

SAFETY INSPECTION REPORT AND COMPLIANCE INSPECTION

1. LICENSEE/LOCATION INSPECTED: 3M Company, 3M Corporate Health Physics 3M Center, Building 220-6W-06, P.O. Box 33283 St. Paul, MN 55133-3283 Location Inspected: Brookings, South Dakota REPORT NUMBER(S) 2016002		2. NRC/REGIONAL OFFICE Region III U. S. Nuclear Regulatory Commission 2443 Warrenville Road, Suite 210 Lisle, IL 60532-4352	
3. DOCKET NUMBER(S) 030-14999	4. LICENSE NUMBER(S) 22-00057-61	5. DATE(S) OF INSPECTION 10/31/16 - 11/3/16	

LICENSEE:

The inspection was an examination of the activities conducted under your license as they relate to radiation safety and to compliance with the Nuclear Regulatory Commission (NRC) rules and regulations and the conditions of your license. The inspection consisted of selective examinations of procedures and representative records, interviews with personnel, and observations by the inspector. The inspection findings are as follows:

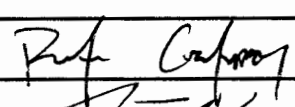
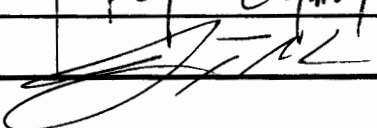
- 1. Based on the inspection findings, no violations were identified.
- 2. Previous violation(s) closed.
- 3. The violation(s), specifically described to you by the inspector as non-cited violations, are not being cited because they were self-identified, non-repetitive, and corrective action was or is being taken, and the remaining criteria in the NRC Enforcement Policy, to exercise discretion, were satisfied.

_____ Non-cited violation(s) were discussed involving the following requirement(s):

- 4. During this inspection, certain of your activities, as described below and/or attached, were in violation of NRC requirements and are being cited in accordance with NRC Enforcement Policy. This form is a NOTICE OF VIOLATION, which may be subject to posting in accordance with 10 CFR 19.11.
(Violations and Corrective Actions)

Statement of Corrective Actions

I hereby state that, within 30 days, the actions described by me to the Inspector will be taken to correct the violations identified. This statement of corrective actions is made in accordance with the requirements of 10 CFR 2.201 (corrective steps already taken, corrective steps which will be taken, date when full compliance will be achieved). I understand that no further written response to NRC will be required, unless specifically requested.

TITLE	PRINTED NAME	SIGNATURE	DATE
LICENSEE'S REPRESENTATIVE			
NRC INSPECTOR	Ryan Craffey		11/3/16
BRANCH CHIEF	Aaron McCraw		11/8/16

Docket File Information

SAFETY INSPECTION REPORT AND COMPLIANCE INSPECTION

1. LICENSEE/LOCATION INSPECTED: 3M Company, 3M Corporate Health Physics 3M Center, Building 220-6W-06, P.O. Box 33283 St. Paul, MN 55133-3283 Location Inspected: Brookings, South Dakota REPORT NUMBER(S) 2016002	2. NRC/REGIONAL OFFICE Region III U. S. Nuclear Regulatory Commission 2443 Warrenville Road, Suite 210 Lisle, IL 60532-4352
---	---

3. DOCKET NUMBER(S) 030-14999	4. LICENSE NUMBER(S) 22-00057-61	5. DATE(S) OF INSPECTION 10/31/16 - 11/3/16
--------------------------------------	---	--

6. INSPECTION PROCEDURES USED 87122	7. INSPECTION FOCUS AREAS All
--	--------------------------------------

SUPPLEMENTAL INSPECTION INFORMATION

1. PROGRAM CODE(S) 03521	2. PRIORITY 2	3. LICENSEE CONTACT Kostas Kaounas - RSO	4. TELEPHONE NUMBER (605) 696-1234
---------------------------------	----------------------	---	---

Main Office Inspection Next Inspection Date: 10/31/2018

Field Office Inspection 601 22nd Street, Brookings, SD

Temporary Job Site Inspection _____

PROGRAM SCOPE

This was an announced routine inspection of a multinational corporation authorized to operate two wet source storage panoramic irradiators (known by their equipment designations, S-8 and S-10) at its Medical Products Division in Brookings, South Dakota. The licensee used the irradiators to sterilize products made at this and other 3M facilities. Occasionally, the licensee irradiated samples from internal and external sources using a research loop (S-11) integrated into S-10. The licensee irradiated greater than small quantities of flammable materials as authorized by its license in both irradiators. At the time of the inspection, the licensee employed approximately 1,000 staff at this facility. Over a dozen of these employees were trained irradiator operators. The licensee staffed both irradiators for 24-hour operation. The licensee's RSO and two assistants oversaw the day-to-day operations of the irradiators. The licensee also had one additional assistant RSO in training at the time of the inspection. Corporate radiation safety staff provided formal training for operators and survey instrument calibrations at the licensee's headquarters in St. Paul, Minnesota, and performed on-site audits of this radiation safety program quarterly.

PERFORMANCE OBSERVATIONS: The inspector toured the licensee's facility in Brookings, and observed the routine operation of the S-10 and S-11 units. The inspector discussed with the on-duty operators their roles and responsibilities, including expected response to a variety of alarms. The inspector also observed source reloading activities at both the S-8 and S-10 units, including cask receipt, handling, and unloading, source manipulation activities performed by MDS Nordion personnel, the replacement of a source rack hoist at S-10, as well as safety system testing and area surveys conducted prior to resuming operations at both units. The inspector conducted independent surveys during normal operations and during all phases of the source exchange activities, and found no exposures to members of the public in excess regulatory limits. The inspector determined through interviews that the individuals involved in these operations were knowledgeable of radiation protection principles, licensee procedures, and regulatory requirements, and moreover found that they implemented satisfactory ALARA practices throughout. The inspector also reviewed a selection of records, including operator training and performance evaluations, preventative maintenance checks of safety equipment, source receipt and tracking documents, personnel dosimetry, survey meter calibrations, water quality and contamination analyses, and quarterly safety audits.

No violations of NRC requirements were identified as a result of this inspection.