

October 25, 2002

TO: N. King Stablein, Chief  
Projects and Engineering Section  
High Level Waste Branch  
Division of Waste Management

FROM: Ted Carter, Project Manager **/RA/**  
Projects and Engineering Section  
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SUBJECT: TRIP REPORT OF PRECISION COMPONENTS CORPORATION

On September 11-13, 2002, I observed parts of a Quality Performance Evaluation (QPE) of Precision Components Corporation (PCC) located in York, Pennsylvania. I accompanied Mr. Charlie Davis of Naval Nuclear Propulsion Program (NNPP) and Mr. John Therien of the Department of Energy, Office of Civilian Radioactive Waste Management on one of the periodic observations/information exchanges that NNPP and DOE-RW conduct to facilitate continued DOE-RW acceptance of the NNPP QA Program.

The purpose of the trip was to observe a NNPP Quality Assurance (QA) Program activity related to spent naval fuel (SNF) disposal. PCC is one of two suppliers who have been manufacturing canisters for the purpose of dry storage of naval spent nuclear fuel at the Naval Reactors Facility in Idaho and for ultimate disposal in the monitored geologic repository planned for the Yucca Mountain Site in Nevada.

The evaluation was conducted by a team of eight individuals from NAVSEA Technical Representative (NSTR-Pittsburgh), Bechtel Plant Machinery, Inc. (BPMI), and the Defense Contract Management Agency representative located on-site at PCC. Attached are the NNPP and DOE-RW trip reports from Mr. Davis and Mr. Brown, respectively, to you and the detailed report of the QPE.

As a result of the QPE, the evaluation team found 12 nonconformities, which PCC agreed to correct, and made four observations. Based on the number and type of nonconformities related to welding, the evaluation team concluded that PCC welding control practices needed improvement and developed a single finding for PCC to address in this area.

My observation consisted of reviewing material used by the evaluation team in preparation for the QPE, PCC work activities, a brief PCC facility tour, a tour of PCC's subcontractor (Fabricated Products, Inc) that is responsible for fit-up and welding of intermediate assemblies and the final assembly of the SNF canister shell, auditing conducted by the evaluation team, and the exit meeting with NSTR-Pittsburgh, PCC, and BPMI management.

In addition, Mr. Davis and Mr. Horne of BMI used a combination of assembly drawings, computer generated pictures, plastic models, and photos to describe the processes and equipment that NNPP plans to use to load a single canister in late 2002 as a proof of concept, which may uncover areas where additional change is warranted before going into full production.

Based on the above observations, I determined that the QPE was effective in identifying deficiencies and recommending improvements for PCC's QA program. This trip also provided beneficial information about the NNPP and its contractor's QA program and NNPP's process and activities for dry storage of spent fuel.

Attachment: As Stated

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