

## Idaho Cleanup Project (ICP) Core Pre-Proposal - Site Tour Solicitation No. DE-SOL-0007097

<b>Stop</b>	<b>Time</b>	<b>Description</b>	<b>Facility</b>	<b>Type</b>	<b>Narrative</b>
EIL	7:00 a.m.	Bus departs Energy Innovation Laboratory (EIL) (775 University Blvd, Idaho Falls), en route to Radioactive Waste Management Complex (RWMC) point out Materials and Fuels Complex (MFC) from highway	Materials and Fuels Complex	Show photographs of the Radioactive Scrap Waste Facility (RSWF)	<ul style="list-style-type: none"> <li>• Pass around photographs of the RSWF facility to participants on the bus ride out to the (Idaho National Laboratory) INL site. Photographs include two aerial shots and two ground level shots of the area.</li> <li>• Point out that the Idaho Cleanup Project (ICP) contractor will operate RSWF for receipts of Experimental Breeder Reactor (EBR)-II fuel from Idaho Nuclear Technology and Engineering Complex (INTEC) and for contract scope related to the Remote Handled Transuranic (RH-TRU) waste in Lots 11 and 12. RH-TRU waste is retrieved from the RSWF for treatment in the Chemical Processing Plant (CPP)-666 hot cell.</li> <li>• INL contractor will continue to receive shipments at the current rate (approximately 6 shipments per year). Remaining shipments will be placed in RSWF.</li> </ul>

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Stop	Time	Description	Facility	Type	Narrative
1	8:00 a.m.	Tour Advanced Mixed Waste Treatment Project (AMWTP)	AMWTP	Transuranic Storage Area Retrieval Enclosure Waste Management Facilities (WMF)-636	<ul style="list-style-type: none"> <li>• WMF-636 was built over the waste to be retrieved and was permitted for RCRA operations to get the waste out by 2018. The Subsurface Disposal Area (SDA) buildings off to the left of the 636 are the targeted TRU waste (CERCLA work).</li> <li>• While standing on Pad 1; Pad 2 is through a door and looks the same as Pad 1. Everything is RCRA permitted (Pad 1 and Pad R has RCRA Interim Status). Point out gray soft-side containers and drums, which are an example of degraded boxes and drums retrieved from the Retrieval Containment Enclosure (RCE). Some of the drums stored in this area came from retrieval and will go over to the treatment facility for treatment. There are various inventories of drums stored in the Pad 1 area that await treatment. It is anticipated that the Pad 1 area could be used to store treated waste, since this waste, after treatment, will have no liquid.</li> <li>• Utilizing the space in Pad 1 for storage of treated waste reduces the need for additional storage down to possibly only one additional storage building.</li> <li>• The building was built around the dirt berm and the drums are in various stages of processing – directly from retrieval the containers are over-packed.</li> <li>• Enter Control Room for RCE - view active retrieval operations.</li> <li>• This contract will involve boxes to be removed that are in poor condition, collapsed boxes, degraded and rust-covered drums. All the waste must be treated - mixed waste types: sludge, debris and soil.</li> <li>• People working in Retrieval are wearing powered-air-purifying-respirators (PAPRs) and Anti-contamination clothing. Two yellow tents stationed over boxes being retrieved (mobile Inner Containment Enclosure (ICE)). Retrieval is done with four-sided supports on boxes to ensure structural integrity. Forklifts and long reach tools are utilized to retrieve waste.</li> <li>• Discuss Pad R (located on other side of the RCE) which includes cargo containers with drums from the 1970s. Cargo containers are now waiting to be retrieved. Cargo containers only have drums, no boxes, but the degraded condition of the waste is similar to the containers in the RCE.</li> <li>• Both the RCE and Pad R cargo unloading location are vented out through the High Efficiency Particulate Air (HEPA) filters and stack.</li> </ul> <p>While driving from RCE to treatment Facility:</p> <ul style="list-style-type: none"> <li>• Payloads are assembled in building WMF-635 and transported to the Type 2 storage modules (WMF-628 through 634), which are RCRA permitted.</li> <li>• TRUPAC trailers are staged between 636 and 635</li> <li>• The small blue building (WMF-618) is used for loading waste into TRUPACT IIs on semi-trailers. Two trailers can be loaded at one time. TRUPACT IIs remain on the trailers at all times during the loading process.</li> <li>• Storage capacity in WMF-628 is limited due to Flam Gas equipment and operations in the building.</li> <li>• While driving by the treatment facility (WMF-676) note that new, empty silver drums are fed into supercompactor building through the east side of the building.</li> </ul>

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Stop	Time	Description	Facility	Type	Narrative
				Characterization Facility (WMF-634)	<ul style="list-style-type: none"> <li>• WMF-634 is permitted for storage, but primarily utilized for characterization.</li> <li>• Characterization is done in two different Real-Time Radiography (RTR) machine systems. Containers come out of retrieval and come here to determine treatment path. The drums and boxes are assayed to determine radiation levels and are RTR's for prohibited items and the type of waste. Boxes are assayed in the box assay machine. After characterization the waste is determined to be TRU or Mixed Low Level/Low Level Waste (M/LLW).</li> <li>• Point out drum and box assay machines.</li> <li>• After treatment the waste containers are assayed a second time in the treatment facility.</li> <li>• WMF-610 has a small assay machine with limited throughput.</li> <li>• There is headspace gas sampling equipment in the building which is in standby in case of changes to Waste Isolation Pilot Project (WIPP) acceptance criteria (WAC).</li> <li>• There are various container configurations – drums and boxes of various sizes, such as some gray boxes containing shredded box material from the treatment facility. These shredder boxes have assayed as TRU waste and will still be here for the upcoming contract. These boxes contain large items that will need to be either removed or the entire container disposed of at WIPP using a TRUPAC III container. Note that AMWTP is not currently authorized for TRUPAC IIIs. In addition the box assay equipment is not currently certified for TRUPAC IIIs.</li> <li>• Another standby capability is the drum coring machine, which is a glove box that was used for RCRA sampling. Offsite waste from the DOE complex (e.g., Hanford) was sampled here prior to a WIPP WAC change that made the core sampling unnecessary. This capability remains in case the WIPP WAC is changed to again require core sampling.</li> <li>• The other Type II RCRA storage facilities (WMF-628 through 633) all look the same, except WMF-628 and 634 are the only Type II storage building that are insulated and heated to maintain the characterization machinery.</li> </ul>

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Stop	Time	Description	Facility	Type	Narrative
				Treatment Facility (WMF-676)	<ul style="list-style-type: none"> <li>• Walked from WMF-634 to WMF-676 (treatment facility) – pointed out the large silver propane tank south of WMF-676.</li> <li>• Everyone enters treatment facility control room to watch the process of the super compactor on the screens. Provide overview of the control room.</li> <li>• View following processes: <ul style="list-style-type: none"> <li>-The boxes and drums come in the facility in boxes or in boxes containing 6 drums per box (6-drum over-packs).</li> <li>- Boxes enter that facility, go up an elevator, the lids are removed by a box-opening robot that cuts the tops off (e.g., the Sandia M3 bins).</li> <li>-The box lines have a clamping frame that lifts the boxes and have a tipping yolk to control the waste being deposited into the box line.</li> <li>-There are two box lines. The northern box line has two troughs and the south box line has one trough. Visual examination is performed and large prohibited items are removed. The box lines are hydraulic driven and there are two ports in each trough. The waste is deposited through the ports and placed in 55-gallon lightweight drum (aka silvers) below the box lines for supercompacting.</li> <li>- The drums enter the lidding station, a lidder crimps, seals, and places the drums in storage waiting assay. There are 2 assay machines in the building. All steps controlled remotely.</li> <li>- For WIPP certification, drums are assayed, since configuration has changed. The waste code is entered into the Waste Tracking System (WTS) before compaction.</li> <li>- There are safety and criticality controls (assay value, WTS, and fissile gram equivalent (FGE) for Mass Control Area (MCA) by the remote operator before the drum is compacted.</li> <li>- The drum enters the supercompactor glove box and verified by the WTS and is punctured/vented and placed into the compactor and compacted into a “puck”.</li> <li>-After the silver becomes a puck it moves in a trolley to the puck handler where the pucks are put in a 100-gallon drums (referred to as 100-gallon product drums).</li> <li>- 100-gallon product drums are then sent for RCRA storage awaiting shipment as M/LLW or to WIPP as TRU waste.</li> <li>- There is spattering in the super compactor from liquid squeezed from the debris waste by the four million pounds of pressure from the supercompactor. This liquid is referred to as “squeezant” and is collected in a sump for later treatment.</li> </ul> </li> <li>• Direct feed – drums that do not need to go through the box line can be direct-fed into the supercompactor for volume reduction. The supercompactor can only compact 55-gallon drums, so 55-gallon drums must be removed from 85-gallon drum overpacks.</li> </ul>

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2	9:45 a.m.	Arrive at Radioactive Waste Management Complex - Restroom Break	RWMC	Guard house (WMF-637) - RWMC model	<ul style="list-style-type: none"> <li>• At the RWMC model note the following: <ul style="list-style-type: none"> <li>- AMWTP portion of RWMC is a RCRA operation under the Idaho Treatment Group (ITG) contract to meet the Idaho Settlement Agreement requirement for the 65,000 m<sup>3</sup> of TRU waste out of Idaho by 2018.</li> <li>- Buried waste exhumation and related work at the SDA is CERCLA work under a CERCLA Record of Decision (ROD). Accelerated Retrieval Project (ARP) V is the exception, where AMWTP TRU sludge waste is repackaged in a WIPP compliant configuration. Exhumation scope at ARP V is completed and the facility is now RCRA permitted for this purpose. SDA work is under the Chem2M Hill Washington Group Idaho (CWI) contract.</li> <li>- AMWTP waste was stored above ground on Asphalt pads after 1970 and then the waste was covered with soil.</li> <li>- Administrative support area boundary</li> <li>- Subsurface disposal Area (SDA) boundary</li> <li>- Aquifer protection is a key aspect of environment work. The Aquifer is over 600 feet deep at RWMC.</li> <li>- Point our LLW disposal area, which is closed except for vault-disposal of RH-LLW from Naval Reactors facility, which expected to continue through 2020 unless NE completes its new disposal facility and it begins to be used for disposal of the Navy RH LLW before 2020.</li> <li>- Point out where ARPs I through VIII were located, and point out ARPs I and VI were D&amp;D'd and where the last ARP IX will be located.</li> </ul> </li> </ul>
3	10:00 a.m.	Subsurface Disposal Area tour- Includes; Accelerated Retrieval Project VIII and ARP V Closed Circuit Television (CCTV) trailer	RWMC Subsurface Disposal Area (SDA)	SDA and Accelerated Retrieval Project (ARP) facilities	<ul style="list-style-type: none"> <li>• While approaching the SDA, point out building (WMF-1602) where Idaho State police do their inspection of TRUPACT II trailers before they leave the site.</li> <li>• In SDA, point out ongoing foundation construction for ARP IX, the final ARP planned. ARP IX's footprint is partially over the footprints of the former ARP I and VI, which are now demolished. ARP IX will have a transfer tunnel to ARP VII, since it will not have its own air lock and drum packaging stations.</li> <li>• Note ongoing pile driving, which is to prevent structural integrity issues caused by subsidence. Foundation is being constructed by CWI. Retrieval enclosure to be constructed by a separate construction/D&amp;D contractor and planned for 2017.</li> </ul>

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			RWMC-SDA	ARP VIII	<ul style="list-style-type: none"> <li>• ARP VIII – note the following:               <ul style="list-style-type: none"> <li>- Point out maintenance bay where equipment is maintained and through which workers enter retrieval area</li> <li>- Workers are in anti-C clothing and using PAPRS for breathing protection. Equipment cabs have supplied air for operators.</li> <li>- Number and letter markings on walls of retrieval enclosure are grid markings, which are used to ensure grid locations and to track exhumation progress for fee and regulatory purposes.</li> <li>- Point out assay screening detector to screen waste trays for radiation levels to facilitate effective waste management</li> <li>- Targeted waste and 5.69-acre exhumation requirement were originally identified through negotiation with regulatory agencies to ensure removal of the material presenting the highest environmental risk - principally uranium and plutonium isotopes - with expectation of removing significant organics as well. This is documented in the Agreement to Implement and the OU 7-13/14 CERCLA ROD.</li> <li>- View Drum packaging Station (DPS) through doors – point out personnel doing Visual Examination portion of waste certification process.</li> <li>- Point out empty drums staged outside DPS room and workers preparing drums with liners, etc., which are part of the process used to ensure no contamination escapes as waste is drummed.</li> <li>- The personnel currently performing Visual Examination of exhumed buried waste are Central Characterization Project (CCP) personnel; however, by the time the ICP Core contract period starts all characterization/certification will be rolled into the AMWTP characterization/certification program. This is part of the consolidation effort and will be accomplished before ICP Core contract transition, so there will be only a single Contact Handled (CH)-TRU characterization/certification program transitioned.</li> </ul> </li> </ul>

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Stop	Time	Description	Facility	Type	Narrative
			RWMC	ARP V CCTV trailer	<ul style="list-style-type: none"> <li>• ARP V Closed Circuit TV (CCTV) trailer – note the following:                             <ul style="list-style-type: none"> <li>- Personnel in CCTV are in communication with equipment operators to direct the operation. Note monitors displaying heat spectrum from infrared camera.</li> <li>- Waste drums are brought in through the maintenance bay. The drums are emptied into the large trough in the retrieval enclosures. Excavator operators empty the drums, add inorganic clay-based absorbent, and put the waste in smaller trays to transport it to the DPSs where it is processed similar to how the buried waste is processed. Emptied drums are crushed and placed in waste boxes and shipped for disposal as M/LLW.</li> <li>- The excavator operator and the CCTV specialist work together to determine how much absorbent needs to be added to the waste in the trough before placing it the waste trays for transport to the DPS.</li> <li>- While at the trailer, point out SDA map on the wall and the footprint of exhumation in each ARP, which is designated on the map.</li> <li>- Working with state to get ARP V RCRA permitted for repackaging CH-TRU sludges from AMWTP saved a lot of money compared to building a new facility for that purpose. Sludge repackaging in ARP V is expected to continue, since additional sludge has to be treated beyond what will be done during the current contract period.</li> </ul> </li> </ul>
4	11:00 a.m.	Depart RWMC for the Idaho Nuclear Technology and Engineering Complex	N/A		
5	11:15 a.m.	Arrive at INTEC	N/A		
6	11:30 a.m.	Restroom Break- <b>LUNCH</b> (INTEC Cafeteria)	INTEC	Cafeteria	LUNCH

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7	12:30 p.m.	Tour Fluorinel Dissolution Process and Fuel Storage Facility (CPP-666) - Includes FDP hot cell, spent nuclear fuel basins	CPP-666	Fluorinel Dissolution Process (FDP) Hot cell	<ul style="list-style-type: none"> <li>• Note that original fuel reprocessing equipment is still in the building.</li> <li>• Historically fuel was brought into hot cell via a transfer canal from the basins. The hot cell was retrofitted from its original mission, so that waste can be transported via truck and offloaded remotely by crane into the hot cell. The 102 cans Navy Nuclear Propulsion Program Pieces Parts and Fines (NNPP PPF) scope, which is located in the spent fuel storage basin, adjacent to the FDP area, will be brought into the hot cell via the original transfer tunnel/canal which requires upgrades prior to use.</li> <li>• Hot Fuel Examination Facility (HFEF)-5 sized waste containers were used to design the current hot-cell operations system. Any larger container size must be size-reduced in cell to be handled effectively.</li> <li>• The waste container or drum, once placed in the hot cell, is placed on a stand, and the lid is cut off the container in order to access the waste inside.</li> <li>• There are three stations: Argon repack station (inert), standard packaging station (not inert), and smaller argon packaging station (inert). Argon atmosphere stations are used to: <ul style="list-style-type: none"> <li>– size reduced</li> <li>– sodium treated</li> <li>– water immersion</li> <li>– spritzing</li> <li>–repacking</li> <li>– sodium distillation (located below hot-cell)</li> </ul> </li> <li>• The standard packaging station functions are the same as inert, but the waste is removed from the argon station and paced here to verify there are no reactive components and allowed to “air cure”.</li> <li>• Visual examination is performed during these steps.</li> <li>• Waste that required sodium distillation is passed through a port in the floor into the sodium distillation system. Once the sodium has been distilled/removed from the waste, it is pulled back up into the hot cell and repackaged.</li> <li>• The waste is loaded out of the cell into 30-gallon drums, the drum goes through the hatch and is lowered into a 55-gallon drum over-pack, it goes through the vault doors and an in-cell crane puts it into a concrete over-pack called an interim storage container (ISC).</li> <li>• Discussed the sodium distillation process where temperature and pressure is used to vaporize the sodium. The vaporized sodium transfers to a condenser, then sodium it is cooled to a liquid, and collected in a transfer vessel. The process approved by the State of ID and allows for the treatment of remote-handled TRU waste containing Sodium. The sodium waste can them be disposed of as M/LLW.</li> <li>• There are some issues with the condensers and Radiation (RAD) levels. There is a new design that is modular where the condenser and collection vessel are one, removable item.</li> <li>• Viewed the sodium distillation equipment on camera located below the hot cell.</li> <li>• Waste goes through a port, into the cell for distillation.</li> </ul>

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			CPP-666	Spent Nuclear Fuel Storage Facility	<p>Left FDP area and entered the spent fuel storage basin area:</p> <ul style="list-style-type: none"> <li>• Three types of SNF discussed (NNPP, Advanced Test Reactor (ATR), and EBR II). Main work is the NNPP fuel returns by 2018, then ATR and EBR II. The EBR II fuel trays have 8 bottles per tray and 2 trays in a shipment for a total of 16 bottles per shipping. This assumes use of HFEF-6 cask.</li> <li>• Point out fuel type models on display rack.</li> <li>• Point out location of Fuel Transfer Cart.</li> <li>• Note that several posters on display will be uploaded to the Documents Library</li> <li>• The NNPP fuel is removed from the basin using a cask liner, the liners are decontaminated in one of the two decontamination rooms, and loaded in a transport cask in the south end of CPP-666. Fuel is transported to NRF where accountability turnover is made at the Naval Reactor Facilities (NRF) facility parking lot. NRF is responsible for unloading and returning cask.</li> <li>• EBR II is currently removed from the basin, loaded into and HFEF-6 transport cask, and turned over the INL contractor for transport to MFC.</li> <li>• The EBR-II scope of work is to remove 3,336 bottles from wet storage, dry if necessary, load it into a transfer cask, and transfer it to MFC for either transfer to the INL contractor or to storage in RSWF.</li> <li>• ATR fuel receipts – the ICP Core contractor will receive up to 15 shipments of ATR spent fuel per year from the INL contractor for placement into the storage basin for further cooling. After approximately five years it can be transferred to dry storage.</li> <li>• ATR fuel in the storage basin that is cooled enough to be placed in dry storage, currently estimated to be 1,000 fuel elements, will need to be removed from the storage basin and placed in dry storage by the end of the contract period.</li> <li>• The water in the storage basin is purified with resins. Resins will be replaced before the new contract. The new resin should last through the upcoming contract period.</li> <li>• The fuel basins are 40 feet deep and are stainless-steel lined.</li> </ul> <p>Exit out of the fuel storage basin area:</p> <ul style="list-style-type: none"> <li>• CPP-603 was the original wet storage basin from the 1950's. The wet storage basins have been closed and grouted in place. CPP-603 also has a dry storage vault currently in use and partially filled. It contains some of the spent fuel from Fort St. Vrain and the ATR spent fuel.</li> <li>• 603 is air-cooled and low temperature.</li> <li>• We are committed to a 2023 removal of all fuel from wet to dry storage per the Idaho Settlement Agreement.</li> </ul>
8	1:25 p.m.	Depart CPP-666	N/A		

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9	1:30 p.m.	Walk by INTEC Tank Farm	INTEC Tank Farm	INTEC Tank Farm	<p>Note the following:</p> <ul style="list-style-type: none"> <li>• Point out Process Equipment Waste Evaporator (PEWE) and Liquid Effluent Treatment &amp; Disposal (LET&amp;D), which are to be RCRA closed per PWS Section C.6.</li> <li>• Point out the seven calcine bins - #7 is empty. First generation bin sets are bermed.</li> <li>• Point out Tank Farm location: <ul style="list-style-type: none"> <li>- 11 tanks are already closed (four smaller tanks and the western seven large 300,000-gallon tanks) leaving only the last four large 300,000-gallon tanks on the eastern end of the tanks farm to be closed.</li> <li>- PWS Section C.4 requires an interim cover over the tank farm in two phases – Phase A over the western 2/3 in 2017 and Phase B over the eastern 1/3 the first field season after closure of the last four Tank Farm tanks.</li> </ul> </li> </ul>
10	1:35 p.m.	Tour New Waste Calcining Facility (CPP-659)	INTEC New Waste Calcining Facility (CPP-659)	RH-TRU Operations	<ul style="list-style-type: none"> <li>• CPP-659 (New Waste Calcine Facility) was originally used to calcine high level liquid waste from the INTEC Tank Farm. The facility is now used to repackage RH-TRU waste that is small enough to fit into the hot cell and is limited to a rad dose rate of 5 R per hour at 30 cm. The hot cell is limited to containers that are less than 10 feet long. RH-TRU waste that can be repackaged in CPP-659 will enter the building through a roll-up door on the south end of the building and is picked up by a crane and brought into the building for repackaging and characterization. The RH-TRU waste from CPP-666 that has been repackaged enters CPP-659 the same way. All RH-TRU waste is characterized in CPP-659 and certified for shipment. The RH-TRU waste is also loaded into RH-72B casks for shipment to WIPP.</li> <li>• View camera monitor showing the hot cell and the repackaging equipment.</li> <li>• All piping to Integrated Waste Treatment Unit (IWTU) from the Tank Farm passes through CPP-659.</li> </ul>
11	1:45 p.m.	Walk by Calcine Bin Sets, cask storage	INTEC		<ul style="list-style-type: none"> <li>• Walk by and pointed out calcine bins</li> <li>• Point out Three Mile Island (TMI) spent fuel dry storage area</li> <li>• Point out CPP-749, underground dry storage vaults for Spent Nuclear Fuel. Looks very similar to RSWF facility at MFC.</li> <li>• Point out M/LLW storage area in CPP-1617 (CPP-1617 is an outdoor fenced in asphalt pad for storage)</li> <li>• Point out Interim Storage Containers (ISC) for RH-TRU waste storage and stored sleeves used at RSWF.</li> </ul>
12	2:15 p.m.	Depart INTEC for Integrated Waste Treatment Unit	N/A		
13	2:45 p.m.	Tour Integrated Waste Treatment Unit (IWTU)	IWTU	Sodium Bearing Liquid Waste Treatment	<ul style="list-style-type: none"> <li>• Tour of the IWTU facility consisting of a walkthrough of the main floor. Point out the various components of the process outlined on the video, which is posted at the procurement web site. (<a href="https://www.emcbc.doe.gov/SEB/ICPCORE/Site%20Tour.php">https://www.emcbc.doe.gov/SEB/ICPCORE/Site%20Tour.php</a>)</li> </ul>
14	4:30 p.m.	Depart IWTU	N/A		

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15	4:40 p.m.	Windshield tour of the Idaho CERCLA Disposal Facility (ICDF)	Idaho CERCLA Disposal Facility	CERCLA Landfill and Evaporation Ponds	<p>Note the following at ICDF:</p> <ul style="list-style-type: none"> <li>• ICDF has two basic parts, the two, lined evaporation ponds and the landfill.</li> <li>• ICDF is for disposal of onsite CERCLA waste, including from D&amp;D under a CERCLA non-time critical removal action.</li> <li>• The ponds have been used for disposal of water from emptying Spent Nuclear Fuel basins. They are currently used mainly for disposal of purge water from groundwater monitor well sampling.</li> <li>• The landfill is over 60% full, but capacity should last beyond the ICP core contract period.</li> <li>• The landfill is currently being used to dispose of soils from AMWTP waste retrieval operations (e.g., firebreaks) and to dispose of empty cargo containers that were used to store waste at AMWTP.</li> <li>• Note that the ICP Core contractor will operate ICDF through FY2016 and then turn it over to the Construction /D&amp;D contractor per the Performance Work Statement (PWS).</li> </ul>
16	4:50 p.m.	Depart ICDF/IWTU for Idaho Falls	N/A		
17	6:00 p.m.	Arrive at EIL, end of tour	N/A		