



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

**DEC 21 1995**

Willis L. Clarke  
Technical Project Officer  
For Yucca Mountain Site  
Characterization Project  
Lawrence Livermore National Laboratory  
P.O. Box 5514, L-217  
Livermore, CA 94551

ISSUANCE OF CORRECTIVE ACTION REQUEST (CAR) YMQAD-96-C001 AND DEFICIENCY REPORT (DR) YMQAD-96-D016 THROUGH YMQAD-96-D019 AND PERFORMANCE REPORT (PR) YMQAD-96-P014 THROUGH YMQAD-96-P016 RESULTING FROM OFFICE OF QUALITY ASSURANCE (OQA) SUPPLIER AUDIT OQA-SA-96-007 OF METAL SAMPLES, INC., WHICH IS A SUBSIDIARY OF ALABAMA SPECIALTY PRODUCTS, INC. (SCPB: N/A)

Enclosed are CAR YMQAD-96-C001 and DRs YMQAD-96-D016 through YMQAD-96-D019 and PRs YMQAD-96-P014 through YMQAD-96-P016 generated as a result of OQA Supplier Audit OQA-SA-96-007. Your action is to forward these to Metal Samples, Inc. Their action is deemed as follows:

Please identify the corrective actions to be taken and implemented to correct the deficiencies. A CAR Continuation Sheet and PR/DR Continuation Pages have been provided. Send the originals of your responses directly to Deborah Sult, MQAD/QATSS, 101 Convention Center Drive, Suite 640, Las Vegas, Nevada 89109. Responses to the CARs are due 20 working days after the date of this letter. Extensions to due dates must be requested in writing, with appropriate justification, prior to the due dates.

270060

YMP-5

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PDR WASTE  
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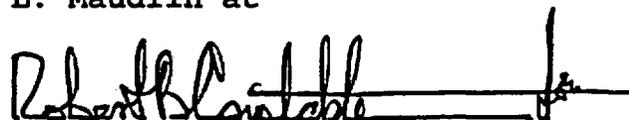
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DEC 21 1995

Willis L. Clarke

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If you have any questions, please contact either Robert B. Constable at (702) 794-7945 or Richard L. Maudlin at (702) 794-7290.



Richard E. Spence, Director  
Yucca Mountain Quality Assurance Division

YMQAD:RBC-801

Enclosures:

1. CAR YMQAD-96-C001
2. DRs YMQAD-96-D016  
through YMQAD-96-D019
3. PRs YMQAD-96-P014  
through YMQAD-96-P016
4. CAR Continuation Sheet
5. PR/DR Continuation Pages

cc w/encl:

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

cc w/o encl:

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

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

B  
CAR NO. YMQAD-96-C001  
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QA: L

CORRECTIVE ACTION REQUEST

1 Controlling Document: POP-002, Revision: New, OCRWM QARD, Revision 5  
2 Related Report No.: OQA-SA-96-007

3 Responsible Organization: Alabama Specialty Products, Inc. (Metal Samples Co.)  
4 Discussed With: Rick Douglas, Kirk Johnson

5 Requirement:  
POP-002, Paragraph 3.1, states in part: "...before adding any supplier to our approved vendor/subcontractor list and/or ordering any material or product, purchasing checks the suppliers reputation and references.... Continuous quality and performance monitoring of suppliers is also an important element of supplier assessment."  
OCRWM QARD, Section 7.0, Subsection 7.2.2(c) states: "Measures for evaluating and selecting procurement sources shall include one or more of the following elements: (1) Evaluation of the supplier's history for providing an identical or similar product which performs satisfactorily in actual use; (2) Evaluation of supplier's current QA records supported by any documented qualitative and

6 Description of Condition:  
Contrary to the above, there was no documented evidence that the suppliers (Castle, Haines International) for LLNL material purchased on Alabama Specialty Products, Inc., Purchase Orders #23563-00, 23501-00, and 23587-00 had been evaluated and found acceptable to provide the material ordered.  
In addition, the calibration services of Certified Measurements, Inc., Alabama Specialty Products, Inc., Purchase Order 23753-00, had been procured to calibrate standards used by Metal Samples Co. to calibrate their internal instruments. No evidence could be provided to indicate that the calibration vendor had been evaluated and found acceptable to provide calibration services.

7 Initiator: *Richard L. Maudlin*  
Richard L. Maudlin Date 12/13/95  
8. Does a stop work condition exist?  
Yes \_\_\_ No  ; If Yes, Attach copy of SWO  
If Yes, Check One: A  B  C

10. Recommended Actions:
- A. Determine the status of all material ordered by LLNL.
  - B. Evaluate and determine the impact on shipped material to LLNL based on a potential lack of vendor qualification. Evaluate the status of all suppliers on the Metal Samples approved suppliers list.
  - C. Determine what action is necessary to accept shipped material to LLNL. Document these actions.
  - D. Investigate and determine the cause, then identify and document all action to preclude recurrence.

11 QA Review: *Richard L. Maudlin* Date 12/18/95  
12 Response Due Date: 20 working days from issuance

13 Affected Organization QA Manager Issuance Approval:  
Printed Name ROBERT B CONSTABLE Signature *Robert B Constable* Date 12-20-95

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U.S. DEPARTMENT OF ENERGY  
WASHINGTON, D.C.**

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 Stop Work Order

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quantitative information; (3) Evaluation of the supplier's technical and quality capability based on an evaluation of supplier's facilities, personnel, and QA program implementation."

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 **Stop Work Order**

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QA: L

**PERFORMANCE/DEFICIENCY REPORT**

1 Controlling Document: QA Manual, Revision: New, QOP-001, Revision: New 2 Related Report No. OQA-SA-96-007

3 Responsible Organization: Alabama Specialty Products, Inc. (Metal Samples Co.) 4 Discussed With: Rick Douglas, Kirk Johnson

5 Requirement/Measurement Criteria:  
QA Manual, Section 4.1.5, states in part: "Our company's executive management reviews the QA system at least once per year. The purpose of these reviews is to access the effectiveness and continuing suitability of the QA System to assure the highest level of quality in our products and services as well as compliance."  
  
QOP-001, Paragraph 2.1, states in part: "However, for the first two years following initial implementation...management reviews will be conducted twice per year..." Paragraph 5.1, states in part: "Minutes of the review meetings are taken by our management representatives."

6 Description of Condition:  
  
Contrary to the above, there is no objective evidence that management reviews have ever been performed since issuance of the QA Manual and Operating Procedures in May 1994.

7 Initiator *Richard L. Maudlin* Date 12/12/95 8 QA Review QAR *Richard L. Maudlin* Date 12/18/95

10 Response Due Date 20 Working Days From Issuance 11 QA Issuance Approval QAR (PR)/AQQAM (DR) *Richard L. Maudlin* Date 12-20-95

12 Remedial Actions:

13 Remedial Action Response By: Date 14 Remedial Action Due Date Date

15 Remedial Action Response Acceptance QAR Date 16 PR Verification/Closure QAR Date

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**DEFICIENCY REPORT**

**17 Recommended Actions:**

Take the necessary action to implement the requirement of QOP-001. Take the necessary steps to evaluate any impact on quality in not performing management reviews, determine the root cause and action to preclude recurrence.

**18 Investigative Actions:**

**19 Root Cause Determination:**

**20 Action to Preclude Recurrence:**

**21 Response by:**

Date

**22 Corrective Action Completion Due Date:**

**23 Response Accepted**

QAR

Date

**24 Response Accepted**

AQQAMM

Date

**25 Amended Response Accepted**

QAR

Date

**26 Amended Response Accepted**

AQQAMM

Date

**27 Corrective Actions Verified**

QAR

Date

**28 Closure Approved by:**

AQQAMM

Date

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**PERFORMANCE/DEFICIENCY REPORT**

1 Controlling Document:  
AOP-001, Revision: New

2 Related Report No.  
OQA-SA-96-007

3 Responsible Organization:  
Alabama Specialty Products, Inc. (Metal Samples Co.)

4 Discussed With:  
Rick Douglas, Roger Borchard, Kirk Johnson

5 Requirement/Measurement Criteria:

AOP-001, Paragraph 3.1, states in part: "Our administrative/personnel manager provides employees orientation training to all new employees. Also, at the time of implementation of this procedure, all existing employees received this training... Our orientation training is comprised of the following topics: ...presentation of our documented quality system... Participation in the employee orientation training is mandatory and is recorded."

6 Description of Condition:

Contrary to the above, no documented evidence could be provided that two of three individuals evaluated had received training on Alabama Specialty Products Quality System.

7 Initiator *R. Maudlin*  
Richard L. Maudlin Date 12/13/95

8 QA Review  
QAR *R. Maudlin* Date 12/18/95

10 Response Due Date  
20 Working Days from Issuance

11 QA Issuance Approval  
QAR (PR)/AQQAM (DR) *Robert D. Sutcliffe* Date 12.20.95

12 Remedial Actions:

13 Remedial Action Response By:  
P Date

14 Remedial Action Due Date  
Date

15 Remedial Action Response Acceptance  
QAR Date

16 PR Verification/Closure  
QAR Date

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**DEFICIENCY REPORT**

**17 Recommended Actions:**

Review all employee training files. Establish baseline training requirements and train all personnel accordingly. Investigate and determine impact on quality due to lack of training. Identify the cause and actions taken to preclude recurrence.

**18 Investigative Actions:**

**19 Root Cause Determination:**

**20 Action to Preclude Recurrence:**

**21 Response by:**

Date

**22 Corrective Action Completion Due Date:**

**23 Response Accepted**

QAR

Date

**24 Response Accepted**

AOQAMM

Date

**25 Amended Response Accepted**

QAR

Date

**26 Amended Response Accepted**

AOQAMM

Date

**27 Corrective Actions Verified**

QAR

Date

**28 Closure Approved by:**

AOQAMM

Date

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QA: L

**PERFORMANCE/DEFICIENCY REPORT**

1 Controlling Document: QOP-008, Revision: New  
2 Related Report No. OQA-SA-96-007

3 Responsible Organization: Alabama Specialty Products, Inc. (Metal Samples Co.)  
4 Discussed With: Rick Douglas, Kirk Douglas

5 Requirement/Measurement Criteria:  
QOP-008, Paragraph 3.1, states in part: "Whenever a nonconformity is identified, it is documented on an anomaly report... The third section of the form is where the cognizant manufacturing supervisor/foreman identifies...how to preclude similar nonconformities in the future."

6 Description of Condition:  
Contrary to the above, two work orders (WO) (WO# 112356-99 and 112282-99) identified nonconforming conditions; however, no objective evidence in the form of Anomaly Reports could be provided which addressed the nonconforming conditions noted in the two work orders.  
Also, Anomaly Report for Job No. 110018-97 did not identify actions to preclude future nonconformities.

7 Initiator: *Richard L. Maudlin* Date: 12/12/95  
9 QA Review: *Richard L. Maudlin* Date: 12/18/95  
10 Response Due Date: 20 Working Days from Issuance  
11 QA Issuance Approval: *Robert B. Constable* Date: 12-20-95

12 Remedial Actions:

13 Remedial Action Response By: \_\_\_\_\_ Date: \_\_\_\_\_  
14 Remedial Action Due Date: \_\_\_\_\_ Date: \_\_\_\_\_  
15 Remedial Action Response Acceptance: \_\_\_\_\_ Date: \_\_\_\_\_  
16 PR Verification/Closure: \_\_\_\_\_ Date: \_\_\_\_\_

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**DEFICIENCY REPORT**

**17 Recommended Actions:**

Perform an investigation to determine the impact on quality due to not documenting nonconformities on Anomaly Reports. Identify the cause and action taken to preclude recurrence.

**18 Investigative Actions:**

**19 Root Cause Determination:**

**20 Action to Preclude Recurrence:**

**21 Response by:**

Date

**22 Corrective Action Completion Due Date:**

**23 Response Accepted**

QAR

Date

**24 Response Accepted**

AOQAMM

Date

**25 Amended Response Accepted**

QAR

Date

**26 Amended Response Accepted**

AOQAMM

Date

**27 Corrective Actions Verified**

QAR

Date

**28 Closure Approved by:**

AOQAMM

Date

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**PERFORMANCE/DEFICIENCY REPORT**

1 Controlling Document:  
QOP-011, Revision: New

2 Related Report No.  
OQA-SA-96-007

3 Responsible Organization:  
Alabama Specialty Products, Inc. (Metal Samples Co.)

4 Discussed With:  
Rick Douglas, Kirk Johnson

5 Requirement/Measurement Criteria:

QOP-011, Paragraph 2.1, states in part: "The compliance director is responsible for planning and scheduling internal quality audits. Each main activity comprising the quality system is audited at least once per year..."

6 Description of Condition:

Contrary to the above, there is no objective evidence that internal audits have been performed since issuance of the QA manual and Operating Procedures in May 1994. There is no evidence to support implementation of QOP-011.

7 Initiator *R. Maudlin*  
Richard L. Maudlin Date 12/12/95

8 QA Review  
QAR *R. Maudlin* Date 12/18/95

10 Response Due Date  
20 Working Days from Issuance

11 QA Issuance Approval  
QAR (PR)/AQAM (DR) *Robert Bluntella for* Date 12.20.95

12 Remedial Actions:

13 Remedial Action Response By: Date

14 Remedial Action Due Date Date

15 Remedial Action Response Acceptance  
QAR Date

16 PR Verification/Closure  
QAR Date

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**DEFICIENCY REPORT**

**17 Recommended Actions:**

Immediately develop a schedule of planned audits as required by QOP-011. Take necessary measures to implement the schedule. Investigate the basis why audits were not scheduled and performed, identify the cause and action(s) taken to preclude recurrence. Also identify the impact on quality of the product(s) in the absence of audits.

**18 Investigative Actions:**

**19 Root Cause Determination:**

**20 Action to Preclude Recurrence:**

**21 Response by:**

Date

**22 Corrective Action Completion Due Date:**

**23 Response Accepted**

QAR

Date

**24 Response Accepted**

AQQAMM

Date

**25 Amended Response Accepted**

QAR

Date

**26 Amended Response Accepted**

AQQAMM

Date

**27 Corrective Actions Verified**

QAR

Date

**28 Closure Approved by:**

AQQAMM

Date

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**PERFORMANCE/DEFICIENCY REPORT**

1 Controlling Document: QOP-003, Revision: New, QOP-005, Revision: New  
2 Related Report No. OQA-SA-96-007

3 Responsible Organization: Alabama Specialty Products, Inc. (Metal Samples Co.)  
4 Discussed With: Rick Douglas, Kirk Johnson

5 Requirement/Measurement Criteria:  
  
QOP-003, Paragraph 3.3, states in part: "If the items are standard catalog items that need not be subjected to a second stage inspection, the items are labeled with green Accepted stickers or tags." Paragraph 3.4, states in part: "If items are custom orders...items are labeled with yellow Hold for Quality...."  
  
QOP-005, Paragraph 3.2, states in part: "When our products have passed all the reviews inspections and tests, they are labeled with green Accepted stickers or tags..."

6 Description of Condition:  
  
Contrary to the above:  
  
A. Material L241 was a special purchased item; however, item was found released to production with no green or yellow tag attached.  
  
B. Final inspected products for Work Order 112282-99 did not have a green accept sticker or tag with material.  
  
NOTE: Inspection status noted on Work Order.

7 Initiator: *Richard L. Maudlin*  
Richard L. Maudlin Date 12/12/95  
8 QA Review  
QAR *Richard L. Maudlin* Date 12/15/95

10 Response Due Date  
20 Working Days from Issuance  
11 QA Issuance Approval  
QAR (PR)/AQQAM (DR) *Richard L. Maudlin* Date 12/15/95

12 Remedial Actions:

13 Remedial Action Response By: Date  
14 Remedial Action Due Date Date

15 Remedial Action Response Acceptance Date  
16 PR Verification/Closure Date  
QAR Date

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**PERFORMANCE/DEFICIENCY REPORT**

1 Controlling Document: QOP-007, Revision: New, QA Manual, Revision: New	2 Related Report No. OQA-SA-96-007
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3 Responsible Organization: Alabama Specialty Products, Inc. (Metal Samples Co.)	4 Discussed With: Rick Douglas, Kirk Johnson
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5 Requirement/Measurement Criteria:

QOP-007, Paragraph 3.1, states in part: "...calibration is performed in an environment that is controlled to be within a temperature range of 65 F to 75 F and a relative humidity range of 45% to 70%."

QA Manual, Section 4.2, states in part: "Alabama Specialty Products, Inc., has implemented a documented QA system that ensure the compliance of our products and services to all contractually specified requirements and the requirements of ISO. 9000..."

6 Description of Condition:

Contrary to the above:

A. There was no instrumentation in the calibration laboratory to monitor the status of temperature and humidity. Also, instrument that was previously used was never calibrated.

B. There are no documented calibration procedures which identify acceptance tolerances for Metal Samples Co. instruments.

NOTE: Instruments in calibration program are mostly calipers and micrometers.

7 Initiator <i>Richard L. Maudlin</i> Richard L. Maudlin Date 12/12/95	8 QA Review QAR <i>Richard L. Maudlin</i> Date 12/15/95
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10 Response Due Date 20 Working Days from Issuance	11 QA Issuance Approval QAR (PR)/AQAM (DR) <i>Richard L. Maudlin</i> Date 12/15/95
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12 Remedial Actions:

13 Remedial Action Response By: Date	14 Remedial Action Due Date Date
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15 Remedial Action Response Acceptance QAR Date	16 PR Verification/Closure QAR Date
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PERFORMANCE/DEFICIENCY REPORT

1 Controlling Document: QA Manual, Revision: New, OCRWM QARD, Revision 5  
2 Related Report No. OQA-SA-96-007

3 Responsible Organization: Alabama Speciality Products, Inc. (Metal Samples Co.)  
4 Discussed With: Rick Douglas, Kirk Johnson

5 Requirement/Measurement Criteria:  
QA Manual Section 4.2, States in part: "Alabama Specialty Products, Inc., has implemented a documented QA system that ensures the compliance of our products and services to all contractually specified requirements and the requirements of ISO 9000...."  
OCRWM QARD, Section 17.0, Subsection 17.2.11(a), states in part: "QA records shall be temporarily stored in a container or facility with a fire rating of 1 hour or dual storage shall be provided."

6 Description of Condition:  
Contrary to the above, records are not being stored in a temporary container or facility with a 1 hour fire rating. Records are not being maintained in dual storage.  
NOTE: Storage of manufacturers CMTRs were reviewed.

7 Initiator: *Richard L. Maudlin*  
Richard L. Maudlin Date 12/12/95  
9 QA Review  
QAR *Richard L. Maudlin* Date 12/15/95

10 Response Due Date: 20 Working Days from Issuance  
11 QA Issuance Approval  
QAR (PR)/AQQAM (DR) *Richard L. Maudlin* Date 12/15/95

12 Remedial Actions:

13 Remedial Action Response By: Date  
14 Remedial Action Due Date Date

15 Remedial Action Response Acceptance: QAR Date  
16 PR Verification/Closure: QAR Date

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