



QA: QA

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**BECHTEL SAIC COMPANY, LLC (BSC) QUALITY ASSURANCE (QA) SUPPLIER
SURVEY REPORT BSC-SFE-02-002 OF COORSTEK**

Enclosed is the Supplier Survey Report BSC-SFE-02-002 of CoorsTek that was performed on January 15-16, 2002, in Livermore, California, to evaluate the implementation and effectiveness of CoorsTek's Quality Program.

The survey revealed that CoorsTek's Quality Program and their implementation resulted in conditions adverse to quality that require resolution to meet the QA requirements that are imposed on suppliers of material fabrication services for the Yucca Mountain Site Characterization Project. The conditions adverse to quality are addressed in section 5.0 of the enclosed survey report as recommendations in the following QA program areas: Procurement Document Control, Implementing Documents, Control of Purchased Items and Services, Control of Measuring and Test Equipment, QA Records, and Audits.

Once BSC has received documentation resolving the recommendations, a determination will be made whether to perform a follow-up evaluation. Upon successful resolution of the recommendations, CoorsTek will be placed on the Office of Civilian Radioactive Waste Management Qualified Supplier List.

This survey is considered complete and closed as of the date of this letter.

If you have any questions, please contact either Richard L. Maudlin at (702) 295-2961 or Daniel A. Klimas at (702) 295-2665.

Donald T. Krisha, Manager
Quality Assurance

2/14/02
Date Signed

RLM:bk-0214021490

NMSS07

February 14, 2002

Page 2

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QA: QA

**BECHTEL SAIC COMPANY, LLC (BSC)
QUALITY ASSURANCE**

SUPPLIER SURVEY REPORT

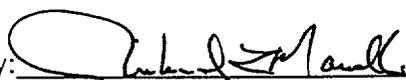
OF

COORSTEK

LIVERMORE, CA

REPORT NUMBER BSC-SFE-02-002

JANUARY 15-16, 2002

Prepared by: 
Richard L. Maudlin
Survey Team Leader
BSC Quality Assurance

Date: 02-07-02

Approved by: 
Donald T. Krishna, Manager
BSC Quality Assurance

Date: 2/13/02

1.0 SURVEY SUMMARY

BSC conducted a supplier survey of CoorsTek on January 15-16, 2002 at the Livermore, CA facility. CoorsTek provides material fabrication services. The survey revealed that CoorsTek's Quality Program and their implementation resulted in conditions adverse to quality that require resolution to meet the QA requirements that are imposed on suppliers of material fabrication services for the Yucca Mountain Site Characterization Project. The conditions adverse to quality are addressed in section 5.0 of the enclosed survey report as recommendations in the following QA program areas: Procurement Document Control, Implementing Documents, Control of Purchased Items and Services, Control of Measuring and Test Equipment, QA Records, and Audits.

The recommendations must be resolved before the BSC Quality Assurance can place CoorsTek on the Office of Civilian Radioactive Waste Management (OCRWM) Qualified Supplier List (QSL). Upon resolution of these recommendations, a decision will be made whether to perform a follow-up evaluation.

2.0 SCOPE

The supplier survey was conducted to evaluate the implementation and effectiveness of CoorsTek's QA Program as delineated in their Quality Assurance Policy Manual, Revision I, dated 01/12/01, and associated procedures. The QA program elements determined to be applicable are: Organization; QA Program; Procurement Document Control; Implementing Documents; Document Control; Control of Purchased Items and Services; Identification and Control of Items; Inspection; Control of Measuring and Test Equipment; Handling, Storage, and Shipping; Inspection, Test, and Operating Status; Nonconformances; Corrective Action; QA Records; and Audits.

The details of the survey, along with the objective evidence reviewed are contained within the survey checklist, which is available from the BSC Records Processing Center.

3.0 SURVEY TEAM MEMBERS

Richard L Maudlin, Survey Team Leader, BSC QA
Charles C. Warren, Survey Team Member, BSC QA
Roxanna VanDillen, Observer, BSC
John Estill, Observer, BSC/LLNL
Steve Mahler, Observer, BSC/LLNL

4.0 PERSONNEL CONTACTED DURING THE AUDIT

John Ghinazzi, Director, CoorsTek
Douglas Franksen, Manager, Quality Assurance, CoorsTek
Charles Murphy, Quality Engineer, CoorsTek
Donald Hawkins, Quality Assurance Systems Manager, CoorsTek
Andy Thomas, Customer Service, CoorsTek

5.0 SURVEY RECOMMENDATIONS

The following recommendations must be resolved prior to BSC placing CoorsTek on the OCRWM QSL.

1. The CoorsTek Quality Assurance Policy Manual does not provide requirements for procurement documents to include technical and quality requirements as required by Section 4.0 of the OCRWM Quality Assurance Requirements Document (QARD). A review of two CoorsTek Purchase Orders, PO 2140000906, dated 01/09/02, and PO 2140000561, dated 11/29/01, failed to include reference to quality requirements.
2. The CoorsTek Quality Assurance Policy Manual, Section 4.6.2, requires that an evaluation of subcontractors be performed based on their ability to meet subcontract requirements, including the quality system and any specific quality assurance requirements. Contrary to these requirements, CoorsTek could not provide adequate documented evidence that CoorsTek suppliers; Precision Measurements Inc., Astro/Cosmos, and CMM had the ability to meet subcontract requirements, including the quality system and any specific quality assurance requirements. Examples are as follows: Precision Measurements Inc. Purchase Order required the subcontractor to meet the requirements of MIL-STD-45662A, ANSI/NCSL Z540-1 and ANSI/ASQC Q9002-1994. Precision Measurements Inc. documentation did not support evaluation to the requirements of MIL-STD-45662A and ANSI/NCSL Z-540-1. There was no documentation on file to support the evaluation of CMM, a calibration supplier.
3. The CoorsTek Quality Assurance Policy Manual does not provide requirements for the receipt verification/inspection of items and services. No documentation could be provided to support the receipt verification/inspection of the calibration of measuring and test equipment to the requirements of CoorsTek Purchase Order PO 30929.
4. The CoorsTek Quality Assurance Policy Manual, Section 4.5.2, requires documents, such as procedures to be reviewed and approved. Contrary to these requirements, no documented evidence could be provided to reflect the review and approval of CoorsTek implementing procedures MEDI 4.05.6, Revision B and MDI 4.06.3, Revision A.
5. The OCRWM QARD, Section 5.0, requires implementing documents to provide a sequential description of the work to be performed. The CoorsTek Quality Assurance Policy Manual, Section 4.2.2, requires that documented procedures will serve to effectively define the quality system. A review of the CoorsTek implementing procedures MDI 4.06.1, Revision D titled "Procurement Procedure" and MDI 4.06.3, Revision A, titled "Supplier Evaluation" failed to include sufficient details, i.e.; sequence of the steps necessary to perform the activity.

6. The CoorsTek Quality Assurance Policy Manual, Section 4.11.7, requires that inspection, measuring, and test equipment users are notified to assess the validity of previous verifications and test results when inspection, measuring, and test equipment are found to be out of calibration. In the review of shop travelers and inspection documentation, no evidence could be found that the use of inspection, measuring, and test equipment is being recorded. Subsequently, if inspection, measuring and test equipment used in the fabrication process were later found to be out of calibration, there would be no way to determine where it was used.
7. The CoorsTek Quality Assurance Policy Manual fails to address requirements for the storage and preservation of quality records to prevent damage due to fire, extreme environmental conditions, and unauthorized entry as required by the OCRWM QARD, Section 17.0.
8. The CoorsTek Quality Assurance Policy manual fails to address requirements for the performance, as a minimum, of annual internal audits of the quality program as required by the OCRWM QARD, Section 18.0.