min.den.) = 0.9935052*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.26267e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.06375e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
```

```
arbmnph2o 3.81674e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                                 8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                                 8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                                 8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                                 8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                                 8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                                 8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                                 8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                                 8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                                 8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                                 8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                                 8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                                 8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                                 8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                                 8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                                 8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                                 8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                                 1001    8.1573
                                 8016   21.5782
                                14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                                 8016   88.8087   15  1       293  end
'steel: liner'
ss304                                            16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                            17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                            18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                            18  1.25705 293  end
```

```
'steel: drum steel for single units'
ss304                                          19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                          19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                               8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
cvcrcyat11 3cyl,1.4in thk np,(30000.0g235, 7991.5gH2O,hx=  6.95),sep=0.254,fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                        end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1006
'content (centered) [Elev= 8.955 in.]'
 cylinder  1  1    4.114800   10.12099   0.12700    com='cylindrical content'
 cylinder  3  1    6.426200   10.24849  -0.0005  com='cv well cavity'
 cylinder  8  1    6.680200   10.24849  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200   10.24849  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev=10.355 in.]'
 cylinder  2  1    5.24510     3.55610   0.0     com='np spacer'
 cylinder  3  1    6.426200    3.55620  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    3.55620  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    3.55620  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'37.85956             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   39.22944   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   39.22944   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   39.22944   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
```

```
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.64 Case cvcrcyat11_11_2

```
=csas25    parm=size=3000000
cvcrcyat11 3cyl,1.4in thk np,(30000.0g235, 7991.5gH2O hx=  6.95),sep=4.826,fr=1.0e+00
238groupndf5 infhommedium
'HEU volume =1594.80409, SPACER volume  614.68012'
'HEU wrapped dry content can hx=0.56, CV void volume 8005.87774'
uranium  1 den=18.81109 1.0 293      92235  100.00
                                     92238   0.000               end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
```

```
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.31846e4 cm3 = (8.0457422e2 in3)(16.387064)'
'den.multiplier = 1.31846e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.518047 = (den.mult)(np277-4 min.den.) = 0.9935052*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.26267e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.06375e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.81674e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                               8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
```

```
                              8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                              8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   21  1.0     293  end
end comp
cvcrcyat11 3cyl,1.4in thk np,(30000.0g235, 7991.5gH2O,hx=  6.95),sep=4.826,fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                       end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
```

```
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.920 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1006
'content (centered) [Elev=10.755 in.]'
 cylinder  1  1    4.114800   12.40699   2.41300    com='cylindrical content'
 cylinder  3  1    6.426200   14.82049  -0.0005  com='cv well cavity'
 cylinder  8  1    6.680200   14.82049  -0.0005  com='cv below 1st step'
 cuboid    21 1 4p24.587200   14.82049  -0.0005  com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev=12.155 in.]'
 cylinder  2  1    5.24510     3.55610   0.0     com='np spacer'
 cylinder  3  1    6.426200    3.55620  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    3.55620  -0.0001  com='cv below 1st step'
 cuboid    21 1 4p24.587200    3.55620  -0.0001  com='drum chine outer radius'
unit 1008
'top of content stack to bottom of 1st step [Elev=35.270 in.]'
'51.57556             stack height (content spacers)       CALCULATED
 cylinder  3  1    6.426200   25.51344   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   25.51344   0.0     com='cv below 1st step'
 cuboid    21 1 4p24.587200   25.51344   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
```

```
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1006 1007 1006 1007 1006 1008 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.65 Case cvcrpunhct11_10_15

```
=csas25    parm=size=3000000
cvcrpunhct11 10000.2gUNHc( 4709.7g235,2165.3gH2O) 6080.8gH2Ocv hx= 49.26 fr=1.0e+00
238groupndf5 infhommedium
'U(enr)O2(NO3)2+6H2O [2.81 g/cc for U(nat)]  2.79329 g/cm3, hx=12.0, gU/L= 461.0422'
'dry content (poly packed or wrapped) h/x=3.56, CV void volume 6091.80676 cm3'
arbmunh    2.79329  5 0 0 0   92235   47.0962
                              92238    0.0000
                               1001    2.4232
                               7014    5.6116
                               8016   44.8690    1  3.5046e-01   293  end
arbmh2oc   0.99820  2 0 0 0  1001   11.1913
                               8016   88.8087    1  5.9634e-01   293  end
arbmpoly   0.92000  2 0 0 0  1001   14.3798
                               6012   85.6202    1  5.3202e-02   293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  5.9526e-01  2 0 0 0   1001   11.1913
                                8016   88.8087     3  1.0     293  end
```

```
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                              8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                              9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                             10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.31846e4 cm3 = (8.0457422e2 in3)(16.387064)'
'den.multiplier = 1.31846e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.518047 = (den.mult)(np277-4 min.den.) = 0.9935052*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.26267e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.06375e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.81674e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                               8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
```

```
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  1       293  end
'steel: liner'
ss304                                          16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                          17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                          18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                          18  1.25705 293  end
'steel: drum steel for single units'
ss304                                          19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                          19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                               8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
cvcrpunhct11 10000.2gUNHc( 4709.7g235,2165.3gH2O) 6080.8gH2Ocv,hx= 49.26 fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                        end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.270 in.]'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200   77.72400   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
```

```
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.66 Case cvcrbpunhct11_24_15

(Note: For the following input file, the case name should read “cvcrbpunhct11” as opposed to “cvcrpunhct11”.)

```
=csas25    parm=size=3000000
cvcrpunhct11 24000.0gUNHc(11303.1g235,5196.7gH2O) 1077.9gH2Ocv hx= 15.97 fr=1.0e+00
238groupndf5 infhommedium
'U(enr)O2(NO3)2+6H2O [2.81 g/cc for U(nat)]  2.79329 g/cm3, hx=12.0'
```

```
'unhc= 24000.0 g, sat.h2o in UNHc=5196.7 g, unh h/x=12.0'
'dry content (poly bottle) h/x=1.48, CV void volume 1079.87091 cm3'
arbmunh    2.62712  5 0 0 0   92235   47.0962
                              92238    0.0000
                               1001    2.4232
                               7014    5.6116
                               8016   44.8690    1  1.0000  293  end
arbmpoly  5.4732e-02    2 0 0 0  1001   14.3798
                               6012   85.6202    1  1.0000  293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  9.9820e-01  2 0 0 0   1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.31846e4 cm3 = (8.0457422e2 in3)(16.387064)'
'den.multiplier = 1.31846e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.518047 = (den.mult)(np277-4 min.den.) = 0.9935052*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.26267e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.06375e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.81674e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
```

```
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                              8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                              8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                              8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                              8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                              8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                              8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                              8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                              8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
```

```
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                              8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   21  1.0     293  end
end comp
cvcrpunhct11 24000.0gUNHc(11303.1g235,5196.7gH2O) 1077.9gH2Ocv,hx= 15.97 fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                         end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.270 in.]'
 cylinder  3  1    6.426200   77.72400  71.05136 com='cavity abv UNHC'
 cylinder  1  1    6.426200   77.72400   0.63500 com='UNHC content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200   77.72400   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.00000 com='cavity abv UNHC'
 cylinder  1  1    6.426200    0.15240   0.0     com='UNHC content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.00000 com='cavity abv UNHC'
 cylinder  1  1    6.426200    0.22860   0.0     com='UNHC content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.00000 com='cavity abv UNHC'
 cylinder  1  1    6.426200    1.27000   0.0     com='UNHC content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
```

```
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.67 Case nciapbmflt11_1_6_4_5

```
=csas25    parm=size=3000000
nciapbmflt11,0.0in thk np, 4000.2gU( 3200.2g235) 9442.7gH2Ocv hx= 82.26 fr=0.0001
238groupndf5 infhommedium
'nciapbmflt11 - n(nct), c(np277-4), ia(infinite array),'
'               pbm (poly homogenized with broken metal),'
'               f(can location height established by packing fraction),'
'               l(designated content in can locations and gap between canned'
'               spacers, and water above content in upper can location),'
'               t11 (NCT_MD&H)'
'HEU volume = 212.11396, SPACER volume    0.01729'
'HEU wrapped dry content can hx=5.24, CV void volume 9459.75243'
'Content in can location 1'
uranium  1 den=18.85873 0.23645 293      92235  80.000
                                         92238   20.000               end
arbmh2oi     0.99820  2 0 0 0  1001   11.1913
                               8016   88.8087    1  1.5773e-01   293  end
arbmpoly     0.92000  2 0 0 0  1001   14.3798
                               6012   85.6202    1  6.0582e-01   293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
```

```
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                8016   88.8087    2  1.0000  293  end
'Content in can location 2'
uranium  3 den=18.85873 0.23645 293      92235  80.000
                                         92238   20.000               end
arbmh2oi     0.99820  2 0 0 0  1001   11.1913
                               8016   88.8087    3  1.5773e-01   293  end
arbmpoly     0.92000  2 0 0 0  1001   14.3798
                               6012   85.6202    3  6.0582e-01   293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                5011   81.8520    4  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                7014    0.0141
                                8016   43.4251
                               11023    0.1174
                               12000    0.3378
                               13027   39.0479
                               14000    2.4672
                               16000    0.3083
                               20000   11.8336
                               26000    0.5298    4  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                8016   88.8087    4  1.0000  293  end
'Content in can location 3'
uranium  5 den=18.85873 0.23647 293      92235  80.000
                                         92238   20.000               end
arbmh2oi     0.99820  2 0 0 0  1001   11.1913
                               8016   88.8087    5  1.5765e-01   293  end
arbmpoly     0.92000  2 0 0 0  1001   14.3798
                               6012   85.6202    5  6.0588e-01   293  end
'void space internal to containment vessel above stacked content'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    6  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                7014    0.0141
                                8016   43.4251
                               11023    0.1174
                               12000    0.3378
                               13027   39.0479
                               14000    2.4672
                               16000    0.3083
                               20000   11.8336
```

```
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'nct array densities are s.u.dens. multiplied by volume ratio 1.34888/1.10336'
arbmh2ok   0.63931  2 0 0 0    1001   11.1913
                                8016   88.8087   12  0.0287  293  end
arbmal2o3  0.42622  2 0 0 0   13027   52.9390
                                8016   47.0610   12  0.096   293  end
arbmsio2   0.42622  2 0 0 0   14000   46.7570
                                8016   53.2430   12  0.367   293  end
arbmfe2o3  0.42622  2 0 0 0   26000   69.9540
                                8016   30.0460   12  0.067   293  end
arbmtio2   0.42622  2 0 0 0   22000   59.9535
                                8016   40.0465   12  0.012   293  end
arbmcao    0.42622  2 0 0 0   20000   71.4815
                                8016   28.5185   12  0.307   293  end
arbmmgo    0.42622  2 0 0 0   12000   60.3169
                                8016   39.6831   12  0.131   293  end
arbmna2o   0.42622  2 0 0 0   11023   74.1961
                                8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                                8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                                8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                                8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                                8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                                8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                                8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                                8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                                8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                                1001    8.1573
                                8016   21.5782
                               14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                                8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                          16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                          17  1.06388 293  end
'steel: angle iron (ai) for single units'
'ss304                                          18  1.0     293  end
'steel: angle iron (ai) for arrays'
```

```
'array density is multiplied by a volume fraction 7.08030/5.63249'
ss304                                          18  1.25705 293  end
'steel: drum steel for single units'
'ss304                                          19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
ss304                                          19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
arbmwed    1.16026  2 0 0 0    1001   11.1913
                               8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                               8016   88.8087   21  1.0     293  end
end comp
nciapbmflt11,0.0in thk np, 4000.2gU( 3200.2g235) 9442.7gH2Ocv,hx= 82.26 fr=0.0001
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                   end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.111 in. at top of unit]'
'cylinder  19 1   22.866096    0.28150   0.0     com='extended radius not used'
 cylinder  19 1   21.722275    0.28150   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p22.866096    0.28150   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.676 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.555075   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.722275   11.59510   0.0     com='drum'
 cuboid    20 1 4p22.866096   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.926 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   21.555075    0.63500   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1004
'content (collapsed) [Elev= 5.833 in.]'
' 2.30470            bottom of cv to top of 1st content      ASSIGNED
' 5.83319            elevation (inches)                       CALCULATED
' 6.426200    5.06   cv inner radius                          M2E801508A011_RvB
' 299.00051            volume of content in unit 1004           CALCULATED
 cylinder  1  1    6.426200    2.30470  0.0      com='homog. HEU poly content'
 cylinder  8  1    6.680200    2.30470  0.0      com='cv below 1st step'
 cylinder  15 1    7.924800    2.30470  0.0      com='void btw cv-np liner'
 cylinder  16 1    8.077200    2.30470  0.0      com='np277_4 liner'
 cylinder  11 1   10.922000    2.30470  0.0      com='np277_4'
 cylinder  16 1   11.074400    2.30470  0.0      com='kaolite liner'
 cylinder  12 1   21.555075    2.30470  0.0      com='kaolite'
 cylinder  19 1   21.722275    2.30470  0.0      com='drum'
 cuboid    20 1 4p22.866096    2.30470  0.0      com='drum chine outer radius'
unit 1005
'np277_4 spacer [Elev= 5.833 in.]'
```

```
' 0.00020            top of 1st content to top 1st spacer    ASSIGNED
' 5.83331            elevation (inches)                       CALCULATED
'   0.00864            volume of spacer in unit 1005            CALCULATED
'   0.03028            volume of void in unit 1005              CALCULATED
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  1  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   21.555075    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   21.722275    0.00020  -0.0001  com='drum'
 cuboid    20 1 4p22.866096    0.00020  -0.0001  com='drum chine outer radius'
unit 1006
'content (collapsed) [Elev= 6.741 in.]'
' 299.00051            volume of content in unit 1006           CALCULATED
 cylinder  3  1    6.426200    2.30470  0.0      com='homog. HEU poly content'
 cylinder  8  1    6.680200    2.30470  0.0      com='cv below 1st step'
 cylinder  15 1    7.924800    2.30470  0.0      com='void btw cv-np liner'
 cylinder  16 1    8.077200    2.30470  0.0      com='np277_4 liner'
 cylinder  11 1   10.922000    2.30470  0.0      com='np277_4'
 cylinder  16 1   11.074400    2.30470  0.0      com='kaolite liner'
 cylinder  12 1   21.555075    2.30470  0.0      com='kaolite'
 cylinder  19 1   21.722275    2.30470  0.0      com='drum'
 cuboid    20 1 4p22.866096    2.30470  0.0      com='drum chine outer radius'
unit 1007
'np277_4 spacer [Elev= 6.741 in.]'
'   0.00864            volume of spacer in unit 1007            CALCULATED
'   0.03028            volume of void in unit 1007              CALCULATED
 cylinder  4  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   21.555075    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   21.722275    0.00020  -0.0001  com='drum'
 cuboid    20 1 4p22.866096    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'content (collapsed) [Elev= 7.648 in.]'
' 299.00051            volume of content in unit 1008           CALCULATED
 cylinder  5  1    6.426200    2.30470  0.0      com='homog. HEU poly content'
 cylinder  8  1    6.680200    2.30470  0.0      com='cv below 1st step'
 cylinder  15 1    7.924800    2.30470  0.0      com='void btw cv-np liner'
 cylinder  16 1    8.077200    2.30470  0.0      com='np277_4 liner'
 cylinder  11 1   10.922000    2.30470  0.0      com='np277_4'
 cylinder  16 1   11.074400    2.30470  0.0      com='kaolite liner'
 cylinder  12 1   21.555075    2.30470  0.0      com='kaolite'
 cylinder  19 1   21.722275    2.30470  0.0      com='drum'
 cuboid    20 1 4p22.866096    2.30470  0.0      com='drum chine outer radius'
unit 1009
'top of content stack to bottom of 1st step [Elev=35.276 in.]'
' 6.91469             stack height (3ccs plus 2 spacers)      CALCULATED
'35.27583            elevation (inches)                       CALCULATED
'35.27583            elevation (inches)                       VERIFIED
'9104.08949            volume of water in unit 1009             CALCULATED
 cylinder  6  1    6.426200   70.17431   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   70.17431   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   70.17431   0.0     com='void btw cv-np liner'
```

```
 cylinder  16 1    8.077200   70.17431   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   70.17431   0.0     com='np277_4'
 cylinder  16 1   11.074400   70.17431   0.0     com='kaolite liner'
 cylinder  12 1   21.555075   70.17431   0.0     com='kaolite'
 cylinder  19 1   21.722275   70.17431   0.0     com='drum'
 cuboid    20 1 4p22.866096   70.17431   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.336 in.]'
'  19.77167            volume of water in unit 1010            CALCULATED
 cylinder  6  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.426 in.]'
'  29.65750            volume of water in unit 1011            CALCULATED
 cylinder  6  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.555075    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.22860   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.926 in.]'
' 164.76390            volume of water in unit 1012            CALCULATED
 cylinder  6  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.27000   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.076 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.555075    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.722275    2.92100   0.0     com='drum'
 cuboid    20 1 4p22.866096    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.476 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.01600   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.536 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
```

```
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.756 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.555075    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.722275    8.17880   0.0     com='drum'
 cuboid    20 1 4p22.866096    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.506 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.555075    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.722275    4.44500   0.0     com='drum'
 cuboid    20 1 4p22.866096    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.756 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.555075    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.512 in.]'
 cylinder  20 1   21.330090    1.91973   0.16720 com='void above lid'
 cylinder  19 1   21.497290    1.91973   0.0     com='drum lid'
 cylinder  20 1   21.555075    1.91973   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.722275    1.91973   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.91973   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.512 in.]'
array 3         2r-22.866096     0.0
'cuboid     0  1 4p24.587200    42.62038  0.0    com='bare package'
'cuboid    21  1 4p55.067200   73.10038 -30.48   com='reflected package'
 cuboid    20  1 4p22.866096    110.5197  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1004 1005 1006 1007 1008 1009 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.68 Case nciapbmfdt11_1_6_4_5

```
=csas25    parm=size=3000000
nciapbmfdt11,0.0in thk np, 4000.2gU( 3200.2g235) 9442.7gH2Ocv hx= 82.26 fr=0.0001
238groupndf5 infhommedium
'nciapbmfdt11 - n(nct), c(np277-4), ia(infinite array),'
'               pbm (poly homogenized with broken metal),'
'               f(can location height established by packing fraction),'
'               d(content resides in can location and gap between canned'
'               spacer and cv, and distributed over upper can location),'
'               t11 (NCT_MD&H)'
'HEU volume = 212.11396, SPACER volume    0.01729'
'HEU wrapped dry content can hx=5.24, CV void volume 9459.75243'
'Content in can location 1'
uranium  1 den=18.85873 0.23645 293      92235  80.000
                                         92238   20.000               end
arbmh2oi     0.99820  2 0 0 0  1001   11.1913
                               8016   88.8087    1  1.5773e-01   293  end
arbmpoly     0.92000  2 0 0 0  1001   14.3798
                               6012   85.6202    1  6.0582e-01   293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'Content in can location 2'
uranium  3 den=18.85873 0.23645 293      92235  80.000
                                         92238   20.000               end
arbmh2oi     0.99820  2 0 0 0  1001   11.1913
                               8016   88.8087    3  1.5773e-01   293  end
arbmpoly     0.92000  2 0 0 0  1001   14.3798
                               6012   85.6202    3  6.0582e-01   293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    4  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    4  1.0000  293  end
```

```
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                  8016   88.8087    4  1.0000  293  end
'Content in can location 3'
uranium  5 den=18.85873 0.00735 293      92235  80.000
                                         92238   20.000               end
arbmh2oi     0.99820  2 0 0 0  1001   11.1913
                               8016   88.8087    5  9.7381e-01   293  end
arbmpoly     0.92000  2 0 0 0  1001   14.3798
                               6012   85.6202    5  1.8837e-02   293  end
'void space internal to containment vessel above stacked content'
arbmwicv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087    6  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                  5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                  7014    0.0141
                                  8016   43.4251
                                 11023    0.1174
                                 12000    0.3378
                                 13027   39.0479
                                 14000    2.4672
                                 16000    0.3083
                                 20000   11.8336
                                 26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                  8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'nct array densities are s.u.dens. multiplied by volume ratio 1.34888/1.10336'
arbmh2ok   0.63931  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.42622  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.42622  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.42622  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.42622  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.42622  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.42622  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.42622  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
```

```
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
'ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
'ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
arbmwed    1.16026  2 0 0 0    1001   11.1913
                               8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                              8016   88.8087   21  1.0     293  end
end comp
nciapbmfdt11,0.0in thk np, 4000.2gU( 3200.2g235) 9442.7gH2Ocv,hx= 82.26 fr=0.0001
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                  end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.111 in. at top of unit]'
'cylinder  19 1   22.866096    0.28150   0.0     com='extended radius not used'
 cylinder  19 1   21.722275    0.28150   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p22.866096    0.28150   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.676 in.]'
```

```
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.555075   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.722275   11.59510   0.0     com='drum'
 cuboid    20 1 4p22.866096   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom [Elev= 4.926 in.]'
 cylinder  8  1    6.680200    0.63500   0.0     com='cv bottom'
 cylinder  15 1    7.924800    0.63500   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.63500   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000    0.63500   0.0     com='np277_4'
 cylinder  16 1   11.074400    0.63500   0.0     com='kaolite liner'
 cylinder  12 1   21.555075    0.63500   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1004
'content (collapsed) [Elev= 5.833 in.]'
' 2.30470            bottom of cv to top of 1st content      ASSIGNED
' 5.83319            elevation (inches)                       CALCULATED
' 6.426200    5.06   cv inner radius                          M2E801508A011_RvB
' 299.00051            volume of content in unit 1004           CALCULATED
 cylinder  1  1    6.426200    2.30470  0.0      com='homog. HEU poly content'
 cylinder  8  1    6.680200    2.30470  0.0      com='cv below 1st step'
 cylinder  15 1    7.924800    2.30470  0.0      com='void btw cv-np liner'
 cylinder  16 1    8.077200    2.30470  0.0      com='np277_4 liner'
 cylinder  11 1   10.922000    2.30470  0.0      com='np277_4'
 cylinder  16 1   11.074400    2.30470  0.0      com='kaolite liner'
 cylinder  12 1   21.555075    2.30470  0.0      com='kaolite'
 cylinder  19 1   21.722275    2.30470  0.0      com='drum'
 cuboid    20 1 4p22.866096    2.30470  0.0      com='drum chine outer radius'
unit 1005
'np277_4 spacer [Elev= 5.833 in.]'
' 0.00020            top of 1st content to top of 1st spacer ASSIGNED
' 5.83331            elevation (inches)                       CALCULATED
'   0.00864            volume of spacer in unit 1005            CALCULATED
'   0.03028            volume of void in unit 1005              CALCULATED
 cylinder  2  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  1  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   21.555075    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   21.722275    0.00020  -0.0001  com='drum'
 cuboid    20 1 4p22.866096    0.00020  -0.0001  com='drum chine outer radius'
unit 1006
'content (collapsed) [Elev= 6.741 in.]'
' 299.00051            volume of content in unit 1006           CALCULATED
 cylinder  3  1    6.426200    2.30470  0.0      com='homog. HEU poly content'
 cylinder  8  1    6.680200    2.30470  0.0      com='cv below 1st step'
 cylinder  15 1    7.924800    2.30470  0.0      com='void btw cv-np liner'
 cylinder  16 1    8.077200    2.30470  0.0      com='np277_4 liner'
 cylinder  11 1   10.922000    2.30470  0.0      com='np277_4'
 cylinder  16 1   11.074400    2.30470  0.0      com='kaolite liner'
 cylinder  12 1   21.555075    2.30470  0.0      com='kaolite'
 cylinder  19 1   21.722275    2.30470  0.0      com='drum'
 cuboid    20 1 4p22.866096    2.30470  0.0      com='drum chine outer radius'
```

```
unit 1007
'np277_4 spacer [Elev= 6.741 in.]'
'   0.00864            volume of spacer in unit 1007            CALCULATED
'   0.03028            volume of void in unit 1007              CALCULATED
 cylinder  4  1    5.24510     0.00010   0.0     com='np spacer'
 cylinder  3  1    6.426200    0.00020  -0.0001  com='cv well cavity'
 cylinder  8  1    6.680200    0.00020  -0.0001  com='cv below 1st step'
 cylinder  15 1    7.924800    0.00020  -0.0001  com='void btw cv-np liner'
 cylinder  16 1    8.077200    0.00020  -0.0001  com='np277_4 liner'
 cylinder  11 1   10.922000    0.00020  -0.0001  com='np277_4'
 cylinder  16 1   11.074400    0.00020  -0.0001  com='kaolite liner'
 cylinder  12 1   21.555075    0.00020  -0.0001  com='kaolite'
 cylinder  19 1   21.722275    0.00020  -0.0001  com='drum'
 cuboid    20 1 4p22.866096    0.00020  -0.0001  com='drum chine outer radius'
unit 1008
'content (collapsed) [Elev= 7.648 in.]'
' 299.00051            volume of content in unit 1008           CALCULATED
 cylinder  5  1    6.426200    2.30470  0.0      com='homog. HEU poly content'
 cylinder  8  1    6.680200    2.30470  0.0      com='cv below 1st step'
 cylinder  15 1    7.924800    2.30470  0.0      com='void btw cv-np liner'
 cylinder  16 1    8.077200    2.30470  0.0      com='np277_4 liner'
 cylinder  11 1   10.922000    2.30470  0.0      com='np277_4'
 cylinder  16 1   11.074400    2.30470  0.0      com='kaolite liner'
 cylinder  12 1   21.555075    2.30470  0.0      com='kaolite'
 cylinder  19 1   21.722275    2.30470  0.0      com='drum'
 cuboid    20 1 4p22.866096    2.30470  0.0      com='drum chine outer radius'
unit 1009
'top of content stack to bottom of 1st step [Elev=35.276 in.]'
' 6.91469             stack height (3ccs plus 2 spacers)      CALCULATED
'35.27583            elevation (inches)                       CALCULATED
'35.27583            elevation (inches)                       VERIFIED
'9104.08949            volume of water in unit 1009             CALCULATED
 cylinder  5  1    6.426200   70.17431   0.0     com='cv well cavity'
 cylinder  8  1    6.680200   70.17431   0.0     com='cv below 1st step'
 cylinder  15 1    7.924800   70.17431   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   70.17431   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   70.17431   0.0     com='np277_4'
 cylinder  16 1   11.074400   70.17431   0.0     com='kaolite liner'
 cylinder  12 1   21.555075   70.17431   0.0     com='kaolite'
 cylinder  19 1   21.722275   70.17431   0.0     com='drum'
 cuboid    20 1 4p22.866096   70.17431   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.336 in.]'
'  19.77167            volume of water in unit 1010             CALCULATED
 cylinder  5  1    6.426200    0.15240   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.426 in.]'
'  29.65750            volume of water in unit 1011             CALCULATED
 cylinder  5  1    6.426200    0.22860   0.0     com='cv well cavity'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.555075    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.22860   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.22860   0.0     com='drum chine outer radius'
```

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unit 1012
'cv flange to top of cv well [Elev=35.926 in.]'
' 164.76390            volume of water in unit 1012            CALCULATED
 cylinder  5  1    6.426200    1.27000   0.0     com='cavity'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.27000   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.076 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.555075    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.722275    2.92100   0.0     com='drum'
 cuboid    20 1 4p22.866096    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.476 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.01600   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.536 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.756 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.555075    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.722275    8.17880   0.0     com='drum'
 cuboid    20 1 4p22.866096    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.506 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.555075    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.722275    4.44500   0.0     com='drum'
 cuboid    20 1 4p22.866096    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.756 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
```

```
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.555075    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.512 in.]'
 cylinder  20 1   21.330090    1.91973   0.16720 com='void above lid'
 cylinder  19 1   21.497290    1.91973   0.0     com='drum lid'
 cylinder  20 1   21.555075    1.91973   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.722275    1.91973   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.91973   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.512 in.]'
array 3         2r-22.866096     0.0
'cuboid     0  1 4p24.587200    42.62038  0.0    com='bare package'
'cuboid    21  1 4p55.067200   73.10038 -30.48   com='reflected package'
 cuboid    20  1 4p22.866096    110.5197  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=19 fill
1001 1002 1003 1004 1005 1006 1007 1008 1009 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.69 Case ncsrpunhct11_8_15

```
=csas25    parm=size=3000000
ncsrpunhct11  8000.1gUNHc( 3767.7g235,1732.2gH2O) 6795.6gH2Ocv hx= 63.53 fr=1.0e+00
238groupndf5 infhommedium
'U(enr)O2(NO3)2+6H2O [2.81 g/cc for U(nat)]  2.79329 g/cm3, hx=12.0, gU/L= 368.8310'
'dry content (poly packed or wrapped) h/x=4.45, CV void volume 6807.84362 cm3'
arbmunh    2.79329  5 0 0 0   92235   47.0962
                              92238    0.0000
                               1001    2.4232
                               7014    5.6116
                               8016   44.8690    1  2.8037e-01   293  end
arbmh2oc   0.99820  2 0 0 0  1001   11.1913
                               8016   88.8087    1  6.6643e-01   293  end
arbmpoly   0.92000  2 0 0 0  1001   14.3798
                               6012   85.6202    1  5.3202e-02   293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
```

```
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  6.6523e-01  2 0 0 0    1001   11.1913
                                 8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                             8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                             9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                            10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                               8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
```

```
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                               8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
ncsrpunhct11  8000.1gUNHc( 3767.7g235,1732.2gH2O) 6795.6gH2Ocv,hx= 63.53 fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                       end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   23.329900    0.26670   0.0     com='drum bottom flat cover'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
```

```
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   23.177500   11.59510   0.0     com='kaolite'
 cylinder  19 1   23.329900   11.59510   0.0     com='drum'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.270 in.]'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cylinder  15 1    7.924800   77.72400   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   77.72400   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   77.72400   0.0     com='np277_4'
 cylinder  16 1   11.074400   77.72400   0.0     com='kaolite liner'
 cylinder  12 1   23.177500   77.72400   0.0     com='kaolite'
 cylinder  19 1   23.329900   77.72400   0.0     com='drum'
 cuboid    21 1 4p24.587200   77.72400   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   23.177500    0.22860   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.22860   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   23.177500    1.27000   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.27000   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   23.177500    2.92100   0.0     com='kaolite'
 cylinder  19 1   23.329900    2.92100   0.0     com='drum'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
```

```
 cylinder  12 1   23.177500    1.01600   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.01600   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   23.177500    8.17880   0.0     com='kaolite'
 cylinder  19 1   23.329900    8.17880   0.0     com='drum'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   23.177500    4.44500   0.0     com='kaolite'
 cylinder  19 1   23.329900    4.44500   0.0     com='drum'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   23.177500    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   23.329900    0.63500   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  21 1   22.961600    1.90500   0.15240 com='void above lid'
 cylinder  19 1   23.114000    1.90500   0.0     com='drum lid'
 cylinder  21 1   23.177500    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   23.329900    1.90500   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
```

```
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.7.70 Case icsrpunhct12_15_15

```
=csas25    parm=size=3000000
icsrpunhct12 15000.0gUNHc( 7064.4g235,3247.9gH2O) 6397.6gH2Ocv hx= 53.28 fr=1.0e+00
238groupndf5 infhommedium
'U(enr)O2(NO3)2+6H2O [2.81 g/cc for U(nat)], UNHc  2.79329 g/cm3, UNH hx=12.0'
'gU/L= 443.7839 dispersed. Bottle hx=2.37 no meaning when dispersed'
'UNHc in cv   9113.74622 g. water in cv  6397.62120 g.'
'UNHc in well  5886.25378 g. water in well  4132.00248 g.'
arbmunh    2.79329  5 0 0 0   92235   47.0962
                              92238    0.0000
                               1001    2.4232
                               7014    5.6116
                               8016   44.8690    1  0.31939 293  end
arbmh2oc   0.99820  2 0 0 0    1001   11.1913
                               8016   88.8087    1  0.62740 293  end
arbmpoly   0.92000  2 0 0 0  1001   14.3798
                               6012   85.6202    1  5.3202e-02   293  end
'np277-4: spacer (HAC_MD&H)'
'HAC min.den.(95.3157 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07071e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.82995e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  9.9820e-01  2 0 0 0    1001   11.1913
                                 8016   88.8087    3  1.0     293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                             8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                             9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                            10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (HAC_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.476265 = (den.mult)(np277-4 min.den.) = 0.9668933*1.526803'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
```

```
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.70316e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                                 8016   88.8087   12  1       293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                                 8016   47.0610   12  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                                 8016   53.2430   12  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                                 8016   30.0460   12  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                                 8016   40.0465   12  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                                 8016   28.5185   12  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                                 8016   39.6831   12  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                                 8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                                 8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                                 8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                                 8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                                 8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                                 8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                                 8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                                 8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                                 8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                                 1001    8.1573
                                 8016   21.5782
```

```
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
'UNHc in cv well   5886.25378 g.'
'water in cv well  4132.00248 g.'
arbmunh    2.79329  5 0 0 0   92235   47.0962
                              92238    0.0000
                               1001    2.4232
                               7014    5.6116
                               8016   44.8690   15  0.33734 293  end
arbmh2oc   0.99820  2 0 0 0    1001   11.1913
                               8016   88.8087   15  0.66266 293  end
'steel: liner'
ss304                                          16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                          17  1.06388 293  end
'steel: angle iron (ai) for HAC'
'nct density is multiplied by volume fraction 7.08030/5.74516'
ss304                                          18  1.23239 293  end
'steel: drum steel for HAC'
'nct density is multiplied by volume fraction 3.20482/2.95645'
ss304                                          19  1.08401 293  end
'void space external to drum'
'array density is assumed not reduced by hac'
'arbmwed    0.9982   2 0 0 0    1001   11.1913
'                              8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
icsrpunhct12 15000.0gUNHc( 7064.4g235,3247.9gH2O) 6397.6gH2Ocv,hx= 53.28 fr=1.0e+00
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                        end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   21.838092    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   21.838092    0.26670   0.0     com='drum bottom flat cover'
 cuboid    21 1 4p21.838092    0.26670   0.0     com='drum(chine)outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
'v1002=1.36748e+01  '
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.685692   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.838092   11.59510   0.0     com='drum'
 cuboid    21 1 4p21.838092   11.59510   0.0     com='drum(chine)outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.270 in.]'
'v1003=4.43850e+03  '
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cylinder  15 1    7.924800   77.72400   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   77.72400   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   77.72400   0.0     com='np277_4'
 cylinder  16 1   11.074400   77.72400   0.0     com='kaolite liner'
 cylinder  12 1   21.685692   77.72400   0.0     com='kaolite'
 cylinder  19 1   21.838092   77.72400   0.0     com='drum'
 cuboid    21 1 4p21.838092   77.72400   0.0     com='drum(chine)outer radius'
```

```
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
'v1010=8.70294e+00  '
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
'v1011=5.36220e+01  '
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.685692    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.22860   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.22860   0.0     com='drum(chine)outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
'v1012=7.43264e+01  '
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.27000   0.0     com='drum'
 cuboid    21 1 4p21.838092    1.27000   0.0     com='drum(chine)outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
'v1013=1.70951e+02  '
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.685692    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.838092    2.92100   0.0     com='drum'
 cuboid    21 1 4p21.838092    2.92100   0.0     com='drum(chine)outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
'v1014=1.39785e+02  '
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.01600   0.0     com='drum'
 cuboid    21 1 4p21.838092    1.01600   0.0     com='drum(chine)outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
'v1015=5.71136e+01  '
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1016
```

```
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
'v1016=6.92877e+02  '
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.685692    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.838092    8.17880   0.0     com='drum'
 cuboid    21 1 4p21.838092    8.17880   0.0     com='drum(chine)outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
'v1017=1.83014e+02  '
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.685692    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.838092    4.44500   0.0     com='drum'
 cuboid    21 1 4p21.838092    4.44500   0.0     com='drum(chine)outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
'v1018=4.14168e+02  '
'Volume cv well=6.24674e+03  '
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.685692    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.838092    0.63500   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.63500   0.0     com='drum(chine)outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  21 1   21.469792    1.90500   0.15240 com='void above lid'
 cylinder  19 1   21.622192    1.90500   0.0     com='drum lid'
 cylinder  21 1   21.685692    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.838092    1.90500   0.0     com='drum'
 cuboid    21 1 4p21.838092    1.90500   0.0     com='drum(chine)outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-21.838092     0.0
'cuboid     0  1 4p21.838092    110.4905  0.0    com='bare package'
 cuboid    21  1 4p52.318092   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

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Appendix 6.9.8
Criticality Evaluation of Additional Content

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Appendix 6.9.8

Criticality Evaluation of Additional Content

This appendix presents the criticality safety evaluation of additional content for the ES-3100 package. Calculations presented herein were performed using the Monte Carlo CSAS25 criticality code sequence and 238-group ENDFB-V cross section library of SCALE 5.0 (NUREG/CR-0200, Rev. 7), executed on identical Hewlett Packard (HP) Model zx6000 Itanium workstations (CMODC and CMODD). Criticality calculations documented in Sects. 6.4–6.6 were performed using SCALE 4.4a (NUREG/CR-0200, Rev. 6) executed on an HP Model J5600 RISC workstation (CMODB). The obsolete CMODB with HP-UX 10.20 operating system was recently retired from service. No longer supported by the code developer, SCALE 4.4a is not portable to the updated computing platforms thus necessitating the use of SCALE 5.0.

SCALE5 incorporates minor improvements in the code modules for the Bondarenko and the Nordheim Integral Treatment processing of resonance cross sections and the KENO V.a module. Consequently, the USL used is validation dependent based on the SCALE-platform combination. The evaluation of the additional content based upon SCALE 5.0 calculations is documented in this appendix separate from the main body of Sect. 6 because this effort could not easily be folded into the existing SCALE 4.4a evaluation without inclusion of a patchwork of clarifications.

A variety of materials identified in Table 6.9.8.1-1 from various reactor programs, including bare, clad, or canned uranium metal alloy or oxide in various shapes as pellets, rods, plates, bundled components, fuel assemblies, and compounds will be shipped in the ES-3100 package.

6.9.8.1 Description of the Criticality Design

The design features of the ES-3100 package addressed in Sect. 6.1.1 are not changed. The same codes and standards addressed in Sect. 6.1.2 apply. No change is employed in the methodology for demonstrating maximum reactivity.

The criticality safety evaluation documented in this appendix is a cursory analysis of the proposed contents listed in Table 6.9.8.1-1. In addition to uranium compounds, these contents comprise a variety of reactor fuel components and scrap materials composed of clad HEU metal or metal hydride, HEU alloy or oxide, or clad HEU alloy. In most cases, the HEU present in the components or scrap represents a small portion of the total mass. Because the HEU fissile material mass loading limits for the ES-3100 are specified in terms of the ^{235}U mass (Table 6.2a), package loading capacities on the order of 35,200 g of content are conceivable as physical dimensions of the content permit. The shipping limits for the contents are derived limits bounded by limits established for similar content types evaluated in Sects. 6.4–6.6, or are less restrictive limits based on further investigation using explicit models of particular components and materials. The revised fissile mass loading limits for specific contents are presented in Table 6.9.8.1-2 for surface only modes of transportation. The CSI is assigned as described in Sect. 6.1.4.

6.9.8.2 The Additional Content for the ES-3100 Package

A variety of materials identified in Table 6.9.8.1-1 from various reactor programs, including bare, clad, or canned uranium metal alloy or oxide in various shapes as pellets, rods, plates, bundled components and fuel assemblies will be shipped in the ES-3100 package. The compounds of uranium identified in Table 6.9.8.1-1 included uranium tetrafluoride, uranyl fluoride, uranium carbide, and uranium nitride. The physical form of these uranium compounds is described as powder, beads, and ash. Both content moisture and content uniformity are not defined.

Table 6.9.8.1-1. 12.1 MTU and RFS items

Name	Detailed description	Qty.	Assay	Net wt (g)	U wt (g)	^{235}U wt (g)
ARMF Idaho	Mark I Elements – 15 plates/element	14	93	5,511 ea.	192 ea	179 ea
	Mark II Elements – 8 flat and 6 bent plates/element	1	93	4,831 ea.	140 ea	131 ea
	Plates – U/Al in Al matrix overall 8.28 × 8.28 × 98 cm flat plate 7.26 × 0.12 × 64.8 cm bent plate var. × 0.12 × 64.8 cm	27	93	239 ea.	13 ea	12.185 ea
	Plate tray and items	1	37.5-93		224	207
	Total	**–**	**93**	**89,248**	**3,403**	**3,137**
BR2 Belgium	Bundles of MTR Type 2 U/Al fuel plates	29	90	7,333 ea	525.87 ea	472.95 ea
	Total	**–**	**90**	**185,926**	**15,195**	**13,658**
Bulk Shielding Reactor ORNL	Fuel assembly scrap plates. U_3O_8 outer plates, U/Al alloy inner plates and control rods	14	93	3,423	3,309	3,020
CNEA RA-2 Argentina	Bundles of MTR Type 2 U/Al fuel plates – 25 plates/ bundle flat plate 7.1 × 0.13 × 65.5 cm	35	90	4,534.9 ea	202.1 ea	181.7 ea
	Total	**–**	**90**	**78,536**	**3,716**	**3,342**
Group 1 Hanford fuel elements	Bundles of MTR Type 2 U/Al fuel plates – 11 plates/ bundle overall 27.125 × 2.5 × 2.845 in. U/Al plate 25.625 × 0.07 × 2.845 in.	21	93.18	NA	156	145.3
	Total	**–**	**93.18**	**NA**	**3,276**	**3,053**
Group 13 CERCA	Powder (sintered U_3O_8 mixed with Al) in containers	13	~45	NA	< 328 ea.	< 137 ea.
	Mixture pressed cores and powder in container	1	~45	NA	1,496	673
	Mixture of fuel plates, pressed cores and powder in containers	1	~45	NA	2,534	1,139
	Total	**15**	**45**	**–**	**6,177**	**2,764**
Group 15 Y-12 CSMO	Sintered U_3O_8 mixed with Al	5	93.2	11,665	8,013	7,464
	UAl fuel plate bundles (FGZ-046)	19	93.2	68,057	6,914.8	6,441.5
	UAl fuel plate bundles (FGZ-046)	35	93	139,646	13,575	12,646
	(ID-93-13)	15	93	34,119	23,319	21,701
	UAl fuel plate bundles (ID-93-13)	17	93.1	77,722	12,649	11,782
	UAl fuel plate bundles (ID-93-13)	16	93.1	77,823	13,282	12,372
	UAl powder in cans (ID-93-13)	15	–	–	–	–
	UAl fuel plate bundles (ID-93-13)	33	–	–	–	–
	(ID-93-13)	7	93.1	34,739	850	791

Table 6.9.8.1-1. 12.1 MTU and RFS items

Name	Detailed description	Qty.	Assay	Net wt (g)	U wt (g)	^{235}U wt (g)
Group 17A ORNL	Bundles of MTR Type 2 fuel U/Al fuel plates. Overall dimensions: 2.5 – 3.0 × 2.5 – 3.0 × 0.03 – 0.07 in.	7	93	–	2,142	1,996
	EU fuel elements & plates (FZB-949)	14	93.2	–	2,044	1,905
	Fuel plates (FZC-938)	2	93	–	79 ea.	67 ea.
	Fuel elements (FZB-881)	7	93.3	–	151 ea.	~140 ea.
	Total	**30**	**93**	**–**	**6,297**	**5,016**
Group 17B SNAP Reactor	Pin overall 1.25 in. OD × 12.45 in. $UZrH_2$ with Hastelloy-N cladding, 877 g H	36	93	56,048	4,976	4,627
Group 5B Georgia Tech	MTR Type 2 fuel Overall dimensions: 3.0 × 3.0 × 30 in.	5	93	–	1,005	936
		5	93	–	1,011	941
		5	93	–	1,008	939
		5	93.2	–	1,011	942
		4	93.2	–	683	636
	Total	**24**	**93**	**5,070**	**4,728**	**4,121**
Group 8 Omega West	MTR Type 2 fuel	20	93.2	–	4,977	4,638
		20	93.2	–	4,720	4,400
		15	93.2	–	3,579	3,336
		8	93.2	–	1,992	1,850
		8	93.2	–	1,316	1,225
	Total	**71**	**93.2**	**420,600**	**16,584**	**15,455**
PBF PWR	Fuel rods 0.422 in. diam × 39.9 in. Active fuel 0.374 in. diam × 36 in. Clad 0.024 in. RA-2 Zr Alloy	2	34.9	1,555.9	1,101	384
		2	93.2	1,551.0	1,095	1,021
	Total	**–**	**93**	**3,107**	**2,196**	**1,405**
Uranium compounds	Uncladded fuel fab materials from TREAT and ROVER: EU oxides (UO_2, U_3O_8), uranium compounds, uranium alloys, carbon, graphite, UF_4, UO_2F_2, UC, UN		20–100	700,000	100,000	–

Table 6.9.8.1-2. Fissile mass loading limits for ground transport of 12.1 MTU and RFS items

Content [a] description		Enrichment	CSI	No can spacers [b, c, d] ^{235}U (g)	Basis for limit
HEU oxide (UO_2, UO_3, U_3O_8, U_3O_8-Al, UO_2-Mg, UO_2-ZrO_2)		≤ 100%	0	9,682 g ^{235}U [e] 921 g C [f]	Table 6.2a, HEU product oxides Table 6.2a, HEU skull oxides
Research reactor fuel elements and components	$UZrH_x$ [g]	≤20%	0	921 g ^{235}U	TRIGA at 20% enrichment
		>20%, ≤70%	0	408 g ^{235}U	TRIGA at 70% enrichment
		≥93%	0	11,164 g $UZrH_x$ 857 g ^{235}U	SNAP at 93% enrichment
	U-Zr	≤ 100%	–	See HEU broken metal limits in Table 6.2a [h]	
	U-Al	≤ 93%	0	7,333 g U-Al [i] 525 g U [i] 473 g ^{235}U [i]	BR-2 MTR Type 2
		≤ 100%	0	7,194 g U-Al [i] 1,117 g U [i] 1050 g ^{235}U [i]	1 MIT U/Al element or bundled plates (up to 30 plates)
	U_3O_8-Al	≤ 100%	0	See HEU oxide limits above	
	UO_2	≤ 100%	0	21,937 g UO_2 19,308 g ^{235}U	
	UO_2-ThO_2	≤ 100%	0	21,937 g UO_2 19,308 g ^{235}U	Bounded by UO_2
	Oxides of U-Zr [j]	≤ 100%	–	See HEU oxide limits above	
	UO_2-Mg	≤ 100%	0	See HEU oxide limits above	
	U_3Si_2-Al	≤ 100%	0	5.825 kg U_3Si_2-Al [i] 2.277 kg U [i] 450 g ^{235}U [i]	1 element with 12 plates or bundled plates (up to 30)
Uranium compounds	UF_4	≤ 100%	0	3,000 g UF_4 2,267 g ^{235}U	
	UO_2F_2	≤ 100%	0	3,000 g UO_2F_2 2,067 g ^{235}U	
	UC	≤ 100%	0	2,000 g UC 1,815 g ^{235}U	
	UN	≤ 100%	0	2,000 g UN 1,888 g ^{235}U	
	TRISO	≤ 100%	0	2,000 g UC_x 1,815 g ^{235}U	Bounded by UC compounds
	U_3Si_2	≥19.7%, <40%	0	13 kg U_3Si_2	
		≥40%, ≤60%	0	7 kg U_3Si_2	
	U_3Si_2-Al	≥19.7%, <40%	0	13 kg U_3Si_2-Al	Bounded by U_3Si_2
		≥40%, ≤60%	0	7 kg U_3Si_2-Al	

Table 6.9.8.1-2. Fissile mass loading limits for ground transport of 12.1 MTU and RFS items

Content [a] description		Enrichment	CSI	No can spacers [b, c, d] ^{235}U (g)	Basis for limit
	U_3Si	≥19.7%, <40%	0	14 kg U_3Si	
		≥40%, ≤60%	0	8.5 kg U_3Si	
	U_3Si-Al	≥19.7%, <40%	0	14 kg U_3Si-Al [k]	Bounded by U_3Si
		≥40%, ≤60%	0	8.5 kg U_3Si-Al [k]	

[a] Content in solution form is not permitted for shipment in the ES-3100.
[b] All limits are expressed in g ^{235}U unless otherwise indicated.
[c] The mass loading limit cannot be rounded up.
[d] 277-4 can spacers as described on Drawing M2E801580A043 (Appendix 1.3.7) not required but are optional as dunnage.
[e] Non-uranium metallic constituents (e.g., aluminum, zirconium, or magnesium) are evaluated further in Appendix 6.9.11.
[f] As discussed in App. 6.9.11, the carbon limit of 921 g does not apply to HEU product oxide for ground transport.
[g] For SNAP $UZrH_x$, $x \leq 2$. For TRIGA $UZrH_x$, $x \leq 1.6$.
[h] Mass limits for alloys are evaluated further in Appendix 6.9.11.
[i] Mass limit is the most restrictive of the three values shown.
[j] Oxides of U-Zr are UO_2-Zr and UO_2-ZrO_2.
[k] No control on the amount of aluminum.

A general description of the Bulk Shielding Reactor-1 reveals that the core consisted of 30 subassemblies (MTR type stacked plates, 18 plates per subassembly), each subassembly with overall dimensions of 3.125 × 3 × 34.5 in., arranged into a parallelepiped with an active core ~15 × 18 × 24 in. The core contained 3,850-g ^{235}U (*Nuclear Reactor Plant Data*, Bulk Shielding Reactor, pp. 33–35).

A general description of the Oak Ridge Research Reactor reveals that the core consisted of 20–30 subassemblies (MTR type stacked plates, 19 plates per subassembly), each subassembly with overall dimensions of 3.015 × 3.15 × 38.375 in., arranged in 7 × 9 grid with an active core ~12 × 21 × 24 in. The core contained 3.5–4 kg ^{235}U (*Nuclear Reactor Plant Data*, Oak Ridge Research Reactor, pp. 102–110).

A general description of the Omega West Reactor reveals that the core consisted of 36 subassemblies (MTR type stacked plates, 18 plates per subassembly), each subassembly with overall dimensions of 2.966 × 3.069 × 30 in., arranged in 6 × 9 grid with an active core ~14 × 28 × 24 in. The core contained ~4-kg ^{235}U (Omega West Reactor).

Uranium tetrafluoride (UF_4), often called green-salt because of its characteristic color, is an intermediate product in the conversion of UF_6 to either uranium oxide (U_3O_8 or UO_2) or uranium metal. UF_4 is a solid composed of agglomerating particles with a texture similar to baking soda. It is non-volatile and non-hygroscopic, but only slightly soluble in water. After exposure to water, UF_4 slowly dissolves and undergoes hydrolysis, forming several possible uranium compounds and hydrogen fluoride (HF). The density of solid UF_4 is 6.7 g/cm^3.

Uranyl fluoride (UO_2F_2) is an intermediate product in the conversion of uranium hexafluoride (UF_6) to an uranium oxide. UO_2F_2 is a direct product of the reaction of UF_6 with moisture in the air. UO_2F_2 is very soluble in water and hygroscopic in air. It changes in color from brilliant orange to yellow after reacting with water. Deliquescence studies show that in room air (~50–60% relative humidity), deposits of UO_2F_2 reach an equilibrium point of hydration (H/U ≤ 4) with the formation of uranyl fluoride dihydrate ($UO_2F_2 \cdot 2H_2O$) [JE/ER-4]. UO_2F_2 is reported to be stable in air to 300°C, above which slow decomposition to U_3O_8 occurs. When heated to decomposition, UO_2F_2 emits toxic fluoride fumes. The densities for UO_2F_2 and $UO_2F_2 \cdot 2H_2O$ are 6.37 and 4.76 g/cm^3, respectively (Barber).

Uranium carbide is a hard refractive ceramic material. It comes in several stoichiometries (UC_x) such as uranium monocarbide (UC), uranium sesquicarbide (U_2C_3), and uranium dicarbide (UC_2). Typically, uranium carbide is used as a nuclear fuel in gas-cooled fast reactors. Uranium carbide is a dull, dark charcoal-gray or flat black colored powder. Theoretical densities for UC, U_2C_3, and UC_2 are 13.63, 12.7, and 11.3 g/cm^3, respectively.

Uranium nitride (UN) is a ceramic material with a high uranium density and melting point (2805°C). These properties make it suitable for both liquid-metal cooled reactor and in-core nuclear thermionic applications. One process for the production of UN powder is hydride-dehydride-nitride process where the starting material is oxide-free uranium metal. Material testing of isostatically pressed and sintered UN cylinders has revealed the presence of uranium sesquinitride (U_2N_3). The theoretical densities for UN and U_2N_3 are 14.32 and 11.24 g/cm^3, respectively. The fact that U_2N_3 has a lower density than UN and decomposes into UN and nitrogen gas at 900°C eliminates it as a potential reactor fuel (ORNL-4608).

Other uranium compounds consist primarily of finished tristructural-isotropic (TRISO) micro fuel particles; however, also included are pure/impure scrap materials generated during various stages of the manufacturing process. These materials have a ^{235}U assay $\leq$ 93.17% and are typically in a solid crystalline or granular form. A finished TRISO fuel particle consists of a kernel composed of UO_X (or sometimes UC or UCO) coated with four exterior layers of three isotropic materials. The four layers are a porous buffer layer made of carbon, followed by a dense inner layer of pyrolytic carbon (PyC), followed by a ceramic layer of SiC to retain fission products at elevated temperatures and to give the TRISO particle more structural integrity, followed by a dense outer layer of PyC. TRISO fuel particles are designed not to crack due to the stresses from processes (such as differential thermal expansion or fission gas pressure) at temperatures beyond 1600°C, and therefore can contain the fuel in the worst of accident scenarios in a properly designed reactor. TRISO fuel particles were originally developed in Germany for high-temperature gas-cooled reactors. Two current reactor designs are the pebble bed reactor (PBR) in which thousands of TRISO fuel particles are dispersed into graphite pebbles, and the prismatic-block gas-cooled reactor (such as the GT-MHR) in which the TRISO fuel particles are fabricated into compacts and placed in a graphite block matrix. Both of these reactor designs are very high temperature reactors (formally known as the high-temperature gas-cooled reactors).

The convenience cans, Teflon and polyethylene bottles, 277-4 canned spacers described in Sect. 6.2.2, and the packing materials described in Sect. 6.2.3 are not affected by inclusion of the package contents. Other than a reference made to Table 6.9.8.1-2, the Packing Content Loading Restrictions stated in Sect. 6.2.4 are unchanged.

6.9.8.3 General Considerations

General considerations expressed in Sect. 6.3 regarding both assumptions made about the ES-3100 packaging and the calculation methodology for the evaluation are maintained. No changes are required to the calculation models of the containment vessel (CV), the single-unit packaging (Sect. 6.3.1.1), the damaged packaging (Sect. 6.3.1.3), or the catastrophically-damaged packaging (Sect. 6.3.1.4). However, the array packaging calculation model used with some of the content models employs the explicit triangular-pitch geometry specification also used in the evaluation of small array configurations (Sect. 6.3.1.2). Both the ETP and the reduced diameter square-pitch configuration for simulating triangular pitch spacing in an array of packages yields acceptable (and comparable) results. Finally, the material properties specification for the content models are addressed in Sect. 6.9.8.3.2.

6.9.8.3.1 Model configuration for supplemental contents

Reactor Fuel Components and Scrap Materials

A variety of materials identified in Table 6.9.8.1-1 from various reactor programs include bare, clad or canned uranium metal alloy, and bare or clad HEU oxide. These items will be shipped in the ES-3100 package as pellets, rods, plates, bundled components and fuel assemblies. An assumed maximum of 500 g of polyethylene is included to represent hydrogenous packing material. Carbon coating on reactor fuel is not controlled. As shown in calculations in Appendix 6.9.11, adding carbon will reduce reactivity. In order to add carbon in the models, water must be removed to conserve volume. Water is a better moderator and reflector than carbon.

The calculation model for the U/Al fuel plates is based on the BR-2 MTR Type 2 fuel plate. Plate dimensions are 7.1 cm width × 0.1561 cm depth × 65.5 cm height based on data for the CNEA MTR Type 2 fuel. With an overall depth of 5.4627 cm, thirty-five BR-2 plates bundled together can be accommodated in the ES-3100 CV. Data for Bundle 29 provides the basis for the calculation model. The net weight is 7,309 g, the uranium mass is 525.19 g, and the ^{235}U mass is 473.09 g. Three loading configurations are analyzed for evaluation of the effect of plate separation. One configuration models a compact array of 35 fuel plates side-by-side inside the CV. The two other configurations model the plates with 0.06- and 0.12-cm separation between the plates. The bundle of plates intersect the CV wall at 0.18-cm separation between the plates.

The Massachusetts Institute of Technology (MIT) U/Al fuel plate aluminum cladding outer dimensions are 2.552-in. (6.48208-cm) wide × 0.08-in. (0.2032-cm) deep (thickness) × 23-in. (58.42-cm) high. An element consists of 15 MIT fuel plates with 0.082 in. (0.20828 cm) separation between plates for an overall depth (thickness) of 2.348 in. (5.96392 cm) for the 0.082-in. (as designed/built) separation. With the as-fabricated element/grid structure, only one MIT fuel element can be accommodated in the ES-3100 CV. If the MIT fuel plates were removed from the element structure and bundled together with no separation between plates, the bundle of plates would be ~1.2-in. (3.048-cm) thick. Since the designed separation distance between plates is slightly larger than the fuel plates themselves (0.082 and 0.080 in., respectively), up to 30 loose fuel plates could be bundled together; in this configuration, 30 plates would occupy approximately the same volume as 15 plates in the fuel element structure. For conservatism, the uranium is modeled as HEU at 94% enrichment [U(94)] and the remainder is modeled as aluminum. Given that ~525-g ^{235}U is present in the fuel element, the 3,597 g of U/Al in the 15 MIT fuel plates would contain 558.5-g U(94). For two sets of fuel element plates bundled together without the fuel element grid structure, the 30 fuel plates would have ~1,050-g ^{235}U [1,117-g U(94)]. The evaluation in Sect. 6.9.8.5.1 covers both a single intact MIT U/Al element with 15 fuel plates and a bundled arrangement of up to 30 MIT U/Al fuel plates.

A uranium silicide (U_3Si_2) fuel plate measures 2.79-in. (7.0866 cm) wide × 0.05-in. (0.127-cm) deep (thickness) × 25-in. (63.5-cm) high. The fuel is 0.02-in. thick with 0.015-in. thick cladding on all sides. A fuel element consists of twelve plates, each plate weighing 161.6 g and containing on average 12.5-g ^{235}U, 63.27-g U (19.7), 5.13-g Si, and 93.4 g of 6061-T0 aluminum cladding. The 12 fuel plates (net weight 1,942 g) bundled together contains 150-g ^{235}U [759-g U(19.7)]. A bundle of 36 fuel plates (net weight 5,825 g) contains 450-g ^{235}U [2,277-g U(19.7)]. U_3Si_2 fuel having similar dimensions and less fissile content is bounded by MIT U/Al fuel.

The evaluation of HEU oxide in Sects. 6.4.3, 6.5.3, and 6.6.3, focuses on product and skull oxides characterized as loose material with bulk densities ranging from 2.0 to 6.54 g/cm^3. Unlike bulk oxides, reactor components of HEU oxide consist of compressed, sintered pellets with densities approaching the theoretical 10.96 g/cm^3. Pellets measuring 1.25 in. in diameter and 3.5 in. in height are stacked into clad-tubing of various lengths. Calculation models consider both bare rods and rods clad with ~2-mil (0.002-in.) thickness of aluminum, stainless-steel or zirconium. Dimensions for a bare rod

are 1.8288 cm (0.7200 in.) in diameter and 63.5000 cm (25.0 in.) in length. Dimensions for a clad rod are 1.8388 cm (0.7239 in.) in diameter and 63.5100 cm (25.0039 in.) in length. Seven different rod arrangements shown in Figs. 6.9.8.3.1-1a through 6.9.8.3.1-1g are analyzed for determining the most reactive configuration. Twelve rods in the CV contain 19,308.9 g ^{235}U in 21,937.6 g UO_2. Additional cases were run with thorium oxide mixed with HEU oxide.

Other proposed contents are U/Al alloy fuel plates and Al-clad HEU fuel plates. Alloys of uranium are not explicitly evaluated in Sects. 6.4.1, 6.4.2, 6.5.1, 6.5.2, 6.6.1, and 6.6.2. Instead, the uranium alloy is conservatively assessed by counting the neutron scattering constituents (aluminum, molybdenum, zirconium, etc.) as multiplying media (^{235}U). When the aluminum alloy or aluminum component of a fuel plate is conservatively assumed to be 100 wt % ^{235}U, then the loading capacity is severely limited by limits given for HEU broken metal. The U/Al or aluminum clad plates are explicitly modeled as a homogenized mixture of 93% enriched uranium and aluminum distributed evenly throughout the plate.

A SNAP reactor fuel pin composed of $UZrH_2$ is ~1.25 in. in diameter and ~12.45 in. long. The calculation model for the TRIGA fuel ($UZrH_{1.6}$) was adapted for use by changing the pin dimensions, the enrichment to 93 wt % ^{235}U, and the hydrogen component from 1.6 to 2.0.

Uranium Compounds

UF_4, UO_2F_2, $UO_2F_2 \cdot 2H_2O$, U_3Si_2, and U_3Si powder are conservatively modeled as water soluble compounds like the UNH content (Sects. 6.4.4, 6.5.4, and 6.6.4). An assumed maximum of 500 g of polyethylene represents Teflon or polyethylene bottles, and hydrogenous material used for packing. A solution formed by UF_4, UO_2F_2, $UO_2F_2 \cdot 2H_2O$, U_3Si_2, or U_3Si powder dissolved in water fills the entire volume of the CV. The amounts of uranium compound and evaluation water in the CV determines the most reactive content condition. Both flooding of the CV and a partial load of uranium compound is required to achieve the most reactive configuration.

Uranium carbide, uranium nitride, and uranium silicide are known to have been fabricated into reactor fuel pellets, fuel plates, and cylinders as solid shapes. The physical form and the moisture content of these materials is not known. These uranium compounds are assumed to be a loose, granular or powdered material. UC, U_2C_3, UC_2, UN, U_3Si_2 , and U_3Si are conservatively modeled both as granular compounds like HEU oxide (Sects. 6.4.3, 6.5.3, and 6.6.3) and as water-soluble compounds like the UNH content (Sects. 6.4.4, 6.5.4, and 6.6.4). An assumed maximum of 500 g of polyethylene is included to represent hydrogenous packing material.

6.9.8.3.2 Content model material specifications

Material properties specification for the content models are presented in Table 6.9.8.3-1.

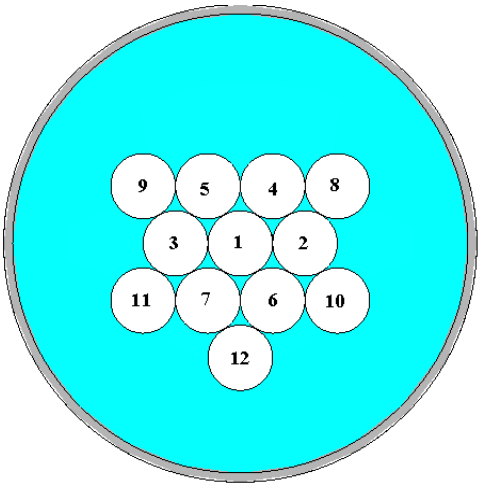


Fig. 6.9.8.3.1-1a. Config. "UO2_A."

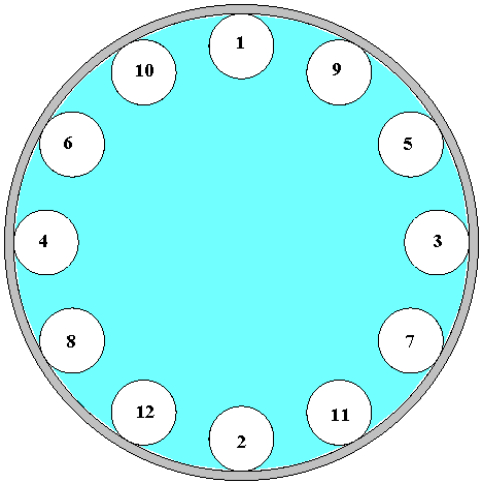


Fig. 6.9.8.3.1-1b. Config. "UO2_B."

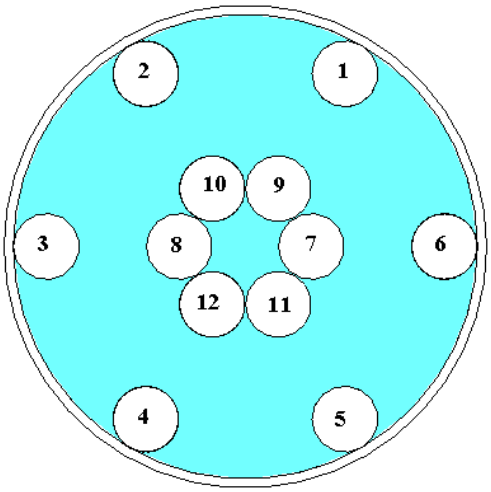


Fig. 6.9.8.3.1-1c. Config. "UO2_C."

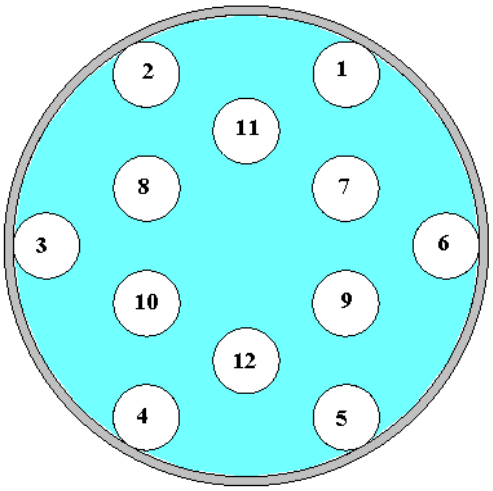


Fig. 6.9.8.3.1-1d. Config. "UO2_D."

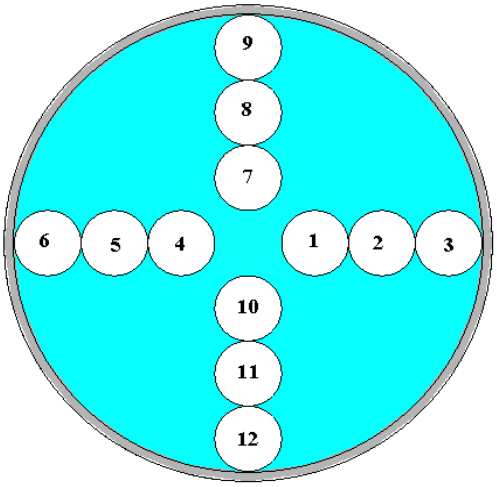


Fig. 6.9.8.3.1-1e. Config. "UO2_E."

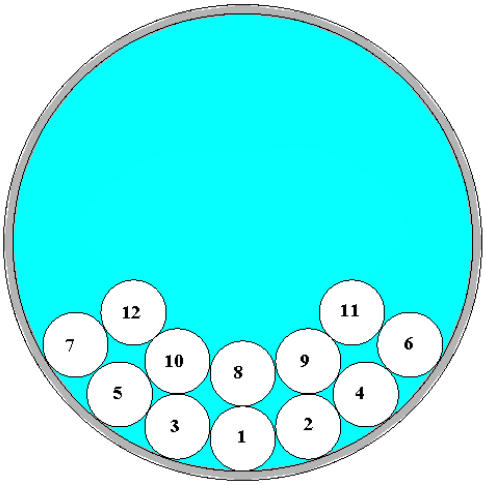


Fig. 6.9.8.3.1-1f. Config. "UO2_F."

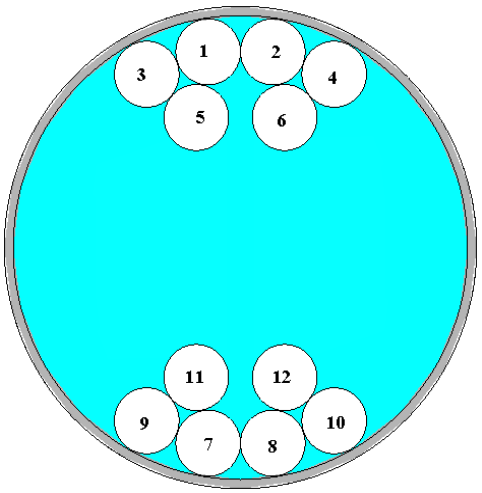


Fig. 6.9.8.3.1-1g. Config. "UO2_G."

Table 6.9.8.3-1. Material compositions for the content calculation models

Material	Mix. No.	Theoretical density input parameter (g/cm^3) [a]	Volume fraction	Constituent	Atomic weight	Weight fraction
Fissile material contents						
Uranium/aluminum	1	2.91688	1.0	Al	26.9818	92.5645
				^{235}U	235.0441	6.9150
				^{238}U	238.0510	0.5205
Uranium/aluminum (MIT U/Al fuel plates)	1	4.03371	1.0	Al	26.9818	61.4529
				^{235}U	235.0441	36.2343
				^{238}U	238.0510	2.3128
Uranium oxide (UO_2)	1	10.96000	1.0	O	15.9904	11.9827
				^{235}U	235.0441	88.0173
Uranium oxide (UO_2)	1	10.96000	1.0	O	15.9904	11.9827
				^{235}U	235.0441	88.0173
Thorium oxide (ThO_2)	1	10.00000	1.0	O	15.9904	12.1161
				^{235}Th	232.0381	87.8839
Aluminum (clad)	4	2.70200	1.0	Al	26.9818	100.0000
Stainless steel (clad)	4	7.94000	1.0	C	12.0111	0.0800
				Si	28.0853	1.0000
				P	30.9741	0.0450
				Cr	51.9957	19.0000
				Mn	54.9381	2.0000
				Fe	55.8447	68.3750
				Ni	58.6871	9.5000
Zirconium (clad)	4	6.49000	1.0	Zr	91.2196	100.0000

Table 6.9.8.3-1. Material compositions for the content calculation models

Material	Mix. No.	Theoretical density input parameter (g/cm^3) [a]	Volume fraction	Constituent	Atomic weight	Weight fraction
Fissile material contents						
93% enriched $UZrH_2$ (11,1647 g)	1	7.43210	1.0	H	1.0078	1.9835
				Zr	91.2196	89.7628
				^{235}U	235.0441	7.6738
				^{238}U	238.0510	0.5799
Uranium tetrafluoride (UF_4) (8,000 g) with 500 g polyethylene	1	1.12580	1.0	H	1.0078	0.6252
				C	12.0111	3.7226
				O	15.9954	0.0000
				F	18.9982	23.3698
				^{235}U	235.0441	72.2823
				^{238}U	238.0510	0.0000
Uranyl fluoride (UO_2F_2) (14,000 g) with 500 g polyethylene	1	1.41940	1.0	H	1.0078	0.4959
				C	12.0111	2.9525
				O	15.9954	10.1258
				F	18.9982	12.0271
				^{235}U	235.0441	74.3989
				^{238}U	238.0510	0.0000
Uranyl fluoride (UO_2F_2) (14,000 g) with 500 g poly and 7,439 g water in CV	1	2.14760	1.0	H	1.0078	4.1225
				C	12.0111	1.9513
				O	15.9954	36.8057
				F	18.9982	7.9489
				^{235}U	235.0441	49.1716
				^{238}U	238.0510	0.0000
Uranyl fluoride dihydrate ($UO_2F_2 \cdot 2H_2O$) (14,000 g) with 500 g of polyethylene	1	1.41940	1.0	H	1.0078	1.6371
				C	12.0000	2.9524
				O	15.9954	18.1130
				F	18.9982	10.7570
				^{235}U	235.0441	66.5411
				^{238}U	238.0510	0.0000
Uranyl fluoride dihydrate ($UO_2F_2 \cdot 2H_2O$) (14,000 g) with 500 g poly and 6,693 g water in CV	1	2.07460	1.0	H	1.0078	4.6544
				C	12.0000	2.0200
				O	15.9954	40.4389
				F	18.9982	7.3598
				^{235}U	235.0441	45.5270
				^{238}U	238.0510	0.0000
Uranium carbide (UC) (2,000 g) with 500 g poly and 8,656 g water in CV	1	2.17160	1.0	H	1.0078	4.9889
				C	12.0000	15.6704
				O	15.9954	22.5678
				^{235}U	235.0441	56.7729
				^{238}U	238.0510	0.0000

Table 6.9.8.3-1. Material compositions for the content calculation models

Material	Mix. No.	Theoretical density input parameter (g/cm^3) [a]	Volume fraction	Constituent	Atomic weight	Weight fraction
Fissile material contents						
Uranium sesquicarbide (U_2C_3) (2,000 g) with 500 g poly and 8656 g water in CV	1	2.16460	1.0	H	1.0078	4.9690
				C	12.0000	17.0712
				O	15.9954	22.3551
				^{235}U	235.0441	56.7729
				^{238}U	238.0510	0.0000
Uranium dicarbide (UC_2) (2,000 g) with 500 g poly and 8656 g water in CV	1	2.15200	1.0	H	1.0078	4.9326
				C	12.0000	18.4667
				O	15.9954	21.9657
				^{235}U	235.0441	54.6351
				^{238}U	238.0510	0.0000
Uranium silicide (U_3Si_2) (7,000 g) with 500 g poly and 8656 g water in CV	1	1.62670	1.0	H	1.0078	6.5728
				C	12.0000	2.5763
				O	15.9954	48.7247
				^{235}U	235.0441	23.4195
				^{238}U	238.0510	15.6132
				Si	28.0853	3.0936
Uranium silicide (U_3Si) (14,000 g) with 500 g poly and 5989 g water in CV	1	2.7162	1.0	H	1.0078	3.62224
				C	12.0107	2.08938
				O	15.9949	25.9597
				^{235}U	235.0439	26.2922
				^{238}U	238.0508	39.4383
				Si	28.0853	2.59818

[a] The theoretical density input parameter is specified for each material such that the required (or desired) mass of material is represented in the KENO V.a calculation model. The mass of material is computed by KENO V.a as the product of the theoretical density input parameter times the volume fraction times the volume of the geometry region in which the material resides in the calculation model.

6.9.8.4 Computer Codes and Cross-Section Libraries

Calculations presented herein were performed using the Monte Carlo CSAS25 criticality code sequence and 238-group ENDFB-V cross section library of SCALE 5.0 (NUREG/CR-0200, Rev. 7), executed on identical Hewlett Packard (HP) Model zx6000 Itanium workstations (CMODC and CMODD) of the Y-12 Safety Analysis Engineering organization in Oak Ridge, Tennessee. Criticality calculations documented in Sects. 6.4–6.6 were performed using SCALE 4.4a (NUREG/CR-0200, Rev. 6) executed on an HP Model J5600 RISC workstation (CMODB). The obsolete CMODB with HP-UX 10.20 operating system was recently retired from service. SCALE 4.4a no longer supported by the code developer is not portable to the updated computing platforms thus necessitating the use of SCALE 5.0.

The SCALE 4.4a criticality codes and cross-section library are addressed in Sect. 6.3.3. The 238-group ENDF/B-V cross-section library used by SCALE 5.0 is unchanged from the previous version SCALE 4.4a. Also, most of the modular codes in CSAS25 control sequence of SCALE 5.0 are unchanged except for the cross-section processing functional module NITAWL-III.

NITAWL-III applies the Nordheim integral treatment to perform neutron cross-section processing in the resonance energy range for nuclides that have ENDF/B resonance parameter data. This technique involves the numerical integration of ENDF/B resonance parameters using a calculated flux distribution, which is based on the calculated collision density across each resonance and subsequent weighing of the reaction cross section to the desired broad group structure. In the CSAS sequence, NITAWL-III assembles the group-to-group transfer arrays from the elastic and inelastic scattering components and performs other tasks to produce a problem-dependent working cross-section library which can be used by KENO V.a.

As noted in the user manual, several extensions to the Nordheim calculation have been implemented into the algorithm contained in NITAWL-III:

- Elements containing more than one isotope can be treated.
- Self-shielding is applied to resonance scattering. Transfer matrices are adjusted.
- g-, f-, d-, and p-wave as well as s-wave levels can be treated.
- The asymptotic approximation for the flux in the thermal energy range is assumed to have a Maxwellian energy distribution.
- A refined procedure for generating the energy mesh over which reaction rates are integrated has been developed.

As with the SCALE 4.4a calculations, the k_{eff} values for each KENO V.a case are based on 500,000 neutron histories produced by running for 215 generations with 2,500 neutrons per generation and truncating the first 15 generations of data. The convergence of the KENO V.a calculation is related to trends in the average calculated k_{eff}. In general, the KENO V.a output table of k_{eff} by generation skipped is reviewed for trends. If no trends are observed, the calculation is accepted, and the reported value of k_{eff} is the one with the most neutron histories. There is usually no statistically significant difference between this result and the one with the smallest standard deviation.

No manual cross-section adjustment is performed for the criticality evaluation. Cross-section processing is performed automatically in the CSAS25 code sequence. Modeling the contents as precisely as possible improves the accuracy of cross-section processing.

The CSAS25 control module, the associated functional modules, the cross section library, and databases used in this evaluation reside in the verified configuration control area designated **/vcc/scale5** on CMODC and CMODD. Also, the computer input and output files for the criticality safety evaluation of the ES-3100 shipping package with the additional content reside in a configuration controlled area **/archive/sppkg_801940a002** on CMODC.

The criticality validation for SCALE 6.1.3 is based on benchmark experiments documented in the Organization for Economic Cooperation and Development (OECD) Handbook [NEA/NSC/DOC(95)03]. The USL without any safety margin—derived for the validation of CSAS5 control module of SCALE 6.1.3 with the multi-group V7-238-gr cross-section library run on ENGHPC workstation—is 0.9868 for thermal energy systems, 0.9852 for intermediate energy HEU systems, and 0.9886 for fast energy systems as documented in RP YAREA-F-0524. NUREG/CR-5661 provides guidance that the USL should be established with a minimum margin of subcriticality of 0.05. Using this safety margin, the USL for the calculations performed in this document would be 0.9368 for thermal energy systems, 0.9352 for intermediate energy systems, and 0.9386 for fast energy systems.

Calculations for U_3Si powder, U_3Si-Al powder, U_3Si_2-Al powder, and UO_2ThO_2 pellets were performed using the Monte Carlo CSAS5 and 238-group ENDF/B-VII (V7-238 gr) cross-section library of SCALE 6.1.3, executed on a Microway Parallel Linux Cluster ENGHPC at the Y-12 National Security Complex.

Several CSAS control modules are contained in SCALE 6.1.3. The CSAS control modules are designed to analyze systems containing fissile material and calculate the neutron multiplication factor (k_{eff}) of the system. The CSAS5 control module calls a series of utility modules and other functional modules to process the cross-section data before calling the KENO V.a functional module for calculating the k_{eff}. The modules associated with CSAS5 are:

- WORKER: This functional module interfaces between the AMPX master library contained in the SCALE code package and the AMPX working library used in KENO V.a.
- BONAMI: This functional module processes the unresolved resonance data contained in the master library and places it in the working library.
- PMC: This functional module uses point-wise continuous cross-section data to solve a one-dimensional equivalent problem producing a flux profile used for processing cross-section data.
- CENTRM: This functional module uses the flux profile calculated in PMC to collapse point-wise continuous cross-section data into the appropriate group structure producing a working library used in KENO V.a.
- KENO V.a: This functional module performs the three-dimensional Monte Carlo calculation using the cross-section library provided by the WORKER module.

The V7-238 gr cross-section library used to perform criticality calculations is a multigroup library containing 238 discrete neutron energy groups processed from the ENDF/B-VII continuous energy cross-section data.

The CSAS5 control module, the associated functional modules, the cross-section library, and databases used in this evaluation reside in the verified configuration control area designated **/vcc/scale6** on ENGHPC. The computer input and output files for the criticality safety evaluation of the ES-3100 package with the additional content also reside in a configuration control area **/wa9/archive/RP-801940-A001R3** on ENGHPC.

6.9.8.5 Single Package Evaluation (NCT and HAC)

The analyses presented in Sect. 6.4 demonstrate that the calculated $k_{eff} \pm 2\sigma$ values increase as a function of increasing MOIFR. Therefore, a fully flooded, reflected package is used to calculate the neutron multiplication factors for the single package analysis.

Reactor Fuel Components and Scrap Materials

6.9.8.5.1 U/Al fuel plates (Table 6.9.8.8-1a)

Uranium alloys may be loaded to the broken metal mass limits by assuming the mass of the alloy is all ^{235}U. An explicit evaluation is performed for deriving less restrictive limits for contents where the constituents of the alloy are predominately non-fissile.

The calculation model for bundled U/Al fuel plates at 93% enrichment is based on the BR-2 MTR Type 2 fuel plate described in Sect. 6.9.8.3.1. Four configurations were developed for the analysis. Case **5cvsrualfpt11p_1_1_15** represents a tight-packed bundle of 35 fuel plates side-by-side inside a flooded CV reflected on all sides by 30.48 cm water. A very small portion of the total 7,333 g of U/Al in a bundle is ^{235}U (~473 g). Cases **5cvsrualfpt11p_2_1_15**, **5cvsrualfpt11p_3_1_15**, and **5cvsrualfpt11p_4_1_15** model the plates with uniform spacing of 0.04 cm, 0.08 cm, and 0.116 cm separation between the plates, respectively. The calculated $k_{eff} \pm 2\sigma$ values range from 0.308 to 0.411. . 0.116 cm is the largest separation between the fuel plates that can be modeled without intersecting the CV.

Similarly, the NCT Cases **5ncsrualfpt11p_1_1_15**, **5ncsrualfpt11p_2_1_15**, **5ncsrualfpt11p_3_1_15,** and **5ncsrualfpt11p_4_1_15** model the U/Al plate configurations inside a flooded ES-3100 package with full water reflection. The calculated $k_{eff} \pm 2\sigma$ values range from 0.262 to 0.342. Comparison of NCT single package results with corresponding case results for the flooded, reflected CV demonstrates that ES-3100 packaging is not as an effective moderator as full water reflection.

HAC Cases **5hcsrualfpt12p_1_1_15**, **5hcsrualfpt12p_2_1_15**, **5hcsrualfpt12p_3_1_15**, and **5hcsrualfpt12p_4_1_15** model the U/Al plate configurations inside a damaged ES-3100 package with full water reflection. Comparison of HAC single package results with corresponding NCT results reaffirms that an insignificant difference is observed between the calculated $k_{eff} \pm 2\sigma$ values.

A single flooded, fully water reflected ES-3100 package, either undamaged or damaged, loaded with U/Al fuel plates (net weight 7,333 g) containing ~473 g of ^{235}U will remain adequately subcritical below the USL of 0.924.

Six loading configurations are analyzed for evaluation of the effect of plate separation for a 15-plate U/Al MIT fuel element. One configuration models a compact array of 15 fuel plates with no separation inside the CV. The five other configurations model the plates with 0.0508-, 0.127-, 0.20828-, 0.37338-, 0.442-, and 0.53594-cm. (maximum) separation between the plates. The two outermost plates would start to intersect the CV wall with larger separation distances between the plates.

Case **5cvcrmitfpt11p_1_1_15** represents a tight-packed bundle of 15 fuel plates face-to-face inside a flooded CV that is reflected on all sides by 30.48 cm of water. Cases **5cvcrmitfpt11p_2_1_15** through **5cvcrmitfpt11p_6_1_15** model the same plates with uniform spacing of 0.0508-, 0.127-, 0.20828-, 0.37338-, and 0.442-cm. separation between the plates, respectively. The calculated $k_{eff} \pm 2\sigma$ values range from 0.325 to 0.478. These same separation values are used in all of the other calculation models for the 15-plate MIT element evaluation.

Similarly, the NCT Cases **5ncsrmitfpt11p_1_1_15** through **5ncsrmitfpt11p_6_1_15** model the MIT fuel plate configurations inside a flooded ES-3100 package with full water reflection. The calculated $k_{eff} \pm 2\sigma$ values range from 0.300 to 0.426.

HAC Cases **5hcsrmitfpt12p_1_1_15** through **5hcsrmitfpt12p_6_1_15** model the MIT 15-plate configurations inside a damaged ES-3100 package with full water reflection. Comparison of HAC single package results with corresponding NCT results reaffirms that an insignificant difference is observed between the calculated $k_{eff} \pm 2\sigma$ values.

Two loading configurations are analyzed for evaluation of the effect of plate separation for a 30-plate bundle of MIT fuel. One configuration models a compact array of 30 fuel plates with no separation inside the CV. The other configuration models the plates with 0.119-cm. separation between the plates. The two outermost plates would start to intersect the CV wall with larger separation distances between the plates.

Case **5cvcr30mitfpt11p_1_1_15** represents a tight-packed bundle of 30 fuel plates face-to-face inside a flooded CV, which is reflected on all sides by 30.48-cm water. Case **5cvcr30mitfpt11p_6_1_15** models the same 30 plates with the maximum possible uniform spacing within the CV of 0.119-cm. separation between the plates. The calculated $k_{eff} \pm 2\sigma$ values for these two extremes are 0.354 and 0.451. These same separation values are used in all of the other calculation models for the evaluation of the 30-plate bundle of MIT U/Al fuel plates.

Similarly, the NCT Cases **5ncsr30mitfpt11p_1_1_15** and **5ncsrmitfpt11p_6_1_15** model the MIT fuel plate configurations inside a flooded ES-3100 package with full water reflection. The calculated $k_{eff} \pm 2\sigma$ values for these two extremes (tight-packed and maximum possible uniform spacing) are 0.263 and 0.369.

HAC Cases **5hcsr30mitfpt12p_1_1_15** and **5hcsr30mitfpt12p_6_1_15** model the MIT 30-plate bundle configurations inside a damaged ES-3100 package with full water reflection. Comparison of HAC single package results with corresponding NCT results reaffirms that an insignificant difference is observed between the calculated $k_{eff} \pm 2\sigma$ values.

A single flooded, fully water reflected ES-3100 package, either undamaged or damaged, loaded with a single MIT element consisting of 15 U/Al fuel plates (net weight 3,597 g) containing ~525 g of ^{235}U, or loaded with a bundle of up to 30 MIT fuel plates (net weight 7,194 g) containing ~1,050 g of ^{235}U, will remain adequately subcritical below the USL of 0.93680.

6.9.8.5.2 Reactor components of HEU oxide (Table 6.9.8.8-2)

Twelve UO_2 oxide rods in a CV are modeled to determine whether the clad or unclad rods are the most reactive. Case **5cvsroxt11_1_4_1_15** models unclad UO_2 rods as shown in Fig. 6.9.8.3.1-1d, while Case **5cvsroxt11p_1_4_1_15** models unclad UO_2 rods with 500 g of polyethylene. Case **5cvsroxt11_1_4_2_15** models Al-clad UO_2 rods. Case **5cvsroxt11_1_4_3_15** models Zr-clad rods. Case **5cvsroxt11_1_4_4_15** is for unclad UO_2 rods. The calculated $k_{eff} \pm 2\sigma$ values for unclad, Al-clad, SS304-clad, and Zr-clad UO_2 rods with no polyethylene range from 0.799 to 0.801. The unclad UO_2 rods are the most reactive configuration. Comparing the fuel rods with polyethylene, the CV and single package cases are slightly more reactive and the array calculations are essentially the same. All cases were well below the USL.

The single unit analysis is performed with unclad rods modeled in the various rod arrangements shown in Figs. 6.9.8.3.1-1a through 6.9.8.3.1-1g. For NCT Cases **5ncsroxt11_1_1_1_15** through **5ncsroxt11_1_7_1_15,** the calculated $k_{eff} \pm 2\sigma$ values range from 0.604 to 0.745. For HAC Cases **5hcsroxt12_1_1_1_15** through **5hcsroxt12_1_7_1_15**, the calculated $k_{eff} \pm 2\sigma$ values range from 0.603 to 0.750. Configuration "**UO2_D**" shown in Fig. 6.9.8.3.1-1d is the most reactive one represented by Cases **5ncsroxt11_1_4_1_15** and **5hcsroxt12_1_4_1_15**. A single flooded, fully water reflected ES-3100 package with up to 12 clad or unclad UO_2 fuel rods, each containing ~1,609 g of ^{235}U are adequately subcritical, below the USL of 0.924. Case **5ncsroxt11p_1_4_1_15** with unclad UO_2 rods with 500 g of polyethylene, are adequately subcritical, below the USL of 0.93520, with no difference between fuel rods with or without polyethylene.

Additional calculations were performed to exam the effect that ThO_2 would have on the UO_2 fuel rods. In this model, UO_2 is replaced with UO_2 in increments of 10% up to all of the fuel rod composed of ThO_2. The results of these calculations are found in Table 6.9.8.8-2. As more ThO_2 is substituted for UO_2, reactivity decreases. This is expected since thorium is not fissile, and as such has no subcritical limits in any ANSI/ANS standards or handbook data.

6.9.8.5.3 $UZrH_2$ fuel (Table 6.9.8.8-3)

SNAP fuel elements are modeled as 12.45-in.-tall cylinders of $UZrH_2$. The analysis assumes that three SNAP fuel elements each are packed into both the bottom and middle can locations, rather than the fuel being size reduced to fit into 10-in. or 8-3/4 in.-tall convenience cans. The top can location is assumed void. For calculations where canned spacers are modeled, two canned spacers are assumed present in the CV. For configurations where canned spacers are not used, the $UZrH_2$ content is assumed stacked end-to-end. The three cylinders of the active fuel are modeled in triangular-pitch configuration within a radial boundary of 4.25 in. The pitch used in the criticality calculation models for the NCT and HAC ground transport is 4.9809 cm (1.96 in.). Five hundred grams of polyethylene is modeled to represent the maximum amount of hydrogenous packing material in the CV.

NCT Cases **5ncsrsnapp_93_1_15_15** and **5ncsrsnapp_93_1_1_15** model the $UZrH_2$ cylinders inside a flooded or dry CV in flooded ES-3100 packaging under full water reflection. The calculated $k_{eff} \pm 2\sigma$ values are 0.571 and 0.283, respectively. Cases **5ncsrsnapp_93_2_15_15** and **5ncsrsnapp_93_2_1_15** model the presence of canned spacers. The calculated $k_{eff} \pm 2\sigma$ values are 0.544 and 0.264, respectively. Case **5ncsrsnap_93_1_1_15** (without polyethylene) has a $k_{eff} \pm 2\sigma$ values of 0.568, which is slightly less reactive than the polyethylene case.

HAC Cases **5hcsrsnapp_93_1_15_15** and **5hcsrsnapp_93_1_1_15** model the $UZrH_2$ cylinders inside a flooded or dry CV in flooded damaged ES-3100 packaging under full water reflection. The calculated $k_{eff} \pm 2\sigma$ values are 0.571 and 0.285, respectively. The 1.4-in.-thick canned spacers are modeled in Cases **5hcsrsnapp_93_2_15_15** and **5hcsrsnapp_93_2_1_15**. The calculated $k_{eff} \pm 2\sigma$ values are 0.545 and 0.265, respectively. Comparison of HAC single package results with corresponding NCT results reaffirms that an insignificant difference is observed between the calculated $k_{eff} \pm 2\sigma$ values. Case **5hcsrsnap_93_1_1_15** (without polyethylene) has a $k_{eff} \pm 2\sigma$ values of 0.569, which is slightly less reactive than the polyethylene case.

10 CFR 71.55(d)(2) requires the geometric form of a package's content not be substantially altered under the NCT. Also, 10 CFR 7155(e)(1) requires that the package be adequately subcritical under HAC with the package contents in the most reactive credible configuration. However, conclusions about damage to the fuel content cannot be extrapolated from test data because a mock (test weight) content rather than actual SNAP content is evaluated in the NCT and HAC tests of 10 CFR 71.71 and 10 CFR 71.73. Consequently, one way for addressing these requirements is to model the content in an extremely damaged condition and make a determination of subcriticality through a series of criticality calculations. Case **5ncsr9355d2p_1_15_15** models the $UZrH_2$ homogenized with the water of a flooded CV and dispersed over the free volume of the CV, where the undamaged ES-3100 packaging is flooded and reflected by 30.48 cm of water. Similarly, Case **5ncsrs9355d2p_1_1_15** and 5ncsrs9355d2p_1_15_15 models the $UZrH_2$ dispersed over the free volume of a dry CV of the ES-3100 packaging. The calculated $k_{eff} \pm 2\sigma$ values are 0.191 and 0.679, respectively.
Cases **5ncsr9355d2p_2_15_15** and **5ncsr9355d2p_2_1_15** model the presence of the canned spacers. The calculated $k_{eff} \pm 2\sigma$ values for these cases are 0.647 and 0.182, respectively. These results indicate that extremely damaged content is more reactive than the unaltered configuration. Nevertheless, each set of cases is adequately below the USL of 0.9352 and the requirement of 10 CFR 71.55(d)(2) is satisfied. Given that changes external to the CV due to HAC do no result in an appreciable change in neutron multiplication for the single package, similar results are expected for the cases demonstrating compliance

with 10 CFR 71.55(e)(1). Conclusions regarding compliance with 10 CFR 71.55(d)(2) equally apply regarding compliance with 10 CFR 71.55(e)(1).

A single flooded, fully water reflected ES-3100 package, either undamaged or damaged, loaded with $UZrH_2$ (net weight 11,164 g) containing ~857 g ^{235}U will remain adequately subcritical below the USL 0.93520.

6.9.8.5.4 UZr fuel plates

As an alloy, UZr fuel plates may be loaded to the broken metal mass limits by assuming the mass of the alloy is all uranium.

Uranium Compounds

UF_4, UO_2F_2, and $UO_2F_2 \cdot 2H_2O$ are conservatively modeled as water soluble compounds like the UNH content (Sects. 6.4.4, 6.5.4, and 6.6.4). UC, U_2C_3, UC_2, and UN are conservatively modeled both as granular compounds like HEU oxide (Sects. 6.4.3, 6.5.3, and 6.6.3) and as water-soluble compounds like the UNH content (Sects. 6.4.4, 6.5.4, and 6.6.4). An assumed maximum of 500 g of polyethylene represents Teflon or polyethylene bottles, and hydrogenous material used for packing.

6.9.8.5.5 UF compounds (Tables 6.9.8.8-5a, 6.9.8.8-5b)

Consider the flooded, water reflected CV with the UF_4 content in solution and homogenized with 500 g polyethylene. The UF_4 content ranges from 24,000 to 1,000 g. For Cases **5cvcrpuf4t11_24_15** through **5cvcrpuf4t11_1_15** (Table 6.9.8.8-5a), the $k_{eff} \pm 2\sigma$ values range from 0.863 to 0.709 and optimum concentration occurs at ~11,000 g UF_4 ($k_{eff} \pm 2\sigma = 0.890$).

Consider a single, flooded ES-3100 package loaded with UF_4 content in solution and homogenized with 500 g polyethylene. The UF_4 content ranges from 24,000 to 1,000 g. For Cases **5ncsrpuf4t11_24_15** through **5ncsrpuf4t11_1_15**, the $k_{eff} \pm 2\sigma$ values range from 0.747 to 0.629 and optimum concentration occurs at ~9,000 g UF_4 ($k_{eff} \pm 2\sigma = 0.783$). Given that the water-reflected CV is more reactive than the water-reflected package, the result for Case **5cvcrpuf4t11_11_15** is reported [10 CFR 71.55(b)].

Consider the flooded, water reflected CV with the UO_2F_2 content in solution and homogenized with 500 g polyethylene. The UO_2F_2 content ranges from 24,000 to 1,000 g. For Cases **5cvcrpuofct11_24_15** through **5cvcrpuofct11_1_15** (Table 6.9.8.8-5b), the $k_{eff} \pm 2\sigma$ values range from 0.851 to 0.710 and optimum concentration occurs at ~8,000 g UO_2F_2 ($k_{eff} \pm 2\sigma = 0.887$). Consider $UO_2F_2 \cdot 2H_2O$ content in solution and homogenized with 500 g polyethylene. The $UO_2F_2 \cdot 2H_2O$ content ranges from 24,000 to 1,000 g. For Cases **5cvcrpuofhct11_24_15** through **5cvcrpuofhct11_1_15** (Table 6.9.8.8-5b), the $k_{eff} \pm 2\sigma$ values range from 0.898 to 0.696 and optimum concentration occurs at ~14,000 g $UO_2F_2 \cdot 2H_2O$ ($k_{eff} \pm 2\sigma = 0.907$). Given that $UO_2F_2 \cdot 2H_2O$ is more reactive than UO_2F_2, calculations with $UO_2F_2 \cdot 2H_2O$ are bounding.

Consider a single, flooded ES-3100 package loaded with $UO_2F_2 \cdot 2H_2O$ content in solution and homogenized with 500 g polyethylene. For Cases **5ncsrpuofhct11_24_15** through **5ncsrpuofhct11_1_15** (Table 6.9.8.8-5b), the $k_{eff} \pm 2\sigma$ values range from 0.787 to 0.614 and optimum concentration occurs at ~14,000 g $UO_2F_2 \cdot 2H_2O$ ($k_{eff} \pm 2\sigma = 0.798$). The water-reflected CV is more reactive than the water-reflected package; therefore the result for Case **5cvcrpuofhct11_14_15** is reported [10 CFR 71.55(b)].

6.9.8.5.6 UC and UN compounds (Tables 6.9.8.8-6a, 6.9.8.8-6b)

Consider the flooded, water reflected CV with 500 g polyethylene homogenized with bulk saturated UC, U_2C_3, UC_2, or UN compound. These uranium compounds are evaluated over the range from 10,000 to 1,000 g. For Cases **5cvcrpuct11_1_10** through **5cvcrpuct11_1_1** (Table 6.9.8.8-6a), the $k_{eff} \pm 2\sigma$ values for UC content decrease from 0.945 to 0.648. For Cases **5cvcrpuct11_2_10** through **5cvcrpuct11_2_1**, the $k_{eff} \pm 2\sigma$ values for U_2C_3 decrease from 0.910 to 0.643. For Cases **5cvcrpuct11_3_10** through **5cvcrpuct11_3_1**, the $k_{eff} \pm 2\sigma$ values for UC_2 decrease from 0.901 to 0.637. For Cases **5cvcrpunt11_10** through **5cvcrpunt11_1** (Table 6.9.8.8-6b), the $k_{eff} \pm 2\sigma$ values for UN decrease from 0.909 to 0.646.

Consider a single ES-3100 package loaded with 500 g polyethylene homogenized with bulk saturated UC, U_2C_3, UC_2, or UN compound. These uranium compounds are evaluated over the range from 10,000 to 1,000 g. For Cases **5ncsrpuct11_1_10_15** through **5ncsrpuct11_1_1_15** (Table 6.9.8.8-6a), the $k_{eff} \pm 2\sigma$ values for UC content decrease from 0.814 to 0.575. For Cases **5ncsrpuct11_2_10_15** through **5ncsrpuct11_2_1_15**, the $k_{eff} \pm 2\sigma$ values for U_2C_3 decrease from 0.811 to 0.575. For Cases **5ncsrpuct11_3_10_15** through **5ncsrpuct11_3_1_15**, the $k_{eff} \pm 2\sigma$ values for UC_2 decrease from 0.802 to 0.570. For Cases **5ncsrpunt11_10_15** through **5ncsrpunt11_1_15** (Table 6.9.8.8-6b), the $k_{eff} \pm 2\sigma$ values for UN content decrease from 0.814 to 0.574. The water-reflected CV cases are more reactive than the corresponding cases for the water-reflected package.

Consider a single ES-3100 package loaded with 500 g polyethylene homogenized with 2,000 g bulk saturated UC or UN compound. The water inside the CV is varied from the flooded to the dry condition. For Cases **5ncsrpuct11_1_2_15** through **5ncsrpuct11_1_2_1** (Table 6.9.8.8-6a), the $k_{eff} \pm 2\sigma$ values for UC content decrease from 0.657 to 0.617. For Cases **5ncsrpunt11_2_15** through **5ncsrpunt11_2_1** (Table 6.9.8.8-6b), the $k_{eff} \pm 2\sigma$ values for UN content decrease from 0.657 to 0.615. These cases reveal that the addition of water in the void region of the CV above the homogenized water saturated content has little effect on neutron multiplication.

6.9.8.5.7 U_3Si_2 and U_3Si_2-Al powder (Tables 6.9.8.8-7a, 6.9.8.8-7b)

Consider the flooded, water-reflected CV loaded with 500-g polyethylene homogenized with bulk saturated U_3Si_2. This content is evaluated from 13,000- to 7,000-g U_3Si_2 over a density range of 7 to 2 g/cm^3. For Cases **5cvcrpdusit11_8_7_13_15** through **5cvcrpdusit11_8_2_13_15** (Table 6.9.8.8-7a), the $k_{eff} \pm 2\sigma$ values for U_3Si_2 content increase from 0.849 to 0.920 as the density decreases. For Cases **5cvcrdpust11_8_7_13_15** through **5cvcrdpust11_8_2_13_15** where the same content is dispersed over the internal volume of the CV, $k_{eff} \pm 2\sigma = 0.929$. The uniform configuration—a column of 8656-g water is mixed with 13-kg U_3Si_2 and 500-g polyethylene—is more reactive than the discrete configuration—13-kg U_3Si_2 (plus 5,490-g saturation water) and 500-g polyethylene separated from the 3,166 g of water filling the remaining volume of the CV.

For Cases **5cvcrdpusttt11_8_7_13_15** through **5cvcrpdusit11_8_7_7_15** (Table 6.9.8.8-7a), the $k_{eff} \pm 2\sigma$ values for U_3Si_2 content decrease from 0.929 to 0.915 as the mass of U_3Si_2 decreases from 13- to 7-kg U_3Si_2 .

For Cases **5cvcrpdusit11_8_7_13_15** through **5cvcrpdusit11_1_7_13_15** (Table 6.9.8.8-7a), the $k_{eff} \pm 2\sigma$ values decrease from 0.849 to 0.624 as the enrichment decreases from 100 to 19.7% in the content (13-kg U_3Si_2 plus 5,490-g saturation water and 500-g polyethylene). Similarly for Cases **5cvcrdpust11_8_7_13_15** through **5cvcrdpust11_1_7_13_15**, the $k_{eff} \pm 2\sigma$ values decrease from 0.929 to 0.763 where this content is dispersed over the CV. The same trend is evident in Cases **5cvcrdpust11_8_7_7_15** through **5cvcrdpust11_1_7_7_15** for a reduced amount of content, the $k_{eff} \pm 2\sigma$ values decrease from 0.915 to 0.724.

For Cases **5cvcrdpustt11_1_7_13_15** through **5cvcrpdusit11_1_7_7_15** (Table 6.9.8.8-7a), the $k_{eff} \pm 2\sigma$ values for U_3Si_2 content decrease from 0.763 to 0.724 as the mass of U_3Si_2 decreases from 13- to 7-kg U_3Si_2 at 19.7% enrichment.

Consider a single ES-3100 package loaded with 500-g polyethylene homogenized with bulk saturated U_3Si_2. This content is evaluated from 13,000- to 7,000-g U_3Si_2 over a density range of 7 to 2 g/cm^3. For Cases **5ncsrpdusit11_8_7_13_15** through **5ncsrpdusit11_8_2_13_15** (Table 6.9.8.8-7b), the $k_{eff} \pm 2\sigma$ values for U_3Si_2 content increase from 0.769 to 0.820 as the density decreases. For Cases **5ncsrdpust11_8_7_13_15** through **5ncsrdpust11_8_2_13_15** where the same content is dispersed over the internal volume of the CV, $k_{eff} \pm 2\sigma = 0.824$. For Cases **5ncsrdpust11_8_7_13_15** through **5ncsrdpust11_8_7_7_15** (Table 6.9.8.8-7b), the $k_{eff} \pm 2\sigma$ values for U_3Si_2 content decrease from 0.824 to 0.809 as the mass of U_3Si_2 decreases from 13- to 7-kg U_3Si_2.

For Cases **5ncsrpdusit11_8_7_13_15** through **5ncsrpdusit11_1_7_13_15** (Table 6.9.8.8-7b), the $k_{eff} \pm 2\sigma$ values decrease from 0.769 to 0.521 as the enrichment decreases from 100 to 19.7% in the content (13-kg U_3Si_2 plus 5,490-g saturation water and 500-g polyethylene). Similarly for Cases **5ncsrdpust11_8_7_13_15** through **5ncsrdpust11_1_7_13_15**, the $k_{eff} \pm 2\sigma$ values decrease from 0.824 to 0.662 where this content is dispersed over the CV. The same trend is evident in Cases **5ncsrdpust11_8_7_7_15** through **5ncsrdpust11_1_7_7_15** for a reduced amount of content, the $k_{eff} \pm 2\sigma$ values decrease from 0.809 to 0.633.

The same trend observed for the flooded reflected CV is apparent for the flooded reflected package; however, the water-reflected CV cases are more reactive than the corresponding cases for the water-reflected package. The result for Case **5cvcrdpust11_8_7_7_15** (Table 6.9.8.8-7a) is reported [10 CFR 71.55(b)].

Additional calculations were performed to determine the effect aluminum would have on the reactivity of U_3Si_2 powder. Parametric studes were performed for U_3Si_2 powder at an enrichment of 100%, varying the amount of aluminum from none up to 4 kg. The aluminum is modeled at the same bulk density as U_3Si_2, which is 2 g/cm^3. The results of these calculations can be found in Table 6.9.8.8-7a. As aluminum powder at the same bulk density as U_3Si_2 is added, reactivity decreases. Thus, the limits and controls for U_3Si_2 would bound this loading.

6.9.8.5.8 U_3Si and U_3Si-Al powder (Tables 6.9.8.8-7a, 6.9.8.8-7b)

Consider the flooded, water-reflected CV loaded with 500-g polyethylene homogenized with bulk saturated U_3Si. This content is evaluated from 4,000- to 14,000-g U_3Si at a density of 2 g/cm^3, since this density has shown to be the most reactive from previous calculations for compounds (see above sections). The results of these cases can be found in Table 6.9.8.8-7a. For U_3Si powder with 500 g of polyethylene at enrichment of 40% in a dry CV, for a CSI = 0, the most reactive case below the USL of 0.9352 is Case **cvcrdpus3sit11_2_6_1**, with a $k_{eff} + 2\sigma$ value of 0.826 for 14 kg of U_3Si. For when U_3Si powder is dispersed over the internal volume of the CV, the most reactive case below the USL of 0.9368 is Case **cvcrdpu3sit11_2_6_1**, with a $k_{eff} + 2\sigma$ value of 0.706 for 14 kg of U_3Si. For a flooded CV, the most reactive case below the USL of 0.9352 is Case **cvcrdpus3sit11_2_6_15**, with a $k_{eff} + 2\sigma$ value of 0.829 for 14 kg of U_3Si. For when U_3Si powder is dispersed over the internal volume of the CV, the most reactive case below the USL of 0.9352 is Case **cvcrdpu3sit11_2_6_15**, with a $k_{eff} + 2\sigma$ value of 0.838 for 14 kg of U_3Si.

For 60% enrichment in a dry CV, the most reactive case below the USL of 0.9352 is Case **cvcrdpus3sit11_3_6_1**, with a $k_{eff} + 2\sigma$ value of 0.859 for 14 kg of U_3Si. For when U_3Si powder is dispersed over the internal volume of the CV, the most reactive case below the USL of 0.9352 is Case **cvcrdpu3sit11_3_6_1**, with a $k_{eff} + 2\sigma$ value of 0.738 for 14 kg of U_3Si. For a flooded CV, the

most reactive case below the USL of 0.9352 is Case **cvcrdpus3sit11_3_6_15**, with a k_{eff} + 2σ value of 0.860 for 14 kg of U_3Si. For when U_3Si powder is dispersed over the internal volume of the CV, the most reactive case below the USL of 0.9352 is Case **cvcrdpu3sit11_3_6_15**, with a k_{eff} + 2σ value of 0.871 for 14 kg of U_3Si.

The results for Cases **cvcrdpu3sit11_2_6_15** and **cvcrdpu3sit11_3_6_15** (Table 6.9.8.8-7a) are reported [10 CFR 71.55(b)].

Consider a single ES-3100 package loaded with 500-g polyethylene homogenized with bulk saturated U_3Si. This content is evaluated from 4,000- to 14,000-g U_3Si at a density of 2 g/cm^3 since this density has shown to be the most reactive from previous calculations for compounds (see previous sections). The results of these cases can be found in Table 6.9.8.8-7b. For U_3Si powder with 500 g of polyethylene at enrichment of 40% in a dry CV, for a CSI = 0, the most reactive case below the USL of 0.9352 is Case **ncsrdpus3sit11_2_6_1**, with a k_{eff} + 2σ value of 0.716 for 14 kg of U_3Si. For when U_3Si powder is dispersed over the internal volume of the CV, the most reactive case below the USL of 0.9352 is Case **ncsrdpu3st11_2_6_1**, with a k_{eff} + 2σ value of 0.563 for 14 kg of U_3Si. For a flooded CV, the most reactive case below the USL of 0.9352 is Case **ncsrdpus3sit11_2_6_15**, with a k_{eff} + 2σ value of 0.719 for 14 kg of U_3Si. For when U_3Si powder is dispersed over the internal volume of the CV, the most reactive case below the USL of 0.9352 is Case **ncsrdpu3st11_2_6_15**, with a k_{eff} + 2σ value of 0.729 for 14 kg of U_3Si.

For 60% enrichment in a dry CV, the most reactive case below the USL of 0.9352 is Case **ncsrdpus3sit11_3_6_1**, with a k_{eff} + 2σ value of 0.751 for 14 kg of U_3Si. For when U_3Si powder is dispersed over the internal volume of the CV, the most reactive case below the USL of 0.9352 is Case **ncsrdpu3st11_3_6_1**, with a k_{eff} + 2σ value of 0.597 for 14 kg of U_3Si. For a flooded CV, the most reactive case below the USL of 0.9352 is Case **ncsrdpus3sit11_3_6_15**, with a k_{eff} + 2σ value of 0.752 for 14 kg of U_3Si. For when U_3Si powder is dispersed over the internal volume of the CV, the most reactive case below the USL of 0.9368 is Case **ncsrdpu3st11_3_6_15**, with a k_{eff} + 2σ value of 0.762 for 14 kg of U_3Si.

The results for Cases **ncsrdpu3st11_2_6_15** and **ncsrdpu3st11_3_6_15** (Table 6.9.8.8-7b) are reported [10 CFR 71.55(b)].

From the additional calculations performed to determine the effect aluminum would have on the reactivity of U_3Si_2 powder, we can conclude that this analysis will bound aluminum in U_3Si powder as well. Thus, the limits and controls for U_3Si would bound this loading.

6.9.8.6 Array Package Evaluation (NCT and HAC)

The analyses presented in Sects. 6.5 and 6.6 demonstrate that maximum reactivity occurs in an array of packages when the CV is flooded (MOCFR = 1.0) and the ES-3100 packaging is dry (MOIFR = 1e-04). A water fraction of MOIFR = 1e-04 pertains specifically to NCT or HAC packages where both the neutron poison of the body weldment liner inner cavity and the Kaolite are dry and both the recesses of the package external to the CV and the interstitial space between drums of the array do not contain any residual moisture.

The analyses presented in Sects. 6.4, 6.5, and 6.6 demonstrate that an insignificant difference is observed between the calculated k_{eff} ± 2σ values for undamaged packages in NCT and damaged packages in HAC. Therefore, the HAC array analysis is redundant and not fully developed in this appendix.

Reactor Fuel Components and Scrap Materials

6.9.8.6.1 U/Al fuel plates (Tables 6.9.8.8-1a, 6.9.8.8-1b)

As stated in Sect. 6.9.8.5.1, an explicit evaluation is performed for deriving less-restrictive loading limits for contents where the constituents of the U-Al alloy are predominately non-fissile. The infinite array packaging calculation model for bundled U/Al fuel plates at 93% enrichment is based on the BR-2 MTR Type 2 fuel plate described in Sect. 6.8.8.3.1. NCT Cases **5nciaualfpt11p_1_1_3**, **5nciaualfpt11p_2_1_3**, **5nciaualfpt11p_3_1_3, and 5nciaualfpt11p_4_1_3** model infinite arrays of undamaged ES-3100 packages with the U/Al plates uniformly spaced at 0.0 cm, 0.04 cm, 0.08 cm, and 0.116 cm separation between plates. The ES-3100 packaging is dry, while the CV with content is flooded. A water fraction of MOIFR = 1e-04 signifies dry NCT packaging where both the neutron poison of the body weldment liner inner cavity and the Kaolite are dry (in the as-manufactured condition) and both the recesses of the package external to the CV and the interstitial space between drums of the array do not contain any residual moisture. The calculated $k_{eff} \pm 2\sigma$ values range from 0.316 to 0.403.

HAC Cases **5hciaualfpt12p_1_1_3** through **5hciaualfpt12p_4_1_3** model the U/Al plate configurations inside damaged ES-3100 packages. The calculated $k_{eff} \pm 2\sigma$ values range from 0.315 to 0.403. Comparison of HAC array package results with corresponding HAC results reaffirms the insignificant difference observed between the calculated $k_{eff} \pm 2\sigma$ values.

Given that the results indicate adequate subcriticality below the USL of 0.924, ES-3100 packages loaded with U/Al fuel plates (net weight 7,333 g) containing ≤473 g of ^{235}U may be shipped under a CSI = 0.

The infinite array NCT Cases **5nciamitfpt11p_1_1_3** through **5nciamitfpt11p_6_1_3** model the MIT U/Al single element/15-plate configurations inside a flooded ES-3100 package with full water reflection. The calculated $k_{eff} \pm 2\sigma$ values range from 0.342 to 0.478.

HAC Cases **5hciamitfpt12p_1_1_3** through **5hciamitfpt12p_6_1_3** model the MIT single element/15-plate configurations inside a damaged ES-3100 package with full water reflection. Comparison of HAC single package results with corresponding NCT results reaffirms that an insignificant difference is observed between the calculated $k_{eff} \pm 2\sigma$ values.

The infinite array NCT Cases **5ncia30mitfpt11p_1_1_3** and **5ncia30mitfpt11p_6_1_3** model the 30 MIT U/Al fuel plates configurations inside a flooded ES-3100 package with full water reflection. The calculated $k_{eff} \pm 2\sigma$ values are 0.363 and 0.439.

HAC Cases **5hcia30mitfpt12_1_1_3** and **5hcia30mitfpt12_6_1_3** model the MIT 30-plate configurations inside a damaged ES-3100 package with full water reflection. Comparison of HAC single package results with corresponding NCT results reaffirms that an insignificant difference is observed between the calculated $k_{eff} \pm 2\sigma$ values.

Given that the results indicate adequate subcriticality below the USL of 0.924, ES-3100 packages loaded with one MIT U/Al element with 15 fuel plates (net weight 3,597 g) containing ~525-g ^{235}U or up to 30 bundled MIT U/Al fuel plates (net weight 7,194 g) containing ~1,050 g of ^{235}U may be shipped under a CSI = 0.

6.9.8.6.2 Reactor components of HEU oxide (Table 6.9.8.8-2)

Unclad UO_2 rods are used in the infinite array analysis like the single unit analysis. Each rod arrangement (Figs. 6.9.8.3.1-1a through 6.9.8.3.1-1g) is evaluated for confirmation that Configuration "**UO2_D**" is the most reactive one. For NCT Cases **5nciaoxt11_1_1_1_3** through **5nciaoxt11_1_7_1_3**, the calculated $k_{eff} \pm 2\sigma$ values range from 0.715 to 0.885. For HAC Cases **5hciaoxt12_1_1_1_15** through **5hciaoxt12_1_7_1_15,** the calculated $k_{eff} \pm 2\sigma$ values range from 0.708 to 0.877. The most reactive configuration is **UO2_D** represented by Cases **5nciaoxt11_1_4_1_15** and **5hciaoxt12_1_4_1_15**. Calculation results for the configurations evaluated indicate adequate subcriticality below the USL of 0.924. The ES-3100 packages loaded with 12 UO_2 (net weight 21,938 g) containing ≤ 19,308 g of ^{235}U may be shipped under a CSI = 0. Cases **5nciaoxt11_1_4_1_15** and **5hciaoxt12_1_4_1_15** were rerun with 500 g of polyethylene as was calculated in the CV and single unit cases. The calculated values for Cases **5nciaoxt11p_1_4_1_15** and **5hciaoxt12p_1_4_1_15** are adequately below the USL of 0.924, with little difference between fuel rods with or without polyethylene.

6.9.8.6.3 $UZrH_2$ fuel (Table 6.9.8.8-3)

NCT Cases **5nciasnapp_93_1_15_3** and **5nciasnapp_93_1_1_3** model infinite arrays of undamaged ES-3100 packages with $UZrH_2$ cylinders inside a flooded or dry CVs. The calculated $k_{eff} \pm 2\sigma$ values are 0.622 and 0.350, respectively. Cases **5nciasnapp_93_2_15_3** and **5nciasnapp_93_2_1_3** model the presence of canned spacers. The calculated $k_{eff} \pm 2\sigma$ values are 0.596 and 0.337, respectively.

HAC Cases **5hciasnapp_93_1_15_3** and **5hciasnapp_93_1_1_3** model infinite arrays of damaged ES-3100 packages with $UZrH_2$ cylinders inside a flooded or dry CVs. The calculated $k_{eff} \pm 2\sigma$ values are 0.6220 and 0.351, respectively. The 1.4-in.-thick canned spacers are modeled in Cases **5hciasnapp_93_2_15_3** and **5hcsrsnapp_93_2_1_3**. The calculated $k_{eff} \pm 2\sigma$ values are 0.595 and 0.336, respectively. Comparison of HAC single package results with corresponding NCT results reaffirms that an insignificant difference is observed between the calculated $k_{eff} \pm 2\sigma$ values.

Case **5ncia9355d2p_1_15_3** models infinite arrays of dry, undamaged ES-3100 packages with the $UZrH_2$ homogenized with the water of a flooded CV and dispersed over the free volume of the CV. Similarly, Case **5ncia9355d2p_1_1_3** models the $UZrH_2$ dispersed over the free volume of a dry CV of the dry ES-3100 packaging. The calculated $k_{eff} \pm 2\sigma$ values are 0.7878 and 0.2476, respectively. Cases **5ncia9355d2p_2_15_15** and **5ncia9355d2p_2_1_1**5 model the presence of the canned spacers. The calculated $k_{eff} \pm 2\sigma$ values for these cases are 0.7414 and 0.2331, respectively. These results indicate that extremely damaged content is more reactive than the unaltered configuration. Nevertheless, each set of cases is adequately below the USL of 0.924 and the requirement of 10 CFR 71.55(d)(2) is satisfied. Given that changes external to the CV due to HAC do no result in an appreciable change in neutron multiplication for the single package, similar results are expected for the cases demonstrating compliance with 10 CFR 71.55(e)(1). Conclusions regarding compliance with 10 CFR 71.55(d)(2) equally apply regarding compliance with 10 CFR 7155(e)(1).

Additional array cases were performed to exam the effect that 500 g of polyethylene will have on SNAP fuel elements. The original cases were rerun using SCALE 6.1.3 with updated cross-sections and more particles. These cases were also modified by adding 500 g of polyethylene. Only the most reactive cases were rerun. The results of these cases are found in Tables 6.9.8.6-1 and 6.9.8.6-2.

Table 6.9.8.6-1. NCT Arrays, SNAP fuel, with and without 500-g polyethylene, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff} + 2\sigma$
5nciasnap_93_1_15_3	3 cylinders per can, two cans, no spacers or polyethylene	0.61809	0.00093	0.61995
5nciasnapp_93_1_15_3	3 cylinders per can, two cans, no spacers, 500 g polyethylene	0.62060	0.00068	0.62196
5nciasnap_93_2_15_3	3 cylinders per can, two cans, with spacers, no polyethylene	0.58957	0.00078	0.59113
5nciasnapp_93_2_15_3	3 cylinders per can, two cans, with spacers, 500 g polyethylene	0.59447	0.00062	0.59571

Table 6.9.8.6-2. HAC Arrays, SNAP fuel, with and without 500-g polyethylene, (USL=0.9352)

Case	Description	k_{eff}	σ	$k_{eff} + 2\sigma$
5hciasnap_93_1_15_3	3 cylinders per can, two cans, no spacers or polyethylene	0.61697	0.00068	0.61833
5hciasnapp_93_1_15_3	3 cylinders per can, two cans, no spacers, 500 g polyethylene	0.62101	0.00067	0.62235
5hciasnap_93_2_15_3	3 cylinders per can, two cans, with spacers, no polyethylene	0.58937	0.00063	0.59063
5hciasnapp_93_2_15_3	3 cylinders per can, two cans, with spacers, 500 g polyethylene	0.59389	0.00067	0.59523

From the result of the single package cases for SNAP fuel, modeling 500 g of polyethylene surrounding the HEU metal is slightly more reactive than no polyethylene.

Given that the results indicate adequate subcriticality below the USL of 0.924, ES-3100 packages loaded with $UZrH_2$ (net weight 11,164 g) containing ≤ 857 g ^{235}U may be shipped under a CSI = 0.

6.9.8.6.4 UZr fuel plates

As stated in Sect. 6.9.8.5.4, UZr fuel plates may be loaded to the broken metal mass limits by assuming the mass of the alloy is all ^{235}U.

6.9.8.6.5 UF compounds (Tables 6.9.8.8-5a, 6.9.8.8-5b)

Cases **5nciapuf4t11_24_1** through **5nciapuf4t11_24_15** (Table 6.9.8.8-5a) model infinite arrays of ES-3100 packages each loaded with 24,000 g UF_4 in solution and homogenized with 500 g polyethylene. The $k_{eff} \pm 2\sigma$ values decrease from 0.981 to 0.765 as the packaging external to the CV and the interstitial space between the packages of the array floods. Comparison of results for Cases **5ncsrpuf4t11_24_15** through **5nciapuf4t11_24_15** confirms that flooded packages in a flooded array are nearly neutronically isolated from each other.

Consider an array of flooded ES-3100 packages loaded with UF_4 content in solution and homogenized with 500 g polyethylene. The UF_4 content ranges from 5,000 to 1,000 g. For Cases **5nciapuf4t11_5_3** through **5nciapuf4t11_1_3**, the $k_{eff} \pm 2\sigma$ value decreases from 0.947 to 0.738.

Given that the results indicate adequate subcriticality below the USL of 0.924, ES-3100 packages loaded with 3000 g UF_4 containing ≤ 2,267 g ^{235}U may be shipped under a CSI = 0.

Cases **5nciapuofhct11_24_1** through **5nciapuofhct11_24_15** (Table 6.9.8.8-5b) model infinite arrays of ES-3100 packages each loaded with 24,000-g $UO_2F_2 \cdot 2H_2O$ in solution and homogenized with 500-g polyethylene. The $k_{eff} \pm 2\sigma$ values decrease from 1.048 to 0.813 as the packaging external to the CV and the interstitial space between the packages of the array floods. Comparison of results for Cases **5ncsrpuofhct11_24_15** and **5nciapuofhct11_24_15** confirms that flooded packages in a flooded array are nearly neutronically isolated from each other.

Consider an array of flooded ES-3100 packages loaded with $UO_2F_2 \cdot 2H_2O$ content in solution and homogenized with 500 g polyethylene. The $UO_2F_2 \cdot 2H_2O$ content ranges from 5,000 to 1,000 g. For Cases **5nciapuofhct11_5_3** through **5nciapuofhctt11_1_3**, the $k_{eff} \pm 2\sigma$ value decreases from 0.949 to 0.719.

Given that the results indicate adequate subcriticality below the USL of 0.924, ES-3100 packages loaded with 3000 g $UO_2F_2 \cdot 2H_2O$ containing ≤ 2,067 g ^{235}U may be shipped under a CSI = 0.

6.9.8.6.6 UC and UN compounds (Tables 6.9.8.8-6a, 6.9.8.8-6b)

As shown in Table 6.9.8.8-6a, UC content bounds the other forms of uranium carbide compounds. Consider an array of flooded ES-3100 packages loaded with UC content homogenized with 500 g polyethylene. For Cases **5nciapuct11_1_10_3** through **5nciapuct11_1_1_3**, the UC content is conservatively modeled as granular compound like HEU oxide. Over the range of 10,000 to 1,000 g UC, the $k_{eff} \pm 2\sigma$ value decreases from 0.914 to 0.577. For Cases **5nciadpuct11_1_10_15_3** through **5nciadpuct11_1_1_15_3**, the UC content is conservatively modeled as a water-soluble compound dispersed over the free volume of the CV, like the UNX, UF_4, UO_2F_2, and $UO_2F_2 \cdot 2H_2O$ contents. Over the range of 10,000 to 1,000 g UC, the $k_{eff} \pm 2\sigma$ value decreases from 1.031 to 0.785.

Given that the UC content may not be well characterized as bulk material like the HEU oxide content, the latter model is used for establishing the loading limits. On the basis of calculation results indicating adequate subcriticality below the USL of 0.924, ES-3100 packages loaded with 2,000 g UC, U_2C_3, or UC_2 containing ≤ 1,903 g ^{235}U may be shipped under a CSI = 0.

Consider an array of flooded ES-3100 packages loaded with UN content homogenized with 500 g polyethylene. For Cases **5nciapunt11_10_3** through **5nciapuct11_1_3**, the UN content is conservatively modeled as granular compound like HEU oxide. Over the range of 10,000 to 1,000 g UN, the $k_{eff} \pm 2\sigma$ value decreases from 0.927 to 0.578. For Cases **5nciadpunt11_10_15_3** through **5nciadpunt11_1_15_3**, the UN content is conservatively modeled as a water-soluble compound dispersed over the free volume of the CV. Over the range of 10,000 to 1,000 g UN, the $k_{eff} \pm 2\sigma$ value decreases from 1.027 to 0.780.

Given that the UN content may not be well characterized as bulk material like the HEU oxide content, the latter model is used for establishing the loading limits. On the basis of calculation results indicating adequate subcriticality below the USL of 0.924, ES-3100 packages loaded with 2,000 g UN containing ≤ 1,888 g ^{235}U may be shipped under a CSI = 0.

6.9.8.6.7 U_3Si_2 powder (Table 6.9.8.8-7c)

Consider an infinite array of ES-3100 packages loaded with saturated bulk U_3Si_2 content homogenized with 500 g of polyethylene in flooded CVs. The packaging external to the CVs and the interstitial void space between packages in the infinite array is assumed dry for maximizing neutronic interaction. For Cases **5nciapdusit11_8_7_13_3** through **5nciapdusit11_8_2_13_3** (Table 6.9.8.8-7c) where

13 kg of U_3Si_2 content is evaluated over a density range of 7 to 2 g/cm^3, the $k_{eff} \pm 2\sigma$ values increase from 0.831 to 0.963 as the density decreases. For Cases **5nciadpust11_8_7_13_3** through **5nciadpust11_8_2_13_3** where this same content is dispersed over the internal volume of the CV, $k_{eff} \pm 2\sigma = 1.037$. In the latter set of cases, the density of the saturated content does not have an effect on neutron multiplication because the amount of water within which the content is dispersed is constant.

For Cases **5nciapdusit11_8_2_13_3** through **5nciapdusit11_8_2_7_3** (Table 6.9.8.8-7c), the $k_{eff} \pm 2\sigma$ values for U_3Si_2 content decrease from 0.964 to 0.863 as the mass of U_3Si_2 decreases from 13 to 7 kg. Similarly for Cases **5nciadpust11_8_7_13_3** through **5nciadpust11_8_7_7_3** (Table 6.9.8.8-7c), the $k_{eff} \pm 2\sigma$ values decrease from 1.037 to 1.006. While the discrete configuration modeled in Cases **5nciapdusit11** indicates that potentially high content loadings can be achieved, the uniform configuration modeled in Cases **5nciadpust11** indicates the contrary.

For Cases **5nciapdusit11_8_2_13_3** through **5nciapdusit11_1_2_13_3**, the $k_{eff} \pm 2\sigma$ values decrease from 0.964 to 0.739 as the enrichment decreases from 100 to 19.7% in the content (13-kg U_3Si_2 plus 5,490-g saturation water and 500-g polyethylene). For Cases **5nciadpust11_8_7_13_3** through **5nciadpust11_1_7_13_3** where content is dispersed over the internal volume of the flooded CV, the $k_{eff} \pm 2\sigma$ values decrease from 1.037 to 0.7993.

The last set of cases presented in Table 6.9.8.8-7c ranks the results for the uniform content configuration model Cases **5nciadpust11** and corresponding discrete configuration model Cases **5nciapdusit11** according to decreased neutron multiplication factor. Given that the U_3Si_2 content may not be as well characterized as bulk HEU oxide content, the uniform model is used for establishing the loading limits. On the basis of calculation results indicating adequate subcriticality below the USL of 0.924, ES-3100 packages may be shipped under a CSI = 0 for:

(A) loading not exceeding 7-kg U_3Si_2 at enrichments ≥40% but ≤ 60% and

(B) loading not exceeding 13-kg U_3Si_2 at enrichments ~19.7 but < 40%.

Additional calculations were performed to determine the effect aluminum would have on the reactivity of U_3Si_2 powder. Parametric studes were performed for U_3Si_2 powder at an enrichment of 100%, varying the amount of aluminum from none up to 4 kg. The aluminum is modeled at the same bulk density as U_3Si_2, which is 2 g/cm^3. The results of these calculations can be found in Table 6.9.8.8-7c. As aluminum powder at the same bulk density as U_3Si_2 is added, reactivity decreases. Thus, the limits and controls for U_3Si_2 would bound this loading.

6.9.8.6.8 U_3Si powder (Table 6.9.8.8-7c)

Consider an infinite array of ES-3100 packages loaded with saturated bulk U_3Si content homogenized with 500 g of polyethylene in flooded CV. The packaging external to the CVs and the interstitial void space between packages in the infinite array is evaluated at a range of interstitial water moderation up to fully flooded. As expected, the dry condition was the most reactive for maximizing neutronic interaction. For U_3Si powder with 500 g of polyethylene at enrichment of 40% in a flooded CV, for a CSI = 0, the most reactive case below the USL of 0.9352 is Case **nciapdu3sit11_2_6_2**, with a $k_{eff} + 2\sigma$ value of 0.839 for 14 kg of U_3Si. For when U_3Si powder is dispersed over the internal volume of the CV, the most reactive case below the USL of 0.9352 is Case **nciapdu3st11_2_6_2**, with a $k_{eff} + 2\sigma$ value of 0.904 for 14 kg of U_3Si.

For 60% enrichment in a flooded CV, the most reactive case below the USL of 0.9352 is Case **nciapdu3sit11_3_6_2**, with a $k_{eff} + 2\sigma$ value of 0.889 for 14 kg of U_3Si. For when U_3Si powder is dispersed over the internal volume of the CV, the most reactive case below the USL of 0.9368 is Case **nciapdu3st11_3_4_2**, with a $k_{eff} + 2\sigma$ value of 0.936 for 8.5 kg of U_3Si.

On the basis of calculation results indicating adequate subcriticality below the USL, ES-3100 packages may be shipped under a CSI = 0 for:

(A) loading not exceeding 8.5-kg U_3Si at enrichments ≥40% but ≤ 60% and

(B) loading not exceeding 14-kg U_3Si at enrichments ~19.7 but < 40%.

From the additional calculations performed to determine the effect aluminum would have on the reactivity of U_3Si_2 powder found in Section 6.9.8.5.7 (Table 6.9.8.8-7a), we can conclude that this analysis will bound aluminum in U_3Si powder as well. Thus, the limits and controls for U_3Si would bound this loading.

6.9.8.7 Benchmark Experiments and the Criticality Validation

The criticality validation for SCALE 5.0 is a repetition of the SCALE 4.4a validation based on benchmark experiments documented in the Organization for Economic Cooperation and Development (OECD) Handbook [NEA/NSC/DOC(95)03]. Validation cases for SCALE 4.4a were executed on an HP Model J5600 RISC workstation under the HP-UX 10.20 operating system. For SCALE 5.0, these same validation cases were executed on an HP Model zx6000 Itanium workstation (CMODC).

The validation of CSAS25 control module of SCALE 5.0 with the 238-group ENDF/B-V cross-section library is documented in Y/DD-1220 and Y/DD-1221. Like Y/DD-896/R1, Y/DD-1220 addresses the establishment of bias, bias trends, and uncertainty associated with the use of SCALE 5.0 for performance of criticality calculations. Like Y/DD-972R1, Y/DD-1221 addresses determining USL and for incorporating uncertainty and margin into this USL.

SCALE5 incorporates minor improvements in the code modules for the Bondarenko and the Nordheim Integral Treatment processing of resonance cross sections and the KENO V.a module. Consequently, the USL used is validation dependent based on the SCALE-platform combination. The evaluation of the contents based upon SCALE 5.0 calculations is documented in this appendix separate from the main body of Chap. 6 because this effort could not easily be folded into the existing SCALE 4.4a evaluation without inclusion of a patchwork of clarifications.

The USL is based on the non-parametric statistics-based lower tolerance limit (LTL) for greater than 0.99/99% where there is a probability of greater than 0.99 that 99% of the population is greater than a specified result, reduced by additional margin. From Table 1 of Y/DD-1221, the LTL combining bias and bias uncertainty is 0.974 for uranium systems, including HEU metal. Tables 4.2, 4.3, and 4.4 of Y/DD-1220 list the maximum (positive) and minimum (negative) biases for HEU (metal, compound, solution), IEU (metal, compound) and LEU (compound, solution) systems. Since the positive bias is conservatively treated as a "zero" bias in the validation analysis, the negative bias is applied to determine the USL for the systems. The minimum bias given for HEU, IEU, and LEU systems is given as −0.0230, −0.0055 and −0.0260, respectively.

The minimum bias given for HEU systems in Table 4.2 of Y/DD-1220 is -0.1423. However, this result is from one of the four k-infinite models which are somewhat different than the usual benchmark experiments. As discussed in Sect. 5.3 of Y/DD-1220, the four outlier results are for benchmark experiments that were modeled as infinite in extent, thereby amplifying the effects of imperfections in cross section data. The models also required additional interpretation and adjustment from the actual finite experimental configuration to create an infinite benchmark model. After eliminating outlier models from the bias determination, the minimum bias was determined to be -0.023 for HEU systems.

The global minimum bias results for these systems (−0.0260) is applied to all uranium enrichments. Ordinarily, the USL would be 0.954 where an additional margin of subcriticality of 0.02 is subtracted from the LTL of 0.974. However, NUREG/CR-5661 provides guidance that the USL should be established with a minimum margin of subcriticality of 0.05. Thus, the USL is equal to 0.95 plus the minimum bias (−0.026), giving a value of 0.924.

The criticality validation for SCALE 6.1.3 is based on benchmark experiments documented in the Organization for Economic Cooperation and Development (OECD) Handbook [NEA/NSC/DOC(95)03]. The USL without any safety margin—derived for the validation of CSAS5 control module of SCALE 6.1.3 with the multi-group V7-238-gr cross-section library run on ENGHPC workstation—is 0.9852 for intermediate energy HEU systems as documented in RP YAREA-F-0524. NUREG/CR-5661 provides guidance that the USL should be established with a minimum margin of subcriticality of 0.05. Using this safety margin, the USL for the calculations performed in this document would be 0.9368 for thermal energy systems, 0.9352 for intermediate energy systems, and 0.9386 for fast energy systems.

6.9.8.8 Calculation Results Tables

Tables 6.9.8.8-1a through 6.9.8.8-7c contain a summary of the calculation results for the additional contents to be shipped in the ES-3100 shipping package. Table 6.9.8.8-4 has been omitted until such time when the Uranium Zirconium alloys are explicitly modeled. Currently these content items are to be treated as broken metal and shipped under these limits accordingly.

Table 6.9.8.8-1a. Results for uranium aluminum fuel plate content, 500 g polyethylene, no can spacers in the CV or ES-3100 packaging calculation models, (USL=0.93680)

Case	Plates per bundle	Plate spacing (in.)	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case	k_{eff}	σ	$k_{eff}+2\sigma$
flooded containment vessel (MOCFR=1.0), reflected										
5cvcrualfpt11p_1_1_15	35	0.00	1.0E+00	0.30731	0.00052	0.30835				
5cvcrualfpt11p_2_1_15	35	0.04	1.0E+00	0.34699	0.00052	0.34803				
5cvcrualfpt11p_3_1_15	35	0.08	1.0E+00	0.38332	0.00048	0.38428				
5cvcrualfpt11p_4_1_15	35	0.116	1.0E+00	0.41008	0.00053	0.41114				
Case	**Plates per bundle**	**Plate spacing (in.)**	**MOIFR**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**	**Case**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**
			NCT					**HAC**		
content in flooded CV (MOCFR=1.0), single package, reflected										
5ncsrualfpt11p_1_1_15	35	0.00	1.0E+00	0.26212	0.00052	0.26316	5hcsrualfpt12p_1_1_15	0.26347	0.00047	0.26441
5ncsrualfpt11p_2_1_15	35	0.04	1.0E+00	0.29613	0.00047	0.29707	5hcsrualfpt12p_2_1_15	0.29685	0.00057	0.29799
5ncsrualfpt11p_3_1_15	35	0.08	1.0E+00	0.32258	0.00051	0.32360	5hcsrualfpt12p_3_1_15	0.32418	0.00054	0.32526
5ncsrualfpt11p_4_1_15	35	0.116		0.34145	0.00052	0.34249	5hcsrualfpt12p_4_1_15	0.34300	0.00053	0.34406
content in flooded CV (MOCFR=1.0), infinite array of packages										
5nciaualfpt11p_1_1_3	35	0.00	1.0E-04	0.31479	0.00051	0.31581	5hciaualfpt12p_1_1_3	0.31434	0.00047	0.31528
5nciaualfpt11p_2_1_3	35	0.04	1.0E-04	0.35314	0.00051	0.35416	5hciaualfpt12p_2_1_3	0.35284	0.00058	0.35400
5nciaualfpt11p_3_1_3	35	0.08	1.0E-04	0.38332	0.00078	0.38488	5hciaualfpt12p3_1_3	0.38263	0.00051	0.38365
5nciaualfpt11p_4_1_3	35	0.116		0.40150	0.00057	0.40264	5hciaualfpt12p_4_1_3	0.40147	0.00062	0.40271

Table 6.9.8.8-1b. Results for MIT uranium aluminum fuel element and plate bundles, 500 g polyethylene, no can spacers in the CV or ES-3100 packaging calculation models, (USL=0.93680)

		Case	Gap (cm)	MOIFR	NCT			HAC		
					k_{eff}	σ	$k_{eff} + 2\sigma$	k_{eff}	σ	$k_{eff} + 2\sigma$
15 fuel plates	Containment vessel				5cvcrmitfpt11p*					
		_1_1_15	0.000	1.00E+00	0.32425	0.00050	0.32525			
		_2_1_15	0.05080	1.00E+00	0.34993	0.00052	0.35097			
		_3_1_15	0.12700	1.00E+00	0.38293	0.00054	0.38401			
		_4_1_15	0.20828	1.00E+00	0.41349	0.00060	0.41469			
		_5_1_15	0.37338	1.00E+00	0.46158	0.00066	0.46290			
		_6_1_15	0.44200	1.00E+00	0.47631	0.00065	0.47761			
	Single unit				5ncsrmitfpt11p*			5hcsrmitfpt12p*		
		_1_1_15	0.000	1.00E+00	0.29920	0.00059	0.30038	0.29893	0.00056	0.30005
		_2_1_15	0.05080	1.00E+00	0.32092	0.00053	0.32198	0.32196	0.00057	0.32310
		_3_1_15	0.12700	1.00E+00	0.35303	0.00059	0.35421	0.35220	0.00054	0.35328
		_4_1_15	0.20828	1.00E+00	0.37952	0.00060	0.38072	0.37943	0.00056	0.38055
		_5_1_15	0.37338	1.00E+00	0.41426	0.00060	0.41546	0.41610	0.00075	0.41760
		_6_1_15	0.44200	1.00E+00	0.42394	0.00077	0.42548	0.42460	0.00058	0.42576
	Infinite array				5nciamitfpt11p*			5hciamitfpt12p*		
		_1_1_3	0.000	1.00E-04	0.34049	0.00056	0.34161	0.33960	0.00054	0.34068
		_2_1_3	0.05080	1.00E-04	0.36479	0.00057	0.36593	0.36463	0.00050	0.36563
		_3_1_3	0.12700	1.00E-04	0.39849	0.00065	0.39979	0.39819	0.00062	0.39943
		_4_1_3	0.20828	1.00E-04	0.42745	0.00063	0.42871	0.42934	0.00057	0.43048
		_5_1_3	0.37338	1.00E-04	0.46948	0.00061	0.47070	0.46858	0.00068	0.46994
		_6_1_3	0.44200	1.00E-04	0.47681	0.00059	0.47799	0.47822	0.00072	0.47966

Table 6.9.8.8-1b. Results for MIT uranium aluminum fuel element and plate bundles, 500 g polyethylene, no can spacers in the CV or ES-3100 packaging calculation models, (USL=0.93680)

		Case	Gap (cm)	MOIFR	NCT			HAC		
					k_{eff}	σ	$k_{eff} + 2\sigma$	k_{eff}	σ	$k_{eff} + 2\sigma$
30 fuel plates	Containment vessel				5cvcr30mitfpt11p*					
		_1_1_15	0.000	1.00E+00	0.35340	0.00051	0.35442			
		_6_1_15	0.119	1.00E+00	0.44990	0.00066	0.45122			
	Single unit				5ncsr30mitfpt11p*			5hcsr30mitfpt12p*		
		_1_1_15	0.000	1.00E+00	0.26236	0.00051	0.26338	0.30669	0.00052	0.30773
		_6_1_15	0.119	1.00E+00	0.36818	0.00059	0.36936	0.37973	0.00058	0.38089
	Infinite array				5ncia30mitfpt11p*			5hcia30mitfpt12p*		
		_1_1_3	0.000	1.00E-04	0.36202	0.00061	0.36324	0.36124	0.00054	0.36232
		_6_1_3	0.119	1.00E-04	0.43788	0.00064	0.43916	0.43745	0.00066	0.43877

Table 6.9.8.8-2. Results for uranium oxide fuel pin content, with and without 500 g polyethylene, no can spacers in the CV or ES-3100 packaging calculation models, (USL=0.93520 for poly and ThO_2 calculations)

Case	Rod config.	Cladding	MOCFR	k_{eff}	σ	k_{eff}+2σ	Case	k_{eff}	σ	k_{eff}+2σ
flooded containment vessel (MOCFR=1.0), reflected										
5cvsroxt11_1_4_1_15	UO2_D	none	1.0E+00	0.79880	0.00113	0.80106				
5cvsroxt11p_1_4_1_15	UO2_D	500 g poly	1.0E+00	0.81377	0.00074	0.81525				
5cvsroxt11_1_4_2_15	UO2_D	Al	1.0E+00	0.79780	0.00143	0.80066				
5cvsroxt11_1_4_3_15	UO2_D	SS304	1.0E+00	0.79704	0.00135	0.79974				
5cvsroxt11_1_4_4_15	UO2_D	Zr	1.0E+00	0.79706	0.00133	0.79972				
cvsroxtho2t11_1 (No ThO_2)	UO2_D	500 g poly	1.0E+00	0.81449	0.00072	0.81593				
cvsroxtho2t11_2 (10% ThO_2)	UO2_D	500 g poly	1.0E+00	0.79617	0.00067	0.79751				
cvsroxtho2t11_3 (20% ThO_2)	UO2_D	500 g poly	1.0E+00	0.77925	0.00069	0.78063				
cvsroxtho2t11_4 (30% ThO_2)	UO2_D	500 g poly	1.0E+00	0.75985	0.00078	0.76141				
cvsroxtho2t11_6 (50% ThO_2)	UO2_D	500 g poly	1.0E+00	0.72204	0.00063	0.72330				
cvsroxtho2t11_8 (70% ThO_2)	UO2_D	500 g poly	1.0E+00	0.67411	0.00090	0.67591				
cvsroxtho2t11_10 (90% ThO_2)	UO2_D	500 g poly	1.0E+00	0.56624	0.00061	0.56746				
cvsroxtho2t11_11 (100% ThO_2)	UO2_D	500 g poly	1.0E+00	0.00706	0.00002	0.00710				
Case	**Rod config.**	**Cladding**	**MOIFR**	**k_{eff}**	**σ**	**k_{eff}+2σ**	**Case**	**k_{eff}**	**σ**	**k_{eff}+2σ**
		NCT						**HAC**		
content in flooded CV (MOCFR=1.0), single package, reflected										
5ncsroxt11_1_1_1_15	UO2_A	none	1.0E+00	0.63776	0.00113	0.64002	5hcsroxt12_1_1_1_15	0.63955	0.00102	0.64159
5ncsroxt11_1_2_1_15	UO2_B	none	1.0E+00	0.67647	0.00099	0.67844	5hcsroxt12_1_2_1_15	0.68016	0.00121	0.68258
5ncsroxt11_1_3_1_15	UO2_C	none	1.0E+00	0.71717	0.00117	0.71951	5hcsroxt12_1_3_1_15	0.72166	0.00133	0.72432
5ncsroxt11_1_4_1_15	UO2_D	none	1.0E+00	0.74420	0.00138	0.74697	5hcsroxt12_1_4_1_15	0.74679	0.00140	0.74959
5ncsroxt11p_1_4_1_15	UO2_D	500 g poly	1.0E+00	0.74751	0.00063	0.74877	5hcsroxt12p_1_4_1_15	0.74853	0.00075	0.75003
5ncsroxt11_1_5_1_15	UO2_E	none	1.0E+00	0.69214	0.00115	0.69445	5hcsroxt12_1_5_1_15	0.69182	0.00128	0.69439
5ncsroxt11_1_6_1_15	UO2_F	none	1.0E+00	0.60129	0.00123	0.60374	5hcsroxt12_1_6_1_15	0.60188	0.00122	0.60433
5ncsroxt11_1_7_1_15	UO2_G	none	1.0E+00	0.60245	0.00098	0.60441	5hcsroxt12_1_7_1_15	0.60159	0.00123	0.60406

Table 6.9.8.8-2. Results for uranium oxide fuel pin content, with and without 500 g polyethylene, no can spacers in the CV or ES-3100 packaging calculation models, (USL=0.93520 for poly and ThO_2 calculations)

content in flooded CV (MOCFR=1.0), infinite array of packages										
5nciaoxt11_1_1_1_3	UO2_A	none	1.0E-04	0.72525	0.00114	0.72753	5hciaoxt12_1_1_1_3	0.71979	0.00110	0.72199
5nciaoxt11_1_2_1_3	UO2_B	none	1.0E-04	0.83897	0.00121	0.84138	5hciaoxt12_1_2_1_3	0.83380	0.00097	0.83575
5nciaoxt11_1_3_1_3	UO2_C	none	1.0E-04	0.84091	0.00106	0.84304	5hciaoxt12_1_3_1_3	0.83516	0.00121	0.83758
5nciaoxt11_1_4_1_3	UO2_D	none	1.0E-04	0.88193	0.00130	0.88454	5hciaoxt12_1_4_1_3	0.87513	0.00116	0.87746
5nciaoxt11p_1_4_1_3	UO2_D	500 g poly	1.0E-04	0.88728	0.00069	0.88866	5hciaoxt12p_1_4_1_3	0.86301	0.00068	0.86437
5nciaoxt11_1_5_1_3	UO2_E	none	1.0E-04	0.80570	0.00128	0.80827	5hciaoxt12_1_5_1_3	0.79920	0.00117	0.80154
5nciaoxt11_1_6_1_3	UO2_F	none	1.0E-04	0.79000	0.00148	0.79297	5hciaoxt12_1_6_1_3	0.78673	0.00115	0.78904
5nciaoxt11_1_7_1_3	UO2_G	none	1.0E-04	0.71258	0.00101	0.71461	5hciaoxt12_1_7_1_3	0.70523	0.00114	0.70750
nsiaoxtho2t11_1 (No ThO_2)	UO2_D	500 g poly	1.0E-04	0.89485	0.00066	0.89617				
nsiaoxtho2t11_2 (10% ThO_2)	UO2_D	500 g poly	1.0E-04	0.87370	0.00079	0.87528				
nsiaoxtho2t11_3 (20% ThO_2)	UO2_D	500 g poly	1.0E-04	0.85124	0.00076	0.85276				
nsiaoxtho2t11_4 (30% ThO_2)	UO2_D	500 g poly	1.0E-04	0.82763	0.00069	0.82901				
nsiaoxtho2t11_6 (50% ThO_2)	UO2_D	500 g poly	1.0E-04	0.77501	0.00070	0.77641				
nsiaoxtho2t11_8 (70% ThO_2)	UO2_D	500 g poly	1.0E-04	0.70606	0.00067	0.70740				
nsiaoxtho2t11_10 (90% ThO_2)	UO2_D	500 g poly	1.0E-04	0.57171	0.00058	0.57287				
nsiaoxtho2t11_10 (100% ThO_2)	UO2_D	500 g poly	1.0E-04	0.00747	0.00002	0.00751				

Table 6.9.8.8-3. Results for $UZrH_2$ content at 93 wt % ^{235}U, with 500 g polyethylene in the CV or ES-3100 packaging calculation models, (USL=0.93520)

Case 5ncsrsnapp_93*	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5hcsrsnapp_93*	k_{eff}	σ	$k_{eff}+2\sigma$
				NCT						HAC		
content in flooded containment vessel (MOCFR=1.0), single package reflected												
no can spacers (np thickness = 0.0 in.)												
_1_15_15	11,164	856.8	8,697.5	265.00	1.0E+00	0.56975	0.00068	0.57111	_1_15_15	0.56947	0.00064	0.57075
_1_1_15	11,164	856.8	8,697.5	265.00	1.0E-20	0.28194	0.00054	0.28302	_1_1_15	0.28404	0.00051	0.28506
content in dry containment vessel (MOCFR=1.0E-20), single package reflected												
no can spacers (np thickness = 0.0 in.)												
_1_15_1	11,164	856.8	0.0	0.00	1.0E+00	0.52633	0.00071	0.52775	_1_15_1	0.52874	0.00071	0.53016
_1_1_1	11,164	856.8	0.0	0.00	1.0E-20	0.15207	0.00041	0.15289	_1_1_1	0.15418	0.00038	0.15494
content in flooded containment vessel (MOCFR=1.0), single package reflected												
can spacers (np thickness = 1.4 in.)												
_2_15_15	11,164	856.8	8,083.9	246.30	1.0E+00	0.54226	0.00075	0.54376	_2_15_15	0.54328	0.00069	0.54466
_2_1_15	11,164	856.8	8,083.9	246.30	1.0E-20	0.26323	0.00055	0.26433	_2_1_15	0.26413	0.00047	0.26507
content in dry containment vessel (MOCFR=1.0E-20), single package reflected												
can spacers (np thickness = 1.4 in.)												
_2_15_1	11,164	856.8	0.0	0.00	1.0E+00	0.50089	0.00071	0.50231	_2_15_1	0.50041	0.00070	0.50181
_2_1_1	11,164	856.8	0.0	0.00	1.0E-20	0.14482	0.00040	0.14562	_2_1_1	0.14562	0.00039	0.14640

Table 6.9.8.8-3. Results for $UZrH_2$ content at 93 wt % ^{235}U, with 500 g polyethylene in the CV or ES-3100 packaging calculation models, (USL=0.93520)

Case 5nciasnapp_93*	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5hciasnapp_93*	k_{eff}	σ	$k_{eff}+2\sigma$
NCT									**HAC**			
content in flooded or dry containment vessel, infinite array of packages (MOIFR=1.0E-04)												
no can spacers (np thickness = 0.0 in.)												
_1_15_3	11,164	856.8	8,697.5	265	1.0E+00	0.62060	0.00068	0.62196	_1_15_3	0.62101	0.00067	0.62235
_1_1_3	11,164	856.8	0.0	0	1.0E-20	0.34873	0.00054	0.34981	_1_1_3	0.34955	0.00048	0.35051
can spacers (np thickness = 1.4 in.												
_2_15_3	11,164	856.8	8,083.9	246.3	1.0E+00	0.59447	0.00062	0.59571	_2_15_3	0.59389	0.00067	0.59523
_2_1_3	11,164	856.8	0.0	0	1.0E-20	0.33534	0.00060	0.33654	_2_1_3	0.33507	0.00045	0.33597
Case 5ncsrs9355d2p*	**$UZrH_x$ (g)**	**^{235}U (g)**	**H_2O (g)**	**h/x**	**MOCFR**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**				
NCT												
content in flooded or dry containment vessel, single package, reflected												
no can spacers (np thickness = 0.0 in.)												
_1_15_15	11,164	857	8,697.5	265.00	1.0E+00	0.67716	0.00075	0.67866				
_1_1_15	11,164	857	0.0	0.00	1.0E-20	0.19031	0.00044	0.19119				
content in flooded or dry containment vessel, infinite array of NCT packages (MOIFR=1.0E-04)												
can spacers (np thickness = 1.4 in.)												
_2_15_15	11,164	857	8,083.9	246.30	1.0E+00	0.64532	0.00076	0.64684				
_2_1_15	11,164	857	0.0	0.00	1.0E-20	0.18161	0.00038	0.18237				

Table 6.9.8.8-3. Results for $UZrH_2$ content at 93 wt % ^{235}U, with 500 g polyethylene in the CV or ES-3100 packaging calculation models, (USL=0.93520)

Case 5ncias9355d2p*	$UZrH_x$ (g)	^{235}U (g)	H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$	
NCT									
content in flooded or dry containment vessel, infinite array of NCT packages (MOIFR=1.0E-04)									
no can spacers (np thickness = 0.0 in.)									
_1_15_3	11,164	857	8,697.5	265.00	1.0E+00	0.78639	0.00070	0.78779	
_1_1_3	11,164	857	0.0	0.00	1.0E-20	0.24683	0.00040	0.24763	
content in flooded or dry containment vessel, infinite array of NCT packages (MOIFR=1.0E-04)									
can spacers (np thickness = 1.4 in.)									
_2_15_3	11,164	857	8,083.9	246.30	1.0E+00	0.74018	0.00062	0.74142	
_2_1_3	11,164	857	0.0	0.00	1.0E-20	0.23225	0.00044	0.23313	

Table 6.9.8.8-5a. Results for uranium tetrafluoride (UF_4) in the CV or ES-3100 packaging calculation models

Case	UF_4 (g)	^{235}U (g)	CV H_2O (g)	h/x	MOCFR or MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
UF_4 content and 500 g polyethylene, flooded containment vessel, reflected								
					MOCFR			
5cvcrpuf4t11_24_15	24,000	18,136	6,045	9.62	1.0E+00	0.85970	0.00145	0.86260
5cvcrpuf4t11_23_15	23,000	17,380	6,195	10.27	1.0E+00	0.86175	0.00129	0.86433
5cvcrpuf4t11_22_15	22,000	16,625	6,345	10.97	1.0E+00	0.86372	0.00151	0.86674
5cvcrpuf4t11_21_15	21,000	15,869	6,496	11.74	1.0E+00	0.86321	0.00152	0.86626
5cvcrpuf4t11_20_15	20,000	15,113	6,646	12.59	1.0E+00	0.86843	0.00121	0.87086
5cvcrpuf4t11_19_15	19,000	14,358	6,797	13.52	1.0E+00	0.87167	0.00120	0.87407
5cvcrpuf4t11_18_15	18,000	13,602	6,947	14.56	1.0E+00	0.86974	0.00152	0.87278
5cvcrpuf4t11_17_15	17,000	12,846	7,097	15.73	1.0E+00	0.87451	0.00130	0.87711
5cvcrpuf4t11_16_15	16,000	12,091	7,248	17.03	1.0E+00	0.87724	0.00175	0.88073
5cvcrpuf4t11_15_15	15,000	11,335	7,398	18.52	1.0E+00	0.87801	0.00156	0.88114
5cvcrpuf4t11_14_15	14,000	10,579	7,549	20.21	1.0E+00	0.88119	0.00147	0.88413
5cvcrpuf4t11_13_15	13,000	9,823	7,699	22.16	1.0E+00	0.88028	0.00136	0.88300
5cvcrpuf4t11_12_15	12,000	9,068	7,850	24.44	1.0E+00	0.88385	0.00139	0.88664
5cvcrpuf4t11_11_15	**11,000**	**8,312**	**8,000**	**27.14**	**1.0E+00**	**0.88690**	**0.00131**	**0.88952**
5cvcrpuf4t11_10_15	10,000	7,556	8,150	30.37	1.0E+00	0.88487	0.00144	0.88776
5cvcrpuf4t11_9_15	9,000	6,801	8,301	34.32	1.0E+00	0.88487	0.00179	0.88845
5cvcrpuf4t11_8_15	8,000	6,045	8,451	39.26	1.0E+00	0.88594	0.00132	0.88859
5cvcrpuf4t11_7_15	7,000	5,289	8,602	45.61	1.0E+00	0.88213	0.00157	0.88526
5cvcrpuf4t11_6_15	6,000	4,534	8,752	54.08	1.0E+00	0.87761	0.00155	0.88070
5cvcrpuf4t11_5_15	5,000	3,778	8,902	65.93	1.0E+00	0.87255	0.00120	0.87494
5cvcrpuf4t11_4_15	4,000	3,022	9,053	83.71	1.0E+00	0.86186	0.00130	0.86446
5cvcrpuf4t11_3_15	3,000	2,267	9,203	113.36	1.0E+00	0.84540	0.00143	0.84827
5cvcrpuf4t11_2_15	2,000	1,511	9,354	172.62	1.0E+00	0.80743	0.00150	0.81044
5cvcrpuf4t11_1_15	1,000	756	9,504	350.39	1.0E+00	0.70654	0.00129	0.70913

Table 6.9.8.8-5a. Results for uranium tetrafluoride (UF_4) in the CV or ES-3100 packaging calculation models

Case	UF_4 (g)	^{235}U (g)	CV H_2O (g)	h/x	MOCFR or MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
UF_4 content with 500 g polyethylene in containment vessel, flooded package, reflected								
5ncsrpuf4t11_24_15	24,000	18,136	6,045	9.62	1.0E+00	0.74487	0.00125	0.74738
5ncsrpuf4t11_23_15	23,000	17,380	6,195	10.27	1.0E+00	0.74674	0.00139	0.74953
5ncsrpuf4t11_22_15	22,000	16,625	6,345	10.97	1.0E+00	0.75066	0.00122	0.75310
5ncsrpuf4t11_21_15	21,000	15,869	6,496	11.74	1.0E+00	0.74939	0.00118	0.75175
5ncsrpuf4t11_20_15	20,000	15,113	6,646	12.59	1.0E+00	0.75270	0.00158	0.75587
5ncsrpuf4t11_19_15	19,000	14,358	6,797	13.52	1.0E+00	0.75465	0.00128	0.75720
5ncsrpuf4t11_18_15	18,000	13,602	6,947	14.56	1.0E+00	0.76103	0.00170	0.76442
5ncsrpuf4t11_17_15	17,000	12,846	7,097	15.73	1.0E+00	0.76089	0.00112	0.76312
5ncsrpuf4t11_16_15	16,000	12,091	7,248	17.03	1.0E+00	0.76404	0.00162	0.76727
5ncsrpuf4t11_15_15	15,000	11,335	7,398	18.52	1.0E+00	0.76718	0.00124	0.76966
5ncsrpuf4t11_14_15	14,000	10,579	7,549	20.21	1.0E+00	0.76630	0.00137	0.76904
5ncsrpuf4t11_13_15	13,000	9,823	7,699	22.16	1.0E+00	0.77064	0.00126	0.77316
5ncsrpuf4t11_12_15	12,000	9,068	7,850	24.44	1.0E+00	0.77019	0.00161	0.77340
5ncsrpuf4t11_11_15	11,000	8,312	8,000	27.14	1.0E+00	0.77412	0.00140	0.77691
5ncsrpuf4t11_10_15	10,000	7,556	8,150	30.37	1.0E+00	0.77743	0.00135	0.78013
5ncsrpuf4t11_9_15	9,000	6,801	8,301	34.32	1.0E+00	0.77855	0.00244	0.78344
5ncsrpuf4t11_8_15	8,000	6,045	8,451	39.26	1.0E+00	0.77398	0.00155	0.77709
5ncsrpuf4t11_7_15	7,000	5,289	8,602	45.61	1.0E+00	0.77431	0.00151	0.77733
5ncsrpuf4t11_6_15	6,000	4,534	8,752	54.08	1.0E+00	0.77174	0.00141	0.77455
5ncsrpuf4t11_5_15	5,000	3,778	8,902	65.93	1.0E+00	0.76857	0.00139	0.77135
5ncsrpuf4t11_4_15	4,000	3,022	9,053	83.71	1.0E+00	0.75863	0.00138	0.76139
5ncsrpuf4t11_3_15	3,000	2,267	9,203	113.36	1.0E+00	0.74294	0.00135	0.74563
5ncsrpuf4t11_2_15	2,000	1,511	9,354	172.62	1.0E+00	0.71219	0.00191	0.71600
5ncsrpuf4t11_1_15	1,000	756	9,504	350.39	1.0E+00	0.62599	0.00150	0.62899

Table 6.9.8.8-5a. Results for uranium tetrafluoride (UF_4) in the CV or ES-3100 packaging calculation models

Case	UF_4 (g)	^{235}U (g)	CV H_2O (g)	h/x	MOCFR or MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
UF_4 content with 500 g poly, flooded containment vessel, infinite array of packages								
					MOIFR			
5nciapuf4t11_24_1	24,000	18,136	6,045	9.62	1.0E-20	0.97902	0.00126	0.98155
5nciapuf4t11_24_2	24,000	18,136	6,045	9.62	1.0E-05	0.97881	0.00120	0.98121
5nciapuf4t11_24_3	24,000	18,136	6,045	9.62	1.0E-04	0.97816	0.00107	0.98030
5nciapuf4t11_24_4	24,000	18,136	6,045	9.62	1.0E-03	0.97536	0.00113	0.97762
5nciapuf4t11_24_5	24,000	18,136	6,045	9.62	1.0E-02	0.95053	0.00135	0.95323
5nciapuf4t11_24_6	24,000	18,136	6,045	9.62	1.0E-01	0.82769	0.00123	0.83014
5nciapuf4t11_24_8	24,000	18,136	6,045	9.62	3.0E-01	0.75894	0.00131	0.76155
5nciapuf4t11_24_15	24,000	18,136	6,045	9.62	1.0E+00	0.76205	0.00140	0.76486
5nciapuf4t11_5_3	5,000	3,778	8,902	65.93	1.0E-04	0.94398	0.00143	0.94684
5nciapuf4t11_4_3	4,000	3,022	9,053	83.71	1.0E-04	0.92856	0.00174	0.93205
5nciapuf4t11_3_3	**3,000**	**2,267**	**9,203**	**113.36**	**1.0E-04**	**0.90021**	**0.00130**	**0.90280**
5nciapuf4t11_2_3	2,000	1,511	9,354	172.62	1.0E-04	0.85169	0.00129	0.85426
5nciapuf4t11_1_3	1,000	756	9,504	350.39	1.0E-04	0.73511	0.00144	0.73800

Table 6.9.8.8-5b. Results for uranyl fluoride (UO_2F_2) and dihydrate ($UO_2F_2 \cdot 2H_2O$) in the CV or ES-3100 packaging calculation models

Case	UO_2F_2 or $UO_2F_2 \cdot 2H_2O$ (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOCFR or MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
UO_2F_2 content and 500-g polyethylene, flooded containment vessel, reflected									
						MOCFR			
5cvcrpuofct11_24_15	24,000	18,493		5,857	9.17	1.0E+00	0.84805	0.00126	0.85056
5cvcrpuofct11_23_15	23,000	17,722		6,015	9.80	1.0E+00	0.85040	0.00128	0.85295
5cvcrpuofct11_22_15	22,000	16,952		6,173	10.49	1.0E+00	0.85175	0.00121	0.85417
5cvcrpuofct11_21_15	21,000	16,181		6,332	11.25	1.0E+00	0.85382	0.00131	0.85644
5cvcrpuofct11_20_15	20,000	15,411		6,490	12.08	1.0E+00	0.85633	0.00119	0.85872
5cvcrpuofct11_19_15	19,000	14,640		6,648	13.00	1.0E+00	0.85906	0.00171	0.86249
5cvcrpuofct11_18_15	18,000	13,870		6,806	14.02	1.0E+00	0.86443	0.00141	0.86725
5cvcrpuofct11_17_15	17,000	13,099		6,964	15.16	1.0E+00	0.86435	0.00148	0.86731
5cvcrpuofct11_16_15	16,000	12,329		7,123	16.44	1.0E+00	0.86719	0.00135	0.86988
5cvcrpuofct11_15_15	15,000	11,558		7,281	17.89	1.0E+00	0.87051	0.00155	0.87361
5cvcrpuofct11_14_15	14,000	10,787		7,439	19.55	1.0E+00	0.87447	0.00125	0.87698
5cvcrpuofct11_13_15	13,000	10,017		7,597	21.47	1.0E+00	0.87165	0.00112	0.87388
5cvcrpuofct11_12_15	12,000	9,246		7,756	23.71	1.0E+00	0.87889	0.00139	0.88167
5cvcrpuofct11_11_15	11,000	8,476		7,914	26.35	1.0E+00	0.87819	0.00144	0.88107
5cvcrpuofct11_10_15	10,000	7,705		8,072	29.52	1.0E+00	0.88027	0.00153	0.88333
5cvcrpuofct11_9_15	9,000	6,935		8,230	33.39	1.0E+00	0.88126	0.00141	0.88409
5cvcrpuofct11_8_15	**8,000**	**6,164**		**8,389**	**38.24**	**1.0E+00**	**0.88397**	**0.00130**	**0.88656**
5cvcrpuofct11_7_15	7,000	5,394		8,547	44.47	1.0E+00	0.87931	0.00143	0.88216
5cvcrpuofct11_6_15	6,000	4,623		8,705	52.77	1.0E+00	0.87723	0.00133	0.87990
5cvcrpuofct11_5_15	5,000	3,852		8,863	64.40	1.0E+00	0.87189	0.00128	0.87446
5cvcrpuofct11_4_15	4,000	3,082		9,022	81.83	1.0E+00	0.86035	0.00130	0.86296
5cvcrpuofct11_3_15	3,000	2,311		9,180	110.90	1.0E+00	0.84392	0.00129	0.84650

Table 6.9.8.8-5b. Results for uranyl fluoride (UO_2F_2) and dihydrate ($UO_2F_2 \cdot 2H_2O$) in the CV or ES-3100 packaging calculation models

Case	UO_2F_2 or $UO_2F_2 \cdot 2H_2O$ (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOCFR or MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
5cvcrpuofct11_2_15	2,000	1,541		9,338	169.02	1.0E+00	0.80710	0.00149	0.81008
5cvcrpuofct11_1_15	1,000	771		9,496	343.36	1.0E+00	0.70780	0.00112	0.71005
$UO_2F_2 \cdot 2H_2O$ content and 500-g polyethylene, flooded containment vessel, reflected									
5cvcrpuofhct11_24_15	24,000	16,540	2,534	4,578	12.24	1.0E+00	0.89612	0.00117	0.89845
5cvcrpuofhct11_23_15	23,000	15,851	2,429	4,789	12.94	1.0E+00	0.89625	0.00162	0.89949
5cvcrpuofhct11_22_15	22,000	15,161	2,323	5,000	13.71	1.0E+00	0.89566	0.00151	0.89867
5cvcrpuofhct11_21_15	21,000	14,472	2,217	5,212	14.56	1.0E+00	0.90107	0.00128	0.90363
5cvcrpuofhct11_20_15	20,000	13,783	2,112	5,424	15.49	1.0E+00	0.89826	0.00199	0.90224
5cvcrpuofhct11_19_15	19,000	13,094	2,006	5,635	16.51	1.0E+00	0.89957	0.00136	0.90230
5cvcrpuofhct11_18_15	18,000	12,405	1,901	5,847	17.65	1.0E+00	0.89897	0.00131	0.90160
5cvcrpuofhct11_17_15	17,000	11,716	1,795	6,058	18.93	1.0E+00	0.89947	0.00145	0.90236
5cvcrpuofhct11_16_15	16,000	11,026	1,689	6,270	20.36	1.0E+00	0.89980	0.00123	0.90226
5cvcrpuofhct11_15_15	15,000	10,337	1,584	6,481	21.99	1.0E+00	0.90038	0.00137	0.90312
5cvcrpuofhct11_14_15	**14,000**	**9,648**	**1,478**	**6,693**	**23.84**	**1.0E+00**	**0.90268**	**0.00196**	**0.90661**
5cvcrpuofhct11_13_15	13,000	8,959	1,373	6,904	25.99	1.0E+00	0.90135	0.00156	0.90446
5cvcrpuofhct11_12_15	12,000	8,270	1,267	7,116	28.49	1.0E+00	0.90033	0.00137	0.90306
5cvcrpuofhct11_11_15	11,000	7,580	1,161	7,328	31.44	1.0E+00	0.90064	0.00155	0.90373
5cvcrpuofhct11_10_15	10,000	6,891	1,056	7,539	34.99	1.0E+00	0.90163	0.00127	0.90418
5cvcrpuofhct11_9_15	9,000	6,202	950	7,751	39.32	1.0E+00	0.90041	0.00143	0.90327
5cvcrpuofhct11_8_15	8,000	5,513	844	7,962	44.73	1.0E+00	0.89433	0.00159	0.89751
5cvcrpuofhct11_7_15	7,000	4,824	739	8,174	51.70	1.0E+00	0.89222	0.00163	0.89547
5cvcrpuofhct11_6_15	6,000	4,135	633	8,385	60.98	1.0E+00	0.88507	0.00142	0.88791
5cvcrpuofhct11_5_15	5,000	3,445	528	8,597	73.98	1.0E+00	0.87613	0.00179	0.87972
5cvcrpuofhct11_4_15	4,000	2,756	422	8,808	93.48	1.0E+00	0.86244	0.00121	0.86486

Table 6.9.8.8-5b. Results for uranyl fluoride (UO_2F_2) and dihydrate ($UO_2F_2 \cdot 2H_2O$) in the CV or ES-3100 packaging calculation models

Case	UO_2F_2 or $UO_2F_2 \cdot 2H_2O$ (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOCFR or MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
5cvcrpuofhct11_3_15	3,000	2,067	316	9,020	125.98	1.0E+00	0.84181	0.00137	0.84456
5cvcrpuofhct11_2_15	2,000	1,378	211	9,231	190.97	1.0E+00	0.79635	0.00128	0.79892
5cvcrpuofhct11_1_15	1,000	689	105	9,443	385.88	1.0E+00	0.69241	0.00157	0.69554
$UO_2F_2 \cdot 2H_2O$ content and 500-g polyethylene, flooded containment vessel, package reflected									
						MOIFR			
5ncsrpuofhct11_24_1	24,000	16,540	2,534	0	5.01	1.0E-20	0.49256	0.00113	0.49483
5ncsrpuofhct11_24_2	24,000	16,540	2,534	0	5.01	1.0E-05	0.49385	0.00104	0.49593
5ncsrpuofhct11_24_3	24,000	16,540	2,534	0	5.01	1.0E-04	0.49252	0.00089	0.49430
5ncsrpuofhct11_24_4	24,000	16,540	2,534	5	5.02	1.0E-03	0.49420	0.00095	0.49609
5ncsrpuofhct11_24_5	24,000	16,540	2,534	46	5.09	1.0E-02	0.49714	0.00115	0.49945
5ncsrpuofhct11_24_6	24,000	16,540	2,534	458	5.74	1.0E-01	0.52171	0.00098	0.52366
5ncsrpuofhct11_24_8	24,000	16,540	2,534	1,373	7.18	3.0E-01	0.58684	0.00114	0.58913
5ncsrpuofhct11_24_15	24,000	16,540	2,534	4,578	12.24	1.0E+00	0.78391	0.00172	0.78736
5ncsrpuofhct11_23_15	23,000	15,851	2,429	4,789	12.94	1.0E+00	0.78964	0.00172	0.79308
5ncsrpuofhct11_22_15	22,000	15,161	2,323	5,000	13.71	1.0E+00	0.78880	0.00124	0.79129
5ncsrpuofhct11_21_15	21,000	14,472	2,217	5,212	14.56	1.0E+00	0.78867	0.00131	0.79129
5ncsrpuofhct11_20_15	20,000	13,783	2,112	5,424	15.49	1.0E+00	0.78987	0.00144	0.79274
5ncsrpuofhct11_19_15	19,000	13,094	2,006	5,635	16.51	1.0E+00	0.78903	0.00171	0.79245
5ncsrpuofhct11_18_15	18,000	12,405	1,901	5,847	17.65	1.0E+00	0.79165	0.00153	0.79471
5ncsrpuofhct11_17_15	17,000	11,716	1,795	6,058	18.93	1.0E+00	0.79090	0.00142	0.79373
5ncsrpuofhct11_16_15	16,000	11,026	1,689	6,270	20.36	1.0E+00	0.79393	0.00145	0.79682
5ncsrpuofhct11_15_15	15,000	10,337	1,584	6,481	21.99	1.0E+00	0.79337	0.00139	0.79615
5ncsrpuofhct11_14_15	14,000	9,648	1,478	6,693	23.84	1.0E+00	0.79414	0.00172	0.79759
5ncsrpuofhct11_13_15	13,000	8,959	1,373	6,904	25.99	1.0E+00	0.79139	0.00126	0.79390

Table 6.9.8.8-5b. Results for uranyl fluoride (UO_2F_2) and dihydrate ($UO_2F_2 \cdot 2H_2O$) in the CV or ES-3100 packaging calculation models

Case	UO_2F_2 or $UO_2F_2 \cdot 2H_2O$ (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOCFR or MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
5ncsrpuofhct11_12_15	12,000	8,270	1,267	7,116	28.49	1.0E+00	0.79345	0.00138	0.79622
5ncsrpuofhct11_11_15	11,000	7,580	1,161	7,328	31.44	1.0E+00	0.79315	0.00194	0.79702
5ncsrpuofhct11_10_15	10,000	6,891	1,056	7,539	34.99	1.0E+00	0.79148	0.00161	0.79470
5ncsrpuofhct11_9_15	9,000	6,202	950	7,751	39.32	1.0E+00	0.79130	0.00138	0.79407
5ncsrpuofhct11_8_15	8,000	5,513	844	7,962	44.73	1.0E+00	0.78925	0.00147	0.79219
5ncsrpuofhct11_7_15	7,000	4,824	739	8,174	51.70	1.0E+00	0.78731	0.00167	0.79066
5ncsrpuofhct11_6_15	6,000	4,135	633	8,385	60.98	1.0E+00	0.78183	0.00158	0.78500
5ncsrpuofhct11_5_15	5,000	3,445	528	8,597	73.98	1.0E+00	0.77586	0.00153	0.77893
5ncsrpuofhct11_4_15	4,000	2,756	422	8,808	93.48	1.0E+00	0.76058	0.00162	0.76382
5ncsrpuofhct11_3_15	3,000	2,067	316	9,020	125.98	1.0E+00	0.74131	0.00163	0.74457
5ncsrpuofhct11_2_15	2,000	1,378	211	9,231	190.97	1.0E+00	0.70445	0.00111	0.70667
5ncsrpuofhct11_1_15	1,000	689	105	9,443	385.88	1.0E+00	0.61078	0.00155	0.61388
$UO_2F_2 \cdot 2H_2O$ content, 500-g polyethylene, flooded containment vessel, infinite array of packages									
5nciapuofhct11_24_1	24,000	16,540	2,534	4578	12.24	1.0E-20	1.01183	0.00147	1.01477
5nciapuofhct11_24_2	24,000	16,540	2,534	4578	12.24	1.0E-05	1.01204	0.00140	1.01484
5nciapuofhct11_24_3	24,000	16,540	2,534	4578	12.24	1.0E-04	1.01068	0.00131	1.01331
5nciapuofhct11_24_4	24,000	16,540	2,534	4578	12.24	1.0E-03	1.01093	0.00141	1.01376
5nciapuofhct11_24_5	24,000	16,540	2,534	4578	12.24	1.0E-02	0.98858	0.00125	0.99109
5nciapuofhct11_24_6	24,000	16,540	2,534	4578	12.24	1.0E-01	0.86983	0.00146	0.87275
5nciapuofhct11_24_8	24,000	16,540	2,534	4578	12.24	3.0E-01	0.80292	0.00136	0.80563
5nciapuofhct11_24_15	24,000	16,540	2,534	4578	12.24	1.0E+00	0.80947	0.00166	0.81279

Table 6.9.8.8-5b. Results for uranyl fluoride (UO_2F_2) and dihydrate ($UO_2F_2 \cdot 2H_2O$) in the CV or ES-3100 packaging calculation models

Case	UO_2F_2 or $UO_2F_2 \cdot 2H_2O$ (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOCFR or MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
5nciapuofhct11_5_3	5,000	3,445	528	8597	73.98	1.0E-04	0.94605	0.00142	0.94889
5nciapuofhct11_4_3	4,000	2,756	422	8808	93.48	1.0E-04	0.92472	0.00122	0.92717
5nciapuofhct11_3_3	**3,000**	**2,067**	**316**	**9020**	**125.98**	**1.0E-04**	**0.89532**	**0.00125**	**0.89782**
5nciapuofhct11_2_3	2,000	1,378	211	9231	190.97	1.0E-04	0.84144	0.00123	0.84391
5nciapuofhct11_1_3	1,000	689	105	9443	385.88	1.0E-04	0.71661	0.00117	0.71896

Table 6.9.8.8-6a. Results for uranium carbide compounds in the CV or ES-3100 packaging calculation models

Case	UC_x (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOCFR or MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
UC content and 500 g polyethylene, flooded containment vessel, reflected									
						MOCFR			
5cvcrpuct11_1_10	10,000	9,514	4,259	4,663	26.24	1.0E+00	0.91168	0.00161	0.91491
5cvcrpuct11_1_9	9,000	8,563	3,833	5,163	29.38	1.0E+00	0.90134	0.00158	0.90450
5cvcrpuct11_1_8	8,000	7,612	3,407	5,662	33.30	1.0E+00	0.89789	0.00126	0.90041
5cvcrpuct11_1_7	7,000	6,660	2,981	6,161	38.34	1.0E+00	0.88176	0.00129	0.88435
5cvcrpuct11_1_6	6,000	5,709	2,555	6,660	45.07	1.0E+00	0.86805	0.00174	0.87154
5cvcrpuct11_1_5	5,000	4,757	2,129	7,159	54.49	1.0E+00	0.84990	0.00147	0.85284
5cvcrpuct11_1_4	4,000	3,806	1,704	7,658	68.61	1.0E+00	0.82598	0.00192	0.82982
5cvcrpuct11_1_3	3,000	2,854	1,278	8,157	92.15	1.0E+00	0.78650	0.00210	0.79070
5cvcrpuct11_1_2	2,000	1,903	852	8,656	139.22	1.0E+00	0.73220	0.00137	0.73494
5cvcrpuct11_1_1	1,000	952	426	9,155	280.42	1.0E+00	0.64502	0.00133	0.64769
U_2C_3 content and 500 g polyethylene, flooded containment vessel, reflected									
5cvcrpuct11_2_10	10,000	9,289	4,205	4,663	26.73	1.0E+00	0.90748	0.00130	0.91008
5cvcrpuct11_2_9	9,000	8,360	3,784	5,163	29.94	1.0E+00	0.89950	0.00134	0.90218
5cvcrpuct11_2_8	8,000	7,431	3,364	5,662	33.96	1.0E+00	0.89139	0.00134	0.89408
5cvcrpuct11_2_7	7,000	6,502	2,944	6,161	39.12	1.0E+00	0.87929	0.00146	0.88220
5cvcrpuct11_2_6	6,000	5,573	2,523	6,660	46.02	1.0E+00	0.86494	0.00134	0.86763
5cvcrpuct11_2_5	5,000	4,644	2,102	7,159	55.66	1.0E+00	0.84909	0.00165	0.85239
5cvcrpuct11_2_4	4,000	3,716	1,682	7,658	70.12	1.0E+00	0.81915	0.00155	0.82225
5cvcrpuct11_2_3	3,000	2,787	1,262	8,157	94.24	1.0E+00	0.78499	0.00137	0.78773
5cvcrpuct11_2_2	2,000	1,858	841	8,656	142.46	1.0E+00	0.72911	0.00158	0.73227
5cvcrpuct11_2_1	1,000	929	421	9,155	287.08	1.0E+00	0.64063	0.00142	0.64347

Table 6.9.8.8-6a. Results for uranium carbide compounds in the CV or ES-3100 packaging calculation models

Case	UC_x (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOCFR or MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
UC_2 content and 500 g polyethylene, flooded containment vessel, reflected									
5cvcrpuct11_3_10	10,000	9,074	4,108	4,663	27.08	1.0E+00	0.89850	0.00141	0.90132
5cvcrpuct11_3_9	9,000	8,166	3,697	5,163	30.37	1.0E+00	0.88960	0.00148	0.89255
5cvcrpuct11_3_8	8,000	7,259	3,286	5,662	34.48	1.0E+00	0.88297	0.00163	0.88623
5cvcrpuct11_3_7	7,000	6,352	2,875	6,161	39.77	1.0E+00	0.87224	0.00126	0.87476
5cvcrpuct11_3_6	6,000	5,444	2,465	6,660	46.83	1.0E+00	0.85667	0.00180	0.86028
5cvcrpuct11_3_5	5,000	4,537	2,054	7,159	56.70	1.0E+00	0.83768	0.00164	0.84095
5cvcrpuct11_3_4	4,000	3,630	1,643	7,658	71.51	1.0E+00	0.81450	0.00137	0.81724
5cvcrpuct11_3_3	3,000	2,722	1,232	8,157	96.19	1.0E+00	0.77746	0.00141	0.78028
5cvcrpuct11_3_2	2,000	1,815	822	8,656	145.55	1.0E+00	0.72120	0.00129	0.72377
5cvcrpuct11_3_1	1,000	908	411	9,155	293.60	1.0E+00	0.63468	0.00121	0.63711
UC content with 500 g polyethylene, flooded containment vessel, flooded package, reflected									
						MOCFR			
5ncsrpuct11_1_10_15	10,000	9,514	4,259	4,663	26.24	1.0E+00	0.81163	0.00116	0.81395
5ncsrpuct11_1_9_15	9,000	8,563	3,833	5,163	29.38	1.0E+00	0.80769	0.00145	0.81060
5ncsrpuct11_1_8_15	8,000	7,612	3,407	5,662	33.30	1.0E+00	0.79915	0.00170	0.80254
5ncsrpuct11_1_7_15	7,000	6,660	2,981	6,161	38.34	1.0E+00	0.78922	0.00142	0.79207
5ncsrpuct11_1_6_15	6,000	5,709	2,555	6,660	45.07	1.0E+00	0.77601	0.00157	0.77915
5ncsrpuct11_1_5_15	5,000	4,757	2,129	7,159	54.49	1.0E+00	0.75825	0.00153	0.76130
5ncsrpuct11_1_4_15	4,000	3,806	1,704	7,658	68.61	1.0E+00	0.73808	0.00130	0.74068
5ncsrpuct11_1_3_15	3,000	2,854	1,278	8,157	92.15	1.0E+00	0.70280	0.00142	0.70564

Table 6.9.8.8-6a. Results for uranium carbide compounds in the CV or ES-3100 packaging calculation models

Case	UC_x (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOCFR or MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
						MOIFR			
5ncsrpuct11_1_2_15	2,000	1,903	852	8,656	139.22	1.0E+00	0.65451	0.00136	0.65724
5ncsrpuct11_1_2_8	2,000	1,903	852	2,597	56.11	3.0E-01	0.62741	0.00153	0.63046
5ncsrpuct11_1_2_6	2,000	1,903	852	866	32.37	1.0E-01	0.61746	0.00123	0.61991
5ncsrpuct11_1_2_5	2,000	1,903	852	87	21.68	1.0E-02	0.61244	0.00119	0.61482
5ncsrpuct11_1_2_4	2,000	1,903	852	9	20.61	1.0E-03	0.61168	0.00122	0.61413
5ncsrpuct11_1_2_3	2,000	1,903	852	1	20.51	1.0E-04	0.61271	0.00127	0.61524
5ncsrpuct11_1_2_2	2,000	1,903	852	0	20.50	1.0E-05	0.61238	0.00127	0.61493
5ncsrpuct11_1_2_1	2,000	1,903	852	0	20.50	1.0E-20	0.61350	0.00158	0.61667
5ncsrpuct11_1_1_15	1,000	952	426	9,155	280.42	1.0E+00	0.57240	0.00136	0.57511
U_2C_3 content with 500 g polyethylene, flooded containment vessel, flooded package, reflected									
						MOIFR			
5ncsrpuct11_2_10_15	10,000	9,289	4,205	4,663	26.73	1.0E+00	0.80860	0.00134	0.81128
5ncsrpuct11_2_9_15	9,000	8,360	3,785	5,163	29.94	1.0E+00	0.80156	0.00146	0.80447
5ncsrpuct11_2_8_15	8,000	7,431	3,364	5,662	33.96	1.0E+00	0.79658	0.00136	0.79931
5ncsrpuct11_2_7_15	7,000	6,502	2,944	6,161	39.12	1.0E+00	0.78449	0.00152	0.78753
5ncsrpuct11_2_6_15	6,000	5,573	2,523	6,660	46.02	1.0E+00	0.77423	0.00147	0.77717
5ncsrpuct11_2_5_15	5,000	4,644	2,103	7,159	55.66	1.0E+00	0.75640	0.00143	0.75925
5ncsrpuct11_2_4_15	4,000	3,716	1,682	7,658	70.12	1.0E+00	0.73260	0.00131	0.73522
5ncsrpuct11_2_3_15	3,000	2,787	1,262	8,157	94.24	1.0E+00	0.70111	0.00164	0.70438
5ncsrpuct11_2_2_15	2,000	1,858	841	8,656	142.46	1.0E+00	0.65046	0.00117	0.65280
5ncsrpuct11_2_1_15	1,000	929	421	9,155	287.08	1.0E+00	0.57215	0.00122	0.57458

Table 6.9.8.8-6a. Results for uranium carbide compounds in the CV or ES-3100 packaging calculation models

Case	UC_x (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOCFR or MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
UC_2 content with 500 g polyethylene, flooded containment vessel, flooded package, reflected									
						MOIFR			
5ncsrpuct11_3_10_15	10,000	9,074	4,108	4,663	27.08	1.0E+00	0.79965	0.00134	0.80232
5ncsrpuct11_3_9_15	9,000	8,166	3,697	5,163	30.37	1.0E+00	0.79317	0.00125	0.79568
5ncsrpuct11_3_8_15	8,000	7,259	3,286	5,662	34.48	1.0E+00	0.78608	0.00155	0.78918
5ncsrpuct11_3_7_15	7,000	6,352	2,875	6,161	39.77	1.0E+00	0.77715	0.00129	0.77973
5ncsrpuct11_3_6_15	6,000	5,444	2,465	6,660	46.83	1.0E+00	0.76221	0.00128	0.76476
5ncsrpuct11_3_5_15	5,000	4,537	2,054	7,159	56.70	1.0E+00	0.74673	0.00139	0.74950
5ncsrpuct11_3_4_15	4,000	3,630	1,643	7,658	71.51	1.0E+00	0.72415	0.00126	0.72666
5ncsrpuct11_3_3_15	3,000	2,722	1,232	8,157	96.19	1.0E+00	0.69399	0.00134	0.69666
5ncsrpuct11_3_2_15	2,000	1,815	822	8,656	145.55	1.0E+00	0.64590	0.00152	0.64895
5ncsrpuct11_3_1_15	1,000	908	411	9,155	293.60	1.0E+00	0.56666	0.00165	0.56995
UC content, 500 g poly, flooded containment vessel, infinite array of packages									
						MOIFR			
5nciapuct11_1_9_3	9,000	8,563	3,833	5,163	29.38	1.0E-04	0.90795	0.00136	0.91066
5nciapuct11_1_8_3	8,000	7,612	3,407	5,662	33.30	1.0E-04	0.89136	0.00139	0.89414
5nciapuct11_1_7_3	7,000	6,660	2,981	6,161	38.34	1.0E-04	0.87019	0.00131	0.87281
5nciapuct11_1_6_3	6,000	5,709	2,555	6,660	45.07	1.0E-04	0.84331	0.00140	0.84610
5nciapuct11_1_5_3	5,000	4,757	2,129	7,159	54.49	1.0E-04	0.81542	0.00127	0.81796
5nciapuct11_1_4_3	4,000	3,806	1,704	7,658	68.61	1.0E-04	0.78005	0.00139	0.78283
5nciapuct11_1_3_3	3,000	2,854	1,278	8,157	92.15	1.0E-04	0.73291	0.00130	0.73550

Table 6.9.8.8-6a. Results for uranium carbide compounds in the CV or ES-3100 packaging calculation models

Case	UC_x (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOCFR or MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
5nciapuct11_1_2_3	2,000	1,903	852	8,656	139.22	1.0E-04	0.67136	0.00129	0.67394
5nciapuct11_1_1_3	1,000	952	426	9,155	280.42	1.0E-04	0.57485	0.00114	0.57712

Case	UC_x (g)	^{235}U (g)	CV H_2O (g)	h/x	MOCFR or MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
UC content, 500 g poly, dispersed in flooded containment vessel, infinite array of packages								
5nciadpuct11_1_9_15_3	9,000	8,563	8,995	29.38	1.0E-04	1.02430	0.00136	1.02702
5nciadpuct11_1_8_15_3	8,000	7,612	9,069	33.30	1.0E-04	1.01560	0.00151	1.01862
5nciadpuct11_1_7_15_3	7,000	6,660	9,142	38.34	1.0E-04	1.00614	0.00147	1.00907
5nciadpuct11_1_6_15_3	6,000	5,709	9,215	45.07	1.0E-04	0.99808	0.00135	1.00078
5nciadpuct11_1_5_15_3	5,000	4,757	9,288	54.49	1.0E-04	0.98482	0.00115	0.98712
5nciadpuct11_1_4_15_3	4,000	3,806	9,362	68.61	1.0E-04	0.96658	0.00121	0.96899
5nciadpuct11_1_3_15_3	3,000	2,854	9,435	92.15	1.0E-04	0.94085	0.00131	0.94347
5nciadpuct11_1_2_15_3	**2,000**	**1,903**	**9,508**	**139.22**	**1.0E-04**	**0.89104**	**0.00175**	**0.89453**
5nciadpuct11_1_1_15_3	1,000	952	9,581	280.42	1.0E-04	0.78231	0.00129	0.78488

Table 6.9.8.8-6b. Results for uranium nitride in the CV or ES-3100 packaging calculation models

Case	UN (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOCFR or MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
UN content and 500 g polyethylene, flooded containment vessel, reflected									
						MOCFR			
5cvcrpunt11_10	10,000	9,438	4,294	4,663	26.55	1.0E+00	0.90649	0.00145	0.90939
5cvcrpunt11_9	9,000	8,494	3,864	5,163	29.71	1.0E+00	0.90302	0.00131	0.90563
5cvcrpunt11_8	8,000	7,550	3,435	5,662	33.67	1.0E+00	0.89305	0.00115	0.89534
5cvcrpunt11_7	7,000	6,607	3,006	6,161	38.75	1.0E+00	0.88246	0.00212	0.88671
5cvcrpunt11_6	6,000	5,663	2,576	6,660	45.53	1.0E+00	0.86740	0.00137	0.87014
5cvcrpunt11_5	5,000	4,719	2,147	7,159	55.03	1.0E+00	0.84695	0.00158	0.85011
5cvcrpunt11_4	4,000	3,775	1,718	7,658	69.26	1.0E+00	0.82223	0.00148	0.82518
5cvcrpunt11_3	3,000	2,831	1,288	8,157	93.00	1.0E+00	0.78572	0.00124	0.78819
5cvcrpunt11_2	2,000	1,888	859	8,656	140.45	1.0E+00	0.73107	0.00156	0.73418
5cvcrpunt11_1	1,000	944	430	9,155	282.79	1.0E+00	0.64271	0.00170	0.64611
UN content with 500 g polyethylene, flooded containment vessel, flooded package, reflected									
						MOIFR			
5ncsrpunt11_10_1	10,000	9,438	4,294	0.00	13.65	1.0E-20	0.80847	0.00142	0.81131
5ncsrpunt11_10_2	10,000	9,438	4,294	0.00	13.65	1.0E-05	0.80937	0.00123	0.81184
5ncsrpunt11_10_3	10,000	9,438	4,294	0.50	13.65	1.0E-04	0.80771	0.00139	0.81048
5ncsrpunt11_10_4	10,000	9,438	4,294	4.70	13.67	1.0E-03	0.80868	0.00145	0.81158
5ncsrpunt11_10_5	10,000	9,438	4,294	46.60	13.78	1.0E-02	0.80964	0.00140	0.81243
5ncsrpunt11_10_6	10,000	9,438	4,294	466	14.94	1.0E-01	0.80771	0.00167	0.81105
5ncsrpunt11_10_8	10,000	9,438	4,294	1,399	17.52	3.0E-01	0.81176	0.00165	0.81506
5ncsrpunt11_10_15	10,000	9,438	4,294	4,663	26.55	1.0E+00	0.81120	0.00138	0.81395
5ncsrpunt11_9_15	9,000	8,494	3,864	5,163	29.71	1.0E+00	0.80784	0.00147	0.81079
5ncsrpunt11_8_15	8,000	7,550	3,435	5,662	33.67	1.0E+00	0.79743	0.00124	0.79990

Table 6.9.8.8-6b. Results for uranium nitride in the CV or ES-3100 packaging calculation models

Case	UN (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOCFR or MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
5ncsrpunt11_7_15	7,000	6,607	3,006	6,161	38.75	1.0E+00	0.78734	0.00139	0.79012
5ncsrpunt11_6_15	6,000	5,663	2,576	6,660	45.53	1.0E+00	0.77284	0.00207	0.77698
5ncsrpunt11_5_15	5,000	4,719	2,147	7,159	55.03	1.0E+00	0.76092	0.00146	0.76383
5ncsrpunt11_4_15	4,000	3,775	1,718	7,658	69.26	1.0E+00	0.73456	0.00132	0.73719
5ncsrpunt11_3_15	3,000	2,831	1,288	8,157	93.00	1.0E+00	0.70343	0.00120	0.70583
5ncsrpunt11_2_15	2,000	1,888	859	8,656	140.45	1.0E+00	0.65433	0.00136	0.65706
5ncsrpunt11_2_8	2,000	1,888	859	2,597	56.67	3.0E-01	0.62697	0.00121	0.62939
5ncsrpunt11_2_6	2,000	1,888	859	866	32.73	1.0E-01	0.61816	0.00117	0.62050
5ncsrpunt11_2_5	2,000	1,888	859	86.60	21.96	1.0E-02	0.61304	0.00124	0.61553
5ncsrpunt11_2_4	2,000	1,888	859	8.70	20.88	1.0E-03	0.61327	0.00134	0.61594
5ncsrpunt11_2_3	2,000	1,888	859	0.90	20.77	1.0E-04	0.61276	0.00152	0.61581
5ncsrpunt11_2_2	2,000	1,888	859	0.10	20.76	1.0E-05	0.61295	0.00136	0.61568
5ncsrpunt11_2_1	2,000	1,888	859	0.00	20.76	1.0E-20	0.61292	0.00107	0.61505
5ncsrpunt11_1_15	1,000	944	430	9,155	282.79	1.0E+00	0.57154	0.00116	0.57387
UN content, 500 g poly, flooded containment vessel, infinite array of packages									
						MOIFR			
5nciapunt11_10_3	10,000	9,438	4,294	4,663	26.55	1.0E-04	0.92423	0.00151	0.92725
5nciapunt11_9_3	9,000	8,494	3,864	5,163	29.71	1.0E-04	0.90687	0.00131	0.90950
5nciapunt11_8_3	8,000	7,550	3,435	5,662	33.67	1.0E-04	0.88819	0.00172	0.89163
5nciapunt11_7_3	7,000	6,607	3,006	6,161	38.75	1.0E-04	0.86369	0.00147	0.86662
5nciapunt11_6_3	6,000	5,663	2,576	6,660	45.53	1.0E-04	0.84576	0.00143	0.84862
5nciapunt11_5_3	5,000	4,719	2,147	7,159	55.03	1.0E-04	0.81575	0.00130	0.81835

Table 6.9.8.8-6b. Results for uranium nitride in the CV or ES-3100 packaging calculation models

Case	UN (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOCFR or MOIFR	k_{eff}	σ	$k_{eff}+2\sigma$
5nciapunt11_4_3	4,000	3,775	1,718	7,658	69.26	1.0E-04	0.77916	0.00132	0.78181
5nciapunt11_3_3	3,000	2,831	1,288	8,157	93.00	1.0E-04	0.73422	0.00140	0.73702
5nciapunt11_2_3	2,000	1,888	859	8,656	140.45	1.0E-04	0.67190	0.00129	0.67448
5nciapunt11_1_3	1,000	944	430	9,155	282.79	1.0E-04	0.57515	0.00132	0.57778
Case	**UN (g)**	**^{235}U (g)**		**CV H_2O (g)**	**h/x**	**MOIFR**	**k_{eff}**	**σ**	**$k_{eff}+2\sigma$**
UN and 500 g poly dispersed inside flooded containment vessel, infinite array of packages									
5nciadpunt11_10_15_3	10,000	9,438		8,957	26.55	1.0E+00	1.02413	0.00140	1.02692
5nciadpunt11_9_15_3	9,000	8,494		9,027	29.71	1.0E+00	1.01877	0.00156	1.02190
5nciadpunt11_8_15_3	8,000	7,550		9,097	33.67	1.0E+00	1.01312	0.00134	1.01581
5nciadpunt11_7_15_3	7,000	6,607		9,166	38.75	1.0E+00	1.00582	0.00149	1.00879
5nciadpunt11_6_15_3	6,000	5,663		9,236	45.53	1.0E+00	0.99488	0.00139	0.99766
5nciadpunt11_5_15_3	5,000	4,719		9,306	55.03	1.0E+00	0.98037	0.00152	0.98341
5nciadpunt11_4_15_3	4,000	3,775		9,376	69.26	1.0E+00	0.96456	0.00166	0.96787
5nciadpunt11_3_15_3	3,000	2,831		9,445	93.00	1.0E+00	0.93621	0.00125	0.93872
5nciadpunt11_2_15_3	**2,000**	**1,888**		**9,515**	**140.45**	**1.0E+00**	**0.88902**	**0.00129**	**0.89159**
5nciadpunt11_1_15_3	1,000	944		9,585	282.79	1.0E+00	0.77903	0.00149	0.78200

Table 6.9.8.8-7a. Results for uranium silicide in the CV calculation models

Case 5cvcrpdusit11*	U_3Si_2 (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	variable	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5cvcrdpust11*	k_{eff}	σ	$k_{eff}+2\sigma$
13 kg sat. U_3Si_2 and 500 g poly in flooded CV, density from 7 to 2 g/cm^3										**Content dispersed in flooded CV**			
_8_7_13_15	13,000	12,041	856	7,801	20.16	7	0.84659	0.00129	0.84917	_8_7_13_15	0.92539	0.00156	0.92852
_8_6_13_15	13,000	12,041	1,165	7,492	20.16	6	0.85534	0.00136	0.85806	_8_6_13_15	0.92539	0.00156	0.92852
_8_5_13_15	13,000	12,041	1,597	7,059	20.16	5	0.86758	0.00115	0.86987	_8_5_13_15	0.92539	0.00156	0.92852
_8_4_13_15	13,000	12,041	2,246	6,410	20.16	4	0.88301	0.00147	0.88595	_8_4_13_15	0.92539	0.00156	0.92852
_8_3_13_15	13,000	12,041	3,327	5,329	20.16	3	0.89897	0.00133	0.90163	_8_3_13_15	0.92539	0.00156	0.92852
_8_2_13_15	13,000	12,041	5,490	3,166	20.16	2	0.91671	0.00154	0.91978	_8_2_13_15	0.92539	0.00156	0.92852
From 13 to 7 kg sat. U_3Si_2 at 7 g/cm^3 and 500 g poly in flooded CV										**Content dispersed in flooded CV**			
_8_7_13_15	13,000	12,041	856	7,801	20.16	-	0.84659	0.00129	0.84917	_8_7_13_15	0.92539	0.00156	0.92852
	12,000	11,115	790	7,943	22.02					_8_7_12_15	0.92346	0.00136	0.92619
	11,000	10,189	724	8,086	24.22					_8_7_11_15	0.92254	0.00144	0.92542
	10,000	9,262	658	8,228	26.85					_8_7_10_15	0.92257	0.00141	0.92539
	9,000	8,336	592	8,371	30.08					_8_7_9_15	0.91555	0.00187	0.91929
	8,000	7,410	527	8,514	34.11					_8_7_8_15	0.91645	0.00169	0.91984
	7,000	6,484	461	8,656	39.29					_8_7_7_15	0.91284	0.00124	0.91532
13 kg sat. U_3Si_2 at 7 g/cm^3 and 500 g poly in flooded CV, enrichment from 100 to 19.7 wt % ^{235}U										**Content dispersed in flooded CV**			
_8_7_13_15	13,000	12,041	856	7,801	20.16	100	0.84659	0.00129	0.84917	_8_7_13_15	0.92539	0.00156	0.92852
_7_7_13_15	13,000	11,440	856	7,801	21.22	95	0.83163	0.00132	0.83427	_7_7_13_15	0.91534	0.00129	0.91791
_6_7_13_15	13,000	10,838	856	7,801	22.39	90	0.81948	0.00126	0.82200	_6_7_13_15	0.90311	0.00132	0.90574
_5_7_13_15	13,000	9,635	856	7,801	25.19	80	0.79868	0.00135	0.80139	_5_7_13_15	0.88874	0.00134	0.89142
_4_7_13_15	13,000	8,431	856	7,801	28.79	70	0.77451	0.00126	0.77702	_4_7_13_15	0.87598	0.00127	0.87853
_3_7_13_15	13,000	7,227	856	7,801	33.58	60	0.75204	0.00113	0.75431	_3_7_13_15	0.86402	0.00155	0.86712
_2_7_13_15	13,000	4,819	856	7,801	50.36	40	0.69967	0.00122	0.70211	_2_7_13_15	0.82956	0.00140	0.83237
_1_7_13_15	13,000	2,290	856	7,801	106.01	19.7	0.62192	0.00116	0.62424	_1_7_13_15	0.76076	0.00137	0.76349

Table 6.9.8.8-7a. Results for uranium silicide in the CV calculation models

Case 5cvcrpdusit11*	U_3Si_2 (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	variable	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5cvcrdpust11*	k_{eff}	σ	$k_{eff}+2\sigma$
7 kg sat. U_3Si_2 at 7 g/cm^3 and 500 g poly in flooded CV, enrichment from 100 to 19.7 wt % ^{235}U										**Content dispersed in flooded CV**			
	7,000	6,484	461	8,656	39.29	100				_8_7_7_15	0.91284	0.00124	0.91532
	7,000	6,160	461	8,656	41.35	95				_7_7_7_15	0.90261	0.00143	0.90547
	7,000	5,836	461	8,656	43.65	90				_6_7_7_15	0.89613	0.00137	0.89886
	7,000	5,188	461	8,656	49.10	80				_5_7_7_15	0.87984	0.00178	0.88339
	7,000	4,540	461	8,656	56.11	70				_4_7_7_15	0.86767	0.00166	0.87099
	7,000	3,892	461	8,656	65.46	60				_3_7_7_15	0.85292	0.00168	0.85627
	7,000	2,595	461	8,656	98.16	40				_2_7_7_15	0.81300	0.00139	0.81579
	7,000	1,233	461	8,656	206.62	19.7				_1_7_7_15	0.72136	0.00111	0.72358
From 13 to 7 kg sat. U_3Si_2 at 19.7 wt % ^{235}U and 7 g/cm^3, and 500 g poly in flooded CV										**Content dispersed in flooded CV**			
_1_7_13_15	13,000	2,290	856	7,801	106.01	19.7	0.62192	0.00116	0.62424	_1_7_13_15	0.76076	0.00137	0.76349
	12,000	2,113	790	7,943	115.79	19.7				_1_7_12_15	0.75612	0.00133	0.75878
	11,000	1,937	724	8,086	127.35	19.7				_1_7_11_15	0.75182	0.00127	0.75437
	10,000	1,761	658	8,228	141.22	19.7				_1_7_10_15	0.75022	0.00124	0.75270
	9,000	1,585	592	8,371	158.18	19.7				_1_7_9_15	0.74197	0.00116	0.74428
	8,000	1,409	527	8,514	179.38	19.7				_1_7_8_15	0.73321	0.00114	0.73549
	7,000	1,233	461	8,656	206.62	19.7				_1_7_7_15	0.72136	0.00111	0.72358
From 4 to 14 kg sat U_3Si at 2 g/cm^3 at 40 wt % ^{235}U and 2 g/cm^3, 500 g poly in dry CV Case cvcrdpus3sit11*, USL=0.93680										**Content dispersed in dry CV Case cvcrdpu3sit11*, USL=0.93680**			
_2_1_1	4,000	1,539	1,711	0.0	39.91	40	0.71069	0.00078	0.71225	_2_1_1	0.40132	0.00053	0.40238
_2_2_1	6,000	2,309	2,567	0.0	36.28	40	0.76239	0.00073	0.76385	_2_2_1	0.46917	0.00054	0.47025
_2_3_1	8,000	3,078	3,422	0.0	34.46	40	0.78845	0.00067	0.78979	_2_3_1	0.53216	0.00062	0.53340
_2_4_1	10,000	3,848	4,278	0.0	33.38	40	0.80614	0.0007	0.80754	_2_4_1	0.59103	0.00068	0.59239
_2_5_1	12,000	4,618	5,134	0.0	32.65	40	0.81825	0.00068	0.81961	_2_5_1	0.64950	0.00072	0.65094
_2_6_1	14,000	5,387	5,989	0.0	32.13	40	0.82408	0.00076	0.82560	_2_6_1	0.70486	0.00065	0.70616

Table 6.9.8.8-7a. Results for uranium silicide in the CV calculation models

Case 5cvcrpdusit11*	U_3Si_2 (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	variable	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5cvcrdpust11*	k_{eff}	σ	$k_{eff}+2\sigma$
From 4 to 14 kg sat U_3Si at 2 g/cm^3 at 40 wt % ^{235}U and 2 g/cm^3, 500 g poly in flooded CV Case cvcrdpus3sit11*, USL=0.93520										**Content dispersed in flooded CV Case cvcrdpu3sit11*, USL=0.93520**			
_2_1_15	4,000	1,539	1,711	7,658	169.77	40	0.72958	0.00060	0.73078	_2_1_15	0.77557	0.00088	0.77733
_2_2_15	6,000	2,309	2,567	6,660	111.57	40	0.76999	0.00068	0.77135	_2_2_15	0.80827	0.00070	0.80967
_2_3_15	8,000	3,078	3,422	5,662	82.47	40	0.79602	0.00070	0.79742	_2_3_15	0.82346	0.00075	0.82496
_2_4_15	10,000	3,848	4,278	4,664	65.01	40	0.81068	0.00078	0.81224	_2_4_15	0.83182	0.00071	0.83324
_2_5_15	12,000	4,618	5,134	3,665	53.37	40	0.82076	0.00072	0.82220	_2_5_15	0.83534	0.00082	0.83698
_2_6_15	14,000	5,387	5,989	2,667	45.05	40	0.82725	0.00075	0.82875	_2_6_15	0.83684	0.00078	0.83840
From 4 to 14 kg sat U_3Si at 2 g/cm^3 at 60 wt % ^{235}U and 2 g/cm^3, 500 g poly in dry CV Case cvcrdpus3sit11*, USL=0.93520										**Content dispersed in dry CV Case cvcrdpu3sit11*, USL=0.93520**			
_3_1_1	4,000	2,309	1,711	0.0	26.61	60	0.74198	0.00073	0.74344	_3_1_1	0.43196	0.00051	0.43298
_3_2_1	6,000	3,463	2,567	0.0	24.19	60	0.79224	0.00076	0.79376	_3_2_1	0.50003	0.00066	0.50135
_3_3_1	8,000	4,617	3,422	0.0	22.98	60	0.82138	0.00074	0.82286	_3_3_1	0.56328	0.00062	0.56452
_3_4_1	10,000	5,771	4,278	0.0	22.25	60	0.83772	0.00071	0.83914	_3_4_1	0.62387	0.00062	0.62511
_3_5_1	12,000	6,926	5,134	0.0	21.77	60	0.85049	0.00075	0.85199	_3_5_1	0.68150	0.00065	0.68280
_3_6_1	14,000	8,080	5,989	0.0	21.42	60	0.85761	0.00072	0.85905	_3_6_1	0.73666	0.00067	0.73800
From 4 to 14 kg sat U_3Si at 2 g/cm^3 at 60 wt % ^{235}U and 2 g/cm^3, 500 g poly in flooded CV Case cvcrdpus3sit11*, USL=0.93520										**Content dispersed in flooded CV Case cvcrdpu3sit11*, USL=0.93520**			
_3_1_15	4,000	2,309	1,711	7,658	113.20	60	0.75936	0.00073	0.76082	_3_1_15	0.82769	0.00082	0.82933
_3_2_15	6,000	3,463	2,567	6,660	74.39	60	0.80271	0.00074	0.80419	_3_2_15	0.84937	0.00071	0.85079
_3_3_15	8,000	4,617	3.422	5,662	54.99	60	0.82776	0.00086	0.82948	_3_3_15	0.86042	0.00091	0.86224
_3_4_15	10,000	5,771	4,278	4,664	43.34	60	0.84152	0.00081	0.84314	_3_4_15	0.86470	0.00073	0.86616
_3_5_15	12,000	6,926	5,134	3,665	35.58	60	0.85208	0.00068	0.85344	_3_5_15	0.86790	0.00097	0.86984
_3_6_15	14,000	8,080	5,989	2,667	30.04	60	0.85871	0.00075	0.86021	_3_6_15	0.86937	0.00074	0.87085

Table 6.9.8.8-7a. Results for uranium silicide in the CV calculation models

Case 5cvcrpdusit11*	U_3Si_2 (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	variable	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5cvcrdpust11*	k_{eff}	σ	$k_{eff}+2\sigma$
Parametric studies for 7 kg U_3Si_2 at 2 g/cm^3, 500 g poly in flooded CV Case cvcrpdusialt11*, USL=0.93520													
_7_1 (no Al)	7,000	6,484	2,956	6,161	14.487	100	0.87133	0.00096	0.87325				
_7_3 (1.0 kg Al)	7,000	6,484	2,956	6,161	14.487	100	0.84708	0.00077	0.84862				
_7_5 (2.0 kg Al)	7,000	6,484	2,956	6,161	14.487	100	0.82455	0.00090	0.82635				
_7_7 (3.0 kg Al)	7,000	6,484	2,956	6,161	14.487	100	0.80440	0.00093	0.80626				
_7_9 (4.0 kg Al)	7,000	6,484	2,956	6,161	14.487	100	0.78721	0.00079	0.78879				

Table 6.9.8.8-7b. Results for uranium silicide in the ES-3100 packaging calculation models

Case 5ncsrpdusit11*	U_3Si_2 (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	variable	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5ncsrdpust11*	k_{eff}	σ	$k_{eff}+2\sigma$
13 kg sat. U_3Si_2 and 500 g poly, density from 7 to 2 g/cm^3, flooded packaging										**Content dispersed in flooded CV**			
_8_7_13_15	13,000	12,041	856	7,801	20.16	7	0.76684	0.00127	0.76937	_8_7_13_15	0.82110	0.00168	0.82447
_8_6_13_15	13,000	12,041	1,165	7,492	20.16	6	0.77522	0.00120	0.77761	_8_6_13_15	0.82110	0.00168	0.82447
_8_5_13_15	13,000	12,041	1,597	7,059	20.16	5	0.78285	0.00135	0.78556	_8_5_13_15	0.82110	0.00168	0.82447
_8_4_13_15	13,000	12,041	2,246	6,410	20.16	4	0.79399	0.00181	0.79760	_8_4_13_15	0.82110	0.00168	0.82447
_8_3_13_15	13,000	12,041	3,327	5,329	20.16	3	0.80614	0.00139	0.80892	_8_3_13_15	0.82110	0.00168	0.82447
_8_2_13_15	13,000	12,041	5,490	3,166	20.16	2	0.81686	0.00139	0.81964	_8_2_13_15	0.82110	0.00168	0.82447

Table 6.9.8.8-7b. Results for uranium silicide in the ES-3100 packaging calculation models

Case 5ncsrpdusit11*	U_3Si_2 (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	variable	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5ncsrdpust11*	k_{eff}	σ	$k_{eff}+2\sigma$
From 13 to 7 kg sat. U_3Si_2 at 7 g/cm^3 and 500 g poly, flooded packaging										**Content dispersed in flooded CV**			
	13,000	12,041	856	7,801	20.16					_8_7_13_15	0.82110	0.00168	0.82447
	12,000	11,115	790	7,943	22.02					_8_7_12_15	0.81912	0.00152	0.82215
	11,000	10,189	724	8,086	24.22					_8_7_11_15	0.81836	0.00127	0.82089
	10,000	9,262	658	8,228	26.85					_8_7_10_15	0.81763	0.00161	0.82084
	9,000	8,336	592	8,371	30.08					_8_7_9_15	0.81283	0.00174	0.81632
	8,000	7,410	527	8,514	34.11					_8_7_8_15	0.81090	0.00166	0.81422
	7,000	6,484	461	8,656	39.29					_8_7_7_15	0.80563	0.00159	0.80881
13 kg sat. U_3Si_2 at 7 g/cm^3 and 500 g poly, 100% to 19.7 wt % ^{235}U, flooded packaging										**Content dispersed in flooded CV**			
_8_7_13_15	13,000	12,041	856	7,801	20.16	100	0.76684	0.00127	0.76937	_8_7_13_15	0.82110	0.00168	0.82447
_7_7_13_15	13,000	11,440	856	7,801	21.22	95	0.75001	0.00114	0.75229	_7_7_13_15	0.81010	0.00128	0.81266
_6_7_13_15	13,000	10,838	856	7,801	22.39	90	0.73588	0.00131	0.73851	_6_7_13_15	0.79989	0.00136	0.80261
_5_7_13_15	13,000	9,635	856	7,801	25.19	80	0.71293	0.00128	0.71548	_5_7_13_15	0.78850	0.00156	0.79162
_4_7_13_15	13,000	8,431	856	7,801	28.79	70	0.68734	0.00121	0.68976	_4_7_13_15	0.77146	0.00176	0.77498
_3_7_13_15	13,000	7,227	856	7,801	33.58	60	0.66250	0.00104	0.66458	_3_7_13_15	0.75908	0.00138	0.76185
_2_7_13_15	13,000	4,819	856	7,801	50.36	40	0.60190	0.00110	0.60410	_2_7_13_15	0.72556	0.00126	0.72807
_1_7_13_15	13,000	2,290	856	7,801	106.01	19.7	0.51868	0.00099	0.52066	_1_7_13_15	0.65956	0.00122	0.66199
7 kg sat. U_3Si_2 at 7 g/cm^3 and 500 g poly, 100 to 19.7 wt % ^{235}U, flooded packaging										**Content dispersed in flooded CV**			
	7,000	6,484	461	8,656	39.29	100				_8_7_7_15	0.80563	0.00159	0.80881
	7,000	6,160	461	8,656	41.35	95				_7_7_7_15	0.79796	0.00165	0.80127
	7,000	5,836	461	8,656	43.65	90				_6_7_7_15	0.79084	0.00143	0.79371
	7,000	5,188	461	8,656	49.10	80				_5_7_7_15	0.77879	0.00148	0.78175
	7,000	4,540	461	8,656	56.11	70				_4_7_7_15	0.76685	0.00132	0.76949
	7,000	3,892	461	8,656	65.46	60				_3_7_7_15	0.74828	0.00130	0.75087
	7,000	2,595	461	8,656	98.16	40				_2_7_7_15	0.71419	0.00146	0.71711
	7,000	1,233	461	8,656	206.62	19.7				_1_7_7_15	0.63031	0.00137	0.63304

Table 6.9.8.8-7b. Results for uranium silicide in the ES-3100 packaging calculation models

Case 5ncsrpdusit11*	U_3Si_2 (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	variable	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5ncsrdpust11*	k_{eff}	σ	$k_{eff}+2\sigma$
From 13 to 7 kg sat. U_3Si_2 at 19.7 wt % ^{235}U and 7 g/cm^3, and 500 g poly, flooded packaging										**Content dispersed in flooded CV**			
	13,000	2,290	856	7,801	106.01	19.7				_1_7_13_15	0.65956	0.00122	0.66199
	12,000	2,113	790	7,943	115.79	19.7				_1_7_12_15	0.65808	0.00126	0.66061
	11,000	1,937	724	8,086	127.35	19.7				_1_7_11_15	0.65479	0.00129	0.65737
	10,000	1,761	658	8,228	141.22	19.7				_1_7_10_15	0.65377	0.00130	0.65636
	9,000	1,585	592	8,371	158.18	19.7				_1_7_9_15	0.64727	0.00141	0.65010
	8,000	1,409	527	8,514	179.38	19.7				_1_7_8_15	0.64207	0.00122	0.64450
	7,000	1,233	461	8,656	206.62	19.7				_1_7_7_15	0.63031	0.00137	0.63304
From 4 to 14 kg sat U_3Si at 40 wt % ^{235}U and 2 g/cm^3, 500 g poly in dry CV Case ncsrdpus3sit11*, USL=0.93520										**Content dispersed in dry CV Case ncsrdpu3st11*, USL=0.93520**			
_2_1_1	4,000	1,539	1,711	0.0	39.91	40	0.61650	0.00071	0.61792	_2_1_1	0.20570	0.00040	0.20650
_2_2_1	6,000	2,309	2,567	0.0	36.28	40	0.66082	0.00069	0.66220	_2_2_1	0.27974	0.00056	0.28086
_2_3_1	8,000	3,078	3,422	0.0	34.46	40	0.68561	0.00084	0.68729	_2_3_1	0.35297	0.00051	0.35399
_2_4_1	10,000	3,848	4,278	0.0	33.38	40	0.69947	0.00066	0.70079	_2_4_1	0.42503	0.00058	0.42619
_2_5_1	12,000	4,618	5,134	0.0	32.65	40	0.70870	0.00091	0.71052	_2_5_1	0.49385	0.00062	0.49509
_2_6_1	14,000	5,387	5,989	0.0	32.13	40	0.71476	0.00072	0.71620	_2_6_1	0.56113	0.00071	0.56255
From 4 to 14 kg sat U_3Si at 2 g/cm^3 at 40 wt % ^{235}U and 2 g/cm^3, 500 g poly in flooded CV Case ncsrdpus3sit11*, USL=0.93520										**Content dispersed in flooded CV Case ncsrdpu3st11*, USL=0.93520**			
_2_1_15	4,000	1,539	1,711	7,658	169.77	40	0.63671	0.00078	0.63827	_2_1_15	0.68177	0.00073	0.68323
_2_2_15	6,000	2,309	2,567	6,660	111.57	40	0.67092	0.00080	0.67252	_2_2_15	0.70733	0.00072	0.70877
_2_3_15	8,000	3,078	3,422	5,662	82.47	40	0.69211	0.00079	0.69369	_2_3_15	0.72065	0.00075	0.72215
_2_4_15	10,000	3,848	4,278	4,664	65.01	40	0.70411	0.00066	0.70543	_2_4_15	0.72445	0.00084	0.72613
_2_5_15	12,000	4,618	5,134	3,665	53.37	40	0.71067	0.00071	0.71209	_2_5_15	0.72572	0.00075	0.72722
_2_6_15	14,000	5,387	5,989	2,667	45.05	40	0.71747	0.00082	0.71911	_2_6_15	0.72733	0.00081	0.72895

Table 6.9.8.8-7b. Results for uranium silicide in the ES-3100 packaging calculation models

Case 5ncsrpdusit11*	U_3Si_2 (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	variable	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5ncsrdpust11*	k_{eff}	σ	$k_{eff}+2\sigma$
From 4 to 14 kg sat U_3Si at 2 g/cm^3 at 60 wt % ^{235}U and 2 g/cm^3, 500 g poly in dry CV Case ncsrdpus3sit11*, USL=0.93520										**Content dispersed in dry CV Case ncsrdpu3st11*, USL=0.93520**			
_3_1_1	4,000	2,309	1,711	0.0	26.61	60	0.65002	0.00076	0.65154	_3_1_1	0.23011	0.00044	0.23099
_3_2_1	6,000	3,463	2,567	0.0	24.19	60	0.69228	0.00065	0.69358	_3_2_1	0.30768	0.00049	0.30866
_3_3_1	8,000	4,617	3,422	0.0	22.98	60	0.71810	0.00074	0.71958	_3_3_1	0.38188	0.00067	0.38322
_3_4_1	10,000	5,771	4,278	0.0	22.25	60	0.73341	0.00076	0.73493	_3_4_1	0.45680	0.00067	0.45814
_3_5_1	12,000	6,926	5,134	0.0	21.77	60	0.74413	0.00066	0.74545	_3_5_1	0.52780	0.00064	0.52908
_3_6_1	14,000	8,080	5,989	0.0	21.42	60	0.74933	0.00094	0.75121	_3_6_1	0.59602	0.00067	0.59736
From 4 to 14 kg sat U_3Si at 2 g/cm^3 at 60 wt % ^{235}U and 2 g/cm^3, 500 g poly in flooded CV Case ncsrdpus3sit11*, USL=0.93520										**Content dispersed in flooded CV Case ncsrdpu3st11*, USL=0.93520**			
_3_1_15	4,000	2,309	1,711	7,658	113.20	60	0.66835	0.00074	0.66983	_3_1_15	0.72750	0.00083	0.72916
_3_2_15	6,000	3,463	2,567	6,660	74.39	60	0.70477	0.00069	0.70615	_3_2_15	0.74549	0.00083	0.74715
_3_3_15	8,000	4,617	3,422	5,662	54.99	60	0.72560	0.00074	0.72708	_3_3_15	0.75389	0.00083	0.75555
_3_4_15	10,000	5,771	4,278	4,664	43.34	60	0.73695	0.00075	0.73845	_3_4_15	0.75652	0.00080	0.75812
_3_5_15	12,000	6,926	5,134	3,665	35.58	60	0.74521	0.00075	0.74671	_3_5_15	0.75880	0.00070	0.76020
_3_6_15	14,000	8,080	5,989	2,667	30.04	60	0.75083	0.00081	0.75245	_3_6_15	0.76087	0.00076	0.76239

Table 6.9.8.8-7c. Results for uranium silicide in infinite array packaging calculation models

Case 5nciapdusit11*	U_3Si_2 (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	variable	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5nciadpust11*	k_{eff}	σ	$k_{eff}+2\sigma$
13 kg sat. U_3Si_2 and 500 g poly, density from 7 to 2 g/cm^3, flooded CV, dry packaging										**Content dispersed in flooded CV**			
_8_7_13_3	13,000	12,041	856	7,801	20.16	7	0.82896	0.00118	0.83132	_8_7_13_3	1.03457	0.00130	1.03718
_8_6_13_3	13,000	12,041	1,165	7,492	20.16	6	0.84437	0.00109	0.84654	_8_6_13_3	1.03457	0.00130	1.03718

Table 6.9.8.8-7c. Results for uranium silicide in infinite array packaging calculation models

Case 5nciapdusit11*	U_3Si_2 (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	variable	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5nciadpust11*	k_{eff}	σ	$k_{eff}+2\sigma$
_8_5_13_3	13,000	12,041	1,597	7,059	20.16	5	0.86019	0.00124	0.86266	_8_5_13_3	1.03457	0.00130	1.03718
_8_4_13_3	13,000	12,041	2,246	6,410	20.16	4	0.88450	0.00126	0.88701	_8_4_13_3	1.03457	0.00130	1.03718
_8_3_13_3	13,000	12,041	3,327	5,329	20.16	3	0.91535	0.00125	0.91785	_8_3_13_3	1.03457	0.00130	1.03718
_8_2_13_3	13,000	12,041	5,490	3,166	20.16	2	0.96155	0.00120	0.96394	_8_2_13_3	1.03457	0.00130	1.03718
From 13 to 7 kg sat. U_3Si_2 at 2 g/cm^3 and 500 g poly, flooded CV, dry packaging										**Content dispersed in flooded CV**			
_8_2_13_3	13,000	12,041	5,490	3,166	20.16		0.96155	0.00120	0.96394	_8_7_13_3	1.03457	0.00130	1.03718
_8_2_12_3	12,000	11,115	5,068	3,665	22.02		0.94644	0.00133	0.94911	_8_7_12_3	1.03086	0.00130	1.03347
_8_2_11_3	11,000	10,189	4,646	4,164	24.22		0.93327	0.00127	0.93582	_8_7_11_3	1.03002	0.00144	1.03290
_8_2_10_3	10,000	9,262	4,223	4,663	26.85		0.91583	0.00134	0.91851	_8_7_10_3	1.02139	0.00141	1.02422
_8_2_9_3	9,000	8,336	3,801	5,163	30.08		0.90106	0.00154	0.90414	_8_7_9_3	1.01603	0.00133	1.01869
_8_2_8_3	8,000	7,410	3,379	5,662	34.11		0.87888	0.00127	0.88142	_8_7_8_3	1.00932	0.00134	1.01201
_8_2_7_3	7,000	6,484	2,956	6,161	39.29		0.86058	0.00128	0.86314	_8_7_7_3	1.00313	0.00155	1.00622
13 kg sat. U_3Si_2 at 7 g/cm^3 and 500 g poly in flooded CV, enrichment from 100 to 19.7 wt % ^{235}U										**Content dispersed in flooded CV**			
_8_2_13_3	13,000	12,041	5,490	3,166	20.16	100	0.96155	0.00120	0.96394	_8_7_13_3	1.03457	0.00130	1.03718
_7_2_13_3	13,000	11,440	5,490	3,166	21.22	95	0.94505	0.00185	0.94876	_7_7_13_3	1.01921	0.00142	1.02206
_6_2_13_3	13,000	10,838	5,490	3,166	22.39	90	0.93320	0.00114	0.93548	_6_7_13_3	1.00777	0.00148	1.01073
_5_2_13_3	13,000	9,635	5,490	3,166	25.19	80	0.91090	0.00142	0.91374	_5_7_13_3	0.98358	0.00113	0.98585
_4_2_13_3	13,000	8,431	5,490	3,166	28.79	70	0.89033	0.00116	0.89266	_4_7_13_3	0.96399	0.00144	0.96687
_3_2_13_3	13,000	7,227	5,490	3,166	33.58	60	0.86922	0.00140	0.87203	_3_7_13_3	0.94189	0.00119	0.94427
_2_2_13_3	13,000	4,819	5,490	3,166	50.36	40	0.81852	0.00119	0.82089	_2_7_13_3	0.88761	0.00140	0.89041
_1_2_13_3	13,000	2,290	5,490	3,166	106.01	19.7	0.73631	0.00133	0.73897	_1_7_13_3	0.79676	0.00126	0.79927
Sat. U_3Si_2 at 2 g/cm^3 and 500 g poly in flooded CV, enrichment from 60 to 19.7 wt % ^{235}U										**Content dispersed in flooded CV**			
_3_2_7_3	**7,000**	**3,892**	**2,956**	**6,161**	**65.46**	**60**	**0.77671**	**0.00138**	**0.77946**	**_3_7_7_3**	**0.91662**	**0.00139**	**0.91940**
_2_2_12_3	12,000	4,448	5,068	3,665	55.01	40	0.80799	0.00121	0.81040	_2_7_12_3	0.88898	0.00169	0.89237
_2_2_13_3	13,000	4,819	5,490	3,166	50.36	40	0.81852	0.00119	0.82089	_2_7_13_3	0.88761	0.00140	0.89041
_2_2_11_3	11,000	4,078	4,646	4,164	60.50	40	0.79496	0.00136	0.79768	_2_7_11_3	0.88471	0.00127	0.88725

Table 6.9.8.8-7c. Results for uranium silicide in infinite array packaging calculation models

Case 5nciapdusit11*	U_3Si_2 (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	variable	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5nciadpust11*	k_{eff}	σ	$k_{eff}+2\sigma$
2_2_10_3	10,000	3,707	4,223	4,663	67.09	40	0.77941	0.00193	0.78326	_2_7_10_3	0.88229	0.00129	0.88488
_2_2_9_3	9,000	3,336	3,801	5,163	75.15	40	0.76650	0.00132	0.76914	_2_7_9_3	0.87546	0.00124	0.87793
_2_2_8_3	8,000	2,966	3,379	5,662	85.22	40	0.75084	0.00119	0.75323	_2_7_8_3	0.87016	0.00146	0.87307
_2_2_7_3	7,000	2,595	2,956	6,161	98.16	40	0.73288	0.00134	0.73556	_2_7_7_3	0.86217	0.00131	0.86480
_1_2_13_3	13,000	2,290	5,490	3,166	106.01	19.7	0.73631	0.00133	0.73897	_1_7_13_3	0.79676	0.00126	0.79927
_1_2_12_3	12,000	2,113	5,068	3,665	115.79	19.7	0.72483	0.00112	0.72707	_1_7_12_3	0.79291	0.00125	0.79541
_1_2_11_3	11,000	1,937	4,646	4,164	127.35	19.7	0.71315	0.00131	0.71577	_1_7_11_3	0.78832	0.00135	0.79102
_1_2_10_3	10,000	1,761	4,223	4,663	141.22	19.7	0.69947	0.00113	0.70172	_1_7_10_3	0.78068	0.00149	0.78365
_1_2_9_3	9,000	1,585	3,801	5,163	158.18	19.7	0.68896	0.00163	0.69221	_1_7_9_3	0.77294	0.00120	0.77535
_1_2_8_3	8,000	1,409	3,379	5,662	179.38	19.7	0.67532	0.00117	0.67767	_1_7_8_3	0.76297	0.00117	0.76531
_1_2_7_3	7,000	1,233	2,956	6,161	206.62	19.7	0.65751	0.00119	0.65988	_1_7_7_3	0.75056	0.00113	0.75282
From 4 to 14 kg sat U_3Si at 40 wt % ^{235}U and 2 g/cm^3, 500 g poly in flooded CV Case nciadpus3sit11*, USL=0.93520										**Content dispersed in flooded CV Case nciadpu3st11*, USL=0.93680**			
_2_1_1	4,000	1,539	1,711	0.0	39.91	40	0.66401	0.00072	0.66545	_2_1_1	0.81976	0.00089	0.82154
_2_2_1	6,000	2,309	2,567	0.0	36.28	40	0.71831	0.00075	0.71981	_2_2_1	0.85990	0.00068	0.86126
_2_3_1	8,000	3,078	3,422	0.0	34.46	40	0.75687	0.00072	0.75831	_2_3_1	0.87961	0.00070	0.88101
_2_4_1	10,000	3,848	4,278	0.0	33.38	40	0.78908	0.00063	0.79034	_2_4_1	0.89044	0.00083	0.89210
_2_5_1	12,000	4,618	5,134	0.0	32.65	40	0.81654	0.00071	0.81796	_2_5_1	0.89816	0.00085	0.89986
_2_6_1	14,000	5,387	5,989	0.0	32.13	40	0.83749	0.00069	0.83887	_2_6_1	0.90111	0.00065	0.90241
_2_6_2	14,000	5,387	5,989	0.0	32.13	40	0.83785	0.00067	0.83919	_2_6_2	0.90272	0.00079	0.90430
_2_6_3	14,000	5,387	5,989	0.0	32.13	40	0.83717	0.00086	0.83889	_2_6_3	0.90159	0.00067	0.90293
_2_6_4	14,000	5,387	5,989	0.0	32.13	40	0.83611	0.00069	0.83749	_2_6_4	0.90004	0.00068	0.90140
_2_6_15	14,000	5,387	5,989	0.0	32.13	40	0.73475	0.00075	0.73625	_2_6_5	0.74690	0.00074	0.74838

Table 6.9.8.8-7c. Results for uranium silicide in infinite array packaging calculation models

Case 5nciapdusit11*	U_3Si_2 (g)	^{235}U (g)	Sat. H_2O (g)	CV H_2O (g)	h/x	variable	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5nciadpust11*	k_{eff}	σ	$k_{eff}+2\sigma$
From 4 to 14 kg sat U_3Si at 60 wt % ^{235}U and 2 g/cm^3, 500 g poly in flooded CV Case nciadpus3sit11*, USL=0.93520										**Content dispersed in flooded CV Case nciadpu3st11*, USL=0.93680**			
_3_1_1	4,000	2,309	1,711	7,658	113.20	60	0.70097	0.00066	0.70229				
_3_2_1	6,000	3,463	2,567	6,660	74.39	60	0.76123	0.00070	0.76263				
_3_3_1	8,000	4,617	3,422	5,662	54.99	60	0.80160	0.00076	0.80312	_3_3_1	0.93011	0.00070	0.93151
	8,500	4,906	3,636	5,412	51.56	60				_3_4_1	0.93432	0.00069	0.93570
	8,500	4,906	3,636	5,412	51.56	60				_3_4_2	0.93481	0.00073	0.93627
	8,500	4,906	3,636	5,412	51.56	60				_3_4_3	0.93315	0.00073	0.93461
	8,500	4,906	3,636	5,412	51.56	60				_3_4_4	0.93166	0.00081	0.93328
	8,500	4,906	3,636	5,412	51.56	60				_3_4_15	0.77463	0.00074	0.77611
	9,000	5,194	3,850	5,163	48.52	60				_3_5_1	0.93715	0.00070	0.93855
_3_4_1	10,000	5,771	4,278	4,664	43.34	60	0.83483	0.00063	0.83609				
_3_5_1	12,000	6,926	5,134	3,665	35.58	60	0.86266	0.00064	0.86394				
_3_6_1	14,000	8,080	5,989	2,667	30.04	60	0.88696	0.00075	0.88846				
_3_6_2	14,000	8,080	5,989	2,667	30.04	60	0.88777	0.00068	0.88913				
_3_6_3	14,000	8,080	5,989	2,667	30.04	60	0.86654	0.00079	0.86812				
_3_6_4	14,000	8,080	5,989	2,667	30.04	60	0.88559	0.00071	0.88701				
_3_6_15	14,000	8,080	5,989	2,667	30.04	60	0.76923	0.00075	0.77073				
Parametric studies for 7 kg U_3Si_2 at 2 g/cm^3, 500 g poly in flooded CV Case nciapdusialt11*, USL=0.93520													
_7_1 (no Al)	7,000	6,484	2,956	6,161	14.487	100	0.85659	0.00071	0.85801				
_7_3 (1.0 kg Al)	7,000	6,484	2,956	6,161	14.487	100	0.83233	0.00073	0.83379				
_7_5 (2.0 kg Al)	7,000	6,484	2,956	6,161	14.487	100	0.81208	0.00076	0.81360				
_7_7 (3.0 kg Al)	7,000	6,484	2,956	6,161	14.487	100	0.79420	0.00081	0.79582				
_7_9 (4.0 kg Al)	7,000	6,484	2,956	6,161	14.487	100	0.77960	0.00072	0.78104				

Appendix 6.9.9
Criticality Evaluation for Increasing the Fissile Loading Limit for HEU Oxide

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Appendix 6.9.9
Criticality Evaluation for Increasing the Fissile Loading Limit for HEU Oxide

This appendix presents the criticality safety evaluation for increasing the fissile loading limit for highly enriched uranium (HEU) oxide content in the ES-3100 package using SCALE5 as the criticality analysis tool. Calculations presented herein were performed using the Monte Carlo CSAS25 [Criticality Safety Analysis Sequence] code and 238-group ENDFB-V cross section library of SCALE 5.0 (NUREG/CR-0200, rev. 7), executed on identical Hewlett Packard (HP) Model zx6000 Itanium workstations (CMODC and CMODD). Criticality calculations documented in Sects. 6.4 – 6.6 were performed using SCALE 4.4a (NUREG/CR-0200, rev. 6) executed on an HP Model J5600 RISC workstation (CMODB). The obsolete CMODB with HP-UX 10.20 operating system was recently retired from service. No longer supported by the code developer, SCALE 4.4a is not portable to the new computing platforms, thus necessitating the use of SCALE 5.0.

SCALE5 incorporates minor improvements in the code modules for the Bondarenko and the Nordheim Integral Treatment processing of resonance cross sections and the KENO V.a module. Consequently, the upper subcritical limit (USL) used is validation dependent based on the SCALE-platform combination. The criticality evaluation based upon SCALE 5.0 calculations is documented in this appendix separate from the main body of Sect. 6 because this new work could not easily be folded into the existing SCALE 4.4a evaluation without inclusion of a patchwork of clarifications.

6.9.9.1 Description of the Criticality Design

The design features of the ES-3100 package addressed in Sect. 6.1.1 are not changed. The same codes and standards apply. No change is employed in the methodology addressed in Sect. 6.1.2 for demonstrating maximum reactivity. The shipping limit for an ES-3100 package with HEU product oxide content having a bulk density $\geq$2.0 g/cm^3 is increased from 9,682 g ^{235}U to 12,323 g ^{235}U by specifying a CSI = 0.4. The CSI is assigned as described in Sect. 6.1.3. This administrative limit restricts the size of an array of packages, maintaining subcriticality for both the Normal Conditions of Transport (NCT) and Hypothetical Accident Conditions (HAC).

6.9.9.2 HEU Oxide Content for the ES-3100 Package

The criticality safety evaluation documented in this appendix pertains to HEU product oxide as described in Sect. 6.2.1, and Appendices 6.9.1 and 6.9.3. The convenience cans described in Sect. 6.2.2 and the packing materials described in Sect. 6.2.3 are not affected by the new fissile loading limit. The packing content loading restrictions stated in Sect. 6.2.4 are unchanged.

6.9.9.3 General Considerations

General considerations expressed in Sect. 6.3 regarding both assumptions made about the ES-3100 packaging and the calculation methodology for the evaluation are maintained. No changes are required to the calculation models of the containment vessel (CV), the single-unit packaging (Sect. 6.3.1.1), the infinite array and finite array packaging (Sect. 6.3.1.2), the damaged packaging (Sect. 6.3.1.3), or the catastrophically-damaged packaging (Sect. 6.3.1.4). The material properties specification for the HEU product oxide (Sect. 6.3.2) does not change.

6.9.9.4 Computer Codes and Cross-Section Libraries

Calculations presented in this appendix were performed using the Monte Carlo CSAS25 code and 238-group ENDFB-V cross section library of SCALE 5.0 (NUREG/CR-0200, rev. 7), executed on identical Hewlett Packard (HP) Model zx6000 Itanium workstations (CMODC and CMODD) of the Y-12 Safety

Analysis Engineering organization in Oak Ridge, Tennessee. Criticality calculations documented in Sects. 6.4–6.6 were performed using SCALE 4.4a (NUREG/CR-0200, rev. 6) executed on an HP Model J5600 RISC workstation (CMODB). The obsolete CMODB with HP-UX 10.20 operating system was recently retired from service. No longer supported by the code developer, SCALE 4.4a is not portable to the new computing platforms, thus necessitating the use of SCALE 5.0.

The SCALE 4.4a criticality codes and cross-section library are addressed in Sect. 6.3.3. The 238-group ENDF/B-V cross-section library used by SCALE 5.0 is unchanged from the previous version SCALE 4.4a. Also, most of the modular codes in CSAS25 control sequence of SCALE 5.0 are unchanged except for the cross-section processing functional module NITAWL-III.

NITAWL-III applies the Nordheim integral treatment to perform neutron cross-section processing in the resonance energy range for nuclides that have ENDF/B resonance parameter data. This technique involves the numerical integration of ENDF/B resonance parameters using a calculated flux distribution, which is based on the calculated collision density across each resonance and subsequent weighing of the reaction cross section to the desired broad group structure. In the CSAS code, NITAWL-III assembles the group-to-group transfer arrays from the elastic and inelastic scattering components and performs other tasks to produce a problem-dependent working cross-section library which can be used by KENO V.a.

As noted in the user manual, several extensions to the Nordheim calculation have been implemented into the algorithm contained in NITAWL-III:

- Elements containing more than one isotope can be treated.
- Self-shielding is applied to resonance scattering. Transfer matrices are adjusted.
- g-, f-, d-, and p-wave as well as s-wave levels can be treated.
- The asymptotic approximation for the flux in the thermal energy range is assumed to have a Maxwellian energy distribution.
- A refined procedure for generating the energy mesh over which reaction rates are integrated has been developed.

As with the SCALE 4.4a calculations, the k_{eff} values for each KENO V.a case are based on 500,000 neutron histories produced by running for 215 generations with 2,500 neutrons per generation and truncating the first 15 generations of data. The convergence of the KENO V.a calculation is related to trends in the average calculated k_{eff}. In general, the KENO V.a output table of k_{eff} by generation skipped is reviewed for trends. If no trends are observed, the calculation is accepted, and the reported value of k_{eff} is the one with the most neutron histories. There is usually no statistically significant difference between this result and the one with the smallest standard deviation.

No manual cross-section adjustment is performed for the criticality evaluation. Cross-section processing is performed automatically in the CSAS25 code. Modeling the contents as precisely as possible improves the accuracy of cross-section processing.

The CSAS25 control module, the associated functional modules, the cross section library, and databases used in this evaluation reside in the verified configuration control area designated **/vcc/scale5** on CMODC and CMODD. Also, the computer input and output files for the criticality safety evaluation of the ES-3100 shipping package with the additional/new content reside in a configuration control area **/archive/ylf717_Rev3PC1** on CMODC.

6.9.9.5 Single Package Evaluation (NCT and HAC)

The analysis presented in Sect. 6.4 demonstrates that $k_{eff} + 2\sigma$ increases with increasing MOIFR. Therefore, a model of a fully flooded, reflected package is used to calculate neutron multiplication factors for the single package analysis. The reference analysis reveals that a continuous decrease in $k_{eff} + 2\sigma$ occurs with decreasing fissile mass when density is held constant. Also, $k_{eff} + 2\sigma$ increases as the bulk density decreases for a fixed fissile mass, which is due to the increased moderation of the HEU oxide.

Cases **5ncsrpdoxt11_1_*n*_14** (Table 6.9.9.8-2) represents the NCT model of an ES-3100 package with 14 kg of HEU oxide (12,323 g ^{235}U). The parameter "***n***" ranging from 1 to 5, signifies oxide density values of 2.0, 3.0, 4.0, 5.0, and 6.54 g/cm^3, respectively. The $k_{eff} + 2\sigma$ values ranging from 0.810 to 0.752 are well below the USL value of 0.924.

Case **5cvcrpdoxt11_1_1_14_15)** (Table 6.9.9.8-1) models a reflected CV with 14 kg of HEU oxide at 2.0 g/cm^3. The $k_{eff} + 2\sigma$ value is ~0.1 greater in the reflected CV than in the corresponding reflected, flooded single package (Case **5cvcrpdoxt11_1_1_14_15)**. This result is consistent with the reference evaluation of Sect. 6.4.

Cases **5hcsrpdoxt12_1_*n*_14** (Table 6.9.9.8-2) represents the HAC model of the damaged ES-3100 package, where the outer dimensions of the package are reduced accordingly and the entire package is flooded except the neutron poison of the body weldment liner inner cavity. The $k_{eff} + 2\sigma$ values range from 0.811 to 0.757. The changes in both the outer dimensions of the package and the compositions of the Kaolite and 277-4 due to HAC result in a ≤0.004 change in the neutron multiplication factor, also consistent with the reference evaluation of Sect. 6.4.

6.9.9.6 Array Package Evaluation (NCT and HAC)

The infinite array analyses presented in Sects. 6.5 and 6.6 demonstrate that the CSI is 0.0 for ES-3100 packages having product oxide content with a bulk density ≥2.0 g/cm^3 and with a maximum of 9,682 g ^{235}U. Case result presented in Table 6.9.9.8-3 substantiate this conclusion.

The array analyses presented in Sects. 6.5 and 6.6 also demonstrate maximum reactivity occurs in an array of packages when both the CV is flooded (MOCFR = 1.0) and the ES-3100 packaging is dry (MOIFR = 1e-04). A water fraction of MOIFR = 1e-04 pertains specifically to NCT or HAC packages where both the neutron poison of the body weldment liner inner cavity and the Kaolite are dry and both the recesses of the package external to the CV and the interstitial space between drums of the array do not contain any residual moisture. Therefore, the ES-3100 package model consisting of dry packaging and flooded CV is used for the finite array package analysis as required for establishing a non-zero CSI value.

Cases **5ncf1pdoxt11_1_*n*_15_3** through **5ncf1pdoxt11_1_*n*_11_3** (Table 6.9.9.8-4) represent a 13 × 13 × 6 array of NCT packages. The content mass ranges from 15 kg of HEU oxide (13,203 g ^{235}U) to 11 kg of HEU oxide (9,682 g ^{235}U). Case parameter "***n***" ranging from 1 to 5, signifies oxide density values of 2.0, 3.0, 4.0, 5.0, and 6.54 g/cm^3, respectively. Likewise, Cases **5hcf2pdoxt12_1_*n*_15_3** through **5hcf2pdoxt12_1_*n*_11_3** (Table 6.9.9.8-4) represent a 9 × 9 × 4 array of HAC packages. These finite array configurations support the assignment of a CSI = 0.4. (Cases **5ncf1pdoxt11_1_1_15_3** and **5hcf2pdoxt12_1_1_15_3** are not evaluated because the capacity of the convenience cans is exceeded for the 15 kg oxide loading at a density of 2.0 g/cm^3.)

As expected, the neutron multiplication factor for the finite array configurations of ES-3100 packages with HEU product oxide decreases as a function of decreasing ^{235}U mass. Also, calculation results for the parametric cases reveal the same continuous increase in the $k_{eff} + 2\sigma$ values with decreasing bulk density as observed in both the single package calculation results (Sect. 6.4.3) and infinite array calculation results (Table 6.9.9.8-4). Given that the $k_{eff} + 2\sigma$ values are below the USL of 0.924, ES-3100

packages may be shipped under a CSI = 0.4 for ES-3100 packages having HEU product oxide content with a bulk density ≥2.0 g/cm^3 and with a maximum of 12,323 g ^{235}U.

6.9.9.7 Benchmark experiments and the criticality

The criticality validation for SCALE 5.0 is a repetition of the SCALE 4.4a validation based on benchmark experiments documented in the Organization for Economic Cooperation and Development (OECD) Handbook. [NEA/NSC/DOC(95)03] Validation cases for SCALE 4.4a were executed on an HP Model J5600 RISC workstation under the HP-UX 10.20 operating system. For SCALE 5.0, these same validation cases were executed on an HP Model zx6000 Itanium workstation (CMODC).

The validation of CSAS25 control module of SCALE 5.0 with the 238-group ENDF/B-V cross-section library is documented in Y/DD-1220 and Y/DD-1221. Like Y/DD-896/R1, Y/DD-1220 addresses the establishment of bias, bias trends, and uncertainty associated with the use of SCALE 5.0 for performance of criticality calculations. Like Y/DD-972R1, Y/DD-1221 addresses determining USL and for incorporating uncertainty and margin into this USL.

SCALE 5.0 incorporates minor improvements in the code modules for the Bondarenko and the Nordheim Integral Treatment processing of resonance cross sections and the KENO V.a module. Consequently, the USL used is validation dependent based on the SCALE-platform combination. The evaluation of additional/new contents based upon SCALE 5.0 calculations is documented in this appendix separate from the main body of Chap. 6 because this new work could not easily be folded into the existing SCALE 4.4a evaluation without inclusion of a patchwork of clarifications.

The USL is based on the non-parametric statistics-based lower tolerance limit (LTL) for greater than 0.99/99% where there is a probability of greater than 0.99 that 99% of the population is greater than a specified result, reduced by additional margin. From Table 1 of Y/DD-1221, the LTL combining bias and bias uncertainty is 0.974 for uranium systems, including HEU metal. Tables 4.2, 4.3, and 4.4 of Y/DD-1220 list the maximum (positive) and minimum (negative) biases for HEU (metal, compound, solution), IEU (metal, compound) and LEU (compound, solution) systems. Since the positive bias is conservatively treated as a "zero" bias in the validation analysis, the negative bias is applied to determine the USL for the systems. The minimum bias given for HEU, IEU, and LEU systems is −0.0230, −0.0055 and −0.0260, respectively.

The minimum bias given for HEU systems in Table 4.2 of Y/DD-1220 is -0.1423. However, this result is from one of the four k-infinite models which are somewhat different than the usual benchmark experiments. As discussed in Sect. 5.3 of Y/DD-1220, the four outlier results are for benchmark experiments that were modeled as infinite in extent, thereby amplifying the effects of imperfections in cross section data. The models also required additional interpretation and adjustment from the actual finite experimental configuration to create an infinite benchmark model. After eliminating outlier models from the bias determination, the minimum bias was determined to be -0.023 for HEU systems.

The global minimum bias results for these systems (−0.0260) is applied to all uranium enrichments. Ordinarily, the USL would be 0.954 where an additional margin of subcriticality of 0.02 is subtracted from the LTL of 0.974. However, NUREG/CR-5661 provides guidance that the USL should be established with a minimum margin of subcriticality of 0.05. Thus, the USL is equal to 0.95 plus the minimum bias (−0.026), giving a value of 0.924.

6.9.9.8 Calculation results tables for additional/new contents

Tables 6.9.9.8-1 through 6.9.9.8-4 contain a summary of the calculation results for the additional/new contents to be shipped in the ES-3100 shipping package.

Table 6.9.9.8-1. Results for HEU oxide content in the containment vessel calculation model

Case 5cvcrpdoxt11*	Oxide (g)	^{235}U (g)	Oxide density (g/cm^3)	Oxide volume (cm^3)	Sat. H_2O (g)	CV H_2O (g)	h/x	MOCFR	k_{eff}	σ	$k_{eff}+2\sigma$
14,000 g UO_2 content, 500-g polyethylene, flooded containment vessel, reflected											
_1_1_14_15	14000	12323	2.00	7000	5712	2667	19.11	1.0E+00	0.91213	0.00154	0.91521

Table 6.9.9.8-2. Results for HEU oxide content in single-unit packaging calculation model

Case 5ncsrpdoxt11*	Oxide (g)	^{235}U (g)	Oxide density (g/cm^3)	Oxide volume (cm^3)	Sat. H_2O (g)	CV H_2O (g)	h/x	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5hcsrpdoxt12*	k_{eff}	σ	$k_{eff}+2\sigma$
UO2, content and 500-g polyethylene in flooded containment vessel, flooded package														
				NCT								**HAC**		
_1_1_14	14000	12323	2.00	7000	5712	2667	19.11	0.80682	0.00154	0.80990	_1_1_14	0.80844	0.00132	0.81108
_1_2_14	14000	12323	3.00	4667	3383	4996	19.11	0.79264	0.00147	0.79557	_1_2_14	0.79564	0.00161	0.79887
_1_3_14	14000	12323	4.00	3500	2219	6161	19.11	0.78217	0.00138	0.78493	_1_3_14	0.78181	0.00127	0.78436
_1_4_14	14000	12323	5.00	2800	1520	6860	19.11	0.76784	0.00125	0.77035	_1_4_14	0.77058	0.00119	0.77296
_1_5_14	14000	12323	6.54	2141	862	7518	19.11	0.74948	0.00136	0.75219	_1_5_14	0.75379	0.00136	0.75651

Table 6.9.9.8-3. Results for HEU oxide content in array packaging calculation model

Case 5nciapdoxt11*	Oxide (g)	^{235}U (g)	Oxide density (g/cm^3)	Oxide volume (cm^3)	Sat. H_2O (g)	CV H_2O (g)	h/x	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5hciapdoxt12*	k_{eff}	σ	$k_{eff}+2\sigma$
UO_2 content and 500 g polyethylene in flooded containment vessel, infinite array packaging model for CSI=0.0														
				NCT									**HAC**	
_1_2_15_3	15000	13203	3.00	5000	3625	4664	17.66	0.91962	0.00120	0.92202	_1_2_15_3	0.92011	0.00143	0.92298
_1_3_15_3	15000	13203	4.00	3750	2377	5911	17.66	0.88779	0.00122	0.89023	_1_3_15_3	0.88737	0.00177	0.89092
_1_4_15_3	15000	13203	5.00	3000	1628	6660	17.66	0.86134	0.00122	0.86377	_1_4_15_3	0.86151	0.00139	0.86429
_1_5_15_3	15000	13203	6.54	2294	923	7365	17.66	0.83226	0.00105	0.83436	_1_5_15_3	0.83147	0.00128	0.83404
_1_1_14_3	14000	12323	2.00	7000	5712	2667	19.11	0.96251	0.00139	0.96530	_1_1_14_3	0.96173	0.00120	0.96413
_1_2_14_3	14000	12323	3.00	4667	3383	4996	19.11	0.90999	0.00125	0.91250	_1_2_14_3	0.91039	0.00133	0.91306
_1_3_14_3	14000	12323	4.00	3500	2219	6161	19.11	0.87432	0.00136	0.87704	_1_3_14_3	0.87390	0.00123	0.87636
_1_4_14_3	14000	12323	5.00	2800	1520	6860	19.11	0.84766	0.00107	0.84981	_1_4_14_3	0.85075	0.00157	0.85390
_1_5_14_3	14000	12323	6.54	2141	862	7518	19.11	0.82262	0.00114	0.82489	_1_5_14_3	0.81885	0.00117	0.82120
_1_1_13_3	13000	11443	2.00	6500	5304	3166	20.79	0.95083	0.00137	0.95356	_1_1_13_3	0.94754	0.00124	0.95002
_1_2_13_3	13000	11443	3.00	4333	3142	5329	20.79	0.89635	0.00119	0.89874	_1_2_13_3	0.89884	0.00238	0.90360
_1_3_13_3	13000	11443	4.00	3250	2060	6410	20.79	0.86131	0.00115	0.86362	_1_3_13_3	0.86176	0.00134	0.86443
_1_4_13_3	13000	11443	5.00	2600	1411	7059	20.79	0.83841	0.00119	0.84080	_1_4_13_3	0.83735	0.00179	0.84093
_1_5_13_3	13000	11443	6.54	1988	800	7670	20.79	0.80709	0.00129	0.80967	_1_5_13_3	0.81006	0.00147	0.81301
_1_1_12_3	12000	10562	2.00	6000	4896	3665	22.74	0.93557	0.00146	0.93849	_1_1_12_3	0.93442	0.00130	0.93701
_1_2_12_3	12000	10562	3.00	4000	2900	5662	22.74	0.88421	0.00123	0.88667	_1_2_12_3	0.88382	0.00127	0.88637
_1_3_12_3	12000	10562	4.00	3000	1902	6660	22.74	0.84986	0.00136	0.85259	_1_3_12_3	0.84962	0.00123	0.85208
_1_4_12_3	12000	10562	5.00	2400	1303	7259	22.74	0.82606	0.00117	0.82839	_1_4_12_3	0.82224	0.00116	0.82456
_1_5_12_3	12000	10562	6.54	1835	739	7823	22.74	0.79269	0.00117	0.79503	_1_5_12_3	0.79562	0.00120	0.79802
_1_1_11_3	11000	9682	2.00	5500	4488	4164	25.06	0.91920	0.00170	0.92260	_1_1_11_3	0.91961	0.00132	0.92224
_1_2_11_3	11000	9682	3.00	3667	2658	5994	25.06	0.86941	0.00134	0.87208	_1_2_11_3	0.87089	0.00131	0.87352
_1_3_11_3	11000	9682	4.00	2750	1743	6909	25.06	0.83680	0.00152	0.83984	_1_3_11_3	0.83444	0.00132	0.83707
_1_4_11_3	11000	9682	5.00	2200	1194	7458	25.06	0.81122	0.00126	0.81373	_1_4_11_3	0.81127	0.00110	0.81346
_1_5_11_3	11000	9682	6.54	1682	677	7976	25.06	0.78014	0.00137	0.78288	_1_5_11_3	0.78034	0.00131	0.78296

Table 6.9.9.8-4. Results for finite array analysis of HEU oxide content in the array packaging calculation model

Case 5ncf1pdoxt11*	Oxide (g)	^{235}U (g)	Oxide density (g/cm^3)	Oxide volume (cm^3)	Sat. H_2O (g)	CV H_2O (g)	h/x	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5hcf2pdoxt12*	k_{eff}	σ	$k_{eff}+2\sigma$
UO_2 content and 500 g polyethylene in flooded containment vessel, finite array packaging model for CSI=0.4														
				NCT								**HAC**		
_1_2_15_3	15000	13203	3.00	5000	3625	4664	17.66	0.86899	0.00119	0.87137	_1_2_15_3	0.85996	0.00128	0.86251
_1_3_15_3	15000	13203	4.00	3750	2377	5911	17.66	0.83024	0.00127	0.83278	_1_3_15_3	0.82926	0.00123	0.83173
_1_4_15_3	15000	13203	5.00	3000	1628	6660	17.66	0.80781	0.00148	0.81077	_1_4_15_3	0.80377	0.00145	0.80667
_1_5_15_3	15000	13203	6.54	2294	923	7365	17.66	0.78101	0.00137	0.78375	_1_5_15_3	0.77553	0.00145	0.77843
_1_1_14_3	14000	12323	2.00	7000	5712	2667	19.11	0.91235	0.00152	0.91539	_1_1_14_3	0.90222	0.00126	0.90473
_1_2_14_3	14000	12323	3.00	4667	3383	4996	19.11	0.85665	0.00130	0.85925	_1_2_14_3	0.85184	0.00187	0.85558
_1_3_14_3	14000	12323	4.00	3500	2219	6161	19.11	0.81979	0.00150	0.82279	_1_3_14_3	0.81814	0.00164	0.82143
_1_4_14_3	14000	12323	5.00	2800	1520	6860	19.11	0.79749	0.00139	0.80027	_1_4_14_3	0.79489	0.00132	0.79752
_1_5_14_3	14000	12323	6.54	2141	862	7518	19.11	0.76730	0.00112	0.76954	_1_5_14_3	0.76607	0.0012	0.76848
_1_1_13_3	13000	11443	2.00	6500	5304	3166	20.79	0.90096	0.00137	0.90369	_1_1_13_3	0.89146	0.00168	0.89482
_1_2_13_3	13000	11443	3.00	4333	3142	5329	20.79	0.84451	0.00150	0.84750	_1_2_13_3	0.83795	0.00125	0.84046
_1_3_13_3	13000	11443	4.00	3250	2060	6410	20.79	0.80806	0.00175	0.81156	_1_3_13_3	0.80364	0.0014	0.80643
_1_4_13_3	13000	11443	5.00	2600	1411	7059	20.79	0.78428	0.00120	0.78668	_1_4_13_3	0.78119	0.0013	0.78379
_1_5_13_3	13000	11443	6.54	1988	800	7670	20.79	0.75713	0.00132	0.75977	_1_5_13_3	0.75345	0.00134	0.75612
_1_1_12_3	12000	10562	2.00	6000	4896	3665	22.74	0.88673	0.00148	0.88969	_1_1_12_3	0.87895	0.00133	0.8816
_1_2_12_3	12000	10562	3.00	4000	2900	5662	22.74	0.83038	0.00129	0.83296	_1_2_12_3	0.82545	0.00137	0.82819
_1_3_12_3	12000	10562	4.00	3000	1902	6660	22.74	0.79879	0.00148	0.80175	_1_3_12_3	0.79221	0.00133	0.79487
_1_4_12_3	12000	10562	5.00	2400	1303	7259	22.74	0.77086	0.00131	0.77349	_1_4_12_3	0.77013	0.00151	0.77316
_1_5_12_3	12000	10562	6.54	1835	739	7823	22.74	0.74245	0.00181	0.74608	_1_5_12_3	0.74028	0.00127	0.74282

Table 6.9.9.8-4. Results for finite array analysis of HEU oxide content in the array packaging calculation model

Case 5ncf1pdoxt11*	Oxide (g)	^{235}U (g)	Oxide density (g/cm^3)	Oxide volume (cm^3)	Sat. H_2O (g)	CV H_2O (g)	h/x	k_{eff}	σ	$k_{eff}+2\sigma$	Case 5hcf2pdoxt12*	k_{eff}	σ	$k_{eff}+2\sigma$
_1_1_11_3	11000	9682	2.00	5500	4488	4164	25.06	0.87072	0.00152	0.87376	_1_1_11_3	0.86583	0.00113	0.86809
_1_2_11_3	11000	9682	3.00	3667	2658	5994	25.06	0.81756	0.00176	0.82108	_1_2_11_3	0.81406	0.00155	0.81715
_1_3_11_3	11000	9682	4.00	2750	1743	6909	25.06	0.78439	0.00122	0.78682	_1_3_11_3	0.77978	0.0015	0.78279
_1_4_11_3	11000	9682	5.00	2200	1194	7458	25.06	0.75752	0.00159	0.76070	_1_4_11_3	0.75642	0.00115	0.75872
_1_5_11_3	11000	9682	6.54	1682	677	7976	25.06	0.72893	0.00156	0.73205	_1_5_11_3	0.72536	0.00168	0.72871

6.9.9.9 Input Listing for Select SCALE 5.0 Cases

Select input files for calculations identified in Tables 6.9.9.8-1 through 6.9.9.8-4 are presented below.

6.9.9.9.1 Case 5cvcrpdoxt11_1_1_14_15

```
=csas25    parm=size=3000000
5cvcrpdoxt11,14000.1gUO2 (12322.9g235)5712.4gSH2O 2667.0gH2Ocv hx= 19.11 fr=1
238groupndf5 infhommedium
'HEU volume =7000.05000 HEU oxide, bulk density of oxide in cans=  2.00000 g/cm3'
'oxide= 14000.1 g, sat.h2o in HEU oxide=5712.4 g, oxide h/x=12.10'
'poly (packed or wrapped) dry content h/x=1.36, CV void volume 2671.83368'
arbmuox    1.85591   2 0 0 0  92235   88.0203
                              8016   11.9797    1  1.0000  293  end
arbmastm  7.5725e-01  2 0 0 0  1001   11.1913
                              8016   88.8087    1  1.0000  293  end
arbmpoly  6.6282e-02  2 0 0 0  1001   14.3798
                              6012   85.6202    1  1.0000  293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  9.9820e-01  2 0 0 0   1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                          8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                          9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                         10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.31846e4 cm3 = (8.0457422e2 in3)(16.387064)'
'den.multiplier = 1.31846e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.518047 = (den.mult)(np277-4 min.den.) = 0.9935052*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.26267e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.06375e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
```

```
                              20000   11.8336
                              26000    0.5298   11  1.0000  293  end
arbmnph2o 3.81674e-1  2 0 0 0    1001   11.1913
                               8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                               8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
```

```
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                          18  1.25705 293  end
'steel: drum steel for single units'
ss304                                          19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                          19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                               8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
5cvcrpdoxt11,14000.1gUO2 (12322.9g235)5712.4gSH2O 2667.0gH2Ocv,hx= 19.11 fr=1
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                         end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.270 in.]'
 cylinder  3  1    6.426200   77.72400  58.78051 com='cavity abv HEU'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cuboid    21 1 4p24.587200   77.72400   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
```

```
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.9.9.2 Case 5ncsrpdoxt11_1_1_14

```
=csas25    parm=size=3000000
5ncsrpdoxt11,14000.1gUO2 (12322.9g235)5712.4gSH2O 2667.0gH2Ocv hx= 19.11 fr=1
238groupndf5 infhommedium
'HEU volume =7000.05000 HEU oxide, bulk density of oxide in cans=  2.00000 g/cm3'
'oxide= 14000.1 g, sat.h2o in HEU oxide=5712.4 g, oxide h/x=12.10'
'poly (packed or wrapped) dry content h/x=1.36, CV void volume 2671.83368'
arbmuox    1.85591   2 0 0 0  92235   88.0203
                              8016   11.9797    1  1.0000  293  end
arbmastm  7.5725e-01  2 0 0 0  1001   11.1913
                              8016   88.8087    1  1.0000  293  end
arbmpoly  6.6282e-02  2 0 0 0  1001   14.3798
                              6012   85.6202    1  1.0000  293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
```

```
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  9.9820e-01  2 0 0 0   1001   11.1913
                                8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
arbmh2ok   0.52294  2 0 0 0    1001   11.1913
                                8016   88.8087   12  1       293  end
arbmal2o3  0.34864  2 0 0 0   13027   52.9390
                                8016   47.0610   12  0.096   293  end
arbmsio2   0.34864  2 0 0 0   14000   46.7570
                                8016   53.2430   12  0.367   293  end
arbmfe2o3  0.34864  2 0 0 0   26000   69.9540
                                8016   30.0460   12  0.067   293  end
arbmtio2   0.34864  2 0 0 0   22000   59.9535
                                8016   40.0465   12  0.012   293  end
arbmcao    0.34864  2 0 0 0   20000   71.4815
                                8016   28.5185   12  0.307   293  end
arbmmgo    0.34864  2 0 0 0   12000   60.3169
                                8016   39.6831   12  0.131   293  end
arbmna2o   0.34864  2 0 0 0   11023   74.1961
                                8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
```

```
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  1       293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
'ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
'ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
'arbmwed    1.16026  2 0 0 0    1001   11.1913
'                              8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   21  1.0     293  end
end comp
5ncsrpdoxt11,14000.1gUO2 (12322.9g235)5712.4gSH2O 2667.0gH2Ocv,hx= 19.11 fr=1
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                       end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   24.587200    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   23.329900    0.26670   0.0     com='drum bottom flat cover'
 cuboid    21 1 4p24.587200    0.26670   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
```

```
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   23.177500   11.59510   0.0     com='kaolite'
 cylinder  19 1   23.329900   11.59510   0.0     com='drum'
 cuboid    21 1 4p24.587200   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.270 in.]'
 cylinder  3  1    6.426200   77.72400  58.78051 com='cavity abv HEU'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cylinder  15 1    7.924800   77.72400   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   77.72400   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   77.72400   0.0     com='np277_4'
 cylinder  16 1   11.074400   77.72400   0.0     com='kaolite liner'
 cylinder  12 1   23.177500   77.72400   0.0     com='kaolite'
 cylinder  19 1   23.329900   77.72400   0.0     com='drum'
 cuboid    21 1 4p24.587200   77.72400   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   23.177500    0.22860   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.22860   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   23.177500    1.27000   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.27000   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   23.177500    2.92100   0.0     com='kaolite'
 cylinder  19 1   23.329900    2.92100   0.0     com='drum'
 cuboid    21 1 4p24.587200    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
```

```
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   23.177500    1.01600   0.0     com='kaolite'
 cylinder  19 1   23.329900    1.01600   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   23.177500    0.15240   0.0     com='kaolite'
 cylinder  19 1   23.329900    0.15240   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   23.177500    8.17880   0.0     com='kaolite'
 cylinder  19 1   23.329900    8.17880   0.0     com='drum'
 cuboid    21 1 4p24.587200    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   23.177500    4.44500   0.0     com='kaolite'
 cylinder  19 1   23.329900    4.44500   0.0     com='drum'
 cuboid    21 1 4p24.587200    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   23.177500    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   23.329900    0.63500   0.0     com='drum'
 cuboid    21 1 4p24.587200    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  21 1   22.961600    1.90500   0.15240 com='void above lid'
 cylinder  19 1   23.114000    1.90500   0.0     com='drum lid'
 cylinder  21 1   23.177500    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   23.329900    1.90500   0.0     com='drum'
 cuboid    21 1 4p24.587200    1.90500   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-24.587200     0.0
'cuboid     0  1 4p24.587200    110.4905  0.0    com='bare package'
 cuboid    21  1 4p55.067200   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
```

```
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.9.9.3 Case 5hcsrpdoxt12_1_1_14

```
=csas25    parm=size=3000000
5hcsrpdoxt12,14000.1gUO2 (12322.9g235)5712.4gSH2O 2667.0gH2Ocv hx= 19.11 fr=1
238groupndf5 infhommedium
'HEU volume =7000.05000 HEU oxide, bulk density of oxide in cans=  2.00000 g/cm3'
'oxide= 14000.1 g, sat.h2o in HEU oxide=5712.4 g, oxide h/x=12.10'
'poly (packed or wrapped) dry content h/x=1.36, CV void volume 2671.83368'
arbmuox    1.85591   2 0 0 0  92235   88.0203
                              8016   11.9797    1  1.0000  293  end
arbmastm  7.5725e-01  2 0 0 0  1001   11.1913
                              8016   88.8087    1  1.0000  293  end
arbmpoly  6.6282e-02  2 0 0 0  1001   14.3798
                              6012   85.6202    1  1.0000  293  end
'np277-4: spacer (HAC_MD&H)'
'HAC min.den.(95.3157 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07071e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.82995e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  9.9820e-01  2 0 0 0   1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (HAC_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.476265 = (den.mult)(np277-4 min.den.) = 0.9668933*1.526803'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
```

```
                                8016   43.4254
                               11023    0.1174
                               12000    0.3378
                               13027   39.0477
                               14000    2.4671
                               16000    0.3083
                               20000   11.8335
                               26000    0.5298   11  1.0000  293  end
arbmnph2o 3.70316e-1  2 0 0 0    1001   11.1913
                                8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                                8016   88.8087   12  1       293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                                8016   47.0610   12  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                                8016   53.2430   12  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                                8016   30.0460   12  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                                8016   40.0465   12  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                                8016   28.5185   12  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                                8016   39.6831   12  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                                8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                                8016   88.8087   13  1       293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                                8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                                8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                                8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                                8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                                8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                                8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                                8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                                1001    8.1573
                                8016   21.5782
                               14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
```

```
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  1       293  end
'steel: liner'
ss304                                          16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                          17  1.06388 293  end
'steel: angle iron (ai) for HAC'
'nct density is multiplied by volume fraction 7.08030/5.74516'
ss304                                          18  1.23239 293  end
'steel: drum steel for HAC'
'nct density is multiplied by volume fraction 3.20482/2.95645'
ss304                                          19  1.08401 293  end
'void space external to drum'
'array density is assumed not reduced by hac'
'arbmwed    0.9982   2 0 0 0    1001   11.1913
'                               8016   88.8087   20  1       293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
5hcsrpdoxt12,14000.1gUO2 (12322.9g235)5712.4gSH2O 2667.0gH2Ocv,hx= 19.11 fr=1
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vac                        end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   21.838092    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   21.838092    0.26670   0.0     com='drum bottom flat cover'
 cuboid    21 1 4p21.838092    0.26670   0.0     com='drum(chine)outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.685692   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.838092   11.59510   0.0     com='drum'
 cuboid    21 1 4p21.838092   11.59510   0.0     com='drum(chine)outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.270 in.]'
 cylinder  3  1    6.426200   77.72400  58.78051 com='cavity abv HEU'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cylinder  15 1    7.924800   77.72400   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   77.72400   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   77.72400   0.0     com='np277_4'
 cylinder  16 1   11.074400   77.72400   0.0     com='kaolite liner'
 cylinder  12 1   21.685692   77.72400   0.0     com='kaolite'
 cylinder  19 1   21.838092   77.72400   0.0     com='drum'
 cuboid    21 1 4p21.838092   77.72400   0.0     com='drum(chine)outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
```

```
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.685692    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.22860   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.22860   0.0     com='drum(chine)outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.27000   0.0     com='drum'
 cuboid    21 1 4p21.838092    1.27000   0.0     com='drum(chine)outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.685692    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.838092    2.92100   0.0     com='drum'
 cuboid    21 1 4p21.838092    2.92100   0.0     com='drum(chine)outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.01600   0.0     com='drum'
 cuboid    21 1 4p21.838092    1.01600   0.0     com='drum(chine)outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.685692    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.838092    8.17880   0.0     com='drum'
 cuboid    21 1 4p21.838092    8.17880   0.0     com='drum(chine)outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
```

```
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.685692    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.838092    4.44500   0.0     com='drum'
 cuboid    21 1 4p21.838092    4.44500   0.0     com='drum(chine)outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.685692    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.838092    0.63500   0.0     com='drum'
 cuboid    21 1 4p21.838092    0.63500   0.0     com='drum(chine)outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  21 1   21.469792    1.90500   0.15240 com='void above lid'
 cylinder  19 1   21.622192    1.90500   0.0     com='drum lid'
 cylinder  21 1   21.685692    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.838092    1.90500   0.0     com='drum'
 cuboid    21 1 4p21.838092    1.90500   0.0     com='drum(chine)outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-21.838092     0.0
'cuboid     0  1 4p21.838092    110.4905  0.0    com='bare package'
 cuboid    21  1 4p52.318092   140.9700 -30.48   com='reflected package'
'cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.9.9.4 Case 5nciapdoxt11_1_1_11_3

```
=csas25    parm=size=3000000
5nciapdoxt11,11000.1gUO2 ( 9682.3g235)4488.3gSH2O 4164.3gHcv hx= 25.06 fr=0.0001
238groupndf5 infhommedium
'HEU volume =5500.05000 HEU oxide, bulk density of oxide in cans=  2.00000 g/cm3'
'oxide= 11000.1 g, sat.h2o in HEU oxide=4488.3 g, oxide h/x=12.10'
'poly (packed or wrapped) dry content h/x=1.73, CV void volume 4171.83368'
arbmuox    1.82015   2 0 0 0  92235   88.0203
                              8016   11.9797    1  1.0000  293  end
arbmastm  7.4266e-01  2 0 0 0  1001   11.1913
                              8016   88.8087    1  1.0000  293  end
arbmpoly  8.2733e-02  2 0 0 0  1001   14.3798
                              6012   85.6202    1  1.0000  293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
```

```
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  9.9820e-01  2 0 0 0   1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'nct array densities are s.u.dens. multiplied by volume ratio 1.34888/1.10336'
arbmh2ok   0.63931  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.42622  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.42622  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.42622  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.42622  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
```

```
arbmcao    0.42622  2 0 0 0   20000   71.4815
                              8016   28.5185   12  0.307   293  end
arbmmgo    0.42622  2 0 0 0   12000   60.3169
                              8016   39.6831   12  0.131   293  end
arbmna2o   0.42622  2 0 0 0   11023   74.1961
                              8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
'ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
'ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
arbmwed    1.16026  2 0 0 0    1001   11.1913
                              8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                              8016   88.8087   21  1.0     293  end
end comp
5nciapdoxt11,11000.1gUO2 ( 9682.3g235)4488.3gSH2O 4164.3gHcv,hx= 25.06 fr=0.0001
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                  end boun
read geometry
```

```
unit 1001
'drum bottom flat cover [Elev= 0.111 in. at top of unit]'
'cylinder  19 1   22.866096    0.28150   0.0     com='extended radius not used'
 cylinder  19 1   21.722275    0.28150   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p22.866096    0.28150   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.676 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.555075   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.722275   11.59510   0.0     com='drum'
 cuboid    20 1 4p22.866096   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.276 in.]'
 cylinder  3  1    6.426200   77.72400  47.21851 com='cavity abv HEU'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cylinder  15 1    7.924800   77.72400   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   77.72400   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   77.72400   0.0     com='np277_4'
 cylinder  16 1   11.074400   77.72400   0.0     com='kaolite liner'
 cylinder  12 1   21.555075   77.72400   0.0     com='kaolite'
 cylinder  19 1   21.722275   77.72400   0.0     com='drum'
 cuboid    20 1 4p22.866096   77.72400   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.336 in.]'
 cylinder  3  1    6.426200    0.15240   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.426 in.]'
 cylinder  3  1    6.426200    0.22860   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.555075    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.22860   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.926 in.]'
 cylinder  3  1    6.426200    1.27000   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.27000   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.076 in.]'
```

```
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.555075    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.722275    2.92100   0.0     com='drum'
 cuboid    20 1 4p22.866096    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.476 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.01600   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.536 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.756 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.555075    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.722275    8.17880   0.0     com='drum'
 cuboid    20 1 4p22.866096    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.506 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.555075    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.722275    4.44500   0.0     com='drum'
 cuboid    20 1 4p22.866096    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.756 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.555075    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.512 in.]'
 cylinder  20 1   21.330090    1.91973   0.16720 com='void above lid'
 cylinder  19 1   21.497290    1.91973   0.0     com='drum lid'
 cylinder  20 1   21.555075    1.91973   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.722275    1.91973   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.91973   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.512 in.]'
```

```
array 3         2r-22.866096     0.0
'cuboid     0  1 4p24.587200    1120.337  0.0    com='bare package'
'cuboid    21  1 4p55.067200   1150.817 -30.48   com='reflected package'
 cuboid    20  1 4p22.866096    110.5197  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.9.9.5 Case 5nciapdoxt11_1_1_12_3

```
=csas25    parm=size=3000000
5nciapdoxt11,12000.0gUO2 (10562.4g235)4896.3gSH2O 3665.3gHcv hx= 22.74 fr=0.0001
238groupndf5 infhommedium
'HEU volume =6000.00000 HEU oxide, bulk density of oxide in cans=  2.00000 g/cm3'
'oxide= 12000.0 g, sat.h2o in HEU oxide=4896.3 g, oxide h/x=12.10'
'poly (packed or wrapped) dry content h/x=1.59, CV void volume 3671.88368'
arbmuox    1.83389   2 0 0 0  92235   88.0203
                              8016   11.9797    1  1.0000  293  end
arbmastm  7.4827e-01  2 0 0 0  1001   11.1913
                              8016   88.8087    1  1.0000  293  end
arbmpoly  7.6412e-02  2 0 0 0  1001   14.3798
                              6012   85.6202    1  1.0000  293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  9.9820e-01  2 0 0 0   1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                          8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                          9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
```

```
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'nct array densities are s.u.dens. multiplied by volume ratio 1.34888/1.10336'
arbmh2ok   0.63931  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.42622  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.42622  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.42622  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.42622  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.42622  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.42622  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.42622  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
```

```
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                           16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                           17  1.06388 293  end
'steel: angle iron (ai) for single units'
'ss304                                           18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
ss304                                           18  1.25705 293  end
'steel: drum steel for single units'
'ss304                                           19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
ss304                                           19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
arbmwed    1.16026  2 0 0 0    1001   11.1913
                               8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                               8016   88.8087   21  1.0     293  end
end comp
5nciapdoxt11,12000.0gUO2 (10562.4g235)4896.3gSH2O 3665.3gHcv,hx= 22.74 fr=0.0001
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                    end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.111 in. at top of unit]'
'cylinder  19 1   22.866096    0.28150   0.0     com='extended radius not used'
 cylinder  19 1   21.722275    0.28150   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p22.866096    0.28150   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.676 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.555075   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.722275   11.59510   0.0     com='drum'
 cuboid    20 1 4p22.866096   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.276 in.]'
 cylinder  3  1    6.426200   77.72400  51.07212 com='cavity abv HEU'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cylinder  15 1    7.924800   77.72400   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   77.72400   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   77.72400   0.0     com='np277_4'
 cylinder  16 1   11.074400   77.72400   0.0     com='kaolite liner'
```

```
 cylinder  12 1   21.555075   77.72400   0.0     com='kaolite'
 cylinder  19 1   21.722275   77.72400   0.0     com='drum'
 cuboid    20 1 4p22.866096   77.72400   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.336 in.]'
 cylinder  3  1    6.426200    0.15240   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.426 in.]'
 cylinder  3  1    6.426200    0.22860   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.555075    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.22860   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.926 in.]'
 cylinder  3  1    6.426200    1.27000   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.27000   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.076 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.555075    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.722275    2.92100   0.0     com='drum'
 cuboid    20 1 4p22.866096    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.476 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.01600   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.536 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1016
```

```
'abv 2nd step in liner to bottom of angle iron [Elev=40.756 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.555075    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.722275    8.17880   0.0     com='drum'
 cuboid    20 1 4p22.866096    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.506 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.555075    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.722275    4.44500   0.0     com='drum'
 cuboid    20 1 4p22.866096    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.756 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.555075    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.512 in.]'
 cylinder  20 1   21.330090    1.91973   0.16720 com='void above lid'
 cylinder  19 1   21.497290    1.91973   0.0     com='drum lid'
 cylinder  20 1   21.555075    1.91973   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.722275    1.91973   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.91973   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.512 in.]'
array 3         2r-22.866096     0.0
'cuboid     0  1 4p24.587200    1120.337  0.0    com='bare package'
'cuboid    21  1 4p55.067200   1150.817 -30.48   com='reflected package'
 cuboid    20  1 4p22.866096    110.5197  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.9.9.6 Case 5nciapdoxt11_1_1_11_3

```
=csas25    parm=size=3000000
5nciapdoxt11,11000.1gUO2 ( 9682.3g235)4488.3gSH2O 4164.3gHcv hx= 25.06 fr=0.0001
238groupndf5 infhommedium
'HEU volume =5500.05000 HEU oxide, bulk density of oxide in cans=  2.00000 g/cm3'
'oxide= 11000.1 g, sat.h2o in HEU oxide=4488.3 g, oxide h/x=12.10'
'poly (packed or wrapped) dry content h/x=1.73, CV void volume 4171.83368'
arbmuox    1.82015   2 0 0 0  92235   88.0203
                              8016   11.9797    1  1.0000  293  end
arbmastm  7.4266e-01  2 0 0 0  1001   11.1913
                              8016   88.8087    1  1.0000  293  end
arbmpoly  8.2733e-02  2 0 0 0  1001   14.3798
                              6012   85.6202    1  1.0000  293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  9.9820e-01  2 0 0 0   1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
```

```
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'nct array densities are s.u.dens. multiplied by volume ratio 1.34888/1.10336'
arbmh2ok   0.63931  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.42622  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.42622  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.42622  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.42622  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.42622  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.42622  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.42622  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
'ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
```

```
'ss304                                          19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
arbmwed    1.16026  2 0 0 0    1001   11.1913
                               8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                               8016   88.8087   21  1.0     293  end
end comp
5nciapdoxt11,11000.1gUO2 ( 9682.3g235)4488.3gSH2O 4164.3gHcv,hx= 25.06 fr=0.0001
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                    end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.111 in. at top of unit]'
'cylinder  19 1   22.866096    0.28150   0.0     com='extended radius not used'
 cylinder  19 1   21.722275    0.28150   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p22.866096    0.28150   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.676 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.555075   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.722275   11.59510   0.0     com='drum'
 cuboid    20 1 4p22.866096   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.276 in.]'
 cylinder  3  1    6.426200   77.72400  47.21851 com='cavity abv HEU'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cylinder  15 1    7.924800   77.72400   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   77.72400   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   77.72400   0.0     com='np277_4'
 cylinder  16 1   11.074400   77.72400   0.0     com='kaolite liner'
 cylinder  12 1   21.555075   77.72400   0.0     com='kaolite'
 cylinder  19 1   21.722275   77.72400   0.0     com='drum'
 cuboid    20 1 4p22.866096   77.72400   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.336 in.]'
 cylinder  3  1    6.426200    0.15240   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.426 in.]'
 cylinder  3  1    6.426200    0.22860   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.555075    0.22860   0.0     com='kaolite'
```

```
 cylinder  19 1   21.722275    0.22860   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.926 in.]'
 cylinder  3  1    6.426200    1.27000   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.27000   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.076 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.555075    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.722275    2.92100   0.0     com='drum'
 cuboid    20 1 4p22.866096    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.476 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.01600   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.536 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.756 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.555075    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.722275    8.17880   0.0     com='drum'
 cuboid    20 1 4p22.866096    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.506 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.555075    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.722275    4.44500   0.0     com='drum'
 cuboid    20 1 4p22.866096    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.756 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
```

```
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.555075    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.512 in.]'
 cylinder  20 1   21.330090    1.91973   0.16720 com='void above lid'
 cylinder  19 1   21.497290    1.91973   0.0     com='drum lid'
 cylinder  20 1   21.555075    1.91973   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.722275    1.91973   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.91973   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.512 in.]'
array 3         2r-22.866096     0.0
'cuboid     0  1 4p24.587200    1120.337  0.0    com='bare package'
'cuboid    21  1 4p55.067200   1150.817 -30.48   com='reflected package'
 cuboid    20  1 4p22.866096    110.5197  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.9.9.7 Case 5nciapdoxt11_1_2_11_3

```
=csas25    parm=size=3000000
5nciapdoxt11,11000.1gUO2 ( 9682.3g235)2658.2gSH2O 5994.4gHcv hx= 25.06 fr=0.0001
238groupndf5 infhommedium
'HEU volume =3666.70000 HEU oxide, bulk density of oxide in cans=  3.00000 g/cm3'
'oxide= 11000.1 g, sat.h2o in HEU oxide=2658.2 g, oxide h/x= 7.17'
'poly (packed or wrapped) dry content h/x=1.73, CV void volume 6005.18368'
arbmuox    2.61274   2 0 0 0  92235   88.0203
                              8016   11.9797    1  1.0000  293  end
arbmastm  6.3139e-01  2 0 0 0  1001   11.1913
                              8016   88.8087    1  1.0000  293  end
arbmpoly  1.1876e-01  2 0 0 0  1001   14.3798
                              6012   85.6202    1  1.0000  293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                              5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                              7014    0.0141
```

```
                                8016   43.4251
                               11023    0.1174
                               12000    0.3378
                               13027   39.0479
                               14000    2.4672
                               16000    0.3083
                               20000   11.8336
                               26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  9.9820e-01  2 0 0 0   1001   11.1913
                              8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                7014    0.0141
                                8016   43.4251
                               11023    0.1174
                               12000    0.3378
                               13027   39.0479
                               14000    2.4672
                               16000    0.3083
                               20000   11.8336
                               26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'nct array densities are s.u.dens. multiplied by volume ratio 1.34888/1.10336'
arbmh2ok   0.63931  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.42622  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.42622  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.42622  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.42622  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.42622  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.42622  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.42622  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
```

```
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
'ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
'ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
arbmwed    1.16026  2 0 0 0    1001   11.1913
                               8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                              8016   88.8087   21  1.0     293  end
end comp
5nciapdoxt11,11000.1gUO2 ( 9682.3g235)2658.2gSH2O 5994.4gHcv,hx= 25.06 fr=0.0001
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                  end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.111 in. at top of unit]'
'cylinder  19 1   22.866096    0.28150   0.0     com='extended radius not used'
 cylinder  19 1   21.722275    0.28150   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p22.866096    0.28150   0.0     com='drum chine outer radius'
unit 1002
```

```
'above drum bottom flat cover and below containment vessel [Elev= 4.676 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.555075   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.722275   11.59510   0.0     com='drum'
 cuboid    20 1 4p22.866096   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.276 in.]'
 cylinder  3  1    6.426200   77.72400  33.08705 com='cavity abv HEU'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cylinder  15 1    7.924800   77.72400   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   77.72400   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   77.72400   0.0     com='np277_4'
 cylinder  16 1   11.074400   77.72400   0.0     com='kaolite liner'
 cylinder  12 1   21.555075   77.72400   0.0     com='kaolite'
 cylinder  19 1   21.722275   77.72400   0.0     com='drum'
 cuboid    20 1 4p22.866096   77.72400   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.336 in.]'
 cylinder  3  1    6.426200    0.15240   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.426 in.]'
 cylinder  3  1    6.426200    0.22860   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.555075    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.22860   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.926 in.]'
 cylinder  3  1    6.426200    1.27000   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.27000   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.076 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.555075    2.92100   0.0     com='kaolite'
```

```
 cylinder  19 1   21.722275    2.92100   0.0     com='drum'
 cuboid    20 1 4p22.866096    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.476 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.01600   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.536 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.756 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.555075    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.722275    8.17880   0.0     com='drum'
 cuboid    20 1 4p22.866096    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.506 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.555075    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.722275    4.44500   0.0     com='drum'
 cuboid    20 1 4p22.866096    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.756 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.555075    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
unit 1019
'drum lid and lip [Elev=43.512 in.]'
 cylinder  20 1   21.330090    1.91973   0.16720 com='void above lid'
 cylinder  19 1   21.497290    1.91973   0.0     com='drum lid'
 cylinder  20 1   21.555075    1.91973   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.722275    1.91973   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.91973   0.0     com='drum chine outer radius'
global
unit 1020
'es3100 drum [Elev=43.512 in.]'
array 3         2r-22.866096     0.0
'cuboid     0  1 4p24.587200    1120.337  0.0    com='bare package'
'cuboid    21  1 4p55.067200   1150.817 -30.48   com='reflected package'
 cuboid    20  1 4p22.866096    110.5197  0.0    com='interstital array space'
'global
'unit 1021
```

```
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.9.9.8 Case 5hciapdoxt12_1_1_11_3

```
=csas25    parm=size=3000000
5hciapdoxt12,11000.1gUO2 ( 9682.3g235)4488.3gSH2O 4164.3gHcv hx= 25.06 fr=0.0001
238groupndf5 infhommedium
'HEU volume =5500.05000 HEU oxide, bulk density of oxide in cans=  2.00000 g/cm3'
'oxide= 11000.1 g, sat.h2o in HEU oxide=4488.3 g, oxide h/x=12.10'
'poly (packed or wrapped) dry content h/x=1.73, CV void volume 4171.83368'
arbmuox    1.82015   2 0 0 0  92235   88.0203
                              8016   11.9797    1  1.0000  293  end
arbmastm  7.4266e-01  2 0 0 0  1001   11.1913
                              8016   88.8087    1  1.0000  293  end
arbmpoly  8.2733e-02  2 0 0 0  1001   14.3798
                              6012   85.6202    1  1.0000  293  end
'np277-4: spacer (HAC_MD&H)'
'HAC min.den.(95.3157 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07071e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.82995e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  9.9820e-01  2 0 0 0   1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (HAC_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
```

```
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.476265 = (den.mult)(np277-4 min.den.) = 0.9668933*1.526803'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.70316e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                               8016   88.8087   12  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                               8016   47.0610   12  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                               8016   53.2430   12  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                               8016   30.0460   12  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                               8016   40.0465   12  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                               8016   28.5185   12  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                               8016   39.6831   12  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                               8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
```

```
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for HAC'
'nct density is multiplied by volume fraction 7.08030/5.74516'
ss304                                         18  1.23239 293  end
'steel: drum steel for HAC'
'nct density is multiplied by volume fraction 3.20482/2.95645'
ss304                                         19  1.08401 293  end
'void space external to drum'
'array density is assumed not reduced by hac'
arbmwed    0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   20  0.0001  293  end
'reflective water'
'arbmh20r   0.9982   2 0 0 0    1001   11.1913
'                              8016   88.8087   21  1.0     293  end
end comp
5hciapdoxt12,11000.1gUO2 ( 9682.3g235)4488.3gSH2O 4164.3gHcv,hx= 25.06 fr=0.0001
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=specular                  end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   21.838092    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   21.838092    0.26670   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p21.838092    0.26670   0.0     com='drum(chine)outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.685692   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.838092   11.59510   0.0     com='drum'
 cuboid    20 1 4p21.838092   11.59510   0.0     com='drum(chine)outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.270 in.]'
 cylinder  3  1    6.426200   77.72400  47.21851 com='cavity abv HEU'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cylinder  15 1    7.924800   77.72400   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   77.72400   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   77.72400   0.0     com='np277_4'
 cylinder  16 1   11.074400   77.72400   0.0     com='kaolite liner'
 cylinder  12 1   21.685692   77.72400   0.0     com='kaolite'
 cylinder  19 1   21.838092   77.72400   0.0     com='drum'
 cuboid    20 1 4p21.838092   77.72400   0.0     com='drum(chine)outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
```

```
 cylinder  3  1    6.426200    0.15240   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.685692    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.22860   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.22860   0.0     com='drum(chine)outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.27000   0.0     com='drum'
 cuboid    20 1 4p21.838092    1.27000   0.0     com='drum(chine)outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.685692    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.838092    2.92100   0.0     com='drum'
 cuboid    20 1 4p21.838092    2.92100   0.0     com='drum(chine)outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.01600   0.0     com='drum'
 cuboid    20 1 4p21.838092    1.01600   0.0     com='drum(chine)outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
```

```
 cylinder  12 1   21.685692    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.838092    8.17880   0.0     com='drum'
 cuboid    20 1 4p21.838092    8.17880   0.0     com='drum(chine)outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.685692    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.838092    4.44500   0.0     com='drum'
 cuboid    20 1 4p21.838092    4.44500   0.0     com='drum(chine)outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.685692    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.838092    0.63500   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.63500   0.0     com='drum(chine)outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  20 1   21.469792    1.90500   0.15240 com='void above lid'
 cylinder  19 1   21.622192    1.90500   0.0     com='drum lid'
 cylinder  20 1   21.685692    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.838092    1.90500   0.0     com='drum'
 cuboid    20 1 4p21.838092    1.90500   0.0     com='drum(chine)outer radius'
global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-21.838092     0.0
'cuboid     0  1 4p21.838092    110.4905  0.0    com='bare package'
'cuboid    21  1 4p52.318092   140.9700 -30.48   com='reflected package'
 cuboid    20  1 4p22.889718    110.5048  0.0    com='interstital array space'
'global
'unit 1021
'array 4   3r0.0
'reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
'ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
'read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.9.9.9 Case 5ncf1pdoxt11_1_1_14_3

```
=csas25    parm=size=3000000
5ncf1pdoxt11,14000.1gUO2 (12322.9g235)5712.4gSH2O 2667.0gHcv hx= 19.11 fr=0.0001
238groupndf5 infhommedium
'HEU volume =7000.05000 HEU oxide, bulk density of oxide in cans=  2.00000 g/cm3'
```

```
'oxide= 14000.1 g, sat.h2o in HEU oxide=5712.4 g, oxide h/x=12.10'
'poly (packed or wrapped) dry content h/x=1.36, CV void volume 2671.83368'
arbmuox    1.85591   2 0 0 0  92235   88.0203
                              8016   11.9797    1  1.0000  293  end
arbmastm  7.5725e-01  2 0 0 0  1001   11.1913
                              8016   88.8087    1  1.0000  293  end
arbmpoly  6.6282e-02  2 0 0 0  1001   14.3798
                              6012   85.6202    1  1.0000  293  end
'np277-4: spacer (NCT_MD&H)'
'NCT min.den.(95.3886 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07070e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.84169e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  9.9820e-01  2 0 0 0   1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (NCT_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.527971 = (95.3886 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.477385 = (den.mult)(np277-4 min.den.) = 0.9668933*1.527971'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9189
                                 7014    0.0141
                                 8016   43.4251
                                11023    0.1174
                                12000    0.3378
                                13027   39.0479
                                14000    2.4672
                                16000    0.3083
                                20000   11.8336
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.71451e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 1.012373*0.51655,  for rest = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'nct array densities are s.u.dens. multiplied by volume ratio 1.34888/1.10336'
```

```
arbmh2ok   0.63931  2 0 0 0    1001   11.1913
                              8016   88.8087   12  0.0287  293  end
arbmal2o3  0.42622  2 0 0 0   13027   52.9390
                              8016   47.0610   12  0.096   293  end
arbmsio2   0.42622  2 0 0 0   14000   46.7570
                              8016   53.2430   12  0.367   293  end
arbmfe2o3  0.42622  2 0 0 0   26000   69.9540
                              8016   30.0460   12  0.067   293  end
arbmtio2   0.42622  2 0 0 0   22000   59.9535
                              8016   40.0465   12  0.012   293  end
arbmcao    0.42622  2 0 0 0   20000   71.4815
                              8016   28.5185   12  0.307   293  end
arbmmgo    0.42622  2 0 0 0   12000   60.3169
                              8016   39.6831   12  0.131   293  end
arbmna2o   0.42622  2 0 0 0   11023   74.1961
                              8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                              8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                              8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                              8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                              8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                              8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                              8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                              8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                              8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                              1001    8.1573
                              8016   21.5782
                             14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                              8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for single units'
'ss304                                         18  1.0     293  end
'steel: angle iron (ai) for arrays'
'array density is multiplied by a volume fraction 7.08030/5.63249'
ss304                                         18  1.25705 293  end
'steel: drum steel for single units'
'ss304                                         19  1.0     293  end
'steel: drum steel for arrays'
'array density is multiplied by a volume fraction 3.20482/3.20544'
ss304                                         19  0.99981 293  end
'void space external to drum'
'array density is multiplied by a volume ratio 8.11698/6.98323'
```

```
arbmwed    1.16026  2 0 0 0    1001   11.1913
                               8016   88.8087   20  0.0001  293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
5ncf1pdoxt11,14000.1gUO2 (12322.9g235)5712.4gSH2O 2667.0gHcv,hx= 19.11 fr=0.0001
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vacuum                      end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.111 in. at top of unit]'
'cylinder  19 1   22.866096    0.28150   0.0     com='extended radius not used'
 cylinder  19 1   21.722275    0.28150   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p22.866096    0.28150   0.0     com='drum chine outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.676 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.555075   11.59510   0.0     com='kaolite'
 cylinder  19 1   21.722275   11.59510   0.0     com='drum'
 cuboid    20 1 4p22.866096   11.59510   0.0     com='drum chine outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.276 in.]'
 cylinder  3  1    6.426200   77.72400  58.78051 com='cavity abv HEU'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cylinder  15 1    7.924800   77.72400   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   77.72400   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   77.72400   0.0     com='np277_4'
 cylinder  16 1   11.074400   77.72400   0.0     com='kaolite liner'
 cylinder  12 1   21.555075   77.72400   0.0     com='kaolite'
 cylinder  19 1   21.722275   77.72400   0.0     com='drum'
 cuboid    20 1 4p22.866096   77.72400   0.0     com='drum chine outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.336 in.]'
 cylinder  3  1    6.426200    0.15240   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.426 in.]'
 cylinder  3  1    6.426200    0.22860   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.555075    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.22860   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.22860   0.0     com='drum chine outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.926 in.]'
 cylinder  3  1    6.426200    1.27000   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
```

```
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.27000   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.27000   0.0     com='drum chine outer radius'
unit 1013
'cv flange above cv well [Elev=37.076 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.555075    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.722275    2.92100   0.0     com='drum'
 cuboid    20 1 4p22.866096    2.92100   0.0     com='drum chine outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.476 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
 cylinder  12 1   21.555075    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.722275    1.01600   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.01600   0.0     com='drum chine outer radius'
unit 1015
'2nd step in liner [Elev=37.536 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.555075    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.722275    0.15240   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.15240   0.0     com='drum chine outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.756 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.555075    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.722275    8.17880   0.0     com='drum'
 cuboid    20 1 4p22.866096    8.17880   0.0     com='drum chine outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.506 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.555075    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.722275    4.44500   0.0     com='drum'
 cuboid    20 1 4p22.866096    4.44500   0.0     com='drum chine outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.756 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.555075    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.722275    0.63500   0.0     com='drum'
 cuboid    20 1 4p22.866096    0.63500   0.0     com='drum chine outer radius'
```

```
unit 1019
'drum lid and lip [Elev=43.512 in.]'
 cylinder  20 1   21.330090    1.91973   0.16720 com='void above lid'
 cylinder  19 1   21.497290    1.91973   0.0     com='drum lid'
 cylinder  20 1   21.555075    1.91973   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.722275    1.91973   0.0     com='drum'
 cuboid    20 1 4p22.866096    1.91973   0.0     com='drum chine outer radius'
'global
unit 1020
'es3100 drum [Elev=43.512 in.]'
array 3         2r-22.866096     0.0
'cuboid     0  1 4p24.587200    1120.337  0.0    com='bare package'
'cuboid    21  1 4p55.067200   1150.817 -30.48   com='reflected package'
 cuboid    20  1 4p22.866096    110.5198  0.0    com='interstital array space'
global
unit 1021
array 4   3r0.0
reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
ara=4 nux=13 nuy=13 nuz=06 fill f1020               end fill
end array
read bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

6.9.9.9.10 Case 5hcf2pdoxt12_1_1_14_3

```
=csas25    parm=size=3000000
5hcf2pdoxt12,14000.1gUO2 (12322.9g235)5712.4gSH2O 2667.0gHcv hx= 19.11 fr=0.0001
238groupndf5 infhommedium
'HEU volume =7000.05000 HEU oxide, bulk density of oxide in cans=  2.00000 g/cm3'
'oxide= 14000.1 g, sat.h2o in HEU oxide=5712.4 g, oxide h/x=12.10'
'poly (packed or wrapped) dry content h/x=1.36, CV void volume 2671.83368'
arbmuox    1.85591   2 0 0 0  92235   88.0203
                              8016   11.9797    1  1.0000  293  end
arbmastm  7.5725e-01  2 0 0 0  1001   11.1913
                              8016   88.8087    1  1.0000  293  end
arbmpoly  6.6282e-02  2 0 0 0  1001   14.3798
                              6012   85.6202    1  1.0000  293  end
'np277-4: spacer (HAC_MD&H)'
'HAC min.den.(95.3157 lb/ft3) and hydrogen'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.31015e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520    2  0.7500  293  end
arbmnpmx  1.07071e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
```

```
                                20000   11.8335
                                26000    0.5298    2  1.0000  293  end
arbmnph2o 3.82995e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087    2  1.0000  293  end
'flooded containmment vessel and content cans -- 10 CFR 71.55(d)(3)'
arbmwicv  9.9820e-01  2 0 0 0   1001   11.1913
                               8016   88.8087    3  1       293  end
'steel: containment vessel body 16.60 lb but use 15.74 lb'
ss304                                           8  1.0     293  end
'steel: cv flange lower use 3.36 lb'
ss304                                           9  0.97267 293  end
'steel: cv flange upper use 13.75 lb'
ss304                                          10  0.94348 293  end
'np277-4: confinement -- neutron poison inner liner (HAC_MD&H)'
'actual vol.= 1.28314e4 cm3 = (7.83023e2 in3)(16.387064)'
'den.multiplier = 1.28314e4 cm3 (actual vol.) / 1.32708e4 cm3 (model vol.)'
'np277-4 min.den.= 1.526803 = (95.3157 lb/ft3)(453.59 g/lb)/(28316.84 cm3/ft3)'
'density = 1.476265 = (den.mult)(np277-4 min.den.) = 0.9668933*1.526803'
'use 75% of boron in calculations per NUREG-1609 Section 6.5.3.2'
arbmboron 7.06813e-2  2 0 0 0    5010   18.1479
                                 5011   81.8520   11  0.7500  293  end
arbmnpmx  1.03525e+0 10 0 0 0    6012    1.9188
                                 7014    0.0141
                                 8016   43.4254
                                11023    0.1174
                                12000    0.3378
                                13027   39.0477
                                14000    2.4671
                                16000    0.3083
                                20000   11.8335
                                26000    0.5298   11  1.0000  293  end
arbmnph2o 3.70316e-1  2 0 0 0    1001   11.1913
                                 8016   88.8087   11  1.0000  293  end
'kaolite 1600 body'
'nct.sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k 0.52294 = 1.012373*0.51655, for rest 0.34864 = 1.012373*0.34438'
'den.mult= 1.36557e5 cm3 (actual vol.) / 1.34888e5 cm3 (model vol.)'
'actual vol.= 1.36557e5 cm3 = (28316.84 cm3/ft3)(108.33188 lb)/(22.464 lb/ft3)'
'hac.s.u.dens= (hac.mult)(nct.s.u.dens)'
'hac.mult = 1.34888e5 cm3 (nct vol.)/ 1.12246e5 cm3 (model vol.)'
' for arbmh2ok 0.62843 = 1.20172*0.52294,   for rest = 1.20172*0.34864'
'hac array densities are hac s.u.dens.'
arbmh2ok   0.62843  2 0 0 0    1001   11.1913
                                8016   88.8087   12  0.0287  293  end
arbmal2o3  0.41898  2 0 0 0   13027   52.9390
                                8016   47.0610   12  0.096   293  end
arbmsio2   0.41898  2 0 0 0   14000   46.7570
                                8016   53.2430   12  0.367   293  end
arbmfe2o3  0.41898  2 0 0 0   26000   69.9540
                                8016   30.0460   12  0.067   293  end
arbmtio2   0.41898  2 0 0 0   22000   59.9535
                                8016   40.0465   12  0.012   293  end
arbmcao    0.41898  2 0 0 0   20000   71.4815
                                8016   28.5185   12  0.307   293  end
arbmmgo    0.41898  2 0 0 0   12000   60.3169
                                8016   39.6831   12  0.131   293  end
arbmna2o   0.41898  2 0 0 0   11023   74.1961
                                8016   25.8039   12  0.020   293  end
'kaolite 1600 top plug'
'sing.unit.density= (den.mult)(min.den.)'
' for arbmh20k = 0.965246*0.51655,  for rest = 0.965246*0.34438'
```

```
'den.mult= 1.21592e4 cm3 (actual vol.) / 1.25970e4 cm3 (model vol.)'
'actual vol.= 1.21592e4 cm3 = (28316.84 cm3/ft3)(9.646 lb)/(22.464 lb/ft3)'
arbmh2ok   0.49860  2 0 0 0    1001   11.1913
                               8016   88.8087   13  0.0287  293  end
arbmal2o3  0.33241  2 0 0 0   13027   52.9390
                               8016   47.0610   13  0.096   293  end
arbmsio2   0.33241  2 0 0 0   14000   46.7570
                               8016   53.2430   13  0.367   293  end
arbmfe2o3  0.33241  2 0 0 0   26000   69.9540
                               8016   30.0460   13  0.067   293  end
arbmtio2   0.33241  2 0 0 0   22000   59.9535
                               8016   40.0465   13  0.012   293  end
arbmcao    0.33241  2 0 0 0   20000   71.4815
                               8016   28.5185   13  0.307   293  end
arbmmgo    0.33241  2 0 0 0   12000   60.3169
                               8016   39.6831   13  0.131   293  end
arbmna2o   0.33241  2 0 0 0   11023   74.1961
                               8016   25.8039   13  0.020   293  end
'silicone rubber pads'
arbmsiru   1.21791  4 0 0 0    6012   32.3767
                               1001    8.1573
                               8016   21.5782
                              14000   37.8878   14  1.0     293  end
'void space external to containment vessel'
arbmwecv   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   15  0.0001  293  end
'steel: liner'
ss304                                         16  1.0     293  end
'steel: plug cover (pc) use 9.907 lb'
ss304                                         17  1.06388 293  end
'steel: angle iron (ai) for HAC'
'nct density is multiplied by volume fraction 7.08030/5.74516'
ss304                                         18  1.23239 293  end
'steel: drum steel for HAC'
'nct density is multiplied by volume fraction 3.20482/2.95645'
ss304                                         19  1.08401 293  end
'void space external to drum'
'array density is assumed not reduced by hac'
arbmwed    0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   20  0.0001  293  end
'reflective water'
arbmh20r   0.9982   2 0 0 0    1001   11.1913
                               8016   88.8087   21  1.0     293  end
end comp
5hcf2pdoxt12,14000.1gUO2 (12322.9g235)5712.4gSH2O 2667.0gHcv,hx= 19.11 fr=0.0001
read parameters nub=yes npg=2500 gen=215 nsk=15 tme=100 end parameters
read boun       all=vacuum                    end boun
read geometry
unit 1001
'drum bottom flat cover [Elev= 0.105 in. at top of unit]'
'cylinder  19 1   21.838092    0.26670   0.0     com='extended radius not used'
 cylinder  19 1   21.838092    0.26670   0.0     com='drum bottom flat cover'
 cuboid    20 1 4p21.838092    0.26670   0.0     com='drum(chine)outer radius'
unit 1002
'above drum bottom flat cover and below containment vessel [Elev= 4.670 in.]'
 cylinder  15 1    3.175000   11.59510  11.16330 com='void in pad-1'
 cylinder  14 1    7.924800   11.59510  11.16330 com='pad-1'
 cylinder  16 1    8.077200   11.59510  11.16330 com='np277_4 liner'
 cylinder  11 1   10.922000   11.59510  11.16330 com='np277_4'
 cylinder  16 1   11.074400   11.59510  10.85850 com='kaolite liner bottom'
 cylinder  12 1   21.685692   11.59510   0.0     com='kaolite'
```

```
 cylinder  19 1   21.838092   11.59510   0.0     com='drum'
 cuboid    20 1 4p21.838092   11.59510   0.0     com='drum(chine)outer radius'
unit 1003
'cv bottom to bottom of 1st step [Elev=35.270 in.]'
 cylinder  3  1    6.426200   77.72400  58.78051 com='cavity abv HEU'
 cylinder  1  1    6.426200   77.72400   0.63500 com='HEU content'
 cylinder  8  1    6.680200   77.72400   0.0     com='cv bottom'
 cylinder  15 1    7.924800   77.72400   0.0     com='void btw cv-np liner'
 cylinder  16 1    8.077200   77.72400   0.0     com='np277_4 liner'
 cylinder  11 1   10.922000   77.72400   0.0     com='np277_4'
 cylinder  16 1   11.074400   77.72400   0.0     com='kaolite liner'
 cylinder  12 1   21.685692   77.72400   0.0     com='kaolite'
 cylinder  19 1   21.838092   77.72400   0.0     com='drum'
 cuboid    20 1 4p21.838092   77.72400   0.0     com='drum(chine)outer radius'
unit 1010
'cv at 1st step in liner [Elev=35.330 in.]'
 cylinder  3  1    6.426200    0.15240   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.15240   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.15240   0.0     com='cv at 1st step'
 cylinder  15 1    7.924800    0.15240   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.15240   0.0     com='liner 1st step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1011
'vertical gap between 1st step in liner and cv flange [Elev=35.420 in.]'
 cylinder  3  1    6.426200    0.22860   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    0.22860   0.0     com='HEU content'
 cylinder  8  1    6.680200    0.22860   0.0     com='cv at gap btwn step-flng'
 cylinder  15 1   10.922000    0.22860   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    0.22860   0.0     com='liner wall'
 cylinder  12 1   21.685692    0.22860   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.22860   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.22860   0.0     com='drum(chine)outer radius'
unit 1012
'cv flange to top of cv well [Elev=35.920 in.]'
 cylinder  3  1    6.426200    1.27000   0.00000 com='cavity abv HEU'
 cylinder  1  1    6.426200    1.27000   0.0     com='HEU content'
 cylinder  9  1    9.525000    1.27000   0.0     com='flange to top of well'
 cylinder  15 1    9.525000    1.27000   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    1.27000   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.27000   0.0     com='void btw cv and liner'
 cylinder  16 1   11.074400    1.27000   0.0     com='liner wall'
 cylinder  12 1   21.685692    1.27000   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.27000   0.0     com='drum'
 cuboid    20 1 4p21.838092    1.27000   0.0     com='drum(chine)outer radius'
unit 1013
'cv flange above cv well [Elev=37.070 in.]'
 cylinder  10 1    9.525000    2.92100   0.0     com='flange above cv well'
 cylinder  15 1    9.525000    2.92100   0.0     com='void btw cv and pad-2'
 cylinder  14 1   10.033000    2.92100   0.0     com='pad-2'
 cylinder  15 1   10.922000    2.92100   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    2.92100   0.0     com='liner wall'
 cylinder  12 1   21.685692    2.92100   0.0     com='kaolite'
 cylinder  19 1   21.838092    2.92100   0.0     com='drum'
 cuboid    20 1 4p21.838092    2.92100   0.0     com='drum(chine)outer radius'
unit 1014
'plugpad2 below liner 2nd step [Elev=37.470 in.]'
 cylinder  14 1   10.033000    0.76200   0.0     com='pad-2'
 cylinder  15 1   10.922000    1.01600   0.0     com='void btw pad2 and liner'
 cylinder  16 1   11.074400    1.01600   0.0     com='liner wall'
```

```
 cylinder  12 1   21.685692    1.01600   0.0     com='kaolite'
 cylinder  19 1   21.838092    1.01600   0.0     com='drum'
 cuboid    20 1 4p21.838092    1.01600   0.0     com='drum(chine)outer radius'
unit 1015
'2nd step in liner [Elev=37.530 in.]'
 cylinder  15 1   10.922000    0.15240   0.0     com='void abv pad2'
 cylinder  16 1   18.757900    0.15240   0.0     com='liner 2nd step'
 cylinder  12 1   21.685692    0.15240   0.0     com='kaolite'
 cylinder  19 1   21.838092    0.15240   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.15240   0.0     com='drum(chine)outer radius'
unit 1016
'abv 2nd step in liner to bottom of angle iron [Elev=40.750 in.]'
 cylinder  13 1   18.097500    8.17880   0.49276 com='plug kaolite'
 cylinder  17 1   18.249900    8.17880   0.34036 com='sides of plug case'
 cylinder  15 1   18.605500    8.17880   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    8.17880   0.0     com='liner wall'
 cylinder  12 1   21.685692    8.17880   0.0     com='kaolite'
 cylinder  19 1   21.838092    8.17880   0.0     com='drum'
 cuboid    20 1 4p21.838092    8.17880   0.0     com='drum(chine)outer radius'
unit 1017
'bottom of angle iron to bend in angle iron [Elev=42.500 in.]'
 cylinder  13 1   18.097500    4.44500   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    4.44500   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    4.44500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    4.44500   0.0     com='liner wall'
 cylinder  18 1   19.392900    4.44500   0.0     com='lower angle iron'
 cylinder  12 1   21.685692    4.44500   0.0     com='kaolite'
 cylinder  19 1   21.838092    4.44500   0.0     com='drum'
 cuboid    20 1 4p21.838092    4.44500   0.0     com='drum(chine)outer radius'
unit 1018
'bend in angle iron to top of angle iron [Elev=42.750 in.]'
 cylinder  13 1   18.097500    0.11176   0.0     com='plug kaolite'
 cylinder  17 1   18.249900    0.26416   0.0     com='sides of plug case'
 cylinder  15 1   18.605500    0.63500   0.0     com='void: plug to liner'
 cylinder  16 1   18.757900    0.63500   0.0     com='liner wall'
 cylinder  18 1   21.685692    0.63500   0.0     com='bend section of ai'
 cylinder  19 1   21.838092    0.63500   0.0     com='drum'
 cuboid    20 1 4p21.838092    0.63500   0.0     com='drum(chine)outer radius'
unit 1019
'drum lid and lip [Elev=43.500 in.]'
 cylinder  20 1   21.469792    1.90500   0.15240 com='void above lid'
 cylinder  19 1   21.622192    1.90500   0.0     com='drum lid'
 cylinder  20 1   21.685692    1.90500   0.0     com='void btw lid - drum wall'
 cylinder  19 1   21.838092    1.90500   0.0     com='drum'
 cuboid    20 1 4p21.838092    1.90500   0.0     com='drum(chine)outer radius'
'global
unit 1020
'es3100 drum [Elev=43.500 in.]'
array 3         2r-21.838092     0.0
'cuboid     0  1 4p21.838092    110.4905  0.0    com='bare package'
'cuboid    21  1 4p52.318092   140.9700 -30.48   com='reflected package'
 cuboid    20  1 4p21.838092    110.4901  0.0    com='interstital array space'
global
unit 1021
array 4   3r0.0
reflector  21 2  6r3.0  10
end geometry
read array
ara=3 nux=1 nuy=1 nuz=13 fill
1001 1002 1003 1010
1011 1012 1013 1014 1015 1016 1017 1018 1019        end fill
```

```
ara=4 nux=09 nuy=09 nuz=06 fill f1020               end fill
end array
ead bias id=500 2  11  end bias
read start nst=0
end start
end data
end
```

Appendix 6.9.10
Criticality Evaluation of HEU Oxide Product Content for Air Transportation

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Appendix 6.9.10
Criticality Evaluation of HEU Oxide Product Content for Air Transportation

Highly enriched uranium (HEU) product oxides (UO_2, UO_3, and U_3O_8), HEU product oxides mixed with thorium oxide, HEU product oxides mixed with zirconium oxide, and HEU product oxides mixed with thorium metal are evaluated as ES-3100 package contents for ground transport in Sects. 6.4 through 6.6. The criticality safety evaluation presented in this appendix is required for the approval of these oxides as a package content under the air transport mode. This analysis is simply an extension of the analysis presented in Sect. 6.7 for HEU metal. The catastrophically damaged package calculation models for HEU described in Sect. 6.3.1.4 for metal content were modified to address HEU product oxide under the air transport mode. Calculations presented in this appendix were performed using the Monte Carlo CSAS5 criticality code sequence and 238-group ENDF/B-VII (V7-238 gr) cross-section library of SCALE 6.1.3.

The criticality validation for SCALE 6.1.3 is based on benchmark experiments documented in the Organization for Economic Cooperation and Development (OECD) Handbook [NEA/NSC/DOC(95)03]. The USL without any safety margin—derived for the validation of CSAS5 control module of SCALE 6.1.3 with the multi-group V7-238-gr cross-section library run on ENGHPC workstation—is 0.9852 for intermediate energy HEU systems and 0.9868 for thermal energy systems as documented in RP YAREA-F-0524 (note there were no fast systems in these calculations). NUREG/CR-5661 provides guidance that the USL should be established with a minimum margin of subcriticality of 0.05. Using this safety margin, the USL for the calculations performed in this document would be 0.9368 for thermal energy systems, 0.9352 for intermediate energy systems, and 0.9386 for fast energy systems.

6.9.10.1 Description of the Criticality Design

Changes to the design features of the ES-3100 package addressed in Sect. 6.1.1 are not required for air transport. However, the total free water permitted in the Kaolite is limited to 12 lb (5,443.1 g) as in the case of HEU metal content assuming the containment vessel (CV) well and other void spaces external to the CV are dry. The codes and standards addressed in Sect. 6.1.2 apply to HEU product oxide as a package content for air transport. Moreover, the methodology for demonstrating maximum reactivity is not changed. The fissile mass loading limits for these contents are presented in Tables 6.9.10.1-1 through 6.9.10.1-4 and 6.2b for the air mode of transportation. Finally, the assignment of the criticality safety index (CSI) as to the ES-3100 package as described in Sect. 6.1.4 is unchanged.

6.9.10.2 The HEU Product Oxide Contents for the ES-3100 Package for Air Transport

HEU product oxide content for shipment by air in the ES-3100 is identified in Table 6.9.10.1-1. Physically, these uranium oxides (UO_2, UO_3, and U_3O_8) are non-rigid, bulk material in loose, granular, or powdered form. These oxides may also be mixed with ThO_2, ZrO_2, and thorium metal and are evaluated under different limits. Both content moisture and content uniformity are undefined. The convenience cans, Teflon and polyethylene bottles, 277-4 canned spacers described in Sect. 6.2.2, and the packing materials described in Sect. 6.2.3 are not affected by inclusion of HEU product oxide as a package content for air transport. The Packing Content Loading Restrictions stated in Sect. 6.2.4 are unchanged.

Table 6.9.10.1-1. HEU product oxide content loadings limits [a, b, c, d]

Detailed description	Assay (wt % ^{235}U)	^{235}U wt (g)
5.0 g/cm^3 ≤ density ≤ 6.54 g/cm^3	≤100	7,570
4.0 g/cm^3 ≤ density < 5.0 g/cm^3	≤100	6,020
3.0 g/cm^3 ≤ density < 4.0 g/cm^3	≤100	4,750
2.0 g/cm^3 ≤ density < 3.0 g/cm^3	≤100	3,380
1.5 g/cm^3 ≤ density < 2.0 g/cm^3	≤100	2,770
1.0 g/cm^3 ≤ density < 1.5 g/cm^3	≤100	2,150

[a] The mass loading limit cannot be rounded up.
[b] Content in solution form is not permitted for shipment in the ES-3100. Content may be a combination of UO_2, UO_3, U_3O_8, U_3O_8-Al, UO_2-Mg.
[c] 277-4 can spacers as described on Drawing M2E801580A043 (Appendix 1.3.7) are not required but are optional.
[d] Non-uranium metallic constituents (e.g., aluminum , zirconium, or magnesium) are evaluated further in Appendix 6.9.11.

Table 6.9.10.1-2. HEU product oxide mixed with thorium oxide content loadings limits [a, b, c, d]

Detailed description	Assay (wt % ^{235}U)	^{235}U wt (g)
5.0 g/cm^3 ≤ density ≤ 6.54 g/cm^3	≤100	7,570
4.0 g/cm^3 ≤ density < 5.0 g/cm^3	≤100	6,020
3.0 g/cm^3 ≤ density < 4.0 g/cm^3	≤100	4,480
2.0 g/cm^3 ≤ density < 3.0 g/cm^3	≤100	2,460
1.5 g/cm^3 ≤ density < 2.0 g/cm^3	≤100	1,580
1.0 g/cm^3 ≤ density < 1.5 g/cm^3	≤100	1,140

[a] The mass loading limit cannot be rounded up.
[b] Content in solution form is not permitted for shipment in the ES-3100. Content may be a combination of product oxides (UO_2, UO_3, U_3O_8) mixed with ThO_2.
[c] 277-4 can spacers as described on Drawing M2E801580A043 (Appendix 1.3.7) are not required but are optional.
[d] Non-uranium metallic constituents (e.g., aluminum , zirconium, or magnesium) are evaluated further in Appendix 6.9.11.

Table 6.9.10.1-3. HEU product oxide mixed with zirconium oxide content loadings limits [a, b, c, d]

Detailed description	Assay (wt % ^{235}U)	^{235}U wt (g)
5.0 g/cm^3 ≤ density ≤ 6.54 g/cm^3	≤100	7,570
4.0 g/cm^3 ≤ density < 5.0 g/cm^3	≤100	6,020
3.0 g/cm^3 ≤ density < 4.0 g/cm^3	≤100	3,120
2.0 g/cm^3 ≤ density < 3.0 g/cm^3	≤100	1,490
1.5 g/cm^3 ≤ density < 2.0 g/cm^3	≤100	830
1.0 g/cm^3 ≤ density < 1.5 g/cm^3	≤100	700

[a] The mass loading limit cannot be rounded up.
[b] Content in solution form is not permitted for shipment in the ES-3100. Content may be a combination of product oxides (UO_2, UO_3, U_3O_8) mixed with ZrO_2.
[c] 277-4 can spacers as described on Drawing M2E801580A043 (Appendix 1.3.7) are not required but are optional.
[d] Non-uranium metallic constituents (e.g., aluminum , zirconium, or magnesium) are evaluated further in Appendix 6.9.11.

Table 6.9.10.1-4. HEU product oxide mixed with thorium metal content loadings limits [a, b, c, d]

Detailed description	Assay (wt % ^{235}U)	^{235}U wt (g)
5.0 g/cm^3 ≤ density ≤ 6.54 g/cm^3	≤100	7,570
4.0 g/cm^3 ≤ density < 5.0 g/cm^3	≤100	6,020
3.0 g/cm^3 ≤ density < 4.0 g/cm^3	≤100	4,660
2.0 g/cm^3 ≤ density < 3.0 g/cm^3	≤100	2,550
1.5 g/cm^3 ≤ density < 2.0 g/cm^3	≤100	1,710
1.0 g/cm^3 ≤ density < 1.5 g/cm^3	≤100	1,180

[a] The mass loading limit cannot be rounded up.
[b] Content in solution form is not permitted for shipment in the ES-3100. Content may be a combination of product oxides (UO_2, UO_3, U_3O_8) mixed with Th metal.
[c] 277-4 can spacers as described on Drawing M2E801580A043 (Appendix 1.3.7) are not required but are optional.
[d] Non-uranium metallic constituents (e.g., aluminum , zirconium, or magnesium) are evaluated further in Appendix 6.9.11.

6.9.10.3 General Considerations

The general considerations expressed in Sect. 6.3 regarding both the calculation methodology for the ground and air transport modes, and the assumptions made about the ES-3100 packaging regarding geometry and material composition are unchanged. Only modifications to the calculation models for the catastrophically damaged package (Sect. 6.3.1.4) were required for evaluating HEU product oxide as a package content in the air transport mode.

6.9.10.3.1 Model configuration

The general modeling technique for the ES-3100 package described in Sect. 6.3.1, the single-unit packaging calculation models (Sect. 6.3.1.1), the infinite array and finite array packaging calculation models (Sect. 6.3.1.2), and the calculation models for damaged packages (Sect. 6.3.1.3) are specific to the ground transport. Only the content portion of the six calculation models for the catastrophically damaged package specific to HEU metal as a package content under the air transport (Sect. 6.3.1.4) were appropriately modified for evaluating HEU product oxide as a package content in the air transport mode. This was accomplished by replacing the homogeneous mixture of HEU metal and 500 g of polyethylene in the original models with a homogeneous mixture of water-saturated HEU oxide and 500 g of polyethylene. The 500-g polyethylene represents a limit on Teflon or polyethylene bottles as well as hydrogenous packing material. Given the requirement that CVs be flooded in the ground transport analysis; credit for product oxide quality (dryness) is not taken in the air transport analysis either. The HEU product oxide is assumed water-saturated in the air transport analysis.

The general arrangements of materials depicted in Figs. 6.11–6.16 (Sect. 6.1.3.4) remains the same for the HEU metal and HEU product oxide content configurations. Note that model dimensions are presented in the calculation results summary tables rather than depicted in these figures. Changes in dimensions of each model resulting from switching content from HEU metal to HEU product oxide content are slight and not visible in the figures. Consequently, revised figures were not drawn for HEU product oxide; instead, Figs. 6.11–6.16 are referenced accordingly in this appendix.

The content description for the HEU product oxide given in Table 6.9.10.1 provides the basis for the calculation model. The 7.57 kg ^{235}U will be shown to be the largest amount allowable for air transport in Table 6.9.10.9-1 for 5.0 g/cm^3 and higher densities at 100% enrichment. There are three major oxides

of uranium—UO_2, UO_3 , and U_3O_8. UO_3 and U_3O_8 are bounded by calculations using UO_2 for two reasons: (1) for the same net weight, there is more ^{235}U in UO_2 than in UO_3 or U_3O_8 and (2) for the same ^{235}U content, the UO_3 and U_3O_8 have more oxygen atoms per uranium atom and, therefore, have lower uranium densities. However, the neutron scattering and absorption in the additional oxygen is a minor effect compared to reactivity changes due to the uranium mass/density differences. For this reason, Table 6.9.10.9-1 contains only a few calculations of UO_3 and U_3O_8 at the 6-kg oxide net weight amount included to demonstrate that the UO_2 is obviously bounding for the other two oxides.

HEU product oxide evaluated for ground transport in Sects. 6.4.3, 6.5.3, and 6.6.3 is characterized as non-hydroscopic or mildly hydroscopic, non-rigid, bulk material in clumped, loose, granular, or powdered form having a bulk density ranging from 1.0 to 6.54 g/cm^3. Oxide impurity (unidentified constituents) is treated as ^{235}U [Sect. 6.2.4, Item 8]. This same criteria is applied in the criticality evaluation for the air transport mode. Given the requirement that CVs be flooded in the ground transport analysis, credit for product quality (dryness) is not taken in the air transport analysis either. The HEU product oxide is assumed water-saturated.

As explained in Sect. 6.3.1.4, the air-transport calculation models incorporate features exhibiting the worst-case assumptions made regarding the geometric arrangement of the packaging and package contents. No credit is taken for the geometric form of the package content. Spherical geometry is used to represent the ultimate configuration of the ES-3100 package which undergoes catastrophic destruction.

The criticality analysis for air transport does not credit the ES-3100 for maintaining the geometrical configuration of the packaged content. Fissile material is configured spherical in shape for optimization of neutron multiplication. Also, the criticality analysis does not credit the ES-3100 packaging for structural integrity of the containment and the confinement. Therefore, the reactivity "enhancing" materials of the packaging may be interspersed with the fissile material content. A calculation model in which the fissile material is homogenized with moderating material is an appropriate representation because the form of HEU product uranium oxide being shipped consists of a bulk material in clumped, loose, granular, or powdered form. However, homogenization of fissile material with moderating material is not performed with exclusive preference given to specific constituents of the moderating material. Selective removal of the neutron-absorbing materials of the package (i.e., Kaolite and stainless steel) accompanied by retention of the moderating constituents of the neutron-absorbing material (i.e., bound water in the Kaolite) for enhancing content reactivity is not a credible condition.

Concerning the "no water inleakage" condition of 10 CFR 71.55(f)(1) and (f)(2), the focus is on the Kaolite region of the ES-3100 package. The 53,419 g of dry-baked Kaolite in the drum body weldment and drum top plug consists of 51,214.9 g of vermiculite-cement constituents and 2,204.7 g of bound water. For establishing the loading limits for air transport, the total **free** water permitted in wet Kaolite was conservatively evaluated up to 15 lb (6,803.8 g). As in the case of HEU metal content, this limit assumes that the CV well and other void spaces external to the CV are dry.

A set of six calculation models are constructed in order to determine the worst case or most reactive configuration with consideration given to the efficiency of moderators, loss of neutron absorbers, rearrangement of packaging components and contents, geometry changes, and temperature effects. In each case, fissile material content in the core consists of HEU product oxide saturated with water (e.g., 2,448.1-g H_2O for UO_2 from 1.0 to 5.0 g/cm^3) and homogenized with 500-g polyethylene which models the allowed hydrogenous packing material.

Model 1 (Fig. 6.11, Sect. 6.3.1.4) represents the fissile material content configured into a spherical core with a 20.0-cm thick water reflector. All ES-3100 packaging material (Kaolite, stainless steel, 277-4 neutron poison, etc.) is excluded from Model 1. The fissile material content considered in the calculation model consists of a specific material form: HEU product oxide (6- to 14-kg UO_2 containing

5,281- to 12,323-g ^{235}U). The presence of hydrogenous packing material inside the CV is also addressed in this calculation model where 500 g of polyethylene is used to represent a maximum amount of hydrogenous packing material allowed in the ES-3100. From the parametric studies for 6-kg HEU product oxide (5,281-g ^{235}U) homogenized with 500 g of polyethylene, the radius of the core is 6.3861 cm. HEU product oxide is assumed to be saturated with water that is 2,448.1-g H_2O for UO_2 at 2.0 g/cm^3. From the results of these parametric studies, UO_2 was shown to be the most reactive HEU product oxide, and the bulk density of 2.0 g/cm^3 was also shown to be the most reactive density (the lowest density evaluated in this study). Thus, UO_2 is used in all subsequent air transport calculations, and these lower density HEU product oxide densities evaluated here will bound the higher density HEU product oxides evaluated.

The parametric variation of both the ^{235}U mass and the density of the water-saturated oxide in Model 1 is used to establish a reference point for the evaluation neutron reflection and absorption effects on k_{eff} provided by the stainless steel and Kaolite packaging materials, which are addressed separately in Models 2 and 3. Case names for Model 1 are designated with the prefix "5atdorxx." The "xx" in alphanumeric prefix indicates calculations were run at a specific oxide density, with 50 for calculations at 5.0 g/cm^3 and 15 for calculations at 1.5 g/cm^3 respectively, UO_2 is shown to be the most reactive uranium oxide; therefore, the oxide content is modeled as UO_2 at various densities ranging from 1.0 to 6.54 g/cm^3. Details are provided in Table 6.9.10.9-1 for each density evaluated.

Model 2 (Fig. 6.12, Sect. 6.3.1.4) represents a spherical core of Model 1 blanketed by a variable-thickness shell of stainless steel and a 20.0-cm-thick water reflector external to the shell. The shell at maximum thickness corresponds to the 66,133-g stainless steel of the CV and the liner and drum assembly Case names in Table 6.9.10.9-1 for Model 2 are designated with the prefix "5atdosrxx."

Model 3 (Fig. 6.13, Sect. 6.3.1.4) is configured the same as Model 2 with the exception that instead of stainless steel, the variable-thickness shell is composed of dry Kaolite in one set of cases and wet Kaolite in the other set. Dry Kaolite from inside the body weldment outer liner and the drum top plug consists of 51,214.3-g vermiculite-cement and 2,204.8-g bound water. Wet Kaolite to a maximum of 60,223 g consists of the dry Kaolite and up to 6,803.9-g free water—moisture which dampens the Kaolite and may also be present in the CV well. Because the Kaolite is constrained within the liners of the ES-3100 packaging, the Kaolite density rather than its volume changes when water is added to the material. The radius of the core is the same as in Model 2, for a homogeneous mixture of HEU product oxide, 2,448.1 g of saturation water, and 500 g of polyethylene. Case names for Model 3 designated with the prefix "5atdodkrxx" are for HEU product oxide content with a dry Kaolite shell (Kaolite only contains bound water), while case names designated with the prefix "5atdo15krxx" are for HEU product oxide content with a wet Kaolite having 15-lb free water. The parametric variation of shell thickness/composition in Models 2 and 3 is performed for the purpose of evaluating the effect on k_{eff} of neutron reflection and absorption provided by each packaging material.

Models 1–3 for water-saturated HEU product oxide evaluate scenarios where containment and confinement of the content are assumed but the physical shape of the packaging is destroyed. Models 4–6 evaluate scenarios where the package content blends with the other materials of the packaging in the air transport accident given the physical form of the HEU product oxide is bulk material in clumped, loose, granular, or powdered form.

Model 4 (Fig. 6.14, Sect. 6.3.1.4) depicts a spherical core of HEU product oxide and 2,448.1 g of saturation water homogenized with wet Kaolite (variable amount) and hydrogenous packing materials from inside the CV represented by 500 g of polyethylene. A 20-cm-thick water reflector blankets the spherical core. All other ES-3100 packaging material (stainless steel, 277-4 neutron poison, etc.) is excluded from Model 4. The core is homogenized containing HEU product oxide, saturation water for the oxide at that particular density, 500 g of polyethylene and wet Kaolite. The amount of water in wet

Kaolite ranges from 2,204.7-g bound water in baked-dry Kaolite to 9,008.6 g (2,204.7-g bound plus 15-lb free water). Case names in Table 6.9.10.9-1 for Model 4 are designated with the prefix "5athop15krxx" for the HEU product oxide.

Model 5 (Fig. 6.15, Sect. 6.3.1.4) is an extension of Model 3 applied to HEU product oxide contents. Excess water from wet Kaolite is homogenized with the fissile material in the core along with the water of saturation and the hydrogenous packing materials (modeled as polyethylene). The core is a homogeneous mixture of HEU product oxide, saturation water for the oxide at that particular density, 500 g of polyethylene, and 0.0 g of free water from wet Kaolite. The corresponding exterior Kaolite shell contains 7,646.8 g (2,204.7-g bound plus 12-lb free water) of water homogenized with the 51,214.9 g of vermiculite-cement constituents. The corresponding exterior shell of dry Kaolite contains 2,204.7 g of bound water and 51,214.9 g of vermiculite-cement constituents. Case names in Table 6.9.10.9-1 for Model 5 are designated with the prefix "5athopw12krxx" for 12-lb free water in the Kaolite.

Model 6 (Fig. 6.16, Sect. 6.3.1.4) is configured similar to Model 4 with the exception that only a partial amount of HEU product oxide resides in the homogenized core. The remainder of the fissile material is modeled as a shell external to the spherical core and internal to the 20.0-cm-thick water reflector. A series cases is run with suffixes "**_f_a_b**" is run where the first number "**f**"designates variable water mass in the fissile core region, the second number "**a**" designates oxide mass in the fissile core, and the third number "**b**"designates oxide mass in shell around the core. For Cases **5athop15korxx_f_a_b**, the amount of water-saturated HEU oxide in the homogenized core is varied in increments for **"a**. The unsaturated HEU product oxide removed from the core to form the shell adjacent to the core correspondingly increases depending on the oxide density for "**b**. For maximization of reactivity, it is assumed that all the saturation water present in the oxide remains in the core. The effect of varying the free water in the core is evaluated in cases designated by the suffix "**f**." In Cases **5athop15korxx_1_a_b**, the saturated water in the oxide plus both the free water and bound water in Kaolite. In Cases **5athop15kor_5_a_b**, the water represents the saturated water in the oxide plus the bound water in Kaolite. Case names in Table 6.9.10.9-2 for Model 6 are designated with the prefix "5athop15korxx" for the HEU product oxide contents. Model 6 addresses potential redistribution of fissile material consisting of HEU product oxide content. The parametric variation of shell thickness in Model 6 is performed for the purpose of evaluating the effect on k_{eff} of moderation efficiency of the core and enhanced neutron multiplication of the shell.

Models 1–6 are applicable to air transport of the ES-3100 package given that the physical integrity of the fissile content following the air-transport accident cannot be established and that the physical form of fissile material content is oxide.

6.9.10.3.2 Content model material specifications for HEU product oxide

The material properties for the ES-3100 package addressed in Sect. 6.3.2 remain unchanged for the air transport analysis. However, additional specification data is provided in Table 6.9.10.3-1 for addressing the HEU product oxide content modeled in the air-transport analysis.

6.9.10.4 Computer Codes and Cross-Section Libraries

This information is discussed in the introductory section of this appendix.

Table 6.9.10.3-1. Material compositions for HEU product oxide content calculation models for air transport

Material	Mix. No.	Theoretical density input parameter (g/cm3) a	Volume fraction	Constituent	Weight fraction
Uranium oxide (UO_2)	1	10.96000	1.0	O	11.9827
				^{235}U	88.0173
HEU product oxide (UO_2) at 2 g/cm^3, 2,448.1-g saturation water, and 500-g poly	1	1.69325	1.0	O	88.0203
				^{235}U	11.9797
	1	0.69089	1.0	H	11.1913
				O	88.8087
	1	0.14110	1.0	C	14.3798
				H	85.6202
HEU product oxide (UO_2) at 3 g/cm^3, 1,449.9-g saturation water, and 500-g poly	1	2.35897	1.0	O	88.0203
				^{235}U	11.9797
	1	0.57006	1.0	H	11.1913
				O	88.8087
	1	0.19658	1.0	C	14.3798
				H	85.6202
HEU product oxide (UO_2) at 4 g/cm^3, 950.8-g saturation water, and 500-g poly	1	2.93617	1.0	O	88.0203
				^{235}U	11.9797
	1	0.46530	1.0	H	11.1913
				O	88.8087
	1	0.24468	1.0	C	14.3798
				H	85.6202
HEU product oxide (UO_2) at 5 g/cm^3, 651.4-g saturation water, and 500-g poly	1	3.44140	1.0	O	88.0203
				^{235}U	11.9797
	1	0.37361	1.0	H	11.1913
				O	88.8087
	1	0.28678	1.0	C	14.3798
				H	85.6202
HEU product oxide (UO_2) at 6.54 g/cm^3, 369.3-g saturation water, and 500-g poly	1	4.10703	1.0	O	88.0203
				^{235}U	11.9797
	1	0.25280	1.0	H	11.1913
				O	88.8087
	1	0.34225	1.0	C	14.3798
				H	85.6202

Table 6.9.10.3-1. Material compositions for HEU product oxide content calculation models for air transport

Material	Mix. No.	Theoretical density input parameter (g/cm3) a	Volume fraction	Constituent	Weight fraction
HEU product oxide (UO_2) and ThO_2 at 2 g/cm^3, 6,095-g saturation water, and 500-g poly	1	0.36225	1.0	O	88.0203
				^{235}U	11.9797
	1	1.5043	1.0	Th	87.8839
				O	11.1913
	1	0.74843	1.0	H	11.1913
				O	88.8087
	1	0.061399	1.0	C	14.3798
				H	85.6202
HEU product oxide (UO_2) and ZrO_2 at 2 g/cm^3, 5,089-g saturation water, and 500-g poly	1	0.24560	1.0	O	88.0203
				^{235}U	11.9797
	1	1.6209	1.0	Zr	87.8839
				O	11.1913
	1	0.62435	1.0	H	11.1913
				O	88.8087
	1	0.061399	1.0	C	14.3798
				H	85.6202
HEU product oxide (UO_2) and thorium metal at 2 g/cm^3, 6,272-g saturation water, and 500-g poly	1	0.38067	1.0	O	88.0203
				^{235}U	11.9797
	1	1.4859	1.0	Th	100.0
	1	0.77014	1.0	H	11.1913
				O	88.8087
	1	0.061399	1.0	C	14.3798
				H	85.6202

[a] The theoretical density input parameter is specified for each material such that the required (or desired) mass of material is represented in the KENO V.a calculation model. The mass of material is computed by KENO V.a as the product of the theoretical density input parameter times the volume fraction times the volume of the geometry region in which the material resides in the calculation model.

6.9.10.5 Single Package Evaluation (NCT and HAC)

The evaluation of a single ES-3100 package with HEU product oxide content for Normal Conditions of Transport (NCT) and Hypothetical Accident Conditions (HAC) in the ground mode of transportation is presented in Sect. 6.4.3, while the evaluation of a catastrophically damaged package in air transport mode is addressed in Sect. 6.9.10.7.

6.9.10.6 Array Package Evaluation (NCT and HAC)

The evaluation of arrays of packages in NCT and in HAC for the ground transport mode are presented in Sects. 6.5.3 and 6.6.3, respectively. The array evaluations are not required by 10 CFR 71.55(f) for the air mode of transportation. However, the CSI established for the ground transport mode establishes the maximum number of packages which can be loaded onto an aircraft for criticality safety purposes.

6.9.10.7 Fissile Material Packages with HEU Product Oxide for Air Transport

As discussed in Sect. 6.7, a series of calculations are performed for determining the most reactive configuration of the content and surrounding packaging material in an ES-3100 package that undergoes catastrophic destruction. Subcriticality is demonstrated after due consideration of such aspects as the efficiency of moderator, loss of neutron absorbers, rearrangement of packaging components and contents, geometry changes and temperature effects. Details of the six calculation models used in this evaluation are described in Sect. 6.9.10.3.1. In this section, HEU oxide, HEU oxide with thorium oxide, HEU oxide with zirconium oxide, and HEU oxide with thorium metal are evaluated, with the density of the HEU oxide and additional material evaluated at 5.0, 4.0, 3.0, 2.0, 1.5, and 1.0 g/cm^3. The results of these calculations are found in Tables 6.9.10.9-2 through 6.9.10.9-9.

Model 1 (Fig. 6.11, Sect. 6.3.1.4) represents fissile material content configured into a spherical core with a 20.0-cm-thick water reflector taking no credit for the geometry or structure of the container. In addition, all ES-3100 packaging material (Kaolite, stainless steel, 277-4 neutron poison, etc.) is excluded from Model 1. The parametric variation of both the ^{235}U mass and the density of the oxide along with its corresponding saturation water in Model 1 is used to establish a reference point for the evaluation of neutron reflection and absorption effects on k_{eff} provided by the stainless steel and Kaolite packaging materials, which are addressed separately in Models 2 and 3. The purpose of the variations in Model 1 is to identify the most reactive oxide (UO_2, UO_3, or U_3O_8) mass at a corresponding density (from 1.0 to 6.54 g/cm^3) for water-saturated HEU product oxide. For the parametric study cases, in Cases **5atdor_1_5_6** through **5atdor_1_5_14** (Table 6.9.10.9-1), the $k_{eff} + 2\sigma$ values increase from 0.751 to 0.871 as the mass of saturated HEU product oxide increases from 6-kg UO_2 (5,281-g ^{235}U) to 14-kg UO_2 (12,323-g ^{235}U) at 6.54 g/cm^3. In Cases **5atdor_1_1_6** through **5atdor_1_5_6** for UO_2, Cases **5atdor_2_1_6** through **5atdor_2_5_6** for U_3O_8, and Cases **5atdor_3_1_6** through **5atdor_3_5_6** for UO_3, the densities of the three oxides are varied from 2 to 6.54 g/cm^3. These contents are most reactive at minimum density where the $k_{eff} + 2\sigma$ values range from 0.671 for UO_3 (**Case 5atdor_3_5_6**) to 0.917 for UO_2 (**Case 5atdor_1_1_6**). UO_2 is the most reactive of the product oxides evaluated and is used in all subsequent HEU oxide calculations.

Cases **5atdor*** (HEU oxide, Table 6.9.10.9-2), **atdothr*** (HEU oxide and ThO_2, Table 6.9.10.9-4), **atdozrr*** (HEU oxide and ZrO_2, Table 6.9.10.9-6), and **atdothmr*** (HEU oxide and thorium metal, Table 6.9.10.9-8), calculate a range of oxide masses from 1.0 to 5.0 g/cm^3. The maximum oxide masses that are below the USL are found in Table 6.9.10.4. Note that for ThO_2, ZrO_2, and thorium metal calculations at densities less than 2.0 g/cm^3, the total amount of HEU oxide and material mixed with HEU oxide that is evaluated is limited by the volume of the CV.

Table 6.9.10.4. Results for Model 1 air transport calculations

Case	Density (g/cm^3)	Oxide (kg)	^{235}U (kg)	$ThO_2/ZrO_2/Th$ (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2								
5atdor10_6	1.0	3.40	2.990	n/a	0.93289	0.00074	0.93437	0.93680
5atdor15_5	1.5	5.10	4.480	n/a	0.93347	0.00076	0.93499	0.93520
5atdor_1_1_6	2.0	6.00	5.281	n/a	0.91417	0.00131	0.91679	0.92400
5atdor30_4	3.0	10.40	9.150	n/a	0.93334	0.00076	0.93486	0.93520
5atdor40_4	4.0	13.65	12.015	n/a	0.93279	0.00070	0.93419	0.93520
5atdor50_4	5.0	16.60	14.611	n/a	0.93283	0.00064	0.93411	0.93520
Saturated UO_2-ThO_2								
atdothr10_2_3	1.0	1.30	1.144	8.35	0.93045	0.00075	0.93195	0.93680
atdothr15_2_3	1.5	1.80	1.584	12.7	0.93196	0.00073	0.93342	0.93680
atdothr_2_3	2.0	2.95	2.597	12.25	0.93351	0.00086	0.93523	0.93680
atdothr30_3_3	3.0	9.40	8.274	5.80	0.93202	0.00074	0.93350	0.93520
atdothr40_1_4	4.0	11.00	9.682	4.20	0.89234	0.0008	0.89394	0.93520
atdothr50_1_4	5.0	11.00	9.682	4.20	0.85077	0.00071	0.85219	0.93520
Saturated UO_2-ZrO_2								
atdozrr10_2_3	1.0	0.80	0.704	8.85	0.93118	0.00073	0.93264	0.93680
atdozrr15_2_3	1.5	0.95	0.836	13.50	0.93031	0.00076	0.93183	0.93680
atdozrr_2_3	2.0	1.75	1.540	13.45	0.93409	0.00083	0.93575	0.93680
atdozrr30_3_3	3.0	9.40	8.274	5.80	0.93334	0.00080	0.93494	0.93520
atdozrr40_1_4	4.0	11.00	9.682	4.20	0.88688	0.00082	0.88852	0.93520
atdozrr50_1_4	5.0	11.00	9.682	4.20	0.83893	0.00076	0.84045	0.93520
Saturated UO_2-thorium metal								
atdothmr10_2_3	1.0	1.35	1.188	8.30	0.92675	0.00071	0.92817	0.93680
atdothmr15_2_3	1.5	1.95	1.716	12.55	0.93399	0.00095	0.93589	0.93680
atdothmr_2_3	2.0	3.10	2.729	12.10	0.93452	0.00075	0.93602	0.93680
atdothmr30_3_3	3.0	9.35	8.230	5.85	0.93266	0.00077	0.93420	0.93520
atdothmr40_1_4	4.0	11.00	9.682	4.20	0.89206	0.00080	0.89366	0.93520
atdothmr50_1_4	5.0	11.00	9.682	4.20	0.85054	0.00085	0.85224	0.93520

Model 2 (Fig. 6.12, Sect. 6.3.1.4) represents a spherical core of water-saturated HEU product oxide and polyethylene (Model 1) blanketed by a variable thickness shell of stainless steel, with a 20.0-cm-thick water reflector external to the shell. The shell at maximum thickness corresponds to the 66,133-g stainless steel of the CV and the liner and drum assembly. For calculations at 2.0 g/cm^3, the thickness of the stainless steel shell is varied from zero to 4.6944 cm in Cases **5atdosr_1** through **5atdosr_11** (Table 6.9.10.9-1). The maximum $k_{eff} + 2\sigma$ is 0.915 for 6 kg of HEU product oxide and zero stainless-steel thickness. The $k_{eff} + 2\sigma$ values decrease to a minimum of 0.863 at 1.84-cm stainless-steel shell thickness (Case **5atdosr_4**). The $k_{eff} + 2\sigma$ values increase to within 0.02 of the maximum at the maximum stainless steel thickness (Case **5atdosr_11**). The overall effect of adding the stainless steel of the ES-3100 packaging to the configuration is the reduction in the neutron multiplication factor for the system. The $k_{eff} + 2\sigma$ values are substantially below the USL of 0.924.

Cases **5atdosr*** (HEU oxide, Table 6.9.10.9-2), **atdothsr*** (HEU oxide and ThO_2, Table 6.9.10.9-4), **atdozrsr*** (HEU oxide and ZrO_2, Table 6.9.10.9-6), and **atdothmsr*** (HEU oxide and thorium metal, Table 6.9.10.9-8), calculate a range of oxide masses from 1.0 to 5.0 g/cm^3. The maximum oxide masses that are below the USL are found in Table 6.9.10.5.

Table 6.9.10.5. Results for Model 2 air transport calculations

Case	Density (g/cm^3)	Oxide (kg)	^{235}U (kg)	$ThO_2/ZrO_2/Th$ (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2								
5atdosr10_1	1.0	3.40	2.990	n/a	0.93367	0.00085	0.93537	0.93680
5atdosr15_1	1.5	5.10	4.480	n/a	0.93317	0.00087	0.93491	0.93520
5atdosr_1	2.0	6.00	5.281	n/a	0.91194	0.00135	0.91464	0.92400
5atdosr30_1	3.0	10.40	9.150	n/a	0.93306	0.00084	0.93474	0.93520
5atdosr40_1	4.0	13.65	12.015	n/a	0.93327	0.00074	0.93475	0.93520
5atdosr50_1	5.0	16.60	14.611	n/a	0.93298	0.00071	0.93440	0.93520
Saturated UO_2-ThO_2								
atdothsr10_1	1.0	1.30	1.144	8.35	0.93045	0.00075	0.93195	0.93680
atdothsr15_1	1.5	1.80	1.584	12.7	0.93196	0.00073	0.93342	0.93680
atdothsr_1	2.0	2.95	2.597	12.25	0.93351	0.00086	0.93523	0.93680
atdothsr30_1	3.0	9.40	8.274	5.80	0.93202	0.00074	0.93350	0.93520
atdothsr40_1	4.0	11.00	9.682	4.20	0.89234	0.00080	0.89394	0.93520
atdothsr50_1	5.0	11.00	9.682	4.20	0.85077	0.00071	0.85219	0.93520
Saturated UO_2-ZrO_2								
atdozrsr10_1	1.0	0.80	0.704	8.85	0.93118	0.00073	0.93264	0.93680
atdozrsr15_1	1.5	0.95	0.836	13.50	0.93031	0.00076	0.93183	0.93680
atdozrsr_1	2.0	1.75	1.540	13.45	0.93409	0.00083	0.93575	0.93680
atdozrsr30_1	3.0	9.40	8.274	5.80	0.93334	0.00080	0.93494	0.93520
atdozrsr40_1	4.0	11.00	9.682	4.20	0.88688	0.00082	0.88852	0.93520
atdozrsr50_1	5.0	11.00	9.682	4.20	0.83893	0.00076	0.84045	0.93520
Saturated UO_2-thorium metal								
atdothmsr10_1	1.0	1.35	1.188	8.30	0.92675	0.00071	0.92817	0.93680
atdothmsr15_1	1.5	1.95	1.716	12.55	0.93399	0.00095	0.93589	0.93680
atdothmsr_1	2.0	3.10	2.729	12.10	0.93452	0.00075	0.93602	0.93680
atdothmsr30_1	3.0	9.35	8.230	5.85	0.93266	0.00077	0.93420	0.93520
atdothmsr40_1	4.0	11.00	9.682	4.20	0.89206	0.00080	0.89366	0.93520
atdothmsr50_1	5.0	11.00	9.682	4.20	0.85054	0.00085	0.85224	0.93520

Model 3 (Fig. 6.13, Sect. 6.3.1.4) is configured the same as Model 2 with the exception that instead of stainless steel, the variable-thickness shell is composed of dry Kaolite (Cases **5atdodrk_1** through **5atdodkr_6**) or wet Kaolite (Cases **5atdo15rk_1** through **5atdo15kr_6**). Dry Kaolite from inside the body weldment outer liner and the drum top plug consists of 51,214.9-g vermiculite-cement and 2,204.7-g bound water. Wet Kaolite to a maximum of 60,223 g consists of the dry Kaolite and up to 6,803.8-g free water—moisture which dampens the Kaolite and may also be present in the CV well. Because the Kaolite is constrained within the liners of the packaging, the Kaolite density rather than its volume changes when water is added to the material. Consequently, the shell thickness in Model 3 does not change as free water is added. The $k_{eff} + 2\sigma$ decreases from 0.915 to 0.719 for dry Kaolite (Cases **5atdodkr_1** through **5atdodkr_6**) and decreases from 0.916 to 0.729 for wet Kaolite (Cases **5atdo15kr_1** − **5atdo15kr_6**). NCT Kaolite of the ES-3100 packaging or wet Kaolite is not as effective a reflector as 20 cm water surrounding the core.

For Model 3 with dry Kaolite, Cases **5atdodkr*** (HEU oxide, Table 6.9.10.9-2), **atdothdkr*** (HEU oxide and ThO_2, Table 6.9.10.9-4), **atdozrdkr*** (HEU oxide and ZrO_2, Table 6.9.10.9-6), and **atdothmdkr*** (HEU oxide and thorium metal, Table 6.9.10.9-8), calculate a range of oxide masses from 1.0 to 5.0 g/cm^3. The maximum oxide masses that are below the USL is found in Table 6.9.10.6. For Model 3 for wet Kaolite, Cases **5atdo15kr*** (HEU oxide, Table 6.9.10.9-2), **atdoth15kr*** (HEU oxide and ThO_2, Table 6.9.10.9-4), **atdozr15kr*** (HEU oxide and ZrO_2, Table 6.9.10.9-6), and **atdothm15kr*** (HEU oxide and thorium metal, Table 6.9.10.9-8), calculate a range of oxide masses from 1.0 to 5.0 g/cm^3. The maximum oxide masses that are below the USL are found in Table 6.9.10.7.

Table 6.9.10.6. Results for Model 3 with dry Kaolite air transport calculations

Case	Density (g/cm^3)	Oxide (kg)	^{235}U (kg)	ThO_2/ZrO_2/Th (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2								
5atdodkr10_1	1.0	3.40	2.990	n/a	0.93450	0.00092	0.93634	0.93680
5atdodkr15_1	1.5	5.10	4.480	n/a	0.93271	0.00079	0.93429	0.93520
5atdodkr_1	2.0	6.00	5.281	n/a	0.91160	0.00180	0.91520	0.92400
5atdodkr30_1	3.0	10.40	9.150	n/a	0.93258	0.00092	0.93442	0.93520
5atdodkr40_1	4.0	13.65	12.010	n/a	0.93373	0.00066	0.93505	0.93520
5atdodkr50_1	5.0	16.60	14.611	n/a	0.93252	0.00067	0.93386	0.93520
Saturated UO_2-ThO_2								
atdothdkr10_1	1.0	1.30	1.144	8.35	0.93045	0.00075	0.93195	0.93680
atdothdkr15_1	1.5	1.80	1.584	12.7	0.93196	0.00073	0.93342	0.93680
atdothdkr_1	2.0	2.95	2.597	12.25	0.93351	0.00086	0.93523	0.93680
atdothdkr30_1	3.0	9.40	8.274	5.80	0.93202	0.00074	0.93350	0.93520
atdothdkr40_1	4.0	11.00	9.682	4.20	0.89234	0.00080	0.89394	0.93520
atdothdkr50_1	5.0	11.00	9.682	4.20	0.85077	0.00071	0.85219	0.93520
Saturated UO_2-ZrO_2								
atdozrdkr10_1	1.0	0.80	0.704	8.85	0.93118	0.00073	0.93264	0.93680
atdozrdkr15_1	1.5	0.95	0.836	13.50	0.93031	0.00076	0.93183	0.93680
atdozrdkr_1	2.0	1.75	1.540	13.45	0.93409	0.00083	0.93575	0.93680
atdozrdkr30_1	3.0	9.40	8.274	5.80	0.93334	0.00080	0.93494	0.93520
atdozrdkr40_1	4.0	11.00	9.682	4.20	0.88688	0.00082	0.88852	0.93520
atdozrdkr50_1	5.0	11.00	9.682	4.20	0.83893	0.00076	0.84045	0.93520

Table 6.9.10.6. Results for Model 3 with dry Kaolite air transport calculations

Case	Density (g/cm^3)	Oxide (kg)	^{235}U (kg)	$ThO_2/ZrO_2/Th$ (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2-thorium metal								
atdothmdkr10_1	1.0	1.35	1.188	8.30	0.92675	0.00071	0.92817	0.93680
atdothmdkr15_1	1.5	1.95	1.716	12.55	0.93399	0.00095	0.93589	0.93680
atdothmdkr_1	2.0	3.10	2.729	12.10	0.93452	0.00075	0.93602	0.93680
atdothmdkr30_1	3.0	9.35	8.230	5.85	0.93266	0.00077	0.93420	0.93520
atdothmdkr40_1	4.0	11.00	9.682	4.20	0.89206	0.00080	0.89366	0.93520
atdothmdkr50_1	5.0	11.00	9.682	4.20	0.85054	0.00085	0.85224	0.93520

Table 6.9.10.7. Results for Model 3 with wet Kaolite air transport calculations

Case	Density (g/cm^3)	Oxide (kg)	^{235}U (kg)	$ThO_2/ZrO_2/Th$ (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2								
5atdod15r10_1	1.0	3.40	2.990	n/a	0.93347	0.00076	0.93499	0.93680
5atdo15kr15_1	1.5	5.10	4.489	n/a	0.93220	0.00087	0.93394	0.93520
5atdo15kr_1	2.0	6.00	5.281	n/a	0.91134	0.00212	0.91558	0.92400
5atdo15kr30_1	3.0	10.40	9.150	n/a	0.93292	0.00075	0.93442	0.93520
5atdo15kr40_1	4.0	13.65	12.010	n/a	0.93485	0.00084	0.93653[a]	0.93520
5atdo15kr50_1	5.0	16.60	14.611	n/a	0.93349	0.00070	0.93489	0.93520
Saturated UO_2-ThO_2								
atdoth15kr10_1	1.0	1.30	1.144	8.35	0.93045	0.00075	0.93195	0.93680
atdoth15kr15_1	1.5	1.80	1.584	12.7	0.93196	0.00073	0.93342	0.93680
atdoth15kr_1	2.0	2.95	2.597	12.25	0.93351	0.00086	0.93523	0.93680
atdoth15kr30_1	3.0	9.40	8.274	5.80	0.93202	0.00074	0.93350	0.93520
atdoth15kr40_1	4.0	11.00	9.682	4.20	0.89234	0.00080	0.89394	0.93520
atdoth15kr50_1	5.0	11.00	9.682	4.20	0.85077	0.00071	0.85219	0.93520
Saturated UO_2-ZrO_2								
atdozr15kr10_1	1.0	0.80	0.704	8.85	0.93118	0.00073	0.93264	0.93680
atdozr15kr15_1	1.5	0.95	0.836	13.50	0.93031	0.00076	0.93183	0.93680
atdozr15kr_1	2.0	1.75	1.540	13.45	0.93409	0.00083	0.93575	0.93680
atdozr15kr30_1	3.0	9.40	8.274	5.80	0.93334	0.00080	0.93494	0.93520
atdozr15kr40_1	4.0	11.00	9.682	4.20	0.88688	0.00082	0.88852	0.93520
atdozr15kr50_1	5.0	11.00	9.682	4.20	0.83893	0.00076	0.84045	0.93520
Saturated UO_2-thorium metal								
atdothm15kr10_1	1.0	1.35	1.188	8.30	0.92675	0.00071	0.92817	0.93680
atdothm15kr15_1	1.5	1.95	1.716	12.55	0.93399	0.00095	0.93589	0.93680
atdothm15kr_1	2.0	3.10	2.729	12.10	0.93452	0.00075	0.93602	0.93680
atdothm15kr30_1	3.0	9.35	8.230	5.85	0.93266	0.00077	0.93420	0.93520
atdothm15kr40_1	4.0	11.00	9.682	4.20	0.89206	0.00080	0.89366	0.93520
atdothm15kr50_1	5.0	11.00	9.682	4.20	0.85054	0.00085	0.85224	0.93520

[a] The keff + 2σ value is above the USL; however, Model 5 is more reactive configuration resulting in lower limits.

Model 4 (Fig. 6.14, Sect. 6.3.1.4) represents a spherical core of water-saturated HEU product oxide and polyethylene (Model 1) homogenized with wet Kaolite. A 20-cm-thick water reflector blankets the spherical core. All other ES-3100 packaging material (stainless steel, 277-4 neutron poison, etc.) is excluded from Model 4. In Cases **5athop15kr_1** through **5athop15kr_5** (Table 6.9.10.9-3), $k_{eff} + 2\sigma$ increases from 0.51089 to 0.60192 as free water is added to the 15-lb limit. Again, the core radius is constant with changing moisture conditions because the volume of the porous Kaolite constrained within the liners of the packaging does not change appreciably as the material is dried out or absorbs water. Small amounts of free water in the Kaolite can have a significant moderating effect if introduced to the fissile core.

For Model 4, Cases **5atdodkr*** (HEU oxide, Table 6.9.10.9-2), **atdothdkr*** (HEU oxide and ThO_2, Table 6.9.10.9-4), **atdozrdkr*** (HEU oxide and ZrO_2, Table 6.9.10.9-6), and **atdothmdkr*** (HEU oxide and thorium metal, Table 6.9.10.9-8), calculate a range of oxide masses from 1.0 to 5.0 g/cm^3. The maximum oxide masses that are below the USL are found in Table 6.9.10.8.

Table 6.9.10.8. Results for Model 4 air transport calculations

Case	Density (g/cm^3)	Oxide (kg)	^{235}U (kg)	$ThO_2/ZrO_2/Th$ (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2								
5athop15kr10_5	1.0	3.40	2.990	n/a	0.55165	0.00057	0.55279	0.93680
5athop15kr15_5	1.5	5.10	4.480	n/a	0.59250	0.00060	0.59370	0.93680
5athop15kr_5	2.0	6.00	5.281	n/a	0.60058	0.00067	0.60192	0.93680
5athop15kr30_5	3.0	10.40	9.150	n/a	0.64512	0.00067	0.64646	0.93680
5athop15kr40_5	4.0	13.65	12.010	n/a	0.66036	0.00080	0.66196	0.93680
5athop15kr50_5	5.0	16.60	14.611	n/a	0.66688	0.00075	0.66838	0.93680
Saturated UO_2-ThO_2								
athothp15kr10_5	1.0	1.30	1.144	8.35	0.43360	0.00047	0.43454	0.93680
athothp15kr15_5	1.5	1.80	1.584	12.7	0.41599	0.00048	0.41695	0.93680
athothp15kr_5	2.0	2.95	2.597	12.25	0.53930	0.00062	0.54054	0.93680
athothp15kr30_5	3.0	9.40	8.274	5.80	0.64230	0.00071	0.64372	0.93680
athothp15kr40_5	4.0	11.00	9.682	4.20	0.64063	0.00067	0.64197	0.93680
athothp15kr50_5	5.0	11.00	9.682	4.20	0.63153	0.00081	0.63315	0.93680
Saturated UO_2-ZrO_2								
athozrp15kr10_5	1.0	0.80	0.704	8.85	0.36338	0.00040	0.36418	0.93680
athozrp15kr15_5	1.5	0.95	0.836	13.50	0.39132	0.00044	0.39220	0.93680
athozrp15kr_1	2.0	1.75	1.540	13.45	0.48221	0.00057	0.48335	0.93680
athozrp15kr30_5	3.0	9.40	8.274	5.80	0.64670	0.00100	0.64870	0.93680
athozrp15kr40_5	4.0	11.00	9.682	4.20	0.64384	0.00074	0.64532	0.93680
athozrp15kr50_5	5.0	11.00	9.682	4.20	0.63428	0.00068	0.63564	0.93680
Saturated UO_2-thorium metal								
athothmp15kr10_5	1.0	1.35	1.188	8.30	0.43898	0.00055	0.44008	0.93680
athothmp15kr15_5	1.5	1.95	1.716	12.55	0.48989	0.00065	0.49119	0.93680
athothmp15kr_5	2.0	3.10	2.729	12.10	0.54412	0.00054	0.54520	0.93680
athothmp15kr30_5	3.0	9.35	8.230	5.85	0.64234	0.00070	0.64374	0.93680
athothmp15kr40_5	4.0	11.00	9.682	4.20	0.63998	0.00069	0.64136	0.93680
athothmp15kr50_5	5.0	11.00	9.682	4.20	0.63124	0.00071	0.63266	0.93680

Model 5 (Fig. 6.15, Sect. 6.3.1.4) is an extension of Model 3 applied to HEU product oxide contents. Excess water from wet Kaolite is homogenized with the spherical core of water-saturated HEU product oxide and polyethylene (Model 3), with a maximum of 12 lb free water from the Kaolite is evaluated. Since the HEU product oxide masses used in Model 1 for use in the calculations for Model 5 are well above the USL, parametric studies were performed to determine the highest HEU product oxide that is below the USL as were performed in Model 1. The results of these calculations for Cases **5athopw12kr*** (HEU oxide, Table 6.9.10.9-2), **athothpw12kr*** (HEU oxide and ThO_2, Table 6.9.10.9-4), **athozrpw12kr*** (HEU oxide and ZrO_2, Table 6.9.10.9-6), and **athothmpw12kr*** (HEU oxide and thorium metal, Table 6.9.10.9-8), calculate a range of oxide masses from 1.0 to 5.0 g/cm^3. The maximum oxide masses that are below the USL are found in Table 6.9.10.9. For the UO_2-ThO_2, UO_2-ZrO_2, and UO_2 thorium metal, HEU oxide for densities of 5.0 and 4.0 g/cm^3 were more reactive without the thorium and zirconium.

Table 6.9.10.9. Results for Model 5 air transport calculations

Case	Density (g/cm^3)	Oxide (kg)	^{235}U (kg)	ThO_2/ZrO_2/Th (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2								
5athopw12kr10_1_5	1.0	2.45	2.157	n/a	0.93370	0.00088	0.93546	0.93680
5athopw12kr15_1_5	1.5	3.15	2.772	n/a	0.93461	0.00091	0.93643	0.93680
5athopw12kr_1_5	2.0	3.85	3.389	n/a	0.93350	0.00110	0.93570	0.93680
5athopw12kr30_1_5	3.0	5.40	4.753	n/a	0.93473	0.00085	0.93643	0.93680
5athopw12kr40_1_5	4.0	6.85	6.029	n/a	0.93208	0.00077	0.93362	0.93520
5athopw12kr50_1_5	5.0	8.60	7.570	n/a	0.93240	0.00100	0.93440	0.93520
Saturated UO_2-ThO_2								
athothpw12kr10_3_2_5	1.0	1.65	1.452	8.00	0.93375	0.00088	0.93551	0.93680
athothpw12kr15_3_2_5	1.5	2.10	1.848	12.40	0.93155	0.00090	0.93335	0.93680
athothpw12kr_3_2_5	2.0	2.80	2.465	12.40	0.93388	0.00089	0.93566	0.93680
athothpw12kr30_3_2_5	3.0	5.10	4.489	10.10	0.93395	0.00086	0.93567	0.93680
athothpw12kr40_1_2_5	4.0	6.85	6.029	0.00	0.93351	0.00079	0.93509	0.93520
athothpw12kr50_1_2_5	5.0	8.60	7.57	0.00	0.93308	0.00082	0.93472	0.93520
Saturated UO_2-ZrO_2								
athozrpw12kr10_3_2_5	1.0	1.15	1.012	8.50	0.92962	0.00069	0.93100	0.93680
athozrpw12kr15_3_2_5	1.5	1.30	1.144	13.15	0.93220	0.00110	0.93440	0.93680
athozrpw12kr_3_2_5	2.0	1.70	1.496	13.50	0.93291	0.00098	0.93487	0.93680
athozrpw12kr30_3_2_5	3.0	3.55	3.128	11.65	0.93409	0.00087	0.93583	0.93680
athozrpw12kr40_1_2_5	4.0	6.85	6.029	0.00	0.93129	0.00082	0.93293	0.93520
athozrpw12kr50_1_2_5	5.0	8.60	7.57	0.00	0.93099	0.00084	0.93267	0.93520
Saturated UO_2-thorium metal								
athothmpw12kr10_3_2_5	1.0	1.75	1.540	7.90	0.93490	0.00079	0.93648	0.93680
athothmpw12kr15_3_2_5	1.5	2.25	1.981	12.25	0.93363	0.00071	0.93505	0.93680
athothmpw12kr_3_2_5	2.0	2.90	2.553	12.30	0.93239	0.00084	0.93407	0.93680
athothmpw12kr30_3_2_5	3.0	5.30	4.665	9.90	0.93133	0.00089	0.93311	0.93680
athothmpw12kr40_3_2_5	4.0	6.85	6.029	0.00	0.93332	0.00073	0.93478	0.93520
athothmpw12kr50_5	5.0	8.60	7.57	0.00	0.93340	0.00100	0.93540	0.93520

Model 6 (Fig. 6.16, Sect. 6.3.1.4) is configured similar to Model 4 with the exception that only a partial amount of HEU product oxide resides in the homogenized core; the remainder of the unsaturated HEU product oxide is modeled as a shell external to the spherical core and internal to the 20.0 cm thick water reflector. The oxide masses evaluated in Models 2 through 4 are calculated here.

For Model 6, Cases **5athop15kor*** (HEU oxide, Table 6.9.10.9-2), **athothp15kor*** (HEU oxide and ThO_2, Table 6.9.10.9-4), **athozrp15kor*** (HEU oxide and ZrO_2, Table 6.9.10.9-6), and **athothmp15kor*** (HEU oxide and thorium metal, Table 6.9.10.9-8), calculate a range of oxide masses from 1.0 to 5.0 g/cm^3. The maximum oxide masses that are below the USL are found in Tables 6.9.10.10a through 6.9.10.10d.

Table 6.9.10.10a. Results for saturated UO_2 Model 6 air transport calculations

Case	Density (g/cm^3)	Oxide core (kg)	Oxide shell (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
5athop15kor10_5_4_4	1.0	2.00	1.40	0.57224	0.00059	0.57342	0.93680
5athop15kor15_5_3_3	1.5	2.00	3.10	0.61700	0.00058	0.61816	0.93680
5athop15kor_5_3_3	2.0	3.00	3.00	0.62602	0.00067	0.62736	0.93680
5athop15kor30_5_3_3	3.0	4.00	6.40	0.67302	0.00086	0.67474	0.93680
5athop15kor40_5_3_3	4.0	5.00	8.65	0.68679	0.00064	0.68807	0.93680
5athop15kor50_5_2_2	5.0	3.00	13.60	0.69547	0.00069	0.69685	0.93680

Table 6.9.10.10b. Results for saturated UO_2-ThO_2 Model 6 air transport calculations

Case	Density (g/cm^3)	Oxide core (kg)	ThO_2 (kg)	Oxide shell (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athothp15kor10_5	1.0	1.00	8.35	0.30	0.43553	0.00050	0.43653	0.93680
athothp15kor15_5_3_3	1.5	1.35	12.70	0.45	0.48462	0.00056	0.48574	0.93680
athothp15kor_5_4_4	2.0	1.95	12.25	1.00	0.55467	0.00059	0.55585	0.93680
athothp15kor30_5_3_3	3.0	4.00	5.80	5.40	0.66930	0.00069	0.67068	0.93680
athothp15kor40_5_2_2	4.0	3.00	4.20	8.00	0.66783	0.00066	0.66915	0.93680
athothp15kor50_5_2_2	5.0	3.00	4.20	8.00	0.65860	0.00063	0.65986	0.93680

Table 6.9.10.10c. Results for saturated UO_2-ZrO_2 Model 6 air transport calculations

Case	Density (g/cm^3)	Oxide core (kg)	ZrO_2 (kg)	Oxide shell (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athozrp15kor10_5_3_3	1.0	0.60	8.85	0.20	0.36114	0.00048	0.36210	0.93680
athozrp15kor15_5_3_3	1.5	0.75	13.50	0.20	0.39026	0.00041	0.39108	0.93680
athozrp15kor_5_3_3	2.0	0.75	13.45	1.00	0.49029	0.00064	0.49157	0.93680
athozrp15kor30_5_3_3	3.0	4.00	5.80	5.40	0.67421	0.00069	0.67559	0.93680
athozrp15kor40_5_2_2	4.0	3.00	4.20	8.00	0.67022	0.00072	0.67166	0.93680
athozrp15kor50_5_2_2	5.0	3.00	4.20	8.00	0.66280	0.00072	0.66424	0.93680

Table 6.9.10.10d Results for Model 6 for Air Transport Calculations for Saturated UO_2-Thorium Metal

Case	Density (g/cm^3)	Oxide core (kg)	Th (kg)	Oxide shell (kg)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athothmp15kor10_5_3_3	1.0	1.00	8.30	0.35	0.44070	0.00059	0.44188	0.93680
athothmp15kor15_5_3_3	1.5	1.47	12.55	0.48	0.49665	0.00050	0.49765	0.93680
athothmp15kor_5_3_3	2.0	1.475	12.25	1.475	0.55539	0.00057	0.55653	0.93680
athothmp15kor30_5_3_3	3.0	4.00	5.85	5.35	0.66820	0.00062	0.66944	0.93680
athothmp15kor40_5_3_3	4.0	5.00	4.20	6.00	0.66777	0.00067	0.66911	0.93680
athothmp15kor50_5_2_2	5.0	3.00	4.20	8.00	0.65847	0.00066	0.65979	0.93680

The bounding model for the air transport of HEU oxide is Model 5 (Table 6.9.10.9), which was shown to be significantly more reactive than the other models. For oxides with ThO_2, ZrO_2, and thorium metal, the bounding model for the air transport of oxides is Model 5 (Table 6.9.10.9) for densities down to 2.0 g/cm^3 and Model 1 (Table 6.9.10.4) for densities of 1.5 and 1.0 g/cm^3.

6.9.10.8 Benchmark Experiments and the Criticality Validation

This information is discussed in Sect. 6.9.8.7. The USL is 0.924 for calculations run using SCALE 5. For the updated cases for 1.0, 1.5, 3.0 through 5.0 g/cm^3 for Models 1 through 6 and 2.0 g/cm^3 for Models 4, 5, and 6, the benchmark experiments and criticality validation is discussed in Appendix 6.9.10.

6.9.10.9 Calculation Results Tables for HEU Product Oxide Contents for Air Transport

Tables 6.9.10.9-1 and 6.9.10.9-2 contain a summary of the calculation results for the HEU product oxide contents to be shipped by air transport as contents in the ES-3100 shipping package.

Table 6.9.10.9-1. Results for HEU oxide content for air transportation (Models 1–3)

Case	Core							Shell				NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	Oxide (g)	^{235}U (g)	H_2O (g)	CH_2 (g)	Kaolite (g)	h/x	Rc (cm)	Kaolite (g)	H_2O (g)	Shell (g)	Rs (cm)				
Compromised package, HEU-poly core in spherical configuration, 20.0 cm water reflector (Model 1)															
Saturated UO_2 at 6.54 g/cm^3															
5atdor_1_5_14	14,000	12,323	861.8	500	na	3.19	8.6213	na	na	na	na	0.0633	0.86843	0.00141	0.87125
5atdor_1_5_13	13,000	11,443	800.2	500	na	3.29	8.4544	na	na	na	na	0.0637	0.85690	0.00144	0.85978
5atdor_1_5_12	12,000	10,562	738.6	500	na	3.41	8.2806	na	na	na	na	0.0645	0.84384	0.00137	0.84658
5atdor_1_5_11	11,000	9,682	677.1	500	na	3.56	8.0992	na	na	na	na	0.0651	0.83277	0.00119	0.83515
5atdor_1_5_10	10,000	8,802	615.5	500	na	3.73	7.9093	na	na	na	na	0.0660	0.81625	0.00152	0.81929
5atdor_1_5_9	9,000	7,922	554.0	500	na	3.94	7.7098	na	na	na	na	0.0677	0.80044	0.00135	0.80314
5atdor_1_5_8	8,000	7,042	492.4	500	na	4.21	7.4994	na	na	na	na	0.0690	0.78520	0.00157	0.78834
5atdor_1_5_7	7,000	6,162	430.9	500	na	4.55	7.2765	na	na	na	na	0.0702	0.76642	0.00132	0.76906
5atdor_1_5_6	6,000	5,281	369.3	500	na	5.00	7.0390	na	na	na	na	0.0715	0.74917	0.00114	0.75145
Saturated UO_2, density increasing from 2.0 to 6.54 g/cm^3 in 1 g/cm^3 increments															
5atdor_1_1_6	6,000	5,281	2,448.1	500	na	15.27	9.4576	na	na	na	na	0.0557	0.91417	0.00131	0.91679
5atdor_1_2_6	6,000	5,281	1,449.9	500	na	10.34	8.4680	na	na	na	na	0.0616	0.84504	0.00131	0.84766
5atdor_1_3_6	6,000	5,281	950.8	500	na	7.87	7.8722	na	na	na	na	0.0655	0.80424	0.00143	0.80710
5atdor_1_4_6	6,000	5,281	651.4	500	na	6.39	7.4664	na	na	na	na	0.0684	0.77776	0.00140	0.78056
5atdor_1_5_6	6,000	5,281	369.3	500	na	5.00	7.0390	na	na	na	na	0.0715	0.74917	0.00114	0.75145
Saturated U_3O_8, density increasing from 2.0 to 6.54 g/cm^3 in 1 g/cm^3 increments															
5atdor_2_1_6	6,000	5,078	2,273.0	500	na	14.98	9.4576	na	na	na	na	0.0579	0.88563	0.00150	0.88863
5atdor_2_2_6	6,000	5,078	1,274.8	500	na	9.85	8.4680	na	na	na	na	0.0637	0.81028	0.00142	0.81312
5atdor_2_3_6	6,000	5,078	775.7	500	na	7.29	7.8722	na	na	na	na	0.0689	0.76364	0.00147	0.76658
5atdor_2_4_6	6,000	5,078	476.2	500	na	5.75	7.4664	na	na	na	na	0.0714	0.73359	0.00133	0.73625
5atdor_2_5_6	6,000	5,078	194.2	500	na	4.30	7.0390	na	na	na	na	0.0751	0.69773	0.00112	0.69997

Table 6.9.10.9-1. Results for HEU oxide content for air transportation (Models 1–3)

Case	Core							Shell				NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	Oxide (g)	^{235}U (g)	H_2O (g)	CH_2 (g)	Kaolite (g)	h/x	Rc (cm)	Kaolite (g)	H_2O (g)	Shell (g)	Rs (cm)				
Saturated UO_3, density increasing from 2.0 to 6.54 g/cm^3 in 1 g/cm^3 increments															
5atdor_3_1_6	6,000	4,983	2,173.0	500	na	14.75	9.4576	na	na	na	na	0.0582	0.87189	0.00138	0.87465
5atdor_3_2_6	6,000	4,983	1,174.8	500	na	9.52	8.4680	na	na	na	na	0.0647	0.79330	0.00132	0.79594
5atdor_3_3_6	6,000	4,983	675.7	500	na	6.91	7.8722	na	na	na	na	0.0695	0.74451	0.00130	0.74711
5atdor_3_4_6	6,000	4,983	376.3	500	na	5.34	7.4664	na	na	na	na	0.0735	0.70743	0.00127	0.70997
5atdor_3_5_6	6,000	4,983	94.2	500	na	3.86	7.0390	na	na	na	na	0.0774	0.66826	0.00120	0.67066
Saturated UO_2 at 2.0 g/cm^3															
5atdor_1_1_14	14,000	12,323	5,712.4	500	na	13.46	12.1664	na	na	na	na	0.0449	1.06986	0.00138	1.07262
5atdor_1_1_13	13,000	11,443	5,304.4	500	na	13.56	11.8915	na	na	na	na	0.0462	1.05375	0.00152	1.05679
5atdor_1_1_12	12,000	10,562	4,896.3	500	na	13.69	11.6031	na	na	na	na	0.0470	1.04068	0.00156	1.04380
5atdor_1_1_11	11,000	9,682	4,488.3	500	na	13.83	11.2997	na	na	na	na	0.0478	1.02468	0.00141	1.02750
5atdor_1_1_10	10,000	8,802	4,080.3	500	na	14.00	10.9791	na	na	na	na	0.0493	1.00466	0.00125	1.00716
5atdor_1_1_9	9,000	7,922	3,672.2	500	na	14.22	10.6385	na	na	na	na	0.0507	0.98663	0.00148	0.98959
5atdor_1_1_8	8,000	7,042	3,264.2	500	na	14.48	10.2740	na	na	na	na	0.0527	0.96167	0.00137	0.96441
5atdor_1_1_7	7,000	6,162	2,856.2	500	na	14.82	9.8831	na	na	na	na	0.0542	0.93946	0.00158	0.94262
5atdor_1_1_6	6,000	5,281	2,448.1	500	na	15.27	9.4576	na	na	na	na	0.0557	0.91417	0.00131	0.91679
Compromised package, HEU-poly core in spherical configuration, stainless-steel shell, 20.0 cm water reflector (Model 2)															
Saturated UO_2at 2.0 g/cm^3, steel from full amount in the packaging (66,113 g) to none															
5atdosr_11	6,000	5,281	2,448.1	500	na	15.27	9.4576	na	na	66,133	14.1521	0.0292	0.89162	0.00136	0.89434
5atdosr_10	6,000	5,281	2,448.1	500	na	15.27	9.4576	na	na	59,520	13.8131	0.0301	0.88373	0.00183	0.88739
5atdosr_9	6,000	5,281	2,448.1	500	na	15.27	9.4576	na	na	52,907	13.4566	0.0313	0.88073	0.00128	0.88329
5atdosr_8	6,000	5,281	2,448.1	500	na	15.27	9.4576	na	na	46,293	13.0802	0.0330	0.87977	0.00157	0.88291
5atdosr_7	6,000	5,281	2,448.1	500	na	15.27	9.4576	na	na	39,680	12.6807	0.0347	0.87051	0.00153	0.87357
5atdosr_6	6,000	5,281	2,448.1	500	na	15.27	9.4576	na	na	33,067	12.2543	0.0367	0.86825	0.00149	0.87123
5atdosr_5	6,000	5,281	2,448.1	500	na	15.27	9.4576	na	na	26,453	11.7960	0.0393	0.86201	0.00170	0.86541

Table 6.9.10.9-1. Results for HEU oxide content for air transportation (Models 1–3)

Case	Core							Shell				NLF	k_{eff}	σ	$k_{eff} + 2\sigma$
	Oxide (g)	^{235}U (g)	H_2O (g)	CH_2 (g)	Kaolite (g)	h/x	Rc (cm)	Kaolite (g)	H_2O (g)	Shell (g)	Rs (cm)				
5atdosr_4	6,000	5,281	2,448.1	500	na	15.27	9.4576	na	na	19,840	11.2990	0.0420	0.85884	0.00223	0.86330
5atdosr_3	6,000	5,281	2,448.1	500	na	15.27	9.4576	na	na	13,227	10.7539	0.0461	0.86209	0.00210	0.86629
5atdosr_2	6,000	5,281	2,448.1	500	na	15.27	9.4576	na	na	6,613	10.1472	0.0499	0.87559	0.00144	0.87847
5atdosr_1	6,000	5,281	2,448.1	500	na	15.27	9.4576	na	na	0	9.4577	0.0557	0.91194	0.00135	0.91464
Compromised package, HEU-poly core in spherical configuration, dry (bound water) Kaolite shell, 20.0 cm water reflector (Model 3)															
Saturated UO_2 at 2.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none															
5atdodkr_6	6,000	5,281	2,448.1	500	na	15.27	9.4576	51,214.3	2,204.8	53,419.1	31.2952	0.0420	0.71552	0.00154	0.71860
5atdodkr_5	6,000	5,281	2,448.1	500	na	15.27	9.4576	40,971.5	1,763.8	42,735.3	29.1186	0.0435	0.72104	0.00132	0.72368
5atdodkr_4	6,000	5,281	2,448.1	500	na	15.27	9.4576	30,728.6	1,322.9	32,051.5	26.5564	0.0451	0.72819	0.00126	0.73071
5atdodkr_3	6,000	5,281	2,448.1	500	na	15.27	9.4576	20,485.7	881.9	21,367.6	23.3725	0.0476	0.74581	0.00142	0.74865
5atdodkr_2	6,000	5,281	2,448.1	500	na	15.27	9.4576	10,242.9	440.9	10,683.8	18.9517	0.0514	0.77362	0.00188	0.77738
5atdodkr_1	6,000	5,281	2,448.1	500	na	15.27	9.4576	0.0	0.0	0.0	9.4577	0.0556	0.91160	0.00180	0.91520
Compromised package, HEU-poly core in sph. config., wet (bound plus 15-lb free water) Kaolite shell, 20.0 cm water reflector (Model 3)															
Saturated UO_2 oxide at 2.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none															
5atdo15kr_6	6,000	5,281	2,448.1	500	na	15.27	9.4576	51,214.3	9,008.7	60,223.0	31.2952	0.0352	0.72501	0.00179	0.72859
5atdo15kr_5	6,000	5,281	2,448.1	500	na	15.27	9.4576	40,971.5	7,206.9	48,178.4	29.1186	0.0371	0.73185	0.00123	0.73431
5atdo15kr_4	6,000	5,281	2,448.1	500	na	15.27	9.4576	30,728.6	5,405.2	36,133.8	26.5564	0.0394	0.73706	0.00135	0.73976
5atdo15kr_3	6,000	5,281	2,448.1	500	na	15.27	9.4576	20,485.7	3,603.5	24,089.2	23.3725	0.0424	0.74768	0.00162	0.75092
5atdo15kr_2	6,000	5,281	2,448.1	500	na	15.27	9.4576	10,242.9	1,801.7	12,044.6	18.9517	0.0474	0.77452	0.00119	0.77690
5atdo15kr_1	6,000	5,281	2,448.1	500	na	15.27	9.4576	0.0	0.0	0.0	9.45770	0.0561	0.91134	0.00212	0.91558

Table 6.9.10.9-2. Results for HEU oxide content for air transportation (Models 1–5)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Kaolite (g)	H_2O (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Compromised package, HEU-poly core in spherical configuration, 20.0-cm water reflector (Model 1)												
Saturated UO_2 at 5.0 g/cm^3												
5atdor50_1	8,600	7,570	934	na	8.14509	na	na	na	0.82662	0.00073	0.82808	0.93520
5atdor50_2	13,000	11,443	1,411	na	9.08742	na	na	na	0.89184	0.00067	0.89318	0.93520
5atdor50_3	16,550	14,567	1,797	na	9.72571	na	na	na	0.93245	0.00082	0.93409	0.93520
5atdor50_4	16,600	14,611	1,802	na	9.73412	na	na	na	0.93283	0.00064	0.93411	0.93520
5atdor50_5	16,650	14,655	1,808	na	9.74251	na	na	na	0.93466	0.00068	0.93602	0.93520
5atdor50_6	17,000	14,964	1,846	na	9.80085	na	na	na	0.93785	0.00078	0.93941	0.93520
5atdor50_7	18,000	15,844	1,954	na	9.96381	na	na	na	0.94796	0.00073	0.94942	0.93520
Saturated UO_2 at 4.0 g/cm^3												
5atdor40_1	6,850	6,029	1,086	na	8.13608	na	na	na	0.82230	0.00065	0.82360	0.93520
5atdor40_2	11,000	9,682	1,743	na	9.22972	na	na	na	0.89699	0.00081	0.89861	0.93520
5atdor40_3	13,600	11,971	2,155	na	9.80085	na	na	na	0.93261	0.00082	0.93425	0.93520
5atdor40_4	13,650	12,015	2,163	na	9.81119	na	na	na	0.93279	0.00070	0.93419	0.93520
5atdor40_5	13,700	12,059	2,171	na	9.82151	na	na	na	0.93558	0.00090	0.93738	0.93520
5atdor40_6	14,000	12,323	2,219	na	9.88300	na	na	na	0.93694	0.00067	0.93828	0.93520
5atdor40_7	15,000	13,203	2,377	na	10.08262	na	na	na	0.94989	0.00073	0.95135	0.93520
Saturated UO_2 at 3.0 g/cm^3												
5atdor30_1	5,400	4,753	1,305	na	8.23994	na	na	na	0.82635	0.00069	0.82773	0.93520
5atdor30_2	8,000	7,042	1,933	na	9.15121	na	na	na	0.88792	0.00079	0.88950	0.93520
5atdor30_3	10,350	9,110	2,501	na	9.84210	na	na	na	0.93261	0.00071	0.93403	0.93520
5atdor30_4	10,400	9,154	2,513	na	9.85577	na	na	na	0.93334	0.00076	0.93486	0.93520
5atdor30_5	10,450	9,198	2,525	na	9.86940	na	na	na	0.93506	0.00081	0.93668	0.93520
5atdor30_6	10,750	9,462	2,598	na	9.95043	na	na	na	0.93955	0.00070	0.94095	0.93520
5atdor30_7	11,000	9,682	2,658	na	10.01696	na	na	na	0.94411	0.00084	0.94579	0.93520

Table 6.9.10.9-2. Results for HEU oxide content for air transportation (Models 1–5)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Kaolite (g)	H_2O (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2 at 1.5 g/cm^3												
5atdor15_1	4,900	4,313	2,814	na	9.68912	na	na	na	0.92632	0.00079	0.92790	0.93520
5atdor15_2	4,950	4,357	2,843	na	9.71729	na	na	na	0.92819	0.00074	0.92967	0.93520
5atdor15_3	5,000	4,401	2,872	na	9.74530	na	na	na	0.92891	0.00077	0.93045	0.93520
5atdor15_4	5,050	4,445	2,900	na	9.77315	na	na	na	0.93012	0.00077	0.93166	0.93520
5atdor15_5	5,100	4,489	2,929	na	9.80085	na	na	na	0.93347	0.00076	0.93499	0.93520
5atdor15_6	5,150	4,533	2,958	na	9.82838	na	na	na	0.93505	0.00075	0.93655	0.93520
5atdor15_7	5,200	4,577	2,986	na	9.85577	na	na	na	0.93773	0.00071	0.93915	0.93520
Saturated UO_2 at 1.0 g/cm^3												
5atdor10_1	3,150	2,772	2,857	na	9.58920	na	na	na	0.91846	0.00079	0.92004	0.93680
5atdor10_2	3,200	2,816	2,902	na	9.63228	na	na	na	0.92182	0.00074	0.92330	0.93680
5atdor10_3	3,250	2,860	2,948	na	9.67497	na	na	na	0.92565	0.00079	0.92723	0.93680
5atdor10_4	3,300	2,904	2,993	na	9.71729	na	na	na	0.92731	0.00086	0.92903	0.93680
5atdor10_5	3,350	2,948	3,038	na	9.75925	na	na	na	0.92962	0.00082	0.93126	0.93680
5atdor10_6	3,400	2,992	3,084	na	9.80085	na	na	na	0.93289	0.00074	0.93437	0.93680
5atdor10_7	3,450	3,037	3,129	na	9.84210	na	na	na	0.93544	0.00078	0.93700	0.93680
Compromised package, HEU-poly core in spherical configuration, stainless-steel shell, 20.0-cm water reflector (Model 2)												
Saturated UO_2 at 5.0 g/cm^3												
5atdosr50_11	16,600	14,611	1,802	na	9.73412	na	na	14.27816	0.90294	0.00079	0.90452	0.93520
5atdosr50_10	16,600	14,611	1,802	na	9.73412	na	na	13.94533	0.89831	0.00078	0.89987	0.93520
5atdosr50_9	16,600	14,611	1,802	na	9.73412	na	na	13.59582	0.89526	0.00071	0.89668	0.93520
5atdosr50_8	16,600	14,611	1,802	na	9.73412	na	na	13.22734	0.89198	0.00072	0.89342	0.93520
5atdosr50_7	16,600	14,611	1,802	na	9.73412	na	na	12.83711	0.88895	0.00078	0.89051	0.93520
5atdosr50_6	16,600	14,611	1,802	na	9.73412	na	na	12.42159	0.88426	0.00084	0.88594	0.93520
5atdosr50_5	16,600	14,611	1,802	na	9.73412	na	na	11.97623	0.88253	0.00075	0.88403	0.93520

Table 6.9.10.9-2. Results for HEU oxide content for air transportation (Models 1–5)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Kaolite (g)	H_2O (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
5atdosr50_4	16,600	14,611	1,802	na	9.73412	na	na	11.49503	0.88307	0.00068	0.88443	0.93520
5atdosr50_3	16,600	14,611	1,802	na	9.73412	na	na	10.96978	0.88663	0.00066	0.88795	0.93520
5atdosr50_2	16,600	14,611	1,802	na	9.73412	na	na	10.38874	0.90326	0.00069	0.90464	0.93520
5atdosr50_1	16,600	14,611	1,802	na	9.73412	na	na	9.73422	0.93298	0.00071	0.93440	0.93520
Saturated UO_2 at 4.0 g/cm^3												
5atdosr40_11	13,650	12,015	2,163	na	9.81119	na	na	14.31417	0.90332	0.00081	0.90494	0.93520
5atdosr40_10	13,650	12,015	2,163	na	9.81119	na	na	13.98308	0.90050	0.00074	0.90198	0.93520
5atdosr40_9	13,650	12,015	2,163	na	9.81119	na	na	13.63552	0.89708	0.00075	0.89858	0.93520
5atdosr40_8	13,650	12,015	2,163	na	9.81119	na	na	13.26928	0.89164	0.00067	0.89298	0.93520
5atdosr40_7	13,650	12,015	2,163	na	9.81119	na	na	12.88162	0.88951	0.00064	0.89079	0.93520
5atdosr40_6	13,650	12,015	2,163	na	9.81119	na	na	12.46911	0.88456	0.00072	0.88600	0.93520
5atdosr40_5	13,650	12,015	2,163	na	9.81119	na	na	12.02733	0.88267	0.00068	0.88403	0.93520
5atdosr40_4	13,650	12,015	2,163	na	9.81119	na	na	11.55047	0.88235	0.00072	0.88379	0.93520
5atdosr40_3	13,650	12,015	2,163	na	9.81119	na	na	11.03061	0.88814	0.00077	0.88968	0.93520
5atdosr40_2	13,650	12,015	2,163	na	9.81119	na	na	10.45650	0.90239	0.00064	0.90367	0.93520
5atdosr40_1	13,650	12,015	2,163	na	9.81119	na	na	9.81129	0.93327	0.00074	0.93475	0.93520
Saturated UO_2 at 3.0 g/cm^3												
5atdosr30_11	10,400	9,154	2,513	na	9.85577	na	na	14.33518	0.90576	0.00071	0.90718	0.93520
5atdosr30_10	10,400	9,154	2,513	na	9.85577	na	na	14.00509	0.90194	0.00085	0.90364	0.93520
5atdosr30_9	10,400	9,154	2,513	na	9.85577	na	na	13.65867	0.89756	0.00070	0.89896	0.93520
5atdosr30_8	10,400	9,154	2,513	na	9.85577	na	na	13.29372	0.89353	0.00089	0.89531	0.93520
5atdosr30_7	10,400	9,154	2,513	na	9.85577	na	na	12.90755	0.89053	0.00078	0.89209	0.93520
5atdosr30_6	10,400	9,154	2,513	na	9.85577	na	na	12.49677	0.88688	0.00076	0.88840	0.93520
5atdosr30_5	10,400	9,154	2,513	na	9.85577	na	na	12.05706	0.88408	0.00075	0.88558	0.93520
5atdosr30_4	10,400	9,154	2,513	na	9.85577	na	na	11.58269	0.88365	0.00073	0.88511	0.93520

Table 6.9.10.9-2. Results for HEU oxide content for air transportation (Models 1–5)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Kaolite (g)	H_2O (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
5atdosr30_3	10,400	9,154	2,513	na	9.85577	na	na	11.06592	0.88926	0.00079	0.89084	0.93520
5atdosr30_2	10,400	9,154	2,513	na	9.85577	na	na	10.49577	0.90249	0.00070	0.90389	0.93520
5atdosr30_1	10,400	9,154	2,513	na	9.85577	na	na	9.85587	0.93306	0.00084	0.93474	0.93520
Saturated UO_2 at 1.5 g/cm^3												
5atdosr15_11	5,100	4,489	2,929	na	9.80085	na	na	14.30932	0.90646	0.00070	0.90786	0.93520
5atdosr15_10	5,100	4,489	2,929	na	9.80085	na	na	13.97799	0.90340	0.00073	0.90486	0.93520
5atdosr15_9	5,100	4,489	2,929	na	9.80085	na	na	13.63017	0.89878	0.00068	0.90014	0.93520
5atdosr15_8	5,100	4,489	2,929	na	9.80085	na	na	13.26363	0.89573	0.00082	0.89737	0.93520
5atdosr15_7	5,100	4,489	2,929	na	9.80085	na	na	12.87562	0.89040	0.00079	0.89198	0.93520
5atdosr15_6	5,100	4,489	2,929	na	9.80085	na	na	12.46271	0.88540	0.00078	0.88696	0.93520
5atdosr15_5	5,100	4,489	2,929	na	9.80085	na	na	12.02045	0.88142	0.00080	0.88302	0.93520
5atdosr15_4	5,100	4,489	2,929	na	9.80085	na	na	11.54301	0.87994	0.00073	0.88140	0.93520
5atdosr15_3	5,100	4,489	2,929	na	9.80085	na	na	11.02243	0.88397	0.00069	0.88535	0.93520
5atdosr15_2	5,100	4,489	2,929	na	9.80085	na	na	10.44739	0.89672	0.00079	0.89830	0.93520
5atdosr15_1	5,100	4,489	2,929	na	9.80085	na	na	9.80095	0.93317	0.00087	0.93491	0.93520
Saturated UO_2 at 1.0 g/cm^3												
5atdosr10_11	3,400	2,992	3,084	na	9.80085	na	na	14.30932	0.90891	0.00089	0.91069	0.93520
5atdosr10_10	3,400	2,992	3,084	na	9.80085	na	na	13.97799	0.90435	0.00078	0.90591	0.93520
5atdosr10_9	3,400	2,992	3,084	na	9.80085	na	na	13.63017	0.89900	0.00083	0.90066	0.93520
5atdosr10_8	3,400	2,992	3,084	na	9.80085	na	na	13.26363	0.89606	0.00077	0.89760	0.93520
5atdosr10_7	3,400	2,992	3,084	na	9.80085	na	na	12.87562	0.89036	0.00086	0.89208	0.93520
5atdosr10_6	3,400	2,992	3,084	na	9.80085	na	na	12.46271	0.88560	0.00077	0.88714	0.93520
5atdosr10_5	3,400	2,992	3,084	na	9.80085	na	na	12.02045	0.88169	0.00078	0.88325	0.93520
5atdosr10_4	3,400	2,992	3,084	na	9.80085	na	na	11.54301	0.87829	0.00083	0.87995	0.93520
5atdosr10_3	3,400	2,992	3,084	na	9.80085	na	na	11.02243	0.88183	0.00091	0.88365	0.93520

Table 6.9.10.9-2. Results for HEU oxide content for air transportation (Models 1–5)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Kaolite (g)	H_2O (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
5atdosr10_2	3,400	2,992	3,084	na	9.80085	na	na	10.44739	0.89338	0.00082	0.89502	0.93520
5atdosr10_1	3,400	2,992	3,084	na	9.80085	na	na	9.80095	0.93367	0.00085	0.93537	0.93680
Compromised package, HEU-poly core in spherical configuration, dry (bound water) Kaolite shell, 20.0 cm water reflector (Model 3)												
Saturated UO_2 at 5.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none												
5atdodkr50_6	16,600	14,611	1,802	na	9.73412	51,214.3	2,204.8	31.32122	0.75792	0.00064	0.75920	0.93520
5atdodkr50_5	16,600	14,611	1,802	na	9.73412	40,971.5	1,763.8	29.14860	0.76473	0.00066	0.76605	0.93520
5atdodkr50_4	16,600	14,611	1,802	na	9.73412	30,728.6	1,322.9	26.59241	0.77254	0.00081	0.77416	0.93520
5atdodkr50_3	16,600	14,611	1,802	na	9.73412	20,485.7	881.9	23.41899	0.78712	0.00070	0.78852	0.93520
5atdodkr50_2	16,600	14,611	1,802	na	9.73412	10,242.9	440.9	19.02237	0.81478	0.00078	0.81634	0.93520
5atdodkr50_1	16,600	14,611	1,802	na	9.73412	0	0	9.73422	0.93252	0.00067	0.93386	0.93520
Saturated UO_2 at 4.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none												
5atdodkr40_6	13,650	12,015	2,163	na	9.81119	51,214.3	2,204.8	31.32872	0.75702	0.00075	0.75852	0.93520
5atdodkr40_5	13,650	12,015	2,163	na	9.81119	40,971.5	1,763.8	29.15726	0.76146	0.00068	0.76282	0.93520
5atdodkr40_4	13,650	12,015	2,163	na	9.81119	30,728.6	1,322.9	26.60282	0.77079	0.00081	0.77241	0.93520
5atdodkr40_3	13,650	12,015	2,163	na	9.81119	20,485.7	881.9	23.43241	0.78470	0.00067	0.78604	0.93520
5atdodkr40_2	13,650	12,015	2,163	na	9.81119	10,242.9	440.9	19.04270	0.81373	0.00074	0.81521	0.93520
5atdodkr40_1	13,650	12,015	2,163	na	9.81119	0	0	9.81129	0.93373	0.00066	0.93505	0.93520
Saturated UO_2 at 3.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none												
5atdodkr30_6	10,400	9,154	2,513	na	9.85577	51,214.3	2,204.8	31.33311	0.75332	0.00076	0.75484	0.93520
5atdodkr30_5	10,400	9,154	2,513	na	9.85577	40,971.5	1,763.8	29.16233	0.75806	0.00075	0.75956	0.93520
5atdodkr30_4	10,400	9,154	2,513	na	9.85577	30,728.6	1,322.9	26.60891	0.76789	0.00069	0.76927	0.93520
5atdodkr30_3	10,400	9,154	2,513	na	9.85577	20,485.7	881.9	23.44026	0.78188	0.00078	0.78344	0.93520
5atdodkr30_2	10,400	9,154	2,513	na	9.85577	10,242.9	440.9	19.05458	0.80961	0.00066	0.81093	0.93520
5atdodkr30_1	10,400	9,154	2,513	na	9.85577	0	0	9.85587	0.93258	0.00092	0.93442	0.93520

Table 6.9.10.9-2. Results for HEU oxide content for air transportation (Models 1–5)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Kaolite (g)	H_2O (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2 at 1.5 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none												
5atdodkr15_6	5,100	4,489	2,929	na	9.80085	51,214.3	2,204.8	31.32771	0.73967	0.00088	0.74143	0.93520
5atdodkr15_5	5,100	4,489	2,929	na	9.80085	40,971.5	1,763.8	29.15609	0.74636	0.00088	0.74812	0.93520
5atdodkr15_4	5,100	4,489	2,929	na	9.80085	30,728.6	1,322.9	26.60141	0.75489	0.00086	0.75661	0.93520
5atdodkr15_3	5,100	4,489	2,929	na	9.80085	20,485.7	881.9	23.43060	0.76972	0.00081	0.77134	0.93520
5atdodkr15_2	5,100	4,489	2,929	na	9.80085	10,242.9	440.9	19.03995	0.79950	0.00071	0.80092	0.93520
5atdodkr15_1	5,100	4,489	2,929	na	9.80085	0	0	9.80095	0.93271	0.00079	0.93429	0.93520
Saturated UO_2 at 1.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none												
5atdodkr10_6	3,400	2,992	3,084	na	9.80085	51,214.3	2,204.8	31.32771	0.73504	0.00097	0.73698	0.93520
5atdodkr10_5	3,400	2,992	3,084	na	9.80085	40,971.5	1,763.8	29.15609	0.74176	0.00083	0.74342	0.93520
5atdodkr10_4	3,400	2,992	3,084	na	9.80085	30,728.6	1,322.9	26.60141	0.74910	0.00095	0.75100	0.93520
5atdodkr10_3	3,400	2,992	3,084	na	9.80085	20,485.7	881.9	23.43060	0.76379	0.00077	0.76533	0.93520
5atdodkr10_2	3,400	2,992	3,084	na	9.80085	10,242.9	440.9	19.03995	0.79358	0.00084	0.79526	0.93520
5atdodkr10_1	3,400	2,992	3,084	na	9.80085	0	0	9.80095	0.93450	0.00092	0.93634	0.93680
Compromised package, HEU-poly core in sph. config., wet (bound plus 15-lb free water) Kaolite shell, 20.0-cm water reflector (Model 3)												
Saturated UO_2 at 5.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none												
5atdo15kr50_6	16,600	14,611	1,802	na	9.73412	51,214.3	9,008.7	31.32122	0.76744	0.00077	0.76898	0.93520
5atdo15kr50_5	16,600	14,611	1,802	na	9.73412	40,971.5	7,206.9	29.14860	0.77197	0.00076	0.77349	0.93520
5atdo15kr50_4	16,600	14,611	1,802	na	9.73412	30,728.6	5,405.2	26.59241	0.77881	0.00073	0.78027	0.93520
5atdo15kr50_3	16,600	14,611	1,802	na	9.73412	20,485.7	3,603.5	23.41899	0.79051	0.00079	0.79209	0.93520
5atdo15kr50_2	16,600	14,611	1,802	na	9.73412	10,242.9	1,801.7	19.02237	0.81608	0.00070	0.81748	0.93520
5atdo15kr50_1	16,600	14,611	1,802	na	9.73412	0	0	9.73422	0.93349	0.00070	0.93489	0.93520
Saturated UO_2 at 4.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none												
5atdo15kr40_6	13,650	12,015	2,163	na	9.81119	51,214.3	9,008.7	31.32872	0.76566	0.00075	0.76716	0.93520
5atdo15kr40_5	13,650	12,015	2,163	na	9.81119	40,971.5	7,206.9	29.15726	0.77116	0.00080	0.77276	0.93520

Table 6.9.10.9-2. Results for HEU oxide content for air transportation (Models 1–5)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Kaolite (g)	H_2O (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
5atdo15kr40_4	13,650	12,015	2,163	na	9.81119	30,728.6	5,405.2	26.60282	0.77743	0.00084	0.77911	0.93520
5atdo15kr40_3	13,650	12,015	2,163	na	9.81119	20,485.7	3,603.5	23.43241	0.78986	0.00073	0.79132	0.93520
5atdo15kr40_2	13,650	12,015	2,163	na	9.81119	10,242.9	1,801.7	19.04270	0.81468	0.00083	0.81634	0.93520
5atdo15kr40_1	13,650	12,015	2,163	na	9.81119	0	0	9.81129	0.93485	0.00084	0.93653	0.93520
Saturated UO_2 at 3.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none												
5atdo15kr30_6	10,400	9,154	2,513	na	9.85577	51,214.3	9,008.7	31.33311	0.76021	0.00073	0.76167	0.93520
5atdo15kr30_5	10,400	9,154	2,513	na	9.85577	40,971.5	7,206.9	29.16233	0.76717	0.00093	0.76903	0.93520
5atdo15kr30_4	10,400	9,154	2,513	na	9.85577	30,728.6	5,405.2	26.60891	0.77406	0.00077	0.77560	0.93520
5atdo15kr30_3	10,400	9,154	2,513	na	9.85577	20,485.7	3,603.5	23.44026	0.78740	0.00062	0.78864	0.93520
5atdo15kr30_2	10,400	9,154	2,513	na	9.85577	10,242.9	1,801.7	19.05458	0.81285	0.00075	0.81435	0.93520
5atdo15kr30_1	10,400	9,154	2,513	na	9.85577	0	0	9.85587	0.93292	0.00075	0.93442	0.93520
Saturated UO_2 at 1.5 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none												
5atdo15kr15_6	5,100	4,489	2,929	na	9.80085	51,214.3	9,008.7	31.32771	0.75068	0.00073	0.75214	0.93520
5atdo15kr15_5	5,100	4,489	2,929	na	9.80085	40,971.5	7,206.9	29.15609	0.75495	0.00075	0.75645	0.93520
5atdo15kr15_4	5,100	4,489	2,929	na	9.80085	30,728.6	5,405.2	26.60141	0.76294	0.00075	0.76444	0.93520
5atdo15kr15_3	5,100	4,489	2,929	na	9.80085	20,485.7	3,603.5	23.43060	0.77355	0.00077	0.77509	0.93520
5atdo15kr15_2	5,100	4,489	2,929	na	9.80085	10,242.9	1,801.7	19.03995	0.80163	0.00084	0.80331	0.93520
5atdo15kr15_1	5,100	4,489	2,929	na	9.80085	0	0	9.80095	0.93220	0.00087	0.93394	0.93520
Saturated UO_2 at 1.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none												
5atdo15kr10_6	3,400	2,992	3,084	na	9.80085	51,214.3	9,008.7	31.32771	0.74769	0.00075	0.74919	0.93520
5atdo15kr10_5	3,400	2,992	3,084	na	9.80085	40,971.5	7,206.9	29.15609	0.75230	0.00083	0.75396	0.93520
5atdo15kr10_4	3,400	2,992	3,084	na	9.80085	30,728.6	5,405.2	26.60141	0.76048	0.00077	0.76202	0.93520
5atdo15kr10_3	3,400	2,992	3,084	na	9.80085	20,485.7	3,603.5	23.43060	0.77120	0.00068	0.77256	0.93520
5atdo15kr10_2	3,400	2,992	3,084	na	9.80085	10,242.9	1,801.7	19.03995	0.79833	0.00072	0.79977	0.93520
5atdo15kr10_1	3,400	2,992	3,084	na	9.80085	0	0	9.80095	0.93347	0.00076	0.93499	0.93680

Table 6.9.10.9-2. Results for HEU oxide content for air transportation (Models 1–5)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Kaolite (g)	H_2O (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Compromised package, homogeneous fixed-radius core [HEU, poly, wet Kaolite], 20.0 cm water reflector (Model 4)												
Saturated UO_2 at 5.0 g/cm^3												
5athop15kr50_5	16,600	14,611	10,811	51,214.9	31.32123	na	na	na	0.66688	0.00075	0.66838	0.93680
5athop15kr50_4	16,600	14,611	9,110	51,214.9	31.32123	na	na	na	0.64213	0.00066	0.64345	0.93680
5athop15kr50_3	16,600	14,611	7,409	51,214.9	31.32123	na	na	na	0.61835	0.00064	0.61963	0.93680
5athop15kr50_2	16,600	14,611	5,708	51,214.9	31.32123	na	na	na	0.59513	0.00065	0.59643	0.93680
5athop15kr50_1	16,600	14,611	4,007	51,214.9	31.32123	na	na	na	0.57238	0.00069	0.57376	0.93680
Saturated UO_2 at 4.0 g/cm^3												
5athop15kr40_5	13,650	12,015	11,172	51,214.9	31.32873	na	na	na	0.66036	0.00080	0.66196	0.93680
5athop15kr40_4	13,650	12,015	9,471	51,214.9	31.32873	na	na	na	0.63435	0.00065	0.63565	0.93680
5athop15kr40_3	13,650	12,015	7,770	51,214.9	31.32873	na	na	na	0.61045	0.00068	0.61181	0.93680
5athop15kr40_2	13,650	12,015	6,069	51,214.9	31.32873	na	na	na	0.58726	0.00063	0.58852	0.93680
5athop15kr40_1	13,650	12,015	4,367	51,214.9	31.32873	na	na	na	0.56407	0.00061	0.56529	0.93680
Saturated UO_2 at 3.0 g/cm^3												
5athop15kr30_5	10,400	9,154	11,521	51,214.9	31.33312	na	na	na	0.64512	0.00067	0.64646	0.93680
5athop15kr30_4	10,400	9,154	9,821	51,214.9	31.33312	na	na	na	0.62005	0.00072	0.62149	0.93680
5athop15kr30_3	10,400	9,154	8,120	51,214.9	31.33312	na	na	na	0.59689	0.00063	0.59815	0.93680
5athop15kr30_2	10,400	9,154	6,419	51,214.9	31.33312	na	na	na	0.57441	0.00063	0.57567	0.93680
5athop15kr30_1	10,400	9,154	4,718	51,214.9	31.33312	na	na	na	0.54978	0.00074	0.55126	0.93680
Saturated UO_2 at 2.0 g/cm^3												
5athop15kr_5	6,000	5,281	11,457	51,214.9	31.29525	na	na	na	0.60058	0.00067	0.60192	0.93680
5athop15kr_4	6,000	5,281	9,756	51,214.9	31.29525	na	na	na	0.57700	0.00066	0.57832	0.93680
5athop15kr_3	6,000	5,281	8,055	51,214.9	31.29525	na	na	na	0.55453	0.00061	0.55575	0.93680
5athop15kr_2	6,000	5,281	6,354	51,214.9	31.29525	na	na	na	0.53171	0.00058	0.53287	0.93680
5athop15kr_1	6,000	5,281	4,653	51,214.9	31.29525	na	na	na	0.50969	0.00060	0.51089	0.93680

Table 6.9.10.9-2. Results for HEU oxide content for air transportation (Models 1–5)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Kaolite (g)	H_2O (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2 at 1.5 g/cm^3												
5athop15kr15_5	5,100	4,489	11,937	51,214.9	31.32771	na	na	na	0.59250	0.00060	0.59370	0.93680
5athop15kr15_4	5,100	4,489	10,237	51,214.9	31.32771	na	na	na	0.56894	0.00060	0.57014	0.93680
5athop15kr15_3	5,100	4,489	8,536	51,214.9	31.32771	na	na	na	0.54630	0.00058	0.54746	0.93680
5athop15kr15_2	5,100	4,489	6,835	51,214.9	31.32771	na	na	na	0.52332	0.00062	0.52456	0.93680
5athop15kr15_1	5,100	4,489	5,133	51,214.9	31.32771	na	na	na	0.50270	0.00060	0.50390	0.93680
Saturated UO_2 at 1.0 g/cm^3												
5athop15kr10_5	3,400	2,992	12,092	51,214.9	31.32771	na	na	na	0.55165	0.00057	0.55279	0.93680
5athop15kr10_4	3,400	2,992	10,391	51,214.9	31.32771	na	na	na	0.52908	0.00052	0.53012	0.93680
5athop15kr10_3	3,400	2,992	8,690	51,214.9	31.32771	na	na	na	0.50781	0.00057	0.50895	0.93680
5athop15kr10_2	3,400	2,992	6,989	51,214.9	31.32771	na	na	na	0.48834	0.00057	0.48948	0.93680
5athop15kr10_1	3,400	2,992	5,289	51,214.9	31.32771	na	na	na	0.46780	0.00059	0.46898	0.93680
Compromised package, homogeneous core [HEU, poly, free water from wet Kaolite], wet Kaolite shell, 20.0 cm water reflector (Model 5)												
Saturated UO_2 at 5.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb												
5athopw12kr50_5_5	16,600	14,611	7,244	na	13.05283	51,214.9	2,205	31.75737	0.98324	0.00084	0.98492	0.93520
5athopw12kr50_4_5	13,000	11,443	6,854	na	12.70748	51,214.9	2,205	31.70045	0.96069	0.00079	0.96227	0.93520
5athopw12kr50_3_5	11,000	9,682	6,636	na	12.50722	51,214.9	2,205	31.66875	0.94791	0.00080	0.94951	0.93520
5athopw12kr50_2_5	9,000	7,922	6,419	na	12.30034	51,214.9	2,205	31.63697	0.93631	0.00080	0.93791	0.93520
5athopw12kr50_1_5	8,600	7,570	6,376	na	12.25811	51,214.9	2,205	31.63061	0.93240	0.00100	0.93440	0.93520
5athopw12kr50_1_4	8,600	7,570	5,015	na	11.48904	51,214.9	3,565	31.52183	0.87767	0.00092	0.87951	0.93520
5athopw12kr50_1_3	8,600	7,570	3,655	na	10.60038	51,214.9	4,926	31.41229	0.81117	0.00089	0.81295	0.93520
5athopw12kr50_1_2	8,600	7,570	2,294	na	9.53085	51,214.9	6,286	31.30198	0.72998	0.00081	0.73160	0.93520
5athopw12kr50_1_1	8,600	7,570	934	na	8.14509	51,214.9	7,647	31.19089	0.62852	0.00064	0.62980	0.93520

Table 6.9.10.9-2. Results for HEU oxide content for air transportation (Models 1–5)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Kaolite (g)	H_2O (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2 at 4.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb												
5athopw12kr40_5_5	13,650	12,015	7,605	na	13.09589	51,214.9	2,205	31.76466	0.98675	0.00088	0.98851	0.93520
5athopw12kr40_4_5	11,000	9,682	7,185	na	12.78098	51,214.9	2,205	31.71233	0.96830	0.00088	0.97006	0.93520
5athopw12kr40_3_5	9,000	7,922	6,868	na	12.53261	51,214.9	2,205	31.67271	0.95179	0.00078	0.95335	0.93520
5athopw12kr40_2_5	8,000	7,042	6,710	na	12.40464	51,214.9	2,205	31.65287	0.94362	0.00087	0.94536	0.93520
5athopw12kr40_1_5	6,850	6,029	6,528	na	12.25414	51,214.9	2,205	31.63002	0.93208	0.00077	0.93362	0.93520
5athopw12kr40_1_4	6,850	6,029	5,167	na	11.48452	51,214.9	3,565	31.52123	0.87684	0.00080	0.87844	0.93520
5athopw12kr40_1_3	6,850	6,029	3,807	na	10.59506	51,214.9	4,926	31.41169	0.80979	0.00075	0.81129	0.93520
5athopw12kr40_1_2	6,850	6,029	2,446	na	9.52427	51,214.9	6,286	31.30137	0.72571	0.00077	0.72725	0.93520
5athopw12kr40_1_1	6,850	6,029	1,086	na	8.13608	51,214.9	7,647	31.19028	0.61924	0.00076	0.62076	0.93520
Saturated UO_2 at 3.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb												
5athopw12kr30_5_5	10,400	9,154	7,955	na	13.12098	51,214.9	2,205	31.76893	0.99190	0.00100	0.99390	0.93520
5athopw12kr30_4_5	8,000	7,042	7,375	na	12.74025	51,214.9	2,205	31.70573	0.96700	0.00094	0.96888	0.93520
5athopw12kr30_3_5	7,000	6,161	7,134	na	12.57469	51,214.9	2,205	31.67932	0.95650	0.00093	0.95836	0.93520
5athopw12kr30_2_5	6,000	5,281	6,892	na	12.40464	51,214.9	2,205	31.65287	0.94327	0.00080	0.94487	0.93520
5athopw12kr30_1_5	5,400	4,753	6,747	na	12.30034	51,214.9	2,205	31.63697	0.93473	0.00085	0.93643	0.93680
5athopw12kr30_1_4	5,400	4,753	5,387	na	11.53707	51,214.9	3,565	31.52824	0.87934	0.00086	0.88106	0.93520
5athopw12kr30_1_3	5,400	4,753	4,026	na	10.65673	51,214.9	4,959	31.41874	0.81255	0.00071	0.81397	0.93520
5athopw12kr30_1_2	5,400	4,753	2,666	na	9.60042	51,214.9	6,286	31.30848	0.73034	0.00075	0.73184	0.93520
5athopw12kr30_1_1	5,400	4,753	1,305	na	8.23994	51,214.9	7,647	31.19743	0.62152	0.00072	0.62296	0.93520
Saturated UO_2 at 2.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb												
5athopw12kr_4_5	6,000	5,281	7,890	na	12.90162	51,214.9	2,205	31.73210	0.97752	0.00098	0.97948	0.93680
5athopw12kr_3_5	5,000	4,401	7,482	na	12.65801	51,214.9	2,205	31.69253	0.95840	0.00100	0.96040	0.93680
5athopw12kr_2_5	4,000	3,521	7,074	na	12.40464	51,214.9	2,205	31.65287	0.93667	0.00077	0.93821	0.93680
5athopw12kr_1_5	3,850	3,389	7,013	na	12.36573	51,214.9	2,205	31.64691	0.93350	0.00110	0.93570	0.93680

Table 6.9.10.9-2. Results for HEU oxide content for air transportation (Models 1–5)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Kaolite (g)	H_2O (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
5athopw12kr_1_4	3,850	3,389	5,653	na	11.61133	51,214.9	3,565	31.53824	0.88356	0.00084	0.88524	0.93680
5athopw12kr_1_3	3,850	3,389	4,292	na	10.74361	51,214.9	4,926	31.42881	0.81725	0.00074	0.81873	0.93520
5athopw12kr_1_2	3,850	3,389	2,931	na	9.70716	51,214.9	6,286	31.31862	0.73584	0.00074	0.73732	0.93520
5athopw12kr_1_1	3,850	3,389	1,571	na	8.38392	51,214.9	7,647	31.20765	0.62537	0.00074	0.62685	0.93520
Saturated UO_2 at 1.5 g/cm^3, maximum free water in wet Kaolite limited to 12 lb												
5athopw12kr15_3_5	5,100	4,489	8,372	na	13.09009	51,214.9	2,205	31.76368	0.98918	0.00091	0.99100	0.93680
5athopw12kr15_2_5	4,000	3,521	7,740	na	12.74025	51,214.9	2,205	31.70573	0.96240	0.00120	0.96480	0.93680
5athopw12kr15_1_5	3,150	2,772	7,251	na	12.45614	51,214.9	2,205	31.66081	0.93461	0.00091	0.93643	0.93680
5athopw12kr15_1_4	3,150	2,772	5,890	na	11.71371	51,214.9	3,565	31.55223	0.88442	0.00087	0.88616	0.93680
5athopw12kr15_1_3	3,150	2,772	4,530	na	10.86293	51,214.9	4,925	31.44291	0.82185	0.00086	0.82357	0.93680
5athopw12kr15_1_2	3,150	2,772	3,170	na	9.85275	51,214.9	6,286	31.33281	0.74520	0.00087	0.74694	0.93520
5athopw12kr15_1_1	3,150	2,772	1,809	na	8.57753	51,214.9	7,647	31.22194	0.63937	0.00076	0.64089	0.93520
Saturated UO_2 at 1.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb												
5athopw12kr10_3_5	3,400	2,992	8,526	na	13.09009	51,214.9	2,205	31.76368	0.97763	0.00082	0.97927	0.93680
5athopw12kr10_2_5	3,000	2,641	8,163	na	12.90162	51,214.9	2,205	31.73210	0.96000	0.00089	0.96178	0.93680
5athopw12kr10_1_5	2,450	2,157	7,664	na	12.63313	51,214.9	2,205	31.68857	0.93370	0.00088	0.93546	0.93680
5athopw12kr10_1_4	2,450	2,157	6,304	na	11.91328	51,214.9	3,565	31.58019	0.88917	0.00089	0.89095	0.93680
5athopw12kr10_1_3	2,450	2,157	4,943	na	11.09401	51,214.9	4,925	31.47105	0.83569	0.00097	0.83763	0.93680
5athopw12kr10_1_2	2,450	2,157	3,583	na	10.13169	51,214.9	6,286	31.36116	0.76249	0.00099	0.76447	0.93680
5athopw12kr10_1_1	2,450	2,157	2,222	na	8.94051	51,214.9	7,647	31.25049	0.66680	0.00076	0.66832	0.93520

Table 6.9.10.9-3. Results for HEU oxide content for air transportation (Model 6)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Oxide (g)	^{235}U (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Compromised package, homogeneous core [HEU, poly, wet Kaolite, sat moisture from oxide], dry oxide shell, 20.0 cm water reflector Saturated UO_2 at 5.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb												
5athop15kor50_5_6_6	16,000	14,083	10,811	51,214.9	32.02751	600	528	32.03692	0.66436	0.00065	0.66566	0.93680
5athop15kor50_4_6_6	16,000	14,083	9,110	51,214.9	31.89476	600	528	31.90425	0.64203	0.00072	0.64347	0.93680
5athop15kor50_3_6_6	16,000	14,083	7,409	51,214.9	31.76090	600	528	31.77047	0.62034	0.00063	0.62160	0.93680
5athop15kor50_2_6_6	16,000	14,083	5,708	51,214.9	31.62591	600	528	31.63555	0.59832	0.00060	0.59952	0.93680
5athop15kor50_1_6_6	16,000	14,083	4,007	51,214.9	31.48975	600	528	31.49947	0.57561	0.00063	0.57687	0.93680
5athop15kor50_5_5_5	13,000	11,443	10,811	51,214.9	31.98090	3,600	3,169	32.03692	0.68057	0.00069	0.68195	0.93680
5athop15kor50_4_5_5	13,000	11,443	9,110	51,214.9	31.84776	3,600	3,169	31.90425	0.65747	0.00066	0.65879	0.93680
5athop15kor50_3_5_5	13,000	11,443	7,409	51,214.9	31.71350	3,600	3,169	31.77047	0.63606	0.00063	0.63732	0.93680
5athop15kor50_2_5_5	13,000	11,443	5,708	51,214.9	31.57810	3,600	3,169	31.63555	0.61254	0.00063	0.61380	0.93680
5athop15kor50_1_5_5	13,000	11,443	4,007	51,214.9	31.44152	3,600	3,169	31.49947	0.58991	0.00064	0.59119	0.93680
5athop15kor50_5_4_4	10,000	8,802	10,811	51,214.9	31.93414	6,600	5,809	32.03692	0.68849	0.00079	0.69007	0.93680
5athop15kor50_4_4_4	10,000	8,802	9,110	51,214.9	31.80062	6,600	5,809	31.90425	0.66527	0.00066	0.66659	0.93680
5athop15kor50_3_4_4	10,000	8,802	7,409	51,214.9	31.66596	6,600	5,809	31.77047	0.64294	0.00064	0.64422	0.93680
5athop15kor50_2_4_4	10,000	8,802	5,708	51,214.9	31.53014	6,600	5,809	31.63555	0.62091	0.00067	0.62225	0.93680
5athop15kor50_1_4_4	10,000	8,802	4,007	51,214.9	31.39315	6,600	5,809	31.49947	0.59596	0.00064	0.59724	0.93680
5athop15kor50_5_3_3	6,000	5,281	10,811	51,214.9	31.87159	10,600	9,330	32.03692	0.69432	0.00078	0.69588	0.93680
5athop15kor50_4_3_3	6,000	5,281	9,110	51,214.9	31.73754	10,600	9,330	31.90425	0.67280	0.00066	0.67412	0.93680
5athop15kor50_3_3_3	6,000	5,281	7,409	51,214.9	31.60234	10,600	9,330	31.77047	0.65030	0.00058	0.65146	0.93680
5athop15kor50_2_3_3	6,000	5,281	5,708	51,214.9	31.46598	10,600	9,330	31.63555	0.62834	0.00062	0.62958	0.93680
5athop15kor50_1_3_3	6,000	5,281	4,007	51,214.9	31.32842	10,600	9,330	31.49947	0.60495	0.00081	0.60657	0.93680
5athop15kor50_5_2_2	3,000	2,641	10,811	51,214.9	31.82452	13,600	11,971	32.03692	0.69547	0.00069	0.69685	0.93680
5athop15kor50_4_2_2	3,000	2,641	9,110	51,214.9	31.69007	13,600	11,971	31.90425	0.67427	0.00070	0.67567	0.93680
5athop15kor50_3_2_2	3,000	2,641	7,409	51,214.9	31.55446	13,600	11,971	31.77047	0.65296	0.00060	0.65416	0.93680

Table 6.9.10.9-3. Results for HEU oxide content for air transportation (Model 6)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Oxide (g)	^{235}U (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
5athop15kor50_2_2_2	3,000	2,641	5,708	51,214.9	31.41768	13,600	11,971	31.63555	0.63156	0.00060	0.63276	0.93680
5athop15kor50_1_2_2	3,000	2,641	4,007	51,214.9	31.27969	13,600	11,971	31.49947	0.60947	0.00069	0.61085	0.93680
5athop15kor50_5_1_1	600	528	10,811	51,214.9	31.78676	16,000	14,083	32.03692	0.68679	0.00067	0.68813	0.93680
5athop15kor50_4_1_1	600	528	9,110	51,214.9	31.65199	16,000	14,083	31.90425	0.66839	0.00057	0.66953	0.93680
5athop15kor50_3_1_1	600	528	7,409	51,214.9	31.51605	16,000	14,083	31.77047	0.65079	0.00061	0.65201	0.93680
5athop15kor50_2_1_1	600	528	5,708	51,214.9	31.37893	16,000	14,083	31.63555	0.63128	0.00057	0.63242	0.93680
5athop15kor50_1_1_1	600	528	4,007	51,214.9	31.24061	16,000	14,083	31.49947	0.61072	0.00064	0.61200	0.93680
Saturated UO_2 at 4.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb												
5athop15kor40_5_6_6	13,000	11,443	11,172	51,214.9	32.03139	650	572	32.04409	0.65847	0.00079	0.66005	0.93680
5athop15kor40_4_6_6	13,000	11,443	9,470	51,214.9	31.89868	650	572	31.91148	0.63504	0.00063	0.63630	0.93680
5athop15kor40_3_6_6	13,000	11,443	7,770	51,214.9	31.76485	650	572	31.77776	0.61213	0.00067	0.61347	0.93680
5athop15kor40_2_6_6	13,000	11,443	6,069	51,214.9	31.62988	650	572	31.64290	0.59009	0.00071	0.59151	0.93680
5athop15kor40_1_6_6	13,000	11,443	4,369	51,214.9	31.49376	650	572	31.50689	0.56922	0.00067	0.57056	0.93680
5athop15kor40_5_5_5	11,000	9,682	11,172	51,214.9	31.99256	2,650	2,333	32.04409	0.67231	0.00065	0.67361	0.93680
5athop15kor40_4_5_5	11,000	9,682	9,470	51,214.9	31.85952	2,650	2,333	31.91148	0.64895	0.00061	0.65017	0.93680
5athop15kor40_3_5_5	11,000	9,682	7,770	51,214.9	31.72537	2,650	2,333	31.77776	0.62601	0.00063	0.62727	0.93680
5athop15kor40_2_5_5	11,000	9,682	6,069	51,214.9	31.59006	2,650	2,333	31.64290	0.60516	0.00065	0.60646	0.93680
5athop15kor40_1_5_5	11,000	9,682	4,369	51,214.9	31.45359	2,650	2,333	31.50689	0.57968	0.00066	0.58100	0.93680
5athop15kor40_5_4_4	8,000	7,042	11,172	51,214.9	31.93414	5,650	4,973	32.04409	0.68231	0.00075	0.68381	0.93680
5athop15kor40_4_4_4	8,000	7,042	9,470	51,214.9	31.80062	5,650	4,973	31.91148	0.65839	0.00066	0.65971	0.93680
5athop15kor40_3_4_4	8,000	7,042	7,770	51,214.9	31.66596	5,650	4,973	31.77776	0.63615	0.00068	0.63751	0.93680
5athop15kor40_2_4_4	8,000	7,042	6,069	51,214.9	31.53014	5,650	4,973	31.64290	0.61361	0.00067	0.61495	0.93680
5athop15kor40_1_4_4	8,000	7,042	4,369	51,214.9	31.39315	5,650	4,973	31.50689	0.59009	0.00061	0.59131	0.93680
5athop15kor40_5_3_3	5,000	4,401	11,172	51,214.9	31.87551	8,650	7,614	32.04409	0.68679	0.00064	0.68807	0.93680
5athop15kor40_4_3_3	5,000	4,401	9,470	51,214.9	31.74149	8,650	7,614	31.91148	0.66511	0.00062	0.66635	0.93680

Table 6.9.10.9-3. Results for HEU oxide content for air transportation (Model 6)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Oxide (g)	^{235}U (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
5athop15kor40_3_3_3	5,000	4,401	7,770	51,214.9	31.60632	8,650	7,614	31.77776	0.64272	0.00064	0.64400	0.93680
5athop15kor40_2_3_3	5,000	4,401	6,069	51,214.9	31.64290	8,650	7,614	31.64290	0.61985	0.00063	0.62111	0.93680
5athop15kor40_1_3_3	5,000	4,401	4,369	51,214.9	31.33247	8,650	7,614	31.50689	0.59639	0.00074	0.59787	0.93680
5athop15kor40_5_2_2	2,000	1,760	11,172	51,214.9	31.81666	11,650	10,254	32.04409	0.68317	0.00064	0.68445	0.93680
5athop15kor40_4_2_2	2,000	1,760	9,470	51,214.9	31.68214	11,650	10,254	31.91148	0.66466	0.00070	0.66606	0.93680
5athop15kor40_3_2_2	2,000	1,760	7,770	51,214.9	31.54647	11,650	10,254	31.77776	0.64469	0.00060	0.64589	0.93680
5athop15kor40_2_2_2	2,000	1,760	6,069	51,214.9	31.40961	11,650	10,254	31.64290	0.62381	0.00058	0.62497	0.93680
5athop15kor40_1_2_2	2,000	1,760	4,369	51,214.9	31.27156	11,650	10,254	31.50689	0.60212	0.00060	0.60332	0.93680
5athop15kor40_5_1_1	650	572	11,172	51,214.9	31.79011	13,000	11,443	32.04409	0.67652	0.00059	0.67770	0.93680
5athop15kor40_4_1_1	650	572	9,470	51,214.9	31.65536	13,000	11,443	31.91148	0.65826	0.00061	0.65948	0.93680
5athop15kor40_3_1_1	650	572	7,770	51,214.9	31.51946	13,000	11,443	31.77776	0.64135	0.00063	0.64261	0.93680
5athop15kor40_2_1_1	650	572	6,069	51,214.9	31.38237	13,000	11,443	31.64290	0.62154	0.00064	0.62282	0.93680
5athop15kor40_1_1_1	650	572	4,369	51,214.9	31.24407	13,000	11,443	31.50689	0.60231	0.00060	0.60351	0.93680
Saturated UO_2 at 3.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb												
5athop15kor30_5_6_6	10,000	8,802	11,522	51,214.9	32.03785	400	352	32.04828	0.64138	0.00064	0.64266	0.93680
5athop15kor30_4_6_6	10,000	8,802	9,821	51,214.9	31.90519	400	352	31.91571	0.62009	0.00069	0.62147	0.93680
5athop15kor30_3_6_6	10,000	8,802	8,120	51,214.9	31.77142	400	352	31.78203	0.59842	0.00061	0.59964	0.93680
5athop15kor30_2_6_6	10,000	8,802	6,419	51,214.9	31.63651	400	352	31.64721	0.57717	0.00065	0.57847	0.93680
5athop15kor30_1_6_6	10,000	8,802	4,718	51,214.9	31.50044	400	352	31.51123	0.55507	0.00068	0.55643	0.93680
5athop15kor30_5_5_5	8,000	7,042	11,522	51,214.9	31.98608	2,400	2,113	32.04828	0.66082	0.00066	0.66214	0.93680
5athop15kor30_4_5_5	8,000	7,042	9,821	51,214.9	31.85299	2,400	2,113	31.91571	0.63810	0.00068	0.63946	0.93680
5athop15kor30_3_5_5	8,000	7,042	8,120	51,214.9	31.71878	2,400	2,113	31.78203	0.61639	0.00063	0.61765	0.93680
5athop15kor30_2_5_5	8,000	7,042	6,419	51,214.9	31.58342	2,400	2,113	31.64721	0.59253	0.00072	0.59397	0.93680
5athop15kor30_1_5_5	8,000	7,042	4,718	51,214.9	31.44689	2,400	2,113	31.51123	0.57080	0.00061	0.57202	0.93680

Table 6.9.10.9-3. Results for HEU oxide content for air transportation (Model 6)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Oxide (g)	^{235}U (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
5athop15kor30_5_4_4	6,000	5,281	11,522	51,214.9	31.93414	4,400	3,873	32.04828	0.66830	0.00073	0.66976	0.93680
5athop15kor30_4_4_4	6,000	5,281	9,821	51,214.9	31.80062	4,400	3,873	31.91571	0.64646	0.00073	0.64792	0.93680
5athop15kor30_3_4_4	6,000	5,281	8,120	51,214.9	31.66596	4,400	3,873	31.78203	0.62439	0.00060	0.62559	0.93680
5athop15kor30_2_4_4	6,000	5,281	6,419	51,214.9	31.53014	4,400	3,873	31.64721	0.60220	0.00063	0.60346	0.93680
5athop15kor30_1_4_4	6,000	5,281	4,718	51,214.9	31.39315	4,400	3,873	31.51123	0.57774	0.00059	0.57892	0.93680
5athop15kor30_5_3_3	4,000	3,521	11,522	51,214.9	31.88204	6,400	5,633	32.04828	0.67302	0.00086	0.67474	0.93680
5athop15kor30_4_3_3	4,000	3,521	9,821	51,214.9	31.74807	6,400	5,633	31.91571	0.65042	0.00065	0.65172	0.93680
5athop15kor30_3_3_3	4,000	3,521	8,120	51,214.9	31.61296	6,400	5,633	31.78203	0.62877	0.00063	0.63003	0.93680
5athop15kor30_2_3_3	4,000	3,521	6,419	51,214.9	31.47669	6,400	5,633	31.64721	0.60694	0.00063	0.60820	0.93680
5athop15kor30_1_3_3	4,000	3,521	4,718	51,214.9	31.33923	6,400	5,633	31.51123	0.58401	0.00071	0.58543	0.93680
5athop15kor30_5_2_2	2,000	1,760	11,522	51,214.9	31.82976	8,400	7,394	32.04828	0.66981	0.00083	0.67147	0.93680
5athop15kor30_4_2_2	2,000	1,760	9,821	51,214.9	31.69535	8,400	7,394	31.91571	0.65119	0.00067	0.65253	0.93680
5athop15kor30_3_2_2	2,000	1,760	8,120	51,214.9	31.55979	8,400	7,394	31.78203	0.62864	0.00063	0.62990	0.93680
5athop15kor30_2_2_2	2,000	1,760	6,419	51,214.9	31.42305	8,400	7,394	31.64721	0.60955	0.00068	0.61091	0.93680
5athop15kor30_1_2_2	2,000	1,760	4,718	51,214.9	31.28512	8,400	7,394	31.51123	0.58632	0.00064	0.58760	0.93680
5athop15kor30_5_1_1	400	352	11,522	51,214.9	31.78781	10,000	8,802	32.04828	0.65358	0.00061	0.65480	0.93680
5athop15kor30_4_1_1	400	352	9,821	51,214.9	31.65304	10,000	8,802	31.91571	0.64001	0.00073	0.64147	0.93680
5athop15kor30_3_1_1	400	352	8,120	51,214.9	31.51712	10,000	8,802	31.78203	0.62396	0.00056	0.62508	0.93680
5athop15kor30_2_1_1	400	352	6,419	51,214.9	31.38001	10,000	8,802	31.64721	0.60617	0.00068	0.60753	0.93680
5athop15kor30_1_1_1	400	352	4,718	51,214.9	31.24169	10,000	8,802	31.51123	0.58697	0.00068	0.58833	0.93680
Saturated UO_2 at 2.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb												
5athop15kor_5_5_5	5,000	4,401	11,457	51,214.9	31.97311	1,000	880	32.01209	0.61105	0.00073	0.61251	0.93680
5athop15kor_4_5_5	5,000	4,401	9,756	51,214.9	31.83991	1,000	880	31.87921	0.59217	0.00067	0.59351	0.93680
5athop15kor_3_5_5	5,000	4,401	8,055	51,214.9	31.70559	1,000	880	31.74522	0.56890	0.00065	0.57020	0.93680

Table 6.9.10.9-3. Results for HEU oxide content for air transportation (Model 6)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Oxide (g)	^{235}U (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
5athop15kor_2_5_5	5,000	4,401	6,354	51,214.9	31.57011	1,000	880	31.61009	0.54809	0.00062	0.54933	0.93680
5athop15kor_1_5_5	5,000	4,401	4,653	51,214.9	31.43347	1,000	880	31.47379	0.52570	0.00056	0.52682	0.93680
5athop15kor_5_4_4	4,000	3,521	11,457	51,214.9	31.93414	2,000	1,760	32.01209	0.62243	0.00060	0.62363	0.93680
5athop15kor_4_4_4	4,000	3,521	9,756	51,214.9	31.80062	2,000	1,760	31.87921	0.60120	0.00062	0.60244	0.93680
5athop15kor_3_4_4	4,000	3,521	8,055	51,214.9	31.66596	2,000	1,760	31.74522	0.57775	0.00062	0.57899	0.93680
5athop15kor_2_4_4	4,000	3,521	6,354	51,214.9	31.53014	2,000	1,760	31.61009	0.55673	0.00059	0.55791	0.93680
5athop15kor_1_4_4	4,000	3,521	4,653	51,214.9	31.39315	2,000	1,760	31.47379	0.53541	0.00058	0.53657	0.93680
5athop15kor_5_3_3	3,000	2,641	11,457	51,214.9	31.89508	3,000	2,641	32.01209	0.62602	0.00067	0.62736	0.93680
5athop15kor_4_3_3	3,000	2,641	9,756	51,214.9	31.76122	3,000	2,641	31.87921	0.60682	0.00062	0.60806	0.93680
5athop15kor_3_3_3	3,000	2,641	8,055	51,214.9	31.62623	3,000	2,641	31.74522	0.58425	0.00058	0.58541	0.93680
5athop15kor_2_3_3	3,000	2,641	6,354	51,214.9	31.49007	3,000	2,641	31.61009	0.56170	0.00061	0.56292	0.93680
5athop15kor_1_3_3	3,000	2,641	4,653	51,214.9	31.35272	3,000	2,641	31.47379	0.54171	0.00057	0.54285	0.93680
5athop15kor_5_2_2	2,000	1,760	11,457	51,214.9	31.85592	4,000	3,521	32.01209	0.62588	0.00063	0.62714	0.93680
5athop15kor_4_2_2	2,000	1,760	9,756	51,214.9	31.72173	4,000	3,521	31.87921	0.60716	0.00062	0.60840	0.93680
5athop15kor_3_2_2	2,000	1,760	8,055	51,214.9	31.58640	4,000	3,521	31.74522	0.58697	0.00067	0.58831	0.93680
5athop15kor_2_2_2	2,000	1,760	6,354	51,214.9	31.44989	4,000	3,521	31.61009	0.56611	0.00063	0.56737	0.93680
5athop15kor_1_2_2	2,000	1,760	4,653	51,214.9	31.31219	4,000	3,521	31.47379	0.54498	0.00064	0.54626	0.93680
5athop15kor_5_1_1	1,000	880	11,457	51,214.9	31.81666	5,000	4,401	32.01209	0.61801	0.00062	0.61925	0.93680
5athop15kor_4_1_1	1,000	880	9,756	51,214.9	31.68214	5,000	4,401	31.87921	0.60185	0.00059	0.60303	0.93680
5athop15kor_3_1_1	1,000	880	8,055	51,214.9	31.54647	5,000	4,401	31.74522	0.58464	0.00065	0.54994	0.93680
5athop15kor_2_1_1	1,000	880	6,354	51,214.9	31.40961	5,000	4,401	31.61009	0.56475	0.00067	0.56609	0.93680
5athop15kor_1_1_1	1,000	880	4,653	51,214.9	31.27156	5,000	4,401	31.47379	0.54602	0.00063	0.54728	0.93680

Table 6.9.10.9-3. Results for HEU oxide content for air transportation (Model 6)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Oxide (g)	^{235}U (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2 at 1.5 g/cm^3, maximum free water in wet Kaolite limited to 15 lb												
5athop15kor15_5_6_6	5,000	4,401	11,938	51,214.9	32.03785	100	88	32.04312	0.58529	0.00076	0.58681	0.93680
5athop15kor15_4_6_6	5,000	4,401	10,238	51,214.9	31.90519	100	88	31.91050	0.56521	0.00062	0.56645	0.93680
5athop15kor15_3_6_6	5,000	4,401	8,537	51,214.9	31.77142	100	88	31.77677	0.54414	0.00063	0.54540	0.93680
5athop15kor15_2_6_6	5,000	4,401	6,835	51,214.9	31.63651	100	88	31.64191	0.52464	0.00064	0.52592	0.93680
5athop15kor15_1_6_6	5,000	4,401	5,135	51,214.9	31.50044	100	88	31.50589	0.50476	0.00057	0.50590	0.93680
5athop15kor15_5_5_5	4,000	3,521	11,938	51,214.9	31.98608	1,100	970	32.04312	0.60542	0.00066	0.60674	0.93680
5athop15kor15_4_5_5	4,000	3,521	10,238	51,214.9	31.85299	1,100	970	31.91050	0.58452	0.00056	0.58564	0.93680
5athop15kor15_3_5_5	4,000	3,521	8,537	51,214.9	31.71878	1,100	970	31.77677	0.56294	0.00060	0.51398	0.93680
5athop15kor15_2_5_5	4,000	3,521	6,835	51,214.9	31.58342	1,100	970	31.64191	0.54282	0.00065	0.54412	0.93680
5athop15kor15_1_5_5	4,000	3,521	5,135	51,214.9	31.44689	1,100	970	31.50589	0.52148	0.00058	0.52246	0.93680
5athop15kor15_5_4_4	3,000	2,640	11,938	51,214.9	31.93414	2,100	1,850	32.04312	0.61514	0.00068	0.61650	0.93680
5athop15kor15_4_4_4	3,000	2,640	10,238	51,214.9	31.80062	2,100	1,850	31.91050	0.59415	0.00066	0.59547	0.93680
5athop15kor15_3_4_4	3,000	2,640	8,537	51,214.9	31.66596	2,100	1,850	31.77677	0.57428	0.00056	0.57540	0.93680
5athop15kor15_2_4_4	3,000	2,640	6,835	51,214.9	31.53014	2,100	1,850	31.64191	0.55386	0.00061	0.55508	0.93680
5athop15kor15_1_4_4	3,000	2,640	5,135	51,214.9	31.39315	2,100	1,850	31.50589	0.53104	0.00056	0.53216	0.93680
5athop15kor15_5_3_3	2,000	1,760	11,938	51,214.9	31.88204	3,100	2,729	32.04312	0.61700	0.00058	0.61816	0.93680
5athop15kor15_4_3_3	2,000	1,760	10,238	51,214.9	31.74807	3,100	2,729	31.91050	0.59728	0.00058	0.59844	0.93680
5athop15kor15_3_3_3	2,000	1,760	8,537	51,214.9	31.61296	3,100	2,729	31.77677	0.57655	0.00065	0.52941	0.93680
5athop15kor15_2_3_3	2,000	1,760	6,835	51,214.9	31.47669	3,100	2,729	31.64191	0.55631	0.00075	0.55781	0.93680
5athop15kor15_1_3_3	2,000	1,760	5,135	51,214.9	31.33923	3,100	2,729	31.50589	0.53671	0.00055	0.53781	0.93680
5athop15kor15_5_2_2	1,000	880	11,938	51,214.9	31.82976	4,100	3,610	32.04312	0.60824	0.00064	0.60952	0.93680
5athop15kor15_4_2_2	1,000	880	10,238	51,214.9	31.69535	4,100	3,610	31.91050	0.59060	0.00060	0.59180	0.93680
5athop15kor15_3_2_2	1,000	880	8,537	51,214.9	31.55979	4,100	3,610	31.77677	0.57480	0.00058	0.57596	0.93680

Table 6.9.10.9-3. Results for HEU oxide content for air transportation (Model 6)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Oxide (g)	^{235}U (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
5athop15kor15_2_2_2	1,000	880	6,835	51,214.9	31.42305	4,100	3,610	31.64191	0.55588	0.00058	0.55704	0.93680
5athop15kor15_1_2_2	1,000	880	5,135	51,214.9	31.28512	4,100	3,610	31.50589	0.53743	0.00059	0.53861	0.93680
5athop15kor15_5_1_1	100	88	11,938	51,214.9	31.78256	5,000	4,401	32.04312	0.58178	0.00058	0.58294	0.93680
5athop15kor15_4_1_1	100	88	10,238	51,214.9	31.64775	5,000	4,401	31.91050	0.57271	0.00067	0.57405	0.93680
5athop15kor15_3_1_1	100	88	8,537	51,214.9	31.51178	5,000	4,401	31.77677	0.56099	0.00056	0.56211	0.93680
5athop15kor15_2_1_1	100	88	6,835	51,214.9	31.37462	5,000	4,401	31.64191	0.54646	0.00062	0.54770	0.93680
5athop15kor15_1_1_1	100	88	5,135	51,214.9	31.23626	5,000	4,401	31.50589	0.53012	0.00063	0.53138	0.93680
Saturated UO_2 at 1.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb												
5athop15kor10_5_6_6	3,000	2,640	12,092	51,214.9	32.01199	400	352	32.04312	0.55427	0.00059	0.55545	0.93680
5athop15kor10_4_6_6	3,000	2,640	10,391	51,214.9	31.87911	400	352	31.91050	0.53581	0.00058	0.53697	0.93680
5athop15kor10_3_6_6	3,000	2,640	8,690	51,214.9	31.74512	400	352	31.77677	0.51751	0.00060	0.51871	0.93680
5athop15kor10_2_6_6	3,000	2,640	6,989	51,214.9	31.60999	400	352	31.64191	0.49909	0.00056	0.50021	0.93680
5athop15kor10_1_6_6	3,000	2,640	5,288	51,214.9	31.47369	400	352	31.50589	0.47931	0.00060	0.48051	0.93680
5athop15kor10_5_5_5	2,500	2,200	12,092	51,214.9	31.97311	900	792	32.04312	0.56690	0.00061	0.56812	0.93680
5athop15kor10_4_5_5	2,500	2,200	10,391	51,214.9	31.83991	900	792	31.91050	0.54756	0.00058	0.54872	0.93680
5athop15kor10_3_5_5	2,500	2,200	8,690	51,214.9	31.70559	900	792	31.77677	0.52790	0.00061	0.52912	0.93680
5athop15kor10_2_5_5	2,500	2,200	6,989	51,214.9	31.57011	900	792	31.64191	0.50904	0.00064	0.51032	0.93680
5athop15kor10_1_5_5	2,500	2,200	5,288	51,214.9	31.43347	900	792	31.50589	0.48928	0.00059	0.49047	0.93680
5athop15kor10_5_4_4	2,000	1,760	12,092	51,214.9	31.93414	1,400	1,232	32.04312	0.57224	0.00059	0.57342	0.93680
5athop15kor10_4_4_4	2,000	1,760	10,391	51,214.9	31.80062	1,400	1,232	31.91050	0.55234	0.00054	0.55342	0.93680
5athop15kor10_3_4_4	2,000	1,760	8,690	51,214.9	31.66596	1,400	1,232	31.77677	0.53428	0.00056	0.53540	0.93680
5athop15kor10_2_4_4	2,000	1,760	6,989	51,214.9	31.53014	1,400	1,232	31.64191	0.51517	0.00059	0.51635	0.93680
5athop15kor10_1_4_4	2,000	1,760	5,288	51,214.9	31.39315	1,400	1,232	31.50589	0.49495	0.00056	0.49607	0.93680

Table 6.9.10.9-3. Results for HEU oxide content for air transportation (Model 6)

Case	Core					Shell						
	Oxide (g)	^{235}U (g)	H_2O (g)	Kaolite (g)	Rc (cm)	Oxide (g)	^{235}U (g)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
5athop15kor10_5_3_3	1,500	1,320	12,092	51,214.9	31.89508	1,900	1,672	32.04312	0.57174	0.00055	0.57284	0.93680
5athop15kor10_4_3_3	1,500	1,320	10,391	51,214.9	31.76122	1,900	1,672	31.91050	0.55501	0.00063	0.55627	0.93680
5athop15kor10_3_3_3	1,500	1,320	8,690	51,214.9	31.62623	1,900	1,672	31.77677	0.53743	0.00059	0.53861	0.93680
5athop15kor10_2_3_3	1,500	1,320	6,989	51,214.9	31.49007	1,900	1,672	31.64191	0.51847	0.00055	0.51957	0.93680
5athop15kor10_1_3_3	1,500	1,320	5,288	51,214.9	31.35272	1,900	1,672	31.50589	0.49967	0.00052	0.50071	0.93680
5athop15kor10_5_2_2	1,000	880	12,092	51,214.9	31.85592	2,400	2,112	32.04312	0.56818	0.00058	0.56934	0.93680
5athop15kor10_4_2_2	1,000	880	10,391	51,214.9	31.72173	2,400	2,112	31.91050	0.55313	0.00059	0.55431	0.93680
5athop15kor10_3_2_2	1,000	880	8,690	51,214.9	31.58640	2,400	2,112	31.77677	0.53603	0.00058	0.53719	0.93680
5athop15kor10_2_2_2	1,000	880	6,989	51,214.9	31.44989	2,400	2,112	31.64191	0.51764	0.00063	0.51890	0.93680
5athop15kor10_1_2_2	1,000	880	5,288	51,214.9	31.31219	2,400	2,112	31.50589	0.49954	0.00064	0.50082	0.93680
5athop15kor10_5_1_1	400	352	12,092	51,214.9	31.80880	3,000	2,641	32.04312	0.55303	0.00059	0.55421	0.93680
5athop15kor10_4_1_1	400	352	10,391	51,214.9	31.67421	3,000	2,641	31.91050	0.53971	0.00061	0.54093	0.93680
5athop15kor10_3_1_1	400	352	8,690	51,214.9	31.53847	3,000	2,641	31.77677	0.52728	0.00060	0.52848	0.93680
5athop15kor10_2_1_1	400	352	6,989	51,214.9	31.40155	3,000	2,641	31.64191	0.51249	0.00053	0.51355	0.93680
5athop15kor10_1_1_1	400	352	5,288	51,214.9	31.26342	3,000	2,641	31.50589	0.49716	0.00057	0.49830	0.93680

Table 6.9.10.9-4. Results for HEU oxide and thorium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Compromised package, HEU-poly core in spherical configuration, 20.0 cm water reflector (Model 1)													
Saturated UO_2-ThO_2 at 5.0 g/cm^3													
atdothr50_4_1	8.00	7.042	7.20	1.587	na	9.49304	na	na	na	0.80511	0.00066	0.80643	0.93520
atdothr50_3_2	9.00	7.922	6.20	1.596	na	9.49304	na	na	na	0.82116	0.00074	0.82264	0.93520
atdothr50_2_3	10.00	8.802	5.20	1.605	na	9.49304	na	na	na	0.83548	0.00069	0.83686	0.93520
atdothr50_1_4	11.00	9.682	4.20	1.613	na	9.49304	na	na	na	0.85077	0.00071	0.85219	0.93520
Saturated UO_2-ThO_2 at 4.0 g/cm^3													
atdothr40_4_1	8.00	7.042	7.20	2.346	na	10.12161	na	na	na	0.85121	0.00079	0.85279	0.93520
atdothr40_3_2	9.00	7.922	6.20	2.355	na	10.12161	na	na	na	0.86532	0.00073	0.86678	0.93520
atdothr40_2_3	10.00	8.802	5.20	2.363	na	10.12161	na	na	na	0.87966	0.00072	0.88110	0.93520
atdothr40_1_4	11.00	9.682	4.20	2.372	na	10.12161	na	na	na	0.89234	0.0008	0.89394	0.93520
Saturated UO_2-ThO_2 at 3.0 g/cm^3													
atdothr30_5_1	8.00	7.042	7.20	3.61	na	11.02288	na	na	na	0.91767	0.00079	0.91925	0.93520
atdothr30_4_2	9.00	7.922	6.20	3.619	na	11.02288	na	na	na	0.92717	0.00075	0.92867	0.93520
atdothr30_3_3	9.40	8.274	5.80	3.623	na	11.02288	na	na	na	0.93202	0.00074	0.93350	0.93520
atdothr30_2_4	10.00	8.802	5.20	3.628	na	11.02288	na	na	na	0.94002	0.00075	0.94152	0.93520
Saturated UO_2-ThO_2 at 2.0 g/cm^3													
atdothr_4_1	2.00	1.760	13.20	6.087	na	12.48074	na	na	na	0.88954	0.00076	0.89106	0.93680
atdothr_3_2	2.50	2.201	12.70	6.091	na	12.48074	na	na	na	0.91728	0.00072	0.91872	0.93680
atdothr_2_3	2.95	2.597	12.25	6.095	na	12.48074	na	na	na	0.93351	0.00086	0.93523	0.93680
atdothr_1_4	3.00	2.641	12.20	6.095	na	12.48074	na	na	na	0.93603	0.00077	0.93757	0.93680
Saturated UO_2-ThO_2 at 1.5 g/cm^3													
atdothr15_4_1	1.00	0.880	13.50	8.211	na	13.45802	na	na	na	0.82465	0.00066	0.82597	0.93680
atdothr15_3_2	1.50	1.320	13.00	8.215	na	13.45802	na	na	na	0.90216	0.00067	0.90350	0.93680
atdothr15_2_3	1.80	1.584	12.70	8.218	na	13.45802	na	na	na	0.93196	0.00073	0.93342	0.93680
atdothr15_1_4	2.00	1.760	12.50	8.219	na	13.45802	na	na	na	0.94806	0.00077	0.94960	0.93680

Table 6.9.10.9-4. Results for HEU oxide and thorium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2-ThO_2 at 1.0 g/cm^3													
atdothr10_4_1	1.00	0.880	8.65	8.678	na	13.45069	na	na	na	0.88049	0.00077	0.88203	0.93680
atdothr10_3_2	1.25	1.100	8.40	8.680	na	13.45069	na	na	na	0.92349	0.00065	0.92479	0.93680
atdothr10_2_3	1.30	1.144	8.35	8.681	na	13.45069	na	na	na	0.93045	0.00075	0.93195	0.93680
atdothr10_1_4	1.50	1.320	8.15	8.683	na	13.45069	na	na	na	0.95521	0.0008	0.95681	0.93680
Compromised package, HEU-poly core in spherical configuration, stainless-steel shell, 20.0 cm water reflector (Model 2)													
Saturated UO_2-ThO_2 at 5.0 g/cm^3													
atdothsr50_1	11.00	9.682	4.20	1.613	na	9.49304	na	na	na	0.85077	0.00071	0.85219	0.93520
atdothsr50_2	11.00	9.682	4.20	1.613	na	9.49304	na	na	10.17803	0.81241	0.00073	0.81387	0.93520
atdothsr50_3	11.00	9.682	4.20	1.613	na	9.49304	na	na	10.78140	0.79519	0.00071	0.79661	0.93520
atdothsr50_4	11.00	9.682	4.20	1.613	na	9.49304	na	na	11.32387	0.78668	0.00066	0.78800	0.93520
atdothsr50_5	11.00	9.682	4.20	1.613	na	9.49304	na	na	11.81882	0.78665	0.00072	0.78809	0.93520
atdothsr50_6	11.00	9.682	4.20	1.613	na	9.49304	na	na	12.27546	0.78707	0.00071	0.78849	0.93520
atdosthr50_7	11.00	9.682	4.20	1.613	na	9.49304	na	na	12.70044	0.78989	0.00072	0.79133	0.93520
atdothsr50_8	11.00	9.682	4.20	1.613	na	9.49304	na	na	13.09874	0.79456	0.00076	0.79608	0.93520
atdothsr50_9	11.00	9.682	4.20	1.613	na	9.49304	na	na	13.47419	0.79734	0.00063	0.79860	0.93520
atdothsr50_10	11.00	9.682	4.20	1.613	na	9.49304	na	na	13.82980	0.80197	0.00067	0.80331	0.93520
atdosthr50_11	11.00	9.682	4.20	1.613	na	9.49304	na	na	14.16801	0.80570	0.00077	0.80724	0.93520
Saturated UO_2-ThO_2 at 4.0 g/cm^3													
atdothsr40_1	11.00	9.682	4.20	2.372	na	10.12161	na	na	na	0.89234	0.00080	0.89394	0.93520
atdothsr40_2	11.00	9.682	4.20	2.372	na	10.12161	na	na	10.73125	0.85848	0.00090	0.86028	0.93520
atdothsr40_3	11.00	9.682	4.20	2.372	na	10.12161	na	na	11.27844	0.84262	0.00069	0.84400	0.93520
atdothsr40_4	11.00	9.682	4.20	2.372	na	10.12161	na	na	11.77714	0.83493	0.00074	0.83641	0.93520
atdothsr40_5	11.00	9.682	4.20	2.372	na	10.12161	na	na	12.23684	0.83368	0.00067	0.83502	0.93520
atdothsr40_6	11.00	9.682	4.20	2.372	na	10.12161	na	na	12.66437	0.83596	0.00067	0.83730	0.93520

Table 6.9.10.9-4. Results for HEU oxide and thorium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdothsr40_7	11.00	9.682	4.20	2.372	na	10.12161	na	na	13.06484	0.83661	0.00068	0.83797	0.93520
atdothsr40_8	11.00	9.682	4.20	2.372	na	10.12161	na	na	13.44216	0.81471	0.00072	0.81615	0.93520
atdothsr40_9	11.00	9.682	4.20	2.372	na	10.12161	na	na	13.79940	0.84468	0.00071	0.84610	0.93520
atdothsr40_10	11.00	9.682	4.20	2.372	na	10.12161	na	na	14.13905	0.84902	0.00071	0.85044	0.93520
atdothsr40_11	11.00	9.682	4.20	2.372	na	10.12161	na	na	14.46312	0.85450	0.00068	0.85586	0.93520
Saturated UO_2-ThO_2 at 3.0 g/cm^3													
atdothsr30_1	9.40	8.274	5.80	3.623	na	11.02288	na	na	na	0.93202	0.00074	0.93350	0.93520
atdothsr30_2	9.40	8.274	5.80	3.623	na	11.02288	na	na	11.54352	0.90362	0.00082	0.90526	0.93520
atdothsr30_3	9.40	8.274	5.80	3.623	na	11.02288	na	na	12.02092	0.88796	0.00073	0.88942	0.93520
atdothsr30_4	9.40	8.274	5.80	3.623	na	11.02288	na	na	12.46314	0.88187	0.00082	0.88351	0.93520
atdothsr30_5	9.40	8.274	5.80	3.623	na	11.02288	na	na	12.87603	0.87974	0.00071	0.88116	0.93520
atdothsr30_6	9.40	8.274	5.80	3.623	na	11.02288	na	na	13.26401	0.88221	0.00086	0.88393	0.93520
atdothsr30_7	9.40	8.274	5.80	3.623	na	11.02288	na	na	13.63053	0.88285	0.00091	0.88467	0.93520
atdothsr30_8	9.40	8.274	5.80	3.623	na	11.02288	na	na	13.97834	0.88432	0.00066	0.88564	0.93520
atdothsr30_9	9.40	8.274	5.80	3.623	na	11.02288	na	na	14.30965	0.88918	0.00072	0.89062	0.93520
atdothsr30_10	9.40	8.274	5.80	3.623	na	11.02288	na	na	14.62628	0.89202	0.00068	0.89338	0.93520
atdothsr30_11	9.40	8.274	5.80	3.623	na	11.02288	na	na	14.92977	0.89598	0.00073	0.89744	0.93520
Saturated UO_2-ThO_2 at 2.0 g/cm^3													
atdothsr_1	2.95	2.597	12.25	6.095	na	12.48074	na	na	na	0.93351	0.00086	0.93523	0.93680
atdothsr_2	2.95	2.597	12.25	6.095	na	12.48074	na	na	12.89262	0.90329	0.00076	0.90481	0.93680
atdothsr_3	2.95	2.597	12.25	6.095	na	12.48074	na	na	13.27964	0.88889	0.00082	0.89053	0.93680
atdothsr_4	2.95	2.597	12.25	6.095	na	12.48074	na	na	13.64534	0.88252	0.00088	0.88428	0.93680
atdothsr_5	2.95	2.597	12.25	6.095	na	12.48074	na	na	13.99242	0.88051	0.00074	0.88199	0.93680
atdothsr_6	2.95	2.597	12.25	6.095	na	12.48074	na	na	14.32308	0.88164	0.00076	0.88316	0.93680
atdothsr_7	2.95	2.597	12.25	6.095	na	12.48074	na	na	14.63914	0.88201	0.00093	0.88387	0.93680

Table 6.9.10.9-4. Results for HEU oxide and thorium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdothsr_8	2.95	2.597	12.25	6.095	na	12.48074	na	na	14.94212	0.88459	0.00085	0.88629	0.93680
atdothsr_9	2.95	2.597	12.25	6.095	na	12.48074	na	na	15.23328	0.88769	0.00078	0.88925	0.93680
atdothsr_10	2.95	2.597	12.25	6.095	na	12.48074	na	na	15.51372	0.89077	0.00079	0.89235	0.93680
atdothsr_11	2.95	2.597	12.25	6.095	na	12.48074	na	na	15.78437	0.89407	0.00082	0.89571	0.93680
Saturated UO_2-ThO_2 at 1.5 g/cm^3													
atdothsr15_1	1.80	1.584	12.70	8.218	na	13.45802	na	na	na	0.93196	0.00073	0.93342	0.93680
atdothsr15_2	1.80	1.584	12.70	8.218	na	13.45802	na	na	13.81455	0.90191	0.00082	0.90355	0.93680
atdothsr15_3	1.80	1.584	12.70	8.218	na	13.45802	na	na	14.15348	0.89045	0.00081	0.89207	0.93680
atdothsr15_4	1.80	1.584	12.70	8.218	na	13.45802	na	na	14.47691	0.88418	0.00073	0.88564	0.93680
atdothsr15_5	1.80	1.584	12.70	8.218	na	13.45802	na	na	14.78650	0.88182	0.00078	0.88338	0.93680
atdothsr15_6	1.80	1.584	12.70	8.218	na	13.45802	na	na	15.08364	0.88391	0.00071	0.88533	0.93680
atdothsr15_7	1.80	1.584	12.70	8.218	na	13.45802	na	na	15.36952	0.88493	0.00066	0.88625	0.93680
atdothsr15_8	1.80	1.584	12.70	8.218	na	13.45802	na	na	15.64514	0.88618	0.00087	0.88792	0.93680
atdothsr15_9	1.80	1.584	12.70	8.218	na	13.45802	na	na	15.91137	0.88996	0.00072	0.89140	0.93680
atdothsr15_10	1.80	1.584	12.70	8.218	na	13.45802	na	na	16.16899	0.89018	0.00077	0.89172	0.93680
atdothsr15_11	1.80	1.584	12.70	8.218	na	13.45802	na	na	16.41864	0.89359	0.00076	0.89511	0.93680
Saturated UO_2-ThO_2 at 1.0 g/cm^3													
atdothsr10_1	1.30	1.144	8.35	8.681	na	13.45069	na	na	na	0.93045	0.00075	0.93195	0.93680
atdothsr10_2	1.30	1.144	8.35	8.681	na	13.45069	na	na	13.80760	0.89833	0.00076	0.89985	0.93680
atdothsr10_3	1.30	1.144	8.35	8.681	na	13.45069	na	na	14.14685	0.88779	0.00082	0.88943	0.93680
atdothsr10_4	1.30	1.144	8.35	8.681	na	13.45069	na	na	14.47058	0.88275	0.00073	0.88421	0.93680
atdothsr10_5	1.30	1.144	8.35	8.681	na	13.45069	na	na	14.78043	0.88071	0.00099	0.88269	0.93680
atdothsr10_6	1.30	1.144	8.35	8.681	na	13.45069	na	na	15.07781	0.88181	0.00078	0.88337	0.93680
atdothsr10_7	1.30	1.144	8.35	8.681	na	13.45069	na	na	15.36390	0.88481	0.00071	0.88623	0.93680
atdothsr10_8	1.30	1.144	8.35	8.681	na	13.45069	na	na	15.63972	0.88576	0.00080	0.88736	0.93680

Table 6.9.10.9-4. Results for HEU oxide and thorium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdothsr10_9	1.30	1.144	8.35	8.681	na	13.45069	na	na	15.90613	0.88780	0.00082	0.88944	0.93680
atdothsr10_10	1.30	1.144	8.35	8.681	na	13.45069	na	na	16.16391	0.89142	0.00084	0.89310	0.93680
atdothsr10_11	1.30	1.144	8.35	8.681	na	13.45069	na	na	16.41372	0.89390	0.00075	0.89540	0.93680
Compromised package, HEU-poly core in spherical configuration, dry (bound water) Kaolite shell, 20.0 cm water reflector (Model 3)													
Saturated UO_2-ThO_2 at 5.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdothdkr50_1	11.00	9.682	4.20	1.613	na	9.49304	0	0	na	0.85077	0.00071	0.85219	0.93520
atdothdkr50_2	11.00	9.682	4.20	1.613	na	9.49304	10.243	0.441	18.9606	0.72169	0.00064	0.72297	0.93520
atdothdkr50_3	11.00	9.682	4.20	1.613	na	9.49304	20.486	0.882	23.3783	0.69198	0.00076	0.69350	0.93520
atdothdkr50_4	11.00	9.682	4.20	1.613	na	9.49304	30.729	1.323	26.56086	0.67770	0.00071	0.67912	0.93520
atdothdkr50_5	11.00	9.682	4.20	1.613	na	9.49304	40.972	1.764	29.12235	0.66803	0.00069	0.66941	0.93520
atdothdkr50_6	11.00	9.682	4.20	1.613	na	9.49304	51.214	2.205	31.29849	0.66170	0.00067	0.66304	0.93520
Saturated UO_2-ThO_2 at 4.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdothdkr40_1	11.00	9.682	4.20	2.372	na	10.12161	0	0	na	0.89234	0.00080	0.89394	0.93520
atdothdkr40_2	11.00	9.682	4.20	2.372	na	10.12161	10.243	0.441	19.12736	0.77086	0.00065	0.77216	0.93520
atdothdkr40_3	11.00	9.682	4.20	2.372	na	10.12161	20.486	0.882	23.48843	0.74395	0.00069	0.74533	0.93520
atdothdkr40_4	11.00	9.682	4.20	2.372	na	10.12161	30.729	1.323	26.64632	0.72820	0.00080	0.72980	0.93520
atdothdkr40_5	11.00	9.682	4.20	2.372	na	10.12161	40.972	1.764	29.19349	0.71889	0.00068	0.72025	0.93520
atdothdkr40_6	11.00	9.682	4.20	2.372	na	10.12161	51.214	2.205	31.36011	0.71328	0.00077	0.71482	0.93520
Saturated UO_2-ThO_2 at 3.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdothdkr30_1	9.40	8.274	5.80	3.623	na	11.02288	0	0	na	0.93202	0.00074	0.93350	0.93520
atdothdkr30_2	9.40	8.274	5.80	3.623	na	11.02288	10.243	0.441	19.39900	0.92391	0.00083	0.92557	0.93520
atdothdkr30_3	9.40	8.274	5.80	3.623	na	11.02288	20.486	0.882	23.66974	0.79656	0.00070	0.79796	0.93520
atdothdkr30_4	9.40	8.274	5.80	3.623	na	11.02288	30.729	1.323	26.78753	0.78241	0.00082	0.78405	0.93520
atdothdkr30_5	9.40	8.274	5.80	3.623	na	11.02288	40.972	1.764	29.31129	0.77183	0.00068	0.77319	0.93520
atdothdkr30_6	9.40	8.274	5.80	3.623	na	11.02288	51.214	2.205	31.46227	0.76511	0.00094	0.76699	0.93520

Table 6.9.10.9-4. Results for HEU oxide and thorium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2-ThO_2 at 2.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdothdkr_1	2.95	2.597	12.25	6.095	na	12.48074	0	0	na	0.93351	0.00086	0.93523	0.93680
atdothdkr_2	2.95	2.597	12.25	6.095	na	12.48074	10.243	0.441	19.92056	0.83976	0.00078	0.84132	0.93680
atdothdkr_3	2.95	2.597	12.25	6.095	na	12.48074	20.486	0.882	24.02423	0.81259	0.00092	0.81443	0.93680
atdothdkr_4	2.95	2.597	12.25	6.095	na	12.48074	30.729	1.323	27.06558	0.79790	0.00100	0.79990	0.93680
atdothdkr_5	2.95	2.597	12.25	6.095	na	12.48074	40.972	1.764	29.54408	0.78927	0.00088	0.79103	0.93680
atdothdkr_6	2.95	2.597	12.25	6.095	na	12.48074	51.214	2.205	31.66462	0.78209	0.00099	0.78407	0.93680
Saturated UO_2-ThO_2 at 1.5 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdothdkr15_1	1.80	1.584	12.70	8.218	na	13.45802	0	0	na	0.93196	0.00073	0.93342	0.93680
atdothdkr15_2	1.80	1.584	12.70	8.218	na	13.45802	10.243	0.441	20.32666	0.85392	0.00072	0.85536	0.93680
atdothdkr15_3	1.80	1.584	12.70	8.218	na	13.45802	20.486	0.882	24.30586	0.82893	0.00082	0.83057	0.93680
atdothdkr15_4	1.80	1.584	12.70	8.218	na	13.45802	30.729	1.323	27.28825	0.81549	0.00072	0.81693	0.93680
atdothdkr15_5	1.80	1.584	12.70	8.218	na	13.45802	40.972	1.764	29.73131	0.80907	0.00083	0.81073	0.93680
atdothdkr15_6	1.80	1.584	12.70	8.218	na	13.45802	51.214	2.205	31.82781	0.80204	0.00082	0.80368	0.93680
Saturated UO_2-ThO_2 at 1.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdothdkr10_1	1.30	1.144	8.35	8.681	na	13.45069	0	0	na	0.93045	0.00075	0.93195	0.93680
atdothdkr10_2	1.30	1.144	8.35	8.681	na	13.45069	10.243	0.441	20.32345	0.85187	0.00085	0.85357	0.93680
atdothdkr10_3	1.30	1.144	8.35	8.681	na	13.45069	20.486	0.882	24.30362	0.82936	0.00081	0.83098	0.93680
atdothdkr10_4	1.30	1.144	8.35	8.681	na	13.45069	30.729	1.323	27.28647	0.81760	0.00090	0.81940	0.93680
atdothdkr10_5	1.30	1.144	8.35	8.681	na	13.45069	40.972	1.764	29.72981	0.80935	0.00088	0.81111	0.93680
atdothdkr10_6	1.30	1.144	8.35	8.681	na	13.45069	51.214	2.205	31.82650	0.80349	0.00075	0.80499	0.93680
Compromised package, HEU-poly core in sph. config., wet (bound plus 15-lb free water) Kaolite shell, 20.0-cm water reflector (Model 3)													
UO_2-ThO_2 saturated oxide at 5.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdoth15kr50_1	11.00	9.682	4.20	1.613	na	9.49304	0	0	na	0.85077	0.00071	0.85219	0.93520
atdoth15kr50_2	11.00	9.682	4.20	1.613	na	9.49304	10.243	1.802	18.96060	0.72168	0.00068	0.72304	0.93520

Table 6.9.10.9-4. Results for HEU oxide and thorium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdoth15kr50_3	11.00	9.682	4.20	1.613	na	9.49304	20.486	3.604	23.37830	0.69457	0.00069	0.69595	0.93520
atdoth15kr50_4	11.00	9.682	4.20	1.613	na	9.49304	30.729	5.405	26.56086	0.68336	0.00066	0.68468	0.93520
atdoth15kr50_5	11.00	9.682	4.20	1.613	na	9.49304	40.972	7.207	29.12235	0.67577	0.00075	0.67727	0.93520
atdoth15kr50_6	11.00	9.682	4.20	1.613	na	9.49304	51.214	9.009	31.29849	0.67133	0.00070	0.67273	0.93520
Saturated UO_2-ThO_2 at 4.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdoth15kr40_1	11.00	9.682	4.20	2.372	na	10.12161	0	0	na	0.89234	0.00080	0.89394	0.93520
atdoth15kr40_2	11.00	9.682	4.20	2.372	na	10.12161	10.243	1.802	19.12736	0.77402	0.00075	0.77552	0.93520
atdoth15kr40_3	11.00	9.682	4.20	2.372	na	10.12161	20.486	3.604	23.48843	0.74584	0.00072	0.74728	0.93520
atdoth15kr40_4	11.00	9.682	4.20	2.372	na	10.12161	30.729	5.405	26.64632	0.73426	0.00077	0.73580	0.93520
atdoth15kr40_5	11.00	9.682	4.20	2.372	na	10.12161	40.972	7.207	29.19349	0.72633	0.00078	0.72789	0.93520
atdoth15kr40_6	11.00	9.682	4.20	2.372	na	10.12161	51.214	9.009	31.36011	0.72198	0.00092	0.72382	0.93520
Saturated UO_2-ThO_2 at 3.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdoth15kr30_1	9.40	8.274	5.80	3.623	na	11.02288	0	0	na	0.93202	0.00074	0.93350	0.93520
atdoth15kr30_2	9.40	8.274	5.80	3.623	na	11.02288	10.243	1.802	19.39900	0.82543	0.00069	0.82681	0.93520
atdoth15kr30_3	9.40	8.274	5.80	3.623	na	11.02288	20.486	3.604	23.66974	0.79921	0.00079	0.80079	0.93520
atdoth15kr30_4	9.40	8.274	5.80	3.623	na	11.02288	30.729	5.405	26.78753	0.78513	0.00073	0.78659	0.93520
atdoth15kr30_5	9.40	8.274	5.80	3.623	na	11.02288	40.972	7.207	29.31129	0.77913	0.00072	0.78057	0.93520
atdoth15kr30_6	9.40	8.274	5.80	3.623	na	11.02288	51.214	9.009	31.46227	0.77288	0.00088	0.77464	0.93520
Saturated UO_2-ThO_2 at 2.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdoth15kr_1	2.90	2.597	12.30	6.095	na	12.48074	0	0	na	0.93351	0.00086	0.93523	0.93680
atdoth15kr_2	2.90	2.597	12.30	6.095	na	12.48074	10.243	1.802	19.92056	0.84231	0.00087	0.84405	0.93680
atdoth15kr_3	2.90	2.597	12.30	6.095	na	12.48074	20.486	3.604	24.02423	0.81734	0.00086	0.81906	0.93680
atdoth15kr_4	2.90	2.597	12.30	6.095	na	12.48074	30.729	5.405	27.06558	0.80339	0.00089	0.80517	0.93680
atdoth15kr_5	2.90	2.597	12.30	6.095	na	12.48074	40.972	7.207	29.54408	0.79651	0.00085	0.79821	0.93680
atdoth15kr_6	2.90	2.597	12.30	6.095	na	12.48074	51.214	9.009	31.66462	0.79157	0.00076	0.79309	0.93680

Table 6.9.10.9-4. Results for HEU oxide and thorium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
UO_2-ThO_2 saturated oxide at 1.5 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdoth15kr15_1	1.80	1.584	12.70	8.218	na	13.45802	0	0	na	0.93196	0.00073	0.93342	0.93680
atdoth15kr15_2	1.80	1.584	12.70	8.218	na	13.45802	10.243	1.802	20.32666	0.85748	0.00091	0.85930	0.93680
atdoth15kr15_3	1.80	1.584	12.70	8.218	na	13.45802	20.486	3.604	24.30586	0.83584	0.00075	0.83734	0.93680
atdoth15kr15_4	1.80	1.584	12.70	8.218	na	13.45802	30.729	5.405	27.28825	0.82184	0.00089	0.82362	0.93680
atdoth15kr15_5	1.80	1.584	12.70	8.218	na	13.45802	40.972	7.207	29.73131	0.81558	0.00079	0.81716	0.93680
atdoth15kr15_6	1.80	1.584	12.70	8.218	na	13.45802	51.214	9.009	31.82781	0.81459	0.00092	0.81643	0.93680
Saturated UO_2-ThO_2 at 1.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdoth15kr10_1	1.30	1.144	8.35	8.681	na	13.45069	0	0	na	0.93045	0.00075	0.93195	0.93680
atdoth15kr10_2	1.30	1.144	8.35	8.681	na	13.45069	10.243	1.802	20.32345	0.85618	0.00093	0.85804	0.93680
atdoth15kr10_3	1.30	1.144	8.35	8.681	na	13.45069	20.486	3.604	24.30362	0.85373	0.00083	0.85539	0.93680
atdoth15kr10_4	1.30	1.144	8.35	8.681	na	13.45069	30.729	5.405	27.28647	0.82505	0.00080	0.82665	0.93680
atdoth15kr10_5	1.30	1.144	8.35	8.681	na	13.45069	40.972	7.207	29.72981	0.81947	0.00075	0.82097	0.93680
atdoth15kr10_6	1.30	1.144	8.35	8.681	na	13.45069	51.214	9.009	31.82650	0.81532	0.00082	0.81696	0.93680
Compromised package, homogeneous fixed-radius core [HEU, poly, wet Kaolite], 20.0 cm water reflector (Model 4)													
Saturated UO_2-ThO_2 at 5.0 g/cm^3													
athothp15kr50_1	11.00	9.682	4.20	3.818	51.214	31.29850	na	na	na	0.53842	0.00070	0.53982	0.93680
athothp15kr50_2	11.00	9.682	4.20	5.519	51.214	31.29850	na	na	na	0.56075	0.00065	0.56205	0.93680
athothp15kr50_3	11.00	9.682	4.20	7.220	51.214	31.29850	na	na	na	0.58424	0.00072	0.58568	0.93680
athothp15kr50_4	11.00	9.682	4.20	8.921	51.214	31.29850	na	na	na	0.60746	0.00071	0.60888	0.93680
athothp15kr50_5	11.00	9.682	4.20	10.622	51.214	31.29850	na	na	na	0.63153	0.00081	0.63315	0.93680
Saturated UO_2-ThO_2 at 4.0 g/cm^3													
athothp15kr40_1	11.00	9.682	4.20	4.575	51.214	31.36011	na	na	na	0.54662	0.00066	0.54794	0.93680
athothp15kr40_2	11.00	9.682	4.20	6.278	51.214	31.36011	na	na	na	0.57060	0.00073	0.57206	0.93680
athothp15kr40_3	11.00	9.682	4.20	7.979	51.214	31.36011	na	na	na	0.59429	0.00063	0.59555	0.93680

Table 6.9.10.9-4. Results for HEU oxide and thorium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athothp15kr40_4	11.00	9.682	4.20	9.680	51.214	31.36011	na	na	na	0.61792	0.00070	0.61932	0.93680
athothp15kr40_5	11.00	9.682	4.20	11.381	51.214	31.36011	na	na	na	0.64063	0.00067	0.64197	0.93680
Saturated UO_2-ThO_2 at 3.0 g/cm^3													
athothp15kr30_1	9.40	8.274	5.80	5.827	51.214	31.46227	na	na	na	0.55098	0.00066	0.55230	0.93680
athothp15kr30_2	9.40	8.274	5.80	7.528	51.214	31.46227	na	na	na	0.57331	0.00071	0.57473	0.93680
athothp15kr30_3	9.40	8.274	5.80	9.229	51.214	31.46227	na	na	na	0.59601	0.00064	0.59729	0.93680
athothp15kr30_4	9.40	8.274	5.80	10.930	51.214	31.46227	na	na	na	0.62068	0.00066	0.62200	0.93680
athothp15kr30_5	9.40	8.274	5.80	12.631	51.214	31.46227	na	na	na	0.64230	0.00071	0.64372	0.93680
Saturated UO_2-ThO_2 at 2.0 g/cm^3													
athothp15kr_1	2.90	2.597	12.30	8.299	51.214	31.66463	na	na	na	0.46458	0.00057	0.46572	0.93680
athothp15kr_2	2.90	2.597	12.30	10.000	51.214	31.66463	na	na	na	0.48239	0.00059	0.48357	0.93680
athothp15kr_3	2.90	2.597	12.30	11.701	51.214	31.66463	na	na	na	0.50118	0.00063	0.50244	0.93680
athothp15kr_4	2.90	2.597	12.30	13.402	51.214	31.66463	na	na	na	0.51899	0.00056	0.52011	0.93680
athothp15kr_5	2.90	2.597	12.30	15.103	51.214	31.66463	na	na	na	0.53930	0.00062	0.54054	0.93680
Saturated UO_2-ThO_2 at 1.5 g/cm^3													
athothp15kr15_1	1.80	1.584	12.70	10.422	51.214	32.82781	na	na	na	0.41599	0.00048	0.41695	0.93680
athothp15kr15_2	1.80	1.584	12.70	12.123	51.214	32.82781	na	na	na	0.43209	0.00047	0.43303	0.93680
athothp15kr15_3	1.80	1.584	12.70	13.824	51.214	32.82781	na	na	na	0.44721	0.00055	0.44831	0.93680
athothp15kr15_4	1.80	1.584	12.70	15.525	51.214	32.82781	na	na	na	0.46341	0.00054	0.46449	0.93680
athothp15kr15_5	1.80	1.584	12.70	17.226	51.214	32.82781	na	na	na	0.47925	0.00054	0.48033	0.93680
Saturated UO_2-ThO_2 at 1.0 g/cm^3													
athothp15kr10_1	1.30	1.144	8.35	10.886	51.214	31.82650	na	na	na	0.37977	0.00060	0.38097	0.93680
athothp15kr10_2	1.30	1.144	8.35	12.586	51.214	31.82650	na	na	na	0.39328	0.00046	0.39420	0.93680
athothp15kr10_3	1.30	1.144	8.35	14.287	51.214	31.82650	na	na	na	0.40696	0.00042	0.40780	0.93680
athothp15kr10_4	1.30	1.144	8.35	15.988	51.214	31.82650	na	na	na	0.41972	0.00056	0.42084	0.93680
athothp15kr10_5	1.30	1.144	8.35	17.689	51.214	31.82650	na	na	na	0.43360	0.00047	0.43454	0.93680

Table 6.9.10.9-4. Results for HEU oxide and thorium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Compromised package, homogeneous core [HEU, poly, free water from wet Kaolite], wet Kaolite shell, 20.0 cm water reflector (Model 5)													
Saturated UO_2-ThO_2 at 5.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb													
athothpw12kr50_1_1_5	8.00	7.042	0.00	6.311	na	12.19423	51.215	2.205	31.62107	0.92691	0.00089	0.92869	0.93520
athothpw12kr50_2_1_5	8.00	7.042	1.00	6.411	na	12.30034	51.215	2.205	31.63697	0.92270	0.00089	0.92448	0.93520
athothpw12kr50_7_1_5	8.00	7.042	7.20	7.029	na	12.92072	51.215	2.205	31.73526	0.90226	0.00087	0.90400	0.93520
athothpw12kr50_1_2_5	8.60	7.57	0.00	6.376	na	12.25812	51.215	2.205	31.63061	0.93308	0.00082	0.93472	0.93520
athothpw12kr50_1_2_4	8.60	7.57	0.00	5.015	na	11.48905	51.215	3.565	31.52183	0.87609	0.00088	0.87785	0.93520
athothpw12kr50_1_2_3	8.60	7.57	0.00	3.655	na	10.60038	51.215	4.926	31.41229	0.81210	0.00090	0.81390	0.93520
athothpw12kr50_1_2_2	8.60	7.57	0.00	2.294	na	9.53085	51.215	6.286	31.30198	0.72910	0.00076	0.73062	0.93520
athothpw12kr50_1_2_1	8.60	7.57	0.00	0.934	na	8.14509	51.215	7.647	31.19089	0.62788	0.00069	0.62926	0.93520
athothpw12kr50_2_2_5	8.60	7.57	1.00	6.476	na	12.36313	51.215	2.205	31.64651	0.92507	0.00079	0.92665	0.93520
athothpw12kr50_3_2_5	8.60	7.57	2.00	6.575	na	12.46639	51.215	2.205	31.66240	0.92172	0.00098	0.92368	0.93520
athothpw12kr50_4_2_5	8.60	7.57	4.00	6.795	na	12.68774	51.215	2.205	31.69728	0.91305	0.00080	0.91465	0.93520
athothpw12kr50_6_2_5	8.60	7.57	6.60	6.795	na	12.68774	51.215	2.205	31.69728	0.91305	0.00080	0.91465	0.93520
athothpw12kr50_1_3_5	9.00	7.922	0.00	6.419	na	12.30034	51.215	2.205	31.63698	0.93462	0.00084	0.93630	0.93520
athothpw12kr50_5_3_5	9.00	7.922	6.20	7.038	na	12.92072	51.215	2.205	31.73526	0.91201	0.00090	0.91381	0.93520
Saturated UO_2-ThO_2 at 4.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb													
athothpw12kr40_1_1_5	6.00	5.281	0.00	6.393	na	12.14048	51.215	2.205	31.61311	0.92355	0.00091	0.92537	0.93520
athothpw12kr40_2_1_5	6.00	5.281	2.00	6.692	na	12.40464	51.215	2.205	31.65287	0.91385	0.00083	0.91551	0.93520
athothpw12kr40_3_1_5	6.00	5.281	4.00	6.992	na	12.65801	51.215	2.205	31.69253	0.91038	0.00098	0.91234	0.93520
athothpw12kr40_7_1_5	6.00	5.281	9.20	7.771	na	13.27328	51.215	2.205	31.79520	0.90830	0.00100	0.91030	0.93680
athothpw12kr40_1_2_5	6.85	6.029	0.00	6.528	na	12.25414	51.215	2.205	31.63002	0.93351	0.00079	0.93509	0.93520
athothpw12kr40_1_2_4	6.85	6.029	0.00	5.167	na	11.48452	51.215	3.565	31.52123	0.87839	0.00085	0.88009	0.93520
athothpw12kr40_1_2_3	6.85	6.029	0.00	3.807	na	10.59507	51.215	4.926	31.41169	0.81050	0.00083	0.81216	0.93520
athothpw12kr40_1_2_2	6.85	6.029	0.00	2.446	na	9.52428	51.215	6.286	31.30137	0.72521	0.00073	0.72667	0.93520

Table 6.9.10.9-4. Results for HEU oxide and thorium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athothpw12kr40_1_2_1	6.85	6.029	0.00	1.086	na	8.13609	51.215	7.647	31.19028	0.61835	0.00071	0.61977	0.93520
athothpw12kr40_2_2_5	6.85	6.029	2.00	6.827	na	12.51358	51.215	2.205	31.66974	0.92354	0.00072	0.92498	0.93520
athothpw12kr40_3_2_5	6.85	6.029	4.00	7.127	na	12.76268	51.215	2.205	31.70936	0.92013	0.00079	0.92171	0.93520
athothpw12kr40_4_2_5	6.85	6.029	6.00	7.426	na	13.00242	51.215	2.205	31.74888	0.91860	0.00093	0.92046	0.93520
athothpw12kr40_6_2_5	6.85	6.029	8.35	7.778	na	13.27328	51.215	2.205	31.79520	0.91723	0.00080	0.91883	0.93520
athothpw12kr40_1_3_5	7.00	6.161	0.00	6.551	na	12.27398	51.215	2.205	31.63300	0.93537	0.00095	0.93727	0.93520
athothpw12kr40_5_3_5	7.00	6.161	8.20	7.779	na	13.27328	51.215	2.205	31.79520	0.91868	0.00073	0.92014	0.93520
Saturated UO_2-ThO_2 at 3.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb													
athothpw12kr30_1_1_5	4.00	3.521	0.00	6.408	na	12.04982	51.215	2.205	31.59983	0.91372	0.00099	0.91570	0.93680
athothpw12kr30_2_1_5	4.00	3.521	2.00	6.875	na	12.40464	51.215	2.205	31.65287	0.90705	0.00081	0.90867	0.93680
athothpw12kr30_3_1_5	4.00	3.521	4.00	7.340	na	12.74025	51.215	2.205	31.70573	0.90540	0.00100	0.90740	0.93680
athothpw12kr30_4_1_5	4.00	3.521	6.20	7.853	na	13.09009	51.215	2.205	31.76368	0.90753	0.00092	0.90937	0.93680
athothpw12kr30_5_1_5	4.00	3.521	8.00	8.272	na	13.36301	51.215	2.205	31.81093	0.90873	0.00088	0.91049	0.93680
athothpw12kr30_6_1_5	4.00	3.521	10.10	8.761	na	13.66794	51.215	2.205	31.86588	0.91199	0.00081	0.91361	0.93680
athothpw12kr30_7_1_5	4.00	3.521	11.20	9.017	na	13.82238	51.215	2.205	31.89459	0.91222	0.00087	0.91396	0.93680
athothpw12kr30_1_2_5	5.10	4.489	0.00	6.675	na	12.24752	51.215	2.205	31.62902	0.93077	0.00088	0.93253	0.93680
athothpw12kr30_1_2_4	5.10	4.489	0.00	5.314	na	11.47698	51.215	3.565	31.52023	0.87543	0.00080	0.87703	0.93520
athothpw12kr30_1_2_3	5.10	4.489	0.00	3.954	na	10.5862	51.215	4.926	31.41068	0.80765	0.00084	0.80933	0.93520
athothpw12kr30_1_2_2	5.10	4.489	0.00	2.593	na	9.5133	51.215	6.286	31.30036	0.72244	0.00099	0.72442	0.93520
athothpw12kr30_1_2_1	5.10	4.489	0.00	1.233	na	8.12103	51.215	7.647	31.18925	0.60971	0.00068	0.61107	0.93520
athothpw12kr30_2_2_5	5.10	4.489	2.00	7.140	na	12.59144	51.215	2.205	31.68196	0.92545	0.00085	0.92715	0.93680
athothpw12kr30_3_2_5	5.10	4.489	4.00	7.606	na	12.91754	51.215	2.205	31.73473	0.92442	0.00096	0.92634	0.93680
athothpw12kr30_4_2_5	5.10	4.489	6.20	8.119	na	13.2582	51.215	2.205	31.79257	0.92837	0.00088	0.93013	0.93680
athothpw12kr30_5_2_5	5.10	4.489	8.00	8.538	na	13.52445	51.215	2.205	31.83974	0.93079	0.00079	0.93237	0.93680

Table 6.9.10.9-4. Results for HEU oxide and thorium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athothpw12kr30_6_2_5	5.10	4.489	10.10	9.027	na	13.82238	51.215	2.205	31.89459	0.93395	0.00086	0.93567	0.93680
athothpw12kr30_1_3_5	6.00	5.281	6.20	6.892	na	12.40464	51.215	2.205	31.65287	0.94403	0.00096	0.94595	0.93680
athothpw12kr30_5_3_5	6.00	5.281	6.20	8.336	na	13.39265	51.215	2.205	31.81617	0.94166	0.00099	0.94364	0.93680
Saturated UO_2-ThO_2 at 2.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb													
athothpw12kr_1_1_5	2.50	2.201	0.00	6.462	na	12.00398	51.215	2.205	31.59319	0.89621	0.00099	0.89819	0.93680
athothpw12kr_2_1_5	2.50	2.201	2.00	7.261	na	12.53261	51.215	2.205	31.67271	0.89598	0.00086	0.89770	0.93680
athothpw12kr_3_1_5	2.50	2.201	4.00	8.059	na	13.02005	51.215	2.205	31.75184	0.90140	0.00095	0.90330	0.93680
athothpw12kr_4_1_4	2.50	2.201	6.00	8.858	na	13.4735	51.215	2.205	31.83058	0.90673	0.00091	0.90855	0.93680
athothpw12kr_5_1_5	2.50	2.201	8.00	9.656	na	13.89832	51.215	2.205	31.90893	0.91169	0.00090	0.91349	0.93680
athothpw12kr_6_1_5	2.50	2.201	10.00	10.455	na	14.29865	51.215	2.205	31.98689	0.91646	0.00093	0.91832	0.93680
athothpw12kr_8_1_5	2.50	2.201	12.70	11.533	na	14.8059	51.215	2.205	32.09155	0.91987	0.00086	0.92159	0.93680
athothpw12kr_1_2_5	2.80	2.465	0.00	6.585	na	12.08625	51.215	2.205	31.60514	0.90446	0.00099	0.90644	0.93680
athothpw12kr_1_2_4	2.80	2.465	0.00	5.224	na	11.2928	51.215	3.565	31.49618	0.85076	0.00082	0.85240	0.93680
athothpw12kr_1_2_3	2.80	2.465	0.00	3.864	na	10.36874	51.215	4.926	31.38646	0.78010	0.00100	0.78210	0.93680
athothpw12kr_1_2_2	2.80	2.465	0.00	2.503	na	9.24184	51.215	6.286	31.27597	0.69033	0.00083	0.69199	0.93520
athothpw12kr_1_2_1	2.80	2.465	0.00	1.143	na	7.7416	51.215	7.647	31.16469	0.56712	0.00076	0.56864	0.93520
athothpw12kr_2_2_5	2.80	2.465	2.00	7.383	na	12.60815	51.215	2.205	31.68461	0.90590	0.00094	0.90778	0.93680
athothpw12kr_3_2_5	2.80	2.465	4.00	8.182	na	13.09009	51.215	2.205	31.76368	0.91332	0.00089	0.91510	0.93680
athothpw12kr_4_2_5	2.80	2.465	6.20	8.980	na	13.53893	51.215	2.205	31.84236	0.91938	0.00097	0.92132	0.93680
athothpw12kr_5_2_5	2.80	2.465	8.00	9.779	na	13.95984	51.215	2.205	31.92065	0.92630	0.00100	0.92830	0.93680
athothpw12kr_6_2_5	2.80	2.465	10.00	10.577	na	14.3568	51.215	2.205	31.99856	0.92955	0.00081	0.93117	0.93680
athothpw12kr_7_2_5	2.80	2.465	12.40	11.536	na	14.8059	51.215	2.205	32.09155	0.93388	0.00089	0.93566	0.93680
athothpw12kr_1_3_5	3.00	2.641	0.00	6.666	na	12.14048	51.215	2.205	31.61311	0.91064	0.00079	0.91222	0.93680
athothpw12kr_5_3_5	3.00	2.641	12.40	11.617	na	14.84211	51.215	2.205	32.09928	0.94380	0.00100	0.94580	0.93680

Table 6.9.10.9-4. Results for HEU oxide and thorium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2-ThO_2 at 1.5 g/cm^3, maximum free water in wet Kaolite limited to 12 lb													
athothpw12kr15_1_1_5	2.00	1.76	0.00	6.591	na	12.04982	51.215	2.205	31.59983	0.88747	0.00085	0.88917	0.93680
athothpw12kr15_2_1_5	2.00	1.76	2.00	7.722	na	12.74025	51.215	2.205	31.70573	0.89237	0.00078	0.89393	0.93680
athothpw12kr15_3_1_5	2.00	1.76	4.00	8.854	na	13.36301	51.215	2.205	31.81093	0.90458	0.00092	0.90642	0.93680
athothpw12kr15_4_1_5	2.00	1.76	6.00	9.985	na	13.93257	51.215	2.205	31.91544	0.91191	0.00081	0.91353	0.93680
athothpw12kr15_5_1_5	2.00	1.76	8.00	11.116	na	14.45902	51.215	2.205	32.01927	0.91627	0.00086	0.91799	0.93680
athothpw12kr15_6_1_5	2.00	1.76	10.00	12.247	na	14.9497	51.215	2.205	32.12243	0.92156	0.00099	0.92354	0.93680
athothpw12kr15_7_1_5	2.00	1.76	12.00	13.379	na	15.41012	51.215	2.205	32.22493	0.92410	0.00088	0.92586	0.93680
athothpw12kr15_9_1_5	2.00	1.76	12.50	13.662	na	15.52102	51.215	2.205	32.25045	0.92517	0.00085	0.92687	0.93680
athothpw12kr15_1_2_5	2.10	1.848	0.00	6.648	na	12.08625	51.215	2.205	31.60514	0.89180	0.00100	0.89380	0.93680
athothpw12kr15_1_2_4	2.10	1.848	0.00	5.288	na	11.2928	51.215	3.565	31.49618	0.84027	0.00087	0.84201	0.93680
athothpw12kr15_1_2_3	2.10	1.848	0.00	3.927	na	10.36874	51.215	4.926	31.38646	0.77467	0.00090	0.77647	0.93680
athothpw12kr15_1_2_2	2.10	1.848	0.00	2.567	na	9.24185	51.215	6.286	31.27597	0.68499	0.00085	0.68669	0.93680
athothpw12kr15_1_2_1	2.10	1.848	0.00	1.206	na	7.7416	51.215	7.647	31.16469	0.55842	0.00000	0.55842	0.93520
athothpw12kr15_2_2_5	2.10	1.848	2.00	7.780	na	12.77285	51.215	2.205	31.71101	0.89910	0.00010	0.89930	0.93680
athothpw12kr15_3_2_5	2.10	1.848	4.00	8.911	na	13.39265	51.215	2.205	31.81617	0.90788	0.00091	0.90970	0.93680
athothpw12kr15_4_2_5	2.10	1.848	6.00	10.042	na	13.95984	51.215	2.205	31.92065	0.91603	0.00085	0.91773	0.93680
athothpw12kr15_5_2_5	2.10	1.848	8.00	11.174	na	14.48435	51.215	2.205	32.02444	0.92433	0.00083	0.92599	0.93680
athothpw12kr15_6_2_5	2.10	1.848	10.00	12.305	na	14.9734	51.215	2.205	32.12757	0.92951	0.00087	0.93125	0.93680
athothpw12kr15_8_2_5	2.10	1.848	12.40	13.662	na	15.52102	51.215	2.205	32.25045	0.93155	0.00090	0.93335	0.93680
athothpw12kr15_1_3_5	2.50	2.201	0.00	6.735	na	12.14048	51.215	2.205	31.61311	0.89772	0.00092	0.89956	0.93680
athothpw12kr15_5_3_5	2.50	2.201	12.00	13.522	na	15.46577	51.215	2.205	32.23770	0.94294	0.00091	0.94476	0.93680
Saturated UO_2-ThO_2 at 1.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb													
athothpw12kr15_1_1_5	1.50	1.32	0.00	6.803	na	12.14048	51.215	2.205	31.61311	0.87323	0.00081	0.87485	0.93680
athothpw12kr15_2_1_5	1.50	1.32	2.00	8.600	na	13.13637	51.215	2.205	31.77156	0.88771	0.00091	0.88953	0.93680

Table 6.9.10.9-4. Results for HEU oxide and thorium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athothpw12kr15_3_1_5	1.50	1.32	4.00	10.396	na	14.00056	51.215	2.205	31.92846	0.90223	0.00082	0.90387	0.93680
athothpw12kr15_4_1_5	1.50	1.32	6.00	12.193	na	14.76951	51.215	2.205	32.08382	0.91035	0.00088	0.91211	0.93680
athothpw12kr15_7_1_5	1.50	1.32	8.15	14.125	na	15.51552	51.215	2.205	32.24918	0.91546	0.00077	0.91700	0.93680
athothpw12kr15_1_2_5	1.65	1.452	0.00	6.939	na	12.22094	51.215	2.205	31.62505	0.88283	0.00088	0.88459	0.93680
athothpw12kr15_1_2_4	1.65	1.452	0.00	5.578	na	11.44669	51.215	3.565	31.51622	0.83831	0.00080	0.83991	0.93680
athothpw12kr15_1_2_3	1.65	1.452	0.00	4.218	na	10.55058	51.215	4.926	31.40664	0.77751	0.00090	0.77931	0.93680
athothpw12kr15_1_2_2	1.65	1.452	0.00	2.857	na	9.46914	51.215	6.286	31.29630	0.69733	0.00079	0.69891	0.93680
athothpw12kr15_1_2_1	1.65	1.452	0.00	1.497	na	8.06026	51.215	7.647	31.18516	0.58040	0.00081	0.58202	0.93520
athothpw12kr15_2_2_5	1.65	1.452	2.00	8.736	na	13.20518	51.215	2.205	31.78338	0.90205	0.00092	0.90389	0.93680
athothpw12kr15_3_2_5	1.65	1.452	4.00	10.532	na	14.06119	51.215	2.205	31.94016	0.91640	0.00085	0.91810	0.93680
athothpw12kr15_4_2_5	1.65	1.452	6.00	12.329	na	14.82402	51.215	2.205	32.09541	0.92630	0.00100	0.92830	0.93680
athothpw12kr15_6_2_5	1.65	1.452	8.00	14.126	na	15.51552	51.215	2.205	32.24918	0.93375	0.00088	0.93551	0.93680
athothpw12kr15_1_3_5	1.75	1.54	0.00	7.030	na	12.27399	51.215	2.205	31.63300	0.89012	0.00087	0.89186	0.93680
athothpw12kr15_5_3_5	1.75	1.54	7.90	14.127	na	15.51552	51.215	2.205	32.24918	0.94117	0.00081	0.94279	0.93680

Table 6.9.10.9-5. Results for HEU oxide and thorium oxide content for air transportation (Model 6)

Case athothp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ThO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Compromised package, homogeneous core [HEU, poly, wet Kaolite, sat moisture from oxide], dry oxide shell, 20.0 cm water reflector													
Saturated UO_2-ThO_2 at 5.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
50_5_6_6	10.00	8.802	4.20	10.622	51.215	31.99956	1.00	0.880	32.01519	0.63573	0.00068	0.63709	0.93680
50_4_6_6	10.00	8.802	4.20	8.921	51.215	31.86658	1.00	0.880	31.88234	0.61346	0.00069	0.61484	0.93680
50_3_6_6	10.00	8.802	4.20	7.220	51.215	31.73248	1.00	0.880	31.74838	0.59166	0.00065	0.59296	0.93680
50_2_6_6	10.00	8.802	4.20	5.519	51.215	31.59724	1.00	0.880	31.61327	0.56792	0.00063	0.56918	0.93680
50_1_6_6	10.00	8.802	4.20	3.818	51.215	31.46083	1.00	0.880	31.477	0.54763	0.00080	0.54923	0.93680
50_5_5_5	8.00	7.042	4.20	10.622	51.215	31.96844	3.00	2.640	32.01519	0.64905	0.00076	0.65057	0.93680
50_4_5_5	8.00	7.042	4.20	8.921	51.215	31.83520	3.00	2.640	31.88234	0.62659	0.00069	0.62797	0.93680
50_3_5_5	8.00	7.042	4.20	7.220	51.215	31.70084	3.00	2.640	31.74838	0.60385	0.00067	0.60519	0.93680
50_2_5_5	8.00	7.042	4.20	5.519	51.215	31.61327	3.00	2.640	31.61327	0.58178	0.00060	0.58298	0.93680
50_1_5_5	8.00	7.042	4.20	3.818	51.215	31.42864	3.00	2.641	31.477	0.55836	0.00066	0.55968	0.93680
50_5_4_4	6.00	5.281	4.20	10.622	51.215	31.93727	5.00	4.401	32.01519	0.65723	0.00062	0.65847	0.93680
50_4_4_4	6.00	5.281	4.20	8.921	51.215	31.80376	5.00	4.401	31.88234	0.63266	0.00064	0.63394	0.93680
50_3_4_4	6.00	5.281	4.20	7.220	51.215	31.66913	5.00	4.401	31.74838	0.61158	0.00065	0.61288	0.93680
50_2_4_4	6.00	5.281	4.20	5.519	51.215	31.53334	5.00	4.401	31.61327	0.58951	0.00083	0.59117	0.93680
50_1_4_4	6.00	5.281	4.20	3.818	51.215	31.39638	5.00	4.401	31.477	0.56738	0.00067	0.56872	0.93680
50_5_3_3	5.00	4.401	4.20	10.622	51.215	31.92165	6.00	5.281	32.01519	0.65765	0.00069	0.65903	0.93680
50_4_3_3	5.00	4.401	4.20	8.921	51.215	31.78802	6.00	5.281	31.88234	0.63676	0.00065	0.63806	0.93680
50_3_3_3	5.00	4.401	4.20	7.220	51.215	31.65325	6.00	5.281	31.74838	0.61414	0.00065	0.61544	0.93680
50_2_3_3	5.00	4.401	4.20	5.519	51.215	31.51733	6.00	5.281	31.61327	0.59173	0.00067	0.59307	0.93680
50_1_3_3	5.00	4.401	4.20	3.818	51.215	31.38022	6.00	5.281	31.477	0.56984	0.00071	0.57126	0.93680
50_5_2_2	3.00	2.640	4.20	10.622	51.215	31.89039	8.00	7.042	32.01519	0.65860	0.00063	0.65986	0.93680
50_4_2_2	3.00	2.640	4.20	8.921	51.215	31.75649	8.00	7.042	31.88234	0.63947	0.00062	0.64071	0.93680

Table 6.9.10.9-5. Results for HEU oxide and thorium oxide content for air transportation (Model 6)

Case athothp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ThO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
50_3_2_2	3.00	2.640	4.20	7.220	51.215	31.62145	8.00	7.042	31.74838	0.61801	0.00063	0.61927	0.93680
50_2_2_2	3.00	2.640	4.20	5.519	51.215	31.48525	8.00	7.042	31.61327	0.59582	0.00072	0.59726	0.93680
50_1_2_2	3.00	2.640	4.20	3.818	51.215	31.34787	8.00	7.042	31.477	0.57434	0.00065	0.57564	0.93680
50_5_1_1	1.00	0.880	4.20	10.622	51.215	31.85906	10.00	8.802	32.01519	0.65149	0.00064	0.65277	0.93680
50_4_1_1	1.00	0.880	4.20	8.921	51.215	31.72489	10.00	8.802	31.88234	0.63438	0.00067	0.63572	0.93680
50_3_1_1	1.00	0.880	4.20	7.220	51.215	31.58959	10.00	8.802	31.74838	0.61535	0.00063	0.61661	0.93680
50_2_1_1	1.00	0.880	4.20	5.519	51.215	31.45311	10.00	8.802	31.61327	0.59620	0.00061	0.59742	0.93680
50_1_1_1	1.00	0.880	4.20	3.818	51.215	31.31544	10.00	8.802	31.477	0.57580	0.00061	0.57702	0.93680
Saturated UO_2-ThO_2 at 4.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
40_5_6_6	10.00	8.802	4.20	11.381	51.215	32.05464	1.00	0.880	32.07409	0.64509	0.00062	0.64633	0.93680
40_4_6_6	10.00	8.802	4.20	9.680	51.215	31.92212	1.00	0.880	31.94173	0.62304	0.00064	0.62432	0.93680
40_3_6_6	10.00	8.802	4.20	7.979	51.215	31.78849	1.00	0.880	31.80827	0.60079	0.00067	0.60213	0.93680
40_2_6_6	10.00	8.802	4.20	6.278	51.215	31.65373	1.00	0.880	31.67367	0.57785	0.00069	0.57923	0.93680
40_1_6_6	10.00	8.802	4.20	4.577	51.215	31.51781	1.00	0.880	31.53792	0.55725	0.00059	0.55843	0.93680
40_5_5_5	8.00	7.042	4.20	11.381	51.215	32.01587	3.00	2.640	32.07409	0.65935	0.00081	0.66097	0.93680
40_4_5_5	8.00	7.042	4.20	9.680	51.215	31.88303	3.00	2.640	31.94173	0.63563	0.00065	0.63693	0.93680
40_3_5_5	8.00	7.042	4.20	7.979	51.215	31.74907	3.00	2.640	31.80827	0.61476	0.00067	0.61610	0.93680
40_2_5_5	8.00	7.042	4.20	6.278	51.215	31.61397	3.00	2.640	31.67367	0.59181	0.00070	0.59321	0.93680
40_1_5_5	8.00	7.042	4.20	4.577	51.215	31.47770	3.00	2.641	31.53792	0.56982	0.00063	0.57108	0.93680
40_5_4_4	6.00	5.281	4.20	11.381	51.215	31.97700	5.00	4.401	32.07409	0.66453	0.00063	0.66579	0.93680
40_4_4_4	6.00	5.281	4.20	9.680	51.215	31.84384	5.00	4.401	31.94173	0.64264	0.00070	0.64404	0.93680
40_3_4_4	6.00	5.281	4.20	7.979	51.215	31.70955	5.00	4.401	31.80827	0.62066	0.00068	0.62202	0.93680
40_2_4_4	6.00	5.281	4.20	6.278	51.215	31.57411	5.00	4.401	31.67367	0.60020	0.00092	0.60204	0.93680
40_1_4_4	6.00	5.281	4.20	4.577	51.215	31.43750	5.00	4.401	31.53792	0.57659	0.00075	0.57809	0.93680

Table 6.9.10.9-5. Results for HEU oxide and thorium oxide content for air transportation (Model 6)

Case athothp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ThO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
40_5_3_3	5.00	4.401	4.20	11.381	51.215	31.95754	6.00	5.281	32.07409	0.66744	0.00063	0.66870	0.93680
40_4_3_3	5.00	4.401	4.20	9.680	51.215	31.82421	6.00	5.281	31.94173	0.64669	0.00072	0.64813	0.93680
40_3_3_3	5.00	4.401	4.20	7.979	51.215	31.68975	6.00	5.281	31.80827	0.62371	0.00064	0.62499	0.93680
40_2_3_3	5.00	4.401	4.20	6.278	51.215	31.55414	6.00	5.281	31.67367	0.60310	0.00067	0.60444	0.93680
40_1_3_3	5.00	4.401	4.20	4.577	51.215	31.41735	6.00	5.281	31.53792	0.57935	0.00067	0.58069	0.93680
40_5_2_2	3.00	2.640	4.20	11.381	51.215	31.91853	8.00	7.042	32.07409	0.66783	0.00066	0.66915	0.93680
40_4_2_2	3.00	2.640	4.20	9.680	51.215	31.78487	8.00	7.042	31.94173	0.64803	0.00070	0.64943	0.93680
40_3_2_2	3.00	2.640	4.20	7.979	51.215	31.65008	8.00	7.042	31.80827	0.62697	0.00063	0.62823	0.93680
40_2_2_2	3.00	2.640	4.20	6.278	51.215	31.51413	8.00	7.042	31.67367	0.60549	0.00061	0.60671	0.93680
40_1_2_2	3.00	2.640	4.20	4.577	51.215	31.37699	8.00	7.042	31.53792	0.58368	0.00071	0.58510	0.93680
40_5_1_1	1.00	0.880	4.20	11.381	51.215	31.87943	10.00	8.802	32.07409	0.65796	0.00079	0.65954	0.93680
40_4_1_1	1.00	0.880	4.20	9.680	51.215	31.74544	10.00	8.802	31.94173	0.64002	0.00068	0.64138	0.93680
40_3_1_1	1.00	0.880	4.20	7.979	51.215	31.61031	10.00	8.802	31.80827	0.62365	0.00071	0.62507	0.93680
40_2_1_1	1.00	0.880	4.20	6.278	51.215	31.47401	10.00	8.802	31.67367	0.60514	0.00061	0.60636	0.93680
40_1_1_1	1.00	0.880	4.20	4.577	51.215	31.33652	10.00	8.802	31.53792	0.58530	0.00073	0.58676	0.93680
Saturated UO_2-ThO_2 at 3.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
30_5_6_6	8.40	7.394	5.80	12.631	51.215	32.14603	1.00	0.880	32.17177	0.64697	0.00070	0.64837	0.93680
30_4_6_6	8.40	7.394	5.80	10.930	51.215	32.01426	1.00	0.880	32.04022	0.62720	0.00069	0.62858	0.93680
30_3_6_6	8.40	7.394	5.80	9.229	51.215	31.88141	1.00	0.880	31.90758	0.60588	0.00081	0.60750	0.93680
30_2_6_6	8.40	7.394	5.80	7.528	51.215	31.74743	1.00	0.880	31.77383	0.58387	0.00067	0.58521	0.93680
30_1_6_6	8.40	7.394	5.80	5.827	51.215	31.61232	1.00	0.880	31.63894	0.56100	0.00061	0.56222	0.93680
30_5_5_5	6.90	6.073	5.80	12.631	51.215	32.10748	2.50	2.201	32.17177	0.66079	0.00068	0.66215	0.93680
30_4_5_5	6.90	6.073	5.80	10.930	51.215	31.97539	2.50	2.201	32.04022	0.63940	0.00068	0.64076	0.93680
30_3_5_5	6.90	6.073	5.80	9.229	51.215	31.84221	2.50	2.201	31.90758	0.61702	0.00064	0.61830	0.93680

Table 6.9.10.9-5. Results for HEU oxide and thorium oxide content for air transportation (Model 6)

Case athothp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ThO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
30_2_5_5	6.90	6.073	5.80	7.528	51.215	31.70791	2.50	2.201	31.77383	0.59587	0.00061	0.59709	0.93680
30_1_5_5	6.90	6.073	5.80	5.827	51.215	31.57245	2.50	2.201	31.63894	0.57311	0.00063	0.57437	0.93680
30_5_4_4	5.40	4.753	5.80	12.631	51.215	32.06883	4.00	3.521	32.17177	0.66679	0.00070	0.66819	0.93680
30_4_4_4	5.40	4.753	5.80	10.930	51.215	31.93643	4.00	3.521	32.04022	0.64560	0.00061	0.64682	0.93680
30_3_4_4	5.40	4.753	5.80	9.229	51.215	31.80292	4.00	3.521	31.90758	0.62301	0.00060	0.62421	0.93680
30_2_4_4	5.40	4.753	5.80	7.528	51.215	31.66828	4.00	3.521	31.77383	0.60190	0.00071	0.60332	0.93680
30_1_4_4	5.40	4.753	5.80	5.827	51.215	31.53249	4.00	3.521	31.63894	0.57975	0.00072	0.58119	0.93680
30_5_3_3	4.00	3.521	5.80	12.631	51.215	32.03268	5.40	4.753	32.17177	0.66930	0.00069	0.67068	0.93680
30_4_3_3	4.00	3.521	5.80	10.930	51.215	31.89998	5.40	4.753	32.04022	0.64890	0.00064	0.65018	0.93680
30_3_3_3	4.00	3.521	5.80	9.229	51.215	31.76616	5.40	4.753	31.90758	0.62729	0.00070	0.62869	0.93680
30_2_3_3	4.00	3.521	5.80	7.528	51.215	31.63121	5.40	4.753	31.77383	0.60603	0.00064	0.60731	0.93680
30_1_3_3	4.00	3.521	5.80	5.827	51.215	31.49510	5.40	4.753	31.63894	0.58456	0.00064	0.58584	0.93680
30_5_2_2	2.50	2.201	5.80	12.631	51.215	31.99386	6.90	6.073	32.17177	0.66682	0.00066	0.66814	0.93680
30_4_2_2	2.50	2.201	5.80	10.930	51.215	31.86083	6.90	6.073	32.04022	0.64827	0.00067	0.64961	0.93680
30_3_2_2	2.50	2.201	5.80	9.229	51.215	31.72668	6.90	6.073	31.90758	0.62777	0.00063	0.62903	0.93680
30_2_2_2	2.50	2.201	5.80	7.528	51.215	31.59139	6.90	6.073	31.77383	0.60752	0.00065	0.60882	0.93680
30_1_2_2	2.50	2.201	5.80	5.827	51.215	31.45493	6.90	6.073	31.63894	0.58650	0.00066	0.58782	0.93680
30_5_1_1	1.00	0.880	5.80	12.631	51.215	31.95494	8.40	7.394	32.17177	0.65517	0.00063	0.65643	0.93680
30_4_1_1	1.00	0.880	5.80	10.930	51.215	31.82159	8.40	7.394	32.04022	0.63964	0.00065	0.64094	0.93680
30_3_1_1	1.00	0.880	5.80	9.229	51.215	31.68711	8.40	7.394	31.90758	0.62043	0.00062	0.62167	0.93680
30_2_1_1	1.00	0.880	5.80	7.528	51.215	31.55147	8.40	7.394	31.77383	0.60369	0.00060	0.60489	0.93680
30_1_1_1	1.00	0.880	5.80	5.827	51.215	31.41467	8.40	7.394	31.63894	0.58634	0.00063	0.58760	0.93680
Saturated UO_2-ThO_2 at 2.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
_5_5_5	2.40	2.113	12.25	15.103	51.215	32.34438	0.55	0.484	32.36538	0.54681	0.00059	0.54799	0.93680
_4_5_5	2.40	2.113	12.25	13.402	51.215	32.21424	0.55	0.484	32.23541	0.53116	0.00057	0.53230	0.93680

Table 6.9.10.9-5. Results for HEU oxide and thorium oxide content for air transportation (Model 6)

Case athothp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ThO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
_3_5_5	2.40	2.113	12.25	11.702	51.215	32.08303	0.55	0.484	32.10438	0.51496	0.00055	0.51606	0.93680
_2_5_5	2.40	2.113	12.25	10.001	51.215	31.95075	0.55	0.484	31.97227	0.49765	0.00055	0.49875	0.93680
_1_5_5	2.40	2.113	12.25	8.300	51.215	31.81736	0.55	0.484	31.83906	0.48103	0.00053	0.48209	0.93680
_5_4_4	1.95	1.716	12.25	15.103	51.215	32.32725	1.00	0.880	32.36538	0.55467	0.00059	0.55585	0.93680
_4_4_4	1.95	1.716	12.25	13.402	51.215	32.19697	1.00	0.880	32.23541	0.53934	0.00054	0.54042	0.93680
_3_4_4	1.95	1.716	12.25	11.702	51.215	32.06563	1.00	0.880	32.10438	0.52340	0.00075	0.52490	0.93680
_2_4_4	1.95	1.716	12.25	10.001	51.215	31.93320	1.00	0.880	31.97227	0.50607	0.00066	0.50739	0.93680
_1_4_4	1.95	1.716	12.25	8.300	51.215	31.79967	1.00	0.880	31.83906	0.48738	0.00065	0.48868	0.93680
_5_3_3	1.475	1.298	12.25	15.103	51.215	32.30916	1.475	1.298	32.36538	0.55539	0.00057	0.55653	0.93680
_4_3_3	1.475	1.298	12.25	13.402	51.215	32.17873	1.475	1.298	32.23541	0.53999	0.00067	0.54133	0.93680
_3_3_3	1.475	1.298	12.25	11.702	51.215	32.04724	1.475	1.298	32.10438	0.52358	0.00059	0.52476	0.93680
_2_3_3	1.475	1.298	12.25	10.001	51.215	31.91466	1.475	1.298	31.97227	0.50842	0.00057	0.50956	0.93680
_1_3_3	1.475	1.298	12.25	8.300	51.215	31.78196	1.475	1.298	31.83906	0.49299	0.00054	0.49407	0.93680
_5_2_2	1.00	0.880	12.25	15.103	51.215	32.29104	1.95	1.716	32.36538	0.54765	0.00062	0.54889	0.93680
_4_2_2	1.00	0.880	12.25	13.402	51.215	32.16047	1.95	1.716	32.23541	0.53421	0.00056	0.53533	0.93680
_3_2_2	1.00	0.880	12.25	11.702	51.215	32.02883	1.95	1.716	32.10438	0.52078	0.00060	0.52198	0.93680
_2_2_2	1.00	0.880	12.25	10.001	51.215	31.89609	1.95	1.716	31.97227	0.50726	0.00065	0.50856	0.93680
_1_2_2	1.00	0.880	12.25	8.300	51.215	31.76224	1.95	1.716	31.83906	0.49218	0.00050	0.49318	0.93680
_5_1_1	0.55	0.484	12.25	15.103	51.215	32.27386	2.40	2.113	32.36538	0.53102	0.00060	0.53222	0.93680
_4_1_1	0.55	0.484	12.25	13.402	51.215	32.14315	2.40	2.113	32.23541	0.52224	0.00056	0.52336	0.93680
_3_1_1	0.55	0.484	12.25	11.702	51.215	32.01136	2.40	2.113	32.10438	0.51110	0.00073	0.51256	0.93680
_2_1_1	0.55	0.484	12.25	10.001	51.215	31.87848	2.40	2.113	31.97227	0.49993	0.00057	0.50107	0.93680
_1_1_1	0.55	0.484	12.25	8.300	51.215	31.74448	2.40	2.113	31.83906	0.48601	0.00050	0.48701	0.93680

Table 6.9.10.9-5. Results for HEU oxide and thorium oxide content for air transportation (Model 6)

Case athothp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ThO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2-ThO_2 at 1.5 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
15_5_3_3	1.35	1.188	12.70	17.226	51.215	32.49894	0.45	0.396	32.52163	0.48462	0.00056	0.48574	0.93680
15_4_3_3	1.35	1.188	12.70	15.525	51.215	32.37004	0.45	0.396	32.39291	0.47279	0.00050	0.47379	0.93680
15_3_3_3	1.35	1.188	12.70	13.824	51.215	32.24011	0.45	0.396	32.26316	0.46005	0.00054	0.46113	0.93680
15_2_3_3	1.35	1.188	12.70	12.123	51.215	32.10912	0.45	0.396	32.13236	0.44814	0.00051	0.44916	0.93680
15_1_3_3	1.35	1.188	12.70	10.422	51.215	31.97705	0.45	0.396	32.00048	0.43431	0.00053	0.43537	0.93680
15_5_2_2	0.90	0.792	12.70	17.226	51.215	32.74632	0.90	0.792	32.52163	0.48338	0.00052	0.48442	0.93680
15_4_2_2	0.90	0.792	12.70	15.525	51.215	32.34724	0.90	0.792	32.39291	0.47310	0.00058	0.47426	0.93680
15_3_2_2	0.90	0.792	12.70	13.824	51.215	32.21712	0.90	0.792	32.26316	0.46284	0.00050	0.46384	0.93680
15_2_2_2	0.90	0.792	12.70	12.123	51.215	32.08594	0.90	0.792	32.13236	0.45143	0.00053	0.45249	0.93680
15_1_2_2	0.90	0.792	12.70	10.422	51.215	31.95368	0.90	0.792	32.00048	0.43917	0.00051	0.44019	0.93680
15_5_1_1	0.45	0.396	12.70	17.226	51.215	32.45367	1.35	1.188	32.52163	0.46463	0.00053	0.46569	0.93680
15_4_1_1	0.45	0.396	12.70	15.525	51.215	32.32441	1.35	1.188	32.39291	0.45768	0.00051	0.45870	0.93680
15_3_1_1	0.45	0.396	12.70	13.824	51.215	32.19411	1.35	1.188	32.26316	0.45107	0.00054	0.45215	0.93680
15_2_1_1	0.45	0.396	12.70	12.123	51.215	32.06274	1.35	1.188	32.13236	0.44257	0.00047	0.44351	0.93680
15_1_1_1	0.45	0.396	12.70	10.422	51.215	31.93029	1.35	1.188	32.00048	0.43297	0.00051	0.43399	0.93680
Saturated UO_2-ThO_2 at 1.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
10_5_3_3	1.00	0.880	8.35	17.689	51.215	32.49768	0.30	0.264	32.52037	0.43553	0.00050	0.43653	0.93680
10_4_3_3	1.00	0.880	8.35	15.988	51.215	32.36878	0.30	0.264	32.39164	0.42551	0.00049	0.42649	0.93680
10_3_3_3	1.00	0.880	8.35	14.287	51.215	32.23883	0.30	0.264	32.26188	0.41525	0.00048	0.41621	0.93680
10_2_3_3	1.00	0.880	8.35	12.586	51.215	32.10783	0.30	0.264	32.13107	0.40485	0.00048	0.40581	0.93680
10_1_3_3	1.00	0.880	8.35	10.885	51.215	31.97575	0.30	0.264	31.99918	0.39398	0.00055	0.39508	0.93680
10_5_2_2	0.65	0.572	8.35	17.689	51.215	32.47129	0.65	0.572	32.52037	0.43415	0.00054	0.43523	0.93680
10_4_2_2	0.65	0.572	8.35	15.988	51.215	32.34217	0.65	0.572	32.39164	0.42581	0.00048	0.42677	0.93680

Table 6.9.10.9-5. Results for HEU oxide and thorium oxide content for air transportation (Model 6)

Case athothp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ThO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
10_3_2_2	0.65	0.572	8.35	14.287	51.215	32.21201	0.65	0.572	32.26188	0.41673	0.00050	0.41773	0.93680
10_2_2_2	0.65	0.572	8.35	12.586	51.215	32.08079	0.65	0.572	32.13107	0.40755	0.00047	0.40849	0.93680
10_1_2_2	0.65	0.572	8.35	10.885	51.215	31.94849	0.65	0.572	31.99918	0.39706	0.00047	0.39800	0.93680
10_5_1_1	0.30	0.264	8.35	17.689	51.215	32.44485	1.00	0.880	32.52037	0.41443	0.00051	0.41545	0.93680
10_4_1_1	0.30	0.264	8.35	15.988	51.215	32.31552	1.00	0.880	32.39164	0.40868	0.00047	0.40962	0.93680
10_3_1_1	0.30	0.264	8.35	14.287	51.215	32.18515	1.00	0.880	32.26188	0.40440	0.00046	0.40532	0.93680
10_2_1_1	0.30	0.264	8.35	12.586	51.215	32.05371	1.00	0.880	32.13107	0.39735	0.00051	0.39837	0.93680
10_1_1_1	0.30	0.264	8.35	10.886	51.215	31.92118	1.00	0.880	31.99918	0.39019	0.00047	0.39113	0.93680

Table 6.9.10.9-6. Results for HEU oxide and zirconium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Compromised package, HEU-poly core in spherical configuration, 20.0-cm water reflector (Model 1)													
Saturated UO_2-ZrO_2 at 5.0 g/cm^3													
atdozrr50_4_1	8.00	7.042	7.20	1.041	na	9.49304	na	na	na	0.77152	0.00072	0.77296	0.93520
atdozrr50_3_2	9.00	7.922	6.20	1.125	na	9.49304	na	na	na	0.79651	0.00080	0.79811	0.93520
atdozrr50_2_3	10.00	8.802	5.20	1.210	na	9.49304	na	na	na	0.81700	0.00066	0.81832	0.93520
atdozrr50_1_4	11.00	9.682	4.20	1.295	na	9.49304	na	na	na	0.83893	0.00076	0.84045	0.93520
Saturated UO_2-ZrO_2 at 4.0 g/cm^3													
atdozrr40_4_1	8.00	7.042	7.20	1.799	na	10.12161	na	na	na	0.83399	0.00072	0.83543	0.93520
atdozrr40_3_2	9.00	7.922	6.20	1.884	na	10.12161	na	na	na	0.85414	0.00075	0.85564	0.93520
atdozrr40_2_3	10.00	8.802	5.20	1.969	na	10.12161	na	na	na	0.82128	0.00069	0.82266	0.93520
atdozrr40_1_4	11.00	9.682	4.20	2.053	na	10.12161	na	na	na	0.88688	0.00082	0.88852	0.93520
Saturated UO_2-ZrO_2 at 3.0 g/cm^3													
atdozrr30_5_1	8.00	7.042	7.20	3.064	na	11.02288	na	na	na	0.91502	0.00090	0.91682	0.93520
atdozrr30_4_2	9.00	7.922	6.20	3.148	na	11.02288	na	na	na	0.92882	0.00073	0.93028	0.93520
atdozrr30_3_3	9.40	8.274	5.80	3.182	na	11.02288	na	na	na	0.93334	0.00080	0.93494	0.93520
atdozrr30_2_4	10.00	8.802	5.20	3.233	na	11.02288	na	na	na	0.94100	0.00084	0.94268	0.93520
Saturated UO_2-ZrO_2 at 2.0 g/cm^3													
atdozrr_4_1	1.25	1.100	13.95	5.021	na	12.48074	na	na	na	0.90460	0.00100	0.90660	0.93680
atdozrr_3_2	1.50	1.320	13.70	5.042	na	12.48074	na	na	na	0.92179	0.00081	0.92341	0.93680
atdozrr_2_3	1.75	1.540	13.45	5.063	na	12.48074	na	na	na	0.93409	0.00083	0.93575	0.93680
atdozrr_1_4	2.00	1.760	13.20	5.084	na	12.48074	na	na	na	0.94514	0.00086	0.94686	0.93680
Ssaturated UO_2-ZrO_2 at 1.5 g/cm^3													
atdozrr15_4_1	0.50	0.440	14.05	7.168	na	13.44336	na	na	na	0.81316	0.00070	0.81456	0.93680
atdozrr15_3_2	0.75	0.660	13.70	7.140	na	13.44336	na	na	na	0.89254	0.00089	0.89432	0.93680

Table 6.9.10.9-6. Results for HEU oxide and zirconium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdozrr15_2_3	0.95	0.836	13.50	7.157	na	13.44336	na	na	na	0.93031	0.00076	0.93183	0.93680
atdozrr15_1_4	1.00	0.880	13.45	7.161	na	13.44336	na	na	na	0.93795	0.00074	0.93943	0.93680
Saturated UO_2-ZrO_2 at 1.0 g/cm^3													
atdozr10_1	0.50	0.440	9.15	7.979	na	13.45069	na	na	na	0.83681	0.00070	0.83821	0.93680
atdozr10_2	0.75	0.660	8.90	8.000	na	13.45069	na	na	na	0.92022	0.00093	0.92208	0.93680
atdozr10_3	0.80	0.704	8.85	8.005	na	13.45069	na	na	na	0.93118	0.00073	0.93264	0.93680
atdozr10_4	1.00	1.320	8.65	8.021	na	13.45069	na	na	na	0.96733	0.00088	0.96909	0.93680
Compromised package, HEU-poly core in spherical configuration, stainless-steel shell, 20.0-cm water reflector (Model 2)													
Saturated UO_2-ZrO_2 at 5.0 g/cm^3													
atdozrsr50_1	11.00	9.682	4.20	1.295	na	9.49304	na	na	na	0.83893	0.00076	0.84045	0.93520
atdozrsr50_2	11.00	9.682	4.20	1.295	na	9.49304	na	na	10.17803	0.79617	0.00079	0.79775	0.93520
atdozrsr50_3	11.00	9.682	4.20	1.295	na	9.49304	na	na	10.78140	0.77664	0.00074	0.77812	0.93520
atdozrsr50_4	11.00	9.682	4.20	1.295	na	9.49304	na	na	11.32387	0.76929	0.00071	0.77071	0.93520
atdozrsr50_5	11.00	9.682	4.20	1.295	na	9.49304	na	na	11.81882	0.76643	0.00075	0.76793	0.93520
atdozrsr50_6	11.00	9.682	4.20	1.295	na	9.49304	na	na	12.27546	0.76884	0.00074	0.77032	0.93520
atdozrsr50_7	11.00	9.682	4.20	1.295	na	9.49304	na	na	12.70044	0.77101	0.00074	0.77249	0.93520
atdozrsr50_8	11.00	9.682	4.20	1.295	na	9.49304	na	na	13.09874	0.77673	0.00078	0.77829	0.93520
atdozrsr50_9	11.00	9.682	4.20	1.295	na	9.49304	na	na	13.47419	0.77942	0.00063	0.78068	0.93520
atdozrsr50_10	11.00	9.682	4.20	1.295	na	9.49304	na	na	13.82980	0.78367	0.00064	0.78495	0.93520
atdozrsr50_11	11.00	9.682	4.20	1.295	na	9.49304	na	na	14.16801	0.78690	0.00069	0.78828	0.93520
Saturated UO_2-ZrO_2 at 4.0 g/cm^3													
atdozrsr40_1	11.00	9.682	4.20	2.053	na	10.12161	na	na	na	0.88688	0.00082	0.88852	0.93520
atdozrsr40_2	11.00	9.682	4.20	2.053	na	10.12161	na	na	10.73125	0.85221	0.00072	0.85365	0.93520
atdozrsr40_3	11.00	9.682	4.20	2.053	na	10.12161	na	na	11.27844	0.83443	0.00084	0.83611	0.93520
atdozrsr40_4	11.00	9.682	4.20	2.053	na	10.12161	na	na	11.77714	0.82585	0.00071	0.82727	0.93520

Table 6.9.10.9-6. Results for HEU oxide and zirconium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdozrsr40_5	11.00	9.682	4.20	2.053	na	10.12161	na	na	12.23684	0.82551	0.00073	0.82697	0.93520
atdozrsr40_6	11.00	9.682	4.20	2.053	na	10.12161	na	na	12.66437	0.82560	0.00081	0.82722	0.93520
atdozrsr40_7	11.00	9.682	4.20	2.053	na	10.12161	na	na	13.06484	0.82801	0.00080	0.82961	0.93520
atdozrsr40_8	11.00	9.682	4.20	2.053	na	10.12161	na	na	13.44216	0.83132	0.00074	0.83280	0.93520
atdozrsr40_9	11.00	9.682	4.20	2.053	na	10.12161	na	na	13.79940	0.83617	0.00072	0.83761	0.93520
atdozrsr40_10	11.00	9.682	4.20	2.053	na	10.12161	na	na	14.13905	0.84049	0.00099	0.84247	0.93520
atdozrsr40_11	11.00	9.682	4.20	2.053	na	10.12161	na	na	14.46312	0.84475	0.00067	0.84609	0.93520
Saturated UO_2-ZrO_2 at 3.0 g/cm^3													
atdozrsr30_1	9.40	8.274	5.80	3.182	na	11.02288	na	na	na	0.93334	0.00080	0.93494	0.93520
atdozrsr30_2	9.40	8.274	5.80	3.182	na	11.02288	na	na	11.54352	0.90293	0.00093	0.90479	0.93520
atdozrsr30_3	9.40	8.274	5.80	3.182	na	11.02288	na	na	12.02092	0.88715	0.00081	0.88877	0.93520
atdozrsr30_4	9.40	8.274	5.80	3.182	na	11.02288	na	na	12.46314	0.87872	0.00076	0.88024	0.93520
atdozrsr30_5	9.40	8.274	5.80	3.182	na	11.02288	na	na	12.87603	0.87665	0.00074	0.87813	0.93520
atdozrsr30_6	9.40	8.274	5.80	3.182	na	11.02288	na	na	13.26401	0.87646	0.00077	0.87800	0.93520
atdozrsr30_7	9.40	8.274	5.80	3.182	na	11.02288	na	na	13.63053	0.87931	0.00096	0.88123	0.93520
atdozrsr30_8	9.40	8.274	5.80	3.182	na	11.02288	na	na	13.97834	0.88328	0.00087	0.88502	0.93520
atdozrsr30_9	9.40	8.274	5.80	3.182	na	11.02288	na	na	14.30965	0.88699	0.00082	0.88863	0.93520
atdozrsr30_10	9.40	8.274	5.80	3.182	na	11.02288	na	na	14.62628	0.88927	0.00090	0.89107	0.93520
atdozrsr30_11	9.40	8.274	5.80	3.182	na	11.02288	na	na	14.92977	0.89326	0.00082	0.89490	0.93520
Saturated UO_2-ZrO_2 at 2.0 g/cm^3													
atdorzsr_1	1.75	1.540	13.45	5.063	na	12.48074	na	na	na	0.93409	0.00083	0.93575	0.93680
atdozrsr_2	1.75	1.540	13.45	5.063	na	12.48074	na	na	12.89262	0.89259	0.00088	0.89435	0.93680
atdozrsr_3	1.75	1.540	13.45	5.063	na	12.48074	na	na	13.27964	0.87421	0.00077	0.87575	0.93680
atdozrsr_4	1.75	1.540	13.45	5.063	na	12.48074	na	na	13.64534	0.86728	0.00097	0.86922	0.93680
atdozrsr_5	1.75	1.540	13.45	5.063	na	12.48074	na	na	13.99242	0.86544	0.00086	0.86716	0.93680

Table 6.9.10.9-6. Results for HEU oxide and zirconium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdozrsr_6	1.75	1.540	13.45	5.063	na	12.48074	na	na	14.32308	0.86703	0.00079	0.86861	0.93680
atdozrsr_7	1.75	1.540	13.45	5.063	na	12.48074	na	na	14.63914	0.86320	0.00099	0.86518	0.93680
atdozrsr_8	1.75	1.540	13.45	5.063	na	12.48074	na	na	14.94212	0.87307	0.00090	0.87487	0.93680
atdozrsr_9	1.75	1.540	13.45	5.063	na	12.48074	na	na	15.23328	0.87284	0.00081	0.87446	0.93680
atdozrsr_10	1.75	1.540	13.45	5.063	na	12.48074	na	na	15.51372	0.87952	0.00096	0.88144	0.93680
atdozrsr_11	1.75	1.540	13.45	5.063	na	12.48074	na	na	15.78437	0.88178	0.00078	0.88334	0.93680
Saturated UO_2-ZrO_2 at 1.5 g/cm^3													
atdozrsr15_1	0.95	0.836	13.50	7.157	na	13.44336	na	na	na	0.93031	0.00076	0.93183	0.93680
atdozrsr15_2	0.95	0.836	13.50	7.157	na	13.44336	na	na	13.80064	0.88868	0.00075	0.89018	0.93680
atdozrsr15_3	0.95	0.836	13.50	7.157	na	13.44336	na	na	14.14022	0.87457	0.00089	0.87635	0.93680
atdozrsr15_4	0.95	0.836	13.50	7.157	na	13.44336	na	na	14.46424	0.86735	0.00080	0.86895	0.93680
atdozrsr15_5	0.95	0.836	13.50	7.157	na	13.44336	na	na	14.77436	0.86530	0.00110	0.86750	0.93680
atdozrsr15_6	0.95	0.836	13.50	7.157	na	13.44336	na	na	15.07198	0.86581	0.00078	0.86737	0.93680
atdozrsr15_7	0.95	0.836	13.50	7.157	na	13.44336	na	na	15.35828	0.86920	0.00077	0.87074	0.93680
atdozrsr15_8	0.95	0.836	13.50	7.157	na	13.44336	na	na	15.63429	0.86995	0.00086	0.87167	0.93680
atdozrsr15_9	0.95	0.836	13.50	7.157	na	13.44336	na	na	15.90089	0.87348	0.00095	0.87538	0.93680
atdozrsr15_10	0.95	0.836	13.50	7.157	na	13.44336	na	na	16.15883	0.87636	0.00081	0.87798	0.93680
atdozrsr15_11	0.95	0.836	13.50	7.157	na	13.44336	na	na	16.40880	0.87906	0.00078	0.88062	0.93680
Saturated UO_2-ZrO_2 at 1.0 g/cm^3													
atdozrsr10_1	0.80	0.704	8.85	8.005	na	13.45069	na	na	na	0.93118	0.00073	0.93264	0.93680
atdozrsr10_2	0.80	0.704	8.85	8.005	na	13.45069	na	na	13.80760	0.89090	0.00082	0.89254	0.93680
atdozrsr10_3	0.80	0.704	8.85	8.005	na	13.45069	na	na	14.14685	0.87858	0.00084	0.88026	0.93680
atdozrsr10_4	0.80	0.704	8.85	8.005	na	13.45069	na	na	14.47058	0.87211	0.00078	0.87367	0.93680
atdozrsr10_5	0.80	0.704	8.85	8.005	na	13.45069	na	na	14.78043	0.86905	0.00075	0.87055	0.93680
atdozrsr10_6	0.80	0.704	8.85	8.005	na	13.45069	na	na	15.07781	0.87184	0.00073	0.87330	0.93680

Table 6.9.10.9-6. Results for HEU oxide and zirconium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdozrsr10_7	0.80	0.704	8.85	8.005	na	13.45069	na	na	15.36390	0.87597	0.00079	0.87755	0.93680
atdozrsr10_8	0.80	0.704	8.85	8.005	na	13.45069	na	na	15.63972	0.87519	0.00083	0.87685	0.93680
atdozrsr10_9	0.80	0.704	8.85	8.005	na	13.45069	na	na	15.90613	0.88062	0.00082	0.88226	0.93680
atdozrsr10_10	0.80	0.704	8.85	8.005	na	13.45069	na	na	16.16391	0.88109	0.00076	0.88261	0.93680
atdozrsr10_11	0.80	0.704	8.85	8.005	na	13.45069	na	na	16.41372	0.88499	0.00077	0.88653	0.93680
Compromised package, HEU-poly core in spherical configuration, dry (bound water) Kaolite shell, 20.0-cm water reflector (Model 3)													
Saturated UO_2-ZrO_2 at 5.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdozrdkr50_1	11.00	9.682	4.20	1.295	na	9.49304	0	0	na	0.83893	0.00076	0.84045	0.93520
atdozrdkr50_2	11.00	9.682	4.20	1.295	na	9.49304	10.243	0.441	18.9606	0.70183	0.00070	0.70323	0.93520
atdozrdkr50_3	11.00	9.682	4.20	1.295	na	9.49304	20.486	0.882	23.3783	0.67047	0.00069	0.67185	0.93520
atdozrdkr50_4	11.00	9.682	4.20	1.295	na	9.49304	30.729	1.323	26.56086	0.65401	0.00069	0.65539	0.93520
atdozrdkr50_5	11.00	9.682	4.20	1.295	na	9.49304	40.972	1.764	29.12235	0.64402	0.00066	0.64534	0.93520
atdozrdkr50_6	11.00	9.682	4.20	1.295	na	9.49304	51.214	2.205	31.29849	0.63740	0.00062	0.63864	0.93520
Saturated UO_2-ZrO_2 at 4.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdozrdkr40_1	11.00	9.682	4.20	2.053	na	10.12161	0	0	na	0.88688	0.00082	0.88852	0.93520
atdozrdkr40_2	11.00	9.682	4.20	2.053	na	10.12161	10.243	0.441	19.12736	0.75949	0.00091	0.76131	0.93520
atdozrdkr40_3	11.00	9.682	4.20	2.053	na	10.12161	20.486	0.882	23.48843	0.72912	0.00072	0.73056	0.93520
atdozrdkr40_4	11.00	9.682	4.20	2.053	na	10.12161	30.729	1.323	26.64632	0.71267	0.00076	0.71419	0.93520
atdozrdkr40_5	11.00	9.682	4.20	2.053	na	10.12161	40.972	1.764	29.19349	0.70352	0.00077	0.70506	0.93520
atdozrdkr40_6	11.00	9.682	4.20	2.053	na	10.12161	51.214	2.205	31.36011	0.69759	0.00069	0.69897	0.93520
Saturated UO_2-ZrO_2 at 3.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdozrdkr30_1	9.40	8.274	5.80	3.182	na	11.02288	0	0	na	0.93334	0.00080	0.93494	0.93520
atdozrdkr30_2	9.40	8.274	5.80	3.182	na	11.02288	10.243	0.441	19.39900	0.81679	0.00073	0.81825	0.93520
atdozrdkr30_3	9.40	8.274	5.80	3.182	na	11.02288	20.486	0.882	23.66974	0.78607	0.00080	0.78767	0.93520
atdozrdkr30_4	9.40	8.274	5.80	3.182	na	11.02288	30.729	1.323	26.78753	0.76957	0.00098	0.77153	0.93520

Table 6.9.10.9-6. Results for HEU oxide and zirconium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdozrdkr30_5	9.40	8.274	5.80	3.182	na	11.02288	40.972	1.764	29.31129	0.76077	0.00082	0.76241	0.93520
atdozrdkr30_6	9.40	8.274	5.80	3.182	na	11.02288	51.214	2.205	31.46227	0.75473	0.00084	0.75641	0.93520
Saturated UO_2-ZrO_2 at 2.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdozrdkr_1	1.75	1.540	13.45	5.063	na	12.48074	0	0	na	0.93409	0.00083	0.93575	0.93680
atdozrdkr_2	1.75	1.540	13.45	5.063	na	12.48074	10.243	0.441	19.92056	0.81790	0.00086	0.81962	0.93680
atdozrdkr_3	1.75	1.540	13.45	5.063	na	12.48074	20.486	0.882	24.02423	0.78622	0.00085	0.78792	0.93680
atdozrdkr_4	1.75	1.540	13.45	5.063	na	12.48074	30.729	1.323	27.06558	0.77083	0.00084	0.77251	0.93680
atdozrdkr_5	1.75	1.540	13.45	5.063	na	12.48074	40.972	1.764	29.54408	0.76008	0.00092	0.76192	0.93680
atdozrdkr_6	1.75	1.540	13.45	5.063	na	12.48074	51.214	2.205	31.66462	0.75070	0.00092	0.75254	0.93680
Saturated UO_2-ZrO_2 at 1.5 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdozrdkr15_1	0.95	0.836	13.50	7.157	na	13.44336	0	0	na	0.93031	0.00076	0.93183	0.93680
atdozrdkr15_2	0.95	0.836	13.50	7.157	na	13.44336	10.243	0.441	20.32024	0.83518	0.00093	0.83704	0.93680
atdozrdkr15_3	0.95	0.836	13.50	7.157	na	13.44336	20.486	0.882	24.30137	0.80807	0.00085	0.80977	0.93680
atdozrdkr15_4	0.95	0.836	13.50	7.157	na	13.44336	30.729	1.323	27.28469	0.79366	0.00089	0.79544	0.93680
atdozrdkr15_5	0.95	0.836	13.50	7.157	na	13.44336	40.972	1.764	29.72831	0.78302	0.00075	0.78452	0.93680
atdozrdkr15_6	0.95	0.836	13.50	7.157	na	13.44336	51.214	2.205	31.82519	0.77825	0.00076	0.77977	0.93680
Saturated UO_2-ZrO_2 at 1.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdozrdkr10_1	0.80	0.704	8.85	8.005	na	13.45069	0	0	na	0.93118	0.00073	0.93264	0.93680
atdozrdkr10_2	0.80	0.704	8.85	8.005	na	13.45069	10.243	0.441	20.32345	0.84314	0.00076	0.84466	0.93680
atdozrdkr10_3	0.80	0.704	8.85	8.005	na	13.45069	20.486	0.882	24.30362	0.81641	0.00085	0.81811	0.93680
atdozrdkr10_4	0.80	0.704	8.85	8.005	na	13.45069	30.729	1.323	27.28647	0.80316	0.00081	0.80478	0.93680
atdozrdkr10_5	0.80	0.704	8.85	8.005	na	13.45069	40.972	1.764	29.72981	0.79615	0.00086	0.79787	0.93680
atdozrdkr10_6	0.80	0.704	8.85	8.005	na	13.45069	51.214	2.205	31.82650	0.79040	0.00082	0.79204	0.93680

Table 6.9.10.9-6. Results for HEU oxide and zirconium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Compromised package, HEU-poly core in sph. config., wet (bound plus 15-lb free water) Kaolite shell, 20.0-cm water reflector (Model 3)													
Saturated UO_2-ZrO_2 at 5.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdozr15kr50_1	11.00	9.682	4.20	1.295	na	9.49304	0	0	na	0.83893	0.00076	0.84045	0.93520
atdozr15kr50_2	11.00	9.682	4.20	1.295	na	9.49304	10.243	1.802	18.96060	0.70175	0.00077	0.70329	0.93520
atdozr15kr50_3	11.00	9.682	4.20	1.295	na	9.49304	20.486	3.604	23.37830	0.67276	0.00069	0.67414	0.93520
atdozr15kr50_4	11.00	9.682	4.20	1.295	na	9.49304	30.729	5.405	26.56086	0.66010	0.00069	0.66148	0.93520
atdozr15kr50_5	11.00	9.682	4.20	1.295	na	9.49304	40.972	7.207	29.12235	0.65084	0.00078	0.65240	0.93520
atdozr15kr50_6	11.00	9.682	4.20	1.295	na	9.49304	51.214	9.009	31.29849	0.64682	0.00078	0.64838	0.93520
Saturated UO_2-ZrO_2 at 4.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdozr15kr40_1	11.00	9.682	4.20	2.053	na	10.12161	0	0	na	0.88688	0.00082	0.88852	0.93520
atdozr15kr40_2	11.00	9.682	4.20	2.053	na	10.12161	10.243	1.802	19.12736	0.76012	0.00074	0.76160	0.93520
atdozr15kr40_3	11.00	9.682	4.20	2.053	na	10.12161	20.486	3.604	23.48843	0.73327	0.00086	0.73499	0.93520
atdozr15kr40_4	11.00	9.682	4.20	2.053	na	10.12161	30.729	5.405	26.64632	0.71959	0.00070	0.72099	0.93520
atdozr15kr40_5	11.00	9.682	4.20	2.053	na	10.12161	40.972	7.207	29.19349	0.71259	0.00076	0.71411	0.93520
atdozr15kr40_6	11.00	9.682	4.20	2.053	na	10.12161	51.214	9.009	31.36011	0.70673	0.00069	0.70811	0.93520
Saturated UO_2-ZrO_2 at 3.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdozr15kr30_1	9.40	8.274	5.80	3.182	na	11.02288	0	0	na	0.93334	0.00080	0.93494	0.93520
atdozr15kr30_2	9.40	8.274	5.80	3.182	na	11.02288	10.243	1.802	19.39900	0.81813	0.00086	0.81985	0.93520
atdozr15kr30_3	9.40	8.274	5.80	3.182	na	11.02288	20.486	3.604	23.66974	0.79112	0.00078	0.79268	0.93520
atdozr15kr30_4	9.40	8.274	5.80	3.182	na	11.02288	30.729	5.405	26.78753	0.77492	0.00085	0.77662	0.93520
atdozr15kr30_5	9.40	8.274	5.80	3.182	na	11.02288	40.972	7.207	29.31129	0.76822	0.00096	0.77014	0.93520
atdozr15kr30_6	9.40	8.274	5.80	3.182	na	11.02288	51.214	9.009	31.46227	0.76167	0.00073	0.76313	0.93520
Saturated UO_2-ZrO_2 at 2.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdozr15kr_1	1.75	1.540	13.45	5.063	na	12.48074	0	0	na	0.93409	0.00083	0.93575	0.93680
atdozr15kr_2	1.75	1.540	13.45	5.063	na	12.48074	10.243	1.802	19.92056	0.82325	0.00086	0.82497	0.93680

Table 6.9.10.9-6. Results for HEU oxide and zirconium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdozr15kr_3	1.75	1.540	13.45	5.063	na	12.48074	20.486	3.604	24.02423	0.79330	0.00100	0.79530	0.93680
atdozr15kr_4	1.75	1.540	13.45	5.063	na	12.48074	30.729	5.405	27.06558	0.78097	0.00089	0.78275	0.93680
atdozr15kr_5	1.75	1.540	13.45	5.063	na	12.48074	40.972	7.207	29.54408	0.77216	0.00082	0.77380	0.93680
atdozr15kr_6	1.75	1.540	13.45	5.063	na	12.48074	51.214	9.009	31.66462	0.76516	0.00094	0.76704	0.93680
Saturated UO_2-ZrO_2 at 1.5 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdozr15kr15_1	0.95	0.836	13.50	7.157	na	13.44336	0	0	na	0.93031	0.00076	0.93183	0.93680
atdozr15kr15_2	0.95	0.836	13.50	7.157	na	13.44336	10.243	1.802	20.32024	0.83997	0.00082	0.84161	0.93680
atdozr15kr15_3	0.95	0.836	13.50	7.157	na	13.44336	20.486	3.604	24.30137	0.81507	0.00097	0.81701	0.93680
atdozr15kr15_4	0.95	0.836	13.50	7.157	na	13.44336	30.729	5.405	27.28469	0.80372	0.00094	0.80560	0.93680
atdozr15kr15_5	0.95	0.836	13.50	7.157	na	13.44336	40.972	7.207	29.72831	0.79778	0.00083	0.79944	0.93680
atdozr15kr15_6	0.95	0.836	13.50	7.157	na	13.44336	51.214	9.009	31.82519	0.79109	0.00083	0.79275	0.93680
Saturated UO_2-ZrO_2 at 1.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdozr15kr10_1	0.80	0.704	8.85	8.005	na	13.45069	0	0	na	0.93118	0.00073	0.93264	0.93680
atdozr15kr10_2	0.80	0.704	8.85	8.005	na	13.45069	10.243	1.802	20.32345	0.84663	0.00083	0.84829	0.93680
atdozr15kr10_3	0.80	0.704	8.85	8.005	na	13.45069	20.486	3.604	24.30362	0.82567	0.00076	0.82719	0.93680
atdozr15kr10_4	0.80	0.704	8.85	8.005	na	13.45069	30.729	5.405	27.28647	0.81199	0.00091	0.81381	0.93680
atdozr15kr10_5	0.80	0.704	8.85	8.005	na	13.45069	40.972	7.207	29.72981	0.80833	0.00086	0.81005	0.93680
atdozr15kr10_6	0.80	0.704	8.85	8.005	na	13.45069	51.214	9.009	31.82650	0.80242	0.00078	0.80398	0.93680
Compromised package, homogeneous fixed-radius core [HEU, poly, wet Kaolite], 20.0 cm water reflector (Model 4)													
Saturated UO_2-ZrO_2 at 5.0 g/cm^3													
athozrp15kr50_1	11.00	9.682	4.20	3.499	51.214	31.29850	na	na	na	0.53985	0.00064	0.54113	0.93680
athozrp15kr50_2	11.00	9.682	4.20	5.200	51.214	31.29850	na	na	na	0.56213	0.00068	0.56349	0.93680
athozrp15kr50_3	11.00	9.682	4.20	6.902	51.214	31.29850	na	na	na	0.58539	0.00076	0.58691	0.93680
athozrp15kr50_4	11.00	9.682	4.20	8.921	51.214	31.29850	na	na	na	0.60901	0.00066	0.61033	0.93680
athozrp15kr50_5	11.00	9.682	4.20	10.622	51.214	31.29850	na	na	na	0.63428	0.00068	0.63564	0.93680

Table 6.9.10.9-6. Results for HEU oxide and zirconium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2-ZrO_2 at 4.0 g/cm^3													
athozrp15kr40_1	11.00	9.682	4.20	4.258	51.214	31.36011	na	na	na	0.54909	0.00064	0.55037	0.93680
athozrp15kr40_2	11.00	9.682	4.20	5.959	51.214	31.36011	na	na	na	0.57282	0.00069	0.57420	0.93680
athozrp15kr40_3	11.00	9.682	4.20	7.660	51.214	31.36011	na	na	na	0.59447	0.00070	0.59587	0.93680
athozrp15kr40_4	11.00	9.682	4.20	9.361	51.214	31.36011	na	na	na	0.61937	0.00073	0.62083	0.93680
athozrp15kr40_5	11.00	9.682	4.20	11.062	51.214	31.36011	na	na	na	0.64384	0.00074	0.64532	0.93680
Saturated UO_2-ZrO_2 at 3.0 g/cm^3													
athozrp15kr30_1	9.40	8.274	5.80	5.387	51.214	31.46227	na	na	na	0.55242	0.00063	0.55368	0.93680
athozrp15kr30_2	9.40	8.274	5.80	7.088	51.214	31.46227	na	na	na	0.57655	0.00062	0.57779	0.93680
athozrp15kr30_3	9.40	8.274	5.80	8.789	51.214	31.46227	na	na	na	0.59895	0.00072	0.60039	0.93680
athozrp15kr30_4	9.40	8.274	5.80	10.490	51.214	31.46227	na	na	na	0.62332	0.00068	0.62468	0.93680
athozrp15kr30_5	9.40	8.274	5.80	12.192	51.214	31.46227	na	na	na	0.64670	0.00100	0.64870	0.93680
Saturated UO_2-ZrO_2 at 2.0 g/cm^3													
athozrp15kr_1	1.75	1.540	13.45	7.268	51.214	31.66463	na	na	na	0.41297	0.00052	0.41401	0.93680
athozrp15kr_2	1.75	1.540	13.45	8.969	51.214	31.66463	na	na	na	0.43060	0.00056	0.43172	0.93680
athozrp15kr_3	1.75	1.540	13.45	10.670	51.214	31.66463	na	na	na	0.44598	0.00058	0.44714	0.93680
athozrp15kr_4	1.75	1.540	13.45	12.371	51.214	31.66463	na	na	na	0.46295	0.00056	0.46407	0.93680
athozrp15kr_5	1.75	1.540	13.45	14.072	51.214	31.66463	na	na	na	0.48221	0.00057	0.48335	0.93680
Saturated UO_2-ZrO_2 at 1.5 g/cm^3													
athozrp15kr15_1	0.95	0.836	13.50	9.362	51.214	31.82519	na	na	na	0.34153	0.00042	0.34237	0.93680
athozrp15kr15_2	0.95	0.836	13.50	11.063	51.214	31.82519	na	na	na	0.35357	0.00046	0.35449	0.93680
athozrp15kr15_3	0.95	0.836	13.50	12.764	51.214	31.82519	na	na	na	0.36563	0.00050	0.36663	0.93680
athozrp15kr15_4	0.95	0.836	13.50	14.465	51.214	31.82519	na	na	na	0.37818	0.00050	0.37918	0.93680
athozrp15kr15_5	0.95	0.836	13.50	16.166	51.214	31.82519	na	na	na	0.39132	0.00044	0.39220	0.93680

Table 6.9.10.9-6. Results for HEU oxide and zirconium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
UO_2-ZrO_2 saturated oxide at 1.0 g/cm^3													
athozrp15kr10_1	0.80	0.704	8.85	10.209	51.214	31.82650	na	na	na	0.31888	0.00038	0.31964	0.93680
athozrp15kr10_2	0.80	0.704	8.85	11.910	51.214	31.82650	na	na	na	0.33023	0.00038	0.33099	0.93680
athozrp15kr10_3	0.80	0.704	8.85	13.611	51.214	31.82650	na	na	na	0.34111	0.00040	0.34191	0.93680
athozrp15kr10_4	0.80	0.704	8.85	15.312	51.214	31.82650	na	na	na	0.35311	0.00039	0.35389	0.93680
athozrp15kr10_5	0.80	0.704	8.85	17.013	51.214	31.82650	na	na	na	0.36338	0.00040	0.36418	0.93680
Compromised package, homogeneous core [HEU, poly, free water from wet Kaolite], wet Kaolite shell, 20.0-cm water reflector (Model 5)													
Saturated UO_2-ZrO_2 at 5.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb													
athozrpw12kr40_1_1_5	8.00	7.042	0.00	6.311	na	12.19423	51.215	2.205	31.62107	0.92884	0.00093	0.93070	0.93520
athozrpw12kr40_2_1_5	8.00	7.042	1.00	6.335	na	12.30034	51.215	2.205	31.63697	0.92517	0.00082	0.92681	0.93520
athozrpw12kr40_7_1_5	8.00	7.042	7.20	6.483	na	12.92072	51.215	2.205	31.73526	0.91233	0.00086	0.91405	0.93520
athozrpw12kr40_1_2_5	8.60	7.57	0.00	6.376	na	12.25812	51.215	2.205	31.63061	0.93099	0.00084	0.93267	0.93520
athozrpw12kr40_1_2_4	8.60	7.57	0.00	5.015	na	11.48905	51.215	3.565	31.52183	0.87724	0.00088	0.87900	0.93520
athozrpw12kr40_1_2_3	8.60	7.57	0.00	3.655	na	10.60038	51.215	4.926	31.41229	0.81014	0.00087	0.81188	0.93520
athozrpw12kr40_1_2_2	8.60	7.57	0.00	2.294	na	9.53085	51.215	6.286	31.30198	0.72984	0.00086	0.73156	0.93520
athozrpw12kr40_1_2_1	8.60	7.57	0.00	0.934	na	8.14509	51.215	7.647	31.19089	0.62668	0.00061	0.62790	0.93520
athozrpw12kr40_2_2_5	8.60	7.57	1.00	6.400	na	12.36313	51.215	2.205	31.64651	0.93034	0.00086	0.93206	0.93520
athozrpw12kr40_3_2_5	8.60	7.57	2.00	6.424	na	12.46639	51.215	2.205	31.66240	0.92638	0.00085	0.92808	0.93520
athozrpw12kr40_4_2_5	8.60	7.57	4.00	6.471	na	12.66794	51.215	2.205	31.69412	0.92303	0.00078	0.92459	0.93520
athozrpw12kr40_6_2_5	8.60	7.57	6.60	6.534	na	12.92072	51.215	2.205	31.73526	0.91706	0.00083	0.91872	0.93520
athozrpw12kr40_1_3_5	9.00	7.922	0.00	6.419	na	12.30034	51.215	2.205	31.63698	0.93656	0.00085	0.93826	0.93520
athozrpw12kr40_5_3_5	9.00	7.922	6.20	6.567	na	12.92072	51.215	2.205	31.73526	0.92005	0.00078	0.92161	0.93520
Saturated UO_2-ZrO_2 at 4.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb													
athozrpw12kr40_1_1_5	6.00	5.281	0.00	6.393	na	12.14048	51.215	2.205	31.61311	0.92417	0.00086	0.92589	0.93520
athozrpw12kr40_2_1_5	6.00	5.281	1.00	6.467	na	12.27398	51.215	2.205	31.63300	0.92154	0.00078	0.92310	0.93520

Table 6.9.10.9-6. Results for HEU oxide and zirconium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athozrpw12kr40_3_1_5	6.00	5.281	2.00	6.541	na	12.40464	51.215	2.205	31.65287	0.92032	0.00080	0.92192	0.93520
athozrpw12kr40_8_1_5	6.00	5.281	9.20	7.072	na	13.27328	51.215	2.205	31.79520	0.92575	0.00084	0.92743	0.93520
athozrpw12kr40_1_2_5	6.85	6.029	0.00	6.528	na	12.25414	51.215	2.205	31.63002	0.93129	0.00082	0.93293	0.93520
athozrpw12kr40_1_2_4	6.85	6.029	0.00	5.167	na	11.48452	51.215	3.565	31.52123	0.87760	0.00077	0.87914	0.93520
athozrpw12kr40_1_2_3	6.85	6.029	0.00	3.807	na	10.59507	51.215	4.926	31.41169	0.81050	0.00100	0.81250	0.93520
athozrpw12kr40_1_2_4	6.85	6.029	0.00	2.446	na	9.52428	51.215	6.286	31.30137	0.72519	0.00075	0.72669	0.93520
athozrpw12kr40_1_2_5	6.85	6.029	0.00	1.086	na	8.13609	51.215	7.647	31.19028	0.61850	0.00072	0.61994	0.93520
athozrpw12kr40_3_2_5	6.85	6.029	2.00	6.675	na	12.51358	51.215	2.205	31.66974	0.93360	0.00092	0.93544	0.93520
athozrpw12kr40_4_2_5	6.85	6.029	4.00	6.823	na	12.76268	51.215	2.205	31.70936	0.93315	0.00091	0.93497	0.93520
athozrpw12kr40_5_2_5	6.85	6.029	6.00	6.971	na	13.00242	51.215	2.205	31.74888	0.92915	0.00084	0.93083	0.93520
athozrpw12kr40_7_2_5	6.85	6.029	8.35	7.144	na	13.27328	51.215	2.205	31.79520	0.93106	0.00091	0.93288	0.93520
athozrpw12kr40_1_3_5	7.00	6.161	0.00	6.551	na	12.27398	51.215	2.205	31.63300	0.93454	0.00084	0.93622	0.93520
athozrpw12kr40_5_3_5	7.00	7.042	8.20	7.157	na	13.27328	51.215	2.205	31.79520	0.93185	0.00093	0.93371	0.93520
Saturated UO_2-ZrO_2 at 3.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb													
athozrpw12kr30_1_1_5	3.00	2.641	0.00	6.167	na	11.86429	51.215	2.205	31.57324	0.89150	0.00120	0.89390	0.93680
athozrpw12kr30_2_1_5	3.00	2.641	2.00	6.481	na	12.22980	51.215	2.205	31.62637	0.89563	0.00096	0.89755	0.93680
athozrpw12kr30_3_1_5	3.00	2.641	4.00	6.795	na	12.57469	51.215	2.205	31.67932	0.89980	0.00089	0.90158	0.93680
athozrpw12kr30_6_1_5	3.00	2.641	10.00	7.737	na	13.50993	51.215	2.205	31.83712	0.91440	0.00110	0.91660	0.93680
athozrpw12kr30_9_1_5	3.00	2.641	12.20	8.082	na	13.82238	51.215	2.205	31.89459	0.92190	0.00100	0.92390	0.93680
athozrpw12kr30_1_2_5	3.55	3.125	0.00	6.300	na	11.96704	51.215	2.205	31.58787	0.90427	0.00088	0.90603	0.93680
athozrpw12kr30_1_2_4	3.55	3.125	0.00	4.940	na	11.15594	51.215	3.565	31.47879	0.84666	0.00083	0.84832	0.93680
athozrpw12kr30_1_2_3	3.55	3.125	0.00	3.579	na	10.20582	51.215	4.926	31.36895	0.77306	0.00079	0.77464	0.93520
athozrpw12kr30_1_2_2	3.55	3.125	0.00	2.218	na	9.03540	51.215	6.286	31.25833	0.67853	0.00080	0.68013	0.93520
athozrpw12kr30_1_2_1	3.55	3.125	0.00	0.858	na	7.44250	51.215	7.647	31.14693	0.54700	0.00080	0.54860	0.93520
athozrpw12kr30_2_2_5	3.55	3.125	2.00	6.614	na	12.32658	51.215	2.205	31.64095	0.90912	0.00097	0.91106	0.93680

Table 6.9.10.9-6. Results for HEU oxide and zirconium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athozrpw12kr30_3_2_5	3.55	3.125	4.00	6.928	na	12.66628	51.215	2.205	31.69385	0.91214	0.00083	0.91380	0.93680
athozrpw12kr30_5_2_5	3.55	3.125	8.00	7.556	na	13.29582	51.215	2.205	31.79913	0.92415	0.00089	0.92593	0.93680
athozrpw12kr30_6_2_5	3.55	3.125	10.00	7.870	na	13.58940	51.215	2.205	31.58940	0.92790	0.00100	0.92990	0.93680
athozrpw12kr30_8_2_5	3.55	3.125	11.65	8.129	na	13.82238	51.215	2.205	31.89459	0.93409	0.00087	0.93583	0.93680
athozrpw12kr30_1_3_5	4.00	3.521	0.00	6.409	na	12.04982	51.215	2.205	31.59983	0.91377	0.00086	0.91549	0.93680
athozrpw12kr30_5_3_5	4.00	3.521	11.20	8.167	na	13.82238	51.215	2.205	31.89459	0.94138	0.00098	0.94334	0.93680
Saturated UO_2-ZrO_2 at 2.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb													
athozrpw12kr_1_1_5	1.50	1.320	0.00	6.054	na	11.72124	51.215	2.205	31.55327	0.84588	0.00080	0.84748	0.93680
athozrpw12kr_2_1_5	1.50	1.320	2.00	6.701	na	12.27398	51.215	2.205	31.63300	0.85994	0.00090	0.86174	0.93680
athozrpw12kr_4_1_5	1.50	1.320	8.00	8.641	na	13.68921	51.215	2.205	31.86980	0.89332	0.00093	0.89518	0.93680
athozrpw12kr_5_1_5	1.50	1.320	12.00	9.935	na	14.49067	51.215	2.205	32.02574	0.91199	0.00085	0.91369	0.93680
athozrpw12kr_8_1_3	1.50	1.320	13.70	10.484	na	14.80590	51.215	2.205	32.09155	0.91767	0.00090	0.91947	0.93680
athozrpw12kr_1_2_5	1.70	1.496	0.00	6.136	na	11.77888	51.215	2.205	31.56126	0.85876	0.00092	0.86060	0.93680
athozrpw12kr_1_2_4	1.70	1.496	0.00	4.775	na	10.93860	51.215	3.565	31.45200	0.80428	0.00086	0.80600	0.93680
athozrpw12kr_1_2_3	1.70	1.496	0.00	3.415	na	9.94452	51.215	4.926	31.34197	0.73265	0.00086	0.73437	0.93680
athozrpw12kr_1_2_2	1.70	1.496	0.00	2.054	na	8.69804	51.215	6.286	31.23116	0.63261	0.00080	0.63421	0.93680
athozrpw12kr_1_2_1	1.70	1.496	0.00	0.694	na	6.92901	51.215	7.647	31.11956	0.48576	0.00063	0.48702	0.93520
athozrpw12kr_2_2_5	1.70	1.496	2.00	6.783	na	12.32658	51.215	2.205	31.64095	0.87259	0.00079	0.87417	0.93680
athozrpw12kr_3_2_5	1.70	1.496	4.00	7.429	na	12.82951	51.215	2.205	31.72024	0.88583	0.00086	0.88755	0.93680
athozrpw12kr_4_2_5	1.70	1.496	8.00	8.723	na	13.73154	51.215	2.205	31.87763	0.90817	0.00087	0.90991	0.93680
athozrpw12kr_5_2_5	1.70	1.496	12.00	10.016	na	14.52847	51.215	2.205	32.03349	0.92789	0.00092	0.92973	0.93680
athozrpw12kr_7_2_5	1.70	1.496	13.50	10.501	na	14.80590	51.215	2.205	32.09155	0.93291	0.00098	0.93487	0.93680
athozrpw12kr_1_3_5	2.00	1.760	0.00	6.258	na	11.86429	51.215	2.205	31.57324	0.87197	0.00089	0.87375	0.93680
athozrpw12kr_5_3_5	2.00	1.760	13.20	10.624	na	14.86015	51.215	2.205	32.10314	0.95533	0.00086	0.95705	0.93680

Table 6.9.10.9-6. Results for HEU oxide and zirconium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2-ZrO_2 at 1.5 g/cm^3, maximum free water in wet Kaolite limited to 12 lb													
athozrpw12kr15_1_1_5	1.00	0.880	0.00	6.017	na	11.67277	51.215	2.205	31.54661	0.80822	0.00084	0.80990	0.93680
athozrpw12kr15_2_1_5	1.00	0.880	2.00	6.996	na	12.40464	51.215	2.205	31.65287	0.82583	0.00089	0.82761	0.93680
athozrpw12kr15_3_1_5	1.00	0.880	4.00	7.975	na	13.05905	51.215	2.205	31.75842	0.84081	0.00085	0.84251	0.93680
athozrpw12kr15_5_1_5	1.00	0.880	10.00	10.914	na	14.70845	51.215	2.205	32.07093	0.87379	0.00084	0.87547	0.93680
athozrpw12kr15_6_1_5	1.00	0.880	12.00	11.893	na	15.18340	51.215	2.205	32.17376	0.88030	0.00079	0.88188	0.93680
athozrpw12kr15_9_1_5	1.00	0.880	13.45	12.603	na	15.51000	51.215	2.205	32.24790	0.88493	0.00094	0.88681	0.93680
athozrpw12kr15_1_2_5	1.30	1.144	0.00	6.189	na	11.78843	51.215	2.205	31.56259	0.83890	0.00086	0.84062	0.93680
athozrpw12kr15_1_2_4	1.30	1.144	0.00	4.828	na	10.94968	51.215	3.565	31.45334	0.78885	0.00077	0.79039	0.93680
athozrpw12kr15_1_2_3	1.30	1.144	0.00	3.468	na	9.95791	51.215	4.926	31.34332	0.72114	0.00085	0.72284	0.93680
athozrpw12kr15_1_2_2	1.30	1.144	0.00	2.107	na	8.71554	51.215	6.286	31.23252	0.62393	0.00096	0.62585	0.93680
athozrpw12kr15_1_2_1	1.30	1.144	0.00	0.747	na	6.95653	51.215	7.647	31.12093	0.48131	0.00084	0.48299	0.93520
athozrpw12kr15_2_2_5	1.30	1.144	2.00	7.168	na	12.50722	51.215	2.205	31.66875	0.85980	0.00110	0.86200	0.93680
athozrpw12kr15_3_2_5	1.30	1.144	4.00	8.148	na	13.15172	51.215	2.205	31.77419	0.87610	0.00078	0.87766	0.93680
athozrpw12kr15_4_2_5	1.30	1.144	8.00	10.107	na	14.27916	51.215	2.205	31.98301	0.90700	0.00100	0.90900	0.93680
athozrpw12kr15_6_2_5	1.30	1.144	12.00	12.066	na	15.25213	51.215	2.205	32.18913	0.92760	0.00092	0.92944	0.93680
athozrpw12kr15_8_2_5	1.30	1.144	13.15	12.629	na	15.51000	51.215	2.205	32.24790	0.93220	0.00110	0.93440	0.93680
athozrpw12kr15_1_3_5	1.50	1.320	0.00	6.304	na	11.86429	51.215	2.205	31.57324	0.85457	0.00086	0.85629	0.93680
athozrpw12kr15_7_3_5	1.50	1.320	12.95	12.646	na	15.51000	51.215	2.205	32.24790	0.95640	0.00100	0.95840	0.93680
Saturated UO_2-ZrO_2 at 1.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb													
athozrpw12kr15_1_1_5	1.00	0.880	0.00	6.349	na	11.86430	51.215	2.205	31.57324	0.81664	0.00087	0.81838	0.93680
athozrpw12kr15_2_1_5	1.00	0.880	2.00	7.994	na	12.90162	51.215	2.205	31.73210	0.84978	0.00079	0.85136	0.93680
athozrpw12kr15_3_1_5	1.00	0.880	4.00	9.639	na	13.79456	51.215	2.205	31.88938	0.87237	0.00081	0.87399	0.93680
athozrpw12kr15_4_1_5	1.00	0.880	6.00	11.284	na	14.58480	51.215	2.205	32.04512	0.88803	0.00080	0.88963	0.93680
athozrpw12kr15_5_1_5	1.00	0.880	8.00	12.929	na	15.29760	51.215	2.205	32.19937	0.89987	0.00085	0.90157	0.93680

Table 6.9.10.9-6. Results for HEU oxide and zirconium oxide content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athozrpw12kr15_8_1_5	1.00	0.880	8.65	13.464	na	15.51552	51.215	2.205	32.24918	0.90292	0.00085	0.90462	0.93680
athozrpw12kr15_1_2_5	1.15	1.012	0.00	6.485	na	11.94850	51.215	2.205	31.58521	0.83611	0.00085	0.83781	0.93680
athozrpw12kr15_1_2_4	1.15	1.012	0.00	5.125	na	11.13459	51.215	3.565	31.47611	0.79148	0.00084	0.79316	0.93680
athozrpw12kr15_1_2_3	1.15	1.012	0.00	3.764	na	10.18029	51.215	4.926	31.36625	0.73064	0.00081	0.73226	0.93680
athozrpw12kr15_1_2_2	1.15	1.012	0.00	2.404	na	9.0028	51.215	6.286	31.25562	0.64614	0.00078	0.64770	0.93680
athozrpw12kr15_1_2_1	1.15	1.012	0.00	1.043	na	7.39431	51.215	7.647	31.1442	0.5138	0.00075	0.51530	0.93680
athozrpw12kr15_2_2_5	1.15	1.012	2.00	8.130	na	12.97294	51.215	2.205	31.74395	0.86955	0.00096	0.87147	0.93680
athozrpw12kr15_3_2_5	1.15	1.012	4.00	9.775	na	13.857	51.215	2.205	31.90111	0.89616	0.00096	0.89808	0.93680
athozrpw12kr15_4_2_5	1.15	1.012	6.00	11.420	na	14.6407	51.215	2.205	32.05674	0.91321	0.00094	0.91509	0.93680
athozrpw12kr15_6_2_5	1.15	1.012	8.00	13.394	na	15.48239	51.215	2.205	32.24152	0.92900	0.00100	0.93100	0.93680
athozrpw12kr15_7_2_5	1.15	1.012	8.50	13.476	na	15.51552	51.215	2.205	32.24918	0.92962	0.00069	0.93100	0.93680
athozrpw12kr15_1_3_5	1.25	1.100	0.00	6.576	na	12.00398	51.215	2.205	31.59319	0.84587	0.00087	0.84761	0.93680
athozrpw12kr15_6_3_5	1.25	1.100	8.40	13.485	na	15.51552	51.215	2.205	32.24918	0.94636	0.00094	0.94824	0.93680

Table 6.9.10.9-7. Results for HEU oxide and zirconium oxide content for air transportation (Model 6)

Case athozrp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Compromised package, homogeneous core [HEU, poly, wet Kaolite, sat moisture from oxide], dry oxide shell, 20.0 cm water reflector													
Saturated UO_2-ZrO_2 at 5.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
50_5_6_6	10.00	8.802	4.20	10.303	51.215	31.99956	1.00	0.880	32.01519	0.63768	0.00062	0.63892	0.93680
50_4_6_6	10.00	8.802	4.20	8.602	51.215	31.86658	1.00	0.880	31.88234	0.61571	0.00074	0.61719	0.93680
50_3_6_6	10.00	8.802	4.20	6.901	51.215	31.73248	1.00	0.880	31.74838	0.59236	0.00060	0.59356	0.93680
50_2_6_6	10.00	8.802	4.20	5.200	51.215	31.59724	1.00	0.880	31.61327	0.57067	0.00064	0.57195	0.93680
50_1_6_6	10.00	8.802	4.20	3.499	51.215	31.46083	1.00	0.880	31.47700	0.54841	0.00065	0.54971	0.93680
50_5_5_5	8.00	7.042	4.20	10.303	51.215	31.96844	3.00	2.640	32.01519	0.65067	0.00071	0.65209	0.93680
50_4_5_5	8.00	7.042	4.20	8.602	51.215	31.83520	3.00	2.640	31.88234	0.62849	0.00075	0.62999	0.93680
50_3_5_5	8.00	7.042	4.20	6.901	51.215	31.70084	3.00	2.640	31.74838	0.60529	0.00071	0.60671	0.93680
50_2_5_5	8.00	7.042	4.20	5.200	51.215	31.61327	3.00	2.640	31.61327	0.58150	0.00065	0.58280	0.93680
50_1_5_5	8.00	7.042	4.20	3.499	51.215	31.42864	3.00	2.641	31.47700	0.56024	0.00065	0.56154	0.93680
50_5_4_4	6.00	5.281	4.20	10.303	51.215	31.93727	5.00	4.401	32.01519	0.65797	0.00072	0.65941	0.93680
50_4_4_4	6.00	5.281	4.20	8.602	51.215	31.80376	5.00	4.401	31.88234	0.63669	0.00064	0.63797	0.93680
50_3_4_4	6.00	5.281	4.20	6.901	51.215	31.66913	5.00	4.401	31.74838	0.61335	0.00059	0.61453	0.93680
50_2_4_4	6.00	5.281	4.20	5.200	51.215	31.53334	5.00	4.401	31.61327	0.59143	0.00066	0.59275	0.93680
50_1_4_4	6.00	5.281	4.20	3.499	51.215	31.39638	5.00	4.401	31.47700	0.56698	0.00065	0.56828	0.93680
50_5_3_3	5.00	4.401	4.20	10.303	51.215	31.92165	6.00	5.281	32.01519	0.66132	0.00082	0.66296	0.93680
50_4_3_3	5.00	4.401	4.20	8.602	51.215	31.78802	6.00	5.281	31.88234	0.63908	0.00075	0.64058	0.93680
50_3_3_3	5.00	4.401	4.20	6.901	51.215	31.65325	6.00	5.281	31.74838	0.61636	0.00069	0.61774	0.93680
50_2_3_3	5.00	4.401	4.20	5.200	51.215	31.51733	6.00	5.281	31.61327	0.59301	0.00068	0.59437	0.93680
50_1_3_3	5.00	4.401	4.20	3.499	51.215	31.38022	6.00	5.281	31.47700	0.57035	0.00068	0.57171	0.93680
50_5_2_2	3.00	2.640	4.20	10.303	51.215	31.89039	8.00	7.042	32.01519	0.66280	0.00072	0.66424	0.93680
50_4_2_2	3.00	2.640	4.20	8.602	51.215	31.75649	8.00	7.042	31.88234	0.64151	0.00075	0.64301	0.93680
50_3_2_2	3.00	2.640	4.20	6.901	51.215	31.62145	8.00	7.042	31.74838	0.62027	0.00085	0.62197	0.93680

Table 6.9.10.9-7. Results for HEU oxide and zirconium oxide content for air transportation (Model 6)

Case athozrp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
50_2_2_2	3.00	2.640	4.20	3.499	51.215	31.34787	8.00	7.042	31.47700	0.57434	0.00064	0.57562	0.93680
50_1_2_2	3.00	2.640	4.20	3.499	51.215	31.34787	8.00	7.042	31.47700	0.57434	0.00064	0.57562	0.93680
50_5_1_1	1.00	0.880	4.20	10.303	51.215	31.85906	10.00	8.802	32.01519	0.65671	0.00065	0.65801	0.93680
50_4_1_1	1.00	0.880	4.20	8.602	51.215	31.72489	10.00	8.802	31.88234	0.63930	0.00062	0.64054	0.93680
50_3_1_1	1.00	0.880	4.20	6.901	51.215	31.58959	10.00	8.802	31.74838	0.61889	0.00059	0.62007	0.93680
50_2_1_1	1.00	0.880	4.20	5.200	51.215	31.45311	10.00	8.802	31.61327	0.59856	0.00066	0.59988	0.93680
50_1_1_1	1.00	0.880	4.20	3.499	51.215	31.31544	10.00	8.802	31.47700	0.57793	0.00062	0.57917	0.93680
Saturated UO_2-ZrO_2 at 4.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
40_5_6_6	10.00	8.802	4.20	11.062	51.215	32.05464	1.00	0.880	32.07409	0.64790	0.00064	0.64918	0.93680
40_4_6_6	10.00	8.802	4.20	9.361	51.215	31.92212	1.00	0.880	31.94173	0.62411	0.00064	0.62539	0.93680
40_3_6_6	10.00	8.802	4.20	7.660	51.215	31.78849	1.00	0.880	31.80827	0.60248	0.00068	0.60384	0.93680
40_2_6_6	10.00	8.802	4.20	5.959	51.215	31.65373	1.00	0.880	31.67367	0.58061	0.00074	0.58209	0.93680
40_1_6_6	10.00	8.802	4.20	4.258	51.215	31.51781	1.00	0.880	31.53792	0.55834	0.00073	0.55980	0.93680
40_5_5_5	8.00	7.042	4.20	11.062	51.215	32.01587	3.00	2.640	32.07409	0.66122	0.00069	0.66260	0.93680
40_4_5_5	8.00	7.042	4.20	9.361	51.215	31.88303	3.00	2.640	31.94173	0.63902	0.00075	0.64052	0.93680
40_3_5_5	8.00	7.042	4.20	7.660	51.215	31.74907	3.00	2.640	31.80827	0.61635	0.00062	0.61759	0.93680
40_2_5_5	8.00	7.042	4.20	5.959	51.215	31.61397	3.00	2.640	31.67367	0.59249	0.00065	0.59379	0.93680
40_1_5_5	8.00	7.042	4.20	4.258	51.215	31.47770	3.00	2.641	31.53792	0.56941	0.00066	0.57073	0.93680
40_5_4_4	6.00	5.281	4.20	11.062	51.215	31.97700	5.00	4.401	32.07409	0.66795	0.00071	0.66937	0.93680
40_4_4_4	6.00	5.281	4.20	9.361	51.215	31.84384	5.00	4.401	31.94173	0.64632	0.00068	0.64768	0.93680
40_3_4_4	6.00	5.281	4.20	7.660	51.215	31.70955	5.00	4.401	31.80827	0.62372	0.00060	0.62492	0.93680
40_2_4_4	6.00	5.281	4.20	5.959	51.215	31.57411	5.00	4.401	31.67367	0.59978	0.00062	0.60102	0.93680
40_1_4_4	6.00	5.281	4.20	4.258	51.215	31.43750	5.00	4.401	31.53792	0.57721	0.00062	0.57845	0.93680
40_5_3_3	5.00	4.401	4.20	11.062	51.215	31.95754	6.00	5.281	32.07409	0.67012	0.00067	0.67146	0.93680
40_4_3_3	5.00	4.401	4.20	9.361	51.215	31.82421	6.00	5.281	31.94173	0.64974	0.00071	0.65116	0.93680

Table 6.9.10.9-7. Results for HEU oxide and zirconium oxide content for air transportation (Model 6)

Case athozrp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
40_3_3_3	5.00	4.401	4.20	7.660	51.215	31.68975	6.00	5.281	31.80827	0.62692	0.00081	0.62854	0.93680
40_2_3_3	5.00	4.401	4.20	5.959	51.215	31.55414	6.00	5.281	31.67367	0.60334	0.00064	0.60462	0.93680
40_1_3_3	5.00	4.401	4.20	4.258	51.215	31.41735	6.00	5.281	31.53792	0.58086	0.00063	0.58212	0.93680
40_5_2_2	3.00	2.640	4.20	11.062	51.215	31.91853	8.00	7.042	32.07409	0.67022	0.00072	0.67166	0.93680
40_4_2_2	3.00	2.640	4.20	9.361	51.215	31.78487	8.00	7.042	31.94173	0.64962	0.00070	0.65102	0.93680
40_3_2_2	3.00	2.640	4.20	7.660	51.215	31.65008	8.00	7.042	31.80827	0.62872	0.00063	0.62998	0.93680
40_2_2_2	3.00	2.640	4.20	5.959	51.215	31.51413	8.00	7.042	31.67367	0.60752	0.00082	0.60916	0.93680
40_1_2_2	3.00	2.640	4.20	4.258	51.215	31.37699	8.00	7.042	31.53792	0.58460	0.00060	0.58580	0.93680
40_5_1_1	1.00	0.880	4.20	11.062	51.215	31.87943	10.00	8.802	32.07409	0.66305	0.00062	0.66429	0.93680
40_4_1_1	1.00	0.880	4.20	9.361	51.215	31.74544	10.00	8.802	31.94173	0.64582	0.00062	0.64706	0.93680
40_3_1_1	1.00	0.880	4.20	7.660	51.215	31.61031	10.00	8.802	31.80827	0.62702	0.00063	0.62828	0.93680
40_2_1_1	1.00	0.880	4.20	5.959	51.215	31.47401	10.00	8.802	31.67367	0.60792	0.00061	0.60914	0.93680
40_1_1_1	1.00	0.880	4.20	4.258	51.215	31.33652	10.00	8.802	31.53792	0.58670	0.00062	0.58794	0.93680
Saturated UO_2-ZrO_2 at 3.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
30_5_6_6	8.40	7.394	5.80	12.191	51.215	32.14603	1.00	0.880	32.17177	0.65177	0.00069	0.65315	0.93680
30_4_6_6	8.40	7.394	5.80	10.490	51.215	32.01426	1.00	0.880	32.04022	0.63042	0.00067	0.63176	0.93680
30_3_6_6	8.40	7.394	5.80	8.789	51.215	31.88141	1.00	0.880	31.90758	0.60884	0.00084	0.61052	0.93680
30_2_6_6	8.40	7.394	5.80	7.088	51.215	31.74743	1.00	0.880	31.77383	0.58590	0.00061	0.58712	0.93680
30_1_6_6	8.40	7.394	5.80	5.387	51.215	31.61232	1.00	0.880	31.63894	0.56356	0.00062	0.56480	0.93680
30_5_5_5	6.90	6.073	5.80	12.191	51.215	32.10748	2.50	2.201	32.17177	0.66423	0.00066	0.66555	0.93680
30_4_5_5	6.90	6.073	5.80	10.490	51.215	31.97539	2.50	2.201	32.04022	0.64310	0.00065	0.64440	0.93680
30_3_5_5	6.90	6.073	5.80	8.789	51.215	31.84221	2.50	2.201	31.90758	0.62123	0.00070	0.62263	0.93680
30_2_5_5	6.90	6.073	5.80	7.088	51.215	31.70791	2.50	2.201	31.77383	0.59709	0.00073	0.59855	0.93680
30_1_5_5	6.90	6.073	5.80	5.387	51.215	31.57245	2.50	2.201	31.63894	0.57579	0.00080	0.57739	0.93680

Table 6.9.10.9-7. Results for HEU oxide and zirconium oxide content for air transportation (Model 6)

Case athozrp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
30_5_4_4	5.40	4.753	5.80	12.191	51.215	32.06883	4.00	3.521	32.17177	0.67105	0.00069	0.67243	0.93680
30_4_4_4	5.40	4.753	5.80	10.490	51.215	31.93643	4.00	3.521	32.04022	0.64971	0.00062	0.65095	0.93680
30_3_4_4	5.40	4.753	5.80	8.789	51.215	31.80292	4.00	3.521	31.90758	0.62677	0.00081	0.62839	0.93680
30_2_4_4	5.40	4.753	5.80	7.088	51.215	31.66828	4.00	3.521	31.77383	0.60548	0.00061	0.60670	0.93680
30_1_4_4	5.40	4.753	5.80	5.387	51.215	31.53249	4.00	3.521	31.63894	0.58288	0.00063	0.58414	0.93680
30_5_3_3	4.00	3.521	5.80	12.191	51.215	32.03268	5.40	4.753	32.17177	0.67421	0.00069	0.67559	0.93680
30_4_3_3	4.00	3.521	5.80	10.490	51.215	31.89998	5.40	4.753	32.04022	0.65275	0.00068	0.65411	0.93680
30_3_3_3	4.00	3.521	5.80	8.789	51.215	31.76616	5.40	4.753	31.90758	0.63034	0.00072	0.63178	0.93680
30_2_3_3	4.00	3.521	5.80	7.088	51.215	31.63121	5.40	4.753	31.77383	0.60796	0.00056	0.60908	0.93680
30_1_3_3	4.00	3.521	5.80	5.387	51.215	31.49510	5.40	4.753	31.63894	0.58565	0.00066	0.58697	0.93680
30_5_2_2	2.50	2.201	5.80	12.191	51.215	31.99386	6.90	6.073	32.17177	0.67226	0.00080	0.67386	0.93680
30_4_2_2	2.50	2.201	5.80	10.490	51.215	31.86083	6.90	6.073	32.04022	0.65259	0.00075	0.65409	0.93680
30_3_2_2	2.50	2.201	5.80	8.789	51.215	31.72668	6.90	6.073	31.90758	0.63290	0.00070	0.63430	0.93680
30_2_2_2	2.50	2.201	5.80	7.088	51.215	31.59139	6.90	6.073	31.77383	0.61021	0.00073	0.61167	0.93680
30_1_2_2	2.50	2.201	5.80	5.387	51.215	31.45493	6.90	6.073	31.63894	0.58912	0.00065	0.59042	0.93680
30_5_1_1	1.00	0.880	5.80	12.191	51.215	31.95494	8.40	7.394	32.17177	0.66293	0.00066	0.66425	0.93680
30_4_1_1	1.00	0.880	5.80	10.490	51.215	31.82159	8.40	7.394	32.04022	0.64642	0.00064	0.64770	0.93680
30_3_1_1	1.00	0.880	5.80	8.789	51.215	31.68711	8.40	7.394	31.90758	0.62796	0.00065	0.62926	0.93680
30_2_1_1	1.00	0.880	5.80	7.088	51.215	31.55147	8.40	7.394	31.77383	0.60943	0.00066	0.61075	0.93680
30_1_1_1	1.00	0.880	5.80	5.387	51.215	31.41467	8.40	7.394	31.63894	0.58918	0.00064	0.59046	0.93680
Saturated UO_2-ZrO_2 at 2.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
_5_4_4	1.50	1.320	13.45	14.072	51.215	32.35578	0.25	0.220	32.36538	0.48282	0.00055	0.48392	0.93680
_4_4_4	1.50	1.320	13.45	12.371	51.215	32.22573	0.25	0.220	32.23541	0.46831	0.00051	0.46933	0.93680
_3_4_4	1.50	1.320	13.45	10.670	51.215	32.09463	0.25	0.220	32.10438	0.54332	0.00062	0.54456	0.93680

Table 6.9.10.9-7. Results for HEU oxide and zirconium oxide content for air transportation (Model 6)

Case athozrp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
_2_4_4	1.50	1.320	13.45	8.969	51.215	31.96244	0.25	0.220	31.97227	0.43875	0.00059	0.43993	0.93680
_1_4_4	1.50	1.320	13.45	7.268	51.215	31.82915	0.25	0.220	31.83906	0.42413	0.00051	0.42515	0.93680
_5_3_3	1.00	0.880	13.45	14.072	51.215	32.33677	0.75	0.660	32.36538	0.49029	0.00064	0.49157	0.93680
_4_3_3	1.00	0.880	13.45	12.371	51.215	32.20657	0.75	0.660	32.23541	0.47813	0.00058	0.47929	0.93680
_3_3_3	1.00	0.880	13.45	10.670	51.215	32.07530	0.75	0.660	32.10438	0.46459	0.00053	0.46565	0.93680
_2_3_3	1.00	0.880	13.45	8.969	51.215	31.94295	0.75	0.660	31.97227	0.45145	0.00054	0.45253	0.93680
_1_3_3	1.00	0.880	13.45	7.268	51.215	31.80950	0.75	0.660	31.83906	0.43583	0.00052	0.43687	0.93680
_5_2_2	0.75	0.660	13.45	14.072	51.215	32.32725	1.00	0.880	32.36538	0.48903	0.00053	0.49009	0.93680
_4_2_2	0.75	0.660	13.45	12.371	51.215	32.19697	1.00	0.880	32.23541	0.47693	0.00065	0.47823	0.93680
_3_2_2	0.75	0.660	13.45	10.670	51.215	32.06563	1.00	0.880	32.10438	0.46486	0.00058	0.46602	0.93680
_2_2_2	0.75	0.660	13.45	8.969	51.215	31.93320	1.00	0.880	31.97227	0.45166	0.00061	0.45288	0.93680
_1_2_2	0.75	0.660	13.45	7.268	51.215	31.79967	1.00	0.880	31.83906	0.43788	0.00052	0.43892	0.93680
_5_1_1	0.25	0.220	13.45	14.072	51.215	32.30821	1.50	1.320	32.36538	0.46556	0.00064	0.46684	0.93680
_4_1_1	0.25	0.220	13.45	12.371	51.215	32.17777	1.50	1.320	32.23541	0.45870	0.00056	0.45982	0.93680
_3_1_1	0.25	0.220	13.45	10.670	51.215	32.04627	1.50	1.320	32.10438	0.45073	0.00058	0.45189	0.93680
_2_1_1	0.25	0.220	13.45	8.969	51.215	31.91368	1.50	1.320	31.97227	0.44075	0.00049	0.44173	0.93680
_1_1_1	0.25	0.220	13.45	7.268	51.215	31.77998	1.50	1.320	31.83906	0.43051	0.00050	0.43151	0.93680
Saturated UO_2-ZrO_2 at 1.5 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
15_5_3_3	0.75	0.660	13.50	16.166	51.215	32.50898	0.20	0.176	32.51912	0.39026	0.00041	0.39108	0.93680
15_4_3_3	0.75	0.660	13.50	14.465	51.215	32.38016	0.20	0.176	32.39038	0.38021	0.00050	0.38121	0.93680
15_3_3_3	0.75	0.660	13.50	12.764	51.215	32.25031	0.20	0.176	32.26061	0.37135	0.00044	0.37223	0.93680
15_2_3_3	0.75	0.660	13.50	11.063	51.215	32.11940	0.20	0.176	32.12979	0.36264	0.00041	0.36346	0.93680
15_1_3_3	0.75	0.660	13.50	9.362	51.215	31.98742	0.20	0.176	31.99789	0.35101	0.00048	0.35197	0.93680
15_5_2_2	0.475	0.418	13.50	16.166	51.215	32.49517	0.475	0.418	32.51912	0.38721	0.00051	0.38823	0.93680
15_4_2_2	0.475	0.418	13.50	14.465	51.215	32.36624	0.475	0.418	32.39038	0.38184	0.00048	0.38280	0.93680

Table 6.9.10.9-7. Results for HEU oxide and zirconium oxide content for air transportation (Model 6)

Case athozrp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	ZrO_2 (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
15_3_2_2	0.475	0.418	13.50	12.764	51.215	32.23628	0.475	0.418	32.26061	0.37476	0.00046	0.37568	0.93680
15_2_2_2	0.475	0.418	13.50	11.063	51.215	32.10526	0.475	0.418	32.12979	0.36566	0.00044	0.36654	0.93680
15_1_2_2	0.475	0.418	14.20	9.362	51.215	31.98742	0.475	0.418	31.99789	0.35609	0.00046	0.35701	0.93680
15_5_1_1	0.20	0.176	13.50	16.166	51.215	32.48135	0.75	0.660	32.51912	0.37044	0.00049	0.37142	0.93680
15_4_1_1	0.20	0.176	13.50	14.465	51.215	32.35231	0.75	0.660	32.39038	0.36690	0.00048	0.36786	0.93680
15_3_1_1	0.20	0.176	13.50	12.764	51.215	32.22232	0.75	0.660	32.26061	0.36194	0.00046	0.36286	0.93680
15_2_1_1	0.20	0.176	13.50	11.063	51.215	32.09110	0.75	0.660	32.12979	0.35679	0.00047	0.35773	0.93680
15_1_1_1	0.20	0.176	13.50	9.362	51.215	31.95888	0.75	0.660	31.99789	0.35014	0.00049	0.35112	0.93680
Ssaturated UO_2-ZrO_2 at 1.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
10_5_3_3	0.60	0.528	8.85	17.013	51.215	32.50522	0.20	0.176	32.52037	0.36114	0.00048	0.36210	0.93680
10_4_3_3	0.60	0.528	8.85	15.312	51.215	32.37637	0.20	0.176	32.39164	0.35424	0.00046	0.35516	0.93680
10_3_3_3	0.60	0.528	8.85	13.611	51.215	32.24649	0.20	0.176	32.26188	0.34620	0.00043	0.34706	0.93680
10_2_3_3	0.60	0.528	8.85	11.910	51.215	32.11555	0.20	0.176	32.13107	0.33761	0.00043	0.33847	0.93680
10_1_3_3	0.60	0.528	8.85	10.209	51.215	31.98353	0.20	0.176	31.99918	0.32952	0.00041	0.33034	0.93680
10_5_2_2	0.40	0.352	8.85	17.013	51.215	32.49015	0.40	0.352	32.52037	0.35760	0.00043	0.35846	0.93680
10_4_2_2	0.40	0.352	8.85	15.312	51.215	32.36118	0.40	0.352	32.39164	0.35290	0.00048	0.35386	0.93680
10_3_2_2	0.40	0.352	8.85	13.611	51.215	32.23117	0.40	0.352	32.26188	0.34676	0.00048	0.34772	0.93680
10_2_2_2	0.40	0.352	8.85	11.910	51.215	32.10011	0.40	0.352	32.13107	0.33926	0.00042	0.34010	0.93680
10_1_2_2	0.40	0.352	8.85	10.209	51.215	31.96797	0.40	0.352	31.99918	0.33179	0.00044	0.33267	0.93680
10_5_1_1	0.20	0.176	8.85	17.013	51.215	32.47506	0.60	0.528	32.52037	0.34439	0.00046	0.34531	0.93680
10_4_1_1	0.20	0.176	8.85	15.312	51.215	32.34597	0.60	0.528	32.39164	0.34116	0.00041	0.34198	0.93680
10_3_1_1	0.20	0.176	8.85	13.611	51.215	32.21584	0.60	0.528	32.26188	0.33811	0.00045	0.33901	0.93680
10_2_1_1	0.20	0.176	8.85	11.910	51.215	32.08466	0.60	0.528	32.13107	0.33291	0.00048	0.33387	0.93680
10_1_1_1	0.20	0.176	8.85	10.209	51.215	31.95239	0.60	0.528	31.99918	0.32629	0.00047	0.32723	0.93680

Table 6.9.10.9-8. Results for HEU oxide/thorium metal content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Compromised package, HEU-poly core in spherical configuration, 20.0 cm water reflector (Model 1)													
Saturated UO_2-Th at 5.0 g/cm^3													
atdothm50_4_1	8.00	7.042	7.20	1.692	na	9.49304	na	na	na	0.80497	0.00069	0.80635	0.93520
atdothm50_3_2	9.00	7.922	6.20	1.686	na	9.49304	na	na	na	0.82144	0.00075	0.82294	0.93520
atdothm50_2_3	10.00	8.802	5.20	1.680	na	9.49304	na	na	na	0.83665	0.00076	0.83817	0.93520
atdothm50_1_4	11.00	9.682	4.20	1.674	na	9.49304	na	na	na	0.85054	0.00085	0.85224	0.93520
Saturated UO_2-Th at 4.0 g/cm^3													
atdothm40_4_1	8.00	7.042	7.20	2.450	na	10.12161	na	na	na	0.85232	0.00076	0.85384	0.93520
atdothm40_3_2	9.00	7.922	6.20	2.445	na	10.12161	na	na	na	0.86661	0.00073	0.86807	0.93520
atdothm40_2_3	10.00	8.802	5.20	2.438	na	10.12161	na	na	na	0.88013	0.00078	0.88169	0.93520
atdothm40_1_4	11.00	9.682	4.20	2.433	na	10.12161	na	na	na	0.89206	0.00080	0.89366	0.93520
Saturated UO_2-Th at 3.0 g/cm^3													
atdothm30_5_1	8.00	7.042	7.20	3.715	na	11.02288	na	na	na	0.91603	0.00087	0.91777	0.93520
atdothm30_4_2	9.00	7.922	6.20	3.709	na	11.02288	na	na	na	0.92895	0.00081	0.93057	0.93520
atdothm30_3_3	9.35	8.230	5.85	3.707	na	11.02288	na	na	na	0.93266	0.00077	0.93420	0.93520
atdothm30_2_4	10.00	8.802	5.20	3.703	na	11.02288	na	na	na	0.94049	0.00073	0.94195	0.93520
Saturated UO_2-Th at 2.0 g/cm^3													
atdothm_4_1	2.50	2.201	12.70	6.275	na	12.48074	na	na	na	0.90953	0.00069	0.91091	0.93680
atdothm_3_2	3.00	2.641	12.20	6.272	na	12.48074	na	na	na	0.93123	0.00080	0.93283	0.93680
atdothm_2_3	3.10	2.729	12.10	6.272	na	12.48074	na	na	na	0.93452	0.00075	0.93602	0.93680
atdothm_1_4	3.50	3.081	11.70	6.269	na	12.48074	na	na	na	0.94556	0.00084	0.94724	0.93680
Saturated UO_2-Th at 1.5 g/cm^3													
atdothm15_4_1	1.00	0.880	13.50	8.406	na	13.45802	na	na	na	0.80914	0.00066	0.81046	0.93680
atdothm15_3_2	1.50	1.320	13.00	8.404	na	13.45802	na	na	na	0.89139	0.00072	0.89283	0.93680

Table 6.9.10.9-8. Results for HEU oxide/thorium metal content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdothm15_2_3	1.95	1.716	12.55	8.401	na	13.45802	na	na	na	0.93399	0.00095	0.93589	0.93680
atdothm15_1_4	2.00	1.760	12.50	8.401	na	13.45802	na	na	na	0.93710	0.00080	0.93870	0.93680
Saturated UO_2-Th at 1.0 g/cm^3													
atdothmr10_4_1	1.00	0.880	8.65	8.804	na	13.45069	na	na	na	0.86926	0.00072	0.87070	0.93680
atdothmr10_3_2	1.25	1.100	8.40	8.802	na	13.45069	na	na	na	0.91405	0.00078	0.91561	0.93680
atdothmr10_2_3	1.35	1.188	8.30	8.801	na	13.45069	na	na	na	0.92675	0.00071	0.92817	0.93680
atdothmr10_1_4	1.50	1.320	8.15	8.801	na	13.45069	na	na	na	0.94500	0.00083	0.94666	0.93680
Compromised package, HEU-poly core in spherical configuration, stainless-steel shell, 20.0-cm water reflector (Model 2)													
Saturated UO_2-Th at 5.0 g/cm^3													
atdothmsr50_1	11.00	9.682	4.20	1.674	na	9.49304	na	na	na	0.85054	0.00085	0.85224	0.93520
atdothmsr50_2	11.00	9.682	4.20	1.674	na	9.49304	na	na	10.17803	0.81356	0.00075	0.81506	0.93520
atdothmsr50_3	11.00	9.682	4.20	1.674	na	9.49304	na	na	10.78140	0.79504	0.00067	0.79638	0.93520
atdothmsr50_4	11.00	9.682	4.20	1.674	na	9.49304	na	na	11.32387	0.78808	0.00074	0.78956	0.93520
atdothmsr50_5	11.00	9.682	4.20	1.674	na	9.49304	na	na	11.81882	0.74710	0.00085	0.74880	0.93520
atdothmsr50_6	11.00	9.682	4.20	1.674	na	9.49304	na	na	12.27546	0.78978	0.00071	0.79120	0.93520
atdosthmr50_7	11.00	9.682	4.20	1.674	na	9.49304	na	na	12.70044	0.79143	0.00078	0.79299	0.93520
atdothmsr50_8	11.00	9.682	4.20	1.674	na	9.49304	na	na	13.09874	0.79414	0.00067	0.79548	0.93520
atdothmsr50_9	11.00	9.682	4.20	1.674	na	9.49304	na	na	13.47419	0.79878	0.00081	0.80040	0.93520
atdothmsr50_10	11.00	9.682	4.20	1.674	na	9.49304	na	na	13.82980	0.80280	0.00064	0.80408	0.93520
atdosthmr50_11	11.00	9.682	4.20	1.674	na	9.49304	na	na	14.16801	0.80549	0.00075	0.80699	0.93520
Saturated UO_2-Th at 4.0 g/cm^3													
atdothmsr40_1	11.00	9.682	4.20	2.433	na	10.12161	na	na	na	0.89206	0.00080	0.89366	0.93520
atdothmsr40_2	11.00	9.682	4.20	2.433	na	10.12161	na	na	10.73125	0.85943	0.00071	0.86085	0.93520
atdothmsr40_3	11.00	9.682	4.20	2.433	na	10.12161	na	na	11.27844	0.84248	0.00088	0.84424	0.93520
atdothmsr40_4	11.00	9.682	4.20	2.433	na	10.12161	na	na	11.77714	0.83598	0.00063	0.83724	0.93520

Table 6.9.10.9-8. Results for HEU oxide/thorium metal content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdothmsr40_5	11.00	9.682	4.20	2.433	na	10.12161	na	na	12.23684	0.83488	0.00073	0.83634	0.93520
atdothmsr40_6	11.00	9.682	4.20	2.433	na	10.12161	na	na	12.66437	0.83620	0.00070	0.83760	0.93520
atdothmsr40_7	11.00	9.682	4.20	2.433	na	10.12161	na	na	13.06484	0.83850	0.00076	0.84002	0.93520
atdothmsr40_8	11.00	9.682	4.20	2.433	na	10.12161	na	na	13.44216	0.84123	0.00070	0.84263	0.93520
atdothmsr40_9	11.00	9.682	4.20	2.433	na	10.12161	na	na	13.79940	0.84408	0.00077	0.84562	0.93520
atdothmsr40_10	11.00	9.682	4.20	2.433	na	10.12161	na	na	14.13905	0.84948	0.00068	0.85084	0.93520
atdothmsr40_11	11.00	9.682	4.20	2.433	na	10.12161	na	na	14.46312	0.85286	0.00066	0.85418	0.93520
Saturated UO_2-Th at 3.0 g/cm^3													
atdothmsr30_1	9.35	8.230	5.85	3.707	na	11.02288	na	na	na	0.93266	0.00077	0.93420	0.93520
atdothmsr30_2	9.35	8.230	5.85	3.707	na	11.02288	na	na	11.54352	0.90381	0.00092	0.90565	0.93520
atdothmsr30_3	9.35	8.230	5.85	3.707	na	11.02288	na	na	12.02092	0.88703	0.00073	0.88849	0.93520
atdothmsr30_4	9.35	8.230	5.85	3.707	na	11.02288	na	na	12.46314	0.88062	0.00072	0.88206	0.93520
atdothmsr30_5	9.35	8.230	5.85	3.707	na	11.02288	na	na	12.87603	0.87844	0.00096	0.88036	0.93520
atdothmsr30_6	9.35	8.230	5.85	3.707	na	11.02288	na	na	13.26401	0.87975	0.00075	0.88125	0.93520
atdothmsr30_7	9.35	8.230	5.85	3.707	na	11.02288	na	na	13.63053	0.88031	0.00093	0.88217	0.93520
atdothmsr30_8	9.35	8.230	5.85	3.707	na	11.02288	na	na	13.97834	0.88518	0.00075	0.88668	0.93520
atdothmsr30_9	9.35	8.230	5.85	3.707	na	11.02288	na	na	14.30965	0.88766	0.00083	0.88932	0.93520
atdothmsr30_10	9.35	8.230	5.85	3.707	na	11.02288	na	na	14.62628	0.89031	0.00096	0.89223	0.93520
atdothmsr30_11	9.35	8.230	5.85	3.707	na	11.02288	na	na	14.92977	0.89297	0.00069	0.89435	0.93520
Saturated UO_2-Th at 2.0 g/cm^3													
atdothmsr_1	3.10	2.729	12.10	6.272	na	12.48074	na	na	na	0.93452	0.00075	0.93602	0.93680
atdothmsr_2	3.10	2.729	12.10	6.272	na	12.48074	na	na	12.89262	0.90322	0.00084	0.90490	0.93680
atdothmsr_3	3.10	2.729	12.10	6.272	na	12.48074	na	na	13.27964	0.88884	0.00079	0.89042	0.93680
atdothmsr_4	3.10	2.729	12.10	6.272	na	12.48074	na	na	13.64534	0.88208	0.00090	0.88388	0.93680
atdothmsr_5	3.10	2.729	12.10	6.272	na	12.48074	na	na	13.99242	0.88012	0.00074	0.88160	0.93680

Table 6.9.10.9-8. Results for HEU oxide/thorium metal content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdothmsr_6	3.10	2.729	12.10	6.272	na	12.48074	na	na	14.32308	0.88206	0.00069	0.88344	0.93680
atdothmsr_7	3.10	2.729	12.10	6.272	na	12.48074	na	na	14.63914	0.88284	0.00086	0.88456	0.93680
atdothmsr_8	3.10	2.729	12.10	6.272	na	12.48074	na	na	14.94212	0.88577	0.00079	0.88735	0.93680
atdothmsr_9	3.10	2.729	12.10	6.272	na	12.48074	na	na	15.23328	0.88800	0.00088	0.88976	0.93680
atdothmsr_10	3.10	2.729	12.10	6.272	na	12.48074	na	na	15.51372	0.89015	0.00072	0.89159	0.93680
atdothmsr_11	3.10	2.729	12.10	6.272	na	12.48074	na	na	15.78437	0.89377	0.00089	0.89555	0.93680
Saturated UO_2-Th at 1.5 g/cm^3													
atdothmsr15_1	1.95	1.716	12.55	8.401	na	13.45802	na	na	na	0.93399	0.00095	0.93589	0.93680
atdothmsr15_2	1.95	1.716	12.55	8.401	na	13.45802	na	na	13.81455	0.90560	0.00073	0.90706	0.93680
atdothmsr15_3	1.95	1.716	12.55	8.401	na	13.45802	na	na	14.15348	0.89094	0.00085	0.89264	0.93680
atdothmsr15_4	1.95	1.716	12.55	8.401	na	13.45802	na	na	14.47691	0.88835	0.00070	0.88975	0.93680
atdothmsr15_5	1.95	1.716	12.55	8.401	na	13.45802	na	na	14.78650	0.88576	0.00078	0.88732	0.93680
atdothmsr15_6	1.95	1.716	12.55	8.401	na	13.45802	na	na	15.08364	0.88739	0.00092	0.88923	0.93680
atdothmsr15_7	1.95	1.716	12.55	8.401	na	13.45802	na	na	15.36952	0.88837	0.00080	0.88997	0.93680
atdothmsr15_8	1.95	1.716	12.55	8.401	na	13.45802	na	na	15.64514	0.88940	0.00100	0.89140	0.93680
atdothmsr15_9	1.95	1.716	12.55	8.401	na	13.45802	na	na	15.91137	0.89171	0.00075	0.89321	0.93680
atdothmsr15_10	1.95	1.716	12.55	8.401	na	13.45802	na	na	16.16899	0.89328	0.00074	0.89476	0.93680
atdothmsr15_11	1.95	1.716	12.55	8.401	na	13.45802	na	na	16.41864	0.89731	0.00080	0.89891	0.93680
Saturated UO_2-Th at 1.0 g/cm^3													
atdothmsr10_1	1.35	1.188	8.30	8.801	na	13.45069	na	na	na	0.92675	0.00071	0.92817	0.93680
atdothmsr10_2	1.35	1.188	8.30	8.801	na	13.45069	na	na	13.80760	0.89751	0.00068	0.89887	0.93680
atdothmsr10_3	1.35	1.188	8.30	8.801	na	13.45069	na	na	14.14685	0.88405	0.00077	0.88559	0.93680
atdothmsr10_4	1.35	1.188	8.30	8.801	na	13.45069	na	na	14.47058	0.88141	0.00092	0.88325	0.93680
atdothmsr10_5	1.35	1.188	8.30	8.801	na	13.45069	na	na	14.78043	0.87897	0.00065	0.88027	0.93680
atdothmsr10_6	1.35	1.188	8.30	8.801	na	13.45069	na	na	15.07781	0.87991	0.00073	0.88137	0.93680

Table 6.9.10.9-8. Results for HEU oxide/thorium metal content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdothmsr10_7	1.35	1.188	8.30	8.801	na	13.45069	na	na	15.36390	0.88172	0.00083	0.88338	0.93680
atdothmsr10_8	1.35	1.188	8.30	8.801	na	13.45069	na	na	15.63972	0.88329	0.00070	0.88469	0.93680
atdothmsr10_9	1.35	1.188	8.30	8.801	na	13.45069	na	na	15.90613	0.88742	0.00075	0.88892	0.93680
atdothmsr10_10	1.35	1.188	8.30	8.801	na	13.45069	na	na	16.16391	0.88821	0.00087	0.88995	0.93680
atdothmsr10_11	1.35	1.188	8.30	8.801	na	13.45069	na	na	16.41372	0.89142	0.00090	0.89322	0.93680
Compromised package, HEU-poly core in spherical configuration, dry (bound water) Kaolite shell, 20.0-cm water reflector (Model 3)													
Saturated UO_2-Th at 5.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdothmdkr50_1	11.00	9.682	4.20	1.674	na	9.49304	0	0	na	0.85054	0.00085	0.85224	0.93520
atdothmdkr50_2	11.00	9.682	4.20	1.674	na	9.49304	10.243	0.441	18.9606	0.72273	0.00080	0.72433	0.93520
atdothmdkr50_3	11.00	9.682	4.20	1.674	na	9.49304	20.486	0.882	23.3783	0.69132	0.00063	0.69258	0.93520
atdothmdkr50_4	11.00	9.682	4.20	1.674	na	9.49304	30.729	1.323	26.56086	0.67789	0.00075	0.67939	0.93520
atdothmdkr50_5	11.00	9.682	4.20	1.674	na	9.49304	40.972	1.764	29.12235	0.66702	0.00070	0.66842	0.93520
atdothmdkr50_6	11.00	9.682	4.20	1.674	na	9.49304	51.214	2.205	31.29849	0.66164	0.00062	0.66288	0.93520
Saturated UO_2-Th at 4.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdothmdkr40_1	11.00	9.682	4.20	2.433	na	10.12161	0	0	na	0.89206	0.00080	0.89366	0.93520
atdothmdkr40_2	11.00	9.682	4.20	2.433	na	10.12161	10.243	0.441	19.12736	0.77097	0.00071	0.77239	0.93520
atdothmdkr40_3	11.00	9.682	4.20	2.433	na	10.12161	20.486	0.882	23.48843	0.74269	0.00069	0.74407	0.93520
atdothmdkr40_4	11.00	9.682	4.20	2.433	na	10.12161	30.729	1.323	26.64632	0.72803	0.00079	0.72961	0.93520
atdothmdkr40_5	11.00	9.682	4.20	2.433	na	10.12161	40.972	1.764	29.19349	0.71827	0.00069	0.71965	0.93520
atdothmdkr40_6	11.00	9.682	4.20	2.433	na	10.12161	51.214	2.205	31.36011	0.71229	0.00069	0.71367	0.93520
Saturated UO_2-Th at 3.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdothmdkr30_1	9.35	8.230	5.85	3.707	na	11.02288	0	0	na	0.93266	0.00077	0.93420	0.93520
atdothmdkr30_2	9.35	8.230	5.85	3.707	na	11.02288	10.243	0.441	19.39900	0.82371	0.00071	0.82513	0.93520
atdothmdkr30_3	9.35	8.230	5.85	3.707	na	11.02288	20.486	0.882	23.66974	0.79450	0.00088	0.79626	0.93520
atdothmdkr30_4	9.35	8.230	5.85	3.707	na	11.02288	30.729	1.323	26.78753	0.77865	0.00078	0.78021	0.93520

Table 6.9.10.9-8. Results for HEU oxide/thorium metal content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdothmdkr30_5	9.35	8.230	5.85	3.707	na	11.02288	40.972	1.764	29.31129	0.77045	0.00091	0.77227	0.93520
atdothmdkr30_6	9.35	8.230	5.85	3.707	na	11.02288	51.214	2.205	31.46227	0.76387	0.00080	0.76547	0.93520
Saturated UO_2-Th at 2.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdothmdkr_1	3.10	2.729	12.10	6.272	na	12.48074	0	0	na	0.93452	0.00075	0.93602	0.93680
atdothmdkr_2	3.10	2.729	12.10	6.272	na	12.48074	10.243	0.441	19.92056	0.83940	0.00091	0.84122	0.93680
atdothmdkr_3	3.10	2.729	12.10	6.272	na	12.48074	20.486	0.882	24.02423	0.81261	0.00086	0.81433	0.93680
atdothmdkr_4	3.10	2.729	12.10	6.272	na	12.48074	30.729	1.323	27.06558	0.79740	0.00097	0.79934	0.93680
atdothmdkr_5	3.10	2.729	12.10	6.272	na	12.48074	40.972	1.764	29.54408	0.78743	0.00075	0.78893	0.93680
atdothmdkr_6	3.10	2.729	12.10	6.272	na	12.48074	51.214	2.205	31.66462	0.78167	0.00080	0.78327	0.93680
Saturated UO_2-Th at 1.5 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdothmdkr15_1	1.95	1.716	12.55	8.401	na	13.45802	0	0	na	0.93399	0.00095	0.93589	0.93680
atdothmdkr15_2	1.95	1.716	12.55	8.401	na	13.45802	10.243	0.441	20.32666	0.85366	0.00092	0.85550	0.93680
atdothmdkr15_3	1.95	1.716	12.55	8.401	na	13.45802	20.486	0.882	24.30586	0.83068	0.00082	0.83232	0.93680
atdothmdkr15_4	1.95	1.716	12.55	8.401	na	13.45802	30.729	1.323	27.28825	0.81766	0.00071	0.81908	0.93680
atdothmdkr15_5	1.95	1.716	12.55	8.401	na	13.45802	40.972	1.764	29.73131	0.81039	0.00082	0.81203	0.93680
atdothmdkr15_6	1.95	1.716	12.55	8.401	na	13.45802	51.214	2.205	31.82781	0.80415	0.00070	0.80555	0.93680
Saturated UO_2-Th at 1.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g) to none													
atdothmdkr10_1	1.35	1.188	8.30	8.801	na	13.45069	0	0	na	0.92675	0.00071	0.92817	0.93680
atdothmdkr10_2	1.35	1.188	8.30	8.801	na	13.45069	10.243	0.441	20.32345	0.84920	0.00100	0.85120	0.93680
atdothmdkr10_3	1.35	1.188	8.30	8.801	na	13.45069	20.486	0.882	24.30362	0.82735	0.00086	0.82907	0.93680
atdothmdkr10_4	1.35	1.188	8.30	8.801	na	13.45069	30.729	1.323	27.28647	0.81471	0.00095	0.81661	0.93680
atdothmdkr10_5	1.35	1.188	8.30	8.801	na	13.45069	40.972	1.764	29.72981	0.80635	0.00080	0.80795	0.93680
atdothmdkr10_6	1.35	1.188	8.30	8.801	na	13.45069	51.214	2.205	31.82650	0.80245	0.00083	0.80411	0.93680

Table 6.9.10.9-8. Results for HEU oxide/thorium metal content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Compromised package, HEU-poly core in sph. config., wet (bound plus 15-lb free water) Kaolite shell, 20.0-cm water reflector (Model 3)													
Saturated UO_2-Th at 5.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdothm15kr50_1	11.00	9.682	4.20	1.674	na	9.49304	0	0	na	0.85054	0.00085	0.85224	0.93520
atdothm15kr50_2	11.00	9.682	4.20	1.674	na	9.49304	10.243	1.802	18.96060	0.72270	0.00074	0.72418	0.93520
atdothm15kr50_3	11.00	9.682	4.20	1.674	na	9.49304	20.486	3.604	23.37830	0.69600	0.00076	0.69752	0.93520
atdothm15kr50_4	11.00	9.682	4.20	1.674	na	9.49304	30.729	5.405	26.56086	0.68356	0.00074	0.68504	0.93520
atdothm15kr50_5	11.00	9.682	4.20	1.674	na	9.49304	40.972	7.207	29.12235	0.67540	0.00070	0.67680	0.93520
atdothm15kr50_6	11.00	9.682	4.20	1.674	na	9.49304	51.214	9.009	31.29849	0.67033	0.00070	0.67173	0.93520
Saturated UO_2-Th at 4.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdothm15kr40_1	11.00	9.682	4.20	2.433	na	10.12161	0	0	na	0.89206	0.00080	0.89366	0.93520
atdothm15kr40_2	11.00	9.682	4.20	2.433	na	10.12161	10.243	1.802	19.12736	0.77428	0.00072	0.77572	0.93520
atdothm15kr40_3	11.00	9.682	4.20	2.433	na	10.12161	20.486	3.604	23.48843	0.74642	0.00082	0.74806	0.93520
atdothm15kr40_4	11.00	9.682	4.20	2.433	na	10.12161	30.729	5.405	26.64632	0.73482	0.00075	0.73632	0.93520
atdothm15kr40_5	11.00	9.682	4.20	2.433	na	10.12161	40.972	7.207	29.19349	0.72592	0.00071	0.72734	0.93520
atdothm15kr40_6	11.00	9.682	4.20	2.433	na	10.12161	51.214	9.009	31.36011	0.72219	0.00064	0.72347	0.93520
Saturated UO_2-Th at 3.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdothm15kr30_1	9.35	8.230	5.85	3.707	na	11.02288	0	0	na	0.93266	0.00077	0.93420	0.93520
atdothm15kr30_2	9.35	8.230	5.85	3.707	na	11.02288	10.243	1.802	19.39900	0.82562	0.00090	0.82742	0.93520
atdothm15kr30_3	9.35	8.230	5.85	3.707	na	11.02288	20.486	3.604	23.66974	0.79815	0.00081	0.79977	0.93520
atdothm15kr30_4	9.35	8.230	5.85	3.707	na	11.02288	30.729	5.405	26.78753	0.78330	0.00072	0.78474	0.93520
atdothm15kr30_5	9.35	8.230	5.85	3.707	na	11.02288	40.972	7.207	29.31129	0.77619	0.00075	0.77769	0.93520
atdothm15kr30_6	9.35	8.230	5.85	3.707	na	11.02288	51.214	9.009	31.46227	0.77050	0.00100	0.77250	0.93520
Saturated UO_2-Th at 2.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdothm15kr_1	3.10	2.729	12.10	6.272	na	12.48074	0	0	na	0.93452	0.00075	0.93602	0.93680
atdothm15kr_2	3.10	2.729	12.10	6.272	na	12.48074	10.243	1.802	19.92056	0.84234	0.00077	0.84388	0.93680

Table 6.9.10.9-8. Results for HEU oxide/thorium metal content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
atdothm15kr_3	3.10	2.729	12.10	6.272	na	12.48074	20.486	3.604	24.02423	0.81663	0.00086	0.81835	0.93680
atdothm15kr_4	3.10	2.729	12.10	6.272	na	12.48074	30.729	5.405	27.06558	0.80446	0.00077	0.80600	0.93680
atdothm15kr_5	3.10	2.729	12.10	6.272	na	12.48074	40.972	7.207	29.54408	0.79497	0.00071	0.79639	0.93680
atdothm15kr_6	3.10	2.729	12.10	6.272	na	12.48074	51.214	9.009	31.66462	0.79225	0.00093	0.79411	0.93680
Saturated UO_2-Th at 1.5 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdothm15kr15_1	1.95	1.716	12.55	8.401	na	13.45802	0	0	na	0.93399	0.00095	0.93589	0.93680
atdothm15kr15_2	1.95	1.716	12.55	8.401	na	13.45802	10.243	1.802	20.32666	0.85770	0.00100	0.85970	0.93680
atdothm15kr15_3	1.95	1.716	12.55	8.401	na	13.45802	20.486	3.604	24.30586	0.83787	0.00082	0.83951	0.93680
atdothm15kr15_4	1.95	1.716	12.55	8.401	na	13.45802	30.729	5.405	27.28825	0.82541	0.00079	0.82699	0.93680
atdothm15kr15_5	1.95	1.716	12.55	8.401	na	13.45802	40.972	7.207	29.73131	0.81859	0.00078	0.82015	0.93680
atdothm15kr15_6	1.95	1.716	12.55	8.401	na	13.45802	51.214	9.009	31.82781	0.81225	0.00086	0.81397	0.93680
Saturated UO_2-Th at 1.0 g/cm^3, Kaolite from full amount in the packaging (53,419.1 g plus 6803.9 g water) to none													
atdothm15kr10_1	1.35	1.188	8.30	8.801	na	13.45069	0	0	na	0.92675	0.00071	0.92817	0.93680
atdothm15kr10_2	1.35	1.188	8.30	8.801	na	13.45069	10.243	1.802	20.32345	0.85320	0.00082	0.85484	0.93680
atdothm15kr10_3	1.35	1.188	8.30	8.801	na	13.45069	20.486	3.604	24.30362	0.83203	0.00072	0.83347	0.93680
atdothm15kr10_4	1.35	1.188	8.30	8.801	na	13.45069	30.729	5.405	27.28647	0.82305	0.00075	0.82455	0.93680
atdothm15kr10_5	1.35	1.188	8.30	8.801	na	13.45069	40.972	7.207	29.72981	0.81533	0.00092	0.81717	0.93680
atdothm15kr10_6	1.35	1.188	8.30	8.801	na	13.45069	51.214	9.009	31.82650	0.81331	0.00071	0.81473	0.93680
Compromised package, homogeneous fixed-radius core [HEU, poly, wet Kaolite], 20.0-cm water reflector (Model 4)													
Saturated UO_2-Th at 5.0 g/cm^3													
athothmp15kr50_1	11.00	9.682	4.20	3.879	51.214	31.29850	na	na	na	0.53892	0.00058	0.54008	0.93680
athothmp15kr50_2	11.00	9.682	4.20	5.580	51.214	31.29850	na	na	na	0.56025	0.00066	0.56157	0.93680
athothmp15kr50_3	11.00	9.682	4.20	7.281	51.214	31.29850	na	na	na	0.58402	0.00080	0.58562	0.93680
athothmp15kr50_4	11.00	9.682	4.20	8.982	51.214	31.29850	na	na	na	0.60619	0.00066	0.60751	0.93680
athothmp15kr50_5	11.00	9.682	4.20	10.683	51.214	31.29850	na	na	na	0.63124	0.00071	0.63266	0.93680

Table 6.9.10.9-8. Results for HEU oxide/thorium metal content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2-Th at 4.0 g/cm^3													
athothmp15kr40_1	11.00	9.682	4.20	4.638	51.214	31.36011	na	na	na	0.54707	0.00070	0.54847	0.93680
athothmp15kr40_2	11.00	9.682	4.20	6.339	51.214	31.36011	na	na	na	0.56955	0.00076	0.57107	0.93680
athothmp15kr40_3	11.00	9.682	4.20	8.040	51.214	31.36011	na	na	na	0.59378	0.00079	0.59536	0.93680
athothmp15kr40_4	11.00	9.682	4.20	9.741	51.214	31.36011	na	na	na	0.61666	0.00074	0.61814	0.93680
athothmp15kr40_5	11.00	9.682	4.20	11.442	51.214	31.36011	na	na	na	0.63998	0.00069	0.64136	0.93680
Saturated UO_2-Th at 3.0 g/cm^3													
athothmp15kr30_1	9.35	8.230	5.85	5.912	51.214	31.46227	na	na	na	0.54982	0.00061	0.55104	0.93680
athothmp15kr30_2	9.35	8.230	5.85	7.613	51.214	31.46227	na	na	na	0.57303	0.00067	0.57437	0.93680
athothmp15kr30_3	9.35	8.230	5.85	9.314	51.214	31.46227	na	na	na	0.59518	0.00063	0.59644	0.93680
athothmp15kr30_4	9.35	8.230	5.85	11.015	51.214	31.46227	na	na	na	0.61849	0.00075	0.61999	0.93680
athothmp15kr30_5	9.35	8.230	5.85	12.715	51.214	31.46227	na	na	na	0.64234	0.00070	0.64374	0.93680
Saturated UO_2-Th at 2.0 g/cm^3													
athothmp15kr_1	3.10	2.729	12.10	8.476	51.214	31.66463	na	na	na	0.46846	0.00055	0.46956	0.93680
athothmp15kr_2	3.10	2.729	12.10	10.177	51.214	31.66463	na	na	na	0.48668	0.00057	0.48782	0.93680
athothmp15kr_3	3.10	2.729	12.10	11.878	51.214	31.66463	na	na	na	0.50502	0.00057	0.50616	0.93680
athothmp15kr_4	3.10	2.729	12.10	13.579	51.214	31.66463	na	na	na	0.52431	0.00061	0.52553	0.93680
athothmp15kr_5	3.10	2.729	12.10	15.280	51.214	31.66463	na	na	na	0.54412	0.00054	0.54520	0.93680
Saturated UO_2-Th at 1.5 g/cm^3													
athothmp15kr15_1	1.95	1.716	12.55	10.606	51.214	31.82781	na	na	na	0.42579	0.00050	0.42679	0.93680
athothmp15kr15_2	1.95	1.716	12.55	12.307	51.214	31.82781	na	na	na	0.44187	0.00046	0.44279	0.93680
athothmp15kr15_3	1.95	1.716	12.55	14.008	51.214	31.82781	na	na	na	0.45834	0.00049	0.45932	0.93680
athothmp15kr15_4	1.95	1.716	12.55	15.709	51.214	31.82781	na	na	na	0.47470	0.00058	0.47586	0.93680
athothmp15kr15_5	1.95	1.716	12.55	17.410	51.214	31.82781	na	na	na	0.48989	0.00065	0.49119	0.93680

Table 6.9.10.9-8. Results for HEU oxide/thorium metal content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2-Th at 1.0 g/cm^3													
athothmp15kr10_1	1.35	1.188	8.30	11.006	51.214	31.82650	na	na	na	0.38290	0.00045	0.38380	0.93680
athothmp15kr10_2	1.35	1.188	8.30	12.707	51.214	31.82650	na	na	na	0.39718	0.00047	0.39812	0.93680
athothmp15kr10_3	1.35	1.188	8.30	14.408	51.214	31.82650	na	na	na	0.41217	0.00048	0.41313	0.93680
athothmp15kr10_4	1.35	1.188	8.30	16.109	51.214	31.82650	na	na	na	0.42509	0.00042	0.42593	0.93680
athothmp15kr10_5	1.35	1.188	8.30	17.810	51.214	31.82650	na	na	na	0.43898	0.00055	0.44008	0.93680
Compromised package, homogeneous core [HEU, poly, free water from wet Kaolite], wet Kaolite shell, 20.0 cm water reflector (Model 5)													
Saturated UO_2-Th at 5.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb													
athothmpw12kr50_1_1_5	8.00	7.042	0.00	6.311	na	12.19423	51.215	2.205	31.62107	0.92732	0.00075	0.92882	0.93520
athothmpw12kr50_2_1_5	8.00	7.042	1.00	6.425	na	12.30034	51.215	2.205	31.63697	0.92100	0.00085	0.92270	0.93520
athothmpw12kr50_7_1_5	8.00	7.042	7.20	7.134	na	12.92072	51.215	2.205	31.73526	0.90092	0.00083	0.90258	0.93520
athothmpw12kr50_1_2_5	8.60	7.57	0.00	6.376	na	12.25812	51.215	2.205	31.63061	0.93340	0.00100	0.93540	0.93520
athothmpw12kr50_1_2_4	8.60	7.57	0.00	5.015	na	11.48905	51.215	3.565	31.52183	0.87666	0.00092	0.87850	0.93520
athothmpw12kr50_1_2_3	8.60	7.57	0.00	3.655	na	10.60038	51.215	4.926	31.41229	0.81143	0.00078	0.81299	0.93520
athothmpw12kr50_1_2_2	8.60	7.57	0.00	2.294	na	9.53085	51.215	6.286	31.30198	0.72917	0.00074	0.73065	0.93520
athothmpw12kr50_1_2_1	8.60	7.57	0.00	0.934	na	8.14509	51.215	7.647	31.19089	0.62664	0.00075	0.62814	0.93520
athothmpw12kr50_2_2_5	8.60	7.57	1.00	6.490	na	12.36313	51.215	2.205	31.64651	0.92511	0.00097	0.92705	0.93520
athothmpw12kr50_3_2_5	8.60	7.57	2.00	6.604	na	12.46639	51.215	2.205	31.66240	0.91963	0.00093	0.92149	0.93520
athothmpw12kr50_4_2_5	8.60	7.57	4.00	6.833	na	12.66794	51.215	2.205	31.69412	0.91117	0.00094	0.91305	0.93520
athothmpw12kr50_6_2_5	8.60	7.57	6.60	7.130	na	12.92072	51.215	2.205	31.73526	0.90744	0.00091	0.90926	0.93520
athothmpw12kr50_1_3_5	9.00	7.922	0.00	6.419	na	12.30034	51.215	2.205	31.63698	0.93570	0.00100	0.93770	0.93520
athothmpw12kr50_5_3_5	9.00	8.802	6.20	7.128	na	12.92072	51.215	2.205	31.73526	0.91216	0.00090	0.91396	0.93520
Saturated UO_2-Th at 4.0 g-cm^3, maximum free water in wet Kaolite limited to 12 lb													
athothmpw12kr40_1_1_5	6.00	5.281	0.00	6.393	na	12.14048	51.215	2.205	31.61311	0.92459	0.00093	0.92645	0.93520
athothmpw12kr40_2_1_5	6.00	5.281	1.00	6.557	na	12.27398	51.215	2.205	31.63300	0.91610	0.00100	0.91810	0.93520

Table 6.9.10.9-8. Results for HEU oxide/thorium metal content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athothmpw12kr40_3_1_5	6.00	5.281	2.00	6.721	na	12.40464	51.215	2.205	31.65287	0.91199	0.00082	0.91363	0.93520
athothmpw12kr40_8_1_5	6.00	5.281	9.20	7.904	na	13.27328	51.215	2.205	31.79520	0.90454	0.00072	0.90598	0.93520
athothmpw12kr40_1_2_5	6.85	6.029	0.00	6.528	na	12.25414	51.215	2.205	31.63002	0.93332	0.00073	0.93478	0.93520
athothmpw12kr40_1_2_4	6.85	6.029	0.00	5.167	na	11.48452	51.215	3.565	31.52123	0.87850	0.00093	0.88036	0.93520
athothmpw12kr40_1_2_3	6.85	6.029	0.00	3.807	na	10.59507	51.215	4.926	31.41169	0.81031	0.00082	0.81195	0.93520
athothmpw12kr40_1_2_2	6.85	6.029	0.00	2.446	na	9.52428	51.215	6.286	31.30137	0.72450	0.00081	0.72612	0.93520
athothmpw12kr40_1_2_1	6.85	6.029	0.00	1.086	na	8.13609	51.215	7.647	31.19028	0.61892	0.00064	0.62020	0.93520
athothmpw12kr40_3_2_5	6.85	6.029	2.00	6.856	na	12.51358	51.215	2.205	31.66974	0.92166	0.00082	0.92330	0.93520
athothmpw12kr40_4_2_5	6.85	6.029	4.00	7.185	na	12.76268	51.215	2.205	31.70936	0.91666	0.00076	0.91818	0.93520
athothmpw12kr40_5_2_5	6.85	6.029	6.00	7.513	na	13.00242	51.215	2.205	31.74888	0.91481	0.00091	0.91663	0.93520
athothmpw12kr40_7_2_5	6.85	6.029	8.35	7.899	na	13.27328	51.215	2.205	31.79520	0.91411	0.00091	0.91593	0.93520
athothmpw12kr40_1_3_5	7.00	6.161	0.00	6.551	na	12.27398	51.215	2.205	31.63300	0.93250	0.00096	0.93442	0.93520
athothmpw12kr40_6_3_5	7.00	7.042	8.20	7.898	na	13.27328	51.215	2.205	31.79520	0.91642	0.00077	0.91796	0.93520
Saturated UO_2-Th at 3.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb													
athothmpw12kr30_1_1_5	5.00	4.401	0.00	6.650	na	12.22981	51.215	2.205	31.62637	0.92870	0.00100	0.93070	0.93680
athothmpw12kr30_2_1_5	5.00	4.401	2.00	7.145	na	12.57469	51.215	2.205	31.67932	0.92203	0.00087	0.92377	0.93680
athothmpw12kr30_3_1_5	5.00	4.401	4.00	7.640	na	12.90162	51.215	2.205	31.73210	0.92145	0.00099	0.92343	0.93680
athothmpw12kr30_4_1_5	5.00	4.401	6.00	8.135	na	13.21278	51.215	2.205	31.78470	0.92300	0.00090	0.92480	0.93680
athothmpw12kr30_5_1_5	5.00	4.401	8.00	8.630	na	13.50993	51.215	2.205	31.83712	0.92666	0.00094	0.92854	0.93680
athothmpw12kr30_8_1_5	5.00	4.401	10.20	9.174	na	13.82238	51.215	2.205	31.89459	0.92730	0.00100	0.92930	0.93680
athothmpw12kr30_1_2_5	5.30	4.665	0.00	6.723	na	12.28278	51.215	2.205	31.63432	0.93418	0.00088	0.93594	0.93680
athothmpw12kr30_1_2_4	5.30	4.665	0.00	5.362	na	11.51711	51.215	3.565	31.52557	0.87665	0.00079	0.87823	0.93520
athothmpw12kr30_1_2_3	5.30	4.665	0.00	4.002	na	10.63333	51.215	4.926	31.41605	0.80988	0.00094	0.81176	0.93520
athothmpw12kr30_1_2_2	5.30	4.665	0.00	2.641	na	9.57156	51.215	6.286	31.30577	0.72636	0.00096	0.72828	0.93520
athothmpw12kr30_1_2_1	5.30	4.665	0.00	1.281	na	8.20069	51.215	7.647	31.19471	0.61679	0.00090	0.61859	0.93520
athothmpw12kr30_2_2_5	5.30	4.665	2.00	7.218	na	12.62481	51.215	2.205	31.68725	0.92680	0.00091	0.92862	0.93680

Table 6.9.10.9-8. Results for HEU oxide/thorium metal content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
athothmpw12kr30_3_2_5	5.30	4.665	4.00	7.713	na	12.94925	51.215	2.205	31.74000	0.92624	0.00073	0.92770	0.93680
athothmpw12kr30_4_2_5	5.30	4.665	6.00	8.207	na	13.2582	51.215	2.205	31.79257	0.92820	0.00087	0.92994	0.93680
athothmpw12kr30_5_2_5	5.30	4.665	8.00	8.702	na	13.55339	51.215	2.205	31.84497	0.92968	0.00095	0.93158	0.93680
athothmpw12kr30_7_2_5	5.30	4.665	9.90	9.172	na	13.82238	51.215	2.205	31.89459	0.93133	0.00089	0.93311	0.93680
athothmpw12kr30_1_3_5	6.00	5.281	1.00	6.892	na	12.40464	51.215	2.205	31.65287	0.93974	0.00096	0.94166	0.93520
athothmpw12kr30_6_3_5	6.00	5.281	9.20	9.168	na	13.82238	51.215	2.205	31.89459	0.94255	0.00080	0.94415	0.93680
Saturated UO_2-Th at 2.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb													
athothmpw12kr_1_1_5	2.50	2.201	0.00	6.462	na	12.00398	51.215	2.205	31.59319	0.89440	0.00110	0.89660	0.93680
athothmpw12kr_2_1_5	2.50	2.201	2.00	7.290	na	12.53261	51.215	2.205	31.67271	0.89190	0.00110	0.89410	0.93680
athothmpw12kr_3_1_5	2.50	2.201	4.00	8.117	na	13.02005	51.215	2.205	31.75184	0.89618	0.00092	0.89802	0.93680
athothmpw12kr_4_1_5	2.50	2.201	10.00	9.773	na	13.89832	51.215	2.205	31.90893	0.90236	0.00073	0.90382	0.93680
athothmpw12kr_5_1_5	2.50	2.201	12.00	10.600	na	14.29865	51.215	2.205	31.98689	0.90855	0.00080	0.91015	0.93680
athothmpw12kr_8_1_5	2.50	2.201	12.70	11.717	na	14.8059	51.215	2.205	32.09155	0.91075	0.00076	0.91227	0.93680
athothmpw12kr_1_2_5	2.90	2.553	0.00	6.625	na	12.11343	51.215	2.205	31.60912	0.90838	0.00086	0.91010	0.93680
athothmpw12kr_1_2_4	2.90	2.553	0.00	5.265	na	11.32391	51.215	3.565	31.50019	0.85392	0.00085	0.85562	0.93680
athothmpw12kr_1_2_3	2.90	2.553	0.00	3.904	na	10.40561	51.215	4.926	31.39050	0.78571	0.00091	0.78753	0.93680
athothmpw12kr_1_2_2	2.90	2.553	0.00	2.544	na	9.2882	51.215	6.286	31.28004	0.69541	0.00079	0.69699	0.93520
athothmpw12kr_1_2_1	2.90	2.553	0.00	1.183	na	7.80743	51.215	7.647	31.16879	0.57328	0.00076	0.57480	0.93520
athothmpw12kr_2_2_5	2.90	2.553	2.00	7.453	na	12.63313	51.215	2.205	31.68857	0.90967	0.00074	0.91115	0.93680
athothmpw12kr_3_2_5	2.90	2.553	4.00	8.281	na	13.11327	51.215	2.205	31.76762	0.91271	0.00080	0.91431	0.93680
athothmpw12kr_4_2_5	2.90	2.553	8.00	9.936	na	13.98023	51.215	2.205	31.92455	0.92279	0.00088	0.92455	0.93680
athothmpw12kr_5_2_5	2.90	2.553	10.00	10.763	na	14.37608	51.215	2.205	32.00244	0.92883	0.00090	0.93063	0.93680
athothmpw12kr_7_2_5	2.90	2.553	12.30	11.715	na	14.8059	51.215	2.205	32.09155	0.93239	0.00084	0.93407	0.93680
athothmpw12kr_1_3_5	3.00	2.641	0.00	6.666	na	12.14048	51.215	2.205	31.61311	0.91006	0.00099	0.91204	0.93680
athothmpw12kr_6_3_5	3.00	2.641	12.20	11.714	na	14.8059	51.215	2.205	32.09155	0.93478	0.00099	0.93676	0.93680

Table 6.9.10.9-8. Results for HEU oxide/thorium metal content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2-Th at 1.5 g/cm^3, maximum free water in wet Kaolite limited to 12 lb													
athothmpw12kr15_1_1_5	2.00	1.76	0.00	6.591	na	12.04982	51.215	2.205	31.59983	0.88600	0.00110	0.88820	0.93680
athothmpw12kr15_2_1_5	2.00	1.76	2.00	7.751	na	12.74025	51.215	2.205	31.70573	0.89230	0.00100	0.89430	0.93680
athothmpw12kr15_3_1_5	2.00	1.76	4.00	8.912	na	13.36301	51.215	2.205	31.81093	0.89845	0.00075	0.89995	0.93680
athothmpw12kr15_4_1_5	2.00	1.76	6.00	10.072	na	13.93257	51.215	2.205	31.91544	0.90383	0.00086	0.90555	0.93680
athothmpw12kr15_5_1_5	2.00	1.76	8.00	11.232	na	14.45902	51.215	2.205	32.01927	0.90959	0.00092	0.91143	0.93680
athothmpw12kr15_6_1_5	2.00	1.76	10.00	12.392	na	14.9497	51.215	2.205	32.12243	0.91209	0.00078	0.91365	0.93680
athothmpw12kr15_7_1_5	2.00	1.76	12.00	13.553	na	15.41012	51.215	2.205	32.22493	0.91348	0.00089	0.91526	0.93680
athothmpw12kr15_9_1_5	2.00	1.76	12.50	13.843	na	15.52102	51.215	2.205	32.25045	0.91282	0.00074	0.91430	0.93680
athothmpw12kr15_2_2_5	2.25	1.981	0.00	6.735	na	12.14048	51.215	2.205	31.61311	0.89837	0.00087	0.90011	0.93680
athothmpw12kr15_2_2_4	2.25	1.981	0.00	5.374	na	11.35486	51.215	3.565	31.50420	0.84758	0.00084	0.84926	0.93680
athothmpw12kr15_2_2_3	2.25	1.981	0.00	4.013	na	10.44223	51.215	4.926	31.39454	0.78275	0.00093	0.78461	0.93680
athothmpw12kr15_2_2_2	2.25	1.981	0.00	2.653	na	9.33409	51.215	6.286	31.28410	0.69370	0.00081	0.69532	0.93680
athothmpw12kr15_2_2_1	2.25	1.981	0.00	1.292	na	7.87217	51.215	7.647	31.17288	0.57225	0.00079	0.57383	0.93520
athothmpw12kr15_2_2_5	2.25	1.981	2.00	7.895	na	12.82144	51.215	2.205	31.71892	0.90399	0.00090	0.90579	0.93680
athothmpw12kr15_3_2_5	2.25	1.981	4.00	9.055	na	13.43687	51.215	2.205	31.82403	0.91242	0.00097	0.91436	0.93680
athothmpw12kr15_4_2_5	2.25	1.981	6.00	10.215	na	14.00056	51.215	2.205	31.92846	0.92127	0.00092	0.92311	0.93680
athothmpw12kr15_5_2_5	2.25	1.981	8.00	11.376	na	14.52218	51.215	2.205	32.03220	0.92767	0.00079	0.92925	0.93680
athothmpw12kr15_6_2_5	2.25	1.981	10.00	12.536	na	15.00881	51.215	2.205	32.13528	0.93118	0.00096	0.93310	0.93680
athothmpw12kr15_8_2_5	2.25	1.981	12.25	13.841	na	15.52102	51.215	2.205	32.25045	0.93363	0.00071	0.93505	0.93680
athothmpw12kr15_1_3_5	2.50	2.201	0.00	6.878	na	12.22981	51.215	2.205	31.62637	0.90965	0.00086	0.91137	0.93680
athothmpw12kr15_7_3_5	2.50	2.201	12.00	13.840	na	15.52102	51.215	2.205	32.25045	0.95186	0.00090	0.95366	0.93680

Table 6.9.10.9-8. Results for HEU oxide/thorium metal content for air transportation (Models 1–5)

Case	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Kaolite (kg)	H_2O (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Saturated UO_2-Th at 1.0 g/cm^3, maximum free water in wet Kaolite limited to 12 lb													
athothmpw12kr10_1_1_5	1.50	1.32	0.00	6.803	na	12.14048	51.215	2.205	31.61311	0.87044	0.00085	0.87214	0.93680
athothmpw12kr10_2_1_5	1.50	1.32	2.00	8.629	na	13.13637	51.215	2.205	31.77156	0.88631	0.00083	0.88797	0.93680
athothmpw12kr10_3_1_5	1.50	1.32	4.00	10.454	na	14.00056	51.215	2.205	31.92846	0.89751	0.00094	0.89939	0.93680
athothmpw12kr10_4_1_5	1.50	1.32	6.00	12.280	na	14.76951	51.215	2.205	32.08382	0.90278	0.00079	0.90436	0.93680
athothmpw12kr10_7_1_5	1.50	1.32	8.15	14.243	na	15.51552	51.215	2.205	32.24918	0.90550	0.00097	0.90744	0.93680
athothmpw12kr10_1_2_5	1.75	1.540	0.00	7.030	na	12.27399	51.215	2.205	31.63300	0.89086	0.00096	0.89278	0.93680
athothmpw12kr10_1_2_4	1.75	1.540	0.00	5.669	na	11.50711	51.215	3.565	31.52423	0.84473	0.00098	0.84669	0.93680
athothmpw12kr10_1_2_3	1.75	1.540	0.00	4.309	na	10.62159	51.215	4.926	31.41471	0.78437	0.00094	0.78625	0.93680
athothmpw12kr10_1_2_2	1.75	1.540	0.00	2.948	na	9.55707	51.215	6.286	31.30442	0.70690	0.00100	0.70890	0.93680
athothmpw12kr10_1_2_1	1.75	1.540	0.00	1.588	na	8.18093	51.215	7.647	31.19334	0.59341	0.00080	0.59501	0.93520
athothmpw12kr10_2_2_5	1.75	1.540	2.00	8.855	na	13.25065	51.215	2.205	31.79126	0.90797	0.00086	0.90969	0.93680
athothmpw12kr10_3_2_5	1.75	1.540	4.00	10.681	na	14.10133	51.215	2.205	31.94796	0.92231	0.00089	0.92409	0.93680
athothmpw12kr10_4_2_5	1.75	1.540	6.00	12.507	na	14.86015	51.215	2.205	32.10314	0.93140	0.00097	0.93334	0.93680
athothmpw12kr10_6_2_5	1.75	1.540	7.90	14.241	na	15.51552	51.215	2.205	32.24918	0.93490	0.00079	0.93648	0.93680
athothmpw12kr10_1_3_5	2.00	1.760	0.00	7.256	na	12.40465	51.215	2.205	31.65287	0.90713	0.00090	0.90893	0.93680
athothmpw12kr10_5_3_5	2.00	1.760	7.65	14.240	na	15.51552	51.215	2.205	32.24918	0.95794	0.00079	0.95952	0.93680

Table 6.9.10.9-9. Results for HEU oxide and thorium metal content for air transportation (Model 6)

Case 5athothp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
Compromised package, homogeneous core [HEU, poly, wet Kaolite, sat moisture from oxide], dry oxide shell, 20.0 cm water reflector Saturated UO_2-Th at 5.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
50_5_6_6	10.00	8.802	4.20	10.683	51.215	31.99956	1.00	0.880	32.01519	0.63497	0.00074	0.63645	0.93680
50_4_6_6	10.00	8.802	4.20	8.982	51.215	31.86658	1.00	0.880	31.88234	0.61309	0.00065	0.61439	0.93680
50_3_6_6	10.00	8.802	4.20	7.281	51.215	31.73248	1.00	0.880	31.74838	0.59113	0.00069	0.59251	0.93680
50_2_6_6	10.00	8.802	4.20	5.580	51.215	31.59724	1.00	0.880	31.61327	0.56978	0.00061	0.57100	0.93680
50_1_6_6	10.00	8.802	4.20	3.879	51.215	31.46083	1.00	0.880	31.477	0.54733	0.00073	0.54879	0.93680
50_5_5_5	8.00	7.042	4.20	10.683	51.215	31.96844	3.00	2.640	32.01519	0.64968	0.00072	0.65112	0.93680
50_4_5_5	8.00	7.042	4.20	8.982	51.215	31.83520	3.00	2.640	31.88234	0.62669	0.00064	0.62797	0.93680
50_3_5_5	8.00	7.042	4.20	7.281	51.215	31.70084	3.00	2.640	31.74838	0.60519	0.00068	0.60655	0.93680
50_2_5_5	8.00	7.042	4.20	5.580	51.215	31.61327	3.00	2.640	31.61327	0.58130	0.00062	0.58254	0.93680
50_1_5_5	8.00	7.042	4.20	3.879	51.215	31.42864	3.00	2.641	31.477	0.55962	0.00059	0.56080	0.93680
50_5_4_4	6.00	5.281	4.20	10.683	51.215	31.93727	5.00	4.401	32.01519	0.65634	0.00067	0.65768	0.93680
50_4_4_4	6.00	5.281	4.20	8.982	51.215	31.80376	5.00	4.401	31.88234	0.63442	0.00061	0.63564	0.93680
50_3_4_4	6.00	5.281	4.20	7.281	51.215	31.66913	5.00	4.401	31.74838	0.61212	0.00069	0.61350	0.93680
50_2_4_4	6.00	5.281	4.20	5.580	51.215	31.53334	5.00	4.401	31.61327	0.59067	0.00067	0.59201	0.93680
50_1_4_4	6.00	5.281	4.20	3.879	51.215	31.39638	5.00	4.401	31.477	0.56683	0.00064	0.56811	0.93680
50_5_3_3	5.00	4.401	4.20	10.683	51.215	31.92165	6.00	5.281	32.01519	0.65749	0.00072	0.65893	0.93680
50_4_3_3	5.00	4.401	4.20	8.982	51.215	31.78802	6.00	5.281	31.88234	0.63679	0.00064	0.63807	0.93680
50_3_3_3	5.00	4.401	4.20	7.281	51.215	31.65325	6.00	5.281	31.74838	0.61426	0.00063	0.61552	0.93680
50_2_3_3	5.00	4.401	4.20	5.580	51.215	31.51733	6.00	5.281	31.61327	0.59182	0.00068	0.59318	0.93680
50_1_3_3	5.00	4.401	4.20	3.879	51.215	31.38022	6.00	5.281	31.477	0.56993	0.00067	0.57127	0.93680
50_5_2_2	3.00	2.640	4.20	10.683	51.215	31.89039	8.00	7.042	32.01519	0.65847	0.00066	0.65979	0.93680
50_4_2_2	3.00	2.640	4.20	8.982	51.215	31.75649	8.00	7.042	31.88234	0.63916	0.00066	0.64048	0.93680
50_3_2_2	3.00	2.640	4.20	7.281	51.215	31.62145	8.00	7.042	31.74838	0.61668	0.00066	0.61800	0.93680

Table 6.9.10.9-9. Results for HEU oxide and thorium metal content for air transportation (Model 6)

Case 5athothp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
50_2_2_2	3.00	2.640	4.20	5.580	51.215	31.48525	8.00	7.042	31.61327	0.59654	0.00062	0.59778	0.93680
50_1_2_2	3.00	2.640	4.20	3.879	51.215	31.34787	8.00	7.042	31.477	0.57389	0.00062	0.57513	0.93680
50_5_1_1	1.00	0.880	4.20	10.683	51.215	31.85906	10.00	8.802	32.01519	0.65070	0.00065	0.65200	0.93680
50_4_1_1	1.00	0.880	4.20	8.982	51.215	31.72489	10.00	8.802	31.88234	0.63401	0.00067	0.63535	0.93680
50_3_1_1	1.00	0.880	4.20	7.281	51.215	31.58959	10.00	8.802	31.74838	0.61614	0.00062	0.61738	0.93680
50_2_1_1	1.00	0.880	4.20	5.580	51.215	31.45311	10.00	8.802	31.61327	0.59681	0.00063	0.59807	0.93680
50_1_1_1	1.00	0.880	4.20	3.879	51.215	31.31544	10.00	8.802	31.477	0.57528	0.00059	0.57646	0.93680
Saturated UO_2-Th at 4.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
40_5_6_6	10.00	8.802	4.20	11.442	51.215	32.05464	1.00	0.880	32.07409	0.64576	0.00091	0.64758	0.93680
40_4_6_6	10.00	8.802	4.20	9.741	51.215	31.92212	1.00	0.880	31.94173	0.62329	0.00066	0.62461	0.93680
40_3_6_6	10.00	8.802	4.20	8.040	51.215	31.78849	1.00	0.880	31.80827	0.60168	0.00071	0.60310	0.93680
40_2_6_6	10.00	8.802	4.20	6.339	51.215	31.65373	1.00	0.880	31.67367	0.57896	0.00061	0.58018	0.93680
40_1_6_6	10.00	8.802	4.20	4.638	51.215	31.51781	1.00	0.880	31.53792	0.55676	0.00065	0.55806	0.93680
40_5_5_5	8.00	7.042	4.20	11.442	51.215	32.01587	3.00	2.640	32.07409	0.65815	0.00066	0.65947	0.93680
40_4_5_5	8.00	7.042	4.20	9.741	51.215	31.88303	3.00	2.640	31.94173	0.63750	0.00080	0.63910	0.93680
40_3_5_5	8.00	7.042	4.20	8.040	51.215	31.74907	3.00	2.640	31.80827	0.61533	0.00070	0.61673	0.93680
40_2_5_5	8.00	7.042	4.20	6.339	51.215	31.61397	3.00	2.640	31.67367	0.59196	0.00069	0.59334	0.93680
40_1_5_5	8.00	7.042	4.20	4.638	51.215	31.47770	3.00	2.641	31.53792	0.56852	0.00063	0.56978	0.93680
40_5_4_4	6.00	5.281	4.20	11.442	51.215	31.97700	5.00	4.401	32.07409	0.66570	0.00076	0.66722	0.93680
40_4_4_4	6.00	5.281	4.20	9.741	51.215	31.84384	5.00	4.401	31.94173	0.64333	0.00062	0.64457	0.93680
40_3_4_4	6.00	5.281	4.20	8.040	51.215	31.70955	5.00	4.401	31.80827	0.62116	0.00067	0.62250	0.93680
40_2_4_4	6.00	5.281	4.20	6.339	51.215	31.57411	5.00	4.401	31.67367	0.60024	0.00067	0.60158	0.93680
40_1_4_4	6.00	5.281	4.20	4.638	51.215	31.43750	5.00	4.401	31.53792	0.57681	0.00074	0.57829	0.93680
40_5_3_3	5.00	4.401	4.20	11.442	51.215	31.95754	6.00	5.281	32.07409	0.66777	0.00067	0.66911	0.93680
40_4_3_3	5.00	4.401	4.20	9.741	51.215	31.82421	6.00	5.281	31.94173	0.64607	0.00070	0.64747	0.93680

Table 6.9.10.9-9. Results for HEU oxide and thorium metal content for air transportation (Model 6)

Case 5athothp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
40_3_3_3	5.00	4.401	4.20	8.040	51.215	31.68975	6.00	5.281	31.80827	0.62390	0.00062	0.62514	0.93680
40_2_3_3	5.00	4.401	4.20	6.339	51.215	31.55414	6.00	5.281	31.67367	0.60233	0.00081	0.60395	0.93680
40_1_3_3	5.00	4.401	4.20	4.638	51.215	31.41735	6.00	5.281	31.53792	0.57937	0.00063	0.58063	0.93680
40_5_2_2	3.00	2.640	4.20	11.442	51.215	31.91853	8.00	7.042	32.07409	0.66735	0.00059	0.66853	0.93680
40_4_2_2	3.00	2.640	4.20	9.741	51.215	31.78487	8.00	7.042	31.94173	0.64783	0.00065	0.64913	0.93680
40_3_2_2	3.00	2.640	4.20	8.040	51.215	31.65008	8.00	7.042	31.80827	0.62593	0.00069	0.62731	0.93680
40_2_2_2	3.00	2.640	4.20	6.339	51.215	31.51413	8.00	7.042	31.67367	0.60552	0.00060	0.60672	0.93680
40_1_2_2	3.00	2.640	4.20	4.638	51.215	31.37699	8.00	7.042	31.53792	0.58381	0.00071	0.58523	0.93680
40_5_1_1	1.00	0.880	4.20	11.442	51.215	31.87943	10.00	8.802	32.07409	0.64654	0.00059	0.64772	0.93680
40_4_1_1	1.00	0.880	4.20	9.741	51.215	31.74544	10.00	8.802	31.94173	0.64100	0.00074	0.64248	0.93680
40_3_1_1	1.00	0.880	4.20	8.040	51.215	31.61031	10.00	8.802	31.80827	0.62208	0.00063	0.62334	0.93680
40_2_1_1	1.00	0.880	4.20	6.339	51.215	31.47401	10.00	8.802	31.67367	0.60497	0.00071	0.60639	0.93680
40_1_1_1	1.00	0.880	4.20	4.638	51.215	31.33652	10.00	8.802	31.53792	0.58447	0.00065	0.58577	0.93680
Saturated UO_2-Th at 3.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
30_5_6_6	8.35	7.350	5.85	12.715	51.215	32.14603	1.00	0.880	32.17177	0.64836	0.00068	0.64972	0.93680
30_4_6_6	8.35	7.350	5.85	11.015	51.215	32.01426	1.00	0.880	32.04022	0.62632	0.00066	0.62764	0.93680
30_3_6_6	8.35	7.350	5.85	9.314	51.215	31.88141	1.00	0.880	31.90758	0.60434	0.00067	0.60568	0.93680
30_2_6_6	8.35	7.350	5.85	7.612	51.215	31.74743	1.00	0.880	31.77383	0.58464	0.00066	0.58596	0.93680
30_1_6_6	8.35	7.350	5.85	5.912	51.215	31.61232	1.00	0.880	31.63894	0.56159	0.00071	0.56301	0.93680
30_5_5_5	6.85	6.029	5.85	12.715	51.215	32.10745	2.50	2.201	32.17177	0.65967	0.00066	0.66099	0.93680
30_4_5_5	6.85	6.029	5.85	11.015	51.215	31.97539	2.50	2.201	32.04022	0.63915	0.00066	0.64047	0.93680
30_3_5_5	6.85	6.029	5.85	9.314	51.215	31.84221	2.50	2.201	31.90758	0.61814	0.00064	0.61942	0.93680
30_2_5_5	6.85	6.029	5.85	7.612	51.215	31.70791	2.50	2.201	31.77383	0.59566	0.00061	0.59688	0.93680
30_1_5_5	6.85	6.029	5.85	5.912	51.215	31.57245	2.50	2.201	31.63894	0.57401	0.00065	0.57531	0.93680

Table 6.9.10.9-9. Results for HEU oxide and thorium metal content for air transportation (Model 6)

Case 5athothp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
30_5_4_4	5.35	4.709	5.85	12.715	51.215	32.06883	4.00	3.521	32.17177	0.66779	0.00065	0.66909	0.93680
30_4_4_4	5.35	4.709	5.85	11.015	51.215	31.93643	4.00	3.521	32.04022	0.64528	0.00063	0.64654	0.93680
30_3_4_4	5.35	4.709	5.85	9.314	51.215	31.80292	4.00	3.521	31.90758	0.62351	0.00073	0.62497	0.93680
30_2_4_4	5.35	4.709	5.85	7.612	51.215	31.66828	4.00	3.521	31.77383	0.60135	0.00076	0.60287	0.93680
30_1_4_4	5.35	4.709	5.85	5.912	51.215	31.53249	4.00	3.521	31.63894	0.58009	0.00073	0.58155	0.93680
30_5_3_3	4.00	3.521	5.85	12.715	51.215	32.03397	5.35	4.709	32.17177	0.66820	0.00062	0.66944	0.93680
30_4_3_3	4.00	3.521	5.85	11.015	51.215	31.90128	5.35	4.709	32.04022	0.64782	0.00063	0.64908	0.93680
30_3_3_3	4.00	3.521	5.85	9.314	51.215	31.76748	5.35	4.709	31.90758	0.62798	0.00066	0.62930	0.93680
30_2_3_3	4.00	3.521	5.85	7.612	51.215	31.63254	5.35	4.709	31.77383	0.60484	0.00064	0.60612	0.93680
30_1_3_3	4.00	3.521	5.85	5.912	51.215	31.49643	5.35	4.709	31.63894	0.58328	0.00063	0.58454	0.93680
30_5_2_2	2.50	2.201	5.85	12.715	51.215	31.99515	6.85	6.029	32.17177	0.66642	0.00066	0.66774	0.93680
30_4_2_2	2.50	2.201	5.85	11.015	51.215	31.86214	6.85	6.029	32.04022	0.64771	0.00073	0.64917	0.93680
30_3_2_2	2.50	2.201	5.85	9.314	51.215	31.72800	6.85	6.029	31.90758	0.62768	0.00068	0.62904	0.93680
30_2_2_2	2.50	2.201	5.85	7.612	51.215	31.59272	6.85	6.029	31.77383	0.60824	0.00062	0.60948	0.93680
30_1_2_2	2.50	2.201	5.85	5.912	51.215	31.45627	6.85	6.029	31.63894	0.58604	0.00060	0.58724	0.93680
30_5_1_1	1.00	0.880	5.85	12.715	51.215	31.95624	8.35	7.350	32.17177	0.65420	0.00069	0.65558	0.93680
30_4_1_1	1.00	0.880	5.85	11.015	51.215	31.82290	8.35	7.350	32.04022	0.63810	0.00062	0.63934	0.93680
30_3_1_1	1.00	0.880	5.85	9.314	51.215	31.68843	8.35	7.350	31.90758	0.62137	0.00064	0.62265	0.93680
30_2_1_1	1.00	0.880	5.85	7.612	51.215	31.55281	8.35	7.350	31.77383	0.60535	0.00074	0.60683	0.93680
30_1_1_1	1.00	0.880	5.85	5.912	51.215	31.41601	8.35	7.350	31.63894	0.58464	0.00059	0.58582	0.93680
Saturated UO_2-Th at 2.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
_5_5_5	2.60	2.289	12.10	15.280	51.215	32.34628	0.50	0.440	32.36538	0.55082	0.00070	0.55222	0.93680
_4_5_5	2.60	2.289	12.10	13.579	51.215	32.21615	0.50	0.440	32.23541	0.53547	0.00059	0.53665	0.93680
_3_5_5	2.60	2.289	12.10	11.878	51.215	32.08497	0.50	0.440	32.10438	0.51819	0.00061	0.51941	0.93680

Table 6.9.10.9-9. Results for HEU oxide and thorium metal content for air transportation (Model 6)

Case 5athothp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
_2_5_5	2.60	2.289	12.10	10.177	51.215	31.95270	0.50	0.440	31.97227	0.50129	0.00049	0.50227	0.93680
_1_5_5	2.60	2.289	12.10	8.476	51.215	31.81933	0.50	0.440	31.83906	0.48453	0.00052	0.48557	0.93680
_5_4_4	2.10	1.848	12.10	15.280	51.215	32.32725	1.00	0.880	32.36538	0.55946	0.00059	0.56064	0.93680
_4_4_4	2.10	1.848	12.10	13.579	51.215	32.19697	1.00	0.880	32.23541	0.54332	0.00063	0.54458	0.93680
_3_4_4	2.10	1.848	12.10	11.878	51.215	32.06563	1.00	0.880	32.10438	0.52754	0.00063	0.52880	0.93680
_2_4_4	2.10	1.848	12.10	10.177	51.215	31.93320	1.00	0.880	31.97227	0.51071	0.00056	0.51183	0.93680
_1_4_4	2.10	1.848	12.10	8.476	51.215	31.79967	1.00	0.880	31.83906	0.49376	0.00056	0.49488	0.93680
_5_3_3	1.55	1.364	12.10	15.280	51.215	32.30630	1.55	1.364	32.36538	0.56010	0.00063	0.56136	0.93680
_4_3_3	1.55	1.364	12.10	13.579	51.215	32.17585	1.55	1.364	32.23541	0.54592	0.00056	0.54704	0.93680
_3_3_3	1.55	1.364	12.10	11.878	51.215	32.04433	1.55	1.364	32.10438	0.53083	0.00057	0.53197	0.93680
_2_3_3	1.55	1.364	12.10	10.177	51.215	31.91173	1.55	1.364	31.97227	0.51361	0.00067	0.51495	0.93680
_1_3_3	1.55	1.364	12.10	8.476	51.215	31.77801	1.55	1.364	31.83906	0.49803	0.00063	0.49929	0.93680
_5_2_2	1.00	0.880	12.10	15.280	51.215	32.28532	2.10	1.848	32.36538	0.55064	0.00059	0.55182	0.93680
_4_2_2	1.00	0.880	12.10	13.579	51.215	32.15470	2.10	1.848	32.23541	0.53965	0.00056	0.54077	0.93680
_3_2_2	1.00	0.880	12.10	11.878	51.215	32.02301	2.10	1.848	32.10438	0.52522	0.00071	0.52664	0.93680
_2_2_2	1.00	0.880	12.10	10.177	51.215	31.89022	2.10	1.848	31.97227	0.51140	0.00056	0.51252	0.93680
_1_2_2	1.00	0.880	12.10	8.476	51.215	31.75632	2.10	1.848	31.83906	0.49757	0.00058	0.49873	0.93680
_5_1_1	0.50	0.440	12.10	15.280	51.215	32.26622	2.60	2.289	32.36538	0.53335	0.00057	0.53449	0.93680
_4_1_1	0.50	0.440	12.10	13.579	51.215	32.13544	2.60	2.289	32.23541	0.52410	0.00056	0.52522	0.93680
_3_1_1	0.50	0.440	12.10	11.878	51.215	32.00359	2.60	2.289	32.10438	0.51320	0.00068	0.51456	0.93680
_2_1_1	0.50	0.440	12.10	10.177	51.215	31.87065	2.60	2.289	31.97227	0.50297	0.00062	0.50421	0.93680
_1_1_1	0.50	0.440	12.10	8.476	51.215	31.73658	2.60	2.289	31.83906	0.48955	0.00053	0.49061	0.93680
Saturated UO_2-Th at 1.5 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
15_5_3_3	1.470	1.294	12.55	17.410	51.215	32.49743	0.480	0.423	32.52163	0.49665	0.00050	0.49765	0.93680
15_4_3_3	1.470	1.294	12.55	15.709	51.215	32.36852	0.480	0.423	32.39291	0.48407	0.00050	0.48507	0.93680

Table 6.9.10.9-9. Results for HEU oxide and thorium metal content for air transportation (Model 6)

Case 5athothp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
15_3_3_3	1.470	1.294	12.55	14.008	51.215	32.23858	0.480	0.423	32.26316	0.47163	0.00057	0.47277	0.93680
15_2_3_3	1.470	1.294	12.55	12.307	51.215	32.10757	0.480	0.423	32.13236	0.45857	0.00050	0.45957	0.93680
15_1_3_3	1.470	1.294	12.55	10.606	51.215	31.97549	0.480	0.423	32.00048	0.44402	0.00049	0.44500	0.93680
15_5_2_2	0.975	0.858	12.55	17.410	51.215	32.52163	0.975	0.858	32.52163	0.49584	0.00054	0.49692	0.93680
15_4_2_2	0.975	0.858	12.55	15.709	51.215	32.34344	0.975	0.858	32.39291	0.48553	0.00053	0.48659	0.93680
15_3_2_2	0.975	0.858	12.55	14.008	51.215	32.21329	0.975	0.858	32.26316	0.47383	0.00053	0.47489	0.93680
15_2_2_2	0.975	0.858	12.55	12.307	51.215	32.08208	0.975	0.858	32.13236	0.46204	0.00051	0.46306	0.93680
15_1_2_2	0.975	0.858	12.55	10.606	51.215	31.94979	0.975	0.858	32.00048	0.45073	0.00052	0.45177	0.93680
15_5_1_1	0.480	0.423	12.55	17.410	51.215	32.44763	1.470	1.294	32.52163	0.47570	0.00072	0.47714	0.93680
15_4_1_1	0.480	0.423	12.55	15.709	51.215	32.31832	1.470	1.294	32.39291	0.46879	0.00053	0.46985	0.93680
15_3_1_1	0.480	0.423	12.55	14.008	51.215	32.18796	1.470	1.294	32.26316	0.46125	0.00047	0.46219	0.93680
15_2_1_1	0.480	0.423	12.55	12.307	51.215	32.05654	1.470	1.294	32.13236	0.45264	0.00050	0.45364	0.93680
15_1_1_1	0.480	0.423	12.55	10.606	51.215	31.92404	1.470	1.294	32.00048	0.44280	0.00061	0.44402	0.93680
Saturated UO_2-Th at 1.0 g/cm^3, maximum free water in wet Kaolite limited to 15 lb													
10_5_3_3	1.000	0.880	8.30	17.810	51.215	32.49392	0.350	0.308	32.52037	0.44070	0.00059	0.44188	0.93680
10_4_3_3	1.000	0.880	8.30	16.109	51.215	32.36498	0.350	0.308	32.39164	0.43127	0.00053	0.43233	0.93680
10_3_3_3	1.000	0.880	8.30	14.408	51.215	32.23500	0.350	0.308	32.26188	0.42045	0.00050	0.42145	0.93680
10_2_3_3	1.000	0.880	8.30	12.707	51.215	32.10397	0.350	0.308	32.13107	0.40997	0.00048	0.41093	0.93680
10_1_3_3	1.000	0.880	8.30	11.006	51.215	31.97186	0.350	0.308	31.99918	0.39855	0.00049	0.39953	0.93680
10_5_2_2	0.675	0.594	8.30	17.810	51.215	32.46940	0.675	0.594	32.52037	0.43975	0.00052	0.44079	0.93680
10_4_2_2	0.675	0.594	8.30	16.109	51.215	32.34027	0.675	0.594	32.39164	0.42986	0.00065	0.43116	0.93680
10_3_2_2	0.675	0.594	8.30	14.408	51.215	32.21009	0.675	0.594	32.26188	0.42193	0.00051	0.42295	0.93680
10_2_2_2	0.675	0.594	8.30	12.707	51.215	32.07886	0.675	0.594	32.13107	0.41220	0.00049	0.41318	0.93680
10_1_2_2	0.675	0.594	8.30	11.006	51.215	31.94654	0.675	0.594	31.99918	0.40209	0.00050	0.40309	0.93680
10_5_1_1	0.350	0.308	8.30	17.810	51.215	32.44485	1.000	0.880	32.52037	0.42190	0.00071	0.42332	0.93680

Table 6.9.10.9-9. Results for HEU oxide and thorium metal content for air transportation (Model 6)

Case 5athothp15kor*	Core						Shell						
	Oxide (kg)	^{235}U (kg)	Th (kg)	H_2O (kg)	Kaolite (kg)	Rc (cm)	Oxide (kg)	^{235}U (kg)	Rs (cm)	k_{eff}	σ	$k_{eff} + 2\sigma$	USL
10_4_1_1	0.350	0.308	8.30	16.109	51.215	32.31552	1.000	0.880	32.39164	0.41652	0.00054	0.41760	0.93680
10_3_1_1	0.350	0.308	8.30	14.408	51.215	32.18515	1.000	0.880	32.26188	0.41042	0.00053	0.41148	0.93680
10_2_1_1	0.350	0.308	8.30	12.707	51.215	32.05371	1.000	0.880	32.13107	0.40291	0.00049	0.40389	0.93680
10_1_1_1	0.350	0.308	8.30	11.006	51.215	31.92118	1.000	0.880	31.99918	0.39445	0.00048	0.39541	0.93680

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Appendix 6.9.11
Criticality Evaluation of the Removal of Carbon Limits for Oxides; Removal of Cladding Limits; and Uranium Tetrafluoride at a Criticality Safety Index of 2.0

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Appendix 6.9.11
Criticality Evaluation of the Removal of Carbon Limits for Oxides; Removal of Cladding Limits; and Uranium Tetrafluoride at a Criticality Safety Index of 2.0

This appendix presents the criticality safety evaluation of several modifications to the limits for the ES-3100 package. This appendix evaluates the removal of the carbon restriction for all HEU oxides (i.e., eliminating the 921-g carbon limit). Furthermore, based on evaluations in this appendix, HEU broken metal cladding restrictions are not required for ground and air transport. Cladding is also not controlled for research reactor fuel elements and components that are shown to be bounded by HEU bulk oxide (U_3O_8-Al, oxides of U-Zr, and UO_2-Mg). Studies on the effect of cladding on fuel pellets are also examined. Lastly, this appendix evaluates uranium tetrafluoride (UF_4) at CSI of 2.0.

Calculations presented in this appendix are performed using the Monte Carlo Criticality Safety Analysis Sequence (CSAS), CSAS5 code module (KENO V.a), and the 238-group ENDF/B-VII cross-section library of the Standardized Computer Analysis for Licensing Evaluation (SCALE) 6.1.1 (ORNL/TM-2005/39). Criticality calculations documented in Sects. 6.4–6.6 were performed using SCALE 4.4a (NUREG/CR-200, Rev. 6) executed on an Hewlett Packard (HP) Model J5600 RISC Workstation (CMODB). This system has been retired from service, and the SCALE 4.4a version of the code is no longer supported by the Radiation Safety Information Computational Center at the Oak Ridge National Laboratory.

6.9.11.1 Description of the Criticality Design

The design features of the ES-3100 package addressed in Sect. 6.1.1 are not changed. The same codes and standards addressed in Sect. 6.1.2 apply.

6.9.11.2 Additional or Revised Content Description for the ES-3100 Package

The materials identified in Table 6.4 are used in this analysis. The only changes from Table 6.4 would be the addition of carbon to UO_2 calculations. The amount of carbon modeled in these calculations is varied from 0 to 5000 g in 1000-g increments. The amount of UO_2 modeled in these calculations is also varied in increments of 1000 g except for the HEU oxide CSI 0.4 calculations in which UO_2 is varied in increments of 250 g. The theoretical density of carbon (2.27 g/cm^3) is used in these calculations. The various amounts of cladding for broken metal is analyzed for both ground and air transport. Cladding is also evaluated for research reactor fuel elements and components that are shown to be bounded by HEU bulk oxide (U_3O_8-Al, oxides of U-Zr, and UO_2-Mg) in Table 6.9.8.1-2.

6.9.11.3 General Considerations

General considerations expressed in Sect. 6.3 regarding assumptions made about the ES-3100 packaging and the calculation methodology for the evaluation is maintained. No changes are required to the calculation models of the containment vessel (CV), the single-unit packaging (Sect. 6.3.1.1), the damaged packaging (Sect. 6.3.1.3), or the material properties specifications (Sect. 6.3.2) except for the analysis of carbon in HEU oxides.

6.9.11.3.1 Model configuration for supplemental contents

Unless stated otherwise, the materials and models used in this analysis are the same as described in Sect. 6.3. The only difference is adding carbon in UO_2 and evaluating UF_4 at a CSI of 2.0.

In this analysis, UO_2 is evaluated with varying amount of carbon. Only UO_2 is evaluated because this is shown as the most reactive oxide in Sect. 6.4.3. Calculations are performed substituting various

amounts of carbon for equal amounts oxide as well as adding carbon to a fixed amount of oxide. These calculations are performed using the same input decks used in the HEU UO_2 evaluation in this safety analysis report for packaging (SARP). The methodologies used for the calculations in this appendix are also used for the rest of the analyses in this SARP. In this SARP—no changes are made in the ES-3100 material content models except for carbon, and no changes are made to the ES-3100 container model. Oxide cases are run with 500 g of polyethylene mixed with the oxide.

6.9.11.3.2 Content model material specification

Material property specifications for this material are presented in Table 6.4.

6.9.11.4 Computer Codes and Cross-Section Libraries

KENO V.a calculations are performed using CSAS5 in SCALE 6.1.1 on the Microway Parallel Linux Cluster ENGHPC01 in the Y-12 Engineering organization in Oak Ridge, Tennessee. The upper subcritical limit (USL) without any safety margin for running SCALE 6.1.1 on this workstation is 0.985 (which covers all HEU systems with enrichments > 60%) as documented in RP YAREA-F-0455. NUREG/CR-5661 provides guidance that the USL should be established with a minimum margin of subcriticality of 0.05. Using this safety margin, the USL for the calculations performed in this appendix would be 0.935.

Several CSAS control modules are contained in SCALE6.1. The CSAS control modules are designed to analyze systems containing fissile material and calculate the neutron multiplication factor (k_{eff}) of the system. This validation is only applicable to the CSAS5 control module that uses the KENO V.a functional module. Prior to entering the KENO V.a functional module, the CSAS5 control module calls a series of utility modules and other functional modules to process the cross-section data. This validation used the 238-group ENDF/B-VII cross-section library. This is a multigroup library containing 238 distinct neutron energy groups based on the ENDF/B-VII library. The CSAS5 control module executes several functional modules to process the cross-section data used in KENO V.a. These programs are:

- WORKER: This functional module interfaces between the AMPX master library contained in the SCALE code package and the AMPX working library used in KENO V.a.
- BONAMI: This functional module processes the unresolved resonance data contained in the master library and places it in the working library.
- PMC: This functional module uses point-wise continuous cross-section data to solve a one dimensional equivalent problem producing a flux profile used for processing cross-section data.
- CENTRM: This functional module uses the flux profile calculated in PMC to collapse point-wise continuous cross-section data into the appropriate group structure producing a working library used in KENO V.a.
- KENO V.a: This functional module performs the three dimensional Monte Carlo calculation using the cross-section library provided by the WORKER module.

This validation covers the execution of the CSAS5 control module and the functional modules that are executed by it.

6.9.11.5 CV and Single Package Evaluation

Calculations are performed for the fully reflected CV and fully reflected single unit [for both Normal Conditions of Transport (NCT) and Hypothetical Accident Conditions (HAC)] with the specific gravity of water inside the CV varied from dry to fully flooded for the CV cases and evaluated as fully flooded for the single-unit cases. The CV is analyzed only for fully flooded because full flooding of the CV is shown to be the most reactive configuration.

6.9.11.5.1 UO_2 and carbon

In the reflected CV cases, calculations are performed examining various amounts of oxide mixed with 500 g of polyethylene and carbon ranging from 0 to 5000 g in 1000-g increments. In Tables 6.9.11.1–6.9.11.3, the fully reflected CV is modeled fully flooded and dry at various uranium and carbon masses. The single package cases are examined in Tables 6.9.11.8–6.9.11.10. Note that the shaded sections of these tables (and those that follow) are masses that would not fit inside the CV at that density, while "N/A" entries in the tables denote where additional calculations are not necessary.

Table 6.9.11.1. ES-3100 results for UO_2 at a bulk density of 2 g/cm^3, reflected CV, varying amounts of carbon, CV fully flooded and dry

MOCFR	Oxide mass (kg)	Case cvcrpdoxt11a_	$k_{eff} + 2\sigma$ [a]					
			No carbon (ω = 1)	1 kg carbon (ω = 2)	2 kg carbon (ω = 3)	3 kg carbon (ω = 4)	4 kg carbon (ω = 5)	5 kg carbon (ω = 6)
1.0	19	1_19_ω_15	0.9168					
1.0	18	1_18_ω_15	0.9186	0.9038				
1.0	17	1_17_ω_15	0.9163	0.9010	0.8871			
1.0	16	1_16_ω_15	0.9148	0.9027	0.8851	0.8707		
1.0	15	1_15_ω_15	0.9120	0.8959	0.8817	0.8679	0.8560	
1.0	14	1_14_ω_15	0.9095	0.8932	0.8785	0.8621	0.8489	0.8350
1.0	13	1_13_ω_15	0.9042	0.8863	0.8726	0.8563	0.8232	0.8299
1.0	12	1_12_ω_15	0.9031	0.8846	0.8654	0.8479	0.8360	0.8207
1.0E-20	19	1_19_ω_1	0.9225					
1.0E-20	18	1_18_ω_1	0.9171	0.9065				
1.0E-20	17	1_17_ω_1	0.9137	0.9017	0.8911			
1.0E-20	16	1_16_ω_1	0.9136	0.8978	0.8878	0.8707		
1.0E-20	15	1_15_ω_1	0.9103	0.8938	0.8811	0.8684	0.8552	
1.0E-20	14	1_14_ω_1	0.9075	0.8888	0.8754	0.8620	0.8460	0.8325
1.0E-20	13	1_13_ω_1	0.9012	0.8866	0.8722	0.8563	0.8405	0.8256
1.0E-20	12	1_12_ω_1	0.9012	0.8811	0.8634	0.8502	0.8360	0.8190

[a] The shaded sections are masses that would not fit inside the CV at that density.

From Table 6.9.11.1 for 2-g/cm^3 bulk density oxide, the volume of oxides with masses >19 kg would not fit inside the CV. Oxide masses of 15 kg and higher with a significant amount of carbon added would also not fit inside the CV. The same volumetric limitation is found for oxide masses of 23 kg and higher for 3-g/cm^3 bulk density oxide.

Table 6.9.11.2. ES-3100 results for UO_2 at a density of 3 g/cm^3, reflected CV, varying amounts of carbon, CV fully flooded and dry

MOCFR	Oxide mass (kg)	Case cvcrpdoxt11a_	$k_{eff} + 2\sigma$ [a]					
			No carbon (ω = 1)	1 kg carbon (ω = 2)	2 kg carbon (ω = 3)	3 kg carbon (ω = 4)	4 kg carbon (ω = 5)	5 kg carbon (ω = 6)
1.0	24	2_24_ω_15	0.9172	0.9045	0.8876	0.8799		
1.0	23	2_23_ω_15	0.9158	0.9012	0.8893	0.8729	0.8594	
1.0	22	2_22_ω_15	0.9133	0.8991	0.8849	0.9012	0.8581	0.8447
1.0	21	2_21_ω_15	0.9113	0.8953	0.8818	0.8691	0.8514	0.8396
1.0	20	2_20_ω_15	0.9113	0.8931	0.8803	0.8640	0.8496	0.8344
1.0	19	2_19_ω_15	0.9091	0.8901	0.8754	0.8580	0.8465	0.8308
1.0E-20	24	2_24_ω_1	0.9185	0.8995	0.8881	0.8754		
1.0E-20	23	2_23_ω_1	0.9140	0.9031	0.8873	0.8723	0.8600	
1.0E-20	22	2_22_ω_1	0.8116	0.8986	0.8826	0.8706	0.8572	0.8449
1.0E-20	21	2_21_ω_1	0.9119	0.8967	0.8790	0.8655	0.8517	0.8419
1.0E-20	20	2_20_ω_1	0.9079	0.8938	0.8785	0.8609	0.8480	0.8377
1.0E-20	19	2_19_ω_1	0.9050	0.8875	0.8739	0.8573	0.8448	0.8300

[a] The shaded sections are masses that would not fit inside the CV at that density.

Table 6.9.11.3. ES-3100 results for UO_2 at a density of 4 g/cm^3, reflected CV, varying amounts of carbon, CV fully flooded and dry

MOCFR	Oxide mass (kg)	Case cvcrpdoxt11a_	$k_{eff} + 2\sigma$					
			No carbon (ω = 1)	1 kg carbon (ω = 2)	2 kg carbon (ω = 3)	3 kg carbon (ω = 4)	4 kg carbon (ω = 5)	5 kg carbon (ω = 6)
1.0	24	3_24_ω_15	0.9085	0.8907	0.8761	0.8590	0.8450	0.8331
1.0	23	3_23_ω_15	0.9095	0.8899	0.8740	0.8579	0.8440	0.8273
1.0	22	3_22_ω_15	0.9035	0.8858	0.8727	0.8530	0.8380	0.8230
1.0	21	3_21_ω_15	0.9037	0.8842	0.8650	0.8494	0.8353	0.8192
1.0	20	3_20_ω_15	0.9005	0.8814	0.8625	0.8441	0.8286	0.8173
1.0	19	3_19_ω_15	0.8980	0.8759	0.8559	0.8386	0.8261	0.8096
1.0E-20	24	3_24_ω_1	0.9089	0.8914	0.8757	0.8580	0.8441	0.8320
1.0E-20	23	3_23_ω_1	0.9059	0.8878	0.8712	0.8558	0.8399	0.8262
1.0E-20	22	3_22_ω_1	0.9022	0.8843	0.8683	0.8517	0.8353	0.8217
1.0E-20	21	3_21_ω_1	0.8964	0.8815	0.8623	0.8462	0.8309	0.8196
1.0E-20	20	3_20_ω_1	0.8935	0.8771	0.8554	0.8454	0.8272	0.8156
1.0E-20	19	3_19_ω_1	0.8924	0.8730	0.8577	0.8385	0.8209	0.8095

From the results found in Tables 6.9.11.1–6.9.11.3 for a fully flooded and dry reflected CV, the most reactive cases are those with no carbon mixed with the oxide. In both scenarios, substituting carbon for oxide and adding carbon to a fixed amount of oxide resulted in a decrease of reactivity. For example, when substituting 1000 g of carbon for 1000 g of oxide at 4-g/cm^3 bulk density for a total mass (oxide and carbon) of 24 kg in a flooded CV (Cases **cvcrpdoxt11a_3_24_1_15**, **cvcrpdoxt11a_3_23_2_15**, **cvcrpdoxt11a_3_22_3_15**, **cvcrpdoxt11a_3_21_4_15**, **cvcrpdoxt11a_3_20_5_15**, and **cvcrpdoxt11a_3_19_6_15** from Table 6.9.11.7), the reactivity decreases from $k_{eff} + 2\sigma$ of 0.909 to 0.810. When adding carbon to 24 kg of oxide (Cases **cvcrpdoxt11a_3_24_1_15**, **cvcrpdoxt11a_3_24_2_15**, **cvcrpdoxt11a_3_24_3_15**, **cvcrpdoxt11a_3_24_4_15**, **cvcrpdoxt11a_3_24_5_15**, and **cvcrpdoxt11a_3_24_6_15**), the reactivity decreases from $k_{eff} + 2\sigma$ of 0.909 to 0.832. In both scenarios, the reactivity of this system decreases. Substitution of carbon for oxide has the highest decrease in reactivity as opposed to just adding carbon to a fixed amount of oxide.

In the reflected single-unit cases for both NCT and HAC, calculations are performed examining uranium oxide with varying amounts of carbon ranging from 0 to 5000 g in 1000-g increments. The ES-3100 package is fully reflected with the specific gravity of water in the CV (MOCFR) modeled as fully flooded because this is shown in Tables 6.9.11.1–6.9.11.3 as the most reactive configuration. The results are shown in Tables 6.9.11.4–6.9.11.6.

Table 6.9.11.4. ES-3100 results for UO_2 at a bulk density of 2 g/cm^3, reflected package, varying amounts of carbon, CV fully flooded

Oxide mass (kg)	Case	$k_{eff} + 2\sigma$ [a]					
		No carbon (ω = 1)	1 kg carbon (ω = 2)	2 kg carbon (ω = 3)	3 kg carbon (ω = 4)	4 kg carbon (ω = 5)	5 kg carbon (ω = 6)
NCT (Case ncsrptoxt11a_)							
19	1_19_ω	0.8143					
18	1_18_ω	0.8104	0.7946				
17	1_17_ω	0.8081	0.7923	0.7757			
16	1_16_ω	0.8071	0.7903	0.7724	0.7568		
15	1_15_ω	0.8083	0.7884	0.7689	0.7470	0.7361	
14	1_14_ω	0.8024	0.7870	0.7631	0.7465	0.7296	0.7142
13	1_13_ω	0.8011	0.7803	0.7602	0.7397	0.7231	0.7048
HAC (Case hcsrpdoxt12a_)							
19	1_19_ω	0.8126					
18	1_18_ω	0.8123	0.7979				
17	1_17_ω	0.8107	0.7946	0.7784			
16	1_16_ω	0.8092	0.7917	0.7742	0.7573		
15	1_15_ω	0.8092	0.7911	07692	0.7519	0.7364	
14	1_14_ω	0.8082	0.7843	0.7662	0.7477	0.7324	0.7119
13	1_13_ω	0.8048	0.7815	0.7623	0.7432	0.7239	0.7066

[a] The shaded sections are masses that would not fit inside the CV at that density.

Table 6.9.11.5. ES-3100 results for UO_2 at a bulk density of 3 g/cm^3, reflected package, varying amounts of carbon, CV fully flooded

Oxide mass (kg)	Case	$k_{eff} + 2\sigma$ [a]					
		No carbon (ω = 1)	1 kg carbon (ω = 2)	2 kg carbon (ω = 3)	3 kg carbon (ω = 4)	4 kg carbon (ω = 5)	5 kg carbon (ω = 6)
NCT (Case ncsrptoxt11a_)							
24	2_24_ω	0.8154	0.7943	0.7791	0.7629		
23	2_23_ω	0.8104	0.7950	0.7786	0.7607	0.7430	
22	2_22_ω	0.8125	0.7900	0.7730	0.7564	0.7395	0.7247
21	2_21_ω	0.8090	0.7896	0.7709	0.7534	0.7366	0.7221
20	2_20_ω	0.8050	0.7871	0.7670	0.7460	0.7328	0.7163
HAC (Case hcsrpdoxt12a_)							
24	2_24_ω	0.8128	0.7984	0.7793	0.7656		
23	2_23_ω	08127	0.7966	0.7760	0.7627	0.7435	
22	2_22_ω	0.8133	0.7948	0.7768	0.7594	0.7399	0.7275
21	2_21_ω	0.8122	0.7890	0.7737	0.7563	0.7366	0.7197
20	2_20_ω	0.8121	0.7914	0.7677	0.7509	0.7356	0.7172

[a] The shaded sections are masses that would not fit inside the CV at that density.

Table 6.9.11.6. ES-3100 results for UO_2 at a bulk density of 4 g/cm^3, reflected package, varying amounts of carbon, CV fully flooded

Oxide mass (kg)	Case	$k_{eff} + 2\sigma$					
		No carbon (ω = 1)	1 kg carbon (ω = 2)	2 kg carbon (ω = 3)	3 kg carbon (ω = 4)	4 kg carbon (ω = 5)	5 kg carbon (ω = 6)
NCT (Case ncsrptoxt11a_)							
24	3_24_ω	0.8107	0.7865	0.7678	0.7468	0.7313	0.7129
23	3_23_ω	0.8084	0.7864	0.7638	0.7444	0.7276	0.7078
22	3_22_ω	0.8057	0.7827	0.7627	0.7417	0.7216	0.7038
21	3_21_ω	0.8042	0.7796	0.7589	0.7358	0.7162	0.6986
20	3_20_ω	0.8026	0.7768	0.7541	0.7318	0.7104	0.6920
HAC (Case hcsrpdoxt12a_)							
24	3_24_ω	0.8115	0.7893	0.7673	0.7507	0.7345	0.7160
23	3_23_ω	0.8090	0.7888	0.7648	0.7465	0.7275	0.7107
22	3_22_ω	0.8092	0.7857	0.7684	0.7430	0.7239	0.7034
21	3_21_ω	0.8057	0.7828	0.7597	0.7379	0.7199	0.6997
20	3_20_ω	0.8018	0.7797	0.7564	0.7333	0.7124	0.6957

From the results found in the Tables 6.9.11.4–6.9.11.6 as in the CV cases shown in Tables 6.9.11.1–6.9.11.3, substituting carbon for oxide and adding carbon to a fixed amount of oxide resulted in a decrease of reactivity. The substitution of carbon for oxide results in the highest decrease in reactivity as opposed to adding carbon to a fixed amount of oxide. All cases in Tables 6.9.11.4–6.9.11.6 are well below the comparative fully flooded and reflected CV cases shown in Tables 6.9.11.1–6.9.11.3.

6.9.11.5.2 Cladding for broken metal

In the broken metal reflected CV cases, calculations are performed examining various amounts of cladding materials (stainless steel, aluminum, zirconium, and nickel). Two reflected CV calculation models are rerun using cladding. The first model is "**cvr3sqa**," which evaluated the broken metal explicitly as small cubes. The second model, "**cvr3lhac**," evaluated the broken metal homogeneously mixed within the rectangular lattices formed by the unit cells of the small cubes. This "**cvr3lhac**" model is the basis for the limits found in Table 6.1.c. The maximum amount of cladding is evaluated for both models that would fit around the small cube without intersection the adjacent cubes. The single package cases are not examined because the CV cases are shown to be the most reactive. The results are found in Tables 6.9.11.7 and 6.9.11.8.

Table 6.9.11.7. ES-3100 results for broken metal cubes with various amounts of cladding CV fully reflected and flooded 27,743.2-g ^{235}U

Clad thickness (cm)	Case cvr3sqac_	$k_{eff} + 2\sigma$ [a]			
		SS304 (ω = 1)	Aluminum (ω = 2)	Zirconium (ω = 3)	Nickel (ω = 4)
0.0	28_1_ω	**0.81945**	N/A	N/A	N/A
0.0506	28_2_ω	0.80551	0.80715	0.80854	0.80144
0.1016	28_3_ω	0.78845	0.79439	0.79857	0.78129
0.1508	28_4_ω	0.77341	0.78234	0.78429	0.75999
0.2032	28_5_ω	0.75227	0.76879	0.77016	0.73555
0.2446	28_6_ω	0.73709	0.75773	0.76040	0.71594

a The "N/A" entries denote where additional calculations are not necessary.
SS304 = Type 304 stainless steel.

Table 6.9.11.8. ES-3100 results for broken metal mixed with various amounts of cladding CV fully reflected and flooded 27,743.2-g ^{235}U

Clad thickness (cm)	Case cvr3lhac_	$k_{eff} + 2\sigma$ [a]			
		SS304 (ω = 1)	Aluminum (ω = 2)	Zirconium (ω = 3)	Nickel (ω = 4)
0.0	28_1_ω	**0.84431**	N/A	N/A	N/A
0.0506	28_2_ω	0.83882	0.83728	0.83899	0.83823
0.1016	28_3_ω	0.83123	0.82932	0.82994	0.83228
0.1508	28_4_ω	0.82467	0.82152	0.82317	0.82490
0.2032	28_5_ω	0.81595	0.81376	0.81514	0.81585
0.2446	28_6_ω	0.80975	0.80727	0.80756	0.80975

a The "N/A" entries denote where additional calculations are not necessary.
SS304 = Type 304 stainless steel.

From the results found in Tables 6.9.11.7 and 6.9.11.8 for a fully flooded and reflected CV, the most reactive cases are those with no cladding material either surrounding the broken metal or intermixed with the broken metal. The more cladding material is added to the broken metal, the more the reactivity of this system is decreased. The single-unit package is not evaluated because it has been shown that the reflected and flooded CV model is bounding.

6.9.11.5.3 Cladding for U_3O_8-Al, oxides of U-Zr, and UO_2-Mg reactor fuel elements and components

For the research reactor fuel elements and components (U_3O_8-Al, oxides of U-Zr, and UO_2-Mg), the bulk oxide cases are rerun modeling varying amounts of cladding material (stainless steel, aluminum, zirconium, and nickel) in a reflected CV with the CV fully flooded. Only the 24-kg bulk oxide cases are rerun for these calculations. The amount of cladding material is varied from none up to 1.5 L for 3.0 g/cm^3 and up to 2.5 L for 4 g/cm^3 calculations. The 2.0-g/cm^3 cases are not run because 24 kg of UO_2 at this density will not fit inside the CV. The results are found in Table 6.9.11.9.

Table 6.9.11.9. ES-3100 results for bulk oxide with various amounts of cladding CV fully reflected and flooded 24 kg UO_2 (21,1242-g ^{235}U)

Clad volume (L)	Case cvcrpdoxt11c_	$k_{eff} + 2\sigma$ [a]			
		SS304 (ω = 1)	Aluminum (ω = 2)	Zirconium (ω = 3)	Nickel (ω = 4)
Bulk density 3.0 g/cm^3					
0.0	2_1_ω	**0.91714**	N/A	N/A	N/A
0.5	2_2_ω	0.89736	0.89736	0.89736	0.89753
1.0	2_3_ω	0.88099	0.87694	0.87975	0.87955
1.5	2_4_ω	0.86201	0.85852	0.86214	0.85886
Bulk density 4.0 g/cm^3					
0.0	3_1_ω	**0.90905**	N/A	N/A	N/A
0.5	3_2_ω	0.88574	0.88348	0.88574	0.88574
1.0	3_3_ω	0.86509	0.86178	0.86250	0.86423
1.5	3_4_ω	0.84416	0.84001	0.84511	0.84274
2.0	3_5_ω	0.82535	0.82009	0.82563	0.82460
2.5	3_6_ω	0.80823	0.80209	0.80762	0.80513

[a] The "N/A" entries denote where additional calculations are not necessary.
SS304 = Type 304 stainless steel.

From the results found in Table 6.9.11.9 for a fully flooded and reflected CV, the most reactive case is with no cladding material intermixed with the bulk oxide. The more cladding material is added to the bulk oxide, the more the reactivity of this system is decreased. The single-unit package is not evaluated because it has been shown that the reflected and flooded CV model is bounding.

6.9.11.5.4 Cladding for fuel pellets

The evaluation involving HEU fuel pellets in rods is performed using the analysis found in Sect. 6.9.8.3.1 as the basis for the next set of calculations. In this section, 12 fuel pellet rods are evaluated inside the CV. These fuel pellets in the shape of rods are modeled as UO_2 at a density of 10.96 g/cm^3

with a diameter of 1.8288 cm and length of 63.5 cm. The SARP evaluated the fuel pellet rods with 0.005-cm-thick aluminum, stainless steel, and zirconium cladding surrounding the fuel pellet rod as well as no cladding. The "UO2_D" model (Fig. 6.9.8.3.1-1d) is shown to be the most reactive configuration for the fuel rods (Table 6.9.8.8-2). The analysis in this appendix modified the "UO2_D" model by varying the cladding thickness up to 0.45-cm thick and adding nickel as cladding material. The results are found in Table 6.9.11.10. These calculations examine the effect of cladding on high density HEU oxide fuel.

Table 6.9.11.10. ES-3100 results for fuel pellet rods with various amounts of cladding CV fully reflected and flooded 27,743.2-g ^{235}U

Clad thickness (cm)	Case 5cvsroxt11c_	$k_{eff} + 2\sigma$ [a]			
		SS304 (ω = 1)	Aluminum (ω = 2)	Zirconium (ω = 3)	Nickel (ω = 4)
0.0	1_ω	**0.80118**			
0.05	2_ω	0.78499	0.79184	0.79419	0.77725
0.10	3_ω	0.76727	0.78347	0.78415	0.75428
0.15	4_ω	0.75077	0.77116	0.77298	0.73055
0.20	5_ω	0.75004	0.75941	0.76237	0.70619
0.25	6_ω	0.70952	0.74496	0.74696	0.68138
0.30	7_ω	0.68972	0.72921	0.73497	0.65613
0.35	8_ω	0.66924	0.71227	0.71956	0.63118
0.40	9_ω	0.64547	0.69589	0.70424	0.60577
0.45	10_ω	0.62212	0.67797	0.68446	0.58020

[a] The shaded sections are masses that would not fit inside the CV at that density.
SS304 = Type 304 stainless steel.

From the results found in Table 6.9.11.10 for a fully flooded and reflected CV, the most reactive case is with no cladding material surrounding each fuel pellet rod. The more cladding material is added to each fuel pellet rod, the more the reactivity of this system is decreased. The single-unit package is not evaluated because it has been shown that the reflected and flooded CV model is bounding.

6.9.11.6 Array Package Evaluation (NCT and HAC)

The analyses presented in Sects. 6.5 and 6.6 demonstrate that maximum reactivity occurs in an array of packages when the CV is flooded (MOCFR of 1.0). Calculations are performed for various size arrays (for both NCT and HAC) with the CV modelled as fully flooded because full flooding of the CV is shown to be the most reactive configuration in Sects. 6.5 and 6.9.11.5.

6.9.11.6.1 UO_2 and carbon

The next set of calculations evaluated the ES-3100 package loaded with oxide with varying amounts of carbon in an infinite array with the CV fully flooded. Calculations for both NCT and HAC are performed varying the amount of carbon from 0 to 5000 g in 1000-g increments at various UO_2 masses. Only calculations with a specific gravity of 1.0E-20 outside the CV (MOIFR) are shown because this specific gravity is shown to be the most reactive. The results of the calculations are found in Tables 6.9.11.11–6.9.11.16 for NCT and HAC cases. The results show that the carbon mixed with oxide does not require any control.

Table 6.9.11.11. ES-3100 results for UO_2 at a density of 2 g/cm^3, infinite array, varying amounts of carbon, CV fully flooded, NCT

MOIFR	Oxide mass (kg)	Case nciapdoxt11a_	$k_{eff} + 2\sigma$					
			No carbon (ω = 1)	1 kg carbon (ω = 2)	2 kg carbon (ω = 3)	3 kg carbon (ω = 4)	4 kg carbon (ω = 5)	5 kg carbon (ω = 6)
1.0E-20	14	1_14_ω_1	**0.9594**	0.9478	0.9375	0.9303	0.9235	0.9213
1.0E-20	13	1_13_ω_1	0.9458	0.9328	0.9202	0.9109	0.9008	0.8946
1.0E-20	12	1_12_ω_1	0.9346	0.9199	0.9254	0.8908	0.8811	0.8717
1.0E-20	11	1_11_ω_1	0.9182	0.9033	0.8868	0.8724	0.8613	0.8499
1.0E-20	10	1_10_ω_1	0.9031	0.8848	0.8680	0.8534	0.8398	0.8274
1.0E-20	9	1_9_ω_1	0.8887	0.8661	0.8486	0.8318	0.8158	0.8006
1.0E-20	8	1_8_ω_1	0.8685	0.8432	0.8249	0.8054	0.7863	0.7205

Table 6.9.11.12. ES-3100 results for UO_2 at a density of 3 g/cm^3, infinite array, varying amounts of carbon, CV fully flooded, NCT

MOIFR	Oxide mass (kg)	Case nciapdoxt11a_	$k_{eff} + 2\sigma$				
			No carbon (ω = 1)	1 kg carbon (ω = 2)	2 kg carbon (ω = 3)	3 kg carbon (ω = 4)	5 kg carbon (ω = 6)
1.0E-20	17	2_17_ω_1	**0.9378**	0.9245	0.9096	0.9027	0.8726
1.0E-20	16	2_16_ω_1	0.9284	0.9110	0.8972	0.8878	0.8649
1.0E-20	15	2_15_ω_1	0.9198	0.9018	0.8879	0.8717	0.8489
1.0E-20	14	2_14_ω_1	0.9070	0.8919	0.8715	0.8577	0.8311
1.0E-20	13	2_13_ω_1	0.8938	0.8736	0.8578	0.8420	0.8145
1.0E-20	12	2_12_ω_1	0.8839	0.8593	0.8448	0.8252	0.7939
1.0E-20	11	2_11_ω_1	0.8679	0.8467	0.8230	0.8075	0.7759

Table 6.9.11.13. ES-3100 results for UO_2 at a density of 4 g/cm^3, infinite array, varying amounts of carbon, CV fully flooded, NCT

MOIFR	Oxide mass (kg)	Case nciapdoxt11a_	$k_{eff} + 2\sigma$				
			No carbon (ω = 1)	1 kg carbon (ω = 2)	2 kg carbon (ω = 3)	3 kg carbon (ω = 4)	5 kg carbon (ω = 6)
1.0E-20	21	3_21_ω_1	**0.9392**	0.9291	0.9142	0.9015	0.8795
1.0E-20	20	3_20_ω_1	0.9312	0.9161	0.9030	0.8897	0.8384
1.0E-20	19	3_19_ω_1	0.9236	0.9065	0.8914	0.8803	0.8572
1.0E-20	18	3_18_ω_1	0.9144	0.8982	0.8811	0.8665	0.8422
1.0E-20	17	3_17_ω_1	0.9065	0.8855	0.8702	0.8562	0.8278
1.0E-20	16	3_16_ω_1	0.8956	0.8761	0.8574	0.8400	0.8153
1.0E-20	15	3_15_ω_1	0.8846	0.8642	0.8453	0.8252	0.7985

Table 6.9.11.14. ES-3100 results for UO_2 at a density of 2 g/cm^3, infinite array, varying amounts of carbon, CV fully flooded, HAC

MOIFR	Oxide mass (kg)	Case hciapdoxt12a_	$k_{eff} + 2\sigma$				
			No carbon (ω = 1)	1 kg carbon (ω = 2)	2 kg carbon (ω = 3)	3 kg carbon (ω = 4)	5 kg carbon (ω = 6)
1.0E-20	14	1_14_ω_1	**0.9606**	0.9520	0.9394	0.9312	0.9190
1.0E-20	13	1_13_ω_1	0.9490	0.9329	0.9224	0.9108	0.8954
1.0E-20	12	1_12_ω_1	0.9335	0.9215	0.9021	0.8944	0.8731
1.0E-20	11	1_11_ω_1	0.9188	0.8997	0.8873	0.8734	0.8495
1.0E-20	10	1_10_ω_1	0.9053	0.8841	0.8714	0.8539	0.8282
1.0E-20	9	1_9_ω_1	0.8868	0.8659	0.8474	0.8308	0.8023
1.0E-20	8	1_8_ω_1	0.8661	0.8472	0.8253	0.8038	0.7746

Table 6.9.11.15. ES-3100 results for UO_2 at a density of 3 g/cm^3, infinite array, varying amounts of carbon, CV fully flooded, HAC

MOIFR	Oxide mass (kg)	Case hciapdoxt12a_	$k_{eff} + 2\sigma$				
			No carbon (ω = 1)	1 kg carbon (ω = 2)	2 kg carbon (ω = 3)	3 kg carbon (ω = 4)	5 kg carbon (ω = 6)
1.0E-20	16	2_16_ω_1	**0.9276**	0.9142	0.9007	0.8875	0.8739
1.0E-20	15	2_15_ω_1	0.9195	0.8998	0.8856	0.8731	0.8469
1.0E-20	14	2_14_ω_1	0.9090	0.8900	0.8735	0.8577	0.8345
1.0E-20	13	2_13_ω_1	0.8947	0.8776	0.8593	0.8434	0.8147
1.0E-20	12	2_12_ω_1	0.8811	0.8591	0.8426	0.8252	0.7948
1.0E-20	11	2_11_ω_1	0.8691	0.8468	0.8272	0.8084	0.7762
1.0E-20	10	2_10_ω_1	0.8527	0.8275	0.8069	0.7879	0.7536

Table 6.9.11.16. ES-3100 results for UO_2 at a density of 4 g/cm^3, infinite array, varying amounts of carbon, CV fully flooded, HAC

MOIFR	Oxide mass (kg)	Case hciapdoxt12a_	$k_{eff} + 2\sigma$				
			No carbon (ω = 1)	1 kg carbon (ω = 2)	2 kg carbon (ω = 3)	3 kg carbon (ω = 4)	5 kg carbon (ω = 6)
1.0E-20	21	3_21_ω_1	**0.9417**	0.9257	0.9111	0.8721	0.8810
1.0E-20	20	3_20_ω_1	0.9309	0.9156	0.9030	0.8897	0.8678
1.0E-20	19	3_19_ω_1	0.9044	0.9072	0.8910	0.8787	0.8553
1.0E-20	18	3_18_ω_1	0.9140	0.8934	0.8802	0.8656	0.8432
1.0E-20	17	3_17_ω_1	0.9048	0.8867	0.8701	0.8537	0.8304
1.0E-20	16	3_16_ω_1	0.8946	0.8739	0.8558	0.8419	0.8161
1.0E-20	15	3_15_ω_1	0.8864	0.8639	0.8452	0.8285	0.8020

From the results found in the Tables 6.9.11.11–6.9.11.16, as in the CV and single package cases shown in Tables 6.9.11.1–6.9.11.6, substituting carbon for oxide and adding carbon to a fixed amount of oxide resulted in a decrease of reactivity. The substitution of carbon for oxide results in the highest decrease in reactivity as opposed to adding carbon to a fixed amount of oxide.

6.9.11.6.2 Cladding for broken metal

The ES-3100 package is evaluated loaded with broken metal with varying amounts of cladding material [SS304 (stainless steel, Type 304), aluminum, zirconium, and nickel] in an infinite array with the CV fully flooded. The case for 2774 g of broken metal at 100% enrichment is used for these calculations because this case is the basis for the limits for broken metal for CSI 0.0 (Table 6.1c). Calculations for the NCT are performed varying the amount of cladding material from none to 6.0-cm thick. The amount of cladding that is evaluated in this section is larger than what is evaluated for the CV cases because the amount of fissile material analyzed in the array cases is significantly less than the CV cases, which allows for more cladding material to be added to the CV. Only calculations with a specific gravity of 1.0E-20 outside the CV (MOIFR) are shown in this section because this specific gravity is shown to be the most reactive.

The HAC cases are not examined because the behavior of the system would be the same due to the only differences in these models are the outer diameter of the drum, the increase of the density of the Kaolite inside the drum, and essentially no difference in the reactivity between NCT and HAC (k_{eff} + 2σ of 0.904 for NCT and 0.905 for HAC from Table 6.1c). The results of the calculations are found in Table 6.9.11.17.

Table 6.9.11.17. ES-3100 results for broken metal with various amounts of cladding CV fully reflected and flooded

Clad thickness (cm)	Case nciabmt11c_	k_{eff} + 2σ [a]			
		SS304 (ω = 1)	Aluminum (ω = 2)	Zirconium (ω = 3)	Nickel (ω = 4)
0.0	1_ω	**0.90406**	N/A	N/A	N/A
0.0506	2_ω	0.90365	0.90304	0.90364	0.90224
0.1016	3_ω	0.90219	0.90319	0.90253	0.90249
0.1508	4_ω	0.90212	0.90066	0.90268	0.90104
0.2032	5_ω	0.90008	0.90210	0.90150	0.89994
0.2446	6_ω	0.89904	0.90043	0.90099	0.89884
1.0	7_ω	0.88358	0.89024	0.89169	0.87866
2.0	8_ω	0.84395	0.86485	0.86666	0.83612
4.0	10_ω	0.71260	0.75712	0.76546	0.68986
6.0	12_ω	0.47076	0.51865	0.53007	0.44871

[a] The "N/A" entries denote where additional calculations are not necessary.
SS304 = Type 304 stainless steel.

From the results found in the Table 6.9.11.17, as in the CV cases (Tables 6.9.11.7 and 6.9.11.8), adding cladding material to broken metal results in a decrease of reactivity. From these calculations, it can be concluded that for stainless steel, aluminum, zirconium, and nickel based cladding, these materials do not need to be controlled for criticality safety purposes.

6.9.11.6.3 Cladding for U_3O_8-Al, oxides of U-Zr, and UO_2-Mg research reactor fuel elements and components

The next set of calculations evaluates the ES-3100 package loaded with research reactor fuel elements and components. This is modeled with varying amounts of cladding material in an infinite array with the CV fully flooded. Only calculations with a specific gravity of 1.0E-20 outside the CV (MOIFR) are shown because this specific gravity is shown to be the most reactive. These contents are shown to be bounded by the bulk oxide analysis evaluated in this SARP. The HEU oxide model used in these calculations is UO_2 at a bulk density of 2.0 g/cm^3 mixed with 500 g of polyethylene with the void spaces inside the oxide filled with water. The 9.682-kg ^{235}U cases are rerun adding cladding to the oxide matrix because this case is the basis for the limits for bulk oxide for CSI 0.0 (Table 6.2a). The HAC cases are not examined since the behavior of the system would be the same due to the only differences in these models are the outer diameter of the drum and the increase of the density of the Kaolite inside the drum. The results of the calculations are found in Table 6.9.11.18.

Table 6.9.11.18. ES-3100 results for oxide research reactor fuel elements and components with various amounts of cladding at 2.0 g/cm^3

Volume (L)	Case nciapdoxt11c_	$k_{eff} + 2\sigma$ [a]			
		SS304 (ω = 1)	Aluminum (ω = 2)	Zirconium (ω = 3)	Nickel (ω = 4)
0.0	1_1_ω	**0.91889**	N/A	N/A	N/A
0.5	1_2_ω	0.89322	0.89297	0.89436	0.89385
1.0	1_3_ω	0.86928	0.87076	0.87378	0.86813
1.5	1_4_ω	0.84743	0.84974	0.85300	0.84612
2.0	1_5_ω	0.82769	0.83251	0.83501	0.82331
3.0	1_7_ω	0.79572	0.80417	0.80824	0.78927
4.0	1_9_ω	0.77617	0.79397	0.79556	0.76332

[a] The "N/A" entries denote where additional calculations are not necessary.
SS304 = Type 304 stainless steel.

From the results found in the Table 6.9.11.18, as in the CV cases (Table 6.9.11.9), adding cladding material to oxides resulted in a decrease of reactivity.

6.9.11.6.4 Cladding for Fuel Pellets

This analysis evaluated the ES-3100 package loaded with HEU fuel pellets modeled as rods as in Sect. 6.9.11.5.6. Calculations are performed varying the types and amounts of cladding material as in the reflected and flooded CV cases but for an infinite array of ES-3100 packages. Only calculations with a specific gravity of 1.0E-20 outside the CV (MOIFR) are shown because this specific gravity is shown to be the most reactive. The HAC cases are not examined because the behavior of the system would be the same due to the only differences in these models are the outer diameter of the drum and the increase of the density of the Kaolite inside the drum. The results of the calculations are found in Table 6.9.11.19.

Table 6.9.11.19. ES-3100 results for fuel pellet rods with various amounts of cladding CV fully flooded infinite array

Clad thickness (cm)	Case 5nsiaoxt11c_	$k_{eff} + 2\sigma$ [a]			
		SS304 (ω = 1)	Aluminum (ω = 2)	Zirconium (ω = 3)	Nickel (ω = 4)
0.0	1_ω	**0.86743**	N/A	N/A	N/A
0.050	2_ω	0.85245	0.85959	0.86152	0.84563
0.100	3_ω	0.83506	0.84831	0.85155	0.82322
0.150	4_ω	0.81643	0.83892	0.83852	0.79969
0.200	5_ω	0.79691	0.82402	0.82557	0.77464
0.300	7_ω	0.75648	0.79220	0.79599	0.72561
0.400	9_ω	0.71180	0.75478	0.75858	0.67644
0.450	10_ω	0.68895	0.73640	0.73757	0.65268

[a] The "N/A" entries denote where additional calculations are not necessary.
SS304 = Type 304 stainless steel.

From the results found in Table 6.9.11.19, the most reactive cases are those with no reflector material surrounding the fuel pellet rod. The more cladding material is added to the fuel pellet rod, the more the reactivity of this system is decreased.

6.9.11.5 Air Transport for Broken Metal

In these calculations, the air transport models are re-evaluated examining the effect of cladding material on these models. For broken metal, Models 1 through 6 are rerun with stainless steel, aluminum, zirconium, and nickel cladding (Tables 6.9.11.20–6.9.11.25). The cladding is homogeneously mixed with the fissile material in all of these models except for Model 6, which homogeneously mixes part of the cladding with fissile material and surrounds the fissile material with the rest of the cladding. A more detailed description of these models is found in Sect. 6.3.1.4 with a brief summary of the models described in this section.

In this analysis, Model 1 is a spherical homogeneous mixture of 10-kg ^{235}U, 500 g of polyethylene, and cladding material surrounded by 20 cm of water. The type and volume of cladding material is varied from none to 5 L in volume.

Model 2 is a spherical homogeneous mixture of 10-kg ^{235}U and 500 g of polyethylene surrounded by cladding material instead of stainless steel, which is surrounded by 20 cm of water. The type and thickness and of cladding material is varied from none to 5.0 cm.

Model 3 a spherical homogeneous mixture of 10-kg ^{235}U, 500 g of polyethylene, and cladding material that is surrounded by wet Kaolite, which is surrounded by 20 cm of water. The amount of Kaolite surrounding the fissile material is varied from none to 60,223.4 g of wet Kaolite (53,419.6 g of dry-baked Kaolite plus 6,803.8 g of free water). The type and volume of cladding material is varied from none to 5 L in volume. If no Kaolite is modeled, Model 3 is the same as Model 1.

Model 4 is a spherical homogeneous mixture of 7-kg ^{235}U, 500 g of polyethylene, wet Kaolite, and cladding material, which is surrounded by 20 cm of water. The amount of water in the Kaolite region is varied from 2,204.7 g in baked-dry Kaolite to 9,008.6 g in wet Kaolite. The type and volume of cladding material is varied from none to 5 L in volume.

Model 5 is a spherical homogeneous mixture of 7-kg ^{235}U, 500 g of polyethylene, excessive moisture from the Kaolite, and cladding material that is surrounded by Kaolite, which is surrounded by 20 cm of water. The amount of water from the Kaolite region in the fissile material region is varied from 2,204.7 g in baked-dry Kaolite to 9,008.6 g in wet Kaolite. The type and volume of cladding material is varied from none to 5 L in volume.

Model 6 is a spherical homogeneous mixture of part of 7-kg ^{235}U, 500 g of polyethylene, wet Kaolite, and part of the cladding material surrounded by a homogeneous mixture of the remaining 7-kg ^{235}U and remaining cladding material, which is surrounded by 20 cm of water. The type and volume of cladding material is varied from none to 5 L in volume.

The most reactive configurations of the models are presented in the tables below. The results of the calculations are found in Tables 6.9.11.20–6.9.11.25.

Table 6.9.11.20. Results for broken metal with various amounts of cladding for air transport Model 1 with 10-kg ^{235}U

Volume (L)	Case atdmrc_	$k_{eff} + 2\sigma$ [a]			
		SS304 (ω = 1)	Aluminum (ω = 2)	Zirconium (ω = 3)	Nickel (ω = 4)
0.0	1_ω	**0.84971**	N/A	N/A	N/A
0.5	2_ω	0.78397	0.77145	0.77785	0.78477
1.0	3_ω	0.73977	0.72595	0.73587	0.73902
2.0	4_ω	0.68695	0.67555	0.68690	0.67948
3.0	5_ω	0.65339	0.64898	0.65839	0.63919
4.0	6_ω	0.62955	0.63199	0.64046	0.61094
5.0	7_ω	0.61142	0.61991	0.62900	0.58934

[a] The "N/A" entries denote where additional calculations are not necessary.
SS304 = Type 304 stainless steel.

Table 6.9.11.21. Results for broken metal with various amounts of cladding for air transport Model 2 with 10-kg ^{235}U

Thickness (cm)	Case atdmsrc_	$k_{eff} + 2\sigma$ [a]			
		SS304 (ω = 1)	Aluminum (ω = 2)	Zirconium (ω = 3)	Nickel (ω = 4)
0.0	1_ω	**0.84971**	N/A	N/A	N/A
0.5	2_ω	0.82856	0.85140	0.85430	0.81418
1.0	3_ω	0.81128	0.84947	0.85743	0.79864
2.0	5_ω	0.79866	0.84471	0.85945	0.80042
3.0	7_ω	0.79961	0.83717	0.85993	0.81461
4.0	9_ω	0.80535	0.82917	0.85824	0.82952
5.0	11_ω	0.81515	0.82212	0.85636	0.84345

[a] The "N/A" entries denote where additional calculations are not necessary.
SS304 = Type 304 stainless steel.

Table 6.9.11.22. Results for broken metal with various amounts of cladding for air transport Model 3 with 10-kg ^{235}U

Volume (L)	Case atdm15krc_	$k_{eff} + 2\sigma$ [a]			
		SS304 (ω = 1)	Aluminum (ω = 2)	Zirconium (ω = 3)	Nickel (ω = 4)
No Kaolite (same as Model 1)					
0.0	1_1_ω	**0.84971**	N/A	N/A	N/A
0.5	2_1_ω	0.78397	0.77145	0.77785	0.78477
1.0	3_1_ω	0.73977	0.72595	0.73587	0.73902
2.0	4_1_ω	0.68695	0.67555	0.68690	0.67948
3.0	5_1_ω	0.65339	0.64898	0.65839	0.63919
4.0	6_1_ω	0.62955	0.63199	0.64046	0.61094
5.0	7_1_ω	0.61142	0.61991	0.62900	0.58934
12.0446-kg Kaolite					
0.0	1_2_ω	**0.70595**	N/A	N/A	N/A
0.5	2_2_ω	0.63285	0.60990	0.61784	0.64469
24.0892-kg Kaolite					
0.0	1_3_ω	**0.68744**	N/A	N/A	N/A
0.5	2_3_ω	0.61131	0.58566	0.59745	0.62464

[a] The "N/A" entries denote where additional calculations are not necessary.
SS304 = Type 304 stainless steel.

Table 6.9.11.23. Results for broken metal with various amounts of cladding for air transport Model 4 with 7-kg ^{235}U, 9008.5-g H_2O

Volume (L)	Case athmp15krc_	$k_{eff} + 2\sigma$ [a]			
		SS304 (ω = 1)	Aluminum (ω = 2)	Zirconium (ω = 3)	Nickel (ω = 4)
0.0	1_5_ω	**0.59294**	N/A	N/A	N/A
0.5	2_5_ω	0.58845	0.59164	0.59324	0.58584
1.0	3_5_ω	0.58305	0.59327	0.59363	0.57542
2.0	4_5_ω	0.57406	0.59250	0.59469	0.56264
3.0	5_5_ω	0.56461	0.59310	0.59466	0.54832
4.0	6_5_ω	0.55635	0.59277	0.59449	0.53526
5.0	7_5_ω	0.54785	0.59345	0.59422	0.52109

[a] The "N/A" entries denote where additional calculations are not necessary.
SS304 = Type 304 stainless steel.

Table 6.9.11.24. Results for broken metal with various amounts of cladding for air transport Model 5 with 7-kg ^{235}U, 5442.1-g H_2O

Volume (L)	Case athmpw12krc_	$k_{eff} + 2\sigma$ [a]			
		SS304 (ω = 1)	Aluminum (ω = 2)	Zirconium (ω = 3)	Nickel (ω = 4)
0.0	1_5_ω	**0.90343**	N/A	N/A	N/A
0.5	2_5_ω	0.88909	0.88024	0.88704	0.89217
1.0	3_5_ω	0.87536	0.85880	0.87092	0.88068
2.0	4_5_ω	0.84699	0.82210	0.84181	0.85351
3.0	5_5_ω	0.81892	0.78912	0.81784	0.82650
4.0	6_5_ω	0.79552	0.75989	0.79505	0.80099
5.0	7_5_ω	0.77264	0.73837	0.77521	0.77475

[a] The "N/A" entries denote where additional calculations are not necessary.
SS304 = Type 304 stainless steel.

From the results found in the Tables 6.9.11.46–6.9.11.50, adding cladding material to broken metal in the air transport model results in a decrease of reactivity. All cases are below the USL.

Table 6.9.11.25. Results for broken metal with various amounts of cladding for air transport Model 6

Clad [core/shell] (L)	Case athmp15kmrc_	$k_{eff} + 2\sigma$ [a]			
		SS304 (ω = 1)	Aluminum (ω = 2)	Zirconium (ω = 3)	Nickel (ω = 4)
1000-g ^{235}U core/6000-g ^{235}U shell					
0.0/0.0	2_1_ω	0.62987	N/A	N/A	N/A
1.0/0.0	2_2_ω	0.61551	0.62984	0.62938	0.608902
3.0/0.0	2_6_ω	0.59160	0.62745	0.62767	0.57460
5.0/0.0	2_11_ω	0.57231	0.62521	0.62801	0.54875
2000-g ^{235}U core/5000-g ^{235}U shell					
0.0/0.0	3_1_ω	0.63258	N/A	N/A	N/A
1.0/0.0	3_2_ω	0.62142	0.63304	0.63321	0.61582
0.5/0.5	3_3_ω	0.61998	0.63155	0.63049	0.61535
0.3/0.7	3_4_ω	0.61991	0.63035	0.63115	0.61403
0.0/1.0	3_5_ω	0.61933	0.62951	0.63083	0.61412
3.0/0.0	3_6_ω	0.60098	0.63028	**0.63272**	0.58879
1.5/1.5	3_7_ω	0.59907	0.62910	0.62952	0.58132
1.0/2.0	3_8_ω	0.59887	0.62719	0.62953	0.58044
0.5/2.5	3_9_ω	0.59994	0.62869	0.62918	0.58138
0.0/3.0	3_10_ω	0.59889	0.62764	0.62898	0.58066
5.0/0.0	3_11_ω	0.58314	0.62987	0.63134	0.50636
2.5/2.5	3_12_ω	0.57968	0.62701	0.62953	0.55325
1.5/3.5	3_13_ω	0.57852	0.62493	0.63093	0.55169
0.5/2.5	3_14_ω	0.57924	0.62504	0.63070	0.55119
0.0/3.0	3_15_ω	0.57994	0.62642	0.63037	0.55204
3000-g ^{235}U core/4000-g ^{235}U shell					
0.0/0.0	4_1_ω	0.63199	N/A	N/A	N/A
1.0/0.0	4_2_ω	0.62195	0.63091	0.63044	0.61573
3.0/0.0	4_6_ω	0.60327	0.63110	0.63185	0.58907
5.0/0.0	4_11_ω	0.58832	0.62999	0.63171	0.56634

[a] The "N/A" entries denote where additional calculations are not necessary.
SS304 = Type 304 stainless steel.

From the results found in the Table 6.9.11.25, adding stainless steel and nickel cladding results in a decrease in reactivity. Adding aluminum and zirconium cladding results in either no increase or a decrease in reactivity. All cases are well below the USL.

6.9.11.6 UF_4 at CSI 2.0

This section discusses the calculations for the array calculations for UF_4 at a CSI of 2.0. For a CSI of 2.0, the array size for NCT is 7 × 7 × 3. The results of these calculations are found in Table 6.9.11.26. The CV and single package models were evaluated in Sect. 6.9.8.5.5 and were shown to be below the USL for up to 24-kg UF_4 (Table 6.9.8.8-5a for calculation results). From Sect. 6.9.8.6, the analyses presented in Sects. 6.4, 6.5, and 6.6 demonstrate that an insignificant difference is observed between the calculated $k_{eff} \pm 2\sigma$ values for undamaged packages in NCT and damaged packages in HAC. Therefore, the HAC array analysis is redundant and not performed.

Table 6.9.11.26. ES-3100 results for UF_4, 7×7×3 array, CSI 2.0, CV fully flooded, NCT

UF_4 mass (kg)	Case 5ncf3puf4t11_	$k_{eff} + 2\sigma$ [a]					
		MOIFR					
		1.0E-20 (ω = 1)	1.0E-5 (ω = 2)	1.0E-4 (ω = 3)	1.0E-3 (ω = 4)	0.1 (ω = 6)	0.3 (ω = 8)
1	1_ω	0.66509	N/A	N/A	N/A	N/A	N/A
5	5_ω	0.84683	N/A	N/A	N/A	N/A	N/A
10	10_ω	0.86702	0.86718	N/A	N/A	N/A	N/A
12	12_ω	0.86687	0.86603	0.86672	0.86569	0.80323	0.76562
13	13_ω	**0.86965**	0.86783	0.86669	0.86720	0.80158	0.76340
14	14_ω	0.86788	0.86627	0.86643	0.86585	0.80143	0.76409
16	16_ω	0.86523	0.86565	N/A	N/A	N/A	N/A
20	20_ω	0.86207	N/A	N/A	N/A	N/A	N/A
24	24_ω	0.85500	N/A	N/A	N/A	N/A	N/A

[a] The "N/A" entries denote where additional calculations are not necessary.

From the results found in Table 6.9.11.26 for a 7 × 7 × 3 array (CSI of 2.0) with NCT, the most reactive configuration is for 13 kg of UF_4 with no interstitial water between the packages. This case is below the USL (Case **5ncf3puf4t11_13_1** with $k_{eff} + 2\sigma$ of 0.870).

6.9.11.7 Conclusions

For uranium oxides, there are no limits on amount of carbon that may be mixed with the oxide; thus, all carbon limitations are removed.

From the calculations performed in this appendix, it is shown that for broken metal and research reactor fuel elements and components bounded by bulk oxide, no cladding is the most reactive configuration. As cladding is added to the fissile material, reactivity decreases. In the air transport models, reactivity decreases as cladding is added to the fissile material, except for Model 6 where reactivity increases slightly but remained well below the USL. Thus, it can be concluded that for stainless steel, aluminum, zirconium, and nickel based cladding, these materials do not need to be controlled for criticality safety purposes.

Uranium metal loadings in this package may contain quantities of alloying constituents, none of which are fissile. These constituents act a diluent when mixed with HEU metal. Calculations are performed in Sects. 6.9.11.5.4 and 6.9.11.6.4 for broken metal evaluated uranium homogeneously mixed with various amounts of aluminum, steel, zirconium, or nickel. Adding these materials to the uranium metal resulted in a decrease in reactivity for both single-unit and array calculations. Furthermore, TID-7016 (Sect. 3.1, p. 71) states that when ^{235}U, ^{233}U, or plutonium metal is mixed with any element from $11 \leq Z$ (atomic number) ≤ 83 (from sodium to bismuth), the amount of fissile material required to go critical increases. If the system was shown to be subcritical without the alloying material, then adding alloying material would increase the amount of fissile material required to go critical, thus diluting the system and resulting in a less reactive system. Therefore, alloying materials of any element from $11 \leq Z \leq 83$ do not require any criticality safety controls.

For UF_4 at a CSI of 2.0, the maximum amount of UF_4 per ES-3100 package is 24 kg (18.136-kg ^{235}U).

Appendix 6.9.12
Chapter 6 References

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7. PACKAGE OPERATIONS

Radioactive material packages shall be operated in accordance with applicable U.S. Nuclear Regulatory Commission (NRC), U.S. Department of Transportation (DOT), and other federal, state, and local regulations to protect the health and safety of the public, workers, and the environment. Furthermore, the packages shall be operated according to a quality assurance (QA) plan approved by the U.S. Department of Energy (DOE), Office of Environmental Management; or DOE, National Nuclear Security Administration (DOE/NNSA); as appropriate.

The user is responsible for following the established NRC regulations for packaging, preparation for shipment, and transportation of radioactive materials given in Title 10, Part 71, of the Code of Federal Regulations (CFR) [10 CFR 71] as well as DOT regulations for packaging and shipment of hazardous materials given in Title 49 CFR. DOE nuclear facility users are responsible for implementing DOE regulations given in Title 10, Parts 830 and 835, of the CFR in addition to directives conveyed in DOE Order (O) 232.2A, DOE O 414.1D, and DOE O 460.1D or DOE O 461.1C, as appropriate.

Specific operational criteria for the ES-3100 package with highly enriched uranium (HEU) content are presented in this section. Where appropriate, facility management may authorize the adjustment of the explicit implementation sequence in this section to accommodate facility-specific workflow logistics and operational requirements. The package user shall develop detailed, written site-specific operating procedures based on the Certificate of Compliance (CoC), the criteria contained herein, and the facility's operational requirements. These procedures shall be in accordance with 10 CFR 71, Subparts A, G, and H; DOT and DOE regulations; and applicable state, tribal, and local regulations not preempted by DOT. The operating procedures should also describe interim activities to be performed if the package is to be temporarily stored prior to shipment. Storage incident to transportation shall be in accordance with the facility Safety Analysis Report (10 CFR 830) or the Transportation Safety Document (TSD) [DOE O 460.1D or DOE O 461.2, as applicable].

The package operations should be consistent with maintaining occupational radiation exposures as low as reasonably achievable (ALARA) [10 CFR 71.87(i)] in addition to addressing applicable safety aspects or activities such as personal protection (radiation, chemical, and physical); contamination or radiation surveys; nuclear criticality safety; provisions for reporting safety concerns associated with the packaging or its use; and the records and reporting requirements cited in Appendix 7.5.1. The user of the packaging shall:

1. have authorization to acquire, package, or transport radioactive, fissile, or special nuclear materials;

2. have the latest CoC and safety analysis report for packaging (SARP) for the ES-3100 package with HEU content, and comply with all actions and restrictions therein;

3. be registered as a user of the ES-3100 packaging with DOE;

4. comply with the applicable requirements of the DOT regulations in Title 49 CFR, Parts 107, 171–180, and 390–397, as appropriate to the mode of transport (10 CFR 71.5); and

5. have a site-approved QA program that meets the requirements of 10 CFR 71, Subpart H.

The ES-3100 package description is presented in Sect. 1.2 with a schematic shown in Fig. 1.1, and an exploded view of the packaging components is presented in Fig. 1.2. The ES-3100 certification drawing can be found in Appendix 1.3.1. The packaging design drawings (Appendix 1.3.7) provide material lists, dimensions, safety components, welding requirements, and gasket requirements. The largest nominal gross shipping weight of the ES-3100 package with bulk HEU content is 187.81 kg (414.05 lb) and the maximum allowable gross weight is 190.5 kg (420 lb).

The ES-3100 is handled using industry-standard drum-handling equipment. When using a forklift, the ES-3100 can be placed on the tines of the forklift from below, or it is designed for a forklift pincher assembly that can be used to grasp the exterior of the drum assembly. Forklift gripping forces of up to 5400 lb can be used with no detrimental effects on the package (Sect. 1.2.1.1).

The site-specific operating procedures, which include the facility's operational requirements, shall ensure that:

1. All appropriate documents have been reviewed by operating personnel and are available for further review, if necessary.

2. Certified equipment is used (e.g., torque wrenches, instrumentation, scales, lifting hardware, and radiation survey instruments) in accordance with the site-approved QA program.

3. Segregated work stations, curtains, lead blankets, personnel protective equipment, or other equipment is used, as necessary, to protect workers and nearby personnel from radioactive material hazards.

4. Appropriate material handling equipment is available and approved for use (e.g., forklifts, hoists, and drum handlers). Operating controls shall be implemented for any forklift pincher assembly to limit clamping forces on the drum body (i.e., $\leq$ 5400 lb).

5. Appropriate provisions to decontaminate packages and packaging components are provided consistent with ALARA principles.

6. During routine package operations, adhesive-backed items such as labels, tags, stickers, tape, or document holders can be affixed to the package stainless-steel surfaces. Unless directed otherwise in this chapter, the placement of adhesive-backed items over painted identification markings on the package will be avoided. Given that commercially available plain vinyl tape and vinyl-type transportation labels are readily removable and leave a minimal adhesive residue, an adhesive-backed item that is not readily removable or leaves an excessive adhesive residue upon removal (resulting in increased maintenance time and expense) will be placed on plain vinyl tape, which is affixed to the package surface.

   Note: The Y-12 ES-3100 Program Manager or the Y-12 ES-3100 packaging engineer may authorize relief from these adhesive-backed item requirements on a per shipment basis. A copy of the Y-12 authorization shall be included with the shipping papers.

7. An optional radio-frequency identification (RFID) monitoring system tag may be secured to the drum assembly in accordance with the applicable requirements of ANL/DIS-09-5. The mounting bracket for the RFID monitoring system tag shall provide the equivalent contact area of a drum washer and the thread engagement for the drum hex nuts shall remain unchanged. When attached, the RFID tag will extend beyond the outside diameter of the drum body, and controls shall be implemented to avoid damage to the RFID tag.

Care should be exercised to control the packaging components when they are removed to ensure that parts are kept with the packaging and not mixed with other loose parts or parts from other packagings. Other preparations should be made to minimize damage or loss of packaging components. The drum and CV are marked with their serial numbers. The numbers are used to control these parts and to accumulate their respective operational and maintenance histories. Applicable serial numbers of packaging components should be verified to ensure that these components are maintained together. Loose parts (e.g., hex nuts, washers, and O-rings) may be reused if it can be shown that they were the parts that were removed and that no damage to the parts has occurred. Otherwise, they shall be discarded and replaced with certified parts. In order to maintain configuration control of the packaging components, the user shall ensure that there are no unauthorized modifications and no substitution of components with unauthorized components. The user may replace certain parts identified in Table 7.1, and the certification of all replacement parts must be traceable. The user shall document any part replacement identifying it to a specific packaging by model and serial number.

Table 7.1. Replacement parts for the ES-3100 packaging

Part	Description	Material	Specification/ Data Sheet [a]
ES-3100 drum assembly (Drawing M2E801580A001, Appendix 1.3.7)			
Drum lid hex nut	5/8-11 UNC-2B hex nut	Silicon bronze	ASTM F 467 per ASME B18.2.2 M2E801580A005-3
Drum lid washer	0.812-in. ID × 1.375-in. OD × 0.25-in.-thick	Stainless steel	ASTM A 240 or ASTM A 276 M2E801580A005-4
Nylon plug	Vent-hole plug (installed around circumference of the drum body and on top of the top plug)	Nylon 6/6	Micro Plastic, Inc. Part 62MP0312 or equivalent M2E801580A002-8 M2E801580A008-7
Silicone rubber pads (CV bottom, CV flange, and plug)		Silicone rubber 22 ± 5 Shore A	M2E801580A009-1 M2E801580A009-2 M2E801580A009-3
Aluminum tape	Duct tape, low temperature (−40 to +250°F), 2-in. wide	Aluminum foil	M2E801580A002-11 McMaster-Carr Part 7616A21 or equivalent
ES-3100 containment vessel assembly (Drawing M2E801580A011, Appendix 1.3.7)			
Outer O-ring	5.859-in. ID × 0.139-in. diam cross section	Ethylene propylene diene monomer (EPDM)	ASTM D 2000, M2E801580A013-2
Inner O-ring	5.359-in. ID × 0.139-in. diam cross section	EPDM	ASTM D 2000, M2E801580A013-1
Modified VCO [b] threaded plug with O-ring	Leak-test-port plug	Brass	Volunteer Industrial P/N 04-2126 M2E801580A011-6

[a] All items beginning with"M2E" or "M8" are part numbers and the parts are shown on the corresponding drawings in Appendix 1.3.7.
[b] VCO—Vacuum coupling O-ring.

If packaging components are stored for an extended period of time, they may be bagged. The packaging components (i.e., complete assembly or individual parts) will be stored in weather-protected indoor facilities and transferred between facilities in an enclosed conveyance for protection from environmental elements. Generally, the exterior surface of the packaging components will remain relatively clean; however, each user will include provisions in the operating procedures to clean packaging components as necessary. Additionally, special precautions should be taken to protect the packaging from inadvertent contamination by radioactive materials. In radiological contamination areas, the packaging or package should be placed onto surfaces that are covered with a disposable covering, such as plastic or paper, to minimize the transfer of contamination.

The reference to nonfixed (removable) surface contamination is repeated throughout the various operating sections. It is essential that radiation exposure be minimized to protect the health and safety of the public, workers, and the environment. As the package is prepared to enter the public domain, the surface contamination level of the package and the conveyance will be maintained ALARA.

All personnel who support and/or perform packaging, transfer and transportation operations will be appropriately trained and qualified in accordance with the site-approved QA program; 49 CFR 171.1; and 49 CFR 172, Subpart H, as appropriate. Auditable training records will be maintained in accordance with site record retention requirements. The Y-12 National Security Complex (Y-12) ES-3100 Program Manager and the Y-12 ES-3100 packaging engineer must be apprised of all planned users of the ES-3100 package to ensure proper operational training has been performed.

7.1 PACKAGE LOADING

This section addresses the operational criteria relating to the preparation for loading, loading of contents, and preparation for transport of the ES-3100 package. Implementation of the operational criteria in this section along with the conditions of the CoC and the requirements of 10 CFR 71.5 will ensure that the package is properly prepared for transport.

7.1.1 Preparation for Loading

The user shall develop detailed operating procedures which include, at a minimum, the process steps listed below for content and packaging preparation activities.

7.1.1.1 Content preparation

Operating personnel shall ensure that:

1. The HEU material has been verified as being within the limits specified in this SARP and the CoC for content form, material mass, material dimensions, uranium content, and ^{235}U enrichment as presented in Sect. 1.2.2. The contents shall be verified using accountability records and weight measurements.

   Note: A radiation survey of the contents may be conducted prior to loading to measure the content dose rate. The measured dose rate should be compared with known or calculated values. This is not a requirement and generally should only be performed if there are shielding concerns.

2. Packing materials (e.g., convenience cans or bottles; polyethylene, nylon, or Teflon bags; silicone can pads; can spacers; stainless-steel scrubbers) are visually inspected for signs of moisture, corrosion, or physical damage.

3. If the contents are broken HEU metal and alloy, proceed to Step 4. For all other contents, proceed to Step 7.

4. For proper handling of broken HEU metal and alloy, pyrophoric concerns will be addressed by one of the following options:

   a. Treat all broken HEU metal and alloy content as pyrophoric and proceed to Step 6; or

   b. Determine whether or not the broken HEU metal and alloy content is pyrophoric in accordance with Step 5.

5. For pyrophoric categorization of broken HEU metal and alloy content, the specific surface area of the metal pieces (surface area to mass ratio) is evaluated. If the specific surface area is $\leq$1.00 cm^2/g, then the metal pieces are not pyrophoric and are acceptable for loading according to Step 7. If the specific surface area is >1.00 cm^2/g or if the specific surface area cannot be evaluated, characterize the metal using the following methods:

   a. Solid-metal pieces that are clearly larger than 3/8 in. in every dimension do not require additional size-grading determinations and are acceptable for loading according to Step 7.

   b. Items which are unacceptable by definition (Sect. 1.2.2), such as powders, foils, wires, and turnings, will be rejected and do not require additional size-grading determinations. These items will be loaded according to Step 6.

   c. Any items that are not obviously larger than the 3/8 in. in every dimension must be size-graded using a 3/8-in. (9.5-mm) mesh sieve as follows:

      Note: With facility management approval, equivalent size-grading methods may be used [e.g., 3/8-in. (9.5 mm) mesh screens, visual comparison to size standards, etc.].

      i. Any item that falls through the sieve must be rejected and will be loaded according to Step 6.

      Note: Operators need to be alert to items which may not fall through the sieve but can be rejected based on the following criteria:

      - Long, thin shapes such as wires and turnings may not fall through the sieve when shaken. If the wire or turning could be picked up and poked through the mesh it must be rejected, even if it did not fall through unassisted.

      - Wires or turnings may form a tangled ball which will not fall through the sieve. If the wire or turning could be separated and poked through the sieve, it must be rejected.

      - Foils, thin chips or shards (any item less than 1/8-in. thick) must be rejected.

      ii. The metal pieces that are not rejected by the criteria above are acceptable for loading according to Step 7.

6. Load the rejected broken HEU metal and alloy content in a sealed container under an inert cover gas (e.g., argon or nitrogen).

   Note: The sealed container with an inert atmosphere will be leaktight as defined in ANSI N14.5-1997.

7. All contents are loaded in appropriate cans, bottles, or bags with associated packing material in accordance with the allowable loading limits and restrictions specified in Sect. 1.2.2.

7.1.1.2 Packaging preparation

Operating personnel shall ensure that:

1. A valid leak-test sticker is present on the drum to ensure that the required periodic maintenance (Sect. 8.2) and leak testing has been performed.

2. For planning purposes, the following conditions will be satisfied:

   a. The package will arrive at its destination prior to the expiration of the CoC;

   b. The package must be loaded in the approved conveyance and the conveyance operator must take custody of the package prior to the leak-test expiration date [recorded on the leak-test label (see Fig. 8.1) on the exterior of the drum]; and

   c. When shipping HEU oxides or uranyl nitrate crystals (UNX), the shipper must verify that the shipment can be completed within the time period allotted [2 or 4 months from CV closure for UNX crystals (Table 1.3a) or 1 year from CV closure for HEU oxides (Table 1.3)].

3. The level of nonfixed radioactive contamination on the external surfaces of the packaging is ALARA and within the limits specified in 49 CFR 173.443 for alpha-, beta-, and gamma-emitting radionuclides or the user's site-specific criteria (whichever is more stringent).

4. The exterior surface of the packaging is visually inspected for signs of moisture, corrosion, or physical damage and is in good condition.

5. If installed on the empty packaging, the tamper-indicating devices (TIDs) are removed when authorized.

6. The drum hex nuts and washers are removed.

   Note: If the optional RFID monitoring system tag is installed, remove the RFID tag in accordance with the applicable requirements of ANL/DIS-09-5.

7. The drum lid is removed.

8. Site-approved lifting hardware is attached to the top plug threaded lifting holes and the top plug is removed.

9. Accessible portions of the interior of the drum body and top plug are visually inspected for signs of moisture, corrosion, or physical damage and are in good condition.

10. The silicone rubber CV flange pad is removed from the top of the CV.

    Note: A contamination survey of the exposed drum liner and top of the CV may be conducted if there are contamination concerns.

11. The silicone rubber CV flange pad and plug pad are visually inspected for signs of moisture and physical damage. There are no significant gouges, cuts, tears, or nondesign voids in the pads.

    Note: Refer to Sect. 8.2.5.6 for silicone rubber pad rejection criteria.

12. The top of the CV is visually inspected for signs of moisture, corrosion, or physical damage and is in good condition. There are no visible signs of damage and the CV sealing lid is secure.

13. The swivel hoist ring is installed in the CV sealing lid and torqued to 16.27 ± 1.36 N·m (12 ± 1 ft-lb) [Drawing M2E801580A011, Appendix 1.3.7].

14. The CV is lifted from the drum body using the swivel hoist ring and site-approved lifting equipment, and the exterior surface of the CV is visually inspected for signs of moisture, corrosion, or physical damage.

15. Comparisons of the serial number etched on the following locations are in agreement:

    a. trefoil data plate located on the side of the drum body,
    b. side of the CV body,
    c. top of the CV sealing lid, and
    d. top of the CV lid closure nut.

16. The leak-test labels are present on the drum and the CV with the recorded expiration date.

17. The drum liner is visually inspected for signs of moisture, corrosion, or physical damage.

18. The aluminum foil tape applied over the neutron-absorbing material cavity fill and vent holes (four places) located on the drum liner lower shelf (Drawing M2E801580A002, Appendix 1.3.7) is visually inspected for damage such as tears, holes, or loose edges.

19. The silicone rubber CV bottom pad is installed in the bottom of the drum cavity. If necessary, the CV bottom pad is removed and visually inspected for signs of moisture and physical damage. There are no significant gouges, cuts, tears, or nondesign voids in the pad.

    Note: Refer to Sect. 8.2.5.6 for silicone rubber pad rejection criteria.

20. In order to support the CV during disassembly and loading operations, users have two options:

    a. Install a site-approved support plate on the top of the drum body and lower the CV into the drum body with the CV flange resting on the support plate; or

    b. Lower the CV into a site-approved support stand.

21. The swivel hoist ring is removed from the CV sealing lid.

22. The CV lid assembly is removed and placed on a protective surface to prevent scratching of the sealing surface.

    Note: A contamination survey of the CV interior surfaces may be conducted if there are contamination concerns.

23. Any packing materials (e.g., convenience cans or bottles; polyethylene, nylon, or Teflon bags, silicone rubber can pads; can spacers; stainless-steel metal scrubbers), if present, are removed from the CV.

24. The interior of the CV is visually inspected for signs of moisture, corrosion, or physical damage and is in good condition.

25. Isopropyl alcohol and lint-free gloves, cloths, or swabs are used to clean the CV interior surface, as necessary.

7.1.2 Loading of Contents

The user shall develop detailed operating procedures which include, at a minimum, the process steps listed below for loading content into the CV. Operating personnel shall ensure that:

1. The CV has been emptied of radioactive contents as far as practical.

2. The O-rings and the O-ring grooves on the CV flange are protected from damage during loading operations.

3. The HEU content and associated packing materials (e.g., convenience cans or bottles; polyethylene, nylon, or Teflon bags; silicone rubber can pads; can spacers; stainless-steel metal scrubbers) are prepared for loading in accordance with the requirements of Sect. 1.2.2. The weight of the CV payload (HEU content including all packing materials) shall not exceed 40.82 kg (90 lb).

4. The CV payload is loaded into the CV body in accordance with Sect. 1.2.2.

7.1.2.1 CV assembly and leak testing

The user shall develop detailed operating procedures which include, at a minimum, the process steps listed below for preparing the CV for closure and leak testing. Operating personnel shall ensure that:

1. The CV O-rings and sealing surfaces are cleaned and inspected as follows:

   Note: The O-rings are retained in half-dovetail grooves and may be removed from the CV flange grooves as necessary to facilitate cleaning and inspection activities. Exercise care during removal and installation to avoid damage to the O-rings and O-ring grooves.

   a. Clean the sealing surfaces and O-rings, as required, with isopropyl alcohol and lint-free gloves, cloths, or swabs.

   b. Visually inspect the sealing surfaces for foreign matter, nicks, and scratches. If nicks or scratches are found, review Sect. 8.2.2 for evaluation criteria.

   c. Visually inspect the inner and outer O-rings for roughness, porosity, or surface defects. Damaged O-rings may be replaced with certified replacement O-rings (Table 7.1) subject to the requirements of Sect. 8.1.5.1 and the following:

      i. If the outer O-ring is damaged and requires replacement, then it can be replaced without performing the maintenance leakage rate testing (Sect. 8.2.2).

      Note: The outer O-ring is not part of the containment boundary. The outer O-ring functions as a seal to create the annulus between the O-rings in support of preshipment leak testing.

      ii. If the inner O-ring is damaged and requires replacement, the HEU content shall be removed (see Steps 14-16 in Sect. 7.2.2), and the leakage testing of the containment boundary shall be performed in accordance with Sect. 8.2.2 by qualified personnel.

      Note: Although only the inner O-ring is installed during the leakage testing (Sect. 8.2.2), both O-rings will be replaced during periodic maintenance in accordance with Sect. 8.2.3.1.

2. The O-rings are lubricated as necessary with a thin coat of Super-O-Lube and inserted into the CV flange grooves.

3. The CV lid closure nut threads are visually inspected for damage and foreign matter. If necessary, clean the threads with lint-free gloves, cloths, or swabs.

4. A thin coat of Krytox grease, Grade 240 AC, is applied as necessary to the CV lid closure nut threads (Drawing M2E801580A011, Appendix 1.3.7).

5. The CV lid assembly is positioned over the CV body with the two alignment pins in the CV flange engaged in the slots on the underside of the CV lid assembly.

6. The CV lid closure nut is torqued to 162.7 ± 6.78 N·m (120 ± 5 ft-lb) [Drawing M2E801580A011, Appendix 1.3.7].

   Note: If the content is HEU oxide or uranyl nitrate crystals (UNX), the seal date is recorded (see Sect. 7.1.1.2, Step 2c).

7. The annulus between the CV O-rings is leak tested to either (1) a leakage rate of not more than the reference air leakage rate, L_R, or (2) no detected leakage when tested to a sensitivity of at least 1×10^{-3} ref-cm^3/s in accordance with the requirements of ANSI N14.5-1997, Subclause 7.6, Preshipment leakage rate test. The preshipment leak-test procedure shall meet the requirements of ANSI N14.5-1997 and the site-approved QA program. Y-12 Product Specification Procedure Y51-01-B2-R-074, *Shipping Container Leak Test* (Appendix 7.5.2) is provided as an example preshipment leak-test procedure. It should be noted that the leakage rate acceptance criteria stated in Procedure Y51-01-B2-R-074 is lower (i.e., more conservative) than the ANSI N14.5-1997 requirements noted above for a preshipment leak test. Operating personnel shall perform the following at a minimum:

   a. Ensure that the preshipment leak testing is performed in accordance with procedures that meet the criteria presented above and that the results are properly documented.

   b. Ensure that leak-test instrumentation has been properly calibrated.

   c. Remove the modified VCO threaded brass plug from the CV lid assembly leak-test port.

      Note: If the plug O-ring is not retained on the VCO threaded plug during plug removal, then use caution when extracting the plug O-ring to prevent damage of the leak-test port O-ring sealing surface.

   d. Connect the leak-test equipment to the leak-test port.

   e. Perform the preshipment leak test under isothermal conditions.

   f. Disconnect the leak-test equipment.

   g. Install the modified VCO threaded brass plug in the CV lid assembly leak-test port.

Following a successful preshipment leak test, the CV is ready to be loaded into the drum body assembly per Sect. 7.1.2.2. However, if the preshipment leak test fails to reach the required vacuum/pressure or fails the leak test, then the following measures should be taken: (1) review the operating procedures; (2) check the leak-test equipment and connections; (3) check the test gauges and instrumentation including verification of calibration and certification records, as necessary; and (4) verify

isothermal test conditions. The user is also cautioned to allow sufficient time after applying the required vacuum or pressure for the O-ring annulus to reach thermal equilibrium.

The CV lid assembly shall be removed if none of the measures described above reveal the root cause for the leak-test failure. Care should be taken to control all parts on removal and then Steps 1-7 specified above shall be repeated. If the preshipment leak test fails again, the HEU content shall be removed by performing Steps 14–16 in Sect. 7.2.2. The packaging and O-rings shall be tagged as "potential" nonconforming parts and returned to the packaging maintenance organization for closer examination and disposition.

7.1.2.2 Drum closure

The user shall develop detailed operating procedures which include, at a minimum, the process steps listed below for preparing the drum assembly for closure. Operating personnel shall ensure that:

1. The CV assembly with HEU content was prepared for loading into the drum body assembly in accordance with Sect. 7.1.2.1.

2. The loaded CV, top plug, drum lid, plug pad, CV bottom pad, CV flange pad, drum nuts and washers, TIDs, and optional RFID monitoring system tag are available.

3. The swivel hoist ring is installed in the CV sealing lid and torqued to 16.27 ± 1.36 N·m (12 ± 1 ft-lb) [Drawing M2E801580A011, Appendix 1.3.7].

4. The loaded CV is lifted using the swivel hoist ring and site-approved lifting equipment.

5. If the CV was loaded while supported in the drum body, then remove the site-approved support plate.

6. The loaded CV is lowered into the drum body cavity and the swivel hoist ring is removed.

7. The CV flange pad is placed over the top of the CV and the plug pad is placed on the top shelf of the drum liner (Drawing M2E801580A001, Appendix 1.3.7).

8. The nylon plug is installed in the top plug vent hole and site-approved lifting hardware is attached to the top plug threaded lifting holes.

9. The top plug is installed in the drum (Drawing M2E801580A001, Appendix 1.3.7) and the lifting hardware is removed.

10. The drum weld studs and hex nut threads are visually inspected for damage and foreign matter. If necessary, clean the threads with lint-free gloves, cloths, or swabs.

11. The drum lid is positioned over the drum with the holes in the lid aligned with the weld studs and the TID lugs, and the lid is lowered into position.

12. The eight 5/8-11 UNC-2B hex nuts with washers (Drawing M2E801580A005, Appendix 1.3.7) are installed and the nuts are torqued to 40.67 ± 6.78 N·m (30 ± 5 ft-lb) [Drawing M2E801580A001, Appendix 1.3.7]. **An impact wrench shall not be used.**

    Note: An optional RFID monitoring system tag may be installed in accordance with the applicable requirements of ANL/DIS-09-5.

13. A nylon plug is installed in each of the four drum vent holes (Drawing M2E801580A002, Appendix 1.3.7).

14. As required by site-specific requirements, either one or two TIDs are attached through the drum TID links.

15. The gross weight of the package does not exceed 190.5 kg (420 lb).

16. All "EMPTY" or inappropriate labels previously affixed to the drum body in conformance with 49 CFR 172, Subpart E are removed, obliterated, or covered. Leak-test labels should not be removed. The drum body is cleaned as necessary including the removal of any adhesive residue from removed labels.

17. The level of nonfixed radioactive contamination on the external surfaces of the package is ALARA and within the limits specified in 49 CFR 173.443 for alpha-, beta-, and gamma-emitting radionuclides or the user's site-specific criteria (whichever is the most stringent).

18. The maximum radiation level at the package surface is measured. In addition, the maximum radiation level at 1 m from the external surface shall be measured to establish the transport index (TI) for the package. The radiation levels should be compared with the expected levels (Chap. 5), as appropriate, and evaluated against the allowable radiation levels prescribed in 10 CFR 71.47 and 49 CFR 173.441.

19. The package is labeled in accordance with 49 CFR 172, Subpart E, and the user shall particularly note the requirements of 49 CFR 172.403, *Class 7 (radioactive) material*.

    Note: All labels shall be vinyl type or placed on plain vinyl tape and applied to the packaging to facilitate removal during maintenance.

20. The package is marked in accordance with 49 CFR 172, Subpart D. The user shall particularly note the requirements of 49 CFR 172.301, *General marking requirements for non-bulk packagings*, and 49 CFR 172.310, *Class 7 (radioactive) materials*.

    Note: For enriched uranium content in the ES-3100, which in aggregate is less than a Type B quantity of material, the proper shipping name and identification number etched on the data plate (Drawing M2E801580A010, Appendix 1.3.7) are appropriate provided that the shipping papers indicate the hazardous material description (e.g., Type A quantity of material) contained in the Type B(U)F packaging.

21. The DOE CoC number [USA/9315/B(U)F-96 (DOE)] is marked on the drum body by one of the following methods:

    a. **Preferred method.** The NRC CoC number [USA/9315/B(U)F-96] will be covered with opaque vinyl tape and the package will be marked near the data plate with the DOE CoC number in letters at least ½-in. high.

    b. **Alternate method.** A "(DOE)" marking in letters at least ½-in. high will be added adjacent to right-hand side of the data plate in line with the NRC CoC number.

    c. **Alternate method.** The DOE CoC number is marked on the data plate in accordance with Drawing M2E801580A010, Appendix 1.3.7.

7.1.3 Preparation for Transport

The transfer of the package to an onsite storage or staging area prior to offsite shipment shall be accomplished in accordance with the facility Safety Analysis Report or the TSD, as applicable. The criticality safety index (CSI) may vary from 0–3.2 for the authorized content and fissile mass loading limits (Table 1.3). Because the dose rate (and therefore the TI) presented in Chap. 5 is conservative,

the actual TI, which is measured at the time of shipment, should be lower than the maximum calculated TI value for the HEU content (TI = 6.2 for 36 kg of HEU metal and TI = 5.1 for 24 kg of HEU oxide (Tables 5.1 and 5.2, respectively). These TI values are greater than or equal to the TI values for the other authorized content and fissile mass loading limits (Sect. 5.1.1).

In support of criticality safety evaluations (Sect. 6.3.1.4) and due to the potential exposure to environmental elements during transfer or handling operations, all packages prepared for air transport will be appropriately covered with an industry-standard drum cover or other waterproof cover to protect against water from entering the drum cavity. After loading in the aircraft, the drum covering may be removed to facilitate tie down of the package.

7.1.3.1 Package transfer or handling

The user shall develop detailed operating procedures which include, at a minimum, the process steps listed below for preparing the package for transfer or handling. Operating personnel shall ensure that:

1. The level of nonfixed radioactive contamination on the external surfaces of the package is ALARA and within the limits specified in 49 CFR 173.443 for alpha-, beta-, and gamma-emitting radionuclides or the user's site-specific criteria (whichever is more stringent).

2. Appropriate package labels are affixed to the package's surface and TIDs are properly installed.

3. Placement restrictions associated with onsite handling, storage, staging, or transfer of radioactive materials for onsite operations are identified. These activities are governed by the applicable requirements of the TSD (DOE O 460.1D or DOE O 461.2, as appropriate) and the facility Safety Analysis Report (10 CFR 830).

4. All packages prepared for air transport will be appropriately covered with an industry-standard drum cover or other waterproof cover to protect against water from entering the drum cavity. After loading in the aircraft, the drum covering may be removed to facilitate tie down of the package.

7.1.3.2 Decontamination

As the package is prepared to enter the public domain, the surface contamination level of the package will be maintained ALARA. The user shall develop detailed operating procedures for decontaminating packages that consider, at a minimum, the items listed below:

1. The drum is austenitic stainless steel.
2. The drum nuts are silicon bronze.
3. The drum vent holes are covered with nylon plugs (Drawing M2E801580A002, Appendix 1.3.7).
4. The labels and markings on the drum must remain legible.

7.1.3.3 Requirements prior to shipment

The shipper shall notify the receiver of the scheduled shipment [49 CFR 173.22(c)] and verify that the receiver has agreed to accept the shipment. If needed, the shipper shall provide any special instructions to the receiver to safely open the package (10 CFR 71.89), including special tools and precautions for handling or unloading. In addition, the shipper will submit appropriate documentation to the receiver to ensure that the physical characteristics and hazards of the HEU content are conveyed (49 CFR 172, Subpart C).

Before each shipment, the shipper shall ensure that the appropriate routine determinations (10 CFR 71.87) and the quality control requirements (49 CFR 173.475) have been satisfied. Detailed operating procedures shall provide evidence that the requirements stated above are met and ensure that:

1. The package has been loaded properly and preparation for shipment has been followed, witnessed, and checked.

2. When shipping HEU oxides or UNX, the shipper provides the receiver with the date that the CV was sealed. The shipper must verify that the shipment can be completed within the time period allotted [2 or 4 months for UNX crystals (Table 1.3a) or 1 year for HEU oxides (Table 1.3)].

3. All records for the shipment are prepared and maintained (Sect. 7.5.1.1) [10 CFR 71.91(a)].

4. The shipping papers including the appropriate shipper's certification (declaration) statement are prepared in accordance with 49 CFR 172, Subpart C.

5. The placarding requirements of 49 CFR 172, Subpart F, are addressed.

6. The emergency response information in accordance with 49 CFR 172, Subpart G, is addressed.

7. As determined by 49 CFR 172.800, security plans are developed in accordance with 49 CFR 172, Subpart I.

7.1.3.4 Securing to the approved conveyance

The package shall be secured against movement within the conveyance in which it is being transported under conditions normally incident to transportation. The user shall develop detailed operating procedures that include, at a minimum, the process steps listed below for loading and securing the package on the approved conveyance. Operating personnel shall ensure that:

1. An approved conveyance is used in accordance with the CoC-authorized mode of transport.

2. Reasonable precautions such as wheel chocking are taken to prevent motion of the conveyance during package loading.

3. The package must be loaded in the approved conveyance and the conveyance operator must take custody of the package prior to the leak-test expiration date [recorded on the leak-test label (see Fig. 8.1) on the exterior of the drum].

4. The consignment is positioned on the conveyance under the direction of qualified personnel in such a way that the weight is properly distributed over the width and length of the conveyance.

5. The ends, sides, or doors of the conveyance are not relied upon to prevent shifting of loads.

6. The package is secured in the conveyance using blocking, bracing, and tie-down equipment that meet industry-standard practices to prevent shifting during Normal Conditions of Transport (NCT) [49 CFR 173.448(a); 49 CFR 175.88(c) and 49 CFR 177.842(d)].

7.2 PACKAGE UNLOADING

Placement restrictions associated with onsite handling, storage, staging, or transfer of radioactive materials for onsite operations will be identified. These activities are governed by the

applicable requirements of the TSD (DOE O 460.1D or DOE O 461.2, as appropriate) and the facility Safety Analysis Report (10 CFR 830).

If HEU oxide or UNX are being shipped, the receiver shall check the seal time and date before opening the container (shipment time restrictions for these contents are discussed in Sect. 1.2.2.8). The receiver shall open the CV prior to the seal time expiring or take special precautions in accordance with the facility Safety Analysis Report requirements when handling and opening the container. Special precautions are associated with the potential buildup of >5 mol % hydrogen in the CV (Appendix 3.5.4). Typical precautions may include, but are not limited to, elimination of ignition sources, gradually opening the CV in a well-ventilated area, or opening the CV in an inert glove box.

7.2.1 Receipt of Package from Carrier

The user shall develop detailed operating procedures that include, at a minimum, the process steps listed below for receiving a package and performing contamination and radiation surveys of the package. Operating personnel shall ensure that:

1. Documentation is received that conveys the physical characteristics and hazards of the package including any special instructions provided in accordance with Sect. 7.1.3.3.

2. When offered by the carrier for delivery, the TIDs on the conveyance (if required) and on the package are examined for signs of tampering. The general appearance of the conveyance and the package are noted.

3. The shipping papers are compared with the consignment, and the package is accepted.

4. The enclosed cargo space of the conveyance is examined for moisture and free liquids. If present, they will be surveyed for contamination and removed.

5. The external surfaces of the package are surveyed for removable radioactive contamination and radiation levels (10 CFR 835.405).

    a. The package nonfixed surface contamination levels are within the limits specified in 49 CFR 173.443 for alpha-, beta-, and gamma-emitting radionuclides or the user's site-specific criteria (whichever is more stringent).

    b. The radiation levels do not exceed the limits specified in 10 CFR 71.47 and 49 CFR 173.441.

6. The conveyance restraint gear was properly used to secure the package.

7. Appropriate labeling and marking of the package is checked for compliance.

8. The package restraint gear is removed and the package is removed from the conveyance.

9. The package is visually inspected for exterior surface damage during shipping or handling.

    Note: If the package surface is damaged, a nonconformance tag shall be completed and attached to the package for subsequent maintenance (10 CFR 71.131).

All users shall include provisions for reporting safety concerns associated with the packaging or its use. The user shall comply with reporting requirements in accordance with DOE O 232.2A, which delineates specific reporting periods in accordance with the category of the occurrence. In addition to the requirements of Sect. 7.5.1.3, incidents requiring notification include the following:

1. Nonfixed radioactive surface contamination is in excess of the limits specified in 49 CFR 173.443.

2. Radiation levels are in excess of the limits specified in 10 CFR 71.47 and 49 CFR 173.441.

3. Discrepancies exist between the shipping papers and the consignment.

4. TIDs are found to be compromised.

5. Adverse conditions are found (i.e., entrapped moisture, noncompliant items/conditions, or visible damage that may significantly reduce the package performance).

7.2.2 Removal of Contents

The user shall develop detailed operating procedures that include, at a minimum, the process steps listed below for removing the contents from the package. Operating personnel shall ensure that:

1. Appropriate labels and markings for the content are affixed to the exterior surface of the drum body.

2. The TIDs remain intact until authorized for removal.

   Note: Notify DOE in accordance with DOE O 232.2A if they are found to be compromised.

3. The drum hex nuts and washers are removed.

   Note: If the optional RFID monitoring system tag is installed, remove the RFID tag in accordance with the applicable requirements of ANL/DIS-09-5.

4. The drum lid is removed.

5. Accessible portions of the top plug and interior of the drum body are visually inspected for signs of moisture, corrosion, or physical damage and are in good condition.

6. Site-approved lifting hardware is attached to the top plug threaded lifting holes, and the top plug is removed.

7. The silicone rubber CV flange pad is removed from the top of the CV.

8. A contamination survey of the exposed drum liner and top of the CV is conducted to determine if there was a release of radioactive material.

   Note: If the nonfixed surface contamination levels exceed the limits specified in 49 CFR 173.443 for alpha-, beta-, and gamma-emitting radionuclides, notify DOE in accordance with DOE O 232.2A.

9. The top of the CV is visually inspected for signs of moisture, corrosion, or physical damage and is in good condition.

10. The swivel hoist ring is installed in the CV sealing lid and torqued to 16.27 ± 1.36 N·m (12 ± 1 ft-lb) [Drawing M2E801580A011, Appendix 1.3.7].

11. The CV is lifted from the drum body using the swivel hoist ring and site-approved lifting equipment and the external surfaces of the CV are visually inspected for signs of moisture, corrosion, or physical damage.

12. In order to support the CV during disassembly and unloading operations, users have two options:

a. Install a site-approved support plate on the top of the drum body and lower the CV into the drum body with the CV flange resting on the support plate; or

b. Lower the CV into a site-approved support stand.

13. The swivel hoist ring is removed from the CV sealing lid.

14. The CV lid assembly is removed and placed on a protective surface to prevent scratching of the sealing surface.

    Note: A contamination survey of the CV interior surface may be conducted if there are contamination concerns.

15. The O-rings and the O-ring grooves on the CV flange are protected from damage.

16. The HEU content and associated packing materials (e.g., convenience cans or bottles; polyethylene, nylon, or Teflon bags; silicone rubber can pads; can spacers; stainless-steel metal scrubbers) are removed from the CV in accordance with site-specific radioactive material handling procedures.

    Note: A contamination survey of the CV interior surfaces and packing materials may be conducted if there are contamination concerns.

17. The HEU content and shipping configuration are compared with the applicable information on the shipping papers and the conditions of approval in the CoC. Instances in which the conditions of approval in the CoC were not observed in making a shipment shall be reported in accordance with Sect. 7.5.1.3.

7.3 PREPARATION OF EMPTY PACKAGE FOR TRANSPORT

General requirements for shipping an empty packaging are provided in 49 CFR 173.428, *Empty Class 7 (radioactive) materials packaging*. The user shall develop detailed operating procedures which include, at a minimum, the process steps listed below to prepare an empty package for transport. Operating personnel shall ensure that:

1. The package has been emptied of radioactive contents as far as practical and the CV internal contamination level does not exceed 100 times the limits in 49 CFR 173.443(a).

2. Isopropyl alcohol and lint-free gloves, cloths, or swabs are used to clean the CV as necessary.

3. The CV sealing surfaces are visually checked for foreign matter, nicks, and scratches. If nicks or scratches are found, review Sect. 8.2.2 for evaluation criteria.

4. The O-rings are free from debris and have not been damaged. The O-rings can be cleaned with isopropyl alcohol and wiped with lint-free gloves, cloths, or swabs.

5. The O-rings are lubricated as necessary with a thin coat of Super-O-Lube and inserted into the CV flange grooves.

6. The CV lid closure nut threads are visually inspected for damage and foreign matter. If necessary, clean the threads with lint-free gloves, cloths, or swabs.

7. A thin coat of Krytox grease, Grade 240 AC, is applied as necessary to the CV lid closure nut threads (Drawing M2E801580A011, Appendix 1.3.7).

8. The CV lid assembly is positioned over the CV body with the two alignment pins in the CV flange engaged in the slots on the underside of the CV lid assembly.

9. The CV lid closure nut is torqued to 162.7 ± 6.78 N·m (120 ± 5 ft-lb) [Drawing M2E801580A011, Appendix 1.3.7].

10. The modified VCO threaded brass plug is installed in the CV lid assembly leak-test port.

11. The CV, top plug, drum lid, plug pad, CV bottom pad, CV flange pad, drum nuts and washers, TIDs, and optional RFID monitoring system tag (depending on site-specific requirements) are available.

12. The aluminum foil tape applied over the neutron-absorbing material cavity fill and vent holes (four places) located on the drum liner lower shelf (Drawing M2E801580A002, Appendix 1.3.7) is visually inspected for damage such as tears, holes, or loose edges.

13. The swivel hoist ring is installed in the CV sealing lid and torqued to 16.27 ± 1.36 N·m (12 ± 1 ft-lb) [Drawing M2E801580A011, Appendix 1.3.7].

14. The CV is lifted using the swivel hoist ring and site-approved lifting equipment.

15. If the CV was supported in the drum body, then remove the site-approved support plate.

16. The CV bottom pad is installed in the bottom of the drum cavity.

17. The CV is lowered into the drum body cavity and the swivel hoist ring is removed.

18. The CV flange pad is placed over the top of the CV and the plug pad is placed on the top shelf of the drum liner (Drawing M2E801580A001, Appendix 1.3.7).

19. The nylon plug is installed in the top plug vent hole and site-approved lifting hardware is attached to the top plug threaded lifting holes.

20. The top plug is installed in the drum (Drawing M2E801580A001, Appendix 1.3.7) and the lifting hardware is removed.

21. The drum weld studs and hex nut threads are visually inspected for damage and foreign matter. If necessary, clean the threads with lint-free gloves, cloths, or swabs.

22. The drum lid is positioned over the drum with the holes in the lid aligned with the weld studs and the TID lugs, and the lid is lowered into position.

23. The eight, 5/8-11 UNC-2B, hex nuts with washers (Drawing M2E801580A005, Appendix 1.3.7) are installed and the nuts are torqued to 40.67 ± 6.78 N·m (30 ± 5 ft-lb) [Drawing M2E801580A001, Appendix 1.3.7]. **An impact wrench shall not be used.**

    Note: An optional RFID monitoring system tag may be installed in accordance with the applicable requirements of ANL/DIS-09-5.

24. A nylon plug is installed in each of the four drum vent holes (Drawing M2E801580A002, Appendix 1.3.7).

25. If required by site-specific requirements, TIDs are attached through the drum TID links.

26. Any inappropriate labels previously affixed to the drum body in conformance with 49 CFR 172, Subpart E are removed, obliterated, or covered. Leak-test labels should not be removed. The drum body is cleaned as necessary including the removal of any adhesive residue from removed labels.

27. The level of nonfixed radioactive contamination on the external surfaces of the package is ALARA and within the limits specified in 49 CFR 173.443(a) for alpha-, beta-, and gamma-emitting radionuclides or the user's site-specific criteria (whichever is more stringent).

28. The "EMPTY" label prescribed in 49 CFR 172.450 is affixed to the drum.

    Note: All labels shall be vinyl type or placed on plain vinyl tape and applied to the packaging to facilitate removal during maintenance.

29. The "Radioactive Material, Type B(U) Package, Fissile UN3328" marking on the ES-3100 data plate is covered with opaque vinyl tape, and the package is marked "UN2908" in accordance with 49 CFR 173.428.

30. The radiation level at any point on the external surface of the package does not exceed 0.5 mrem/h.

31. The package is prepared for shipment as specified in 49 CFR 173.422.

7.4 OTHER OPERATIONS

There are no additional special controls unique to this package.

7.5 APPENDIX

Appendix 7.5.1 Records and Reporting Requirements 7-21
Appendix 7.5.2 Example Leak-Test Procedure, Y-12 Product Specification Procedure Y51-01-B2-R-074, *Shipping Container Leak Test* 7-23
Appendix 7.5.3 Chapter 7 References 7-33

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Appendix 7.5.1
Records and Reporting Requirements

7.5.1.1 Records for each shipment

A record of each shipment shall be maintained for a period of 3 years after the shipment in accordance with Title 10, Part 71, Sect. 91(a), of the Code of Federal Regulations (CFR) [10 CFR 71.91(a)]. As specified in 10 CFR 71.91(c), records are only valid if stamped, initialed, or signed and dated by authorized personnel, or otherwise authenticated. These records shall include:

1. The identification of the packaging by model and serial number.
2. Verification that there were no significant defects in the packaging as shipped.
3. Type and quantity of radioactive material in each package and total quantity for each shipment.
4. Date of the shipment.
5. Any special controls exercised.
6. Name and address of the transferee (receiver).
7. Address to which the shipment was made.
8. Results of the determinations required by 10 CFR 71.87 and 49 CFR 173.475 (including documentation of replacement parts) and conditions of approval in the Certificate of Compliance (CoC).

If requested, records of the package shipping history or other information shall be forwarded to the Y-12 National Security Complex in support of recertification efforts. Additionally, each packaging user shall maintain a file of procedures and operating records associated with the ES-3100. These records shall be available for the U.S. Department of Energy (DOE) Headquarters Certifying Official audits and appraisals upon reasonable notice.

7.5.1.2 Records of packaging history

Users shall maintain sufficient written records to furnish evidence of the quality of packagings for a period of three years after the life of the packaging to which they apply in accordance with 10 CFR 71.91(d). As specified in 10 CFR 71.91(c), records are only valid if stamped, initialed, or signed and dated by authorized personnel, or otherwise authenticated. Inspection, tests, and audit records must identify the packaging by model and serial number, the inspector, the type of observation, the results, the acceptability, and the action taken in connection with any deficiencies noted. These records shall include:

1. Results of determinations required by 10 CFR 71.85 and 49 CFR 173.474.
2. Design, fabrication, and assembly records.
3. Results of reviews, inspections, tests, and audits.
4. Results of monitoring work performance and materials analyses.
5. Results of maintenance, modification, and repair activities.

The user shall permit the DOE Headquarters Certifying Official, or designee, at all reasonable times to inspect the radioactive material, packaging, premises, and facilities in which the radioactive material or packaging is used, provided, constructed, fabricated, tested, stored, or shipped [10 CFR 71.93(a)]. Authorized users shall perform any tests deemed necessary or appropriate by the DOE Headquarters Certifying Official in accordance with 10 CFR 71.93(b).

7.5.1.3 Reports

Users shall include provisions in their operating procedures for reporting safety concerns associated with the packaging or its use. The user shall comply with 10 CFR 71.95 by providing written notification to the DOE Headquarters Certifying Official in accordance with DOE O 232.2A for the following:

1. Instances where there is a significant reduction in the effectiveness of the packaging during use.

2. Details of any defects with safety significance of the packaging after first use.

3. Instances in which the conditions of approval in the CoC were not observed in making a shipment.

In addition, the U.S. Department of Transportation will be notified of hazardous materials incidents during loading, unloading, and temporary storage operations in accordance with 49 CFR 171.15 and 171.16, as appropriate. The user shall particularly note the requirements of 49 CFR 171.15(b)(2) and 49 CFR 171.16(a)(2) and (4).

Appendix 7.5.2
Example Leak-Test Procedure, Y-12 Product Specification
Procedure Y51-01-B2-R-074, *Shipping Container Leak Test*

PET No. 110120

Consolidated Nuclear Security, LLC Y-12 Management Requirements	Product Specification Procedure Title: Shipping Container Leak Test	Number: Y51-01-B2-R-074 Revision: A.9 Supersedes: A.8 Page: 1 of 10 Use Category: REFERENCE

Responsible Organization/Department Assembly/Disassembly Operations					
	Responsible Manager Tracy Roosa /s/ (Signature) 7/17/19 (Date)				
Quality Engineer E. A. Fought /s/ (Signature) 7/17/19 (Date)		Packaging Engineer Chris Smith/email w/Harris Barwick (Signature) 7/17/19 (Date)		CC Review DLH /s/ (Initials) 7/17/19 (Date)	
	Approved for Practice (Signature) (Date)				
Verified to be the latest revision (Initials) (Date)			7/17/19 Effective Date		
Concurrence by the following is documented in the Procedure History File:					
Assembly/Disassembly Operations Facility Operations Management (Operations Manager) (Shift Technical Advisor) Industrial Safety and Hygiene (Industrial Hygiene) (Industrial Safety)		Packaging Engineer Production Support (Criticality Safety Officer)		Radiological Control Safety Analysis Engineering (Nuclear Criticality Safety) Subject Matter Expert Weapons Quality Engineer	

This document has been reviewed by a Y-12 DC/UCNI-RO and has been determined to be UNCLASSIFIED and contains no UCNI. This review does not constitute clearance for Public Release.

Name: Erick Loveland /s/ 53268

Date: 7-17-19

Revision Number	Modification Description	Affected Page(s)
A.8	On Record	
A.9	**19-PMR-403**, OTS Intent modification to remove step stating information about compressor that is not used. Deletions, on page 5, are not denoted with revision bars.	4, 5

TABLE OF CONTENTS

1 APPLICABILITY AND SCOPE 4
2 PRECAUTIONS AND LIMITATIONS 4
3 ACCEPTANCE CRITERIA 4
4 PREREQUISITE ACTIONS 5
4.1 Special Tools, Test Equipment, Parts and Supplies 5
4.2 Field Preparations 5
4.3 Approvals and Notifications 5
5 PERFORMANCE ACTIVITIES 6
5.1 VTI Smart Station 6
5.1.1 VTI Smart Station - System Functional Check 6
5.1.2 VTI Smart Station – Leak Testing 8
6 POST-PERFORMANCE ACTIVITIES 9
6.1 Extended Shutdown 9
7 RECORDS 9
8 APPENDIX 9

1 APPLICABILITY AND SCOPE

To provide instructions for operating the shipping container leak test stations. The VTI Smart Station consists of a touch screen PC, printer, two MKS vacuum gauges, reference volume, vacuum pump, automatic valve manifold, and temperature sensor mounted on a rolling cart. Either one of the systems may be used to perform leak tests on shipping containers.

Applies to the leak test of the O-ring seal found in leak testable inner containers. The VTI Smart Station is capable of determining a leak rate of 1.0×10^{-4} atm-cm^3/sec.

The Orifice Leak Test Station correlates the pressure drop across an orifice as compared to the pressure drop across the orifice when a calibrated leak is installed.

The VTI Smart Station performs a pressure (vacuum) rate of rise test using air as the test gas with the part under vacuum.

Program: WC

2 PRECAUTIONS AND LIMITATIONS

A. Use of standard tools and equipment, as needed, is acceptable without being listed in the tooling/equipment list.

B. The VTI Smart Station leak rate is displayed with the units of measure of "atm-cc/s" which is equivalent to "atm-cm^3/sec."

3 ACCEPTANCE CRITERIA

A. Container has passed the leak test **WHEN** the test result is PASS.

4 PREREQUISITE ACTIONS

4.1 Special Tools, Test Equipment, Parts and Supplies

Supervisor

[1] Ensure the following equipment is available:

- Leak Tester (Appendix A)
- Test Cap
- FAIL Test Standard Leak
- O-ring lube
- Container Leak Test Adapter.

4.2 Field Preparations

Assemblyperson

NOTE *Facility Instrument Air may be connected to the VTI Smart Station via quick disconnect (if equipped) in lieu of on-board compressor.*

[1] Verify leak tester vacuum pump oil level is between minimum and maximum line on gauge.

[2] **IF** the leak tester vacuum pump is **NOT** between the minimum and maximum line on the gauge, **THEN** notify Supervisor.

[3] Ensure printer is ready (i.e., turned on, has paper and ink) for operation.

[4] Ensure leak tester is turned on.

[5] **IF** system was started from power off condition, **THEN** ensure MKS Baratron transducer is allowed at least four (4) hours warm up time.

[6] Verify certification sticker(s) is **NOT** expired.

4.3 Approvals and Notifications

Supervisor

[1] Obtain permission from the Shift Manager to start the Performance Section of this procedure.

5 PERFORMANCE ACTIVITIES

5.1 VTI Smart Station

5.1.1 VTI Smart Station - System Functional Check

Assemblyperson

NOTE 1 *The operator may log in to the leak tester, as necessary, by entering login password.*

NOTE 2 *After the login password is entered, a "Manual Commands" screen may display momentarily, but the screen is not used.*

NOTE 3 *If "Welcome to HP Product Assistant" screen appears, the operator may clear this screen and continue.*

NOTE 4 *A system functional check is to be performed prior to the first leak test of the day/shift in order to verify proper function of the leak tester. Two test volumes (one PASS test and one FAIL test) are run to ensure acceptable operation.*

NOTE 5 *Operator I.D. time limit may expire. Operator I.D. may be re-entered, as necessary.*

[1] **IF** system functional check has already been performed during the current shift, **THEN GO TO** Section **5.1.2**, *VTI Smart Station – Leak Testing.*

[2] Ensure pigtail at back of leak tester is installed.

[3] Perform a PASS function test as follows:

- **[a]** Ensure free end of pigtail is capped.
- **[b]** Double touch VTI icon, as needed.
- **[c]** Enter Operator ID (badge number).
- **[d]** Enter "DT22" in the location designated for Package Model.
- **[e]** Enter "CAP" in the location designated for serial number.
- **[f]** Press the "Start Test" icon.
- **[g]** **IF** alarm lights (e.g., evac. fault or settle press, etc.) activate during test, **THEN** press "ABORT TEST" icon **AND** notify Supervisor.
- **[h]** Receive the printout of the test results.
- **[i]** **IF** result is FAIL (the first attempt), **THEN REPEAT** Steps **5.1.1[3]** - **5.1.1[3][h]** to perform test again.
- **[j]** **IF** result is FAIL (the second attempt), **THEN** notify Supervisor.
- **[k]** **IF** result is PASS, **THEN GO TO** Step **5.1.1[4]**.

5.1.1 VTI Smart Station - System Functional Check (cont.)

Assemblyperson

[4] Perform a FAIL function test as follows:

[a] Remove cap from free end of pigtail.

[b] Connect the FAIL Test Standard Leak (labeled "FAIL") to the free end of the pigtail.

[c] Double touch VTI icon, as needed.

[d] Enter Operator ID (badge number).

[e] Enter "DT22" in the location designated for Package Model.

[f] Enter "FAIL" and the serial number on the standard leak tag (if applicable) in the location designated for serial number.

[g] Press the "Start Test" icon.

[h] **IF** alarm lights (e.g., evac. fault or settle press) activate during test, **THEN** press "ABORT TEST" icon **AND** notify Supervisor.

[i] Receive the printout of the test results.

[j] **IF** result is PASS (the first attempt), **THEN REPEAT** Steps **5.1.1[4]** - **5.1.1[4][i]** to perform test again.

[k] **IF** result is PASS (the second attempt), **THEN** notify Supervisor.

[l] **IF** result is FAIL, **THEN** remove FAIL Test Standard Leak **AND GO TO** Step **5.1.2**.

5.1.2 VTI Smart Station – Leak Testing

Assemblyperson

NOTE 1 *The operator may log in to the leak tester, as necessary, by entering login password.*

NOTE 2 *After the login password is entered, a "Manual Commands" screen may display momentarily, but the screen is not used.*

NOTE 3 *If "Welcome to HP Product Assistant" screen appears, the operator may clear this screen and continue.*

NOTE 4 *Operator I.D. time limit may expire. Operator I.D. may be re-entered, as necessary.*

[1] Ensure the leak test port plug has been removed from the test port on the container to be tested.

[2] Ensure flexible hose from the VTI Smart Station to the container test port, (using the container leak test adapter if necessary is connected).

[3] Double touch VTI icon, as needed.

[4] Enter Operator ID (badge number).

[5] Enter Package Model (e.g., DT22, ES 3100, etc).

[6] Enter Serial Number (last five digits of inner container serial number).

[7] Press "Start Test" icon.

[8] **IF** alarm occurs, **THEN** press "ABORT TEST" icon, **AND** notify Supervisor.

[9] **IF** test results printout is "FAIL," **THEN** perform the following:

- **[a]** Clean **OR** replace O-ring at the end of the pigtail **AND** add O-ring lube, as necessary.
- **[b]** Check pigtail for leaks at leak tester connection **AND** repair or replace, using new metal sealing washer, as necessary.
- **[c]** Notify Supervisor for determination on whether to **RETURN TO** Step **5.1.2[2] OR** disconnect drum **AND** exit procedure.

5.1.2 VTI Smart Station – Leak Testing (cont.)

Assemblyperson

[10] **IF** test result is PASS, **THEN** perform the following:

[a] Attach leak test printout to the associated container documentation.

[b] Verify the serial number of the container matches the serial number of the container on the printout.

[c] Disconnect pigtail from container.

[d] **IF** additional containers will be leak tested, **THEN REPEAT** Steps **5.1.2[1] – 5.1.2[10][c]** until all containers are leak tested.

[e] Install cap onto pigtail.

6 POST-PERFORMANCE ACTIVITIES

6.1 Extended Shutdown

Assemblyperson

[1] **IF** placing the VTI Smart Station into extended shutdown, **THEN** turn off all power to VTI Smart Station.

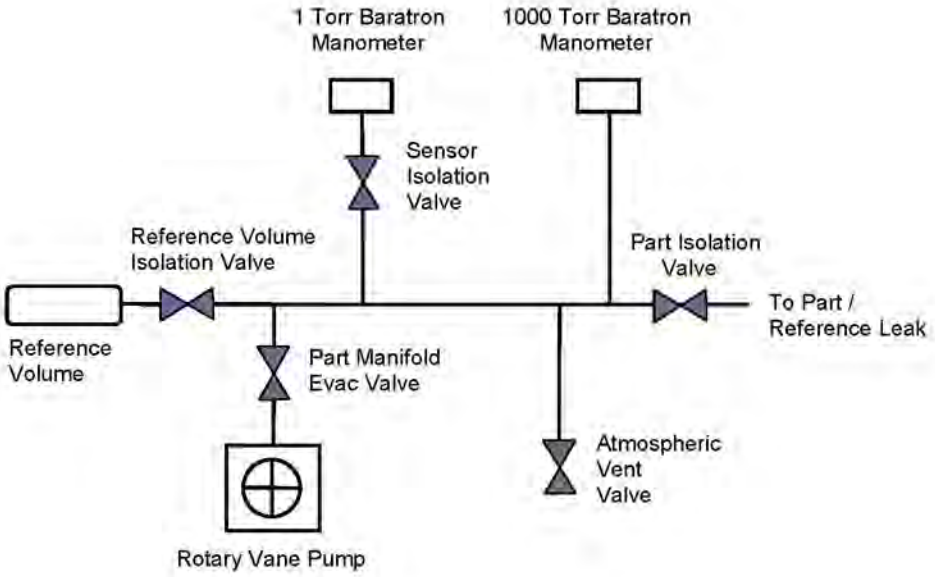
7 RECORDS

No records are generated by the performance of this procedure.

8 APPENDIX

A. VTI Smart Station Manifold

APPENDIX A
VTI Smart Station Manifold
(Page 1 of 1)



Appendix 7.5.3
Chapter 7 References

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DOE O 461.2, *Onsite Packaging and Transfer of Materials of National Security Interest*, U.S. DOE, November 2010.

SAE AMS-R-83485, *Rubber, Fluorocarbon Elastomer, Improved Performance at Low Temperatures*, Aerospace Material Specification, SAE International, Warrendale, Pa., May 1998.

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8. ACCEPTANCE TESTS AND MAINTENANCE PROGRAM

Radioactive material packagings shall be fabricated, procured, and maintained in accordance with applicable U.S. Nuclear Regulatory Commission (NRC), U.S. Department of Transportation (DOT), and other federal, state, and local regulations to protect the health and safety of the public, the workers, and the environment. The basis of the ES-3100 acceptance tests and maintenance requirements is primarily established in the design drawings and equipment specifications that are applied to the packaging components during design and fabrication. The packaging must continue to meet these requirements during its useful lifetime. Acceptance tests and maintenance activities are used to ensure that the design requirements and the conditions of approval in the Certificate of Compliance (CoC) are satisfied in addition to ensuring the integrity of the packaging components with respect to the structural, thermal, containment, shielding, and criticality evaluations in this safety analysis report for packaging (SARP). Furthermore, the packagings shall be fabricated, procured, and maintained according to a quality assurance (QA) plan approved by the U.S. Department of Energy (DOE), Office of Environmental Management; or DOE, National Nuclear Security Administration (DOE/NNSA), as appropriate.

The user is responsible for following the established NRC regulations for packaging, preparation for shipment, and transportation of radioactive materials given in Title 10, Part 71, of the Code of Federal Regulations (CFR) [10 CFR 71] as well as DOT regulations for packaging and shipment of hazardous materials given in Title 49 CFR. DOE nuclear facility users are responsible for implementing DOE regulations given in Title 10, Parts 830 and 835, of the CFR in addition to directives conveyed in DOE Order (O) 232.2A, DOE O 414.1D, and DOE O 460.1D or DOE O 461.1C, as appropriate.

Specific acceptance testing and maintenance criteria for the ES-3100 are presented in this section. Where appropriate, facility management may authorize the adjustment of the explicit implementation sequence in this section to accommodate facility-specific workflow logistics and operational requirements. The packaging owner and user shall develop detailed, written site-specific procedures based on the CoC and the criteria contained herein. These procedures shall be in accordance with 10 CFR 71, Subparts A, G, and H; DOT and DOE regulations; and applicable state, tribal, and local regulations not preempted by DOT.

The packaging acceptance testing and maintenance operations should be consistent with maintaining occupational radiation exposures as low as reasonably achievable (ALARA) [10 CFR 71.87(i)] in addition to addressing applicable safety aspects or activities such as personal protection (radiation, chemical, and physical); contamination or radiation surveys; provisions for reporting safety concerns associated with the packaging or its use; and the records and reporting requirements cited in Appendix 7.5.1.

The ES-3100 packaging description is presented in Sect. 1.2 with a schematic shown in Fig. 1.1 and an exploded view of the packaging components presented in Fig. 1.2. The ES-3100 certification drawing can be found in Appendix 1.3.1. The packaging design drawings (Appendix 1.3.7) provide material lists, dimensions, safety components, welding requirements, and gasket requirements. The maximum gross weight of the ES-3100 package is 190.5 kg (420 lb).

The requirements for fabricating, procuring, and maintaining the packaging are presented in this section. Nonconforming conditions or deficiencies will be appropriately dispositioned to satisfy the applicable design requirements in accordance with 10 CFR 71.131. Rework or repair authorization for packaging components would include applicable nondestructive examinations and pressure/leak testing

as specified in the design requirements. Fabrication requirements for the ES-3100 components are listed on the design drawings (Appendix 1.3.7) and the following specifications:

1. JS-YMN3-801580-A002, *ES-3100 Drum Assembly* (Appendix 1.3.2);

2. JS-YMN3-801580-A001, *ES-3100 Containment Vessel* (Appendix 1.3.3);

3. JS-YMN3-801580-A003, *Manufacturing Process Specification for Casting Kaolite 1600TM into the ES-3100 Shipping Package* (Appendix 1.3.4);

4. JS-YMN3-801580-A005, *Casting Catalog No. 277-4 Neutron Absorber for the ES-3100 Shipping Package* (Appendix 1.3.5);

5. SPC-M801580-0002, *ES-3100 Ethylene Propylene Diene Monomer (EPDM) Containment Vessel (CV) O-rings* (Appendix 1.3.9);

6. SPC M801580-0004, *Heavy Can Spacers* (Appendix 1.3.10);

7. SPC M801794-0003 *Packcrete Preliminary Lot Qualification* (Appendix 1.3.11);

8. SPC M801580-0003 *ES-3100 Packcrete Final Lot Qualification and Production Processing* (Appendix 1.3.12).

The containment vessel (CV) is designed and built to meet American Society of Mechanical Engineers *Boiler and Pressure Vessel Code* (ASME Code), Sect. III, Div. 1, Subsection NB. The ES-3100 includes the following packaging components/assemblies:

1. A drum assembly: body weldment, lid weldment, top plug weldment, CV bottom pad, CV flange pad, plug pad, hex nuts, washers, and paint (Drawing M2E801580A001, Appendix 1.3.7); with a data plate and a trefoil data plate (Drawing M2E801580A010, Appendix 1.3.7).

2. A CV assembly: CV body assembly; CV lid assembly (sealing lid, closure nut, and retaining ring); O-rings; brass VCO (vacuum coupling O-ring) threaded plug; and swivel hoist ring (Drawing M2E801580A011, Appendix 1.3.7).

3. Packing materials, as appropriate: convenience cans or bottles; polyethylene, nylon, or Teflon bags; metal scrubbers; silicone rubber can pads (Drawing M2E801580A024, Appendix 1.3.7); and heavy can spacer assemblies (Drawing M2E801580A043, Appendix 1.3.7).

Care should be exercised to control the packaging components when they are removed to ensure that parts are kept with the packaging and not mixed with other loose parts or parts from other packagings. Other preparations should be made to minimize damage or loss of packaging components. The drum assembly and containment vessel are marked with serial numbers. The numbers are used to control these parts and to accumulate their respective operational and maintenance histories. Applicable serial numbers of packaging components should be verified to ensure that these components are maintained together. Loose parts (e.g., hex nuts, washers, O-rings) may be reused if it can be shown that they were the parts that were removed and that no damage to the parts has occurred. Otherwise, they shall be discarded and replaced with certified parts. In order to maintain configuration control of the packaging components, the user shall ensure that there are no unauthorized modifications and no substitution of components with unauthorized components. The certification of all replacement parts must be traceable. The user shall document any part replacement identifying it to a specific packaging by model and serial number.

The ES-3100 is handled using industry-standard drum-handling equipment. When being moved using a forklift, it can be placed on the tines of the forklift from below. The ES-3100 is also designed for a forklift pincher assembly that can be used to grasp the exterior of the drum assembly. Forklift gripping forces of up to 5400 lb can be used with no detrimental effects on the packaging (Sect. 1.2.1.1).

Site-specific maintenance procedures including the facility's operational requirements shall ensure the following:

1. All appropriate documents have been reviewed by operating personnel and are available for further review, if necessary.

2. Certified equipment is used (e.g., torque wrenches, instrumentation, scales, lifting hardware, and radiation survey instruments) in accordance with the site-approved QA program.

3. Segregated work stations, curtains, lead blankets, personnel protective equipment, or other equipment are used, as necessary, to protect workers and nearby personnel from radioactive material hazards.

4. Appropriate material handling equipment is available and approved for use (e.g., forklifts, hoists, drum handlers). Operating controls shall be implemented for any forklift pincher assembly to limit clamping forces on the drum body (i.e., ≤ 5400 lb).

5. Appropriate provisions to decontaminate packaging components are provided consistent with ALARA principles.

All personnel who support and/or perform fabrication, assembly, testing, and maintenance operations will be appropriately trained and qualified in accordance with the site-approved QA program; 49 CFR 171.1; and 49 CFR 172, Subpart H, as appropriate. Auditable training records will be maintained in accordance with site record retention requirements.

8.1 ACCEPTANCE TESTS

Before the first use of the packaging, the owner shall determine that the packaging has been fabricated in accordance with the approved design including the preliminary determinations (10 CFR 71.85), the quality control for construction of packaging (49 CFR 173.474), and the conditions of approval in the CoC. Guidance provided in NUREG/CR-6314, *Quality Assurance Inspections for Shipping and Storage Containers*, for conducting QA inspections of packaging suppliers may be used as necessary. Acceptance test requirements in Sect. 8.1 are derived from the design drawings and equipment specifications, and their determinations shall be present in the owner's or appropriate supplier's fabrication records as described in Sect. 7.5.1.2. The minimum certification requirements are shown on the ES-3100 certification drawing (Appendix 1.3.1).

The design drawings and specifications indicate the applicable inspections, testing, records, and reports required to properly document the quality of the packaging. The minimum acceptance test and inspection requirements for the packaging components (Tables 8.1 and 8.2) and packing materials (Table 8.3) are presented in the following sections. Prior to first use of the packaging, the user, packaging suppliers, or both shall meet these requirements.

Table 8.1. Acceptance tests for the drum assembly

Component [a]	Inspection	Structural and pressure tests	Leak tests
Double open head drum	Material certification [b], gauging [c], marking, liquid penetrant, weld examinations [d], corrosion, dents	Tensile, percent elongation, yield point, chemistry, pneumatic pressure test [e]	NA [f]
Weld studs	Part certifications, gauging	Tensile, percent elongation, yield point, chemistry	NA
Inner liner weldment	Material certification, weld examinations, gauging	Tensile, percent elongation, yield point, chemistry	NA
Flat cover (drum bottom)	Material certification, gauging	Tensile, percent elongation, yield point, chemistry	NA
Lid weldment	Material certification, weld examinations, gauging	Tensile, percent elongation, yield point, chemistry	NA
Top plug weldment	Material certification, weld examinations, gauging	Tensile, percent elongation, yield point, chemistry	NA
Kaolite 1600 or Packcrete insulation	C of C [g], damage	NA	NA
Cat 277-4 neutron-absorber material	C of C, damage	NA	NA
Hex nuts	C of C, gauging, damage	NA	NA
Washers	C of C, damage	NA	NA
TID [h] lugs	C of C, damage	NA	NA
Data plate and trefoil data plate	Material certification, gauging, marking	NA	NA
Nylon plug	C of C	NA	NA
Paint	C of C, color comparison	NA	NA
Aluminum tape	C of C, damage	NA	NA
Silicone rubber pads (CV bottom pad, CV flange pad, and plug pad)	C of C, damage, marking	NA	NA
RFID monitoring system [i]	NA	NA	NA

[a] ES-3100 drum assembly components (Drawing M2E801580A001, Appendix 1.3.7).
[b] Material certification – Certified quantitative data (physical, mechanical, chemical, functional, dimensional, and/or visual) demonstrating compliance with the drawing/specification requirements.
[c] Gauging refers to dimensional inspections for height, width, thickness, diameter, position, edge breaks, and surface finish.
[d] Weld examinations in accordance with Sect. 8.1.2.
[e] Pneumatic pressure test in accordance with Sect. 8.1.3.3.
[f] NA—Not applicable.
[g] C of C—Certificate of Conformance. A document signed or otherwise authenticated by an authorized individual certifying the degree to which items or services meet the specified requirements.
[h] TID—Tamper-indicating device.
[i] An optional radio-frequency identification (RFID) monitoring system tag may be secured to the drum assembly in accordance with the applicable requirements of ANL/DIS-09-5.

Table 8.2. Acceptance tests for the CV assembly

Component [a]	Inspection	Structural and pressure tests	Leak tests
Body assembly and lid assembly (as applicable)	Material certification [b], gauging [c], marking, liquid penetrant, weld examinations, qualification tests, corrosion, scratches	Tensile, percent elongation, yield point, chemistry, hydrostatic pressure test [d]	Helium leak test [e]
Inner O-ring	Material certification, gauging, packaging, marking	Shore A durometer, elongation	NA [f]
Outer O-ring	Material certification, gauging, packaging, marking	Shore A durometer, elongation	NA
External retaining ring	C of C [g], damage	NA	NA
Modified VCO [h] threaded plug with O-ring	C of C, damage	NA	NA

[a] ES-3100 CV assembly components (Drawing M2E801580A011, Appendix 1.3.7).
[b] Material certification – Certified quantitative data (physical, mechanical, chemical, functional, dimensional, and/or visual) demonstrating compliance with the drawing/specification requirements.
[c] Gauging refers to dimensional inspections for height, width, thickness, diameter, position, edge breaks, and surface finish.
[d] Hydrostatic pressure test in accordance with Sect. 8.1.3.3.
[e] Leakage test in accordance with Sect. 8.1.4.
[f] NA—Not applicable.
[g] C of C—Certificate of Conformance. A document signed or otherwise authenticated by an authorized individual certifying the degree to which items or services meet specified requirements.
[h] VCO—Vacuum coupling O-ring.

Table 8.3. Acceptance tests for packing materials

Component [a]	Inspection	Structural and pressure tests	Leak tests
Silicone rubber pad [b] (can pad)	C of C [c], damage, marking	NA [d]	NA
Heavy can spacer assembly [e]	Material certification [f], sample pour	NA	NA
Convenience cans	C of C, damage	NA	NA
Convenience bottles	C of C, damage	NA	NA
Polyethylene, nylon, or Teflon bags	C of C, damage	NA	NA
Metal scrubbers	C of C	NA	NA

[a] ES-3100 CV packing materials, as appropriate (see Sect 1.2.2.4).
[b] Drawing M2E801580A024, Appendix 1.3.7.
[c] C of C—Certificate of Conformance. A document signed or otherwise authenticated by an authorized individual certifying the degree to which items or services meet specified requirements.
[d] NA—Not applicable.
[e] Packing material, as appropriate, not part of CV (Drawing M2E801580A043, Appendix 1.3.7).
[f] Material certification – Certified quantitative data (physical, mechanical, chemical, functional, dimensional, and/or visual) demonstrating compliance with the drawing/specification requirements.

8.1.1 Visual Inspections and Measurements

Visual inspections with the unaided eye of all pertinent features of the packaging shall be performed during fabrication. There shall be no cracks, pinholes, uncontrolled voids, or other defects that could significantly reduce the effectiveness of the packaging [10 CFR 71.85(a)]. These inspections include paint color; surface condition; marking content; gauging (toleranced dimensions, positioning, edge breaks, surface finish); and welding. The required inspections are summarized in Tables 8.1–8.3.

8.1.1.1 Paint color

Paint color, which is not a safety item, is used to identify, segregate, and document packagings. The acceptance criteria for paint color are given in the drawings (Appendix 1.3.7). Incorrect or incomplete application of paint is cause for rejection. An application of incorrect letters or misspelled words is also cause for rejection.

8.1.1.2 Surface condition

The surfaces of the drum assembly and CV shall be visually inspected for penetrations, dents, and corrosion. Dents >1-in. deep in the drum body will be cause for the drum body to be reworked to remove the dent. The CV surfaces must be in accordance with the dimensional requirements on the drawings (Appendix 1.3.7). Penetrations (e.g., cracks, pinholes, other defects) in the drum or CV will be cause for the component to be rejected.

The packaging components (i.e., complete assembly or individual parts) will be stored in weather-protected indoor facilities. However, before acceptance of any component, accessible surfaces shall be inspected for corrosion. The presence of surface corrosion on any component will be cause for further inspection. If the corrosion can be easily wiped off and no pitting is apparent beneath it, the component is acceptable. If the corrosion cannot be easily wiped off, if scaling is present, or if pitting is observed, the component must undergo a dimensional inspection, including nondestructive examinations as necessary, to determine the extent of the damage before the packaging component can be used. If the corrosion has compromised the structural integrity of the component (i.e., the component no longer meets dimensional or surface finish criteria for a new part as specified on the design drawings), then the component shall be rejected.

8.1.1.3 Marking packaging components

Markings on the packaging components provide traceability for the fabrication, operation, and maintenance of the packaging components. All markings (e.g., model number, serial numbers, instructions, identification) shall be compared with the acceptance criteria (e.g., paint color, etching, dimensions) for markings on the design drawings (Appendix 1.3.7) or equipment specifications, as appropriate. Incorrect or incomplete marking is cause for rejection.

8.1.1.4 Gauging

The ES-3100 design drawings list the dimensions/tolerances; positions (e.g., bolt holes, grooves, leak-test port); edge breaks; and surface finishes. A “Diamond I” or “Diamond S” symbol is used on the drawings or equipment specifications to designate significant dimensions or features, which are specifically inspected and documented in the inspection reports. Inspection of gauging features will be performed on dimensions to ensure that each component meets the applicable tolerances, which are provided on the drawings. Gauging outside the tolerance is cause for rejection.

8.1.2 Weld Examinations

As discussed in Sect. 2.3, *Fabrication and Examination*, all welded or weld-repair surfaces shall be visually examined by a qualified weld examiner for indications of inclusions, cracks, or porosity using a written weld examination procedure. Weld examiners are qualified to perform weld inspections in accordance with the techniques specified on the applicable design drawings and equipment specifications. Weld symbols are provided on the design drawings indicating for each weld the type of weld and dimensions of weld. These weld symbols are interpreted in accordance with American Welding Society (AWS) A2.4. For a detailed description of the drum assembly and CV manufacturing requirements, see the appropriate equipment specification and the following SARP sections:

Drum Assembly [JS-YMN3-801580-A002 (Appendix 1.3.2)]

- Section 2.3.1.1, Drum assembly fabrication.
- Section 2.3.2.1, Examination of the drum assembly fabrication.

Containment Vessel [JS-YMN3-801580-A001 (Appendix 1.3.3)]

- Section 2.3.1.2, Containment boundary fabrication.
- Section 2.3.2.2, Examination of the containment vessel fabrication.

8.1.3 Structural and Pressure Tests

Structural tests for the drum and CV include mechanical properties and chemical tests to ensure that the correct materials are used. The CV is hydrostatically pressure tested to ensure that the supplier's fabrication meets the requirements. These tests are discussed below. The drum body is pressure tested (Sect. 8.1.3.3) in accordance with the QA provisions in Military Specification MIL-D-6054F, *Drum, Metal—Shipping and Storage*.

8.1.3.1 Mechanical property tests

The design drawings or equipment specifications specify the requirements for the packaging materials. The mechanical properties and specifications for these materials are discussed in Sect. 2.2.1 and summarized in Tables 2.12–2.17. Visual examination and mechanical property testing requirements for the O-rings are discussed in Sect. 8.1.5.1. An out-of-specification property is cause for rejection.

8.1.3.2 Chemical tests

Tests shall be performed to determine the chemical properties of the packaging materials. The acceptance criteria and their sensitivity are provided in the appropriate national material standard specified on the design drawings (Appendix 1.3.7). An out-of-specification chemical property is cause for rejection. Material that cannot be traced to the mill or heat-treatment lot shall be rejected.

8.1.3.3 Pressure tests

The CV assembly shall be hydrostatically pressure tested at 150 ± 5 psig per Sect. 3.6 of JS-YMN3-801580-A001 (Appendix 1.3.3). Visible indication of a leak on the exterior surface of the CV is cause for rejection. This testing exceeds the regulatory requirement in 10 CFR 71.85(b) [1.5 × maximum normal operating pressure] and the requirement stipulated in ASME Code, Sect. III, Div. 1, NB-6200 (1.25 × design pressure). The CV maximum normal operating pressure is 15.576 psig (Appendix 3.5.1) and the CV design pressure is 101.5 psig (DAC-M900000-0003).

The drum pressure test is performed in accordance with Drawing M2E801580A004 (Appendix 1.3.7) to verify the integrity of the welded seam. Typically, one sample drum in each lot fabricated is pressure tested (MIL-D-6054F, Para. 4.6.1). The pressure test is performed prior to the drilling of the four vent holes with the opened ends of the drum sealed. This test is observed by the owner during the First Article Evaluation of the drum. To conduct the pressure test, the drum is pressurized with air to 10 psig as specified in MIL-D-6054F. The compressed air supply line is closed, but the pressure gauge is left connected to the drum. The initial pressure is recorded. All joints and seams are coated with a bubble-supporting film. The drum is turned so that all surfaces may be observed for leakage. Five minutes after the initial pressure is recorded, the final gauge pressure is recorded. If a loss of pressure is observed and no leaks were detected by bubbles, the bubble-supporting film operation is repeated to find any leaks that were not detected initially. Any evidence of leakage is cause for rejection.

8.1.4 Leakage Tests

Following the hydrostatic pressure test, a leak test of the containment boundary shall be performed with the inner O-ring installed in accordance with American National Standards Institute (ANSI) N14.5-1997, Subclause 7.3, *Fabrication leakage rate test*, as prescribed in Sect. 3.7 of JS-YMN3-801580-A001 (Appendix 1.3.3). This leak testing demonstrates that the CV is fabricated properly and that the containment boundary is "leaktight." An integrated air leakage rate exceeding 1×10^{-7} ref-cm^3/s (or equivalent) is cause for rejection. Per ANSI N14.5-1997, the test procedure shall have a sensitivity of 5×10^{-8} ref-cm^3/s (one-half the reference air leakage rate) or equivalent.

As required in JS-YMN3-801580-A001 (Appendix 1.3.3), the containment vessel leakage rate testing will be performed by trained and qualified personnel using certified equipment and written leak-test procedures in accordance with the applicable sections of ANSI N14.5-1997. Y-12 Product Specification Procedure Y51-01-B2-R-140, *He Leak Testing in B2* (Appendix 8.3.1) is provided as an example leak-test procedure.

In addition, a leakage rate test will be performed at initial fabrication on the fully assembled CV with both O-rings installed to demonstrate the functionality of the leak-test port and sealing capability of the outer O-ring. The leak testing acceptance criterion is that the CV shall not have an air leakage rate $>1 \times 10^{-4}$ ref-cm^3/s. Y-12 Product Specification Procedure Y51-01-B2-R-074, *Shipping Container Leak Test* (Appendix 7.5.2) is provided as an example leak-test procedure.

8.1.5 Component and Material Tests

8.1.5.1 Containment vessel O-rings

The O-ring visual inspection and mechanical tests are described below. Additionally, the fabrication leak test (Sect. 8.1.4), the periodic and maintenance leak tests (Sect. 8.2.2), and the preshipment leak test (Sect. 7.1.2.1) verify the functionality of the O-rings.

Visual inspection

A visual inspection of the O-ring surface shall be performed. The surface shall be smooth, nonporous, and free of skin defects. O-rings that do not meet these requirements shall be rejected.

Each O-ring shall be packaged separately to provide traceability. Each O-ring package shall be marked with the O-ring identification number, lot number, cure date, compound number, and established expiration date. The material identification numbers shall be assigned uniquely to each lot and to each size of O-ring. The identifications shall be adequate to trace the O-rings to their raw material

master batch. Improper packaging or marking is cause for rejection. Additionally, no O-ring shall be installed after the established expiration date noted on the manufacturer's packaging.

Mechanical properties

The O-ring material mechanical properties and acceptance criteria shall be in accordance with SPC-M801580-0002 (Appendix 1.3.9) for EPDM O-rings.

8.1.5.2 Valves and pressure-relief devices

The ES-3100 packaging does not incorporate any valves or pressure-relief devices.

8.1.5.3 Neutron-absorber material

The Cat 277-4 neutron-absorber material is specifically designed for criticality safety. Acceptance testing for the Cat 277-4 procurement, preparation, and casting is described in JS-YMN3-801580-A005 (Appendix 1.3.5).

8.1.6 Shielding Tests

No gamma or neutron radiation shielding features are integral to the packaging.

8.1.7 Thermal Tests

A thermal acceptance test is not required for the passive thermal features of this packaging. The maximum decay heat generated by the radioactive material is 5 W (Sects. 1.2.2.7 and 3.1.2), which is negligible. The QA and technical requirements for weighing, mixing, pouring, vibrating, curing and baking the Kaolite 1600 thermal insulation is described in JS-YMN3-801580-A003 (Appendix 1.3.4). The QA and technical requirements for weighing, mixing, pouring, vibrating, curing and baking the Packcrete material are described in SPC M801794-0003 (Appendix 1.3.11) and SPC M801580-0003 (Appendix 1.3.12).

8.1.8 Miscellaneous Tests

No additional tests are required prior to the use of the ES-3100 packaging.

8.2 MAINTENANCE PROGRAM

The ES-3100 maintenance program ensures that the packaging continues to meet the design requirements and the conditions of approval in the CoC. Periodic maintenance inspections and testing requirements verify that the performance of the packaging has not deviated or degraded during use from the authorized configuration. Incidental maintenance activities and routine determinations/quality control requirements (10 CFR 71.87 and 49 CFR 173.475) are authorized and performed during package operations as described in Sect. 7 of this SARP.

Although Subclause 7.5.2 of ANSI N14.5-1997 states that the periodic leakage rate testing shall be conducted within 12 months prior to each shipment, periodic maintenance of the ES-3100 packaging shall be performed on a 2-year basis as discussed in Sect. 4.4. Periodic maintenance is not required during a period of nonuse (i.e., extended storage or inactivity). The user shall verify that the ES-3100 periodic leakage rate testing (ANSI N14.5-1997, Subclause 7.5) and any necessary maintenance leakage rate testing (ANSI N14.5-1997, Subclause 7.4) [including any required corrective maintenance associated

with noncompliant conditions] have been performed within the 2-year period prior to shipment to ensure full compliance with the containment requirements of 10 CFR 71.

Maintenance requirements presented in Sect. 8.2 shall be considered as minimum requirements, and their determinations shall be included in the owner's or user's packaging maintenance records as described in Sect 7.5.1.2. Packaging components may be repaired, reworked, or replaced in accordance with the requirements specified in 10 CFR 71.131 and Sect. 9.3.15.

8.2.1 Structural and Pressure Tests

The ES-3100 packaging does not require any structural tests or pressure tests during periodic maintenance. Welding and structural repair/rework of the containment vessel or drum assembly would involve operations that are considered beyond the scope of routine maintenance.

8.2.2 Leakage Tests

The fabrication leak test (Sect. 8.1.4) must be performed before the first use of the packaging and the periodic leak test is performed on a 2-year basis thereafter while the packaging is in use. The maintenance leak test is performed following the structural repair/rework or replacement of a containment boundary component (e.g., weld repair or inner O-ring replacement).

The user shall develop detailed maintenance procedures which include, at a minimum, the process steps listed below for CV leak testing. Maintenance personnel shall ensure that:

1. The CV periodic maintenance has been performed in accordance with Sect. 8.2.5.2 and the O-ring grooves and sealing surfaces are cleaned, as necessary, with isopropyl alcohol and lint-free gloves, cloths, or swabs.

2. Certified replacement O-rings are obtained in accordance with Sect. 8.2.3.1 and the O-rings are cleaned, as necessary, with isopropyl alcohol and lint-free gloves, cloths, or swabs.

3. The inner O-ring is lubricated with a thin coat of Super-O-Lube and inserted into the CV flange groove.

   Note: Only the inner O-ring is installed during the maintenance or periodic leakage rate testing of the containment boundary.

4. The leak-test fixture is installed as follows:

   a. The leak check flange assembly (Drawing T2E801827A008, Appendix 1.3.7) is positioned over the CV body and lowered into the CV flange.

   b. The leak check flange O-ring has been installed in the O-ring groove.

   c. The CV lid assembly is placed on top of the leak check flange assembly.

      Note: The above fixture installation sequence assumes the use of a leak check flange assembly (Drawing T2E801827A008, Appendix 1.3.7). With facility management approval, an alternate leak-test fixture and installation sequence may be used.

5. The CV is leak tested with the inner O-ring installed in accordance with ANSI N14.5-1997, Subclause 7.4, *Maintenance leakage rate test*, or Subclause 7.5, *Periodic leakage rate test*, to demonstrate that the containment boundary is "leaktight." An integrated air leakage rate exceeding 1×10^{-7} ref-cm^3/s (or equivalent) is cause for rejection. Per ANSI N14.5-1997, the test procedure shall have a sensitivity of 5×10^{-8} ref-cm^3/s (one-half the reference air leakage rate) or equivalent. Maintenance personnel shall ensure the following, at a minimum:

    a. The leak testing is performed by trained and qualified personnel in accordance with the requirements of ANSI N14.5-1997 and the site-approved QA program.

        Note: Y51-01-B2-R-140 (Appendix 8.3.1) is provided as an example leak-test procedure.

    b. Leak-test instrumentation has been properly calibrated.

    c. The leak-test equipment is connected to the leak-test port in the leak check flange assembly.

    d. The leak test is performed under isothermal conditions.

        Note: If the leak test fails, the following measures should be performed: (1) review the operating procedures; (2) check the leak-test equipment and connections; and (3) check the test gauges and instrumentation including verification of calibration and certification records, as necessary. If none of these measures reveal the root cause for the leak-test failure, the following inspections should be considered: (1) visually inspect the O-rings per Sect. 8.2.3.1; (2) visually inspect the O-ring grooves and sealing surfaces per Sect. 8.2.5.2; (3) visually inspect the containment boundary; and (4) perform other nondestructive examinations, as appropriate.

6. Following successful completion of the leak test, the leak-test equipment is disconnected.

7. The CV lid assembly and the leak check flange assembly (or approved alternate leak-test fixture) are removed from the CV body.

8. The outer O-ring is lubricated with a thin coat of Super-O-Lube and inserted into the CV flange groove.

9. The CV lid closure nut threads are visually inspected for foreign matter. If necessary, clean the threads with lint-free gloves, cloths, or swabs and apply a thin coat of Krytox grease, Grade 240 AC, to the threads, as required [Drawing M2E801580A011, Appendix 1.3.7].

10. The CV lid assembly is positioned over the CV body with the two alignment pins in the CV flange engaged in the slots on the underside of the CV lid assembly.

11. The CV lid closure nut is hand tightened.

12. The CV lid assembly has a brass VCO threaded plug installed in the leak-test port.

13. The expiration date (2 years from the leak-test date) and either the signature or badge number of the person who performed the testing or certified the test results shall be entered on two copies of a leak-test label (see example label in Fig. 8.1). One label will be attached to the exterior surface of the CV, and the second label will be attached to the exterior surface of the drum. The leak-test label must contain organization information, "LEAK TEST APPROVED," "DO NOT REMOVE," expiration date, and either the name or badge number of the person (who performed the testing or certified the test results), at a minimum.

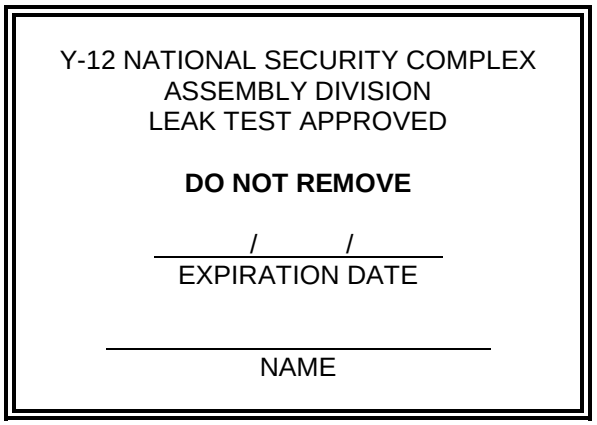


Fig. 8.1. Example label for use on the exterior surface of the containment vessel and the drum.

14. An optional radio-frequency identification (RFID) monitoring system tag may be secured to the drum assembly in accordance with the applicable requirements of ANL/DIS-09-5.

    Note: The mounting bracket for the RFID monitoring system tag shall provide the equivalent contact area of a drum washer and the thread engagement for the drum hex nuts shall remain unchanged.

8.2.3 Component and Material Tests

8.2.3.1 Containment vessel O-rings

The inner and outer O-rings will be replaced during periodic maintenance of the packaging. Certified replacement O-rings (see Sect. 8.1.5.1) are visually inspected for defects such as roughness, porosity, and surface defects. Defective O-rings are discarded. Replacement O-rings (stored in sealed containers) will have an established expiration date marked on the O-ring manufacturer's packaging, and no O-rings shall be installed after the established expiration date.

8.2.3.2 Thermal insulation and neutron-absorber material

Since the Kaolite or Packcrete insulation and Cat 277-4 are encapsulated within the stainless-steel liner, no damage or deterioration is expected. However, the drum, liner, internal flange, flat cover, and top plug shall all be visually inspected for tears or punctures or other defects that would allow for the escape of insulating or neutron-absorbing material. The drum assembly and top plug will be weighed prior to first use and during periodic maintenance to evaluate density variations in the insulation (Kaolite 1600 or Packcrete) or the Cat 277-4. For the purpose of weight comparisons, the drum does not include the lid, pads, nuts, or washers. Weights recorded during periodic maintenance will be compared to the recorded weights prior to first use, and the packaging components will be rejected and evaluated for rework if the weight change of the drum is >10 lb or the weight change of the top plug is >2 lb.

8.2.4 Thermal Tests

There are no periodic maintenance thermal test requirements for the passive thermal features of this packaging.

8.2.5 Miscellaneous Tests

8.2.5.1 Visual inspection for corrosion

The ES-3100 packaging will be stored in weather-protected indoor facilities; thus, surface corrosion is not expected. However, during periodic maintenance inspections, accessible surfaces shall be visually inspected for corrosion, moisture, and damage. The observation of surface corrosion on any component will be cause for further inspection. If the corrosion can be easily wiped off and no pitting is apparent beneath it, the package is acceptable for use. If the corrosion cannot be easily wiped off, if scaling is present, or if pitting is observed, the component must undergo a dimensional inspection, including nondestructive examinations as necessary, to determine the extent of the damage before the packaging component can be used. If the corrosion has compromised the structural integrity of the component (i.e., the component no longer meets dimensional or surface finish criteria for a new part as specified on the design drawings), then the component shall be rejected.

8.2.5.2 Containment vessel maintenance

The CV must be removed from the drum assembly for periodic maintenance inspections. After removing the CV lid assembly, interior and exterior CV surfaces shall be examined for signs of moisture, corrosion, or physical damage. Any CV exhibiting signs of moisture inside will be tagged and segregated until the cause is determined and corrected and the CV has been successfully reinspected. If physical damage has compromised the structural integrity of the CV [i.e., the component no longer meets dimensional requirements specified on the design drawings (Appendix 1.3.7) or JS-YMN3-801580-A001 (Appendix 1.3.3)] the component shall be rejected. Repair/rework authorization of damaged surfaces would include any nondestructive examinations and pressure/leak-test requirements in accordance with the design requirements. A repaired component shall meet the established acceptance criteria in Sect. 8.1.

The CV closure nut and CV flange threads shall be cleaned, as necessary, and visually inspected for damage. Minor defects such as small nicks or burrs may be smoothed with a thread file; however, components with damaged threads (evidence of cross-threading, or flattened threads) or excessive wear (visually apparent rounding of the fastener threads) are cause for rejection. Repair/rework of damaged threads on the CV closure nut or body flange would involve operations that are considered beyond the scope of routine maintenance.

The CV sealing lid leak-test port and brass VCO plug threads shall be cleaned, as necessary, and visually inspected for damage. Minor defects such as small nicks or burrs may be smoothed with a thread file or chased with a tap or die, as appropriate; however, components with damaged threads (as determined by the criteria noted above) must be replaced with certified replacement parts. Repair/rework of damaged threads on the CV sealing lid leak-test port would involve operations that are considered beyond the scope of routine maintenance.

The CV lid assembly (Drawing M2E801580A014, Appendix 1.3.7) will be evaluated to ensure that the CV closure nut rotates freely on the CV sealing lid. If there is excessive binding or varying resistance, the external retaining ring will be removed, and the CV lid assembly will be disassembled. The contact surface between the CV sealing lid and closure nut will be cleaned and lubricated with a thin film of Krytox grease, Grade 240 AC (Drawing M2E801580A011, Appendix 1.3.7). The CV sealing lid, closure nut, and external retaining ring will be assembled per Drawing M2E801580A014 (Appendix 1.3.7), and a thin coat of Krytox grease, Grade 240 AC, will be applied to the CV closure nut threads.

If installed, the O-rings will be removed from the CV flange grooves. The sealing surfaces of the CV sealing lid and CV flange grooves will be cleaned, as necessary, with isopropyl alcohol and lint-free

gloves, cloths, or swabs. The O-ring grooves and sealing surfaces will be visually inspected for foreign matter, nicks, and scratches. If nicks or scratches are found, the affected sealing surfaces may be smoothed with a stone or with fine sandpaper to return them to specification. Surface defects or imperfections that impact containment performance and cannot be removed without taking the component out of dimensional specification constitute cause for rejection of the component. Welding and structural repair/rework of the CV would involve operations that are considered beyond the scope of routine maintenance.

8.2.5.3 Subsystem maintenance

Touch-up paint that complies with drawing requirements should be applied to worn or faded packaging markings as necessary. The data plate and trefoil data plate (Drawing M2E801580A010, Appendix 1.3.7) shall be visually examined for legibility of all required information, and the plates will be securely attached to the drum as shown in Drawing M2E801580A031 (Appendix 1.3.7). Interior and exterior surfaces of the drum body shall be visually inspected for signs of moisture, corrosion, or physical damage. Defects in the drum assembly (e.g., tears, broken welds, dents >1-in. deep) are cause for rejection and possible reporting in accordance with Sect. 7.5.1.3.

8.2.5.4 Drum fastener inspection

The drum lid fasteners (5/8-11 UNC-2B silicon-bronze hex nuts and stainless-steel weld studs) shall be cleaned as necessary and visually inspected for damage. Minor defects such as small nicks or burrs may be smoothed with a thread file or chased with a tap, as appropriate; however, fasteners with damaged threads (evidence of cross-threading, or flattened threads) or excessive wear (visually apparent rounding of the fastener threads) must be replaced with certified replacement parts. In addition, the drum hex nuts will be inspected for proper certification markings. If there is any question about the certification status of the hex nuts, all suspect parts shall be replaced with certified replacement parts. Welding and structural repair/rework of a drum weld stud would involve operations that are considered beyond the scope of routine maintenance.

8.2.5.5 Valves and pressure-relief devices

The ES-3100 packaging does not incorporate any valves or pressure-relief devices.

8.2.5.6 Miscellaneous

The silicone rubber pads (Drawing M2E801580A009, Appendix 1.3.7) shall be visually inspected during periodic maintenance to verify that there are no signs of moisture and no significant gouges, cuts, tears, or nondesign voids in the pads that would cause them to be unusable. A silicone rubber pad shall be considered unusable if the following conditions are observed: (1) a through-section cut or tear that extends beyond half of the radial pad width or (2) a gouge or nondesign void larger than 1/2 in. diameter and deeper than 1/8 in. or one half of the pad thickness, whichever is less. Defective pads shall be rejected and replaced

8.3 APPENDIX

Appendix 8.3.1 Example Leak-test Procedure, Y-12 Product Specification
Procedure Y51-01-B2-R-140, *He Leak Testing in B2* 8-17
Appendix 8.3.2 Chapter 8 References 8-39

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Appendix 8.3.1
Example Leak-test Procedure, Y-12 Product Specification
Procedure Y51-01-B2-R-140, *He Leak Testing in B2*

PET No. 110111

Consolidated Nuclear Security, LLC Y-12 Management Requirements	Product Specification Procedure Title: He Leak Testing in B2	Number: Y51-01-B2-R-140 Revision: C.3 Supersedes: C.2 Page: 1 of 22 Use Category: REFERENCE

Responsible Organization/Department Assembly/Disassembly Operations		
	Responsible Manager Abe Mathews /s/ 7/16/19 Signature Date	
Quality Engineer E. A. Fought /s/ 07-11-19 Signature Date	Packaging Engineer Chris Smith per email to Harris Barwick /s/ 7/15/19 Signature Date	CC Review Peggy Hughes /s/ 7/16/19 Signature Date
	Approved for Practice Signature Date	

Verified to be the latest revision Initials Date	7/16/19 Effective Date

Concurrence by the following is documented in the Procedure History File:

Facility Operations Management
(Operations Manager)
(Shift Technical Advisor)
Industrial Safety & Hygiene
(Industrial Hygiene)
(Industrial Safety)
Radiological Control

Packaging and Transportation Engineering
(Packaging Engineer)
Subject Matter Expert
Weapons Quality Engineering

This procedure has been reviewed by a Derivative Classifier and an UCNI Reviewing Official and has been determined to be UNCLASSIFIED and contains no UCNI. This review does not constitute clearance for public release.

Reviewed by: Rashaun A. Williams /s/

Date: 7/16/19

Title: He Leak Testing in B2	Number: Y51-01-B2-R-140 Revision: C.3 Supersedes: C.2 Page: 2 of 22 Use Category: REFERENCE

Revision Number	Modification Description	Affected Page(s)
C.2	On Record.	
C.3	**19-PMR-386, OTS Intent Modification** to fix steps that are switch in order.	13

TABLE OF CONTENTS

1 APPLICABILITY AND SCOPE 4
2 PRECAUTIONS AND LIMITATIONS 4
3 ACCEPTANCE CRITERIA 5
4 PREREQUISITE ACTIONS 5
4.1 Special Tools, Test Equipment, Parts and Supplies 5
4.2 Field Preparations 6
5 PERFORMANCE ACTIVITIES 7
5.1 Helium Leak Testing Using the MS-50 Leak Test Station 7
5.1.1 Performing the MS-50 Operational Check 7
5.1.2 Pumping Down the Containers With the MS-50 Leak Test Station 9
5.1.3 Leak Testing the Containers With the MS-50 Leak Test Station 10
5.2 Helium Leak Testing Using the MS-50GT Leak Test Station 14
5.2.1 Performing the MS-50GT Operational Check 14
5.2.2 Pumping Down the Containers With the MS-50GT Leak Test Station 16
5.2.3 Leak Testing the Containers With the MS-50GT Leak Test Station 17
6 RECORDS 21
7 SOURCE REQUIREMENTS 21
8 APPENDIXES 21
Appendix A, Leak Test Station 22

1 APPLICABILITY AND SCOPE

To provide instructions for operating the helium leak test stations in Building 9204-2. The leak stations consist of Veeco MS-50 or MS-50GT leak detectors, vacuum pumps, pressure gauges, and the connecting valve manifold. This system has a multiple unit capability which allows the system operator to pump down the other units while running a leak test. Although there are multiple roughing pump valves, multiple manifold valves, and multiple vacuum gauges, during Section **5**, *Performance Activities*, **NO** specific valve number alpha designator is given. These valves and gauges are referred to as "valve (gauge) associated with the part under test" to allow the operator to perform a leak test on whichever unit roughs down first.

Applies to leak test equipment used to determine leak rates. The equipment, as currently set-up, is sensitive to Helium leak rates as low as 1×10^{-8} cc/sec.

The component to be tested is first vacuum evacuated. Then the component's exterior surfaces are exposed to a helium atmosphere. The atmosphere internal to the part is then valved into the leak detector to check for the presence of helium. A gross leak is indicated by a severe leak rate that exceeds the value normally encountered for the component being tested, and in some instances, may also exceed the pumping capacity of the vacuum system. A gross leak may be the result of an unacceptable part or a poor quality vacuum test connection.

Program: WC (Weapons Container)

2 PRECAUTIONS AND LIMITATIONS

Industrial Hygiene

A. Nitrile gloves SHALL be worn when using organic solvents (isopropyl alcohol, Right Stuff, etc.).

Industrial Safety

B. Safety shoes SHALL be worn while performing material activities detailed in this procedure.

C. Leather gloves or approved work gloves SHALL be worn, as needed, for work requiring tooling.

Radiological Control (RADCON)

D. RADCON SHALL perform any surveys requested or surveys that are deemed necessary by RADCON.

3 ACCEPTANCE CRITERIA

A. The acceptance criteria for helium leak testing each container is listed in the applicable container refurbishment procedure or work request (e.g., DT-20, DT-22, DT-23, DPP-2, ES-2100, ES-3100, etc.).

4 PREREQUISITE ACTIONS

4.1 Special Tools, Test Equipment, Parts and Supplies

Supervisor or Assemblyperson

[1] Ensure the following equipment is available, as necessary:

- Adhesive tape
- Helium supply bottle with regulator and tubing
- LT-283, LT-285, LT-286, LT-287, or other Leak Test Station(s)
- Leak Test flange for package
- Low Vacuum Source (Shop-Vac®, Wet-Vac™), or equivalent
- Plastic bags.

4.2 Field Preparations

Assemblyperson

[1] Ensure all equipment, fixtures, and accessories are:

- Operable
- Current on required inspection and/or maintenance
- Determined to be in good condition.

[2] Ensure helium supply bottle pressure is 200 psig or greater.

[3] Ensure certification stickers are attached and **NOT** expired on the following:

- Internal Standard Leak
- Pump A Vacuum
- Pump C Vacuum
- Temperature Sensor.

[4] Ensure the printer is on **AND** Leak Rate Results forms are in the paper tray.

[5] Ensure the Leak Detector is set to the test reject point (recipe) related to the acceptance criteria listed in the applicable container refurbishment procedure for the container being tested **OR** check with Packaging Engineer for equivalent detector reject point (recipe) if refurbishment procedure acceptance criteria is not listed in this chart.

Conversion Table	
Acceptance Criteria from Refurbishment Procedure	**Leak Detector Test Reject Point (Recipe)**
≤ 1.0 X 10^{-5} atm-cc/sec of helium	1.0 X 10^{-5} atm-cc/sec of helium
≤ 1.0 x 10^{-5} std-cc/sec helium	1.0 X 10^{-5} atm-cc/sec of helium
≤ 2.0 X 10^{-7}cc/s of helium	1.0 X 10^{-7} atm-cc/sec of helium
≤ 1 × 10^{-7} ref-cm^3/s - air	1.0 X 10^{-7} atm-cc/sec of helium
≤ 1.9 X 10^{-7} cc/s of helium	1.0 X 10^{-7} atm-cc/sec of helium
Atm cc/sec, cc/s, std-cc/sec, and ref- cm^3/s are nominally equal	

5 PERFORMANCE ACTIVITIES

Assemblyperson

NOTE 1 *Section 5.1, Helium Leak Testing Using the MS-50 Leak Test Station, will be used when leak testing with the Veeco MS-50 Leak Test Station.*

NOTE 2 *Section 5.2, Helium Leak Testing Using the MS-50GT Leak Test Station, will be used when leak testing with the Veeco MS-50GT Leak Test Station.*

NOTE 3 *While multiple containers may be in process concurrently on one leak test station, each container must be processed through its respective sub-section before moving to another sub-section.*

NOTE 4 *There are four Veeco Leak Test stations in the Container Refurbishment areas (LT-283, LT-285, LT-286, LT-287). Equipment valve number labels will consist of the appropriate Leak Test system ID and the valve number (e.g., LT-283-PV-101A, LT-286-PV-102A, etc.). For consistency, the Leak Test system ID numbers will be omitted from the label numbers in the procedure leaving only the ending valve numbers (e.g., PV-101A, PV-102A, etc.).*

[1] Notify Supervisor if maintenance is needed for any leak detection equipment.

5.1 Helium Leak Testing Using the MS-50 Leak Test Station

5.1.1 Performing the MS-50 Operational Check

Assemblyperson

NOTE 1 *Any leak detector may be interchanged with any applicable manifold system (i.e., LD 283 may be used with manifold system 284, etc.). The Supervisor gives direction for interchanging manifold systems.*

NOTE 2 *A Veeco operational check is performed by Maintenance, as necessary.*

NOTE 3 *The Veeco MS-50GT leak detector may be used at any of the above listed manifold stations if the respective Veeco LD is down for service. The Supervisor gives direction on making the substitution.*

5.1.1 Performing the MS-50 Operational Check (cont.)

Assemblyperson

[1] Ensure the following valves are CLOSED:

- PV-110, LEAK DETECTOR ISOLATION
- PV-101A, TEST POINT A PUMP ISOLATION
- PV-102A, TEST POINT A LD ISOLATION
- PV-101B, TEST POINT B PUMP ISOLATION
- PV-102B, TEST POINT B LD ISOLATION
- PV-101C, TEST POINT C PUMP ISOLATION
- PV-102C, TEST POINT C LD ISOLATION
- PV-101D, TEST POINT D PUMP ISOLATION
- PV-102D, TEST POINT D LD ISOLATION.

NOTE *The vertically arranged blue soft-keys (numbered 1-5) correspond to settings and selections that appear on the CRT.*

[2] Ensure the roughing pumps are running.

[a] **IF** the roughing pumps will **NOT** turn on, **THEN** notify the Supervisor.

[3] **IF** the Veeco is turned off, **THEN** turn on the Veeco.

[a] **IF** the Veeco will **NOT** turn on, **THEN** notify the Supervisor.

[4] **IF** Veeco is in SLEEP MODE, **THEN** press any key to wake it up.

[5] Verify the READY TO TEST screen is displayed.

[6] **IF** the FIL ON/OFF LED light is off, **THEN** press the FIL ON/OFF key **AND** wait 15 seconds.

[a] **IF** the FIL ON/OFF LED light **DOES NOT** illuminate after 15 seconds, **THEN** notify the Supervisor.

5.1.2 Pumping Down the Containers With the MS-50 Leak Test Station

Assemblyperson

NOTE 1 *Section 5.1.2 may be performed concurrently with other sections in the procedure.*

NOTE 2 *Multiple containers may be pumped down at one time.*

[1] Ensure the following valves are CLOSED:

- PV-101A, TEST POINT A PUMP ISOLATION
- PV-102A, TEST POINT A LD ISOLATION
- PV-101B, TEST POINT B PUMP ISOLATION
- PV-102B, TEST POINT B LD ISOLATION
- PV-101C, TEST POINT C PUMP ISOLATION
- PV-102C, TEST POINT C LD ISOLATION
- PV-101D, TEST POINT D PUMP ISOLATION
- PV-102D, TEST POINT D LD ISOLATION.

[2] **IF** test line(s) are capped, **THEN** remove cap.

[3] Ensure each Containment Vessel's (CV) Leak Test Flange is connected to the following station test line(s), as necessary:

- Test Point A
- Test Point B
- Test Point C
- Test Point D.

NOTE *The bag will be placed on the CV during the respective container refurbishment operating procedure.*

[4] Ensure the CV to be leak tested is fully encapsulated within a plastic bag.

[5] Ensure the PV-101 pump isolation valve(s) associated with the CV to be tested is opened to evacuate CV using the roughing pump.

NOTE *All remaining CVs will continue to be pumped down, with their PV-101 pump isolation valves remaining open.*

[6] **WHEN** the Granville Phillips (GP) vacuum gauge reads maximum vacuum (less than 15 mTorr), **THEN** close the PV-101 pump isolation valve for the CV being tested.

[7] Ensure the PV-101 pump isolation valves remain open for all remaining CVs being pumped down.

5.1.3 Leak Testing the Containers With the MS-50 Leak Test Station

Assemblyperson

NOTE *Leaks may be repaired and the test repeated, as directed by the Supervisor.*

[1] Select Containment Vessel (CV) to be tested.

[2] Remove as much air as possible from the bag, using a Shop-Vac® (Wet-Vac™), or other vacuum source.

[3] Insert the helium fill tube near the bottom of the bag, **AND** secure, as needed.

[4] Ensure the display screen shows READY TO TEST **AND** the appropriate REJECT POINT is displayed.

- **[a]** **IF** the appropriate REJECT POINT is **NOT** displayed, **THEN** perform the following steps:
  - **[i]** Press 5, SETTINGS/HELP on READY TO TEST screen.
  - **[ii]** Press 3, SELECT UP, **OR** 4, SELECT DOWN, on HELP/SETTINGS menu, **UNTIL** TEST RECIPE field is highlighted.
  - **[iii]** Press 2, CHANGE, to access SELECT TEST RECIPE menu.
  - **[iv]** Press 3, SELECT UP, or 4, SELECT DOWN, to specify test recipe with the appropriate REJECT point.
  - **[v]** Press 5, EXIT, to return to test mode.

[5] Ensure ALL of the PV-102 leak detector (LD) isolation valves are closed to isolate the manifold from the leak detector (i.e., upper valves).

[6] Ensure PV-110, LEAK DETECTOR ISOLATION, is OPEN.

NOTE 1 *The READY TO TEST light on the screen goes away when the START button is pressed.*

NOTE 2 *Pressing START a second time after testing begins will halt testing.*

[7] Press **AND** hold START button **UNTIL** leak test begins (this will allow the piping from the VEECO to the leak detector isolation valve to be pumped down by the VEECO before the isolation valve is opened).

NOTE *One CV will be tested at a time. The remaining PV-102 isolation valves for the CVs being pumped down remain closed.*

[8] Open the PV-102 LD isolation valve associated with the CV under test.

5.1.3 Leak Testing the Containers With the MS-50 Leak Test Station (cont.)

Assemblyperson

NOTE 1 *The test start time begins when the plastic bag is full of helium.*

NOTE 2 *To ensure a helium atmosphere, a slight purge of helium may be necessary to keep the bag inflated during testing. Helium must flow into the bag and be purged from a point below the CV being tested throughout the test. This continuous purge may be at a lower helium pressure than the pressure used to inflate the bag.*

[9] Open the Helium Tank Valve **AND** fill the plastic bag with Helium **UNTIL** the bag is full of helium (puffed up).

NOTE *Helium will diffuse through the O-ring in 10 minutes. Testing longer than this can cause a false failed test due to the diffusion process.*

[10] Wait for at least two minutes (minimum time to ensure detector stability) for test to complete.

NOTE *Step **5.1.3[11]** is performed when the CV fails the leak test.*

[11] **IF** LEAK RATE is more than the REJECT set point and the REJECT message is displayed, **THEN** end the test by performing the following:

- **[a]** **WHEN** the leak test time is complete, **THEN** press **AND** hold VENT button **UNTIL** test ends.
- **[b]** Ensure the leak test results are printed.
- **[c]** Close the PV-102 LD isolation valve associated with the CV under test.
- **[d]** Close the Helium Tank Valve.
- **[e]** Ensure the PV-110 is CLOSED.
- **[f]** Ensure the associated PV-101 pump isolation valve is OPEN (to allow the manifold to pump down):
  - PV-101A, TEST POINT A PUMP ISOLATION
  - PV-101B, TEST POINT B PUMP ISOLATION
  - PV-101C, TEST POINT C PUMP ISOLATION
  - PV-101D, TEST POINT D PUMP ISOLATION.

5.1.3 Leak Testing the Containers With the MS-50 Leak Test Station (cont.)

Assemblyperson

[g] **IF** this is the FIRST **OR** SECOND leak test attempt **AND** the CV **DOES NOT** pass the leak test, **THEN** perform the following:

[i] Remove **AND** clean the O-Ring(s).

[ii] **IF** testing an ES-3100 container, **THEN** lubricate the O-ring(s).

[iii] Re-install the O-Ring(s).

[iv] **GO TO** Step **5.1.2[4]**.

[h] **IF** this is the THIRD leak test attempt **AND** the CV **DOES NOT** pass the leak test, **THEN** contact the Supervisor.

Supervisor

NOTE *The Supervisor contacts the Packaging Engineer after the third failed attempt to leak test the Containment Vessel. The Packaging Engineer will determine whether to test the CV again.*

[i] Contact the Packaging Engineer for disposition instructions **AFTER** three failed attempts.

Assemblyperson

[ii] **IF** directed, **THEN** place a UCN-11738, Tag: *Nonconforming Material*, on the Containment Vessel **AND** set the container aside for disposition.

NOTE *Step **5.1.3[12]** is performed when the CV passes the leak test **AND** may be performed at any time **AFTER** the ACCEPT is displayed.*

[12] **IF** the LEAK RATE is less than the REJECT set point **AND** the ACCEPT is displayed, **THEN** end the test by performing the following:

[a] **WHEN** the leak test time is complete, **THEN** press **AND** hold the VENT button **UNTIL** the test ends.

[b] Ensure the leak test results are printed.

[c] Close the Helium Tank Valve.

[d] Remove helium tube.

5.1.3 Leak Testing the Containers With the MS-50 Leak Test Station (cont.)

Assemblyperson

[e] Close the PV-102 leak detector (LD) isolation valve associated with the CV under test.

[f] Ensure the following is recorded on the Leak Rate Results form **AND** attached to the part card:

- Internal Standard Leak SAP # and Expiration Date
- Pump A Vacuum SAP # and Expiration Date
- Pump C Vacuum SAP # and Expiration Date
- Temperature Sensor SAP # and Expiration Date.

[13] **IF** there are remaining CV(s) that have been roughed down (i.e., pumped down) for testing, **THEN GO TO** Step **5.1.2[1]**.

[14] Ensure the helium is turned off.

[15] Ensure the PV-110 is CLOSED.

[16] Disconnect CV(s) from leak test station line(s).

[17] Replace cap(s).

[18] Ensure ALL PV-101 pump isolation valves **AND** PV-102 LD isolation valves are OPEN to evacuate the test lines:

- PV-101A, TEST POINT A PUMP ISOLATION
- PV-102A, TEST POINT A LD ISOLATION
- PV-101B, TEST POINT B PUMP ISOLATION
- PV-102B, TEST POINT B LD ISOLATION
- PV-101C, TEST POINT C PUMP ISOLATION
- PV-102C, TEST POINT C LD ISOLATION
- PV-101D, TEST POINT D PUMP ISOLATION
- PV-102D, TEST POINT D LD ISOLATION.

[19] Ensure the roughing pumps are running.

[a] **IF** roughing pumps are **NOT** running, **THEN** contact Supervisor.

5.2 Helium Leak Testing Using the MS-50GT Leak Test Station

NOTE 1 *Section 5.1, Helium Leak Testing Using the MS-50 Leak Test Station, will be used when leak testing with the Veeco MS-50 Leak Test Station.*

NOTE 2 *Section 5.2, Helium Leak Testing Using the MS-50GT Leak Test Station, will be used when leak testing with the Veeco MS-50GT Leak Test Station.*

5.2.1 Performing the MS-50GT Operational Check

Assemblyperson

NOTE 1 *Any leak detector may be interchanged with any applicable manifold system (i.e., LD 283 may be used with manifold system 284, etc.). The Supervisor gives direction for interchanging manifold systems.*

NOTE 2 *A Veeco operational check is performed by Maintenance, as necessary.*

NOTE 3 *There are four Veeco Leak Test stations in the Container Refurbishment areas (LT-283, LT-285, LT-286, LT-287). Equipment valve number labels will consist of the appropriate Leak Test system ID and the valve number (e.g., LT-283-PV-101A, LT-286-PV-102A, etc.). For consistency, the Leak Test system ID numbers will be omitted from the label numbers in the procedure leaving only the ending valve numbers (e.g., PV-101A, PV-102A, etc.).*

NOTE 4 *The Veeco MS-50GT leak detector may be used at any of the above listed manifold stations if the respective Veeco LD is down for service. The Supervisor gives direction on making the substitution.*

[1] Ensure the following valves are CLOSED:

- PV-110, LEAK DETECTOR ISOLATION
- PV-101A, TEST POINT A PUMP ISOLATION
- PV-102A, TEST POINT A LD ISOLATION
- PV-101B, TEST POINT B PUMP ISOLATION
- PV-102B, TEST POINT B LD ISOLATION
- PV-101C, TEST POINT C PUMP ISOLATION
- PV-102C, TEST POINT C LD ISOLATION
- PV-101D, TEST POINT D PUMP ISOLATION
- PV-102D, TEST POINT D LD ISOLATION.

5.2.1 Performing the MS-50GT Operational Check (cont.)

Assemblyperson

NOTE *The MS-50GT uses touch screen technology rather than soft-key buttons.*

[2] Ensure the roughing pumps are running.

[a] **IF** the roughing pumps will **NOT** turn on, **THEN** notify the Supervisor.

[3] **IF** the Veeco is turned off, **THEN** turn on the Veeco.

[a] **IF** the Veeco will **NOT** turn on, **THEN** notify the Supervisor.

[4] **IF** the Veeco is in SLEEP MODE, **THEN** press any key to wake it up.

[5] Verify the green START button is illuminated.

[6] Press MORE, followed by CALIBRATE (on bottom of screen).

5.2.2 Pumping Down the Containers With the MS-50GT Leak Test Station

Assemblyperson

[1] Ensure the following valves are CLOSED:

- PV-101A, TEST POINT A PUMP ISOLATION
- PV-102A, TEST POINT A LD ISOLATION
- PV-101B, TEST POINT B PUMP ISOLATION
- PV-102B, TEST POINT B LD ISOLATION
- PV-101C, TEST POINT C PUMP ISOLATION
- PV-102C, TEST POINT C LD ISOLATION
- PV-101D, TEST POINT D PUMP ISOLATION
- PV-102D, TEST POINT D LD ISOLATION.

[2] **IF** test line(s) are capped, **THEN** remove cap.

[3] Ensure each Containment Vessel's (CV) Leak Test Flange is connected to the following station test line(s), as necessary:

- Test Point A
- Test Point B
- Test Point C
- Test Point D.

NOTE *The bag will be placed on the CV during the respective container refurbishment operating procedure.*

[4] Ensure the CV to be leak tested is fully encapsulated within a plastic bag.

[5] Ensure the PV-101 pump isolation valve(s) associated with the CV to be tested is opened to evacuate the CV using the roughing pump.

NOTE *All remaining CVs will continue to be pumped down, with their PV-101 pump isolation valves remaining open.*

[6] **WHEN** the Granville Phillips (GP) vacuum gauge reads maximum vacuum (less than 15 mTorr), **THEN** close the PV-101 pump isolation valve for the CV being tested.

[7] Ensure the PV-101 pump isolation valves remain open for all remaining CVs being pumped down.

5.2.3 Leak Testing the Containers With the MS-50GT Leak Test Station

Assemblyperson

NOTE *Leaks may be repaired and the test repeated, as directed by the Supervisor.*

[1] Select the Containment Vessel (CV) to be tested.

[2] Remove as much air as possible from the bag, using a Shop-Vac® (Wet-Vac™), or other vacuum source.

[3] Insert the helium fill tube near the bottom of the bag, **AND** secure, as needed.

[4] Verify the green START button is illuminated **AND** the appropriate REJECT POINT is displayed.

- **[a]** **IF** the appropriate REJECT POINT is **NOT** displayed, **THEN** perform the following steps:
  - **[i]** Press RECIPE.
  - **[ii]** Press LOAD.
  - **[iii]** Enter recipe number.
  - **[iv]** Press ENTER.
  - **[v]** Press LEAK RATE to return to home screen.

[5] Ensure ALL of the PV-102 leak detector (LD) isolation valves are closed to isolate the manifold from the vacuum pump (i.e., upper valves).

[6] Ensure the PV-110, LEAK DETECTOR ISOLATION, is OPEN.

NOTE 1 *The READY TO TEST light on the screen goes away when the START button is pressed.*

NOTE 2 *Pressing START a second time after testing begins will halt testing.*

NOTE 3 *Pressing and holding the START button will allow the piping from the VEECO to the leak detector isolation valve to be pumped down by the VEECO before the isolation valve is opened.*

[7] Press **AND** hold START button **UNTIL** leak test begins.

NOTE *One CV will be tested at a time. The remaining PV-102 isolation valves for the CVs being pumped down remain closed.*

[8] Open the PV-102 LD isolation valve associated with the CV under test.

5.2.3 Leak Testing the Containers With the MS-50GT Leak Test Station (cont.)

Assemblyperson

NOTE 1 *The test start time begins when the plastic bag is full of helium.*

NOTE 2 *To ensure a helium atmosphere, a slight purge of helium may be necessary to keep the bag inflated during testing. Helium must flow into the bag and be purged from a point below the CV being tested throughout the test. This continuous purge may be at a lower helium pressure than the pressure used to inflate the bag.*

[9] Open the Helium Tank Valve **AND** fill the plastic bag with Helium **UNTIL** the bag is full of helium (puffed up), indicating that the test start time begins now.

NOTE *Helium will diffuse through the O-ring in 10 minutes. Testing longer than this can cause a false failed test due to the diffusion process.*

[10] Wait for at least two minutes (minimum time to assure detector stability) for test to complete.

NOTE *Step **5.2.3[11]** is performed when the CV fails the leak test.*

[11] **IF** the LEAK RATE is more than the REJECT set point **AND** the screen displays a red "thumbs down" symbol (upper right-hand corner of screen), **THEN** end the test by performing the following:

- **[a]** **WHEN** the leak test time is complete, **THEN** press **AND** hold the VENT button **UNTIL** test ends.
- **[b]** Ensure the leak test results are printed.
- **[c]** Close the PV-102 LD isolation valve associated with the CV under test.
- **[d]** Close the Helium Tank Valve.
- **[e]** Ensure the PV-110 is CLOSED.
- **[f]** Ensure the associated PV-101 pump isolation valve is OPEN (to allow the manifold to pump down):
  - PV-101A, TEST POINT A PUMP ISOLATION
  - PV-101B, TEST POINT B PUMP ISOLATION
  - PV-101C, TEST POINT C PUMP ISOLATION
  - PV-101D, TEST POINT D PUMP ISOLATION.

5.2.3 Leak Testing the Containers With the MS-50GT Leak Test Station (cont.)

Assemblyperson

[g] **IF** this is the FIRST **OR** SECOND leak test attempt **AND** the Containment Vessel **DOES NOT** pass the leak test, **THEN** perform the following:

[i] Remove, clean, **AND** re-install the O-Ring(s).

[ii] **GO TO** Step **5.2.2[4]**.

[h] **IF** this is the THIRD leak test attempt **AND** the Containment Vessel **DOES NOT** pass the leak test, **THEN** contact the Supervisor.

Supervisor

NOTE *The Supervisor contacts the Packaging Engineer after the third failed attempt to leak test the Containment Vessel. The Packaging Engineer will determine whether to test the CV again.*

[i] Contact the Packaging Engineer for disposition instructions for three failed attempts **AND** set container aside for disposition.

Assemblyperson

[ii] **IF** directed, **THEN** place a UCN-11738, Tag: *Nonconforming Material*, on the Containment Vessel, **AND** set container aside for disposition.

NOTE *Step **5.2.3[12]** is performed when the CV passes the leak test.*

[12] **IF** the LEAK RATE is less than the REJECT set point **AND** the screen displays a green "thumbs up" symbol (upper right-hand corner of screen), **THEN** end the test by performing the following:

[a] **WHEN** the leak test time is complete, **THEN** press **AND** hold the VENT button **UNTIL** the test ends.

[b] Ensure leak test results are printed.

[c] Close the Helium Tank Valve.

[d] Remove helium hose

[e] Close the PV-102 LD isolation valve associated with the CV under test.

[f] Ensure the following is recorded on the Leak Rate Results form **AND** attached to the part card:

- Internal Standard Leak SAP # and Expiration Date
- Pump A Vacuum SAP # and Expiration Date
- Pump C Vacuum SAP # and Expiration Date
- Temperature Sensor SAP # and Expiration Date.

5.2.3 Leak Testing the Containers With the MS-50GT Leak Test Station (cont.)

Assemblyperson

[13] **IF** there are remaining CV(s) that have been roughed down (i.e., pumped down) for testing, **THEN GO TO** Step **5.2.2[1]**.

[14] Ensure the helium is turned off.

[15] Disconnect CV(s) from the leak test station test line(s).

[16] Replace cap(s) on leak test station test line(s).

[17] Ensure PV-110 is CLOSED.

[18] Ensure ALL PV-101 pump isolation valves **AND** PV-102 LD isolation valves are OPEN to evacuate the test lines:

- PV-101A, TEST POINT A PUMP ISOLATION
- PV-102A, TEST POINT A LD ISOLATION
- PV-101B, TEST POINT B PUMP ISOLATION
- PV-102B, TEST POINT B LD ISOLATION
- PV-101C, TEST POINT C PUMP ISOLATION
- PV-102C, TEST POINT C LD ISOLATION
- PV-101D, TEST POINT D PUMP ISOLATION
- PV-102D, TEST POINT D LD ISOLATION.

[19] Ensure the roughing pumps are running.

[a] **IF** the roughing pumps are **NOT** running, **THEN** contact the Supervisor.

6 RECORDS

All records generated as a result of this procedure are maintained in accordance with E-PROC-3114, *Records Management*.

Record Copy Owner	Record(s)	Record Type(s)
Assembly/Disassembly Operations	Leakage test results printout	QA

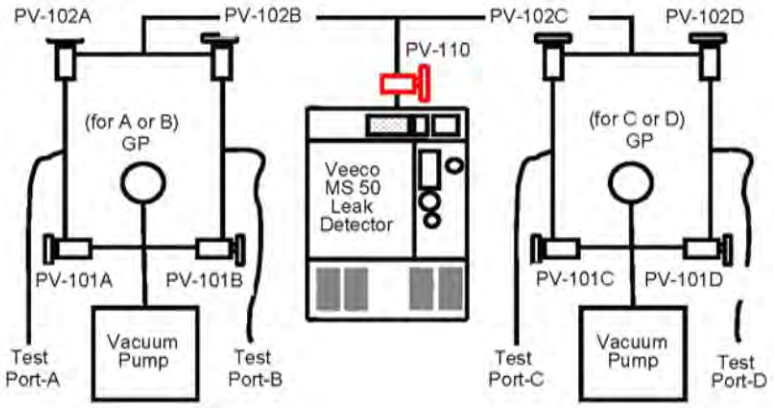
7 SOURCE REQUIREMENTS

- *VIC Leak Detection, MS-50 Automatic Leak Detector System Manual, Vacuum Instrument Corporation, Vacuum Metrology Division, New York*
- *VIC Leak Detection, MS-50 Automatic Leak Detector System Manual (MS-50GT Addendum), Vacuum Instrument Corporation, Vacuum Metrology Division, New York*
- Y60-015, *Integrated Quality Manual.*

8 APPENDIXES

A. Leak Test Station.

Appendix A
Leak Test Station
(Page 1of 1)



Appendix 8.3.2
Chapter 8 References

10 CFR 71, *Packaging and Transportation of Radioactive Material*, January 2019.

10 CFR 830, *Nuclear Safety Management*, January 2019.

10 CFR 835, *Occupational Radiation Protection*, January 2019.

49 CFR, *Transportation,* October 2019.

ANL/DIS-09-5, *Guide to the RFID Monitoring System*, Argonne Natl. Lab., latest revision.

ANSI N14.5-1997, *Radioactive Materials—Leakage Tests on Packages for Shipment*, American Natl. Standards Institute, Feb. 5, 1998.

ASME Boiler and Pressure Vessel Code, Sect. III, Div. 1, Subsection NB, *Class 1 Components*, American Society of Mechanical Engineers, New York, revision at time of fabrication.

AWS A2.4, *Standard Symbols for Welding, Brazing, and Nondestructive Examination*, American Welding Society, Miami, Fla., 2012.

DAC-M900000-0003, C. R. Hammond, *Stress Analysis of ES-3100 Containment Vessel with Viton O-rings*, B&W Y-12, Y-12 National Security Complex, May 23, 2012.

DOE O 232.2A, Chg 1 (MinChg), *Occurrence Reporting and Processing of Operations Information*, U.S. DOE, October 2019.

DOE O 414.1D, Admin Chg 1, *Quality Assurance*, U.S. DOE, May 2013.

DOE O 460.1D, *Hazardous Materials Packaging and Transportation Safety*, U.S. DOE, December 2016.

DOE O 461.1C, Chg 1 (MinChg), *Packaging and Transportation for Offsite Shipment of Materials of National Security Interest*, U.S. DOE, October 2019.

MIL-D-6054F, Amendment 1, *Drum, Metal—Shipping and Storage*, U.S. DoD, June 30, 1989.

NUREG/CR-6314, H. M. Stromberg et al., *Quality Assurance Inspections for Shipping and Storage Containers*, U.S. NRC and Idaho Natl. Engineering Lab., April 1996.

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9. QUALITY ASSURANCE

This chapter of the safety analysis report for packaging (SARP) describes the ES-3100 package quality assurance (QA) requirements that apply to packaging-related activities necessary for the design, fabrication, assembly, testing, maintenance, repair, modification, and use in accordance with applicable U.S. Nuclear Regulatory Commission (NRC), U.S. Department of Transportation (DOT), and other federal, state, and local regulations to protect the health and safety of the public, workers, and the environment. This package must comply with the NRC requirements specified in Title 10 of the Code of Federal Regulations (CFR), Part 71 (10 CFR 71), *Packaging and Transportation of Radioactive Material,* including DOT regulations in Title 49 CFR as cited in 10 CFR 71.5. Furthermore, packaging-related activities shall be performed according to a QA program approved by the U.S. Department of Energy (DOE), Office of Environmental Management; or National Nuclear Security Administration (NNSA), as appropriate. Title 10 CFR 71.101 requires the establishment, maintenance, and implementation of a QA program that satisfies each of the applicable criteria of 10 CFR 71, Subpart H. The applicable criteria shall be executed in a graded approach to an extent that is commensurate with their respective importance to safety.

As used in 10 CFR 71, QA comprises all planned and systematic actions necessary to provide adequate confidence that a system or component will perform satisfactorily in service. Consequently, QA includes quality control, which comprises those QA actions related to control of the physical characteristics and quality of the material or component to predetermined requirements.

9.1 INTRODUCTION

The Packaging and Transportation QA Program has been established at Y-12 in accordance with QAP-Y-91-273860-1, *Packaging and Transportation Quality Assurance Program Plan* (QAPP), which has been approved by the National Nuclear Security Administration (NNSA), Office of Packaging and Transportation (OPT) and endorsed by the DOE Certifying Official. The program was designed and implemented using a graded approach to selectively apply the QA requirements contained in 10 CFR 830, *Nuclear Safety Management*; U.S. Department of Energy (DOE) O 414.1D, *Quality Assurance*; 10 CFR 71; ASME NQA-1, *Quality Assurance Requirements for Nuclear Facility Applications*; and DOE O 460.1D, *Hazardous Materials Packaging and Transportation Safety* or DOE O 461.1C, *Packaging and Transportation for Offsite Shipment of Materials of National Security Interest*, as applicable. The U.S. Nuclear Regulatory Commission (NRC) regulations for packaging, preparation for shipment, and transportation of radioactive materials are given in 10 CFR 71, and DOT regulations for packaging and shipment of hazardous materials are given in Title 49 CFR. DOE nuclear facility users are also responsible for implementing DOE regulations given in 10 CFR 830 and 835, *Occupational Radiation Protection*, in addition to directives conveyed in DOE O 414.1D and DOE O 460.1D or DOE O 461.1C, as applicable. (References to DOE O 460.1D and DOE O 461.1C are used in this chapter because these orders are incorporated into the current conformed contract. However, when this SARP was released the associated QAPP, which has been updated to reference the latest order revisions, is currently under NNSA OPT review.)

The QA requirements and quality control provisions of the program apply to packaging-related activities and services necessary for the design, purchase, fabrication, handling, shipping, storing, cleaning, assembly, inspection, testing, operation, maintenance, repair, and modification of Type B and fissile material packagings for offsite transportation. These requirements are incorporated into an integrated body of packaging activities established to ensure quality. Achieving quality of design, conformance, and performance that meets or exceeds all packaging standards is the essential purpose of this program.

9.2 SCOPE

The design agency (Y-12) and owner of the ES-3100 packaging will implement a QA program that addresses the following QA elements of 10 CFR 71, Subpart H, as well as appropriate suspect/counterfeit item and software quality assurance requirements:

- § 71.103, *Quality assurance organization*;
- § 71.105, *Quality assurance program*;
- § 71.106, *Changes to quality assurance program;*
- § 71.107, *Package design control*;
- § 71.109, *Procurement document control*;
- § 71.111, *Instructions, procedures, and drawings*;
- § 71.113, *Document control*;
- § 71.115, *Control of purchased material, equipment, and services*;
- § 71.117, *Identification and control of materials, parts, and components*;
- § 71.119, *Control of special processes*;
- § 71.121, *Internal inspection*;
- § 71.123, *Test control*;
- § 71.125, *Control of measuring and test equipment*;
- § 71.127, *Handling, storage, and shipping control*;
- § 71.129, *Inspection, test, and operating status*;
- § 71.131, *Nonconforming materials, parts, or components*;
- § 71.133, *Corrective action*;
- § 71.135, *Quality assurance records*; and
- § 71.137, *Audits*.

In accordance with their site-approved QA program, authorized users of the ES-3100 packaging must address the following QA elements, as a minimum:

- § 71.103, *Quality assurance organization*;
- § 71.105, *Quality assurance program*;
- § 71.106, *Changes to quality assurance program;*
- § 71.111, *Instructions, procedures, and drawings*;
- § 71.113, *Document control*;
- § 71.115, *Control of purchased material, equipment, and services*;
- § 71.117, *Identification and control of materials, parts, and components*;
- § 71.121, *Internal inspection*;
- § 71.123, *Test control*;
- § 71.125, *Control of measuring and test equipment*;
- § 71.127, *Handling, storage, and shipping control*;
- § 71.129, *Inspection, test, and operating status*;
- § 71.131, *Nonconforming materials, parts, or components*;
- § 71.133, *Corrective action*;
- § 71.135, *Quality assurance records*; and
- § 71.137, *Audits*.

Additional QA elements may also be addressed as commensurate with the user scope of responsibility (i.e., if authorized for packaging-related design, fabrication, maintenance, repair, or modification activities). All providers of items and/or services must demonstrate that they meet the applicable QA requirements for their respective work scope. Each user of the ES-3100 package must also develop an appropriate site-approved QA plan and related implementing documentation.

9.3 QUALITY ASSURANCE PLAN

The QA requirements from 10 CFR 71, Subpart H are to be selectively applied using a graded approach to the specific packaging programs being developed and implemented. This selective application requires that the detail and magnitude of resources expended for a packaging-related activity be commensurate with the activity's importance to safe and reliable operations, environmental compliance, safeguards and security, programmatic mission, and/or other packaging-specific requirements. As stated in NRC Regulatory Guide 7.10, "structures, systems, and components important to safety mean the features of a Type B or fissile material package that are intended to (1) maintain the conditions required to safely transport the package contents; (2) prevent damage to the package during transport; or (3) provide reasonable assurance that the radioactive contents can be received, handled, transported, and retrieved without undue risk to the health and safety of the public or the environment."

In conjunction with the overall QA Program (E-SD-0002, *Quality Assurance Program Description)*, the QAPP identifies the management system that applies to ES-3100 packages for offsite transportation and describes the method of control over those structures, systems, and components (SSCs) and activities that are important to safety. Section 9.3.1 – 9.3.19 discuss how these requirements are implemented at Y-12 for the ES-3100 package.

9.3.1 Quality Assurance Organization

As described in Sect. 1 of the QAPP, the organizations ultimately responsible for QA within the Y-12 offsite packaging and transportation program are: (1) Packaging and Transportation Engineering (PTE); (2) Production Operations; (3) Quality; (4) Program Integration; and (5) Transportation and Traffic Management. Other Y-12 organizations have QA functions in support of the organizations identified above. An organization chart that depicts PTE and its relationship with the functional and technical support groups that provide items and services or that conduct other activities in support of radioactive material packagings is provided in Fig. 9.1.

PTE is responsible for the development of the QAPP and quality requirements for packaging components designed at Y-12. The PTE Manager has the responsibility for the technical leadership of the program. The PTE organization is part of the Y-12 Engineering division, which reports to the Vice President of Mission Engineering (Fig. 9.1). They also ensure that packagings fully comply with the applicable regulations, requirements, and standards. PTE and the Y-12 QA organizations ensure that the quality of packagings is maintained throughout the design, testing, fabrication, and maintenance processes. PTE is the design authority and primary contact for all packaging-related activities and services necessary for the design, purchase, fabrication, handling, shipping, storing, cleaning, assembly, inspection, testing, operation, maintenance, repair, and modification of Y-12 Type B and fissile material packagings, such as the ES-3100. PTE provides requested technical assistance for other Type B radioactive material packages. The complete description of the engineering roles and responsibilities is described in Y17-69-PE-335PD, *Packaging and Transportation Engineering Program Description*.

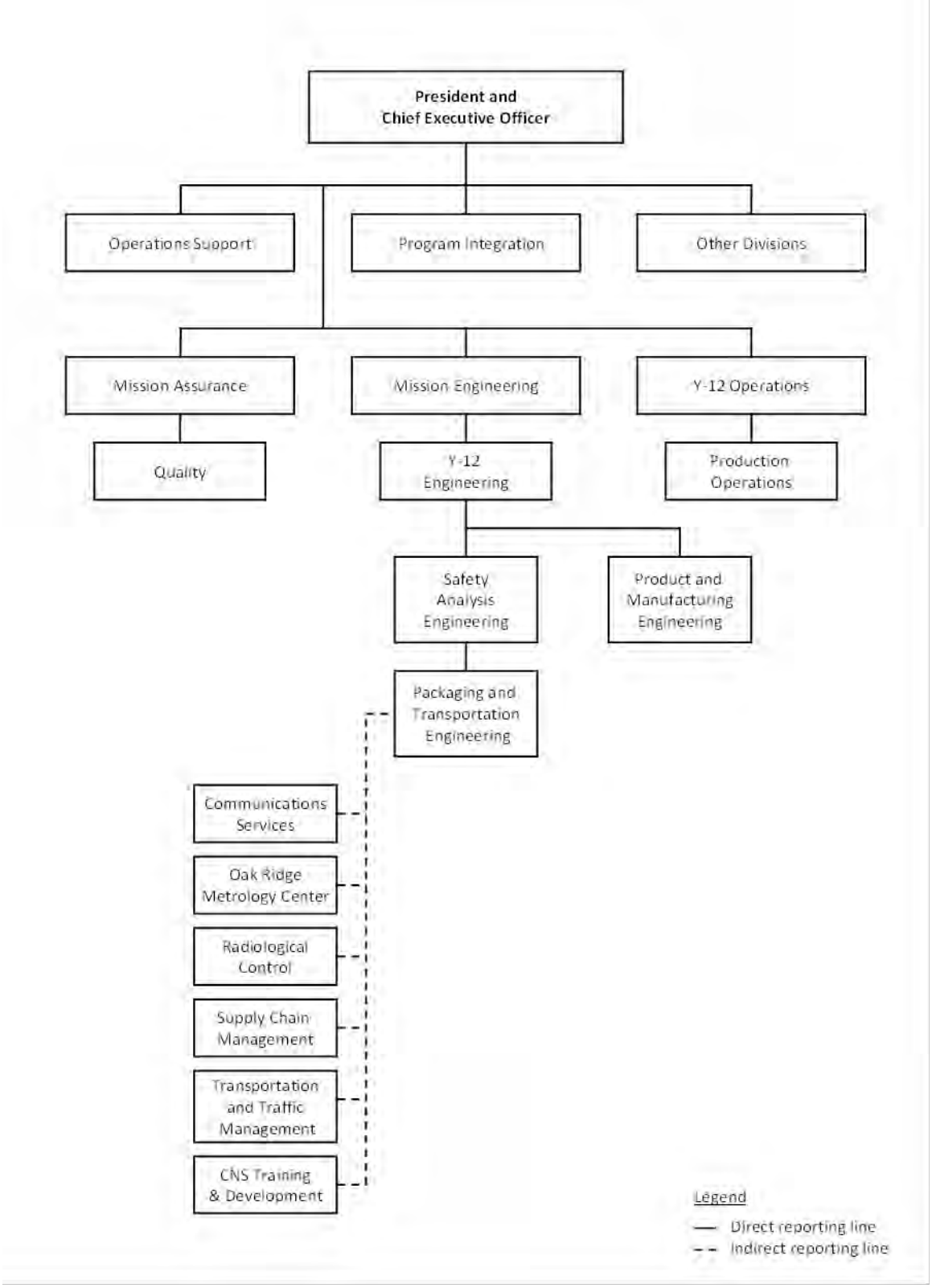


Fig. 9.1. Y-12 Packaging and Transportation Engineering organizational support.

In conjunction with Program Integration management, the PTE Manager plans, schedules, and assigns work activities and also obtains adequate funding to accomplish program goals and milestones. Production Operations conducts packing, maintenance, loading, and material handling activities with qualified personnel. Production Operations activities related to packaging are controlled by procedures approved by PTE and overseen by the Quality organization. Production Operations reports to the Vice President and Y-12 Site Manager, is funded by the program integration organizations, and receives technical support from PTE and quality oversight from the Quality organization. Production Operations is responsible for complying with implementing procedures, instructions, and/or checklists for loading, unloading, and maintenance of the packagings. Production Operations has the primary responsibility for the proper use of the package.

The Quality organization is responsible for the management and execution of the overall QA Program (E-SD-0002). The Quality organization is also responsible for providing qualified personnel for assessments and oversight for operations, supplier evaluations, and independent component inspections. The Quality Senior Director reports to the Vice President of Mission Assurance.

Program Integration management provides the funding for the daily maintenance and compliance activities necessary to ensure that the Y-12 packaging and transportation program complies with NRC, DOT, and DOE regulations. These activities include DOE order compliance, programmatic training, assessments, QA, investigations, packaging maintenance, and user support. The Vice President of Program Integration reports to the Chief Executive Officer.

The Transportation and Traffic Management organization provides compliance oversight to ensure compliance with DOE orders and federal, state, and local laws for the offsite shipment of radioactive materials. Other organizations provide services to PTE as shown in Fig. 9.1. Every individual and organization that produces an item, performs an activity, or provides a service for radioactive material packagings has direct responsibility for the quality of that item, activity, or service. Every organization using a package is responsible for ensuring proper procedures, training, and qualifications are in place.

9.3.2 Quality Assurance Program

Through the effective implementation of the QA program, Y-12 management provides control over activities affecting the quality of identified materials and components of the ES-3100 packaging to the extent commensurate with their importance to safety and, as necessary, to ensure conformance to the approved design of the packaging used to ship radioactive material. The QA program also provides for activities affecting quality to be accomplished under suitably controlled conditions.

The QA program is implemented by the preparation, review, approval, and use of implementing procedures. These procedures provide a system of checks and balances to ensure a safe, reliable, quality product. Each user of the ES-3100 package must also develop an appropriate site-approved QA program and related implementing documentation.

At Y-12, a graded approach is used to selectively apply QA requirements to the ES-3100 packaging components and any related services and activities in accordance with 10 CFR 71.105. The purpose of the graded approach is to select the QA controls and appropriate verification actions to be applied to the various packaging to the various packaging items, services and activities consistent with the extent of their importance to health and safety or to a significant environmental event.

The graded approach is consistent with that defined in NRC Regulatory Guide 7.10. This process involves (1) classifying packaging SSCs as "important to safety" or "not important to safety"; (2) grouping SSCs classified as "important to safety" into quality categories; and (3) specifying the applicable level of QA effort for each category. Approved procedures provide instructions to analyze packaging SSCs to determine whether their functions or physical characteristics are essential to safety, and they provide the criteria for grouping SSCs into one of the following quality categories as defined below. Table 9.1 shows the typical level of QA effort for each element of 10 CFR 71, Subpart H, relative to the graded safety-related quality categories. Each packaging component is graded by the Quality Category Committee using the quality category definitions in a manner similar to the procedure described in NRC Regulatory Guide 7.10, Appendix A. The results of the quality category grading for ES-3100 packaging components are given in Table 9.2, and the correlation between the NRC Regulatory Guide 7.10–based quality categories and the Y-12 quality levels (based on ASME NQA-1) is presented in the QAPP.

- **Category A** (critical to safe operation) components whose failure or malfunction will directly result in an unacceptable condition of containment, shielding, or nuclear criticality.
- **Category B** (major impact on safety) components whose failure or malfunction will indirectly result in an unacceptable condition of containment, shielding, or nuclear criticality (if the primary event occurred in conjunction with a secondary event, another failure, or an environmental event).
- **Category C** (minor impact on safety) components whose failure or malfunction does not result in an unacceptable condition of containment, shielding, or nuclear criticality regardless of other failures in this category.
- **NITS** (not important to safety).

Training and qualifications are required for personnel within Y-12 performing packaging activities related to design, fabrication, testing, procurement, loading, unloading, leak testing, quality oversight, transportation, and record keeping. Each activity is evaluated, and the proper training plan is developed and documented in accordance with E-PROC-3028, *Enterprise Training and Qualification Program.* Vendors performing packaging activities will require training or qualifications in accordance with the established contract. Activities involving special processes as defined in 10 CFR 71, Subpart H, may require specialized qualifications in accordance with established approved training requirements or through a nationally recognized standard such as the American Society for Nondestructive Testing, ASME, or American National Standards Institute.

The management assessment process is designed to focus on the compliance and flow down of contractual requirements, including applicable standards and codes, how those requirements are implemented in procedures, and the measurement of implementation effectiveness. Management assessments are conducted by members of the line organization or program to evaluate and determine whether packaging-related activities are properly focused on achieving desired results. These assessments serve as a periodic self-analysis tool and include reviewing the processes, systems, and programs that are important to the specified mission, goals, and objectives as well as identifying areas for continuous improvement. The assessment process includes provisions to appropriately evaluate all aspects of the Y-12 packaging process, determine how well the management system meets specified requirements, and assess methods to safely perform packaging-related activities.

Table 9.1. Typical level of quality assurance effort by graded quality category

10 CFR 71, Subpart H, level of quality assurance effort	Graded quality category		
	A	B	C
§ 71.103, *Quality assurance organization*			
– Quality assurance program established	✓	✓	✓
– Responsibilities defined	✓	✓	✓
– Quality assurance functions executed	✓	✓	✓
– Reporting levels established	✓	✓	✓
– Management endorsement	✓	✓	✓
§ 71.105, *Quality assurance program*			
– 10 CFR 71, Subpart H, compliant quality assurance program	✓	✓	
– Written procedures and instructions	✓	✓	✓
– Activities affecting quality are appropriately controlled and performed by trained personnel	✓	✓	✓
– Management review	✓	✓	✓
§ 71.107, *Package design control*			
– Most stringent Codes and Standards	✓		
– Formal test for complex items (first article evaluation)	✓		
– Codes and Standards	✓	✓	
– Formal engineering design process (control of design inputs, outputs, reviews, verifications, testing, changes/deviations, analyses, and interfaces)	✓	✓	
– Software quality assurance	✓	✓	
– Catalog/off-the-shelf components			✓
– Design change approval required for certifier controlled design conditions	✓	✓	✓
§ 71.109, *Procurement document control*			
– Traceability	✓	✓	
– Qualified supplier lists	✓	✓	
– Suppliers and subtier suppliers meet the applicable provisions of 10 CFR 71, Subpart H–*Quality Assurance*	✓	✓	
– Commercial grade dedication of items or services	✓	✓	
– Catalog/off-the-shelf components			✓
§ 71.111, *Instructions, procedures, and drawings*			
– Written and controlled	✓	✓	
– Quantitative or qualitative acceptance criteria	✓	✓	
– Controlled changes and deviations for certifier controlled design conditions	✓	✓	✓
§ 71.113, *Document control*			
– Controlled issuance	✓	✓	
– Controlled changes and deviations	✓	✓	

Table 9.1. Typical level of quality assurance effort by graded quality category

10 CFR 71, Subpart H, level of quality assurance effort	Graded quality category		
	A	B	C
§ 71.115, *Control of purchased material, equipment, and services*			
– Source evaluation and selection	✓		
– Inspections, audits, or surveillances at supplier facilities in accordance with specified requirements	✓	✓	
– Objective evidence of quality furnished by the supplier	✓	✓	
– Commercial grade dedication of items or services	✓	✓	
– Documentary evidence provided to ensure that material, equipment, and services conform to the procurement documents and specified requirements	✓	✓	✓
– Packaging components identified upon receipt and checked for damage	✓	✓	✓
§ 71.117, *Identification and control of materials, parts, and components*			
– Positive identification and traceability of each packaging component	✓		
– Control, identification, and traceability to heat number, part number, or other appropriate means throughout fabrication, installation, and use	✓	✓	
– Identification to end use instructions, procedures, specifications, or drawings	✓	✓	✓
§ 71.119, *Control of special processes*			
– Special processes including welding, heat treating, and nondestructive testing performed with qualified personnel and procedures	✓	✓	
– Special process qualification records	✓	✓	
– Special processes conducted in accordance with specified requirements	✓	✓	✓
§ 71.121, *Internal inspection*			
– Documented inspection to verify conformance with instructions, procedures, drawings, and specifications	✓	✓	
– Process monitoring provided as appropriate to assure quality control	✓	✓	
– Examination, measurements, or tests of material or products processed in accordance with specified requirements	✓	✓	
– Qualified inspectors independent of those performing the activities being inspected	✓	✓	
– Visual examination in accordance with specified requirements	✓	✓	✓
§ 71.123, *Test control*			
– Formal test program implemented using written test procedures	✓	✓	
– Formal test for complex items (first article evaluation)	✓		
– Test results are documented and evaluated	✓	✓	
– Observation and evaluation of supplier acceptance tests in accordance with specified requirements	✓	✓	
– Testing and acceptance criteria in accordance with specified requirements	✓	✓	✓
§ 71.125, *Control of measuring and test equipment*			
– Formal calibration program to ensure that tools, gauges, instruments, and other measuring and testing devices are controlled, calibrated, and adjusted	✓	✓	

Table 9.1. Typical level of quality assurance effort by graded quality category

10 CFR 71, Subpart H, level of quality assurance effort	Graded quality category		
	A	B	C
§ 71.127, *Handling, storage, and shipping control*			
– Written procedures for handling, storing, shipping, cleaning, and preservation of packaging components to prevent damage or deterioration	✓	✓	
– Routine handling activities			✓
§ 71.129, *Inspection, test, and operating status*			
– Status or condition of individual packaging components is identified	✓	✓	
– Stamps, tags, labels, or other suitable means indicate the status or condition	✓	✓	✓
§ 71.131, *Nonconforming materials, parts, or components*			
– Written procedures to identify, document, segregate, disposition, notify affected organizations, and to prevent inadvertent use or installation	✓	✓	✓
– Nonconforming conditions must be documented and closed in accordance with written procedures	✓	✓	✓
– Records of disposal (i.e., reject or scrap) required	✓	✓	
§ 71.133, *Corrective action*			
– Written procedures to identify and correct conditions adverse to quality	✓	✓	✓
– Cause and corrective action documented	✓	✓	
– Significant conditions adverse to quality reported	✓	✓	✓
§ 71.135, *Quality assurance records*			
– Records of reviews, inspections, tests, audits, surveillances, and material analyses	✓	✓	
– Records of design, fabrication, acceptance testing, and maintenance retained for the life of the packaging plus 3 years	✓	✓	
– Records of each shipment of radioactive materials for 3 years after the shipment	✓	✓	✓
– Qualification records of personnel, procedures, and equipment in accordance with specified requirements	✓	✓	✓
– Procurement records and nonconformance reports	✓	✓	✓
– Records managed by written program	✓	✓	✓
§ 71.137, *Audits*			
– All auditors are qualified	✓		
– Lead auditor is qualified	✓	✓	
– Written plan of periodic audits	✓	✓	✓
– Implementation by written procedures or checklists	✓	✓	✓

Table 9.2. Quality category for ES-3100 packaging components

ES-3100 component	Quality category
ES-3100 drum assembly (Drawing M2E801580A001, Appendix 1.3.7)	
Drum, inner liner, lid, and top plug weldments	B
Weld studs	B
Hex nuts	B
Washers	C
TID lugs, data plate, and trefoil data plate	C
Kaolite or Packcrete insulation	B
277-4 neutron-absorbing material	A
Silicone rubber pads (CV bottom pad, CV flange pad, and plug pad)	C
Aluminum foil duct tape	C
Nylon plug	C
Paint	C
RFID monitoring system tag	NITS [a]
ES-3100 containment vessel assembly (Drawing M2E801580A011, Appendix 1.3.7)	
Body [b]	A
Lid assembly	
Sealing lid and closure nut	A
Round bar and weld filler material	B
External retaining ring	C
Inner O-ring	A
Outer O-ring	C
Super-O-Lube	C
Modified VCO threaded plug with O-ring	C
Krytox grease, grade 240 AC	C
Hoist ring	C
ES-3100 packing materials (Sect. 1.2.2.4)	
Convenience cans	C
Convenience bottles	C
Silicone rubber pad [c] (can pad)	C
Heavy can spacer assembly [d]	
Can body and end cover	B
277-4 neutron-absorbing material	A
Lanyard, band clamp, and labels	C
Metal scrubbers	C
Polyethylene, nylon, or Teflon bag	C

[a] An optional radio-frequency identification (RFID) monitoring system tag (categorized as not important to safety) may be secured to the drum assembly. The QA requirements for the design, procurement, operation, and maintenance of the RFID monitoring system tag and support programs are presented in ANL/DIS-09-5.
[b] Component including any weld filler material.
[c] Drawing M2E801580A024, Appendix 1.3.7.
[d] Drawing M2E801580A043, Appendix 1.3.7.

9.3.3 Package Design Control

PTE is responsible for the ES-3100 package design and any design changes in accordance with approved design control procedures. The ES-3100 packaging certification drawing (Appendix 1.3.1) specifies those details of the package design that affect its evaluation under 10 CFR 71. The packaging design drawings (Appendix 1.3.7) and the equipment specifications (Appendices 1.3.2–1.3.5 and 1.3.9–1.3.12) provide detailed fabrication and acceptance criteria for the packaging components.

PTE performs or coordinates the preparation of design calculations and analyses, which are incorporated into or referenced in the certification documentation (i.e., SARP). As applicable, design inputs are collected from safety guides, regulatory requirements, national codes and standards, and customer performance requirements. In accordance with Sect. 3 of QAPP, PTE is also responsible for the design process, including design verification activities. Design output documents include drawings; system requirements; equipment specifications; data sheets; thermal, structural, criticality, and shielding analyses; and the safety grading worksheet.

Any changes to design inputs or final designs shall be justified and subjected to design control measures commensurate with those applied to the original design. Changes shall be approved by the same groups or organizations that reviewed and approved the original design documents. A change to Category A and B components (Sect. 9.3.2 and Tables 9.1 and 9.2) that affects a design feature, requirement, or specification shown on the ES-3100 certification drawing (Appendix 1.3.1) or condition of approval in the Certificate of Compliance shall be submitted to DOE Headquarters Certifying Official for review and approval, and the change shall not be implemented until the DOE Headquarters Certifying Official has provided approval of the change in writing. A change to Category C or NITS components may be approved by PTE (the design authority and SARP owner). Approved design changes must also be incorporated by revising procurement specifications and documents, manufacturer drawings, and operational procedures that are affected by the design change. At a minimum, design control measures will be applied to the following: criticality physics, radiation shielding, structural, thermal, containment, and accident analyses; compatibility of materials; accessibility for in-service inspection, maintenance, and repair; features to facilitate decontamination; and delineation of acceptance criteria for inspections and testing.

Design verification for the package design and design changes is performed in accordance with approved procedures. Qualified personnel, other than those who performed the original design work, check and verify design output documents and the supporting calculations and analyses using standard engineering practices identified in approved procedures. The package design is reviewed by a qualified design review team, and the results are documented. The design engineer and review team approve the drawings, specifications, and data sheets. These specific interfaces are discussed in approved design control procedures, which also implement peer reviews as quality control checks.

9.3.4 Procurement Document Control

In accordance with Sect. 4 of the QAPP, the Y-12 procurement process is implemented in accordance with documented management controls and approved procedures to ensure that adequate quality controls are incorporated in the procurement documents for packaging material, equipment, and services, whether purchased by Y-12 or its suppliers. Controls are implemented to ensure that procurements are planned and applicable technical and quality requirements are included or referenced in the procurement documents, that procurement documents are reviewed, and that changes are subject to the same degree of control used in preparation of the original documents. These controls also ensure that the items, materials, or services required for safety systems have been assigned a quality category. This procurement process, which is based on NQA-1 requirements, ensures that those items and/or services

provided by approved suppliers meet the 10 CFR 71, Subpart H requirements. Using a graded approach, the QA organization executes the procurement process by performing vendor qualification reviews, assessments, and first article evaluations (FAEs), as required, ensuring that:

- requirements are accurately, completely, and clearly communicated to the supplier;
- suppliers comply with regulatory qualification requirements;
- suppliers fabricate according to the design documentation; and
- the requested documentation is provided.

Applicable QA requirements are flowed down and verified through reviews, assessments, audits, and inspections of suppliers and sub-tier suppliers, as required, to ensure that they are capable of and continue to meet the specified technical and quality requirements. Packaging components identified as either Category A or B must be purchased from qualified vendors or through commercial grade dedication in accordance with established procedures. Approved design changes must also be incorporated by revising procurement specifications and documents, manufacturer drawings, and operational procedures that are affected by the design change.

Controls are implemented to ensure that procurements are planned and applicable technical and quality requirements are included or referenced in the procurement documents, that procurement documents are reviewed, and that changes are subject to the same degree of control used in preparation of the original documents. These controls also ensure that the items, materials, or services have been assigned a quality category (Sect. 9.3.2).

9.3.5 Instructions, Procedures, and Drawings

Y-12 organizations responsible for specific packaging-related operations and activities prepare the procedures, instructions, checklists, and/or similar documents for their particular packaging activities. These documents provide quantitative or qualitative acceptance criteria to ensure that the activities have been performed satisfactorily and that they meet the packaging requirements. In accordance with Sect. 5 of the QAPP, the packaging activities that are important to safety are accomplished and controlled in accordance with written and approved instructions, procedures, drawings, and other documents that identify the quality requirements for each item, service, or activity, and should include the methods for complying with applicable sections in 10 CFR 71, Subpart H. Packaging activities will be described to a level of detail commensurate with the complexity of the operation and the need to ensure consistent and acceptable results.

Y-12 organizations that fabricate, test, or maintain packagings or that pack, unpack, or maintain packages are defined as packaging users. Users are responsible for preparing and controlling procedures and instructions that implement packaging requirements. These activities are coordinated with QA personnel to verify that all inspections, hold points, and work activities have been performed satisfactorily. The instructions, procedures, and drawings used to carry out work activities also contain acceptance criteria to demonstrate activities that are important to safety have been completed as required. Procedures that concern packaging activities (i.e., packing, unpacking, maintenance) must be reviewed and concurred by the PTE Manager or designee.

9.3.6 Document Control

In accordance with Sect. 6 of the QAPP, Y-12 has an established document control system to ensure that documents within the scope of the Packaging and Transportation QA Program, including changes thereto, are prepared, reviewed for adequacy and completeness, and approved for release. Documents necessary to accomplish and/or verify packaging-related activities are identified and controlled to ensure that only current, accurate, approved documents are used. Implementation of this document control system ensures that:

- changes to documents (other than minor "non-intent" changes) are reviewed and approved by the same organizations that performed the original review and approval;
- approved documents are available at work locations when operations, which are essential to the effective functioning of the quality system, are performed; and
- recipients are notified when documents are superseded so they can be promptly removed from all points of issue or use, and originals are maintained for establishing history and maintaining traceability.

9.3.7 Control of Purchased Material, Equipment, and Services

In accordance with Sect. 7 of the QAPP, Y-12 has an established system for planning and executing packaging-related procurements to ensure that purchased material, equipment, and services whether purchased directly or through contractors and subcontractors, conform to the packaging procurement documents. Purchased items and services are controlled to ensure conformance to specified requirements. Depending on the quality level required, control measures for purchased items and services are performed relative to the level of importance, complexity, and quantity of the item or service being procured and the supplier quality performance. In addition, Y-12 has a suspect and counterfeit item (S/CI) program to prevent and control the hazards posed by the use of S/CIs, which can lead to unexpected equipment failures and undue risks to the DOE/NNSA mission, the environment, and personnel. Procurement documents contain provisions to ensure that suppliers are aware of any S/CI issues.

Procurement planning helps ensure that the appropriate QA requirements are identified in procurement documents. Y-12 evaluates the supplier capability to provide items or services in accordance with the requirements of the procurement documents. The supplier evaluation process includes one or more of the following, as appropriate:

- historical performance review,
- commercial grade survey
- third-party audit/survey review, or
- supplier QA program audit.

The Y-12 Supplier Quality organization maintains the Y-12 Quality Approved Supplier List (QASL) and reviews the supplier QA plans to ensure that the appropriate 10 CFR 71, Subpart H elements are properly included and addressed. Procurement of Category A and B packaging components may only be done through suppliers who have been evaluated and placed on the QASL or through commercial grade dedication.

The Y-12 supplier evaluation teams, which typically include representatives from Quality and Procurement, may be supplemented with subject matter experts (i.e., packaging engineers) who are knowledgeable of the technical details and the required manufacturing processes. Suppliers are selected based on their evaluated and documented capabilities to provide items and services. The procurement documents provide for access to facilities and records for inspection or audit and require that records be

forwarded when required for review and approval. These provisions are extended as appropriate through procurement documents to subtier suppliers.

Supplier performance is monitored and reviewed at intervals based on the complexity and technical requirements of the product supplied and the quality performance of the supplier. Records are established and maintained to identify the continuing acceptability of each supplier. FAEs and associated manufacturing hold/witness points are specified in procurement documents for Category A and B items or when they are needed to evaluate the performance of each supplier. When an FAE is specified, the Y-12 FAE team performs an in-depth evaluation of the first article at the supplier facility, and the evaluation is completed before release for production. Upon successful completion and acceptance of the FAE, the supplier is released to initiate the manufacture of production quantities. Any subsequent process change to manufacturing and acceptance procedures, facilities, type of personnel, or testing could conceivably affect product quality and requires the notification of proposed changes to Y-12.

In accordance with Sect. 7.6 of the QAPP, procurement documents will include provisions for: (1) supplier reporting of nonconformances that do not meet specified requirements and (2) obtaining Y-12 approval of the nonconformance report (NCR) disposition. Noncompliances to the procurement specifications, drawings, statement of work, or any other procurement document must be documented and dispositioned using the request for waiver or deviation (RFWD) process before the item can be accepted and released for shipment to Y-12. The procurement documents specify the test/inspection requirements, the acceptance criteria for safety-related items, suitable environmental conditions, and the identity of all documents to be submitted as records for information, review, or approval by the purchaser. When PTE requires the supplier to maintain specific records, the retention times and disposition requirements are prescribed in the purchase order. These documents generally include:

- documentation that identifies material or equipment and the specific procurement requirements (e.g., codes, standard, and specifications met by the items);
- documentation that identifies any procurement requirements that have not been met along with copies of applicable NCRs and RFWDs;
- documentation that the supplier material and equipment meet the applicable procurement requirements prior to installation or use; and
- any other documentation required by the procurement documents.

9.3.8 Identification and Control of Materials, Parts, and Components

In accordance with Sect. 8 of the QAPP, Y-12 packaging and related components, including unique tooling and fixtures, are identified and controlled to ensure their proper fabrication, assembly, use, and status. The identification of items shall be maintained to ensure appropriate traceability. Applicable design documents or implementing procedures specify the traceability requirements. Approved management controls establish and implement the processes to control consumables and items with limited service or shelf life and to prevent the use of incorrect or defective items.

Packagings and packaging components are identified either directly on the item or by tags, markings on envelopes container the part, or other means of documentation directly traceable to the item. Materials designated for destructive testing or special evaluations are controlled to prevent their inadvertent use. Limited life materials or components such as O-rings are identified and controlled to preclude use of expired items and to provide for recall if necessary, “QA accepted” tags must either be attached to the packaging components or to lots of components. These tags are attached after the Y-12 Quality organization completes a successful audit of the supplier certification data and other associated certification documents.

9.3.9 Control of Special Processes

Processes to be controlled as special processes are those where: (1) the results are highly dependent on the control of the process; (2) the results are highly dependent on the skill of the operator; and (3) the quality of the results cannot be readily determined by inspection or test of the item or component. ES-3100 packaging-related special processes comprise, but are not limited to, the following:

- mixing, casting, and curing of thermal insulation and neutron-absorbing materials;
- flow forming;
- welding;
- heat treating of materials;
- and conducting nondestructive examinations (e.g., radiographic, leak testing, liquid penetrant methods).

In accordance with Sect. 9 of the QAPP, Y-12 prepares specifications and requirements that direct the performance of special processes for packagings at offsite locations (i.e., supplier facilities) as well as onsite locations. These measures ensure that special processes are controlled and accomplished with qualified personnel and procedures in accordance with applicable specification, criteria, codes, standards, and other specified requirements.

9.3.10 Internal Inspection

A program for inspection of activities affecting the quality of packaging has been established and implemented. Multiple organizations within Y-12 have the responsibility for conducting inspections within the scope of the overall QA Program and shall provide documented management controls for such actions (E-SD-0002, Sect. 10). Inspections shall be conducted on packaging-related activities, or items affecting quality and/or nuclear safety to verify conformance with applicable codes, standards, regulatory requirements, procedures, and procurement documents or because of specific management requests. Inspection activities shall be documented and controlled by instructions, procedures, specifications, drawings, checklists, travelers, or other appropriate means.

Inspection activities are planned and performed using approved procedures, instructions, and checklists to verify conformance of an item or activity to specified requirements. In accordance with Sect. 10 of the QAPP, these documents will include methods for inspection, acceptance and rejection criteria, and identification of those responsible for performing the inspection. Inspections for acceptance shall be performed by qualified personnel other than those who performed or directly supervised the work being inspected, and those individuals shall not report directly to the supervisor immediately responsible for performance of the work. Personnel who perform nondestructive examinations such as radiographic, liquid penetrant, leak testing, and visual inspection to verify conformance to the specified requirements shall be qualified in accordance with documented management controls. Minimum certification requirements are shown on the ES-3100 certification drawing (Drawing M2E801580A037, Appendix 1.3.1).

9.3.11 Test Control

Y-12 defines requirements and acceptance criteria in conjunction with appropriate quality measures used to verify that packages meet design requirements, directs testing used to verify that the design meets regulatory requirements, and performs some acceptance and maintenance testing onsite. Testing used to verify production of packages is provided in specifications and data sheets produced in accordance with approved procedures. These management control documents ensure that testing and changes to testing are done per design intent, that all necessary testing is completed, and that the results of testing are reviewed to determine acceptability.

PTE has established a test program in accordance with Sect. 11 of the QAPP, which ensures required testing demonstrates that the packaging components will perform satisfactorily in service/use. Before the start of testing-related activities, qualified personnel will ensure that the testing organization has implemented a QA program that is compliant with the appropriate elements of 10 CFR 71, Subpart H. This testing is performed in accordance with written and approved test procedures that incorporate the necessary requirements and acceptance limits contained in the package design documents and federal regulations and ensure that qualification testing of prototype packages is performed under the most adverse design conditions. The packaging and certain components are subject to initial and verification testing in accordance with written test procedures. Test records and test results documentation are maintained by the organization responsible for the tests, and copies are sent to PTE.

9.3.12 Control of Measuring and Test Equipment

As described in Sect. 12 of the QAPP, the Y-12 Standards and Calibration Program, which is administered by the Y-12 Oak Ridge Metrology Center, ensures measuring and test equipment (M&TE) is calibrated and controlled. This control process ensures that tools, gauges, and other instruments used for packaging-related inspections, tests, and measurement activities are of the proper range, type, accuracy, and precision and that they are handled, stored, and maintained within specified calibration limits. The Oak Ridge Metrology Center has the responsibility for:

- maintaining primary standards,
- calibrating and maintaining secondary standards,
- calibrating and maintaining working standards,
- calibrating product acceptance test equipment and process applications equipment, and
- providing oversight and approval of the calibration program.

Calibration of M&TE is required whenever the equipment is used to determine conformance or acceptance to customer or regulatory compliance or whenever the measurement is required to meet safety, health, environmental, or quality parameters. Y-12 calibration organizations supporting packaging and transportation activities (e.g., Analytical Chemistry; Industrial Hygiene; Oak Ridge Metrology Center; Radiological Control) are responsible for maintaining measurement standards and calibrating M&TE by trained personnel and approved procedures or work instructions.

Records shall be established and maintained to indicate calibration status and the capability of M&TE to satisfactorily perform its intended function. Calibration reports and certificates reporting the results of calibrations shall include the information and data necessary for interpretation of the calibration results and verification of conformance to applicable requirements. Calibration records shall be controlled and stored to establish traceability to approved national or international standards.

9.3.13 Handling, Storage, and Shipping Control

In accordance with Sect. 13 of the QAPP, Y-12 has established measures to ensure that the handling, storing, shipping, cleaning, and preservation of materials and equipment to be used in packaging are accomplished in accordance with design requirements to prevent damage or deterioration by environmental conditions such as temperature and humidity, damage, mixing, substitution, or loss. The requirements for handling, storage, shipping, cleaning, packing, segregating, and preserving are specified in procedures, shipping instructions, checklists, or other documents. When necessary, special handling, lifting, storage devices, or equipment and special protective environments (e.g., inert gas or controlled moisture/temperature levels) are specified with appropriate provisions for their verification.

Packaging components shall be stored in weather-protected indoor facilities commensurate with established storage requirements. Stored packagings and components are placed in designated controlled storage areas. Monitoring of items in storage is conducted at appropriate intervals as determined by PTE. Marking and labeling measures shall be established (Sect. 9.3.8) for the handling, storage, packing, and shipping of items as necessary to adequately identify, maintain, and preserve the item. Markings and labels shall indicate the presence of special environments or the need for special controls if necessary.

ES-3100 package operations will be performed in accordance with Chap. 7 and applicable NRC, DOT, and other federal, state, and local regulations to protect the health and safety of the public, workers, and the environment. In accordance with Sect. 13 of the QAPP, operators will ensure (prior to shipment) that (1) packages have been prepared in accordance with approved drawings, procedures, specifications, regulatory requirements, SARP, DOE directives, and certificate; (2) packages have passed applicable inspections and tests; (3) packages are properly identified by physical markings or tags; and (4) shipping papers have been prepared as required and reviewed by qualified personnel to verify completeness and accuracy.

9.3.14 Inspection, Test, and Operating Status

Approved procedures and procurement documents describe the use of markings (i.e., stamps, tags, labels, routing cards, or other suitable means) and the status of inspections, tests, and operating conditions (including maintenance of items) that may be performed on packaging components. Facility operating procedures identify which methods are used and how they are implemented.

The status of inspection and test activities is identified in operating procedures to ensure that (1) required inspections and tests are performed and (2) items that have not passed the required inspections and tests are not inadvertently installed, used, or operated. Independent inspections are implemented at critical acceptance steps that are conducted by the QA organization through the use of certification reports. Y-12 uses a production control system, which schedules an inspection, test, or other activity before the packaging moves to the next activity. The status of each packaging can be determined from the production control system.

9.3.15 Nonconforming Materials, Parts, or Components

Items that do not conform to specified requirements shall be controlled to prevent inadvertent installation, use, or shipment. Controls shall provide for identification, documentation, evaluation, segregation when practical, disposition of nonconforming items, and notification to affected organizations.

In accordance with Sect. 15 of the QAPP, Y-12 employees are responsible for identifying and documenting nonconformances. If a vendor supply issue for packaging components is identified, items that are out of specification may be used as is with a RFWD approved by PTE. Items that cannot be returned to an acceptable condition are appropriately controlled to prevent inadvertent installation or use. Waivers or deviations on quality Category A and B packaging components also require approval by the DOE Certifying Official prior to implementation. After receipt at Y-12, the nonconforming materials, parts or components will be appropriated tagged, segregated when practical, and dispositioned. These nonconformance control activities are necessary to prevent further processing, delivery, installation, or inadvertent use of nonconforming items until affected organizations (including QA) are notified, and the proposed technical disposition, remedial actions, and corrective actions are approved.

9.3.16 Corrective Action

The identification, cause, and corrective actions for conditions adverse to quality are documented and reported in accordance with approved procedures to the appropriated levels of management. If a significant condition is identified, the system ensures that: (1) the root cause of the conditions is determined, (2) a Price-Anderson Amendments Act screening is performed, and (3) corrective action is taken to prevent recurrence.

In accordance with the Sect. 16 of the QAPP, Y-12 approved procedures establish the process to be used for conditions that may be noncompliant with respect to contractual requirements or that are adverse to safety, health, environment, operations, quality, safeguards and security, or mission performance. These issues are managed in accordance with the significance of the issues and the associated risk. For reportable occurrences involving packaging and transportation, the DOE Occurrence Reporting and Processing System is used in accordance with DOE O 232.2A. In addition to the DOE O 232.2A notification and reporting requirements, occurrences will be reported to the DOE Certifying Official upon discovery of the following:

- instance in which there is a significant reduction in the effectiveness (as defined by the certificate holder) of any approved fissile or Type B packaging during use,
- discovery of a defect with safety significance (as determined by the certificate holder) in a Type B or fissile material packaging, after first use (by any shipper), and
- instance in which the conditions of approval in the Certificate of Compliance were not met in making a shipment.

9.3.17 Quality Assurance Records

The Y-12 records management process is established in accordance with approved procedures (QAPP, Sect. 17) and implemented to ensure that sufficient records are specified, prepared, completed, reviewed, approved, and maintained to accurately reflect completed work. A QA record is a completed document that furnishes evidence of the quality of items and/or activities affecting quality. Records are identified, generated, reviewed, approved, collected, and indexed for both accountability and retrievability; are protected in storage for required retention limits; and have a specified final disposition. The records may be originals, copies of authenticated records (if needed to be stored by different organizations), or electronic media. These records are generated by many Y-12 organizations, including suppliers. QA records generated for or by PTE provide evidence of packaging quality. Examples of the types of QA record documents are listed in Table 9.3; specific records associated with operations are listed in Appendix 7.5.1.

Records are to be legible, complete, retrievable, and protected from damage, deterioration, and loss. In accordance with 10 CFR 71.91(a), records of each shipment of radioactive material are maintained for 3 years after the shipment, and quality records are maintained for 3 years beyond the life of the packaging (i.e., following decommissioning of the packaging) as required by 10 CFR 71.91(d). Records to be generated, supplied, or maintained are specified in applicable documents, such as design specifications, procurement documents, test procedures, and operational procedures. Site-level and departmental procedures provide for the retention, protection, preservation, traceability, accountability, and retrievability of records in the Y-12 document and record management systems.

Table 9.3. Typical quality assurance records

System requirements documents	SARPs
Design drawings	Work requests
Data sheets	Manufacturing and assembly procedures
Design criteria documents	Personnel qualification records
Graded approach results	Operating and maintenance procedures
Equipment specifications	Vendor certification evidence
Design review documentation	Product Information and Control Summary
Design change documentation	Preshipment leak-test records
Test plans and procedures	Offsite fissile material container inspection forms
Test reports	NCRs and log sheets
Quality assurance/control manuals	Corrective action reports
Procurement specifications	Quality Certification and Procurement Instructions
Material specifications	Certification data verification work requests
Manufacturing specifications	Certification procedures
Vendor QA program evaluation results	Self-appraisal reports
Audit reports	Surveillance reports
Weld radiographs	Liquid penetrant reports
Prototype data certification	Dimensional inspection results
Packing follow sheets	Maintenance follow sheets
Calibration procedures	Equipment calibration records

9.3.18 Audits

In accordance with Sect. 18 of the QAPP, a comprehensive system of planned and scheduled audits are conducted using written procedures to: (1) verify compliance with the requirements of packaging-related processes; (2) determine the effectiveness of the program; and (3) focus on improving items and processes. Audit personnel are provided with reasonable and timely access to facilities, documents, and appropriate personnel in the audited organizations. Audits are performed in accordance with procedures, and audit teams use prepared checklists to guide the audit process. Audit results are documented in formal reports that are transmitted to the responsible audited organization management as well as the auditing organization management.

Audit teams include both individuals trained in assessment and subject matter experts who are knowledgeable in the area being audited. Audits are led by a qualified lead auditor and conducted by qualified personnel who are (1) technically knowledgeable/experienced in the functional area being audited, (2) independent with no direct responsibilities in the functional area being audited, and (3) granted organizational freedom and authority to perform an effective audit. Lead auditors are certified by management and have qualifications that are outlined in accordance with approved procedures.

The results of each audit report are reviewed, and the managers who are assigned responsibility for an issue shall ensure that corrective actions addressing the cause are planned, implemented, and tracked to closure. For corrective actions to be considered complete, the audit team lead shall verify that (1) the audited organization provides a timely response to the audit report, (2) the response is adequate and complete, and (3) the corrective actions have been implemented. Areas of improvement that are not findings but may warrant strengthening are also considered as potential quality improvements.

9.3.19 Software Quality Assurance

Y-12 uses software in the design and analysis of packages. In addition, software is used to track packaging activities, file occurrences, maintain records, and provide communications. Y-12 has developed and implemented computer software programs, including configuration controls, which will improve safety, increase the reliability of packaging operations and data, and support the achievement of programmatic missions. Software controls include verification, validation, and configuration management. Software is used in accordance with the responsibilities and requirements for developing, procuring, implementing, maintaining, and applying computer software as described in Sect. 19 of the QAPP.

9.4 APPENDIX

Appendix 9.4.1 Chapter 9 References 9-23

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Appendix 9.4.1
Chapter 9 References

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