



QA: QA

Mark T. Peters, Manager
Science & Engineering Testing
Bechtel SAIC Company, LLC
1180 Town Center Drive
Las Vegas, NV 89144

**VERIFICATION OF CORRECTIVE ACTION AND CLOSURE OF DEFICIENCY REPORT
(DR) BSC(V)-02-D-044 RESULTING FROM THE BECHTEL SAIC COMPANY, LLC (BSC)
QUALITY ASSURANCE AUDIT BSC-SA-02-005 OF METAL SAMPLES COMPANY**

BSC Quality Assurance has verified implementation of corrective action for DR BSC(V)-02-D-044 and determined the results to be satisfactory. As a result, the DR has been closed.

If you have any questions, please contact either Robert D. Habbe at (702) 295-1631 or Daniel A. Klimas at (702) 295-2665.

A handwritten signature in cursive script that reads 'D. T. Krishna'.

Donald T. Krishna, Manager
Quality Assurance

4/10/02

Date Signed

RDH:bw-0405022104

Enclosure:
DR BSC(V)-02-D-044

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WM-11*

April 10, 2002

Page 2

cc w/encl:

L. H. Barrett, DOE/HQ (RW-2) FORS
L. W. Bradshaw, Nye County, Pahrump, NV
Margaret Chu, DOE/HQ (RW-1) FORS
J. R. Dyer, DOE/YMSCO, Las Vegas, NV
W. J. Glasser, NQS, Las Vegas, NV
Birdie Hamilton-Ray, DOE/YMSCO, Las Vegas, NV
C. E. Hampton, DOE/YMSCO, Las Vegas, NV
R. W. Henderson, BSC, Las Vegas, NV
D. G. Horton, DOE/YMSCO, Las Vegas, NV
D. A. Klimas, BSC, Las Vegas, NV
D. T. Krisha, BSC, Las Vegas, NV
Robert Latta, NRC, Las Vegas, NV
S. W. Lynch, State of Nevada, Carson City, NV
S. P. Mellington, DOE/YMSCO, Las Vegas, NV
Ram Murthy, DOE/OQA, Las Vegas, NV
D. G. Opielowski, NQS, Las Vegas, NV
R. E. Powe, BSC, Las Vegas, NV
J. M. Replogle, DOE/YMSCO, Las Vegas, NV
N. K. Stablein, NRC, Rockville, MD ✓
D. D. vonderLinden, BSC, Las Vegas, NV
Engelbrecht von Tiesenhausen, Clark County, Las Vegas, NV
B. L. Wilson, BSC, Las Vegas, NV

cc w/encl:

R. W. Andrews, BSC Las Vegas, NV
Rick Douglas, Metal Samples Company, Munford, AL
K. O. Gilkerson, BSC Las Vegas, NV
R. D. Habbe, BSC Las Vegas, NV
R. F. Hartstern, BSC Las Vegas, NV
R. E. Rucinski, BSC Las Vegas, NV
Roxanne Van Dillen, BSC Las Vegas, NV

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RADIOACTIVE WASTE MANAGEMENT
U.S. DEPARTMENT OF ENERGY
WASHINGTON, D.C.**

8. DEFICIENCY REPORT
 CORRECTIVE ACTION REPORT

NO. BSC(V)-02-D-044

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PAGE 1 OF 4
QA: QA

DEFICIENCY/CORRECTIVE ACTION REPORT

1. Controlling Document:
Alabama Specialty Products Incorporated (ASPI) Quality Manual, Revision 2/16/99 and implementing procedures.

2. Related Report No.:
BSC-SA-02-005

3. Responsible Organization:
BSC/Metal Samples Company (MSC)

4. Discussed With:
M. Peters, BSC; R. Douglas, MSC

5. Requirement:

ASPI Operational Procedure OP 13.0-1, Revision 7, Section 13.0.3.3 states in part: Nonconformities in this Quality System, our processes and products are documented on our Anomaly Report.

6. Description of Condition:

Metal Samples did not prepare an Anomaly Report for an out of tolerance dimensional condition on samples provided on TRW Purchase Order A15414SS0B, Schedule FY00-05, MSC Job No. 176043.

7. Initiator:

Robert D. Habbe

Date 12/13/01

9. Does a stop work condition exist? (Not required for a DR)

Yes No

If Yes, Check One: A B C D

10. Recommended Actions:

1. Review the quality and dimensional records for similar product provided to BSC and determine if additional products were supplied to BSC with out of tolerance conditions not documented on an anomaly report.
2. Determine the impact on services/products provided, as a result of above deficiency.
3. Revise procedure(s) if applicable and provide training to applicable personnel.

11. QA Review:

QAR R. D. Habbe

Date 12/13/01

12. Response Due Date:

20 Working Days From Issuance

13. DOQA Issuance Approval:

Printed Name Donald T. Krishna

Signature

Date

22. Corrective Actions Verified:

QAR R.D. HABBE

Date 4-2-02

23. Closure Approved by:

DOQA

Date

TYPE RESPONSE:

- Initial
- Complete
- Amended

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DR/CAR NO. BSC(V)-02-D-044

PAGE **2** OF **4**

QA: QA

DEFICIENCY/CORRECTIVE ACTION REPORT (RESPONSE)

14a. Immediate Actions:

N/A - No YMP-related work currently being performed at Metal Samples Company (MSC), a division of Alabama Specialty, Inc. (ASPI).

Compliance Date: N/A

14. Remedial Actions:

MSC completed QF 7.1-A, Notification of Deficient Product on 02/21/02. Work Instruction WI 13.1-1, Initiation and Use of Anomaly Reports, Paragraph 13.1.3.2 describes when anomaly reports should be initiated. The out-of-tolerance condition was identified by the machine operator at in-process inspection during processing. The customer was notified of the deficiencies by email on December 19, 2000, and approval for supplying out-of-tolerance specimens was received by email from Gopal De on December 26, 2000. The specimens in question were manufactured in performance of TRW Purchase Order A15414SS0B, Schedule FY00-07, Rev. 01, Line 1, MSC Job No. 176043, **not Schedule FY00-05 as was stated in the original deficiency report.**

15. Extent of Condition:

All other out-of-tolerance conditions identified on Yucca Mountain Project (YMP) products have been documented. Not all are documented on anomaly reports. No out-of-tolerance YMP product has been shipped without prior approval from the customer, therefore, there is no impact on YMP products as a result of this deficiency.

16. Cause: (Attach results of root cause determination prepared in accordance with AP-16.4Q for a significant deficiency.)

MSC Work Instruction WI 13.1-1, Initiation and Use of Anomaly Reports, does not require initiation of anomaly reports for deficiencies identified during processing **as indicated by the auditor in the original deficiency report.**

Inadvertent failure to complete QF 7.1-A, Notification of Deficient Product in accordance with WI 7.1-1, Reporting Customer Supplied Product Deficiencies to Customers. (The MSC sales representative assumed the email notification to TRW was sufficient.)

17. Action to Preclude Recurrence:

MSC will retrain sales and QC personnel in the use of Work Instruction WI 7.1-1, Reporting Customer Supplied Product Deficiencies to Customers.

18. Due Date: March 8, 2002

- For submittal of complete response
- For completion of corrective action

19. Response by: Mark Peters (Roxie VanDillen - Resp. Ind.)

Mark Peters mP *Roxie VanDillen* 2/27/02
Date: February 27, 2002 Phone: 5-3644 *33694*

20. Evaluation: Accept Partially Accept Reject

21. Concurrence:

QAR Date

DOQA Date

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TYPE RESPONSE: <input type="checkbox"/> Initial <input checked="" type="checkbox"/> Complete <input checked="" type="checkbox"/> Amended	OFFICE OF CIVILIAN RADIOACTIVE WASTE MANAGEMENT U.S. DEPARTMENT OF ENERGY WASHINGTON, D.C.	DR/CAR NO. BSC(V)-02-D-044 PAGE 3 OF 4 QA: QA
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DEFICIENCY/CORRECTIVE ACTION REPORT (RESPONSE)

14a. Immediate Actions:
Note: THIS AMENDED RESPONSE SUPERCEDES THE RESPONSE SUBMITTED ON 2/27/02 AS NOTED IN BLOCK 19 OF PAGE 2 OF THE DR.
 N/A - No Yucca Mountain Project (YMP)-related work currently being performed at Metal Samples Company (MSC), a division of Alabama Specialty, Inc. (ASPI).
 All YMP-related work was stopped at Metal Samples Company on 11/15/01 by BSC buyer S. Silva via email and Letter Im-1205010695 to B. Smith, MSC.

Compliance Date: 11/15/01

14. Remedial Actions:
 MSC completed an anomaly report on 03/15/02. BSC was notified of the deficiencies by email on December 19, 2000, and approval for supplying out-of-tolerance specimens was received by email from Gopal De on December 26, 2000. The specimens in question were manufactured in performance of TRW Purchase Order A15414SS0B, Schedule FY00-07, Rev. 01, Line 1, MSC Job No. 176043, **not Schedule FY00-05 as was stated in the original deficiency report.** The Science and Engineering Testing Department has issued a Nonconformance Report (NCR) (NCR No. YMSCO-02-0031) to document the deficient conditions and disposition the specimens.

15. Extent of Condition:
 This was the only instance where an anomaly report was not completed in accordance with the requirements in the procurement document. The specimens are being used in non-Q testing activities currently underway at Purdue University. There is no impact on YMP products as a result of this deficiency.
→ and ASPI Operational Procedure OPIS 2.0-1. RW 03/25/02 DW 3-25-02

16. Cause: (Attach results of root cause determination prepared in accordance with AP-16.4Q for a significant deficiency.)
 Due to schedule driven urgency, initiation of an anomaly report was overlooked, and a request for deviation thickness from .031" to .038" was emailed to the customer.

17. Action to Preclude Recurrence:
 MSC will not be used for future YMP-related activities.

18. Due Date: March 22, 2002
 For submittal of complete response
 For completion of corrective action

19. Response by: Mark Peters (Roxie VanDillen - Resp. Ind.)
Daw M.T.P. *Roxie VanDillen*
 Date: March 22, 2002 *for* Phone: 5-3644 *www* *100 BSE QA* *03/25/02*

20. Evaluation: Accept Partially Accept Reject
 QAR *R.D. HABBE* Date *4-2-02*

21. Concurrence:
 DOQA *D.T. Kiiska* Date *4/10/02*

Exhibit AP-16.1Q.1

Rev. 12/20/1999

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NO: BSC(V)-02-D-044
PAGE 4 OF 4
QA: QA

CONDITION ADVERSE TO QUALITY CONTINUATION PAGE

Verification of corrective action and closure of DR BSC(V)-02-D-044.

This verification was based on a review of documentation provided by Science Engineering and Testing (SE&T) and Metal Samples Company (MSC).

Verification of Immediate Actions:

The QAR verified that Sharon Silva, BSC Buyer sent an email to MSC on 11/15/01 to stop work on Yucca Mountain Project samples and followed up with a letter to MSC on 12/05/01 repeating the same.

Verification of Remedial Actions:

The QAR performed a review of MSC Anomaly Report dated 3/15/02 for Job No. 176043, which clearly described the deficient condition of the samples. The Anomaly Report was dispositioned "Use As Is". The QAR verified that MSC notified BSC on 12/19/2000 that samples for schedule FY00-07, Line 1 were found to be out of tolerance. The QAR verified that Gopal De, BSC sent an email to MSC on 12/26/2000 accepting the samples as is.

The QAR performed a review of OCRWM Nonconformance Report YMSCO-02-0031 that documented the deficient condition of the 24 non-conforming samples.

Extent of Condition:

The QAR verified that BSC has a non-Q purchase order 24540-160-TA-18710 with Purdue University for corrosion testing.

Verification of Action to Preclude Recurrence

Verified that the OCRWM Qualified Supplier List has a restriction that prohibits MSC from performing any Quality work for OCRWM.

A review of the extent of condition did not indicate that this DR is a significant condition.

The documentation provided and the corrective actions taken provide satisfactory implementation of correction actions for this DR. Based on the above this DR is considered closed.

Robert D. Habbe, 04/02/02



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