

LIMITORQUE CORPORATION

5114 Woodall Road • P. O. Box 11318 • Lynchburg, Virginia 24506
Telephone—804-528-4400 • Telex—82-9448



April 28, 1980

United States Nuclear Regulatory Commission
Region IV
611 Ryan Plaza Drive, Suite 1000
Arlington, Texas 76012

Attention: Mr. Uldis Potopovs, Chief
Vendor Inspection Branch

Subject: Docket No. 99900100/80-01

Gentlemen:

In addressing the two deviations (Item A and B) listed in the Notice of Deviations of your letter of April 3, 1980, we report as follows:

- A. 1. To correct the item of, the Tool and Gage Inspection/Calibration Record card was not maintained for the Wilson Rockwell Hardness tester and the calibration computer list record of employee owned tools did not include an inside micrometer owned by employee clock number 254. The Tool and Gage Inspection/Calibration record (QC001) has been completed for this recently purchased Wilson Rockwell Hardness tester and the inside micrometer recently purchased by employee 254 will be added to the calibration computer list.
2. To prevent recurrence, a special addendum to the next Manufacturing Plant Internal Audit check list will include in the area of calibration a sample of Limitorque and employee owned tools to verify these records are maintained.
3. Date of corrective action, Wilson Rockwell Hardness tester Tool and Gage Inspection/Calibration Record completed April 28, 1980 and the calibration computer list will be updated July 31, 1980 for the employee owned tools.
- B. 1. To correct the item of some of the Inspection Travel Cards not being completed and filed daily the Machine Shop Quality Control Inspectors have been notified that, The following procedure is to be used in the completion of Inspection Travel Cards: The inspector upon making a first piece or patrol inspection of a part will complete the Travel Card as follows:

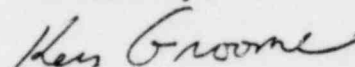
8006040004

1. Dwg. No. _____
Use drawing or part number as given on drawing, usually ten digits. (60-601-0007-4)
2. Part _____
Use full description given under part name on drawing.
3. Start Quantity _____
Use actual count of parts starting on first operation.
4. Order No. _____
Use Limitorque order number found on upper right hand corner of drawing, usually one letter and five digits (V99724) for stock orders and six digits (3A7166) for special orders.
5. Final Quantity _____
This is to be completed by the inspector at final inspection. Use actual count of parts going to stock.
6. Operation _____
Use description of operation from machinist production card.
7. Date _____
Use date inspection was made.
8. Shift _____
Use 1st for day shift and 2nd for night shift. This is to indicate shift that part was made on.
9. Machine No. _____
Use machine identification number.
10. First-Piece _____
This block is checked if the part being checked is the first piece made on this order.
11. Patrol _____
This block is checked if part is checked during production run. Record each inspection made.
12. V.R. Nr. Qty. Desp. _____
Use this block to list V.R. number, Qty. of rejections and disposition of parts.
13. Inspector's Initials _____
The inspector should use this space to put his initials after he has checked the piece
14. All travel cards will be removed from drawings at stockroom inspection by the inspector and filed daily. The travel card for a particular order will be filed for proof of material inspection.

2. To prevent recurrence, a special addendum to the next Manufacturing Plant Internal Audit check list will include in the area of Manufacturing Control "Are Inspection Travel Cards properly completed and filed per QCP-4.E.1."
3. Date of corrective action, letter re-emphasizing QCP-4.E.1 April 28, 1980. Date of Preventive measure, Manufacturing Internal Audit will be completed by June 30, 1980.

We trust that the above corrective steps and preventive actions will satisfy the two deviations outlined in your report.

Sincerely,



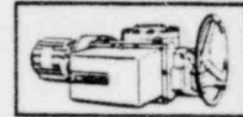
Ken Groome
Quality Control Manager

pgw

cc: Tom Mignogna
Pat McQuillan

LIMITORQUE CORPORATION

Inter-Office Correspondence



DATE: 4/28/80

FROM: Ken Groome

TO: All Machine Shop Q.C. Inspectors ATTENTION:

SUBJECT: Proper Completion of Inspection Travel Cards
Re-emphasizing of QCP-4 Machine Shop Inspection Procedure
Inspection Travel Cards, Dated 4/1/80.

Gentlemen:

The following procedure is to be used in the completion of Travel Cards: The inspector upon making a first piece of patrol inspection of a part will complete the Travel Card as follows:

1. Dwg. No. _____
Use drawing or part number as given on drawing, usually ten digits. (60-601-0007-4)
2. Part _____
Use full description given under part name on drawing.
3. Start Quantity _____
Use actual count of parts starting on first operation.
4. Order No. _____
Use Limitorque order number found on upper right hand corner of drawing, usually one letter and five digits (V99724) for stock orders and six digits (3A7166) for special parts.
5. Final Quantity _____
This is to be completed by the inspector at final inspection. Use actual count of parts going to stock.
6. Operation _____
Use description of operation from machinist production card.
7. Date _____
Use date inspection was made.
8. Shift _____
Use 1st for day shift and 2nd for night shift. This is to indicate shift that part was made on.
9. Machine No. _____
Use machine identification number.
10. First Piece _____
This block is checked if the part being checked is the first piece made on this order.

11. Patrol _____
This block is checked if part is checked during production run.
Record each inspection made.
12. V.R. No. Qty. Desp. _____
Use this block to list V.R. number, quantity of rejections and
disposition of parts.
13. Inspector's Initials _____
The inspector should use this space to put his initials after
he has checked the piece.
14. All travel cards will be removed from drawings at stockroom
inspection by the inspector and filed daily. The travel card
for a particular order will be filed for proof of material
inspection.

pgw

cc: Wilford Wood
Donnie Pillow
Frank Evans
Clarence St. Clair
Preston Ferguson
Gerald Sparrow
Eugene McDaniel
Jesse Puryear
Alton Lucado
Kevin Eubanks
Clyke Hicks
Gary Mason

Ken Groome

Ken Groome
Quality Control Manager