

U. S. NUCLEAR REGULATORY COMMISSION
OFFICE OF INSPECTION AND ENFORCEMENT
REGION IV

Report No. 99900315/78-02

Program No. 44070

Company: E-Systems Incorporated

Montek Division
2268 South 3270 West
Salt Lake City, Utah 84119

Inspection Conducted: November 27-30, 1978

Inspector:

R. E. Oller
R. E. Oller, Contractor Inspector, Vendor
Inspection Branch

12/8/78
Date

Approved by:

D. M. Hunnicutt
D. M. Hunnicutt, Chief, Components Section II,
Vendor Inspection Branch

12/8/78
Date

Summary

Inspection on November 27-30, 1978 (99900315/78-02)

Areas Inspected: Implementation of 10 CFR 50, Appendix B criteria; other NRC requirements; and applicable Codes and Standards including training, material identification and control, testing of completed products, product acceptance, and action on the previous inspection finding. The inspection involved twenty (20) inspector-hours on site.

Results: In the Five (5) areas inspected, no deviations or unresolved items were identified.

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Details Section

(Prepared by R. E. Oller)

A. Persons Contacted

J. Edginton, QC Technician
*W. Enright, Director - Mechanical QA
*J. Lynch, Quality Engineer
*A. Wolff, Director - Quality Assurance

*Attended Exit Meeting.

B. Action On Previous Inspection Findings

1. (Closed) Deviation (Report No. 78-01) Failure to identify in the QA program all types of purchase requisitions being used. The inspector found that in accordance with Montek's corrective action response letter dated June 19, 1978, that Section N-4.0, paragraph 4.1.1(2) of the QA Manual has been revised to allow the use of "Purchase Requisition" Form 0223 or "Traveling Requisition" Form MD222 in the procurement of materials.

C. Training

1. Objectives

The objectives of this area of the inspection were to verify that the following items were controlled in accordance with applicable NRC and ASME Code requirements:

- a. A written system has been established to assure that indoctrination and training of personnel performing activities affecting quality is implemented in accordance with applicable codes.
- b. Appropriate written agenda are used.
- c. Records of training sessions agenda and attendance are maintained.
- d. The agenda includes subject matter adequate to provide an understanding of the general and detailed aspects of the QA program, codes, standards and applicable technical disciplines.
- e. The instructors are suitably qualified.

2. Method of Accomplishment

The preceding objectives were accomplished by

- a. Review of the QA Manual Section N-1.0, "Training Program" and QA Procedure No. and Training Program", to verify that to accomplish the subject activities are
- b. Review of training records for the period through November, 1978 to verify the assigned to the snubber (hydraulic shock) on a full time or part time basis has in accordance with the QA program.
- c. Discussions with cognizant personnel

3. Findings

Within this area of the inspection, no items were identified.

D. Material Identification and Control

1. Objectives

The objectives of this area of the inspection the following items were controlled in accordance with NRC and ASME Code Requirements:

- a. A written system has been established for identification and control of items using applicable codes.
- b. Documented measures have been taken to ensure control of materials and item fabricated assemblies.
- c. Identification is maintained and is traceable to the item.
- d. Permanent or temporary identification is legible and are not detrimental to the function of the item.
- e. All characteristics required by the design or Certified Material Test Report received, reviewed and found acceptable.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of the QA Manual Section N-4.0, paragraph 4.4 "Receiving Inspection", and Section N-5.0 "Control of Fabrication Processes", to verify that adequate controls for material identification and control, from the receiving inspection of parts and material through the final assembly of the snubbers, are documented.
- b. Review of the following receiving inspection package records covering forgings, to verify that the raw materials are controlled and identification of each item is maintained by serial number on each record:

Individual record packages, for three (3) lots of forgings, Part No. 152039-002, containing records such as:

- (1) Supplier's Certificate of Compliance.
- (2) Certified Material Test Reports.
- (3) Heat Treatment Reports.
- (4) Chemical and Physical properties Analysis Reports.

- c. Review of the following receiving inspection package records covering received finished parts to verify that these parts are controlled and identification is maintained by Inspection Code Number for each item on each record:

Individual record packages for part No. 152064-001, Inspection Code B.1.3 and part No. 152067, Inspection Code C.1.2 containing records such as:

- (1) Invoice.
- (2) Heat Treatment Report and Chart.
- (3) Certificate of Passivation.
- (4) Certificate of Test (physical and chemical properties).
- (5) Aging and Heat Treatment Report.

- d. Examination of three (3) lots of U-Bolts PN-152432-01, PN-152431-003 and PN-152431-004, in the receiving area and the related test reports to verify that these items were traceable to the assigned Inspection Code numbers.
- e. Review of the raw material receiving log "Traceability Log for Code Material", to verify that this record was maintained in accordance with the QA program.
- f. Examination of various semi-machined parts to verify that they were identified by their stamped serial numbers.
- g. Examination of completed snubber assemblies No. 152002-900 Serial Numbers SN-415, SN-417 and SN-419 and the related Manufacturing Travelers and Code Material Verification Lists, to verify that parts verification inspection operations on the travelers were properly completed; the parts lists items were signed off, and the parts serial numbers could be identified on the components of the completed snubbers.
- h. Examination of completed snubber No. PN-152005-33.0F, SN-307 to verify that the name plate information was complete in preparation for the application for the Code Symbol.

3. Findings

Within this area of the inspection, no deviations or unresolved items were identified.

E. Testing of Completed Products

1. Objectives

The objective of this area of the inspection was to verify that the following items were controlled in accordance with applicable NRC, QA Program, and Contractual requirements.

- a. A written system has been established to assure that functional tests are controlled in accordance with applicable procedures and specifications.
- b. Functional tests are performed in accordance with approved procedures and instructions.
- c. The results of test are documented and reviewed for acceptability.
- d. The test equipment is calibrated where required.
- e. The tests are performed by qualified personnel.

2. Method of Accomplishment

The preceding objective was accomplished by:

- a. Review of the QA Manual Section N-10.0 "Test Control", to verify that adequate controls for testing of completed products are documented.
- b. Review of the following approved procedures for use in testing 20, 30, 50 and 100 kip snubbers, respectively, to verify that these contract required procedures prescribe approved systems for final tests of snubbers (hydraulic shock suppressors).
 - (1) No. 152002-410, Revision B.
 - (2) No. 152003-410, Revision B.
 - (3) No. 152005-410, Revision B.
 - (4) No. 152010-410, Revision B.
- c. Observation of an in-process performance test on snubber assembly PN-152002-40, SN-448 using procedure No. 152002-410, Revision B. "Acceptance Specification, Including Filling, Bleeding, Testing, and Rigging for 152002 Snubber Assembly", to verify that the test was conducted and the test data recorded in accordance with the prescribed procedure by qualified personnel.
- d. Observations of the calibration status of the mechanical test equipment and instrumentation to verify that all items, where required, were appropriately calibrated.
- e. Review of the "Acceptance Test Data Sheets" for the following identified completed snubbers, to verify that tests were properly recorded and the tests were evaluated and accepted by the Montek QC representative, the Authorized Nuclear Inspector and Montek's customer representative.
 - (1) Six (6) No. 152003 Snubbers.
 - (2) Ten (10) No. 152005 Snubbers.
 - (3) Fourteen (14) No. 152010 Snubbers.
- f. Discussions with cognizant personnel.

3. Findings

Within this area of the inspection, no deviations or unresolved items were identified.

F. Product Acceptance

1. Objectives

The objective of this area of the inspection was to verify that the following items were controlled in accordance with applicable NRC and ASME Code requirements.

- a. A written system has been established to assure that product acceptance activities related to procurement of items are controlled.
- b. Procedures have been prepared, approved and implemented by responsible personnel to control the subject activities.
- c. The results of product acceptance activities are documented and reviewed for acceptability by responsible personnel.

2. Method of Accomplishment

The preceding objective was accomplished by:

- a. Review of the QA Manual Section N-4.0, paragraph 4.4 "Receiving Inspection", to verify that controls for the subject activity are documented.
- b. Review of three (3) Receiving Inspection record packages for raw material forgings for Part No. 152039-002 and two (2) record packages for finished part No. 152064-001 and part No. 152067-001 to verify that the material records contained in these packages were reviewed for acceptability by the Montek quality assurance department and the Authorized Nuclear Inspector.
- c. Observation of U-Bolt materials and the documentation packages in the receiving inspection area.
- d. Discussion with cognizant personnel.

3. Findings

Within this area of the inspection, no deviations or unresolved items were identified.

G. Exit Interview

1. The inspector met with management representatives denoted in paragraph A of Details Section at the conclusion of the inspection on November 30, 1978.
2. The following subjects were discussed:
 - a. Areas inspected.
 - b. Status of corrective action for the previously identified deviation.
 - c. The absence of deviations and unresolved items in the areas inspected.
3. Management's comments were related to clarification of the above subjects.