

**U.S. DEPARTMENT OF ENERGY
OFFICE OF CIVILIAN RADIOACTIVE WASTE MANAGEMENT
OFFICE OF QUALITY ASSURANCE**

SUPPLIER AUDIT REPORT

OF

CLIMATRONICS CORPORATION

BOHEMIA, NEW YORK

**REPORT NUMBER OQA-SA-96-003A
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Prepared by: *Richard L. Maudlin* Date: 5/10/96

**Richard L. Maudlin
Audit Team Leader
Yucca Mountain Quality
Assurance Division**

Approved by: *DC Spence For* Date: 5/17/96

**Donald G. Horton
Director
Office of Quality Assurance**

1.0 EXECUTIVE SUMMARY

The results of the supplier audit of Climatronics Corporation revealed an unsatisfactory condition resulting in the issuance of one Performance Report (PR) to the Science Applications International Corporation (SAIC)/Civilian Radioactive Waste Management System Management and Operating Contractor (CRWMS M&O) for action which relates to the Quality Assurance (QA) program for the Office of Civilian Radioactive Waste Management (OCRWM) activities. The PR reflects that Climatronics' internal audits do not address all applicable aspects of the QA Manual.

The unsatisfactory condition identified during the audit was discussed with the QA Manager of Climatronics Corporation who agreed to work with SAIC/CRWMS M&O in the resolution of the unsatisfactory condition. The continued monitoring of suppliers by Climatronics management was adequate for a calibration organization of this size. A review of Supplier Quality Evaluation Reports revealed that suppliers used to calibrate Climatronics' standards are evaluated as frequently as yearly, but at least once every three years. Documentation of the evaluations was complete and readily available.

2.0 SCOPE

The limited scope supplier audit was conducted to evaluate the adequacy, implementation, and effectiveness of Climatronics Corporation's quality program in the areas of Procurement and Audits. This was accomplished by determining if Climatronics Corporation's program implements the applicable QA requirements specified in the SAIC procurement document 39-960033-39, the Climatronics Corporation's Quality Assurance Manual, Revision J, as accepted by SAIC, and the OCRWM Quality Assurance and Requirements Description (QARD) for the scope of work. The QA program elements determined to be applicable for this limited scope audit are: Procurement Document Control; Control of Purchased Items and Services; and Audits.

3.0 AUDIT TEAM AND OBSERVERS

Richard L. Maudlin, Audit Team Leader, Office of Quality Assurance (OQA), Yucca Mountain Quality Assurance Division (YMQAD)

4.0 PERSONNEL CONTACTED DURING FACILITY AUDIT

J. Berry, QA Manager, Climatronics Corporation

5.0 SUMMARY OF AUDIT RESULTS

For the QA elements evaluated, Climatronics Corporation's QA Manual, Revision J, addresses the applicable elements of the OCRWM QARD for the intended scope of work. Adequacy and implementation, with one exception, of QA Elements 4, 7, and 18 of the QARD by Climatronics Corporation was considered satisfactory. Specifics of the unsatisfactory condition are described in Section 6.0 of this report, "Deficiencies/Recommendations."

The details of the audit, along with the objective evidence reviewed, are contained within the audit checklist which is available from the OQA's supplier evaluation files.

6.0 DEFICIENCIES/RECOMMENDATIONS

The unsatisfactory condition has been documented on the respective corrective action document and submitted to the SAIC/CRWMS M&O for action and resolution. The recommendations are offered as suggestions to improve your processes and are not required to be acknowledged unless otherwise stated.

DEFICIENCIES

PR No. YMQAD-96-P027 - The Climatronics QA Manual, Section QA-1700, Revision A, Paragraph 4.1, requires the quality program to include provisions for audit of all quality operations to ensure compliance to the quality requirements set forth in this manual.

Contrary to this requirement, no objective evidence could be provided to reflect evaluations of areas such as: Organization, Procurement Control, QA records, and Audits.

RECOMMENDATIONS

1. Climatronics QA Manual, Section QA-304, discusses parameters related to the assurance that subcontractors establish a calibration system. Part of this system is assuring that the subcontractor perform calibrations in a controlled environment to the extent necessary to assure continued measurements of required accuracy. In the review of Climatronics' Supplier's Quality System Survey Questionnaires, there were no questions related to environmental controls established for performing calibrations. It is recommended that Climatronics add a question or questions to the Quality System Survey Questionnaire related to environmental controls

that the supplier should be implementing in the performance of calibrations.

- 2. The Climatronics QA Manual makes reference to the National Bureau of Standards (NBS) in various sections such as QA-303 and QA-305. NBS as a reference to standard traceability no longer exists. It is recommended that all references in the Climatronics QA Manual to NBS be revised to reference the National Institute of Standards and Technologies (NIST).**