

Department of Energy
Office of Civilian Radioactive Waste Management
Yucca Mountain Site Characterization Office
P.O. Box 98608
Las Vegas, NV 89193-8608

FEB 22 1996

L. Dale Foust
Technical Project Officer
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Site Characterization Project
TRW Environmental Safety Systems, Inc.
Bank of America Center, Suite P-110
101 Convention Center Drive
Las Vegas, NV 89109

EVALUATION OF RESPONSES TO DEFICIENCY REPORTS (DR) YMQAD-96-D021 THROUGH YMQAD-96-D024, YMQAD-96-D026 THROUGH YMQAD-96-D028 AND PERFORMANCE REPORTS (PR) YMQAD-96-P018 THROUGH YMQAD-96-P020 RESULTING FROM YUCCA MOUNTAIN QUALITY ASSURANCE DIVISION'S (YMQAD) AUDIT YM-ARC-96-03 OF KIEWIT/PARSONS BRINCKERHOFF (SCPB: N/A)

The YMQAD staff has evaluated the responses to DRs YMQAD-96-D021 through YMQAD-96-D024 and YMQAD-96-D026 through YMQAD-96-D028 and PRs YMQAD-96-P018 through YMQAD-96-P020. The responses have been determined to be satisfactory.

Verification has been completed on PR YMQAD-96-P018 and DR YMQAD-96-D021 and those are considered closed. For the remaining deficiency documents, verification of completion of the corrective actions will be performed after the effective dates provided. Any extension to these dates must be requested in writing, with appropriate justification, prior to the date. Please send a copy of extension requests to Deborah Sult, YMQAD/QATSS, 101 Convention Center Drive, Suite 640, Las Vegas, Nevada 89109.

If you have any questions, please contact either Robert B. Constable at 794-7945 or John S. Martin at 794-7881.

Richard E. Spence, Director
Yucca Mountain Quality Assurance Division

YMQAD:RBC-1127

Enclosures:

1. DRs YMQAD-96-D021 through YMQAD-96-D024
2. DRs YMQAD-96-D026 through YMQAD-96-D028
3. PRs YMQAD-96-P018 through YMQAD-96-P020

YMP-5

270034

9602270404 960222
PDR WASTE
WM-11 PDR

102.7
WM-11
NH03

L. Dale Foust

-2-

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cc w/encls:

T. A. Wood, HQ (RW-14) FORS
J. G. Spraul, NRC, Washington, DC
S. W. Zimmerman, NWPO, Carson City, NV
R. L. Strickler, M&O, Vienna, VA
R. P. Ruth, M&O, Las Vegas, NV

cc w/o encls:

W. L. Belke, NRC, Las Vegas, NV
J. S. Martin, YMQAD/QATSS, Las Vegas, NV
D. G. Sult, YMQAD/QATSS, Las Vegas, NV

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WASHINGTON, D.C.☐ Performance Report
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NO. YM-QAD-96-D021

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QA: L

PERFORMANCE/DEFICIENCY REPORT

1 Controlling Document:
Quality Assurance Requirements and Description (QARD), DOE/RW-0333P, Rev. 52 Related Report No.
YM-ARC-96-033 Responsible Organization:
Kiewit/Parsons Brinckerhoff (Kiewit/PB)4 Discussed With:
Jon Christensen

5 Requirement/Measurement Criteria:

1. QARD, Section 5.0, Paragraph 5.2.2, states, in part: "Implementing documents shall include the following information as appropriate to the work to be performed:
- B. Technical and regulatory requirements.
 - D. Quantitative or qualitative acceptance criteria sufficient for determining that activities were satisfactorily accomplished."

Section 2.0, Paragraph 2.2.12, "Personnel Selection, Indoctrination, and Qualification," states in part:

"Each Affected Organization shall establish a program for the evaluation, selection, indoctrination, training, and qualification of personnel performing work subject to the QARD. The program shall:

H. Ensure the required indoctrination and training for a specified task is complete prior to performing the task."

6 Description of Condition:

1. The acceptance criteria for bolted connections of steel sets was not specified in QCP-008. The procedure referenced a paragraph in the specification. The procedure was revised to specify the requirement, rather than reference the specification paragraph.
2. There is no objective evidence that inspectors are aware of changes (ECRs and revisions) to specifications prior to performing an inspection; i.e., 1) the revision/ECR status is not noted on the inspection form, nor is it in the procedure, 2) there is no record of the inspectors reading the change. (NOTE: Deficiency Report, K/PB 96-D018, Revision 1, addresses the condition of not being able to determine the effective date of ECRs but does not address the requirements for training if procedures do reference specifications.

7 Initiator

Patout H. Cotter

Date 12/4/95

8 QA Review

QAR P.H. COTTER

Date 12/4/95

10 Response Due Date

20 Working Days from Issuance

11 QA Issuance Approval

QAR (PR/AOQAM (DR)

Date 12-21-95

12 Remedial Actions:

SEE PAGE 3

13 Remedial Action Response By:

J. Christensen

Date 1/23/96

14 Remedial Action Due Date:

Completed

Date

15 Remedial Action Response Acceptance

QAR

P.H. Cotter

Date 2/6/96

16 PR Verification/Closure

QAR P.H. Cotter

N/A

DS 2/6/96

Date 2/6/96

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17 Recommended Actions:

1. Revise procedure or inspection form to identify the specification or drawing change status; or if the acceptance criteria is referenced:
2. Revise procedure MCP-10.0, to describe the controls which ensure that the inspector has read the change and that it is documented.

18 Investigative Actions:

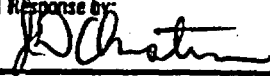
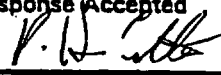

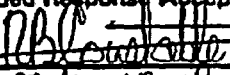
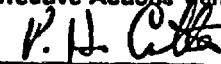
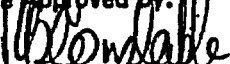
SEE PAGE 3

19 Root Cause Determination:

NOT APPLICABLE FOR THESE DEFICIENCIES AS
DETERMINED THROUGH INVESTIGATION.

20 Action to Preclude Recurrence:

SEE PAGE 3. CORRECTIVE ACTION IS BEING
ACCOMPLISHED IN YMQAD 96-D020 AND
K/PB 96-D018R1

<p>21 Response by:  Date 1/23/96</p>	<p>22 Corrective Action Completion Due Date: SEE BLOCK 20</p>
<p>23 Response Accepted OAR  Date 2/6/96</p>	<p>24 Response Accepted AOQAM  for Date 2.15.96</p>
<p>25 Amended Response Accepted OAR _____ Date _____</p>	<p>26 Amended Response Accepted AOQAM  for Date 2.15.96</p>
<p>27 Corrective Actions Verified OAR  Date 2/6/96</p>	<p>28 Closure Approved By: AOQAM  for Date 2.15.96</p>

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Kiewit/PB response to DR YMQAD-96-D021

Item 1

Procedure was corrected during audit.

Item 2

Individual inspectors are not routinely made aware of ECR's and revisions to specifications. The inspectors work to procedures, not specifications. All change documents to specifications ie; ECR's, BCP's etc. are evaluated by quality engineering for impact on existing procedures or the need for new procedures. Procedures are revised or developed based on this evaluation and reading assignments are performed in accordance with pre-established core reading requirements. The core reading assignment for inspectors obviously includes revisions to QCP's. The condition described in item #1 of this DR is an isolated case. A comprehensive review of our QCP's has been performed and it has been verified that similar conditions do not exist. It certainly is not the intent of Kiewit/PB to refer inspectors to specifications for acceptance criteria.

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VERIFICATION OF CORRECTIVE ACTION FOR YMQAAD-95-D-021

1. KIEWIT/PB MCP-5.0, REV 11, Dated 2/1/96, PROCEDURE PREPARATION AND CONTROL was reviewed to verify that the requirement: that procedures contain acceptance criteria is specified. Exhibit 5.1, paragraph 6.D(2) addresses this requirement.

2 Based on the review of the above document, the required action have been satisfactory implemented and this deficiency is considered closed.



P.H. Cotter

2/6/96

Date

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PERFORMANCE/DEFICIENCY REPORT

1 Controlling Document:
Quality Assurance Requirements and Description (QARD), DOE/RW-0333P, Rev. 5

2 Related Report No.
YM-ARC-96-03

3 Responsible Organization:
Kiewit/Parsons Brinckerhoff (Kiewit/PB)

4 Discussed With:
Jon Christensen

5 Requirement/Measurement Criteria:

The QARD, Section 5.0, Paragraph 5.2, states, that: "Work shall be performed in accordance with controlled implementing documents."

6 Description of Condition:

Contrary to the above requirements, Kiewit/PB is using a "Kiewit/PB Yucca Mountain Project Material Acceptance Tag" on material deemed acceptable, without this tag being described in any Kiewit/PB implementing document. It is noted that a revision to procedure MCP-8.0 (Revision 7) was made in an attempt to describe controls for accepted material; however, this revision does not specify the name of the Accept Tag being used, and it includes other means such as "etc." to control accepted items, which is not considered adequate qualitative or quantitative acceptance criteria.

7 Initiator

Sam H. Horton

Date 12/1/95

9 QA Review

QAR Sam Horton

Date 12/1/95

10 Response Due Date

20 Working Days from Issuance

11 QA Issuance Approval

QAR (PRI/AOQAM (DR)

Date 12-21-95

12 Remedial Actions:

SEE PAGE 3

13 Remedial Action Response By:

1/23/96
Date

14 Remedial Action Due Date

NONE REQUIRED

Date

15 Remedial Action Response Acceptance

QAR

Sam Horton

(see page 3)

Date 2/1/96

16 PR Verification/Closure

QAR

N/A

Date

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17 Recommended Actions:

Revise procedure MCP-8.0 to specify what particular acceptance tag is being used by Kiewit/PB and provide a copy of this tag as an Exhibit to the procedure.

Determine what, if any, other tags are being used by Kiewit/PB that are not described in implementing documents and, if so, include a description of these tags and an exhibit of each in the next procedure revision.

18 Investigative Actions:

SEE PAGE 3

19 Root Cause Determination:

NONE REQUIRED

20 Action to Preclude Recurrence:

SEE PAGE 3

21 Response by:

D. Horton Date 1/23/96

22 Corrective Action Completion Due Date:

FEB 28 1996

23 Response Accepted

(see page

QAR *Sam Horton* 3) Date 2/1/96

24 Response Accepted

AOQAM *W. D. Doble* Date 2-15-96

25 Amended Response Accepted

QAR Date

26 Amended Response Accepted

AOQAM Date

27 Corrective Actions Verified

QAR Date

28 Closure Approved by:

AOQAM Date

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Kiewit/PB response to DR YMQAD 96-D022

This DR addresses the situation where the use of an accept tag at receiving is not defined in our MCP's. An attempt was made during the audit to revise MCP 8.0 to address the issue which apparently, in the opinion of the auditor, was insufficient. The issue is when items are accepted at receiving, the items are then transferred to the issued for construction hold area. There are instances when it is not practical or feasible to immediately make this transfer and site QC has taken steps internally to identify which items have been accepted and which have not yet been inspected. They have elected to use a tag. Kiewit/PB feels that this level of detail is not required to be proceduralized, however, to resolve this concern, MCP 8.0 will be further revised to describe the use of the acceptance tag.

feels
PL 2/5/96

QAR REMEDIAL ACTION & RESPONSE EVALUATION

The K/PB response to this DR is acceptable provided that the revision to K/PB procedure MCP 8.0 adequately describes the use of the acceptance tag & shows it as an exhibit in the procedure. J. Houston Feb. 01-1996

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WASHINGTON, D.C.

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PERFORMANCE/DEFICIENCY REPORT

1 Controlling Document:
Quality Assurance Requirements and Description (QARD), DOE/RW-0333P, Rev. 5

2 Related Report No.
YM-ARC-96-03

3 Responsible Organization:
Kiewit/Parsons Brinckerhoff (Kiewit/PB)

4 Discussed With:
Jon Christensen

5 Requirement/Measurement Criteria:

The QARD, Section 5.0, Paragraph 5.2, states, that: "Work shall be performed in accordance with controlled implementing documents."

6 Description of Condition:

- Contrary to the above requirement, Kiewit/PB has entered a disposition choice of "OTHER" in Block 2 of the Nonconformance Report (NCR) form. There are no provisions in MCP 15.0 (latest revision) or YAP 15.1Q (Revision 2) that describes the use of the "OTHER" disposition. Kiewit/PB NCRs 95-0104, 0109, 0131, and 0134 have "OTHER" dispositions.
- Contrary to the above requirement, Kiewit/PB has entered information in Block 2 of the NCR form describing the attributes of "Work Package Number" and "Travel Line Item Number." These attributes are not described in the procedures that control the reporting and dispositioning of nonconformances.

7 Initiator *Sam H. Horton*
Sam H. Horton

Date 12/21/95

9 QA Review *Sam H. Horton*
QAR SAM HORTON

Date 12/21/95

10 Response Due Date

20 Working Days from Issuance

11 QA Issuance Approval
QAR (PRI/AOQAM (DR)

Date 12-21-95

12 Remedial Actions:

SEE PAGE 3

13 Remedial Action Response By:

Jon Christensen

Date 1/23/96

14 Remedial Action Due Date

SEE PAGE 3

Date

15 Remedial Action Response Acceptance

QAR Sam Horton

Date 2/1/96

16 PR Verification/Closure

QAR N/A

Date

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17 Recommended Actions:

Submit a Document Action Request in accordance with procedure YAP 5.2Q to change the form as needed and to request a revision to YAP 15.1Q. This request needs to describe the disposition of "OTHER" and the purpose of adding the two aforementioned attributes in Block 2 of the NCR form.

Evaluate those NCRs that have been dispositioned as "OTHER" and determine what the appropriate disposition per YAP 15.1Q should have been. Evaluate and determine whether the disposition "OTHER" has had a negative impact on affected NCR. Revise or provide documented justification for the NCRs disposition remaining as "OTHER."

18 Investigative Actions:

SEE PAGE 3

19 Root Cause Determination:

NOT REQUIRED

20 Action to Preclude Recurrence:

SEE PAGE 3

21 Response by:

D. Christen

Date

1/23/96

22 Corrective Action Completion Due Date:

JAN 26 1996

23 Response Accepted

QAR

Sam Horton

Date

2/1/96

24 Response Accepted

AOQAM

P. Bonable

Date

2-15-96

25 Amended Response Accepted

QAR

Date

26 Amended Response Accepted

AOQAM

Date

27 Corrective Actions Verified

QAR

Date

28 Closure Approved by:

AOQAM

Date

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Response to YMOAD-96-D023 Items #1 and #2

Remedial Actions:

NCRs with dispositions on "OTHER" have been reviewed and no deficient conditions have been identified.

Investigative Actions:

Kiewit/PB made no changes to the existing information on the YAP-15.1Q NCR form. Kiewit/PB needed additional information added to the form to provide some traceability information and to accommodate transferring a nonconforming condition to another controlling document. Specifically, two line items, "Work Package No." and "Traveler Line Item No.", were added to block 2 to facilitate records keeping activities and an "Other" category was added, as needed, to block 4 for dispositions such as "Transferred to NCR No. XX-XXX" and "Transferred to FDR No. XX-XXX" that do not fit any of the other categories provided on the original form.

These additions have had no impact on the NCR process nor on the proper dispositioning of any nonconforming condition.

Root Cause:

None required.

Actions to Preclude Recurrence:

1. The use of "OTHER" for dispositioning will be discontinued.
2. Kiewit/PB will use the forms prescribed by YAP-15.1Q and will enter the additional traceability information to facilitate records keeping in the appropriate block.

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PERFORMANCE/DEFICIENCY REPORT

1 Controlling Document:
MCP-11.0, "Test Control" & MCP-12.0, "Control of Measuring and Test Equipment"

2 Related Report No.
YM-ARC-96-03

3 Responsible Organization:
Kiewit/Parsons Brinckerhoff

4 Discussed With:
Jon Christensen

5 Requirement/Measurement Criteria:

MCP-11.0, "Test Control," Rev. 3, states in Section 3.1.H that test procedures shall include, "Selection and identification of the measuring and test equipment to be used to perform the test to ensure that the equipment is the proper type, range, accuracy, and tolerance to accomplish the intended function."

MCP-12.0 states, "The basis for calibration acceptance shall be documented in the applicable equipment's data package ..."

6 Description of Condition:

For Swellex bolt installation, the gauge supplied by the vendor was used. There is no documentation of the tolerance required for this gauge, so the Physical Standards and Calibration Facility has assumed that the minor division on the gauge face is the tolerance to be used for calibration. For example, for gauge Y11497 the calibration tolerance used was plus or minus 20 BAR. The data package documents the tolerance used on the calibration report, but there is no documentation of the tolerance required by the project.

TCP-2.20, Permanent Function Rockbolt Installation, Rev. 2, Section 3.7.5 requires that "The inflation pressure for Super Swellex Rock Bolts shall be 300 BAR plus or minus 10 BAR. The pump units shall be periodically monitored and adjusted to ensure that the pump delivers water within the pressure range stated above." The gauge is read as a verification of the proper pressure being achieved. No gauge or gauge accuracy is specified. Therefore, if the inspector sees the gauge reading 290 BAR, he may assume that the specification is met even though the actual pressure may be only 270 BAR.

7 Initiator

Alan W. Rabe

Date

12/21/95

9 QA Review

QAR

Date

12/21/95

10 Response Due Date

20 Working Days from Issuance

11 QA Issuance/Approval

QAR (PR)/AOQAM (DR)

Date

12-21-95

12 Remedial Actions:

SEE PAGE 3 FOR ITEM 1
SEE PAGE 4 FOR ITEM 2

13 Remedial Action Response By:

1/23/96
Date

14 Remedial Action Due Date

Item 1: FEB 2

Date 1996

15 Remedial Action Response Acceptance

QAR

Date

2/6/96

16 PR Verification/Closure

QAR

Date

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17 Recommended Actions:

1. Determine from the manufacturer the actual pressure tolerance needed.
2. Determine the tolerance to which the gauge should be read during the test.
3. Determine the capability of the gauge.
4. Using the above, document the required accuracies.
5. Revise TCP-2.20 to properly direct the readings and identify the required gauges.
6. Revise MCP-12.0 to provide for determination of required tolerances for acceptance of calibration and transmit these to the calibration lab.
7. Determine the extent of this condition with regard to other M&TE and make changes as needed.

18 Investigative Actions:

SEE PAGE 3 (ITEM 1)

19 Root Cause Determination:

SEE PAGE 3 (ITEM 1)

20 Action to Preclude Recurrence:

SEE PAGE 3 (ITEM 1)

21 Response by:

[Signature] Date 1/23/96

22 Corrective Action Completion Due Date:

FEB 2 1996

23 Response Accepted

QAR *[Signature]* Date 2/6/96

24 Response Accepted

AOQAM *[Signature]* Date 2-15-96

25 Amended Response Accepted

QAR Date

26 Amended Response Accepted

AOQAM Date

27 Corrective Actions Verified

QAR Date

28 Closure Approved by:

AOQAM Date

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Item 1

K/PB agrees that a deficiency exists. The tolerance of the gauge sent for calibration was not specified by the manufacturer nor is it addressed in the applicable installation requirements. The calibration lab can only determine the "accuracy" of the gauge and report their findings (the tolerance shown on the lab report is for the lab's benefit only). The results are then reviewed by Quality Control for acceptability for use as allowed by MCP-12.0, 3.2.1, next to last sentence, which states:

"If no nationally-recognized standards or physical constants exist, or the manufacturer has no established method, the basis for calibration shall be documented."

The accuracy of gauge Y11497 was found to be 98.4% and greater at the pressure used in the field. This accuracy was determined to be within an acceptable range based on experience that a tolerance of $\pm 2\%$, with the accompanying accuracy of 98%, is generally accepted for gauges in the construction industry when no other accuracy is specified. K/PB QC, however, failed to appropriately document this basis of acceptability in the applicable data package.

Remedial Actions:

The basis for acceptance of the accuracy of gauges supplied by Atlas Copco for use in installing Super Swellex rockbolts will be inserted in the appropriate data packages.

Remedial Action Due Date:

See "Corrective Action Due Date"

Investigative Actions:

All M&TE will be reviewed for appropriate documentation of acceptance where the manufacturer has no established method.

Root Cause Determination:

Human error. The K/PB Quality Control Manager considered this equipment to be normal commercial equipment, and required accuracy checks only to assure reasonable controls. He failed to apply all of the requirements of MCP-12.0 to gauges that had no specified tolerance or accuracy.

Action to Preclude Recurrence:

Responding to this Deficiency Report has retrained the K/PB Quality Control Manager in the Projects expectations regarding calibration of measuring equipment. Additional action in this area is not required.

Corrective Action Completion Due Date:

Feb. 2, 1996

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Item 2

As stated previously, in the response to Item 1, since no tolerances were specified, an industry standard of plus/minus 2% was selected. Also, as previously stated, the selection of this tolerance was not documented, but will be as part of the corrective action for item 1. Gauges falling outside this acceptable range have been documented on NCR's totally unrelated to this Deficiency Report. Discussions with the supplier indicate that an accuracy of plus/minus 3% for these gauges would be acceptable. No further action is required.

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PERFORMANCE/DEFICIENCY REPORT

1 Controlling Document:
MCP-17.0, Revision 92 Related Report No.
YM-ARC-96-033 Responsible Organization:
Kiewit/Parsons Brinckerhoff (Kiewit/PB)4 Discussed With:
Jon Christensen

5 Requirement/Measurement Criteria:

Paragraph 3.2.3, states, in part: "Responsible record sources shall ensure the following elements are followed:

A. Legibility

1. Verify that records/record packages are legible."

6 Description of Condition:

Contrary to the above, completed Work Package 1.12, Section B, "Steel Set Fabrication" contains stamped Quality Control Inspector numbers and inspection dates that are illegible. Affected records include Steel Set Installation Inspection Forms within Line Items B-214, B-215, and B-216, some being originals and others copies of originals.

7 Initiator

Kristi A. Hodges

Date 12/21/95

9 QA Review

QAR

Date 12/21/95

10 Response Due Date

20 Working Days from Issuance

11 QA Issuance Approval

QAR (PRI/AOQAM (ORI)

Date 1-21-96

12 Remedial Actions:

SEE PAGE 3

13 Remedial Action Response By:

Date

1/23/96

14 Remedial Action Due Date

Date

Completed

15 Remedial Action Response Acceptance

QAR

Date

1/31/96

16 PR Verification/Closure

QAR

Date

N/A

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17 Recommended Actions:

1. Evaluate the identified records to determine appropriate action: e.g., deduction of information or regeneration of the record with documented justification.
2. Investigate the extent of the deficiency to determine whether other records that have been turned over to the DRC or in-process records are affected by the same condition.
3. Re-evaluate the use of these stamps and/or the size of the stamps used.

18 Investigative Actions:


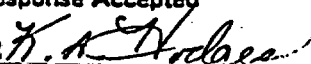
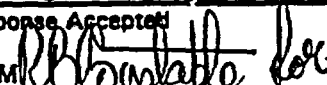
SEE PAGE 3

19 Root Cause Determination:

SEE PAGE 3

20 Action to Preclude Recurrence:

SEE PAGE 3

<p>21 Response by:  Date 1/23/96</p>	<p>22 Corrective Action Completion Due Date: Jan 26 1996</p>
<p>23 Response Accepted QAR  Date 1/31/96</p>	<p>24 Response Accepted AOQAM  Date 2-15-96</p>
<p>25 Amended Response Accepted QAR _____ Date _____</p>	<p>26 Amended Response Accepted AOQAM _____ Date _____</p>
<p>27 Corrective Actions Verified QAR _____ Date _____</p>	<p>28 Closure Approved by: AOQAM _____ Date _____</p>

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K/PB agrees that the stated deficiency existed.

Remedial Actions:

The problem of illegible QC and date stamps was identified in August, 1995 and was addressed via QC memo 95-67 (copy attached) on August 25, 1995. Additionally, steps were taken for the Quality Coordination group to monitor QC reports generated after issuance of the memo to ascertain directive effectiveness.

Work package 1.12 was developed prior to the identification of the problem, and issuance of the memo mentioned above, and contained illegible or missing stamps and/or dates. These problems, however, were not detected during initial review of the Work Package. Work Package 1.12 has been re-reviewed to correct illegible or missing data.

Remedial Action Due Date:

See Corrective Action Completion Due Date

Investigative Actions:

Monitoring for illegible or missing data in quality documentation has been an ongoing activity since discovery in August, 1995. Documentation contained in Work Packages generated prior to August, 1995 are being reviewed or re-reviewed, as the case may be, to detect and correct any documentation that is illegible or missing.

Root Cause Determination:

QC inspector and document review personnel lack of attention to records requirements details.

Action to Preclude Recurrence:

QC inspectors were instructed in the importance of legible documentation via QC memo 95-67.

Subsequent to this audit finding each Quality Coordinator has been verbally instructed, by the QC Manager, to review records with an eye toward legibility and completeness. This verbal instruction will be reinforced via a memo to all QC personnel on the importance of complete and legible documentation. Generated QC reports are being monitored for compliance.

Corrective Action Completion Due Date:

Jan. 26, 1996

**KIEWIT/PB
YUCCA MOUNTAIN PROJECT****INTEROFFICE MEMO**

QA: N/A
SCPB: N/A
QC:MEM:95-67

To: All QC Inspectors

From: Howard R. Cox *H. Cox*

Date: August 25, 1995

SUBJECT: ILLEGIBILITY OF INSPECTION AND DATE STAMPS

An inordinate amount of reports are being submitted without legible date and/or QC inspection stamps. This practice must cease immediately. All inspectors are responsible for the reports they generate. Besides not meeting Project requirements, illegible documentation is unprofessional.

If reports are not turned in with legible date and/or QC stamps, they will be returned for correction. Repetitive conditions will result in stamps being revoked and written signature and date required.

HRC:kck

cy: Thomas J. Tomek
Wesley C. Pugmire
Job File

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PERFORMANCE/DEFICIENCY REPORT

1 Controlling Document:
Quality Assurance Requirements and Description (QARD), DOE/RW-0333P, Rev. 5

2 Related Report No.

3 Responsible Organization:
Kiewit/Parsons Brinckerhoff4 Discussed With:
Jon Christensen5 Requirement/Measurement Criteria:
Section 5.0, Paragraph 5.2.2 states, in part: "Implementing documents shall include ...

C. A sequential description of the work to be performed including controls for altering the sequence of required inspection, test, and other operations ...

D. Quantitative or qualitative acceptance criteria sufficient for determining that activities were satisfactorily accomplished."

Section 2.0, Paragraph 2.2.1B states: "Affected Organizations shall establish implementing documents applicable to their scope of work that translate QARD requirements into work processes."

6 Description of Condition:
Contrary to the above cited QARD requirements:

1) MCP-4.0, "Procurement," Revision 12, fails to provide the required methodology and proper sequence. In addition, omissions or errors were identified as follows:

- a) Section 3.2.5 Does not include review criteria for Engineering.
- b) Section 3.2.6 Does not include review criteria for Construction Management.
- c) Section 3.3.1 Only provides limited QE review criteria.
- d) Section 3.4.7 Only parrots the QARD requirement for bid/proposal evaluations; there are no criteria or methodology.
- e) Section 3.6.1 Requires a technical and quality review of the purchase order; this section addresses QE functions but nothing for the technical review.

(Continued on Page 3)

7 Initiator
Donald J. Harris
Date 12-21-959 QA Review
OAR Donald J. Harris
Date 12-21-9510 Response Due Date
20 Working Days from Issuance11 QA Issuance Approval
OAR (PRI)/AOQAM (DRI)
Date 12-21-9512 Remedial Actions:
ITEMS 1 AND 2 - SEE PAGE 6
ITEM 3 - NONE13 Remedial Action Response By:
Jon Christensen
Date 1/24/9614 Remedial Action Due Date
SEE PAGE 6
Date15 Remedial Action Response Acceptance
OAR J. Harris
Date 1/31/9616 PR Verification/Closure
OAR N/A
Date

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17 Recommended Actions:

- 1) Revise MCP-4.0, MCP-7.1, and VTP-001; provide methodology, proper sequence, acceptance criteria, and correct errors and omissions.

18 Investigative Actions:

SEE PAGES 4, 5, & 6

19 Root Cause Determination:

NONE REQUIRED. ROOT CAUSE FOR
PROCEDURAL ERRORS IS BEING ADDRESSED
IN YMOAD 96-0020

20 Action to Preclude Recurrence:

TO BE ADDRESSED IN YMOAD 96-0020

21 Response by:

[Signature]

Date

1/24/96

22 Corrective Action Completion Due Date:

SEE YMOAD 96-0020

23 Response Accepted

QAR

[Signature]

Date

1/31/96

24 Response Accepted

AOQAM

[Signature]

Date

2-15-96

25 Amended Response Accepted

QAR

Date

26 Amended Response Accepted

AOQAM

Date

27 Corrective Actions Verified

QAR

Date

28 Closure Approved by:

AOQAM

Date

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BLOCK 6: (Continued)

- f) Section 3.6.3C Needs to address purchase orders.
- g) Section 3.6.3 The procedure does not address any procurement action when the design documents require a change to existing procurement documents.
- h) Section 3.7.5 Reference 2.6 is incorrect; it should be 2.4 and maybe 2.6.
- i) Section 3.9 Supplier certification requirements appear to be out of sequence, especially if required to be in a PR (Section 3.2), purchase order (Section 3.5), and RIP (Section 3.2.10).
- j) Section 3.10B Reference 2.4 should be 2.5.
- k) Section 3.10D Reference 2.5 should be 2.4.
- l) Section 4.2 Records turnover in conflict with YAP 17.1Q, ICN #1, Attachment 9.6 records submittals.
- 2) MCP-7.1, "Acceptance of Procured Items and Services"
- a) Section 3.3.1C Technical verification of product produced. This requirement is also referenced in 3.3.6 and 3.9; however, the procedure does not provide any criteria or methodology.
- b) Section 3.4.13 Beside the RIP there are other required documents; i.e., test reports, certifications, deficiency documents, etc.
- c) Section 3.5.2A Fails to provide any methodology.
- d) Section 3.7.6 QC should obtain Exhibit 5.2 from the QE and include it and the certifications with the procurement package.
- e) Section 3.11.3 Established QC instructions are not identified.
- f) Section 3.13.1 Material Dedication Plan; the procedure fails to provide any criteria or methodology for the development of the dedication plan. Reference 2.9 is the QARD, which is only a requirements document; it does not provide any methodology.
- g) Section 3.13.2C Inspection is performed to the RIP, not to the dedication plan. Inspection should not have anything to do with that document.
- h) Section 4.1C This should include the supplier's documentation.
- i) The Receiving Inspector Level II uses a red ink stamp for QC review of the Level I processed documents (RIPs). The Level II stated that this stamp is for the verification of the documented entries on the RIP by the Level I. The use of this stamp is not defined or explained in this procedure.
- 3) VTP-001, "Verification Testing of Rockbolts"
- a) Section 3.6.2 Specifies the test methods of ASTM F432 and states the acceptance of the test shall be based on meeting the manufacturer's minimum published requirements. The published requirements are not a controlled document or immediately available. The quantitative or qualitative acceptance criteria should be in the VTP so the material test lab can flag discrepancies or incorporated into the RIP (or both).

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Kiewit/PB response to DOE DR YMOAD-96-D027

The following are responses to the DOE comments regarding MCP-4.0 rev 12:

Item 1(a)

Par. 3.2.5 will be revised to include review criteria for engineering review of PR's.

Item 1(b)

Since the review of PR's by construction management is basically a financial and quantity review and is not quality affecting, review criteria is not applicable, however, procedure will be modified to reflect this position.

Item 1(c)

The review criteria for QE is considered sufficient, however, Par. 3.3.1.A is somewhat unclear and will be modified for clarity.

Item 1(d)

The DR states that there are no criteria or methodology for bid/proposal evaluation. Although the Kiewit/PB procedure essentially repeats the evaluation criteria contained in the QARD, we believe that this is adequate for the following reasons:

- A very limited number of proposals for quality-related procurements are conducted. There are currently no plans for additional procurements to be made from qualified suppliers.
- The Kiewit/PB staff involved in proposal evaluations is very small. The personnel conducting these evaluations are experienced, which results in adequate and properly documented evaluations.

Item 1(e)

The procedure will be revised to more adequately address the technical review of PO's.

Item 1(f)

DR states that paragraph 3.6.3.C needs to address PO's. Procedure will be modified to address actions taken regarding the impact on outstanding PO's due to design changes.

Item 1(g)

DR states that the procedure does not address any procurement action when design documents require a change to procurement documents. Kiewit/PB disagrees with this opinion. Paragraph 3.6.3.C requires QE to notify procurement when changes to existing PO's are required and paragraph 3.6.3.A requires all revisions to PO's be processed the same as the original PO. No deficiency exists.

Item 1(h)

Procedure typographical error will be corrected.

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Item 1(i)

The DR states that this section appears to be out of sequence. Kiewit/PB disagrees with this opinion. Paragraph 3.2.3.E states that the PR shall include the requirements for supplier documentation as required by the applicable specification and further instructs the PR originator to refer to paragraph 3.9 (the paragraph in question) for additional information. No deficiency exists.

Items 1(i) and 1(k)

Procedure typographical errors will be corrected.

Item 1(l)

The DR states that the procedure is in conflict with YAP 17.1Q in terms of records turnover. Although Kiewit/PB disagrees with this opinion, we are going to make some changes to the turnover process. Paragraph 4.2 of our procedure states that procurement records will be retained by the procurement department until the end of the fiscal year following the year of PO closeout. At that time procurement prepares the table of contents, as required by YAP 17.1Q, and either "authenticates" for Q orders or "submits" for non-Q. The package is then turned over within 20 days of this authentication date. This practice complies with the requirements of the YAP,

After investigating this process, Kiewit/PB has concluded that we do not need to keep these records as long as originally thought and will revise our procedure to state that procurement will prepare the Table of Contents for authentication or submittal no later than 30 days from closure of the order. The authenticated or submitted packages will then be turned over to the M&O within 20 days from that date. It will still be at the discretion of the procurement department as to when a procurement file is considered closed.

The following are responses to DOE comments regarding MCP 7.1 Rev.7:

Item 2(a)

The DR states that there is no criteria or methodology for implementing the "Technical Verification of Product Produced" method of acceptance. This is a true statement, however, as stated in paragraph 3.9 of the procedure, Kiewit/PB does not anticipate utilizing this method for acceptance of items. This method of acceptance is referenced in the procedure to show that Kiewit/PB has considered all of the acceptance methods as identified in the QARD. Should it become appropriate, in the future, to use this method of acceptance, the procedure will be revised to include applicable criteria and methodology. No deficiency exists.

Item 2(b)

The DR states that, in addition to the RIP, there are other required documents to be placed in the FFP. This is a true statement, however, the procedure section in question (section 3.4) covers RIP development and processing. The content of the FFP is addressed in MCP 4.0. No deficiency exists.

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Item 2(c)

The DR states that there is no methodology for arranging an independent inspection and/or test of the item when the C of C method of acceptance is used. Kiewit/PB disagrees with this opinion. A requirement to "arrange an independent inspection and/or test" is adequately clear and no more detail is required. It should be understood that Kiewit/PB does not use the C of C method of acceptance of Q items. The method is referenced in the procedure to show that all of the acceptance methods as identified in the QARD have been considered. No deficiency exists.

Item 2(d)

Verbal confirmation is obtained by QC from QE of the acceptance of supplier certifications prior to release of the items by QC. A copy of the QE review (exhibit 5.2) is then forwarded to QC for record purposes and another copy along, with the actual supplier certifications, is forwarded procurement for inclusion into the procurement package. Although no deficiency exists, paragraph 3.7.6 will be revised to better define the actual process.

Item 2(e)

Procedure will be revised to include reference to QCP-002 for placement of "Hold" tags.

Item 2(f)

Since the requirements and criteria for the development of a Material Dedication Plan are unique to each specific case, the Dedication Plans will be based on the requirements provided by the design specifications. Procedure will be modified to reflect this position.

Item 2(g)

The statement that "Inspection is performed to the RIP, not to the dedication plan" is true and that is exactly what we do. Any other interpretation of paragraph 3.13.2C is a mis-interpretation. No deficiency exists.

Item 2(h)

The DR states that this paragraph should include supplier's documentation as Lifetime QA Records. This section of the procedure identifies only those Lifetime QA Records which are generated by the procedure. Supplier documentation is not generated by this procedure, however, MCP-4.0 will be revised to include supplier documentation as QA records.

Item 2(i)

The requirement is that the Level II inspector review for acceptability, the entries on the RIP performed by a Level I inspector. The Level II inspector has elected to use a stamp to track the entries of the Level I which he has verified. Since we don't agree that procedures should be reduced to this level of detail, the use of the stamp for this purpose will be discontinued.

Remedial Action response to YMQAD-96-D027

All revisions to MCP-4.0 and MCP-7.1, identified in investigative actions, will be completed by 2/29/96

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Response to YMOAD-96-D027 ITEM 3A

K/PB disagrees that the stated deficiencies exist.

The finding alleges that the manufacturer's published requirements are not controlled. There are two reasons that K/PB disagrees with this statement:

- The manufacturer's requirements are "published" for general description and use as supplier catalogs. These are generally available to the public and, normally, do not require "control".
- In this case the manufacturer's requirements were a submittal item (02165-VD-04) and are controlled by the submittal process as a specification requirement.

The finding alleges that the published requirements were not "immediately available". Although the finding does not specify where the requirements were not immediately available, a copy is, and has been, immediately available in the K/PB QC Coordinator's office. The QC Coordinator is the person responsible for determining that the test results, reported by the Test Lab, are acceptable.

The finding states that the acceptance criteria "should" have been provided to the Test Lab and/or incorporated into the RIP (Receipt Inspection Plan). Although previous data has been properly reviewed and accepted, we agree to incorporate the acceptance criteria into the applicable RIP for future work. RIP's are in process of being revised and will be completed by 2/15/96.

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PERFORMANCE/DEFICIENCY REPORT

1 Controlling Document:
Quality Assurance Requirements and Description (QARD), DOE/RW-0333P, Rev. 52 Related Report No.
YM-ARC-96-033 Responsible Organization:
Kiewit/Parsons Brinckerhoff (Kiewit/PB)4 Discussed With:
Jon Christensen

5 Requirement/Measurement Criteria:

Section 2.0, Paragraph 2.2.1, QA Program Documents, states in part:

B. "AOs shall establish implementing documents applicable to their scope of work that translate QARD requirements into work processes."

Section 5.0, Paragraph 5.2.2, states in part: "Implementing documents shall include:

C. a sequential description of the work to be performed including controls for altering the sequence of required inspection, test, and other operations.

D. Quantitative or qualitative acceptance criteria sufficient for determining that activities were satisfactorily accomplished."

Section 10.0, Paragraph 10.2.9D.3, states: "Level-III personnel shall have Level-II capabilities for the corresponding category or class (which includes supervisory and certifying lower level personnel, Section 10.0, Paragraph 10.2.9D.2) (contd. Page 3)

6 Description of Condition:

Contrary to the cited QARD requirements:

1. MCP-10.1, "Qualification and Certification of Inspection and Test Personnel," Revision 7, fails to translate the QARD requirements into work processes that provide the methodology to accomplish the requirements as follows:

a) 3.1.1B The section does not provide the methodology or basis for determining if the candidates for Level II and III Inspectors have the required capabilities identified in 3.1.1B, items 1 through 5.

b) 3.1.1D states in part: "The Certifying Agent (CA) shall be designated by the QA Manager. the CA shall be responsible for preparation, administration, testing, and certification of K/PB Inspection and Test Personnel." 3.5.1 states: "Testing not required for CA."

(Contd. on Page 3)

7 Initiator:

Donald J. Harris

Date 12/21/95

9 QA Review:

QAR Don HARRIS

Date 1/4/96

10 Response Due Date

20 Working Days from Issuance

11 QA Issuance Approval

QAR (PRI)/AOQAM (DR)

Date 2-21-96

12 Remedial Actions:

SEE PAGE 4

13 Remedial Action Response By:

J. Christensen

Date 1/23/96

14 Remedial Action Due Date

SEE PAGE 4

Date

15 Remedial Action Response Acceptance

QAR J. Harris

Date 1/31/96

16 PR Verification/Closure

QAR

N/A

Date

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17 Recommended Actions:

1. Provide the methodology and the basis for satisfying the QARD requirements into the work process.
2. Review the Kiewit/PB Inspectors (Level-I, Level-II, and Level-III) certifications to ensure the CA, in fact has the education, experience, and/or required training in accordance with MCP-10.1, Section 3.1.5 and was tested and certified as a Level-III in each NDE method (RT, PT, MT, UT) or Inspection discipline (civil, construction, welding, mechanical, electrical) that the CA certified personnel in.

18 Investigative Actions:

SEE PAGE 4

19 Root Cause Determination:

NONE REQUIRED

20 Action to Preclude Recurrence:

SEE PAGE 5

21 Response by:

D. Christen

Date

1/23/96

22 Corrective Action Completion Due Date:

MAR 16, 1996

23 Response Accepted

QAR *de Maris*

Date

1/31/96

24 Response Accepted

AOQAM *Whitham*

Date

2-15-96

25 Amended Response Accepted

QAR

Date

26 Amended Response Accepted

AOQAM

Date

27 Corrective Actions Verified

QAR

Date

28 Closure Approved by:

AOQAM

Date

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Block 5 continued

In addition, the Level-III personnel shall also be capable of evaluating the adequacy of specific programs used to train, qualify, and certify the personnel."

Block 6 continued

e) 3.2.6 Does not provide the methodology of documenting additional education, training, and/or experience.

f) 3.5.1 CA is not tested or certified (see b above)

g) 3.5.7 Agree with no general test being required when associated with a National recognized Certification ASNT TC.1A or AWS D.1.1, Weld Inspection. The Inspector, however, needs to be knowledgeable of YMP specification, drawings, and Kiewit/PB implementing documents.

NOTE: Kiewit/PB has certified Level-I inspectors, the program does not provide for on-the-job training under the direct supervision of a qualified person.

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YMQAD-96-D028

Remedial Actions:

Item 1.a)

MCP-10.1, Paragraph 3.1.1B is not intended to provide the methodology nor basis for determining a candidate's capabilities. It simply lists the capability requirements for Level II inspectors. Paragraph 3.1.2 and Section 3.2 provide the methodology for determining that individuals meet the requirements of Paragraph 3.1.1B. However, to resolve this concern, Section 3.2 will be revised to clearly indicate that the education, experience, and the results of the examination or capability demonstration shall be reviewed and evaluated to determine that the candidate for certification has demonstrated capabilities as defined by Paragraphs 3.1.1A., B., or C. as applicable.

Items 1. b) and f)

MCP-10.1 will be revised to indicate that the Certifying Agent is responsible for the overall control and administration of the Kiewit/PB program for the qualification and certification of inspection and testing personnel. It will further require that persons certifying inspectors shall be themselves certified Level III in the discipline of the person being certified.

It should be noted that the Kiewit/PB Certifying Agent is Certified Level III in RT, UT, MT, PT, Welding Inspection, Civil Inspection, and Construction Inspection. A review has been conducted and it has been verified that all Kiewit/PB inspectors that have conducted QARD-related inspections have been certified by individuals who were properly certified Level III in the applicable disciplines. Also, Kiewit/PB will assure that no QARD related inspections will be performed by individuals who have not been certified by an appropriately certified Level III. No further evaluation or remedial actions are required.

Item 1.e)

MCP-10.1, Paragraph 3.2.6 states "Should a candidate fail an examination, additional education, training and/or experience, as determined by the Certifying Agent, shall be completed and documented prior to re-examination." MCP-10.1 will be modified to address the method of documenting the additional education, training and/or experience prior to re-examination as determined by the CA.

Item 1.g)

Kiewit/PB agrees that the inspector needs to be knowledgeable in the use of specifications and implementing documents. This is why MCP-10.1, Paragraph 3.5.7B requires the administration of a specific examination in accordance with paragraph 3.2.2B. This, along with the indoctrination and training accomplished in accordance with MCP-2.4, ensures these inspectors are knowledgeable of YMP specifications, drawings, and Kiewit/PB implementing documents.

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Revisions to MCP-10.1 will be completed by February 16, 1996.

Action to Preclude Recurrence:

Personnel responsible for implementing MCP-10.1 requirements will be trained in its new requirements after revision.

ORIGINAL
THIS IS A RED STAMP

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ORIGINAL
THIS IS A RED STAMP

8 ☒ Performance Report
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PERFORMANCE/DEFICIENCY REPORT

1 Controlling Document:
MCP-12.0, Revision 9; QAP-12-1, Revision 1

2 Related Report No.
YM-ARC-96-03

3 Responsible Organization:
M&TE and Kiewit/Parsons Brinckerhoff (Kiewit/PB)

4 Discussed With:
D. Franks and Jon Christensen

5 Requirement/Measurement Criteria:

Kiewit/PB procedure MCP-12.0, "Control of Measuring and Test Equipment," Paragraph 1.2, states: "This procedure is applicable to all tools, gauges, instruments, or other test equipment that require calibration and will be utilized for quality verification activities."

CRWMS M&O procedure QAP-12-1, "Control of Measuring and Test Equipment and Calibration Standards," Paragraph 3.1 (Definition), states: Measuring and Test Equipment (M&TE). Devices or systems used to calibrate, measure, gage, test, or inspect in order to control or acquire data to verify conformance to specified requirements."

6 Description of Condition:

1. Steel set jacking rams, which are part of the jacking system, are not under the control of the Kiewit/PB M&TE Program. Note that the gauges are included in the program and the only items missing are the identification numbers and the one time only test to verify the piston area and establish the multiplier (similar rams, those used in rock bolt testing, are included in the M&TE program).
2. The CRWMS M&O Architect/Engineer Title III organization which dispositioned Nonconformance Report YMSCO-95-0014 (which addressed this subject) did not consider the hydraulic jacking system used to install steel sets to be a M&TE system. Consideration should have been given that it has a dual function: 1) to install the steel set; and 2) to verify conformance to specified requirements. Also, the ram is part of the hydraulic system and the manufacturer's tolerances needs to be verified by testing or measurement.

7 Initiator

Patout H. Cotter

Date 12/4/95

9 QA Review

QAR P.H. COTTER

Date 12/4/95

10 Response Due Date

20 Working Days from Issuance

11 QA Issuance Approval

QAR (PRI)/AOQAM (DR)

Date 12/4/95

12 Remedial Actions:

PLEASE SEE CONTINUATION P20F2

13 Remedial Action Response By:

Date 1/25/96

14 Remedial Action Due Date

JANUARY 26, 1996 Date

15 Remedial Action Response Acceptance

QAR

Date 1/25/96

16 PR Verification/Closure

QAR P.H. COTTER

Date 1/30/96

OFFICE OF CIVILIAN
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U.S. DEPARTMENT OF ENERGY
WASHINGTON, D.C.

8 ☒ Performance Report
☐ Deficiency Report

NO. YMQAD-96-P-018

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QA: L

PR/DR CONTINUATION PAGE

12 Remedial Action

1. The steel set jacking system is considered a commercial item. The jacks are tools used to expand the steel sets into contact with the adjacent rock. There is no special criteria for this function that requires more than a standard commercial system. The jack capacity was selected, from an array of available commercial equipment, so that the force exerted on the steel set members would not exceed design limits. The force allowed is 27 tons, per the specification. The jacks selected are rated at 25 tons (See the attached catalog cut sheet). This system falls under the portion of Section 12 of the QARD that deals with Commercial Device. Quoting from the QARD: "Calibration and control shall not be required for rulers, tape measures, levels and other normal commercial equipment that provides adequate accuracy." The jacks as selected are considered "...normal commercial equipment that provides adequate accuracy."
2. Considering that the jack model numbers and the jack ram diameter have all been verified (See Attachments 1 and 2, IOC and catalog cut respectively), the conditions described in the PR has been adequately addressed considering the function of the jacks.

The final remedial action will be that copies of the Performance Report will be sent to the RPC and that a note will be added to the transmittal to supplement the disposition of NCR No. YMSCO-95-0014.

prjacksa.wp5

Interoffice Correspondence
Civilian Radioactive Waste Management System
Management & Operating Contractor



TRW Environmental
Safety Systems Inc.

Subject
PR YMQAD-96-P018
(SCPB: N/A)

Date
January 16, 1996
LV.ESSB.CRG.1/96-003

WBS: 1.2.6
QA: L
From
Charles R. Garrett

1 Garrett

To
Dana J. Rogers, TES3/423

cc
J. J. Clark, TES3/423
Title III File
RPC

Location/Phone
TES3/763
(702) 295-6618

As you requested, today we physically measured the rams of the jacks used underground for steel set installation and reverified that they are Enerpac Model RC 2510.

The dimensions of the rams using Vernier Calipers measured 2.255 in against the manufacturers' catalog dimension of 2.25 in. This is consistent with the manufacturer's stated tolerances as referenced in the Telecon Report listed as attachment 3 contained in NCR YMSCO 95-0014.

2nd 2.255 1-18-96

*2.255" and
2.248"
1-18-96*

NOTE: The calipers used have the number Y11444. They were calibrated 2-16-95 and are due to be calibrated 2-16-96. This information rec'd from C. R. Garrett by telephone on 1-18-96.

*John J. Clark
1-18-96*

Single-Acting, Solid Plunger Hydraulic Cylinders

RC Series - 10,000 PSI

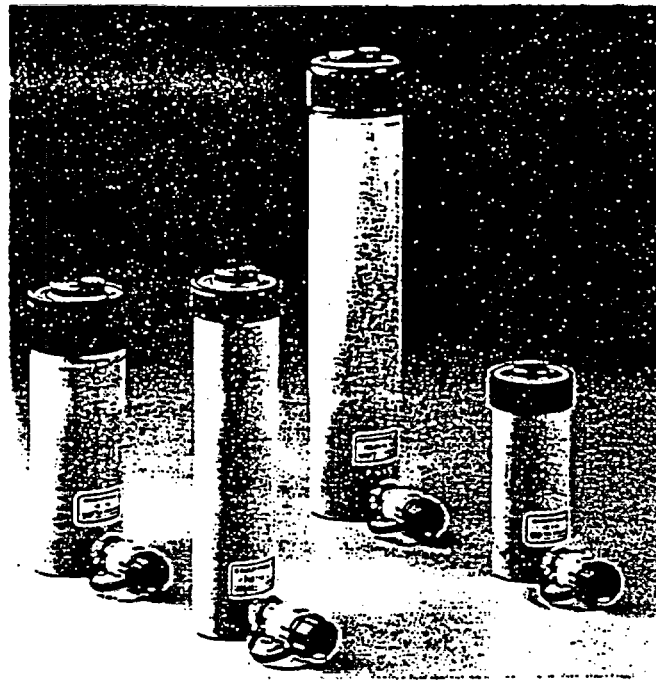
15 and 25 Ton Capacities

Applications

These cylinders can be used in many applications, including maintenance, production, fabrication and construction. They are designed for use in all positions and can be powered by a wide range of Enerpac pumps.

Features

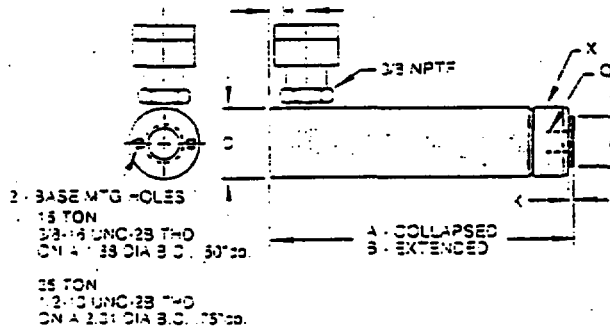
- 16 models.
- Includes QR-400 coupler and dust cap.
- Collar threads enable easy fixturing.
- Baked enamel paint finish provides increased corrosion resistance.
- Spring return.
- Base mounting holes.
- Snap-in, removable, grooved saddles.



RC-256, RC-158, RC-2514, RC-154

Ordering Information

Refer to the selection chart below for the available models. Many of these cylinders are also available in hand pump, hose and cylinder sets for your ordering convenience (see page 42). Load holding valves (see page 77) and pressure gauges (see page 79) are some of the optional equipment you may also need to order.



Accessories

Cylinder Saddles

Cylinders are supplied standard with grooved saddles. All saddles shown in selection chart may be ordered separately. CAT-50 tilt saddles pivot 5°, have a 2" diam. and protrude 1" from plunger.



A-252G CAT-10 CAT-50

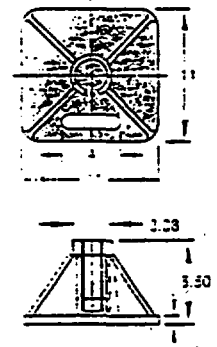
Selection Chart

Model No.	Type Of Saddle	For Use With Cylinder
A-152G	Grooved	15 Ton
A-252G	Grooved	25 Ton
CAT-10	Tilt	15 Ton
CAT-50	Tilt	25 Ton

Cylinder base for 25 ton cylinders



Shown with RC-256



Selection Chart

Model No.	Cyl. Cap. (Tons)	Stroke (In.)	Cyl. Effect. Area Sq. In.	Oil Dia. (In.)	Collapsed Ht. (In.)	Ext. Ht. (In.)	Out. Dia. (In.)	Cyl. Bore Dia. (In.)	Plgr. Dia. (In.)	Base To Adv. Port (In.)	Saddle Dia. (In.)	X Saddle Protrusion From Plgr. (In.)	Plgr. Int. Thd. (In.)	Plgr. Thd. Lgth. (In.)	Collar Thd. Lgth. (In.)	Collar Thd. (In.)	Weight (Lbs.)
RC-151	15	1.00	2.14	2.00	4.38	5.38	2.75	2.20	1.50	75	1.30	.38	1-8	1	1.19	2K-16	7.2
RC-152	15	2.00	2.14	4.50	5.38	7.38	2.75	2.20	1.50	75	1.30	.38	1-8	1	1.19	2K-16	9
RC-153	15	4.00	2.14	12.50	7.38	11.38	2.75	2.20	1.50	75	1.30	.38	1-8	1	1.19	2K-16	11
RC-156	15	6.00	2.14	19.00	10.39	14.39	2.75	2.20	1.50	100	1.50	.38	1-8	1	1.19	2K-16	15
RC-158	15	8.00	2.14	25.00	12.39	16.39	2.75	2.20	1.50	100	1.50	.38	1-8	1	1.19	2K-16	18
RC-1510	15	10.00	2.14	31.50	14.39	18.39	2.75	2.20	1.50	100	1.50	.38	1-8	1	1.19	2K-16	21
RC-1512	15	12.00	2.14	38.00	16.39	20.39	2.75	2.20	1.50	100	1.50	.38	1-8	1	1.19	2K-16	24
RC-1514	15	14.00	2.14	44.00	18.39	22.39	2.75	2.20	1.50	100	1.50	.38	1-8	1	1.19	2K-16	26
RC-251	25	1.00	5.15	3.20	5.30	6.30	3.28	2.56	2.25	1.20	2.20	.41	1-11.8	1	1.34	3K-12	13
RC-252	25	2.00	5.15	10.50	6.30	8.30	3.28	2.56	2.25	1.20	2.20	.41	1-11.8	1	1.34	3K-12	14
RC-253	25	4.00	5.15	21.30	8.30	12.30	3.28	2.56	2.25	1.20	2.20	.41	1-11.8	1	1.34	3K-12	18
RC-256	25	6.25	5.15	32.20	10.75	17.20	3.28	2.56	2.25	1.20	2.20	.41	1-11.8	1	1.34	3K-12	22
RC-258	25	8.25	5.15	42.30	12.75	21.20	3.28	2.56	2.25	1.20	2.20	.41	1-11.8	1	1.34	3K-12	27
RC-2510	25	10.25	5.15	52.30	14.75	25.00	3.28	2.56	2.25	1.20	2.20	.41	1-11.8	1	1.34	3K-12	31
RC-2512	25	12.25	5.15	62.00	16.75	29.00	3.28	2.56	2.25	1.20	2.20	.41	1-11.8	1	1.34	3K-12	36
RC-2514	25	14.25	5.15	71.50	18.75	33.00	3.28	2.56	2.25	1.20	2.20	.41	1-11.8	1	1.34	3K-12	39

QA: N

23. ACCESSION NO(S): (RPC use only)

Complete only applicable items.

1. COMPLETE THE FOLLOWING FOR ACCESS TO PRIVILEGED RECORDS

☐ DOE 28 - Use standard access list ☐ Other - Access instructions:

2. RECORD DATE	3. TITLE/DESCRIPTION	4. TRACKING/BATCH NO.	5. NO. OF PAGES
01/25/96	OBJECTIVE EVIDENCE OF COMPLETION OF REMEDIAL ACTION FOR DEFICIENCY YMQAD-96-P-018 <i>(SCP B : N/A)</i>		7
TOTAL PAGE COUNT			7
6. COMMENTS: NOTE: THIS PERFORMANCE REPORT REMEDIAL ACTION IS SUPPLEMENTAL TO THE DISPOSITION OF NCR NO. YMSCO-95-0014.			
7. SENDER JOHN J. CLARK	8. ORGANIZATION MGDS DEV.	9. MAILSTOP 423	10. DATE 01/25/96
11. RECIPIENT	12. ORGANIZATION	13. MAILSTOP	14. DATE
15. SENDER	16. ORGANIZATION	17. MAILSTOP	18. DATE
19. RECIPIENT	20. ORGANIZATION	21. MAILSTOP	22. DATE
24. RPC ACCEPTANCE			25. DATE

Complete only applicable items.

14. TRACKING NUMBER (RPC USE ONLY)	1. RECORDS PACKAGE DATE	2. TOTAL PAGE COUNT
	01/25/96	7
3. TITLE/DESCRIPTION OF PACKAGE		
OBJECTIVE EVIDENCE OF COMPLETION OF REMEDIAL ACTION FOR DEFICIENCY YMQAD-96-P-018 (SCPb:N/A)		

[illegible]

8. COMPILED BY JOHN J. CLARK	9. SIGNATURE <i>John J. Clark</i>	10. DATE 01/25/96
11. AUTHENTICATED BY <i>Nickelle Proter</i>	12. SIGNATURE <i>Nickelle Proter</i>	13. DATE 1-25-96

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PERFORMANCE/DEFICIENCY REPORT

1 Controlling Document: MCP-12.0, Revision 9; QAP-12-1, Revision 1		2 Related Report No. YM-ARC-96-03	
3 Responsible Organization: M&O and Kiewit/Parsons Brinckerhoff (Kiewit/PB)		4 Discussed With: D. Franks and Jon Christensen	
5 Requirement/Measurement Criteria: Kiewit/PB procedure MCP-12.0, "Control of Measuring and Test Equipment," Paragraph 1.2, states: "This procedure is applicable to all tools, gauges, instruments, or other test equipment that require calibration and will be utilized for quality verification activities." CRWMS M&O procedure QAP-12-1, "Control of Measuring and Test Equipment and Calibration Standards," Paragraph 3.1 (Definition), states: Measuring and Test Equipment (M&TE). Devices or systems used to calibrate, measure, gage, test, or inspect in order to control or acquire data to verify conformance to specified requirements."			
6 Description of Condition: 1. Steel set jacking rams, which are part of the jacking system, are not under the control of the Kiewit/PB M&TE Program. Note that the gauges are included in the program and the only items missing are the identification numbers and the one time only test to verify the piston area and establish the multiplier (similar rams, those used in rock bolt testing, are included in the M&TE program). 2. The CRWMS M&O Architect/Engineer Title III organization which dispositioned Nonconformance Report YMSCO-95-0014 (which addressed this subject) did not consider the hydraulic jacking system used to install steel sets to be a M&TE system. Consideration should have been given that it has a dual function: 1) to install the steel set; and 2) to verify conformance to specified requirements. Also, the ram is part of the hydraulic system and the manufacturer's tolerances needs to be verified by testing or measurement.			
7 Initiator Patout H. Cotter Date 12/24/95		9 QA Review P.H. Cotter OAR P.H. COTTER Date 12/24/95	
10 Response Due Date 20 Working Days from Issuance		11 QA Issuance Approval P.H. Cotter OAR (PRI/AOQAM (DH)) Date 12/24/95	
12 Remedial Actions: FOR ITEM 1 SEE PAGE 2			
13 Remedial Action Response By: J. Christensen Date 1/23/96		14 Remedial Action Due Date ITEM 1 - NONE Date	
15 Remedial Action Response Acceptance OAR P.H. Cotter Date 1/24/96		16 PR Verification/Closure OAR P.H. Cotter Date 1/30/96	

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PR/DR CONTINUATION PAGE

YMQAD-96-P018

Remedial Actions:

Item 1.

The jacking system employed by Kiewit/PB as discussed in this Performance Report consists of a calibrated pressure gauge and the jack. NCR YMSCO-95-0014 was issued to address the very concern (that both the gauge and the jack needed to be calibrated) stated in this PR. The A/E evaluated the issue and, in the disposition of the NCR, determined that the jacks did not need to be included in the calibration program. Kiewit/PB has complied with this disposition and no discrepancy related to Kiewit/PB activities in this area exists.

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PR VERIFICATION / CLOSURE

*the remedial action, submitted of objective evidence
transmitted by letter L.V. H6. JJC.1 1/76-011 dated 1/24/76
was reviewed.*

this PR is now closed

P.I. letter 1/30/96

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NO. YMOAD-96-P019

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PERFORMANCE/DEFICIENCY REPORT

1 Controlling Document:
QARD, DOE/RW-0333P, Rev. 5, and MCP-4.0, Rev. 12

2 Related Report No. RBE 12-2145
YM-ARC-96-03

3 Responsible Organization:
Kiewit/Parsons Brinckerhoff (Kiewit/PB)

4 Discussed With:
Jon Christensen

5 Requirement/Measurement Criteria:

QARD - Section 4.0, Paragraph 4.2.2B, states: "A review of the procurement documents and any changes thereto shall be made to verify that documents include appropriate provisions to ensure that items and services will meet the governing requirements."

MCP - Section 3.1, establishes responsibilities for PR/PO approvals.

MCP - Section 3.6.3C, states: "QE shall review revisions to specifications for impact on Q-List items covered by Continuous Use (CU) POs and shall notify the PRM when these specification revisions require changes to the CU contracts."

6 Description of Condition:

Contrary to the above cited requirements, the Purchase Requisition (PR) PR A02910 release for Purchase Order 1848-8015 for channels was only initialed by the Construction Manager. The other required initials were not obtained. This is a Continuing Order Purchase Order 1848-CU-012. Originally, the PR was designated as Non-Q and the Request for Proposal and PO were not reviewed by the technical and QA reviewers. However, the specification changed and there is no evidence that QE notified the PRM for changes to the CU contract.

7 Initiator Donald J. Harris
Donald J. Harris Date 12-21-95

8 QA Review
QAR Donald J. Harris Date 12-21-95

10 Response Due Date
20 Working Days from Issuance

11 QA Issuance Approval
QAR (PRI)/ACQAM (DRN) Donald J. Harris Date 12-21-95

12 Remedial Actions:

The required approvals of subject non-Q Purchase Request have been obtained. QE has notified procurement of the need to review the existing CU contract due to specification changes. The notification, however, was performed verbally. In the future, QE notifications to procurement will be handled by memo. The QE review did not result in any changes to the CU contract. No further remedial action is required.

13 Remedial Action Response By: [Signature] Date 1/23/96

14 Remedial Action Due Date
COMPLETED Date

15 Remedial Action Response Acceptance
QAR [Signature] Date 1/31/96

16 PR Verification/Closure
QAR Date

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QA: L

PERFORMANCE/DEFICIENCY REPORT

1 Controlling Document:
Quality Assurance Requirements and Description (QARD), DOE/RW-0333P, Rev. 52 Related Report No.
YM-ARC-96-033 Responsible Organization:
Kiewit/Parsons Brinckerhoff (Kiewit/PB)4 Discussed With:
Jon Christensen

5 Requirement/Measurement Criteria:

QARD, Section 5.0, Paragraph 5.2.2, states in part:

"Implementing documents shall include the following information as appropriate to the work to be performed:

- A. Responsibilities and organizational interfaces of the organizations affected by the document.
- B. A sequential description of the work to be performed including controls for altering the sequence of required inspections, tests, and other operations."

QARD, Section 2.0, Paragraph 2.2.10, states in part:

"Implementing documents and documents that specify technical or quality requirements shall be reviewed to the following requirements:

- A. Review criteria shall be established before performing the review.

(Contd. on Page ² 5)

RBC 12-21-95

6 Description of Condition:

Contrary to the above, MCP-2.0, Revision 13 does not:

1. Adequately define the responsibilities of the Construction Manager or Quality Control Manager and the sequential description of the work to be performed as it relates to the initiation and preparation of the Work Package.
2. Define the interface between MCP-2.0 and MCP 10.0 as it relates to the Work Package. MCP-10.0, Revision 9, Section 3.2.2, identifies how inspection hold and witness points are identified in the Work Package and Section 3.2.1 establishes requirements/guidance on Work Package content and review criteria.
3. Adequately define the process or address QARD, Section 2.0, Paragraph 2.2.10, requirements for the review, approval, and revision of the Work Process Description (WPD).
4. Adequately define what is considered a revision to the Work Package as addressed by Section 3.2.4 and when ES&H, Construction, and QC review is required. Revisions to Travelers and WPDs are not being documented in accordance with 3.2.4.

(contd. on Page ² 5)

RBC 12-21-95

7 Initiator *Mary G. McDaniel*
Mary G. McDaniel

Date 12-21-95

9 QA Review

QAR *Mary G. McDaniel* Date 12-21-95

10 Response Due Date

20 Working Days from Issuance

11 QA Issuance Approval
QAR (PR) / QOQM (DR) *Mary G. McDaniel* Date 12-21-95

12 Remedial Actions:

SEE PAGE 3

13 Remedial Action Response By:

J. Christensen 1/23/96
Date

14 Remedial Action Due Date

FEB 29, 1996 Date

15 Remedial Action Response Acceptance

QAR *Mary G. McDaniel* Date 1/31/96

16 PR Verification/Closure

QAR Date

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Block 5 continued

C. The review shall be performed by individuals other than the preparer.

E. The scope of the review shall consider all aspects of the document.

1. Each organization or technical discipline affected by the document shall review the document according to the established review criteria. Changes to the document..."

QARD, Section 17.0, Paragraph 17.2.2.A, states: "Implementing documents shall:

1. Identify those documents that will become QA Records."

Block 6 continued

5. The generation of records by the WPD is not addressed. WPD 2.20.3, Revision 4, "TBM Excavation - North Ramp," controls the generation of records that provide objective evidence for TCP-2.3.

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Block 12 - Remedial Actions - Continued

- 1&2 The roles of the CM and QCM shall be clarified in MCP-2.0. The work package requirements addressed in MCP-10.0 will be incorporated into MCP-2.0 and reference to MCP-10.0 will be deleted. MCP-10.0 will also be reviewed and revised to incorporate any required changes.
- 3.&4 MCP-2.0 will be revised to require Construction, QC and ES&H review of initial issuance and all revisions of Work Packages. New Work Package Review Checklists will be prepared for any revisions made to the WPD, Traveler or Supplemental Travelers and will be signed by the CM, QCM, and ES&H Manager. The Master Approval Sheet has also been revised to indicate the signature requirements for ES&H. WPDs will not be approved other than through the checklist and MAS.
- MCP-2.0 will be revised to enforce the above review process. All past segments will be evaluated to identify missed revisions and will be reviewed in accordance with the above. Training will occur for all applicable personnel to the new procedure.
5. Records should not be generated by the WPD. A review of WPDs will be performed to eliminate any record generation requirement and in those cases where records are not covered by other implementing documents, provisions will be made to incorporate the requirement in the applicable implementing documents of, if required, new implementing documents prepared.