

CRUCIBLE STEEL CASTING COMPANY

A DIVISION OF CONSOLIDATED FOUNDRIES AND MFG. CORP.

ALMIRA AVENUE AND WEST 84TH STREET

CLEVELAND, OHIO 44102

Title: Quality Assurance Program (U.S.N.R.C. 10CFR Part 71), Rev. 1

Reference: U.S.N.R.C. Material License Number 34,04657-02
Issue Date June 23, 1977
Expiration Date June 30, 1982

1.0 Scope

- 1.1 The following system describes the Quality Assurance Program employed by Crucible Steel Casting Company for the packaging of radioactive seal source material for the purpose of transportation.

2.0 Organization

- 2.1 The final responsibility for the Quality Assurance Program for the 10CFR Part 71 requirements rests with Crucible Steel Casting Company. (Note: See Attachment No. 1, "Organization Chart.")
- 2.2 The Radiation Protection Officer is responsible for the overall administration of the program, training and certification, and document control.
- 2.3 The Radiation Safety Officer is responsible for the handling, storing, shipping inspection, test, operating status and record keeping.

3.0 Quality Assurance Program

- 3.1 The management of Crucible Steel Casting Company establishes and implements this Quality Assurance Program. Training and/or instructions for all quality assurance functions, prior to engagement in these functions, is required.
 - 3.1.1 Training and/or instructions will be provided for proper use of the package (source changer) container as per the manufacturer's operating instructions. When and where manufacturer's operating instructions do not exist, they will be written by Crucible.
- 3.2 The Radiation Protection Officer shall assure that all radioactive material shipping packages are designed and manufactured under a Quality Assurance Program approved by the Nuclear Regulatory Commission for all packages designed or fabricated after July 1, 1978. This requirement shall be considered satisfied by receiving a certification to the effect from the manufacturer.

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Quality Assurance Program

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4.0 Document Control

- 4.1 All documents related to this program will be controlled, prepared, and maintained by the Radiation Protection Officer.
- 4.2 All revisions to this program or related procedure, and documents which form a part of this program shall be approved by the Radiation Protection officer.
- 4.3 The Radiation Protection Officer shall insure that all quality assurance functions are conducted in accordance with the latest applicable changes to regulations, quality assurance program, and supporting procedures.

5.0 Handling, Storage and Shipping

- 5.1 Written safety procedures concerning the handling, storage, receiving and shipping of package container (source changer) for special form radioactive material will be followed. Shipments will not be made unless all test, certifications of acceptance, and final inspections have been completed.
- 5.2 Critical handling, storage and shipping operations shall be handled by radiographic personnel only.

6.0 Quality Assurance Records

- 6.1 Records of package approvals, inspection, test, audit results, personnel training and qualification, receiving and shipping records, description of equipment and written procedures will be maintained.

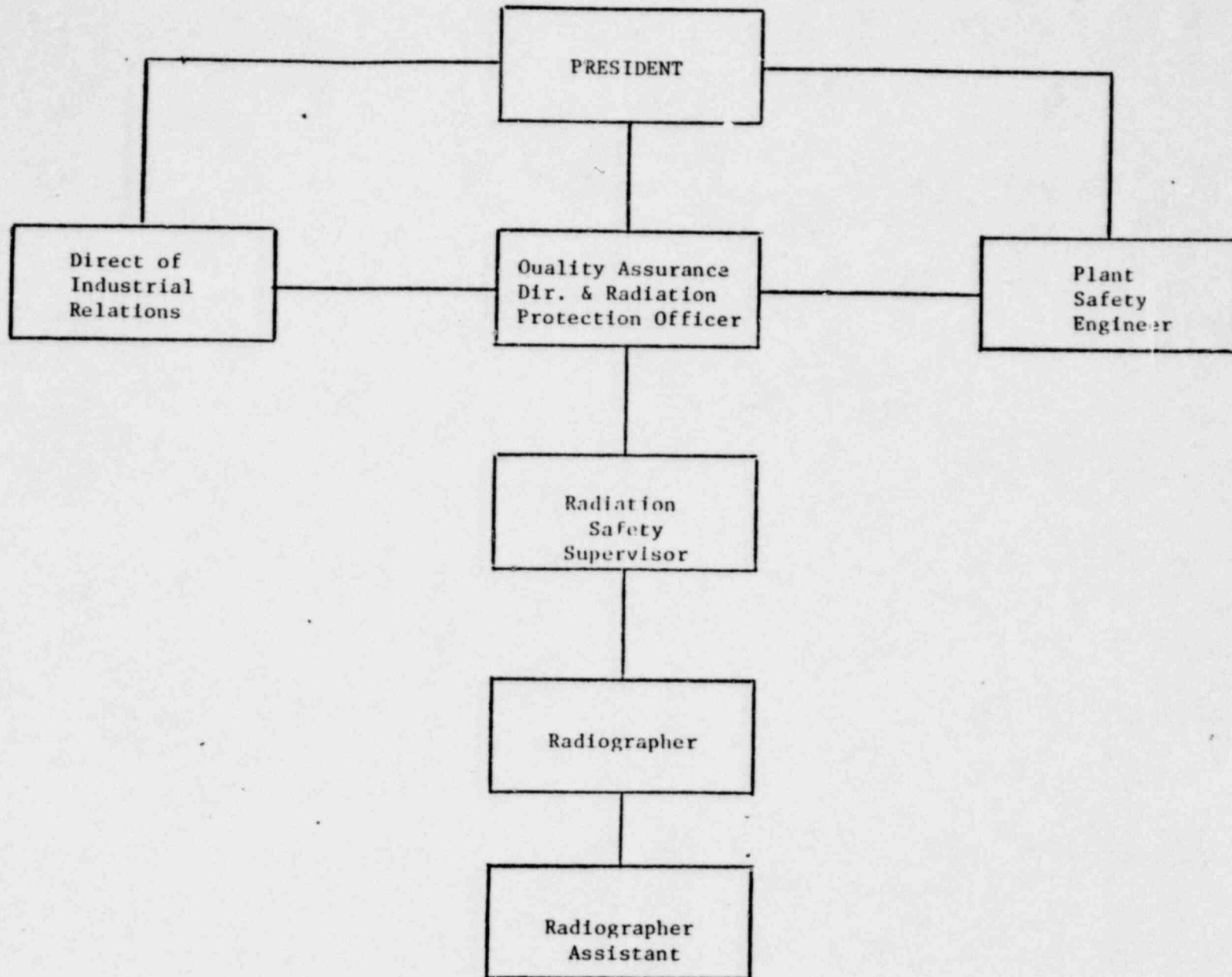
7.0 Audits

- 7.1 Audits of the Quality Assurance Program will be performed using written check list. The frequency of audits will be as necessary to insure that the requirements of the Quality Assurance Program and associated procedures are being met, but shall be conducted at least once each year.
 - 7.1.2 Members of the audit team shall have no responsibility in the activity being audited.

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RADIOGRAPHIC DEPARTMENT
ORGANIZATION CHART

AUGUST 8, 1978



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