

95/3322.0094

START



11
0029165

STATE OF WASHINGTON
DEPARTMENT OF ECOLOGY

Mail Stop PV-11 • Olympia, Washington 98504-8711 • (206) 459-6000

April 5, 1993

Dear Interested Citizen:

Enclosed please find a summary of U.S. Department of Energy's (USDOE) Tank Waste Remediation System (TWRS) proposal and associated Hanford Federal Facility Agreement and Consent Order (Hanford Tri-Party Agreement) milestone change requests. This is USDOE's proposal to integrate the management of projects that focus on the cleanup of single and double shell tank wastes. Washington State Department of Ecology (Ecology) received this proposal April 1, 1993.

TWRS includes activities and projects such as tank waste characterization, waste retrieval technology development, tank safety, storage, pretreatment, and vitrification leading to the eventual disposal of both low and high level wastes. USDOE's TWRS proposal requests changes to the very core of the Hanford Tri-Party Agreement, signed by USDOE, U.S. Environmental Protection Agency, and Ecology less than four years ago.

On March 19, Governor Mike Lowry and Secretary of Energy Hazel O'Leary met and talked about the TWRS proposal. As a result of that meeting, Governor Lowry directed Ecology to develop a six-month schedule (April 1-September 30, 1993) for TWRS negotiations and public involvement.

We have been working with the Washington Nuclear Waste Advisory Council to develop an initial set of criteria for evaluating TWRS. We have also asked the Council for advice on how to involve the public with decisions Washington State will be making on TWRS. The 19-member Council is made up of ten citizens appointed by the Governor, a Yakima Indian Nation representative, and eight legislators. The Council advises Ecology on nuclear waste policy and related public involvement issues.

We are preparing an assessment of issues or concerns on USDOE's TWRS proposal which we will send to you within the next few weeks. Our initial assessment will give you Washington state's opening criteria, based upon advice from the Nuclear Waste Advisory Council, for evaluating USDOE's TWRS proposal.



**THIS PAGE INTENTIONALLY
LEFT BLANK**

THIS PA NALLY

THIS PA NALLY



Interested Citizen

April 5, 1993

Page 2

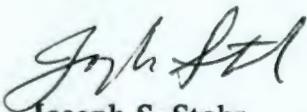
The Nuclear Waste Advisory Council is advising us to involve the public in a variety of ways, to ensure the broadest possible involvement by the public. Ecology, along with USDOE and EPA, plans to conduct public workshops and meetings in Washington and Oregon. The daytime workshops, followed by evening meetings will be conducted by a professional facilitator. Both the Nuclear Waste Advisory Council and Oregon Hanford Waste Board will be asked to review workshop and meeting materials. In addition, Ecology, USDOE, and EPA hope to establish a facilitated Stakeholders Forum to closely examine the TWRS proposal. We will be providing you with information regarding these activities within the next few weeks.

The TWRS proposal is undoubtedly the most challenging and significant issue Ecology has faced since the signing of the Hanford Tri-Party Agreement. Washington State continues to be vigilant to ensure the continued effectiveness of the Hanford Tri-Party Agreement and substantial cleanup progress in the near term. Four years ago, Washington State pledged to do its part to see that the hazardous and mixed wastes in Hanford's underground storage tanks would be retrieved and disposed efficiently, safely, and in a timely manner. Now we are being asked to revisit that Agreement.

Ecology supports USDOE's efforts to integrate management of Hanford tank waste remediation systems. We further agree that careful consideration of new information and recent concerns is warranted. In order to clean up Hanford's tank wastes, USDOE must be committed to enforceable schedules. Copies of the lengthy TWRS proposal are available for your viewing at the Hanford Tri-Party Agreement Public Information Repositories (see enclosed list).

Your continued interest and participation during this critical period will be sincerely appreciated. If you would like further information regarding the TWRS proposal and Ecology's review of it, please contact Mary Getchell, of my staff, at (206) 459-6862.

Sincerely,



Joseph S. Stohr
Acting Program Manager
Nuclear and Mixed Waste Management

JS:md
Enclosures

cc: Betty Tabbutt, NWAC

**THIS PAGE INTENTIONALLY
LEFT BLANK**

DRAFT

Change Number M-TWRS-93-01	Federal Facility Agreement and Consent Order Change Control Form Do not use blue ink. Type or print using black ink.	Date 01 1993
Originator _____ Phone _____		
Class of Change <input checked="" type="checkbox"/> I - Signatories <input type="checkbox"/> II - Project Manager <input type="checkbox"/> III - Unit Manager		
Change Title Tank Waste Remediation System Integrated Change Request Encompassing Management, Processing, and Disposal of Wastes Currently Stored in Single- and Double-Shell Tanks		
Description/Justification of Change This change request proposes fundamental changes to the Hanford Federal Facility Agreement and Consent Order (commonly know as the Tri-Party Agreement) milestones which encompass the management, treatment, and disposal of wastes currently stored in single- and double-shell tanks. The request is divided into five sections. The first section provides the background for the changes. The second section provides a description of the TWRS new technical strategy. The third section provides a strategy for grouping the Tri-Party Agreement milestones to accommodate the changes proposed by the New Technical Strategy and a strategy to support the decisions which will be made during the technology development phase of the program. (continued on page 2)		
Impact of Change This change request deletes major milestones M-01 through M-10, and M-31. Much of the work scope encompassed by these milestones will be included in the reconfigured portion of the Tri-Party Agreement proposed by this change. In addition, three major new milestones groupings will be created to reflect the major programmatic elements of the Tank Waste Remediation System program. These three major milestone groups are: <ul style="list-style-type: none"> - M-40 through 49 Manage Tank Waste - M-50 through 59 Process Tank Waste - M-60 through 69 Manage System Generated Waste Each of these milestone groupings will have a number of major milestones which reflect the key work to be performed within the program area.		
Affected Documents The Hanford Federal Facility Agreement and Consent Order; Tank Waste Remediation System (TWRS) Program Plans, Budgets, Schedules, Work Plans, etc; a new TWRS-EIS will be developed; and generally all tank waste-related programs will be integrated.		
Approvals ___ Approved ___ Disapproved DOE _____ Date _____ EPA _____ Date _____ Ecology _____ Date _____		

Description/Justification of Change (Cont.)

The fourth section provides an outline of the milestones being proposed by the change request. The fifth section provides the specific new milestone descriptions which the U.S. Department of Energy (DOE) suggests be established to reflect the adoption of this integrated approach to the management and clean-up of tank wastes.

Section 1: Background:

The "Environmental Impact Statement for the Disposal of Hanford Defense High-Level, Transuranic and Tank Waste" (HDW-EIS) Record of Decision (ROD), issued on April 8, 1988, established the technical direction that the retrieval, pretreatment, and disposal of double-shell tank wastes would take. Priority was focused on retrieving, processing, and disposing of the waste in the 28 double-shell tanks. Waste from 10 of the double-shell tanks was to be retrieved, pretreated and immobilized with the high-level fraction vitrified for disposal in a federally licensed geologic repository and low-level fraction disposed of on-site as grout. Waste in the remaining 18 double-shell tanks was to be retrieved and immobilized in grout, without pretreatment, for on site disposal as low-level waste. Waste pretreatment was to be accomplished in modified existing facilities.

The HDW-EIS ROD deferred decisions on the disposal of waste in the 149 single-shell tanks until additional development and evaluation could take place. The technical direction established by the HDW-EIS ROD served as the basis for negotiation of the original Tri-Party Agreement in 1989 in the area of disposal of tank wastes.

The Tri-Party Agreement set forth actions and milestones deemed necessary to ensure acceptable progress towards implementing the course of action outlined by the HDW-EIS and actions to bring the Hanford Site into compliance with Resource Conservation and Recovery Act (RCRA), Comprehensive Environmental Response, Compensation and Liability Act (CERCLA), and the Washington State Hazardous Waste Management Act. Inherent in the negotiation of the original Tri-Party Agreement milestones was a set of underlying assumptions and constraints including: use of existing facilities (B-Plant and 244-AR Vault for pretreatment and use of existing lines for waste transfer); grout disposal of certain tank waste without pretreatment, deferral of the decision to retrieve single-shell tank waste until 2003; and the availability of lessons learned and data from the Defense Waste Processing Facility (DWPF) at the Savannah River Site. These assumptions were considered valid at the time of the negotiations.

A number of significant changes have occurred in tank waste conditions and understanding, requirements, and policy since the Record of Decision for the HDW-EIS was issued and the original Tri-Party Agreement was signed.

First and foremost was the emergence of potential imminent threats to safety and the environment posed by waste in a number of tanks. High priority issues included flammable gases, flammable and/or explosive organic and ferrocyanide compounds, high heat, noxious tank vapors, and criticality. Second was the deterioration and leaking of the single-shell tanks and deterioration of the overall tank farm infrastructure, including systems critical to ensuring safety and environmental protection. Third, environmental, safety and regulatory considerations have resulted in the Department's determination to plan to retrieve waste from the single-shell tanks. Retrieval of waste from the single-shell tanks would result in a four-fold increase in the quantity of waste to be processed; the current vitrification and grout facilities are significantly undersized to

DRAFT

Description/Justification of Change (Cont.)

process this increased volume and placing additional emphasis on the need to develop a robust pretreatment capability. Additionally the complexity, difficulty, and uncertainty of all aspects of the tank waste remediation effort (including retrieval, pretreatment, immobilization, and disposal) are greatly increased by the physical and chemical characteristics of the single-shell tank waste, the heterogeneity of the waste, the very limited information available on waste and tank conditions, and the poor and deteriorating condition of the single-shell tanks and supporting infrastructure. Fourth, regulatory criteria, particularly those promulgated under the RCRA preclude the use of existing facilities, including B Plant, for critical waste pretreatment process operations. Fifth, DOE believes, based on the recent Nuclear Regulatory Commission determination, that liquid in double-shell tanks requires pretreatment prior to grout disposal; this action would require planning to obtain the necessary pretreatment capability.

The identification of tank safety issues, the poor and deteriorating condition of single-shell tanks, the inclusion of single-shell tank wastes in the planning base for retrieval and treatment of tank wastes, the need to pretreat liquid from these tanks prior to grout disposal, and the loss of B Plant as the facility for pretreatment and treatment of these wastes severely undermined the technical feasibility of the tank waste program as originally envisioned and incorporated into the Tri-Party Agreement.

In December 1991, the three parties to the Tri-Party Agreement, (the U.S. Department of Energy, the Washington State Department of Ecology, and the U.S. Environmental Protection Agency) agreed to a comprehensive "rebaselining" effort to assess the impact of changes upon the remediation program and associated Tri-Party Agreement milestones and, if justified by the assessment, entertain a proposal to revise the plan, i.e., employ a new technical strategy and baseline.

The Tank Waste Remediation System (TWRS) Rebaselining Study was undertaken to provide a systematic reevaluation of the strategy and technologies that should be considered to provide the best technical solution to the Hanford tank waste problems. The result of this study is a proposed New Technical Strategy.

Description/Justification of Change (Cont.)

Section 2: Proposed TWRS New Technical Strategy

The primary goal of the Tank Waste Remediation System is to minimize the environmental, safety and health risks associated with existing waste stored in the double-shell tanks and single-shell tanks, with reduction of safety risks given the highest priority. The new technical strategy contains three major program elements. These are to Manage Tank Waste, Process Waste, and Manage System-Generated Waste and Excess Facilities. These three elements are briefly described below.

Manage Tank Waste - includes a wide range of activities to ensure that the storage, characterization, retrieval, and transfer of double- and single-shell tank wastes is conducted in a safe, environmentally sound, and compliant manner, and to ensure that these activities are integrated with and supportive of other TWRS activities. Major activities include:

- Characterize the waste in double- and single-shell tanks to support safety issue resolution, technology development, waste retrieval, and processing for disposal. Characterization is an integral part of the entire Tank Waste Remediation System. The characterization program embodied in the current Tri-Party Agreement focuses on obtaining information about the contents of single-shell tanks to support a future "leave/retrieve" decision. As retrieval of the single-shell tank wastes is the planning basis for the proposed New Technical Strategy, the characterization program must be refocused to obtain information on the characteristics of the tank waste needed for safety issues resolution and for development and implementation of waste retrieval and processing capabilities required for successful implementation of the New Technical Strategy. The efficiency of the characterization program will be enhanced through the use of the Data Quality Objectives approach to defining data needs, judicious use of existing analytical and process history information, development of techniques for in situ characterization, and use of offsite analytical laboratories to supplement the analytical capacity and capabilities of the Hanford analytical laboratories;
- Resolve safety issues, including noxious vapors issues;
- Establish a comprehensive safety and environmental basis for resolving safety issues, operating facilities, restoring and upgrading facilities equipment, and all other activities needed to ensure safe and environmentally sound management of tank waste;
- Restore and upgrade facilities and systems to improve facility operations and surveillance (ensuring safe storage and transfer of the wastes);
- Prevent or minimize leaks to the environment;
- Provide sufficient waste storage capacity to support safety issue resolution, retrieval and processing needs, and the overall Hanford environmental restoration missions, including construction of new double-shell tanks; and
- Establish waste retrieval capability to support the Process Waste function.

DRAFT

Change Number

M-TWRS-93-01

Page 5

Description/Justification of Change (Cont.)

Process Waste - This element of the proposed New Technical Strategy encompasses activities required for processing of tank wastes for disposal. One key aspect is the early pretreatment of the soluble fraction of the tank wastes (which comprises the majority of tank waste volume) to remove the majority of their radioactivity and destroy hazardous components. Another key element is development of the technologies required for decision on the process and capacity needed to pretreat and immobilize the sludge portion of the tank waste, followed by design, construction, and operation of the facilities required to implement this decision.

Within the proposed New Technical Strategy, an accelerated development and deployment of required processing capabilities coupled with a phased approach to processing of the waste (the order in which wastes will be processed will be phased to coincide with the availability of the capability required to perform the needed processing) is planned. In order to ensure that the required processing capabilities are operational as rapidly as possible, existing technologies and commercially available systems will be used whenever appropriate.

Two phases of waste processing are planned. The first phase includes processing of waste from "watch list" tanks to resolve safety issues, and processing of the soluble fraction of the waste (liquid, saltcake, and sludge wash solution) from all tanks. An Initial Pretreatment Module is being designed for addressing the tank safety issues, including destroying organic compounds and removing selected radionuclides. The soluble fraction comprises approximately 70% or more of the waste in the Hanford tanks. This soluble fraction will be processed to remove the majority of the radioactivity and destroy certain hazardous components, including organics and nitrates/nitrites. The pretreated waste stream will be low-level waste and be disposed of onsite, first as grout and possibly later as another improved waste form.

The second phase involves technology development and pretreatment of the insoluble (sludge) fraction of the waste to separate the radioactive and non-radioactive components, and solidification of the radioactive components (plus the radionuclides removed from the soluble fraction) as glass. With the planning base now including treatment of both double- and single-shell tank waste, the glass production capacity of the previously-planned Hanford Waste Vitrification Plant (HWVP) is too small. On the other hand, the capacity of the previously-planned HWVP could be too large if extensive radionuclide separations can be achieved. Thus, expedited decisions must be made about the pretreatment processes that will be applied to the sludge (which will essentially define the amount of radioactive waste to be solidified as high-level waste glass). To provide the information required for making this decision, DOE is developing a program for 1) developing and demonstrating pretreatment technologies, and 2) technologies for improving vitrification capacity. Once a decision has been reached, schedules for the design, construction and operation of additional pretreatment and vitrification facilities can be developed.

Manage System-Generated Waste and Excess Facilities - The low-level waste generated as a result of the processing of tank waste will be disposed of on-site as grout or other compliant waste form. Other secondary wastes will be prepared for disposal in accordance with applicable standards. Excess facilities will be cleaned out and transferred to the Environmental Restoration Program for decontamination and decommissioning. All waste from the tanks will be sufficiently retrieved to meet closure requirements. The empty tanks will be transferred to the Environmental Restoration Program for closure.

Description/Justification of Change (Cont.)

In summary, the TWRS Strategic outlook can best be viewed in phases. In the first phase, the "Manage Tank Waste" Activities will focus on resolution of safety issues and reducing leaks, characterization of wastes, restoration of the storage system functions, initiation of upgrades of facilities and equipment to bring them into compliance with requirements; reduction of waste volumes; and the construction of new waste tanks. The "Process Waste" Activities will include a program to pretreat selected salt cake and supernate wastes which can be treated with existing technology to yield a compliant low-level waste for subsequent immobilization and disposal and an aggressive technology development and demonstration program to enable a joint selection of a technical approach for treating and immobilizing the difficult-to-treat sludge. "Manage System-Generated Wastes" activities will focus on immobilization and disposal of compliant low-level wastes and cleanup and transfer of excess facilities and equipment to appropriate organizations outside of TWRS.

In the next phase, the "Manage Tank Waste" Activities will focus on completing activities initiated in the first phase, staging waste to facilitate processing, reducing the volume of waste, extending the service life of the storage system, and the design and construction of needed replacement or additional facilities. The "Process Waste" Activities will focus on continuing to process wastes that can be processed to compliant waste forms using available technology to design, construct and operate processing facilities to treat all of the wastes. "Manage System-Generated Waste" Activities will continue activities as discussed above. The long-term horizon is dominated by the acquisition and operation of needed replacement systems until the completion of the processing of wastes for disposal or storage. This period is characterized by the completion of the processing system implementation, emptying of tanks and resultant closure.

Benefits of the proposed New Technical Strategy include:

- Addressing all double- and single-shell tank wastes in a comprehensive manner
- Early resolution of safety issues, minimization of leaks, and improvements in tank farm instrumentation and infrastructure
- Moving forward the decision to retrieve waste from single-shell tanks
- Earlier initiation of tank waste cleanup with pretreatment of soluble fraction
- Potential for less radioactivity being disposed of at Hanford, reducing the environmental impact to the region and minimizing the number of high-level waste canisters to be disposed of in a repository
- Opportunity for technology development and transfer, enhancing the regional technology and economic base
- Improved management as an integrated system
- Enhancement of the Tri-Party Agreement by providing a comprehensive and integrated set of milestones for managing the Tank Waste Remediation System
- Levelized construction impacts on local community infrastructure

DRAFT

Change Number

M-TWRS-93-01

Page 7

Description/Justification of Change (Cont.)

Section 3: Strategy for Tri-Party Agreement Changes

To reflect the substantial departure from the current Tri-Party Agreement proposed by this change request, the following major changes to the Tri-Party Agreement are proposed:

- Major Milestones M-01 through M-10, and M-31 will be deleted. Much of the work scope encompassed by these milestones will be included in the reconfigured portion of the Tri-Party Agreement as outlined below. To avoid confusion, the numbers deleted will not be reused.
- Three major new milestones groupings will be created to reflect the major programmatic elements of the Tank Waste Remediation System program. These three major milestone groups are:
 - M-40 through M-49 Manage Tank Waste
 - M-50 through M-59 Process Tank Waste
 - M-60 through M-69 Manage System-Generated Waste

Each of these milestone groupings will have a number of major milestones which reflect the key work to be performed within the program area.

- Finally, milestones will be established for making key decisions on the dual technology development path necessary to select the most viable pretreatment and immobilization pathway. These key decisions on which new technologies to pursue for the future cleanup of tank waste will lead to the development of further milestones. Commitment dates will be established during the public involvement period for those activities where there is an adequate technical and schedular basis.

Description/Justification of Change (Cont.)

Section 4: Proposed Milestone Outline

Manage Tank Wastes:

- M-40 Resolve Tank Safety Issues for High Priority Watch List Tanks
- M-41 Complete Single-Shell Tank Interim Stabilization for non-Watch List Tanks
- M-42 Provide Additional Double-Shell Tank Capacity
- M-43 Tank Farm Upgrades
- M-44 Characterize 177 Hanford HLW Tanks
- M-45 Evaporator Operation
- M-46 New Double-Shell Tank Storage Capacity
- M-47 Retrieval of Tank Waste
- M-48 Complete SST Retrieval

Process Tank Waste:

- M-51 Initiate Pretreatment Operations to Resolve Tank Safety Issues
- M-52 Initiate Early Pretreatment Operations to Demonstrate Capabilities and to Provide Tank Space for Resolution of Tank Safety Issues and Management of Tank Wastes
- M-53 Develop Pretreatment Technologies for Supernatants, Salt Cake, and Sludge
- M-54 Melter Technology Development
- M-55 Select TWRS Pretreatment and Immobilization Strategy
- M-56 Initiate Operations of Separations Pretreatment Complex
- M-57 Design and Construct Hanford Waste Immobilization Plant

DRAFT

Change Number

M-TWRS-93-01

Page 10

Description/Justification of Change (Cont.)

Section 5;

Milestones M-40 through M-49

Manage Tank Waste

951332.0100

Description/Justification of Change (Cont.)

Manage System-Generated Waste

- M-60 Initiate Grout Operations to dispose pretreated, low-level wastes
- M-61 Construct New Grout Vaults to Support Grout Operations
- M-62 Technology Development for Enhanced Grout or Alternate Low-Level Waste Immobilization Forms
- M-63 Design, Construct, and Initiate Operations of Enhanced Low-Level Waste Immobilization Facility
- M-64 Operate Enhanced Low-Level Waste Immobilization Facility

Description/Justification of Change (Cont.)

Milestone Descriptions

<u>Milestone</u>	<u>Description</u>	<u>Proposed Dates</u>
M-40-00	Resolve Tank Safety Issues for High Priority Watch List Tanks	
M-40-01	Complete Tank 241-SY-101 low speed mixer pump test and issue report	March 1995
M-40-02	Upgrade temperature monitoring capabilities in ferrocyanide tanks	December 1995
M-40-03	Complete vapor space sampling of all ferrocyanide tanks	June 1995
M-40-05	Complete process test in high heat tank 241-C-106	August 1995
M-40-06	Complete vapor sampling characterization of tank 241-C-103 (Phase 2)	September 1995
M-40-07	<u>Watch list Tank Interim Stabilization:</u> Recommend new milestones for remainder of stabilization program for the watch list tanks.	March 1995
M-40-07-T1	Complete engineering analysis and safety assessment to determine action to be taken if a Watch List tank begins to leak.	March 1995
M-40-07-T2	Complete safety study analysis and provide report to EPA and Ecology on interim stabilization of all remaining watch list tanks. This study to include: (a) Ferrocyanide tanks (b) Hydrogen/flammable (c) Organic tanks	September 1994
M-40-07-T3	Resolve Criticality USQ in Hanford tank farms to allow waste transfers required by interim stabilization.	March 1995
M-41-00	Complete Single-Shell Tank Interim Stabilization for non-Watch List Tanks	
M-41-01-T1	Interim Stabilize an Additional Five Single-Shell Tanks	October 1994

* Final TWRS program schedules and corresponding milestones will be developed after the public involvement process has been completed and adequate technical and scheduler basis has been developed.

9313322.0101

Description/Justification of Change (Cont.)

Milestone Descriptions

<u>Milestone</u>	<u>Description</u>	<u>Proposed Dates</u>
M-41-02	<u>Emergency Leak Response</u> : Prepare an improved single-shell tank emergency pumping capability.	March 1995
M-41-02-T1	Complete Safety Analysis to allow alternate methods for transfer of radioactive waste within single-shell tank (SST) farms.	March 1995
M-41-02-T2	Complete design and procurement of alternate transfer methods, and mount appropriate equipment in the emergency pumping trailer.	September 1994
M-41-02-T3	Issue detailed procedures for emergency pumping (or other action if not safe to pump) for each tank.	March 1995
M-41-02-T4	Complete restoration of 244-U, double-contained receiver tank (DCRT).	March 1995
M-43-00	Tank Farm Upgrades	
M-43-01A	Issue FDC for ventilation systems on double-shell tanks, Project W-061	March 1995
M-43-03A	Issue FDC for tank farm instrumentation, data collection, reduction and analysis as an integrated system, Project W-199	September 1994
M-43-05	Upgrade tank farm electrical distribution systems	
M-43-05A	Issue Engineering Study for tank farm electrical distribution systems	June 1995
M-43-08	<u>Construction of less-than-90-day storage pad</u> : Construct and place in service a fully compliant less-than-90-day storage pad within the 200 areas	September 1993
M-43-09	The USDOE shall provide to EPA and Ecology the draft curricula for the upgraded Maintenance Training program and an implementation schedule for that training.	June 1994

* Final TWRS program schedules and corresponding milestones will be developed after the public involvement process has been completed and adequate technical and scheduler basis has been developed.

DRAFT

Description/Justification of Change (Cont.)

Milestone Descriptions

<u>Milestone</u>	<u>Description</u>	<u>Proposed Dates</u>
M-43-10	The USDOE shall complete the portions of the Nuclear Operator systems class and on-the-job training that relate to the Operator Routines and Liquid Level Monitoring. Documentation of completion of Operator training shall be provided by submittal of a letter from USDOE to EPA and Ecology.	December 1993
M-43-11	The USDOE shall provide to EPA and Ecology the schedule for completing the training for all Operations Supervisors and Shift Managers in accordance with the upgraded Supervisor and Shift Managers will also be provided.	June 1993
M-44-00	Characterize 177 Hanford HLW Tanks	
M-44-01	Take 24 core samples from DST's or SST's	September 1993
M-44-01-T01	Resubmit TWRS waste analysis plan, focusing on safety, retrieval, pretreatment and other processing needs via DQO process	September 1993
M-44-01-T02	Submit 3 tank characterization reports for initial evaluation	September 1993
M-44-02	Issue 20 tank characterization reports	September 1994
M-44-02-T01	Complete all FY 1992 and 1993 core sample analyses	September 1994
M-44-03	Issue 30 tank characterization reports	September 1995
M-44-08	Restore Rotary Mode Core Sampling to Hanford	March 1994
M-45-00	Evaporator Operation	
M-45-01	Restart the 242-A Evaporator - Discharge to LERF Basins	December 1993
M-45-02	Complete Initial Processing of Dilute DST Waste - to LERF Basins	March 1995

* Final TWRS program schedules and corresponding milestones will be developed after the public involvement process has been completed and adequate technical and schedular basis has been developed.

Description/Justification of Change (Cont.)

Milestone Descriptions

<u>Milestone</u>	<u>Description</u>	<u>Proposed Dates</u>
M-46-00	New Double-Shell Tank Storage Capacity	
M-46-01	Recommend Additional Double-Shell Tank Milestone(s)	December 1993
	This milestone provides an engineering study of future tank storage requirements and will determine if additional tanks will be required to facilitate the cleanup of Hanford tank waste.	
M-48-00	Complete SST Retrieval	
M-48-01A	Start Design for sluicing of high heat waste to resolve safety issue	October 1994
M-48-02A	Complete Technology Development required to support SST Retrieval Demo	September 1994

* Final TWRS program schedules and corresponding milestones will be developed after the public involvement process has been completed and adequate technical and scheduler basis has been developed.

Change Number
M-TWRS-93-01
Page 15

DRAFT

Description/Justification of Change (Cont.)

Milestones M-51 through M-59
Process Tank Waste

93-01-015

Description/Justification of Change (Cont.)

Milestone Descriptions

<u>Milestone</u>	<u>Description</u>	<u>Proposed Dates</u>
M-51-00	Initiate Pretreatment Operations to Resolve Tank Safety Issues	
M-52-00	Initiate Early Pretreatment Operations to Demonstrate Capabilities and to Provide Tank Space for Resolution of Tank Safety Issues and Management of Tank Wastes	
M-52-01A	Select Initial Tanks for Cesium Removal	April 1994
M-54-00	Melter Technology Development - Complete melter and pretreatment technology development sufficient for disposal long range deployment decisions	
M-54-01	Start Pilot-Scale testing (3-5x HWVP)	December 1994

* Final TWRS program schedules and corresponding milestones will be developed after the public involvement process has been completed and adequate technical and schedular basis has been developed.

Change Number
M-TWRS-93-01
Page 17

DRAFT

Description/Justification of Change (Cont.)

**Milestones M-60 through M-69
Manage System Generated Waste**

99/3322.0104

Description/Justification of Change (Cont.)

Milestone Descriptions

<u>Milestone</u>	<u>Description</u>	<u>Proposed Dates</u>
M-60-00	Initiate Grout Operations to dispose pretreated, low-level wastes	
M-60-01-T01	Issue WHC Grout Performance Assessment for DOE-HQ Review	July 1993
M-60-01-T02	Complete Grout operations Implementation Plan for Emergency Operations Readiness until pretreated waste is available	September 1994

* Final TWRS program schedules and corresponding milestones will be developed after the public involvement process has been completed and adequate technical and scheduler basis has been developed.