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GENERAL INFORMATION or OTHER

EVENT NUMBER: 27986

LICENSEE: COPE-S-VULCAN INCORPORATED  
 CITY: LAKE CITY REGION: 1  
 COUNTY: STATE: PA  
 LICENSE#: AGREEMENT: N  
 DOCKET:

NOTIFICATION DATE: 11/03/94  
 NOTIFICATION TIME: 13:39 [ET]  
 EVENT DATE: 11/03/94  
 EVENT TIME: 00:00[EST]  
 LAST UPDATE DATE: 11/03/94

PERSON ORGANIZATION

NRC NOTIFIED BY: SCARPELLI  
 HQ OPS OFFICER: GREG SCARFO

EMERGENCY CLASS: NOT APPLICABLE  
 10 CFR SECTION:

DEFECTS/NONCOMPLIANCE

#### EVENT TEXT

DEFECTIVE COPE-S-VULCAN YOKES WERE DELIVERED TO SEVERAL UTILITIES.

THE FOLLOWING IS A TEXT OF A FACSIMILE SUBMITTED BY THE LICENSEE:  
 "COPE-S-VULCAN, LAKE CITY, PENNSYLVANIA, HAS BEEN INFORMED BY TENNESSEE  
 VALLEY AUTHORITY, SEQUOYAH, THAT NINE (9) YOKES, P/N 342849, SUPPLIED TO  
 THEM AS PART OF AN UPGRADE PROGRAM, HAVE DISCREPANT 1/2-13UNC TAPED HOLES  
 WHICH COULD IMPACT THE ABILITY TO OPERATE IF INSTALLED.

COPE-S-VULCAN HAS TRACED THE PROBLEM TO A MANUFACTURING OPERATION WHICH  
 DRILLS THE HOLES OVERSIZE AND THEN USES A ROLL TAP TO RE-FORM THE THREADS.  
 IF A ROLL TAP IS NOT USED, THE THREAD MINOR DIAMETER IS OVERSIZE TO THE  
 POINT OF WEAKENING THE THREAD. THIS IS WHAT HAPPENED IN THIS INSTANCE.

AN INVESTIGATION INTO THE AFFECTED YOKES HAS LIMITED THE USAGE TO NINE (9)  
 YOKES AT TVA, ONE (1) YOKE AT THE WISCONSIN POWER AND ONE (1) YOKE AT  
 FARLEY SOUTHERN COMPANY. THE TVA YOKES HAVE NOT BEEN INSTALLED AT THIS  
 TIME AND THE WISCONSIN POWER, POINT BEACH, ACTUATOR WHICH MAY CONTAIN A  
 DEFECTIVE YOKE, WOULD PERFORM ITS FAIL SAFE MODE AS DELIVERED WAS WOULD THE  
 VALVE AT FARLEY.

THE AFFECTED UTILITIES HAVE BEEN NOTIFIED AS OF NOVEMBER 3, 1994." END OF  
 TEXT.

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# COPEES-VULCAN, INC.

MARTIN & RICE AVENUES  
LAKE CITY, PA 16423  
USA

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DATE: November 3, 1994 NO. OF PAGES SENT 1

FROM: J.R. Scarpelli  
QUALITY ASSURANCE DEPARTMENT

TO: COMPANY NRC Operations Center

ATTENTION

FAX NO. 301-492-8187

Copes-Vulcan, Lake City, Pennsylvania, has been informed by Tennessee Valley Authority, Sequoyah, that nine (9) yokes, P/N 342849, supplied to them as part of an upgrade program, have discrepant 1/2-13UNC taped holes which could impact the ability to operate if installed.

Copes-Vulcan has traced the problem to a manufacturing operation which drills the holes oversize and then uses a roll tap to re-form the threads. If a roll tap is not used, the thread minor diameter is oversize to the point of weakening the thread. This is what happened in this instance.

An investigation into the affected yokes has limited the usage to nine (9) yokes at TVA, one (1) yoke at Wisconsin Power and one (1) yoke at Farley Southern Company. The TVA yokes have not been installed at this time and the Wisconsin Power, Point Beach, actuator which may contain a defective yoke, would perform its fail safe mode as delivered as would the valve at Farley.

The affected utilities have been notified as of November 3, 1994.

A written report as required by 10CFR21 will be issued.



J.R. Scarpelli  
Director Quality Assurance

JRS/pjg