




**LOW LEVEL WASTE REPOSITORY GUIDANCE ON THE
 PREPARATION OF AN OPERATIONAL QUALITY PLAN FOR THE USE
 OF TC02 RE-USABLE IP-2 ISO CONTAINER**

Summary

Subject to the foregoing this Guidance Note should be read in conjunction with the LLW Repository Ltd IP-2 ISO Container Operational Documentation. Notwithstanding any other term of this Guidance Note, this Guidance Note is intended only to support the Container Design Operational Documentation by explaining the basis of the conditional requirements and providing additional information. Nothing in this Guidance Note shall be legally binding upon the Operator of the LLW Repository Ltd and all Terms and Conditions between such Operator and the Customer for the use of the LLW Repository Ltd IP-2 ISO supplied containers. In the event of any conflict between the provisions of the Guidance Note and any LLW Repository Ltd IP-2 ISO Container Design Approval Conditions, the Container Design Approval Conditions shall prevail in all respects.

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Prepared by		
		Johan Langham Package Approvals Engineer LLW Repository Ltd
Checked by		
		Mark Williams Package Services Manager LLW Repository Ltd
Approved by		
		Marc Flynn Transport & Logistics Manager LLW Repository Ltd

INDEX

Introduction 3

References..... 3

Appendix 1 Quality plan for operation of TC02 4

Introduction

This guidance note has been produced to outline the requirements for an operational quality plan for the TC02. As part of the license [1] to operate the TC02 IP-2 half height ISO container there is a requirement to use an operational quality plan to document all steps that are required in the Packing and Handling Instructions [2] to ensure the package meets the license requirements when operated by consignors.

An example of an operational quality plan has been produced by LLWR, see Appendix 1 This can be used by consignors to develop their own operational quality plan to comply with their own management systems, i.e. it dictates they have their own site specific quality plans. For small users with no site specific requirements the quality plan in appendix 1 may be used

References

1. TC02 Reusable HHISO Certificate of Approval, IP-96/GB/TC02
2. Packaging and Handling Instructions for Type TC02, IP-2 ISO Container , OM_LLWRGR_MECH_0001_A

Appendix 1 Quality plan for operation of TC02

**Example Quality Plan for Customer
Operation of the LLWR IP-2 TC02
Reusable Container & Stillage Restraint
System.**

Purpose: Operation of the LLWR IP-2 reusable container & stillage restraint system to comply with transport requirements.

Intended user: Users of the LLWR IP-2 TC02 HHISO Reusable Container	How to be used: Only for the operation of the LLWR IP-2 Reusable container & stillage system.
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Safety requirements

It is up to the customer to put in place the relevant safety controls.

Industrial safety requirements and other related information

Refer to P&H OM/LLWR/GR/MECH/00001/A

Personal Protective Equipment (PPE)

The recommended PPE is Hard Hat, EPD, Safety Boots, Gloves, High Viz.

Risk Assessment/Work Safety Plan

It is the customer's responsibility to undertake a risk assessment for the operations associated within this quality plan .

Amendment record

Amendments detailed below, are those made from:

Issue	to	Issue 1
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Date amendment(s) made	Section or paragraph amended	Details of amendment
Jan 2012		Initial issue

Introduction

The purpose of this quality plan is to ensure that packaging design N° TC02 and stillage restraint system can safely and correctly be used to load and transport waste from customer sites. This is an example quality plan produced by LLWR, it is recommended that the users of the TC02 container write their own quality plans in accordance with their own systems.

No work should begin until receipt Health Physics Survey for radiation contamination has been completed by Health Physics Department and recorded on Health Physics Monitoring Form TC02/MON/001 and they have released the Container and Stillage Restraint system.

Health Physics Survey's takes place at various stages of the disassembly process and is controlled by designated HOLD POINTS. The results of all Health Physics Monitoring is recorded on Form TC02/MON/001 which will remain in the TC02 Record Wallet throughout the receipt, loading and release process.

This Quality Plan will be used to record the activities undertaken at the by users of the TC02 during the receipt loading and release of the TC- 02 and stillage restraint system and identifies the activities, control documents, person responsible for signature and supplementary documents.

The Quality Plan will be used as an auditable record document, with certification signatures for completion of each activity.

Where the Container is received without Stillage's then N/A must be inserted against those operations associated with Stillage(s).

Where only Stillage's are received then N/A must be inserted against all those operations not associated with Stillage(s).

Before the TC02 container and/or Stillage's are released, a Suitably Qualified person must sign each item of the Quality Plan as acceptable. If an item on the Quality Plan is considered to be "REJECT", the reason for rejection must be either recorded on the plan, or recognised within an inspection report.

Major physical defects detected on the container and stillage restraint system shall only be repaired in accordance with approved procedures, endorsed by the LLWR Package Design Authority.

Where a line item calls for items to be replaced then "N/A" should be inserted if the Visual Inspection activity above it identified it as "Accept". Where a the Visual Inspection activity is identified as "Reject" then once the item has been replaced the "Accept" box should be ticked.

Any activity or condition identified as 'Reject' must have the reason for rejection and repair requirements added to the 'TC02 Repair Register'. Spares used in the repair must be added to the TC02 Spares Usage Register, Form 0301– Appendix 1'.

Scope

The Quality Plan splits the operations into ten distinct areas of work. A total of nine appendices are included for additional information:

The Quality Plan covers the receipt, visual inspection of the Container and Lid, Stillage(s), Lifting Frame and Waste Boxes, assembly and release inspection prior to transporting the container to a waste treatment facility.

If any damage to the container exceeds the limits detailed in the package and handling instructions the container shall be quarantined and the Design Authority notified.

WARNING:

- **HEALTH PHYSICS SURVEY'S AND INSPECTIONS OF THE CONTAINER BASE, CONTAINER LID AND STILLAGE BASE SHOULD BE CARRIED OUT FROM THE SIDE (DO NOT WORK UNDER THE CONTAINER).**

CAUTION:

- Any single dent greater than 25 mm are not acceptable on any part of the Container and must be referred to the Design Authority for sentencing. Two or more dents in any one plane greater than 15mm must be referred to the Design Authority.
- Petroleum based lubricants **MUST NOT BE USED** as they have a detrimental affect on seal life.
- Grease used for general lubrication of clamps etc **MUST NOT BE USED ON THE FILTER OR LID SEALS**
- All lifting and handling of the TC02 Container and its component part must comply with the Packing and Handling Instruction for Type TC02, IP-2 Container Doc Ref: OM/LLWRGR/MECH/00001/A.

This Quality Plan has been raised by LLWR Quality Department, on completion, this document shall be retained by LLWR Quality Department for archiving.

Glossary of abbreviations and definition of terms

SQEP	Suitably Qualified Experienced Person
TC	Transport Container
TQP	This Quality Plan
DGSA	Dangerous Goods Safety Advisor

Process and Control Description

The TC-02 container is designed, constructed and tested in accordance with the requirements for a Series 1 freight container, and as such it incorporates standard corner fittings and forklift pockets.

All container lifting and loading equipment must be suitably rated to handle the container safely. The following weight and dimensional information in table 1 below applies to the TC02 Container.

Table 1 Container Specification

G.A. Drg. No	OBE 2668146
Indicative Weights (kgs):	
Body	3575
Lid	525
Permissible Gross Weight	35000
Indicative External Dimensions:	
Height (mm)	1325
Width (mm)	2438
Length (mm)	6058
Volume (m ³)	12
Aperture Dimensions:	
Length (mm)	5040
Width (mm)	2008
Maximum Stacking Height:-	6
Lid Seal Configuration	Double
Seal Leak Test Method	Interspace

Table 2 Specific Information for the use of Stillage TC02/S1 & associated lifting frame TC02/L1

	TC02/S1	TC02/L1
G.A. Drgs. No	OBE 2688291	OBE 2688295
Indicative Weights (kgs):		
Weight	690	160
Safe Working Load	4310	5000
Indicative External Dimensions:		
Height (mm)	1137	N/A
Width (mm)	1950	1752
Length (mm)	2667	1650
Available Envelope		
Height (mm)	890	N/A
Length (mm)	2420	N/A
Width (mm)	1680	N/A
Maximum height required from crane hook to top of container during loading/unloading (mm)		3200

Reference Documents

OM/LLWRGR/MECH/00001/A.	Package and Handling Instructions for Container Design No TC-02
OM/LLWRGR/MECH/00002/A.	Maintenance Instruction for Container Design No TC-02
TC-02 Release Procedure Guidance Note	PAA/GN05
TC02/MON/001	TC02 Monitoring Form

Drawings

O BE 2668146 C	TC-02 Container General Arrangement
O BE 2688291 C	Base Stillage General Arrangement

Contents

Title	Page
1.....Plant Status, Receipt & Documentation Checks	11
2.....Pre- Inspection Preparation	13
3.....External Body Checks	14
4.....Lid Checks	16
5.....Stillage & Restraint System Checks	19
6.....Internal Container Body Checks	24
7.....HEPA Filter Checks	27
8.....Checks to Waste Boxes & Loading onto Stillage.	28
9.....Loading of Stillage & Waste Boxes into Container	30
10.....Final Inspection & Release Checks	35
Appendix 1.....TCO2 Spares Usage Register	37
Appendix 2.....Lifting using bottom fittings	38
Appendix 3.....Lifting using top fittings.	39
Appendix 4.....General Layout of Container	40
Appendix 5.....Layout of Stillage's & Lifting Frame within Container	41
Appendix 6.....Lid Guidance	42
Appendix 7.....Stillage locking positions	43
Appendix 8.....Stillage & Lifting Frame	44
Appendix 9.....Hepa Filter configuration	45

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 11 of 44

Record and Schedule of work for the Operation of a TC02 IP-2 Reusable Container & Stillage Restraint System.

WARNING:

HEALTH PHYSICS SURVEY AND INSPECTIONS OF THE CONTAINER BASE, CONTAINER LID AND STILLAGE BASE SHOULD BE CARRIED OUT FROM THE SIDE (DO NOT WORK UNDER THE CONTAINER)

Container Serial No :

1 Plant Status, Receipt & Documentation Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
1.1	Record vehicle and Container weight: Weight _____	TQP			Operations		
1.3	HOLD POINT Health Physics conduct initial <u>Receipt</u> Radiological Survey of Container outer surfaces and record on Health Physics Form TC02/MON/001.	PAA/GN05			Health Physics Monitor		
1.4	Check the CSC approval plate identifies the container is still within its maintenance date. Ensure the container maintenance is not due for at least one month from the estimated time of expected receipt by the consignee remains Record maintenance expiry date _____	P&H Inst			DGSA		
1.5	Confirm Package has valid package approvals certificate	P & H Inst			DGSA		

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Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 12 of 44

1 Plant Status, Receipt & Documentation Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
1.6	HOLD POINT Check the receipt Radiological Survey is complete and the container is within prescribed limits.	TQP			Operations		
1.7	HOLD POINT Check the document holder for damage assessment form, monitoring certificate and weight declaration form	TQP			Operations		
1.8	Record Container Serial No. Serial No. _____	TQP			Operations		
1.9	Record Lid Serial No. Serial No. _____	TQP			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 13 of 44

2 Pre- Inspection Preparation							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
2.1	Lift Container using suitable lifting equipment (see Appendix 2 & 3) and hold while Health Physics monitoring is carried out. Continue Container lowering in stages to permit additional Health Physics checks of corners of base to be carried out as required. CAUTION: Ensure the Container is set down on a flat surface (or castors) and not on any sharp objects.	TQP and P & H Inst			Operations		
2.2	HOLD POINT Health Physics conduct full Receipt Radiological Survey of Container outer surfaces and HEPA Filter and record on Health Physics Form TC02/MON/001.	PAA/GN05			Health Physics Monitor		
2.3	HOLD POINT Check the full Radiological Survey is complete and the container is within prescribed limits.	TQP			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 14 of 44

3 External Body Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
3.1	Visually examine all the external surfaces of the Container and Lid for signs of damage, burrs and distortion.	P&H Inst			Operations		
3.2	Cracking of welded joints is unacceptable.	P&H Inst			Operations		
3.3	Puncturing of the container body or lid is unacceptable.	P&H Inst			Operations		
3.4	Cuts, tears or abrasions in the container skin greater than 1.5 mm deep are unacceptable.	P&H Inst			Operations		
3.5	Small dents are acceptable (any single dent at 25mm on all parts. On panels, any single dent less than 25mm deep, any two dents 15mm greater than 1m apart are acceptable. On structural frame any single dent less than 25mm or two dents less than 15mm on a single plane are acceptable), provided that no puncturing of the skin has taken place.	P&H Inst			Operations		
3.6	Check condition of decal holders and repair or replace any damaged items.	P&H Inst			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 15 of 44

3 External Body Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
3.7	Replace any missing or damaged decal holders and record on Spares usage register. Form 0301 Appendix 1.	TQP			Operations		
3.8	Visually examine container corner post lifting points for signs of damage, cracking of welded joints is unacceptable.	P&H Inst			Operations		
3.9	Visually examine container Fork Pockets for signs of damage, cracking of welded joints is unacceptable.	P&H Inst			Operations		
3.10	Visually examine paint finish (minor scuffing of the paint finish is acceptable, bare metal is not acceptable except on base) and touch up if required.	P&H Inst			Operations		
3.11	Record any new damage on the damage assessment form 311 which accompanies the container	TQP			Operations		

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Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 16 of 44

4 Lid Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
4.1	<p>Remove the Lid by loosening the 24 nuts on the swing bolts that hold the clamps down and rotate the bolts and clamps away from the Lid.</p> <p>CAUTION: Use "Lid Guides Bars" to manoeuvre Lid (see Appendix 6)</p> <p>Lift Container Lid (see Appendix 4) to break the seal with the container flange using suitable lifting equipment and hold while monitoring is carried out. Ensure that the Lid and the base have separated before lifting the Lid clear. Continue Lid lifting in stages to permit additional checks on container to be carried out as required by Health Physics.</p>	TQP & P&H Inst			Operations		
4.2	<p>HOLD POINT Check there are no additional items other than Stillages inside the container</p>	TQP			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 17 of 44

4 Lid Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
4.3	HOLD POINT Health Physics conduct Receipt Radiological Survey of underside of Container Lid surfaces and record on Health Physics Form TC02/MON/001.	PAA/GN05			Health Physics Monitor		
4.4	HOLD POINT Check the Radiological Survey is complete and the container is within prescribed limits.	TQP			Operations		
4.5	Check underside of Lid panels for damage Small dents are acceptable (less than 25 mm on all parts).	P&H Inst			Operations		
4.6	Check underside of Lid for damage to Seal mating surface.	P&H Inst			Operations		
4.7	Lay Container Lid down in designated lay down on timber supports.	P&H Inst			Operations		
4.8	Visually examine all the external surfaces of the Lid including Guide Handles for signs of damage, burrs and distortion.	P&H Inst			Operations		
4.9	Visually examine all the top external surfaces of the Lid Lifting Lugs for signs of damage, burrs, distortion and cleanliness.	P&H Inst			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 18 of 44

4 Lid Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
4.10	Record any new damage on the damage assessment form 311 which accompanies the container	TQP			Operations		

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Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 19 of 44

5 Stillage & Restraint System Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
5.1	HOLD POINT Health Physics conduct Receipt Radiological Survey of all Stillage Twist Lock handle surfaces and record on Health Physics Form TC02/MON/001.	PAA/GN05			Health Physics Monitor		
5.2	HOLD POINT Check the Stillage Twist Lock Radiological Survey is complete and the container is within prescribed limits.	TQP			Operations		
5.3	Visually examine Stillage Lifting Frame attachment points for signs of damage, burrs, distortion and cleanliness.	P&H Inst			Operations		
5.4	Check Lifting frame is within inspection date.	P&H Inst			Operations		
5.5	Check pins on lifting frame are free from damage. There shall be no cracks, distortion and gross deformation visible	P&H Inst			Operations		
5.6	Check welds for damage.	P&H Inst			Operations		
5.7	Check there is no deformation on the beams and plate.	P&H Inst			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 20 of 44

5 Stillage & Restraint System Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
5.8	Check chains for any damage.	P&H Inst			Operations		
5.9	Release all Stillage Twist Locks (see Appendix 7) into open position.	P&H Inst			Operations		
5.10	Fix lifting frame to stillage.	P&H Inst			Operations		
5.11	Lift Stillage using suitable lifting equipment (see Appendix 8) and hold while monitoring is carried out. Continue Stillage lifting in stages to permit additional checks to be carried out as required by Health Physics.	TQP			Operations		
5.12	HOLD POINT Health Physics conduct Receipt Radiological Survey of underside of Stillage surfaces and record on Health Physics Form TC02/MON/001.	PAA/GN05			Health Physics Monitor		
5.13	HOLD POINT Check the Radiological Survey is complete and is within prescribed limits.	TQP			Operations		
5.14	Lift Stillage and visually check underside of Stillage for damage and place the Stillage on a protective floor covering in designated area.	TQP P&H Inst			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 21 of 44

5 Stillage & Restraint System Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
5.15	HOLD POINT Health Physics conduct Receipt Radiological Survey of Stillage surfaces and record on Health Physics Form TC02/MON/001.	PAA/GN05			Health Physics Monitor		
5.16	HOLD POINT Check the Radiological Survey is complete and the container is within prescribed limits.	TQP			Operations		
5.17	Record Stillage and Restraint System No 1 : Design No. _____ Serial No. _____	TQP			Operations		
5.18	Record Stillage and Restraint System No 2 : Design No. _____ Serial No. _____	TQP			Operations		
5.19	Visually examine all the external surfaces of Stillage for signs of damage. There shall be no cracks, distortion or gross deformation.	P&H Inst			Operations		
5.20	Cracking of welded joints is unacceptable.	P&H Inst			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 22 of 44

5 Stillage & Restraint System Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
5.21	Visually examine Stillage lifting posts for distortion.	P&H Inst			Operations		
5.22	Check all Stillage labels are in place and legible.	P&H Inst			Operations		
5.23	Replace any missing or damaged labels and record on Spares usage register. Form 0301 Appendix 1.	P&H Inst			Operations		
5.24	Visually examine Stillage Twist Lock assemblies for signs of damage. Replace any missing or damaged parts and record on Spares usage register. Form 0301 Appendix 1.	P&H Inst			Operations		
5.25	Remove Stillage Chocks and visually examine for damage then secure them to Stillage base.	P&H Inst			Operations		
5.26	Visually examine Chock fixing locations. There shall be no cracks or deformation.	P&H Inst			Operations		
5.27	Visually examine the Stillage Chocks T-Handle Lock Pins and Retaining Cables.	P&H Inst			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 23 of 44

5 Stillage & Restraint System Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
5.28	Secure Stillage base Chocks to Stillage base.	TQP			Operations		
5.29	Record any new damage on the damage assessment form 311 which accompanies the container	TQP			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 24 of 44

6 Internal Container Body Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
6.1	HOLD POINT Health Physics conduct Receipt Radiological Survey of Container inner surfaces including HEPA Filter and record on Health Physics Form TC02/MON/001 and insert completed form into TC02 Document Holder	PAA/GN05			Health Physics Monitor		
6.2	HOLD POINT Check the Radiological Survey is complete and the container is within prescribed limits.	TQP			Operations		
6.3	Visually examine the container internals for signs of damage, burrs, distortion and cleanliness.	P&H Inst			Operations		
6.4	Visually examine tie down points for damage, corrosion, deformation, change in section, cracks evident in main body or welds of tie down points.	P&H Inst			Operations		
6.5	Cracking of welded joints is unacceptable.	P&H Inst			Operations		
6.6	Puncturing of the container body is unacceptable.	P&H Inst			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 25 of 44

6 Internal Container Body Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
6.7	Cuts or abrasions in the container skin greater than 1.5 mm deep are unacceptable.	P&H Inst			Operations		
6.8	Small dents are acceptable (less than 25 mm), provided that no puncturing of the skin has taken place.	P&H Inst			Operations		
6.9	Visually examine seal housing and seal retaining grooves for damage, cracking of welded joints is unacceptable.	P&H Inst			Operations		
6.10	Visually examine containment Seal for signs of damage and deformity.	P&H Inst			Operations		
6.11	HOLD POINT Replace Seals if required and apply a light surface of silicone based grease on the seal surface. Record on Spares usage register Form 0301 Appendix 1. NOTE: Design Authority must be contacted and Container placed "On Hold".	TQP			Operations		
6.12	Visually examine swing bolts housings for damage, cracking of welded joints is unacceptable.	P&H Inst			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 26 of 44

6 Internal Container Body Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
6.13	Visually examine swing bolts & clamps for signs of damage and deformity. Ensure the retaining nuts can freely rotate by hand all the way down the thread.	P&H Inst			Operations		
6.14	Replace any missing or damaged bolts, nuts and washers and record on Spares usage register. Form 0301 Appendix 1.	P&H Inst			Operations		
6.15	Visually examine container corner post lifting points for signs of damage, cracking of welded joints is unacceptable.	P&H Inst			Operations		
6.16	Record any new damage on the damage assessment form 311 which accompanies the container	TQP			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 27 of 44

7 HEPA Filter Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
7.1	Visually examine all the external surfaces of Filter at 'A' end of Container for damage including securing bolts and washers (see Appendix 9).	P&H Inst			Operations		
7.2	Check the Filter is not blocked (replace if damaged). Including securing bolts and washers if damaged and record on Spares usage register. Form 0301 Appendix 1.	P&H Inst			Operations		
7.3	HOLD POINT Replace if damaged including securing bolts and washers if damaged and record on Spares usage register. Form 0301 Appendix 1. NOTE: Design Authority must be contacted and Container placed "On Hold".	TQP			Operations		
7.4	Check the Filter is in position.	TQP			Operations		
7.5	Health Physics complete Form TC02/MON/001 for Receipt and insert completed form into TC02 Record Wallet.	PAA/GN05			Health Physics Monitor		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 28 of 44

8 Checks to Waste Boxes & Loading onto Stillage.							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
8.1	Health Physics conduct Despatch monitoring checks of Waste Boxes on Health Physics Form TC02/MON/001.	PAA/GN05			Health Physics Monitor		
8.2	Check box(s) for any significant damage. Replace is necessary.	TQP			Operations		
8.3	The waste shall be evenly distributed along the length of the box and shall be distributed so that the centre of gravity is lower than half the height of the box.	P&H Inst			Operations		
8.4	The waste shall be loaded into the boxes in an efficient manor that makes maximum use of the available space. Accessible voidage (air space) shall be kept to a minimum to avoid any movement of contents during transport.	P&H Inst			Operations		
8.5	Large heavy items must be packed such that no significant movement can occur.	P&H Inst			Operations		
8.6	Check weight of waste and box does not exceed SWL of stillage and lifting frame.	P&H Inst			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 29 of 44

8 Checks to Waste Boxes & Loading onto Stillage.							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
8.7	Check box for damage after loading	TQP			Operations		
8.8	Load box on to stillage centrally ensuring no more than 60% of the weight is spread over 50% of the length of the stillage	P&H Inst			Operations		
8.9	Measure the item or box and position three (3) chocks on each side of the box in the predrilled holes on the base of the stillage so that when the item(s) is placed it is central on the stillage and the vertical face of the chock is as close to each end of the item as practicable. The chocks do not need to be in contact with the box or item but should be placed as close to the item or box as possible.	P&H Inst			Operations		
8.10	Fix a minimum of two ratchet straps over the box(s)/items(s) in both the longitudinal and lateral directions.	P&H Inst			Operations		
8.11	Check waste box is secured and ratchet straps are working and show no signs of damage (2.5 Te certified).	P&H Inst			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 30 of 44

9 Loading of Stillage & Waste Boxes into Container and re-assembly of TC02							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
9.1	Health Physics conduct Despatch Radiological Survey of Container inner surfaces including HEPA Filter and record on Health Physics Form TC02/MON/001	PAA/GN05			Health Physics Monitor		
9.2	Attach Lifting frame to stillage.	P&H Inst			Operations		
9.3	Lift the Stillage and place in the container so that the four uprights site correctly over the tie-down points in the base of the container. (Guides have been marked on top of container to assist the alignment over fixing points.	P&H Inst			Operations		
9.4	If shipping one box place in centre position of the container. If shipping two waste boxes place boxes in either end of the container. Ensure that no more than 60% of the weight is spread over 50% of the container.	P&H Inst			Operations		
9.5	Lift each Stillage and locate into Container body using Stillage location blocks after verifying Stillage & Restraint Systems are those removed from the Container.	P&H Inst			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 31 of 44

9 Loading of Stillage & Waste Boxes into Container and re-assembly of TC02							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
9.6	Remove Lifting Frame(s) from Stillage's	P&H Inst			Operations		
9.7	Record Stillage and Restraint System No 1 Design No. _____ Serial No. _____	TQP			Operations		
9.8	Record Stillage and Restraint System No 2 Serial No. _____ Design No. _____ Serial No. _____	TQP			Operations		
9.9	Confirm all Stillage Twist Locks have been closed. (see Appendix 7).	P&H Inst			Operations		
9.10	Health Physics conduct Despatch monitoring checks of Container outer surface on Health Physics Form TC02/MON/001.	PAA/GN05			Health Physics Monitor		
9.11	HOLD POINT A light surface of silicone based grease must be maintained on the seal surface and there must be no signs of age, damage, deformity or hardening of the seal.	P&H Inst			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 32 of 44

9 Loading of Stillage & Waste Boxes into Container and re-assembly of TC02							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
9.12	HOLD POINT Ensure all swing bolts are in the approximately horizontal position. The clamps need not be removed from the swing bolts. Apply 'Copaslip' or a similar anti-seize lubricant to the bolt threads as required.	P&H Inst			Operations		
9.13	Check that the seal interspace is clear.	P&H Inst			Operations		
9.14	Health Physics conduct Despatch monitoring checks of Lid on Health Physics Form TC02/MON/001.	PAA/GN05			Health Physics Monitor		
9.15	Check the Serial Number of the Container Lid to ensure it will be reassembled with the correct Container.	P&H Inst			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 33 of 44

9 Loading of Stillage & Waste Boxes into Container and re-assembly of TC02							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
9.16	<p>Lift Container Lid and locate onto Container body. The lid should only be located in one position on the container:</p> <p>NOTE: When positioning the lid ensure the decals match on each end of the Container and "A" end has the HEPA Filter.</p> <p>CAUTION: Use "Lid Guides Bars" (see Appendix 6) after verifying Lid is that removed from the Container.</p>	P&H Inst			Operations		
9.17	<p>Rotate the lid swing bolts and the clamps onto the lid edge and the clamp blocks (spherically seated washers are included in the assembly so no additional washers are required), ensure that clamps are located properly and not touching the lid.</p> <p>Check Torque Wrench is within calibration Period and then tighten all the nuts to a torque of 170 +/-10 Nm</p>	P&H Inst			Operations		
9.18	<p>Once the lid is secured, fit the security seals in each of the two positions located at each end of the lid/container.</p>	P&H Inst			Operations		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012
Last review date 01/2012
Page 34 of 44

9 Loading of Stillage & Waste Boxes into Container and re-assembly of TC02							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
9.19	Health Physics complete Form TC02/MON/001 for Despatch and insert completed form into TC02 Record Wallet.	PAA/GN05			Health Physics Monitor		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 35 of 44

10 Final Inspection & Release Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
10.1	Confirm the Container is free from dirt and ready for use.	TQP			DGSA		
10.2	Check all external Labels/decals are in position.	TQP			DGSA		
10.3	Verify the Serial Number of the Container.	TQP			DGSA		
10.4	Verify the Serial Number of the Container Lid to ensure it has been reassembled with the correct Container.	TQP			DGSA		
10.5	Where any repairs have taken place, provide details to LLWR	TQP			Quality Engineer		
10.6	Verify the security seals are fitted to each of the two positions located at each end of the lid/container.	TQP			DGSA		
10.7	Verify all areas of this quality plan are complete.	TQP			DGSA		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 36 of 44

10 Final Inspection & Release Checks							
Step	Description	Control Document	Inspection Condition		Person Responsible for Signature	Signature	Date
			Accept	Reject			
10.8	Verify completed: <ul style="list-style-type: none"> Health Physics Form TC02/MON/001 TC02 Spares usage register Form 0301 are included in TC02 Record Pack.	TQP			DGSA		
10.9	HOLD POINT Verify Container approved for Release.	TQP			DGSA		
10.10	Check all four Twistlocks on each rail carriage/road trailer are locked.	TQP			DGSA		
10.11	Record vehicle and Container weight: Weight _____	TQP			DGSA		
10.12	TC02 Record Pack together with this completed Quality Plan and all completed Forms placed in records storage.	TQP			DGSA		

LLW Repository Ltd

Quality Plan

QP

Issue 1 01/2012

Last review date 01/2012

Page 37 of 44

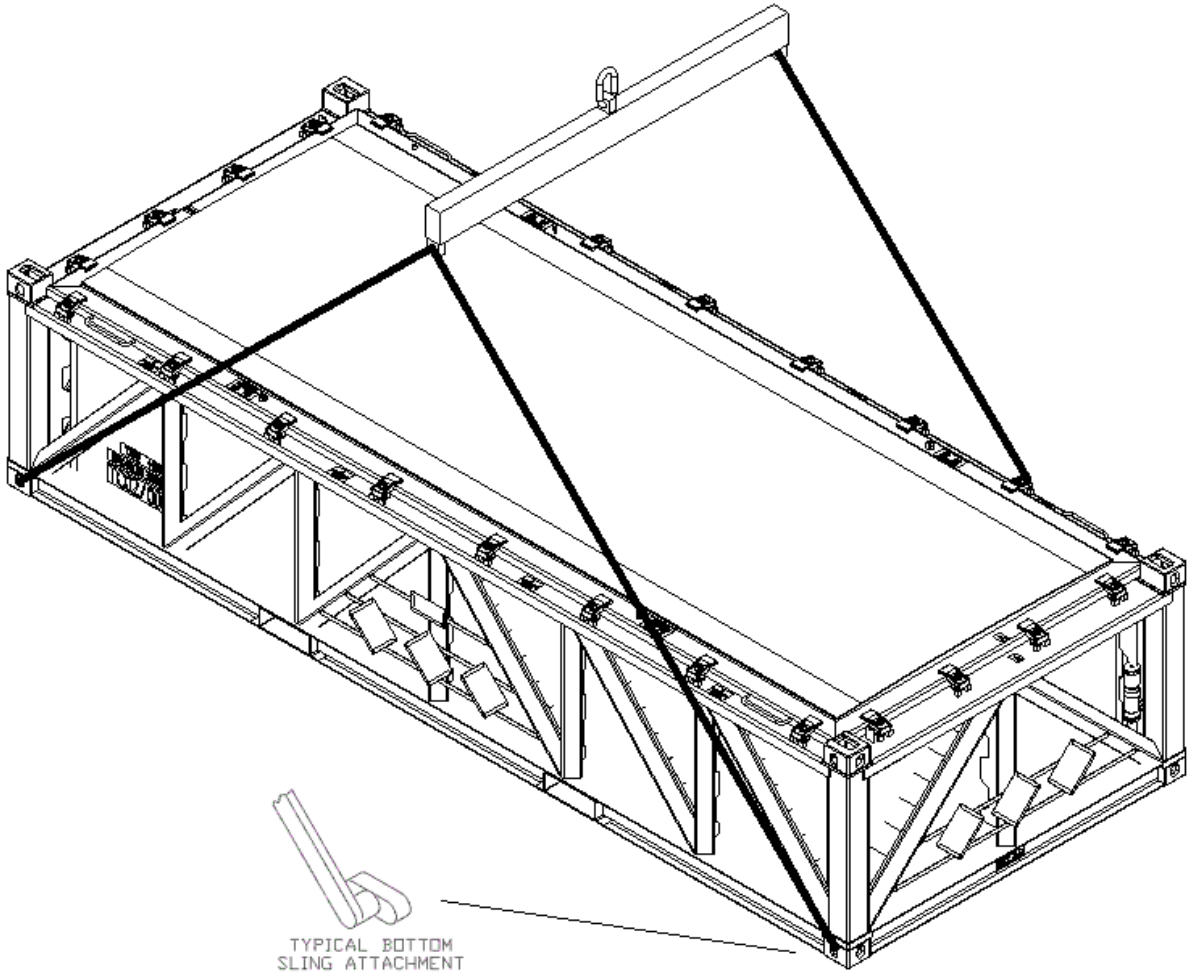
Appendix 1 TC02 Spares Usage Register

Equipment Type	Equipment Serial No	Description of item used	Manufacturer's batch and material identity code.	Number of items used	Signature of user	Date Used

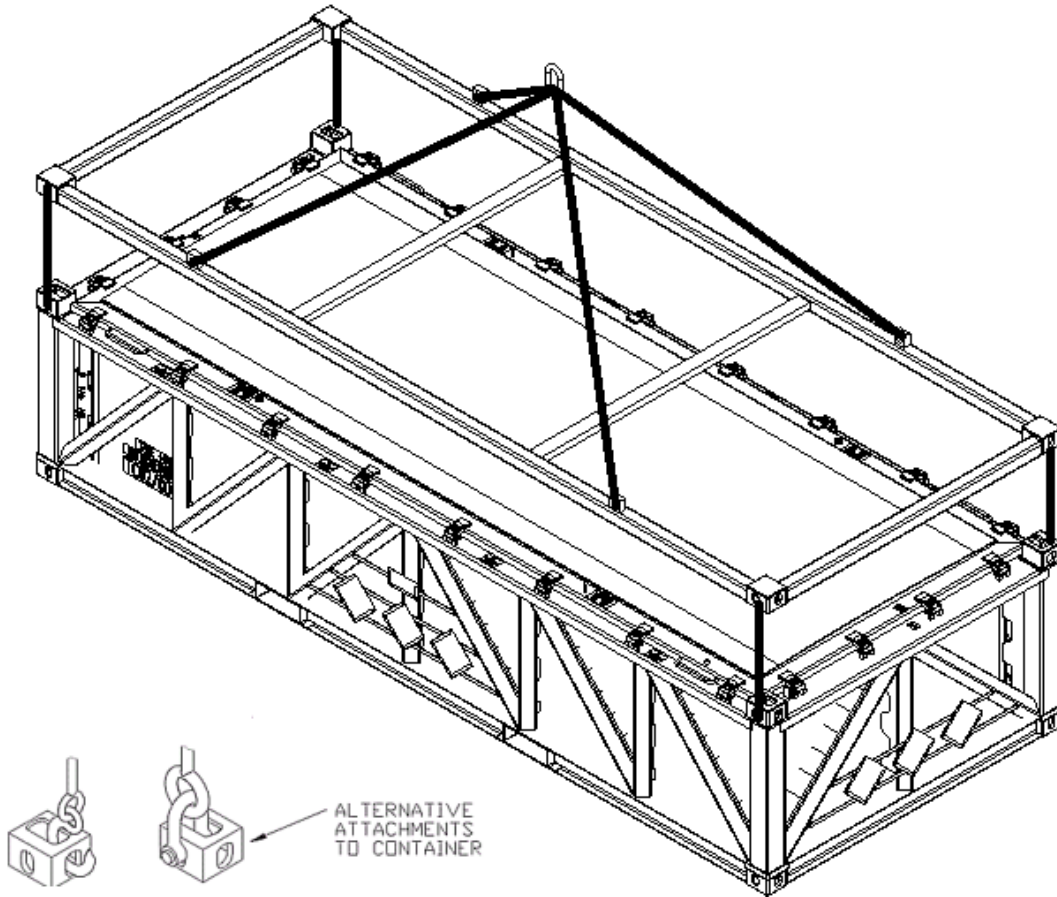
TC02 Repair Register

Equipment Type	Equipment Serial No	Description of Repair	NCR Ref No	SQEP signature	Date Repair Completed

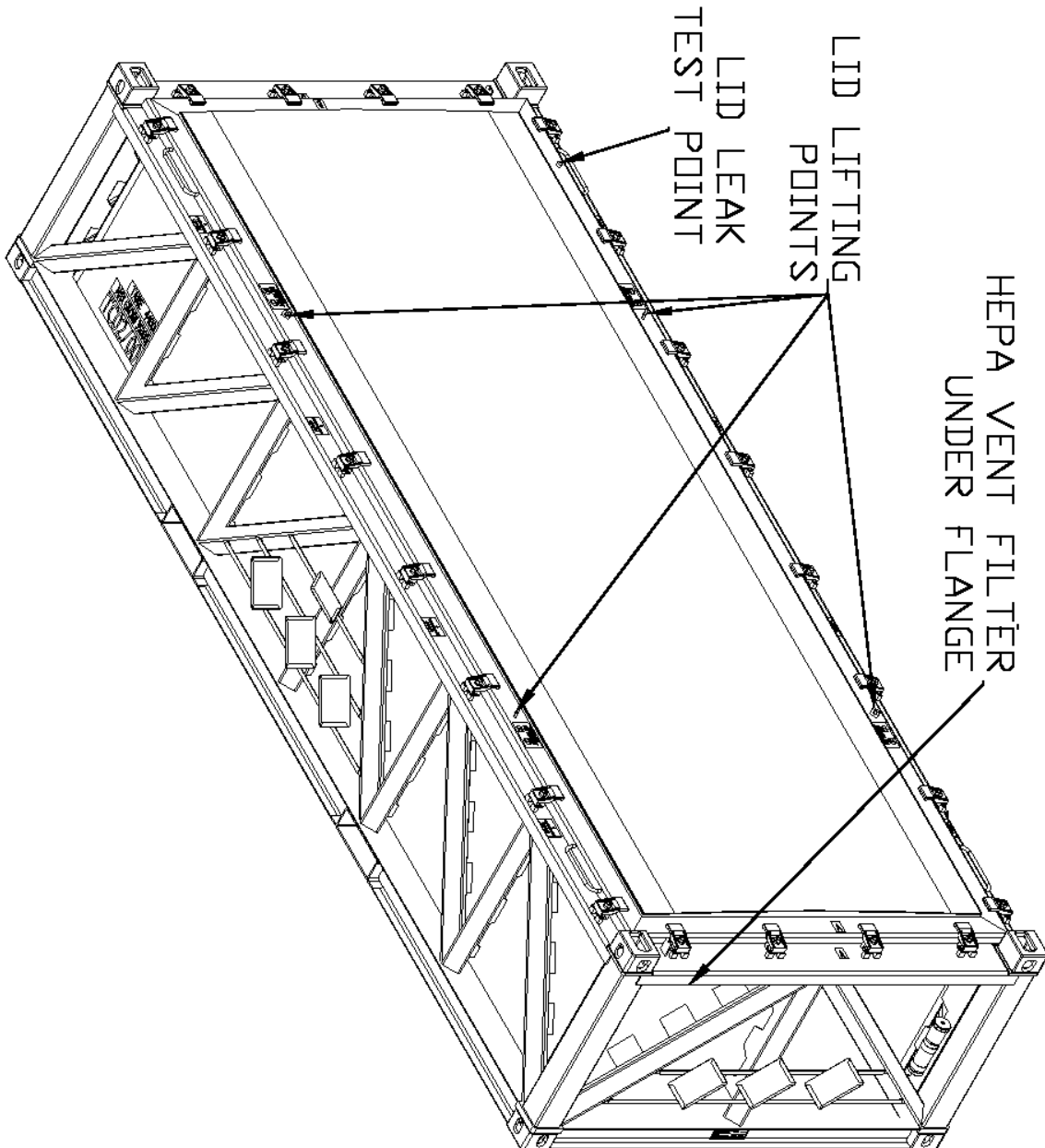
Appendix 2 Lifting using bottom fittings



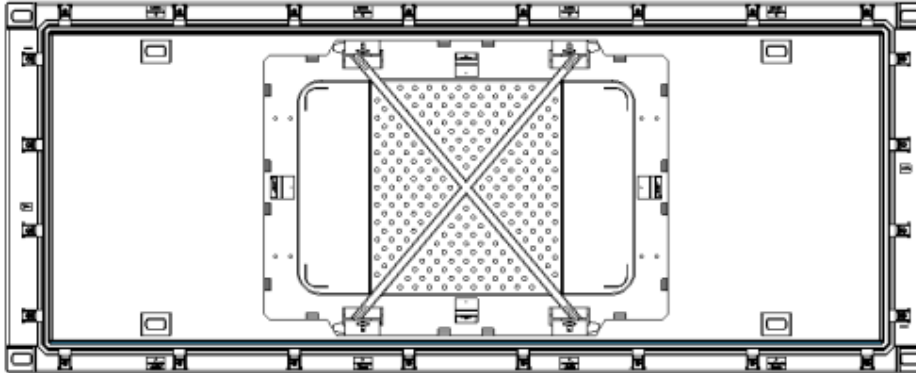
Appendix 3 Lifting using top fittings.



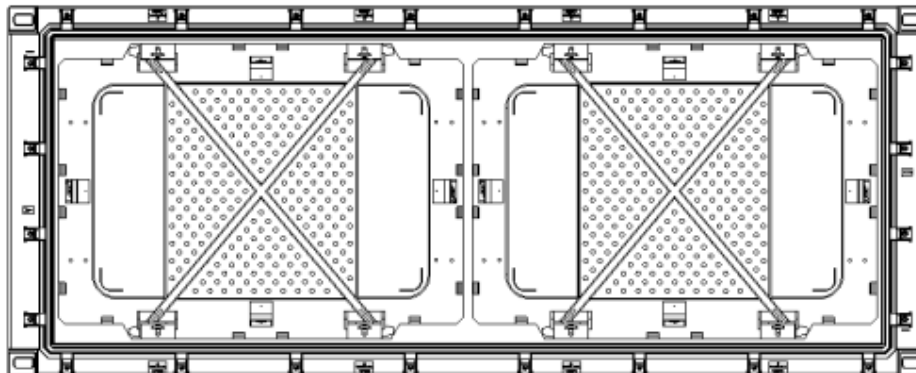
Appendix 4 General Layout of Container



Appendix 5 Layout of Stillage's & Lifting Frame within Container



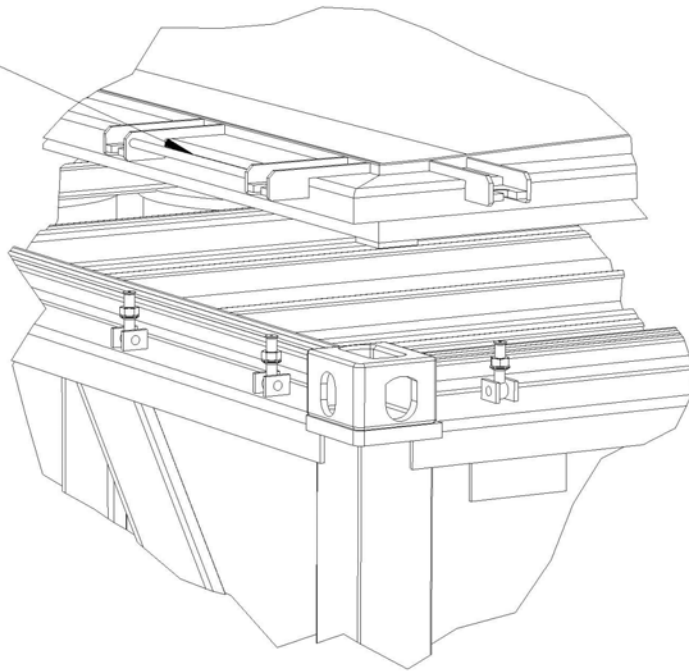
SINGLE STILLAGE ARRANGEMENT



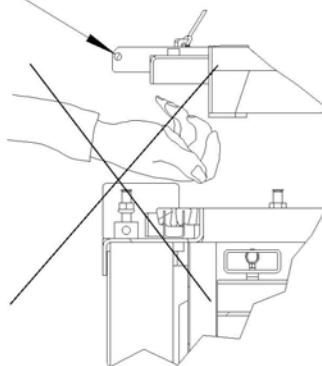
DOUBLE STILLAGE ARRANGEMENT

Appendix 6 Lid Guidance

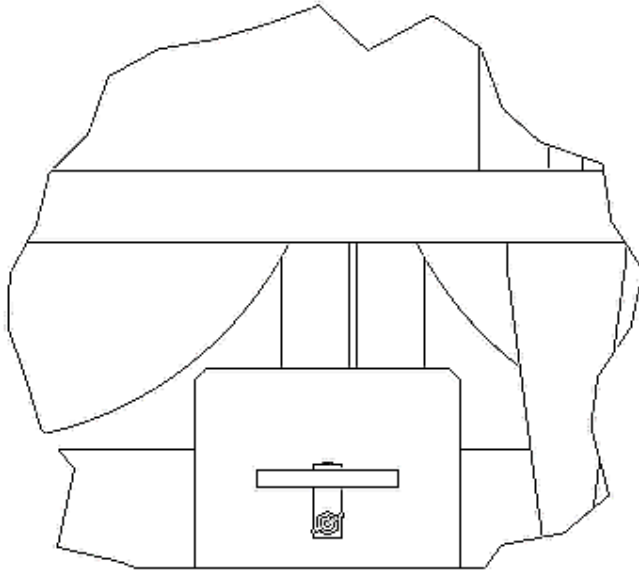
**LID GUIDE
HANDLE**



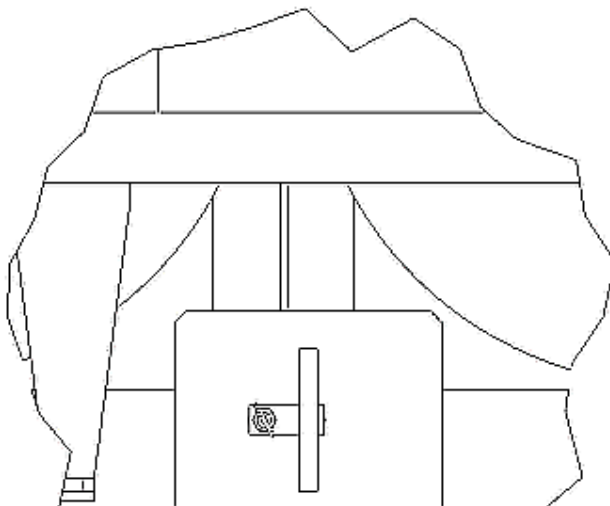
**USE LID GUIDE
HANDLES DURING
CLOSURE AS
NO CLEARANCE
UNDER LIP IN FINAL
POSITION**



Appendix 7 Stillage locking positions

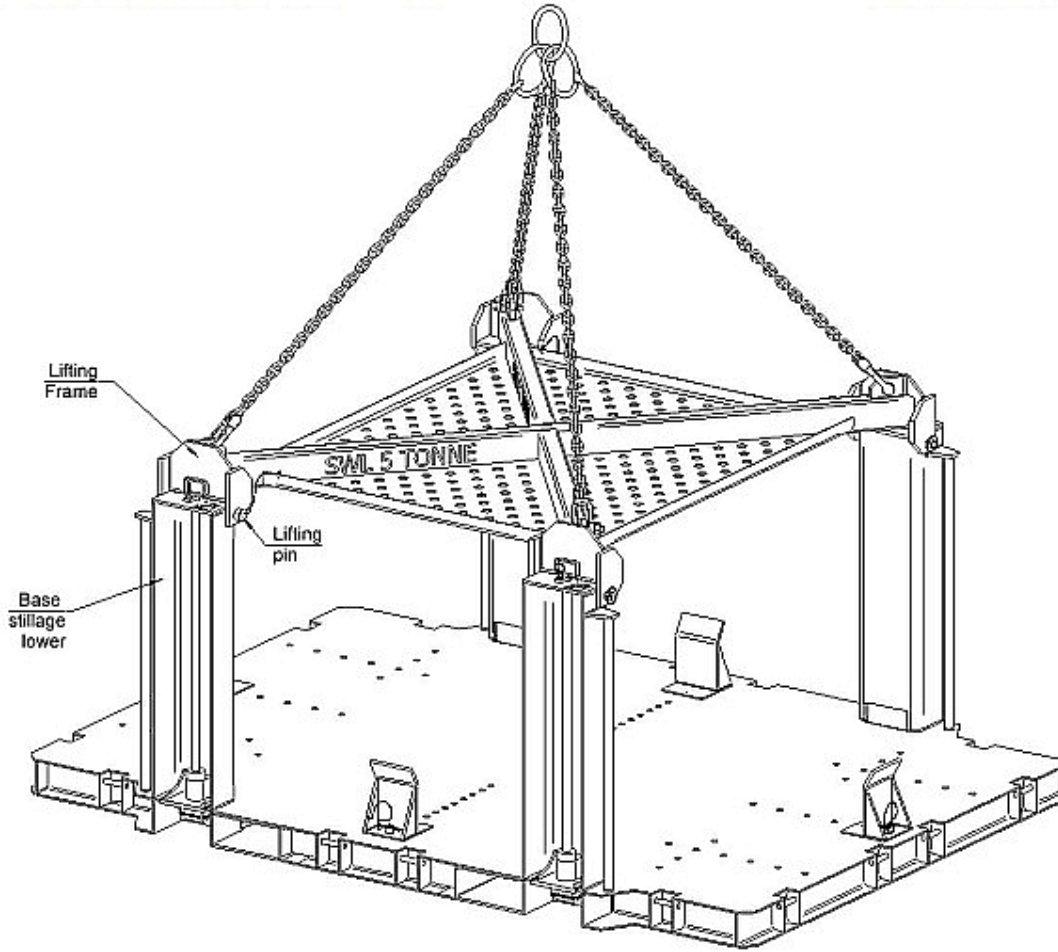


**STILLAGE IN THE
OPEN POSITION**



**STILLAGE IN THE
CLOSED / LOCKED POSITION**

Appendix 8 Stillage & Lifting Frame



Appendix 9 Hepa Filter configuration

