

POOR ORIGINAL

QUALITY ASSURANCE PROGRAM
OF

Cleveland X-Ray Inspection, Inc.
(Name of Licensee)

35-15205-01
(License Number)

FOR COMPLIANCE WITH 10 CFR PART 71, APPENDIX E

1. Organization

The final responsibility for the Quality Assurance (QA) Program for Part 71 Requirements rests with Cleveland X-Ray Inspection, Inc.
(Name of Licensee)

Design and Fabrication shall not be conducted under this QA Program. The QA Program is implemented as shown on the attached organization chart.

The Radiation Safety Officer is responsible for overall administration of the program, training and certification, document control, and auditing.

The Radiographers are responsible for handling, storing, shipping, inspection, test and operating status and record keeping.

2. Quality Assurance Program

The management of Fayette D. Currie of Cleveland X-Ray Inspection
(Licensee Name)

establishes and implements this QA Program. Training, prior to engagement, for all QA functions is required according to written procedures. QA Program revisions will be made according to written procedures with management approval. The QA Program will ensure that all defined QA procedures, engineering procedures, and specific provisions of the package design approval are satisfied. The QA Program will emphasize control of the characteristics of the package which are critical to safety.

The Radiation Safety Officer shall assure that all radioactive material shipping packages are designed and manufactured under a QA Program approved by Nuclear Regulatory Commission for all packages designed or fabricated after July 1, 1978. This requirement can be satisfied by receiving a certification to this effect from the manufacturer.

3. Document Control

All documents related to a specific shipping package will be controlled through the use of written procedures. All document changes will be performed according to written procedures approved by management.

The Radiation Safety Officer shall insure that all QA functions are conducted in accordance with the latest applicable changes to these documents.

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4. Handling Storage and Shipping

Written safety procedures concerning the handling, storage and shipping of packages for certain special form radioactive material will be followed. Shipments will not be made unless all tests, certifications, acceptances, and final inspections have been completed. Work instructions will be provided for handling, storage, and shipping operations.

Radiography personnel shall perform the critical handling, storage and shipping operations.

5. Inspection, Test and Operating Status

Inspect test and operating status of packages for certain special form radioactive material will be indicated and controlled by written procedures. Status will be indicated by tag, label, marking or log entry. Status of nonconforming parts or packages will be positively maintained by written procedures.

Radiography personnel shall perform the regulatory required inspections and tests in accordance with written procedures. The Radiation Safety Officer shall ensure that these functions are performed.

6. Quality Assurance Records

Records of package approvals (including references and drawings), procurement, inspections, tests, operating logs, audit results, personnel training and qualifications and records of shipments will be maintained. Descriptions of equipment and written procedures will also be maintained.

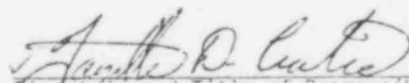
These records will be maintained in accordance with written procedures. The records will be identifiable and retrievable. A list of these records, with their storage locations, will be maintained by the Radiation Safety Officer.

7. Audits

Established schedules of audits of the QA Program will be performed using written check lists. Results of audits will be maintained and reported to management. Audit reports will be evaluated and deficient areas corrected. The audits will be dependent on the safety significance of the activity being audited, but each activity will be audited at least once per year. Audit reports will be maintained as part of the quality assurance records. Members of the audit team shall have no responsibility in the activity being audited.

July 2, 1979

Date



Signature and Title of Responsible
Licensee Official

Fayette D. Curtis, President
Printed Name and Title of Responsible
Licensee Official

909 West Osage

Cleveland, Oklahoma 74020
Licensee Address

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QUALITY ASSURANCE PROGRAM ORGANIZATION CHART FOR

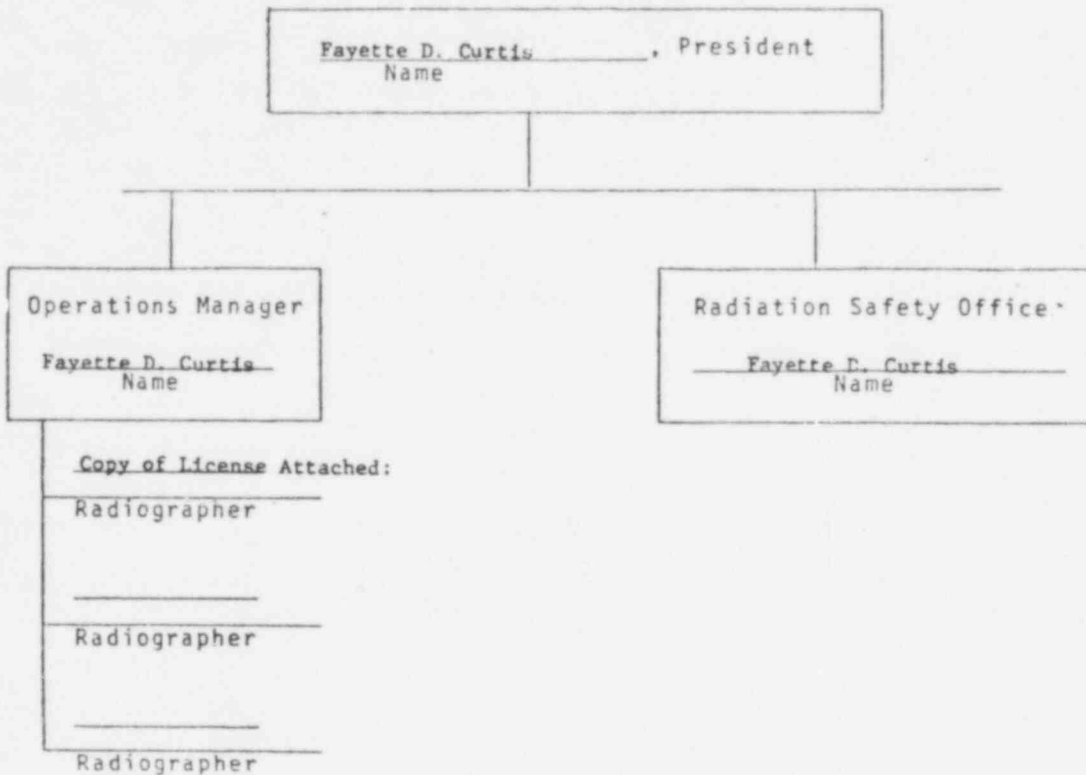
Cleveland X-Ray Inspection, Inc.
(Name of Licensee)

35-15205-01
(License Number)

FOR

COMPLIANCE WITH 10 CFR PART 71, APPENDIX E

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DESCRIPTION OF RESPONSIBILITY

1. President - General management of the company.
2. Operations Manager - Responsible for operations control of the company, supervision of employees, cost control, job assignments, personnel relations, training.
3. Radiation Safety Officer - Responsible for overall administration of the radiation safety program (including Quality Assurance), personnel radiation safety training and certification, document control, and auditing of the radiation safety program.
4. Radiographers - Responsible for using, storing, shipping, inspection, testing, operating status, and record keeping of radioisotope sources and devices in accord with written procedures of the company as approved by the Operations Manager and Radiation Safety Officer.

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**U. S. NUCLEAR REGULATORY COMMISSION
MATERIALS LICENSE**

Pursuant to the Atomic Energy Act of 1954, as amended, the Energy Reorganization Act of 1974 (Public Law 93-438) and Title 10, Code of Federal Regulations Chapter 1, Parts 30, 31, 32, 33, 34, 35, 36, 40 and 70, and in reliance on statements and representations heretofore made by the licensee, a license is hereby issued authorizing the licensee to receive, acquire, possess, and transfer byproduct, source, and special nuclear material designated below; to use such material for the purpose(s) and at the place(s) designated below; to deliver or transfer such material to persons authorized to receive it in accordance with the regulations of the applicable Part(s); and to import such byproduct and source material. This license shall be deemed to contain the conditions specified in Section 183 of the Atomic Energy Act of 1954, as amended, and is subject to all applicable rules, regulations and orders of the Nuclear Regulatory Commission now or hereafter in effect and to any conditions specified below.

Licensee Cleveland X-Ray Inspection, Inc. 909 West Osage Cleveland, Okla. 74020		In accordance with application dated September 20, 1977	
		3. License number 35-15205-01 is amended in its entirety to read as follows:	
		4. Expiration date November 30, 1983	
		5. Docket or Reference No	
6. Byproduct, source, and/or special nuclear material	7. Chemical and/or physical form	8. Maximum amount that licensee may possess at any one time under this license	
A. Iridium 192	A. Gulf Nuclear, Inc. Model RG-13 Sealed Sources	A. No single source to exceed 100 curies	
B. Iridium 192	B. Source Production and Equipment Models G-1 and G-3 Sealed Sources	B. No single source to exceed 100 curies	
C. Iridium 192	C. Gamma Industries Model A-1-A Sealed Sources	C. No single source to exceed 35 curies	
D. Iridium 192	D. Gulf Nuclear, Inc. Model RG-13 Sealed Sources	D. No single source to exceed 35 curies	
E. Iridium 192	E. Source Production and Equipment Models G-1 and G-3 Sealed Sources	E. No single source to exceed 100 curies	
F. Iridium 192	F. Source Production and Equipment Model G-23 Sealed Sources	F. No single source to exceed 100 curies	
G. Iridium 192	G. Gulf Nuclear, Inc. Model RPL-5 Sealed Sources	G. No single source to exceed 100 curies	

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MATERIALS LICENSE

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Supplementary Sheet

Continued From Page 1

License Number 35-15205-01

Docket or
Reference No. _____

Amendment No. 07

6. Byproduct, source, and/or
special nuclear material

H. Cesium 137

I. Cesium 137

7. Chemical and/or physical form

H. Technical Operations
Model 72602 Sealed
Sources

I. Gamma Industries
Model VD(HP) Sealed
Sources

8. Maximum amount that licensee
may possess at any one time
under this license

H. No single source to
exceed 100 millicuries

I. No single source to
exceed 225 millicuries

9. Authorized use

- A. For use in Gulf Nuclear, Inc. Model 20V exposure devices for industrial radiography and in Gulf Nuclear, Inc. Model U-110A source changers for storage and replacement of sources.
- B. For use in Source Production and Equipment Model 2-T exposure devices for industrial radiography and in Source Production Equipment Model C-1 source changers for storage and replacement of sources.
- C. For use in Gamma Industries Model 35 exposure devices for industrial radiography and in Gamma Industries Model C-10 source changers for storage and replacement of sources.
- D. For use in Gulf Nuclear, Inc. Model 20V exposure devices for industrial radiography and in Gulf Nuclear Model U-110A source changers for storage and replacement of sources.
- E. For use in Source Product and Equipment Model 2-T exposure devices for industrial radiography and in Source Production and Equipment Model C-1 source changers for storage and replacement of sources.
- F. For use in Source Production and Equipment Model SPEC-Check Model I exposure devices for industrial radiography.
- G. For use in Gulf Nuclear, Inc. Model 10X Pipeliner exposure device for industrial radiography.
- H. For use in Technical Operations Model 726 meter calibration kit for calibration of survey instruments.
- I. For use in Gamma Industries Master Minder Model No. 1 to control the motion of x-ray crawlers within pipelines.

CONDITIONS

- 10. Licensed material may be stored at 909 West Osage, Cleveland, Oklahoma. Licensed material shall be used only at temporary job sites of the licensee anywhere in the United States where the Nuclear Regulatory Commission maintains jurisdiction for regulating the use of licensed material.

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Supplementary Sheet

CONDITIONS

License Number 35-15205-01Docket or
Reference No. _____

Amendment No. 07

(continued)

11. The licensee shall comply with the provisions of Title 10, Chapter 1, Code of Federal Regulations, Part 19, "Notices, Instructions and Reports to Workers; Inspections," Part 20, "Standards for Protection Against Radiation," and Part 34, "Licenses for Radiography and Radiation Safety Requirements for Radiographic Operations."
12. A. Pursuant to Section 34.25, 10 CFR 34, the licensee is authorized to perform tests for leakage or contamination of the sealed sources authorized by this license in accordance with procedures contained in applications dated May 23, 1978 as amended September 28, 1978.
B. Notwithstanding the periodic leak test required by Section 34.25(b), 10 CFR 34, such requirement does not apply to radiography sources that are stored and not being used. The sources excepted from this test shall be tested for leakage prior to any use or transfer to another person unless they have been leak tested within six months prior to the date of use or transfer.
C. Sealed sources authorized for a use other than radiography shall be tested as radiography sources in accordance with Section 34.25 of 10 CFR 34.
13. The licensee is authorized to receive, possess, and use sealed sources of Iridium 192 or Cobalt 60 where the radioactivity exceeds the maximum amount of radioactivity specified in Item 8 of this license provided:
 - A. Such possession does not exceed the quantity per source specified in Item 8 by more than 20% for Iridium 192 or 10% for Cobalt 60;
 - B. Records of the licensee show that no more than the maximum amount of radioactivity per source specified in Item 8 of the license was ordered from the supplier or transferor of the byproduct material; and
 - C. The levels of radiation for radiographic exposure devices and storage containers do not exceed those specified in Section 34.21, 10 CFR 34.
14. Pursuant to Title 10, Chapter 1, Code of Federal Regulations, Part 40, "Licensing of Source Material," the licensee is authorized to possess, use, transfer, and import up to 450 kilograms of uranium contained as shielding material in the radiography exposure devices and source changers authorized by this license.
15. The licensee may transport licensed material or deliver licensed material to a carrier for transport in accordance with the provisions of Title 10, Code of Federal Regulations, Part 71, "Packaging of Radioactive Material For Transport."

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Supplementary Sheet
CONDITIONS

License Number 35-15205-01

Docket or
Reference No. _____

Amendment No. 07

(continued)

- 16. Except as specifically provided otherwise by this license, the licensee shall possess and use licensed material described in Items 6, 7, and 8 of this license in accordance with statements, representations, and procedures contained in application dated September 20, 1977 and application dated May 23, 1978 as amended September 28, 1978.

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For the U. S. Nuclear Regulatory Commission

by License Management Branch

Division of Fuel Cycle and
Material Safety
Washington, D.C. 20555

Date NOV 16 1978

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