

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

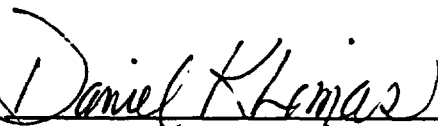
**SUPPLIER AUDIT REPORT**

**OF**

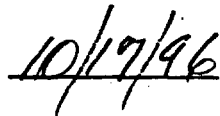
**ACCUTECH**

**REPORT NUMBER OQA-SA-96-030  
SEPTEMBER 30 - OCTOBER 2, 1996**

Prepared by:



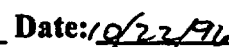
Date:



**Daniel A. Klimas  
Audit Team Leader  
Yucca Mountain Quality Assurance**

Approved by:



Date: 

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

Enclosure

## **1.0 EXECUTIVE SUMMARY**

The results of the supplier audit of ACCUTECH revealed satisfactory implementation of the Quality Assurance (QA) requirements for the Office of Civilian Radioactive Waste Management (OCRWM) activities. Implementing procedures and processes were in place for the scope of work and implementation was considered to be effective in producing the desired results. ACCUTECH currently holds an American Society of Mechanical Engineers Quality System Certificate #QSC-518, expiration January 9, 1999, as a material organization manufacturing and supplying various shapes, material, and products, including the qualification of suppliers, testing, and upgrading of material. ACCUTECH currently is extending threads on bolts to be used in the steel sets and channel lagging to accommodate ground support during tunneling operations at Yucca Mountain.

There were no unsatisfactory conditions identified during the audit and the ACCUTECH QA Program was determined to be effectively implemented. However, during the audit ACCUTECH was in the process of extending the threads on 4,200 American Society of Testing Material 307 bolts, supplied by Kiewit/Parsons Brinckerhoff (Kiewit/PB), to be used in the steel sets within the tunnel at Yucca Mountain. After extending the threads on the bolts supplied to ACCUTECH, the finished bolt has a pitch diameter that does not meet specifications located at the transition area of the original bolt threads. This condition is being evaluated for acceptability on Nonconformance Report LVMO-97-001.

## **2.0 SCOPE**

The supplier audit was conducted to evaluate the adequacy, implementation, and effectiveness of ACCUTECH's QA Program within their organization. This was accomplished by determining if ACCUTECH's program meets the quality and technical requirements specified in the Kiewit/PB procurement document number 18992103, the ACCUTECH Quality System Manual (QSM), Second Edition, Revision 0, dated November 29, 1995, and the OCRWM Quality Assurance Requirements and Description (QARD) for the specific scope of work. The QA Program elements determined to be applicable are: Organization; QA Program; Procurement Document Control; Implementing Documents; Document Control; Control of Purchased Items and Services; Identification and Control of Items; Control of Special Processes; Inspection; Test Control; Control of Measuring and Test Equipment; Handling, Storage, and Shipping; Inspection, Test and Operating Status; Nonconformances; Corrective Action; QA Records; Audits; and Sample Control.

### **3.0 AUDIT TEAM AND OBSERVERS**

Daniel A. Klimas, Audit Team Leader, Office of Quality Assurance (OQA), Yucca Mountain Quality Assurance (YMQA)  
Stephen D. Harris, Audit Team Member, OQA, YMQA  
Patrick V. Auer, Audit Team Member, OQA, YMQA

### **4.0 PERSONNEL CONTACTED DURING THE AUDIT**

The following are all ACCUTECH personnel:

Ron Brecht, Level II Inspector  
Lee Conrad, QA Technician  
Addie Domaszek, QA Supervisor  
Steve Gauthier, Material Testing  
David Hathcock, QA Manager  
Norm Henderson, Material Testing Supervisor  
Richard Johns, Receiving Clerk  
Vince Kethen, Purchasing  
Bayard Lester, Shipping Lead  
Billie Morris, Calibration Technician  
Pam Ray, Purchasing  
Ernest Roberts, Chief Level II Inspector  
Gary Tang, Methods Engineer

### **5.0 SUMMARY OF SURVEY RESULTS**

The ACCUTECH QSM, Second Edition, Revision 0, dated November 29, 1995, addresses the applicable elements of the Kiewit/PB purchase order number 18992103 and the applicable elements of the OCRWM QARD for the intended scope of work. Procedures or processes described within the manual were in place and implementation was considered to be effective. The auditees were knowledgeable in the quality requirements necessary for their activities and were very cooperative during the audit process. The ACCUTECH personnel expressed a commitment to quality and pride in the work they performed.

Included in the QSM, Section 18.0, are requirements for Heat Treatment. The Supplier Evaluation Report, approved by the Kiewit/PB QA Manager on April 15, 1996, does not list Heat Treatment as an approved capability in the vendor items. This audit evaluated the quality assurance requirements imposed on their activities in Heat Treatment and

found them to be effectively implemented. ACCUTECH has specific capabilities for Heat Treatment that should be considered for addition to the Supplier Evaluation Report if Kiewit/PB has future needs for such capability.

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

#### **6.0 DEFICIENCIES CORRECTED DURING THE AUDIT/RECOMMENDATIONS**

There were no deficiencies found to be corrected during the audit and no deficiencies were initiated as a result of the audit.

#### **RECOMMENDATIONS**

The ACCUTECH QSM states in Section 9.6.3 and 9.6.4, the heat number and lot number (among other items) will be identified on material labels as a minimum. The material labels for the Work Order (WO) 318551 did not have the heat number and the lot number indicated. For the Work Order, it would have been Kiewit/PB's responsibility to supply the information; the ACCUTECH QSM needs to be more specific on the minimum information required for customer-provided materials. In addition, Section 10.2.1, of the QSM states, "all PO's shall include the applicable WO number, material description, lot number, heat number if applicable and definitive process to be performed, including procedure revision level and applicable QA Program or requires a source inspection to be conducted per SOP 8.005." ACCUTECH WO PC 316506 did not include the procedure revision level for the process to be performed by Phoenix Heat Treating. The words of the QSM in both cases appear to indicate the requirement for specific information. It is recommended that these sections of the manual be rewritten at the next revision of the QSM to more clearly describe the specific information to be provided.