

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

Report No. 99900089/80-01

Program No. 51300

Company: Huico Incorporated
724 Taylor Road
Merridian, Idaho 83642

Inspection Conducted: May 5-8, 1980

Inspectors:

for Wm. D. Kelley
V. H. Hunter, Contractor Inspector
Components Section I
Vendor Inspection Branch

5/27/80
Date

Approved by:

for Wm. D. Kelley
S. E. Whitesell, Chief
Components Section I
Vendor Inspection Branch

5/27/80
Date

Summary

Inspection on May 5-8, 1980 (99900089/80-01)

Areas Inspected: Implementation of 10 CFR 50, Appendix B criteria including action on previous findings, training, audits, and calibration. The inspection involved twenty-eight (28) inspector-hours on site.

Results: In the four (4) areas inspected there were no apparent deviations or unresolved items identified in three (3) areas. The following apparent deviations were identified in the remaining area.

Deviations: Audit Control; (1) Department Heads do not include the probable cause or effective date of corrective action in their response to adverse findings (See Notice of Deviation, Item C.); (2) One (1) QA supervisor audits functions for which he supervises (See Notice of Deviation, Item A.); and (3) The QA Manager does not maintain a log for audit reports, follow-up action and re-audits (See Notice of Deviation, Item B.)

All of the above deviations were contrary to the requirements of Criterion V of Appendix B to 10 CFR 50 and Section 18.0 of the ASME accepted QA manual.

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General Information: It was noted that the position of the president of Huico at the Corporate offices in Seattle, Washington has been transferred to the Huico facility in Boise, Idaho. Mr. D. Church has been appointed as president.

DETAILS SECTIONA. Principal Persons Contacted

- D. Church - President
- *K. Han - Vice President
- *D. D. Volkman - Quality Assurance Manager
- *R. V. Olson - Director of Engineering
- *P. W. Sly - Director Corporate Quality Assurance
- *J. Harper - Procurement Manager
- *J. Freeman - Superintendent
- *N. W. Seid - Senior Welding Engineer
- *L. E. Garrison - NDE Supervisor Level III

B. Action on Previous Inspection Findings

(Closed) Deviation (Report No. 99900089/79-01): Welder qualification records - It was verified that all weld performance qualification records had been reviewed. In addition, a schedule for a periodic review of the weld engineering files has been established to assure compliance with the QA manual.

(Closed) Deviation (Report No. 99900089/79-01): Welding not performed per procedure - It was verified that: (1) the affected weld had been cut out, (2) the responsible welder and inspector attended special training sessions, and (3) that comparison sheets attached to the weld machines have been simplified in order to eliminate errors when checking volt and amp meters during welding.

C. Audit Control1. Objectives

The objectives of this area of the inspection were to verify that procedures had been prepared and approved by the vendor that prescribed a system for auditing which is consistent with the commitments of the ASME accepted Quality Assurance Manual. Also, verify that these audit procedures were being properly and effectively implemented by the vendor.

2. Method of Accomplishment

The objectives of this area of the inspection were accomplished by:

- a. Review of the ASME accepted Quality Assurance Manual, Section 18.0, titled "Audits" to verify that procedures had been established to prescribe a system for auditing.

b. Review of the following documents:

- (1) Current audit check list
- (2) Current audit schedule
- (3) Audit personnel qualifications

to verify that they had been prepared by the designated authority, approved by management, and reviewed by quality assurance.

- c. Review of selective audit reports to verify that they identify the written plan, team selection, team orientation, audit notification, pre-audit conference, audit performance, and post-audit conference.
- d. Review of randomly selected audit reports to verify that the distribution to management, and the audited organization, and follow-up regarding corrective action had been accomplished.
- e. Review of internal and external audit reports to verify that the applicable procedures were available to the audit team personnel, and that the audit procedures were properly and effectively implemented.

3. Findings

a. Deviation

Refer to Notice of Deviation, Items A, B, and C

b. Unresolved Items

None were identified.

D. Calibration

1. Inspection Objectives

The objectives of this inspection were to:

- a. Ascertain that a system has been established and is maintained to assure that tools, gages, instruments and other measuring devices used in activities affecting quality are properly controlled, calibrated and adjusted at specified periods to maintain accuracy within specified limits.

- b. Verify that the system described in (a) above, has been adequately documented with approved procedures and that these procedures are being implemented.

2. Objectives Accomplished by:

- a. Review of Section 12.0 of the ASME accepted QA manual.
- b. Review of calibration master file.
- c. Review of identifying codes and tool recall system.
- d. Visual observation of calibrated tools and gages in all major work stations.
- e. Interviews with cognizant technical and management personnel.

3. Inspection Findings

The objectives of the inspection were met with no deviation from commitments identified.

E. Training

1. Inspection Objectives

The objectives of this inspection were:

- a. To ascertain that programs are established for indoctrination and training of personnel performing activities affecting quality.
- b. To ascertain that indoctrination and training measures are effectively implemented.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of Section 1.3 of the ASME accepted QA manual.
- b. Review of annual training schedules.
- c. Review of training outlines submitted by engineering, production, quality assurance, and procurement.
- d. Review of training records for all departments.

3. Inspection Findings

There were no deviations or unresolved items identified.

F. Quality Assurance Records

1. Inspection Objectives

The objectives of the inspection were to verify that quality assurance records were maintained for fabrication, manufacturing, or installation and provide traceability, and the records contained as a minimum of documents pertaining to materials manufacturing, examination and test data, procedures, drawings and Stress Report, qualification of personnel, procedures and equipment, and these records are maintained in a manner that allows ready access.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of Section 19.0 of the ASME accepted QA manual.
- b. Review of selective QC plans and checklists.
- c. Review of completed data packages for required records.
- d. Interviews with technical and management personnel.

3. Inspection Findings

There were no deviations or unresolved items identified.

G. Exit Interview

The inspector met with those individuals noted in paragraph A above at the conclusion of the inspection on May 8, 1980. The inspector summarized the scope and findings identified during the inspection. Management acknowledged the inspector's comments regarding the scope and findings as presented.