



QA: QA

Jerry Van Wormer, QA Manager  
Vaisala, Inc.  
100 Commerce Way  
Woburn, MA 01801

BECHTEL SAIC COMPANY, LLC (BSC) QUALITY ASSURANCE (QA) SUPPLIER AUDIT REPORT BSC-SA-02-016 OF VAISALA, INC.

Enclosed is the Supplier Audit Report BSC-SA-02-016 of Vaisala, Inc. that was performed on February 26-27, 2002, in Woburn, Massachusetts, to evaluate the implementation and effectiveness of Vaisala Quality Program. Vaisala provides calibration of relative humidity and temperature monitoring sensors.

The audit revealed effective implementation of the quality requirements in BSC Purchase Order B001928, the previous Vaisala Quality Program, Revision D, and supporting implementing procedures, which were in place when Yucca Mountain Site Characterization Project (YMSCP) work was performed. However, the audit also revealed that the new revision of the Vaisala Quality Program, dated March 2001 (effective February 2002), fails to contain an acceptable Quality Assurance (QA) Program to meet the procurement requirements that are imposed on suppliers of calibration services to the YMSCP in the areas of: QA Program, Implementing Documents, Control of Purchased Items and Services, Corrective Action, and Audits.

As a result of the audit, Vaisala, Inc. will be removed from the Office of Civilian Radioactive Waste Management, Qualified Suppliers List.

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

If you have any questions, please contact either Michael A. Goyda at (702) 295-2797 or Daniel A. Klimas at (702) 295-2665.

Donald T. Krishna, Manager  
Quality Assurance

3/25/02  
Date Signed

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Enclosure:  
Supplier Audit Report BSC-SA-02-016

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WM-11*

March 25, 2002

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cc w/encl:

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QA: QA

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

**SUPPLIER AUDIT REPORT**

**OF**

**VAISALA, INC.**

**WOBURN, MASSACHUSETTS**

**REPORT NUMBER BSC-SA-02-016**

**FEBRUARY 26-27, 2002**

Prepared by: *M. A. Goyda*  
Michael A. Goyda  
Audit Team Leader  
BSC Quality Assurance

Date: 3/18/02

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

Date: 3/22/02

## 1.0 AUDIT SUMMARY

BSC Supplier Audit BSC-SA-02-016 of Vaisala, Inc. was performed on February 26-27, 2002, in Woburn, Massachusetts, to evaluate the implementation and effectiveness of Vaisala's Quality Program. Vaisala, Inc. provides calibration of relative humidity and temperature monitoring sensors.

The audit revealed effective implementation of the quality requirements in BSC Purchase Order B001928, the previous Vaisala Quality Program, Revision D, and supporting implementing procedures. The work performed for the Yucca Mountain Site Characterization Project (YMSCP) was accomplished during the period when this QA Program was in place. However, the audit also revealed that the new revision of the Vaisala Quality Program, dated March 2001 (effective February 2002), fails to contain an acceptable Quality Assurance (QA) Program to meet the procurement requirements that are imposed on suppliers of calibration services to the YMSCP in the areas of: QA Program, Implementing Documents, Control of Purchased Items and Services, Corrective Action, and Audits.

As a result of the audit, Vaisala, Inc. will be removed from the Office of Civilian Radioactive Waste Management (OCRWM), Qualified Suppliers List.

## 2.0 SCOPE

The supplier audit was conducted to evaluate the implementation and effectiveness of Vaisala's Quality Program as described in their previous Quality Manual, Revision D, associated implementing procedures, and the quality requirements delineated in the BSC Purchase Order B001928. This audit also served to review the new Vaisala, Inc. Quality Manual, dated March 2001 (effective February 2002), during the conduct of this audit. The revised Vaisala, Inc. QA Program has been developed around the requirements of ISO 9001-2000. Vaisala, Inc. headquartered in Helsinki, Finland has developed a topical QA Program for use by all of its worldwide facilities. Vaisala has established their new QA Program measures through the use of a company intranet system at the procedure work level. The contents of the QA Program and implementing procedures had to be evaluated at the Vaisala facility. The BSC audit determined that the new Vaisala QA Program does not contain QA program attributes needed to meet the OCRWM QA Program requirements. This audit verified the establishment of the new QA Program measures, as well as the previous QA program implementation, at Vaisala, Inc. that are consistent with applicable elements of the OCRWM Quality Assurance Requirements and Description document. The OCRWM QA program elements determined to be applicable are: Organization; QA Program; Procurement Document Control; Implementing Documents; Document Control; Control of Purchased Items and Services; Control of Measuring and Test Equipment; Corrective Action; QA Records; Audits; and Software.

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

**3.0 AUDIT TEAM MEMBERS AND OBSERVERS**

Michael A. Goyda, Audit Team Leader, BSC QA

Richard L. Hand, Audit Team Member, BSC QA

**4.0 PERSONNEL CONTACTED DURING THE AUDIT**

Jerry Van Wormer, QA Manager, Vaisala, Inc.

Mike Johnson, Laboratory Manager, Vaisala, Inc.

Tim Bradley, Materials Manager, Vaisala, Inc.

Gerry Ducharme, Director, Vaisala, Inc.

Patty Federico, Buyer, Vaisala, Inc.

**5.0 CONDITIONS ADVERSE TO QUALITY/RECOMMENDATIONS FOR IMPROVEMENT**

None