

Anderson, Greenwood & Co.

MAILING ADDRESS:
P O BOX 1097
BELLAIRE, TEXAS 77401

TEL: 713-668-0631
TWX: 910-881-2652
TELEX: 77-5219

INDUSTRIAL PRODUCTS
SAFETY RELIEF VALVES
HAND & GAGE VALVES
INSTRUMENT MANIFOLDS
CHECK VALVES
PRESSURE REGULATORS
NUCLEAR VALVES

MAIN OFFICE AND PLANT
5425 SOUTH RICE AVE
HOUSTON, TEXAS 77081

ACCOUNTING
5234 GLENMONT
HOUSTON, TEXAS 77081

AEROSPACE PRODUCTS
TARGET TOW EQUIPMENT

July 9, 1980

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

Attn: Mr. Uldis Potapovs, Chief
Vendor Inspection Branch

Ref: Docket No. 999 00214/80-01

Dear Mr. Potapovs,

As per letter from our T. C. Dolson dated May 9, 1980, you will find copies of the following Internal Implementing Procedures attached:

Deviation A

Quality Procedure Directive

Q.P.D. No. 1-2 Training Program Outline for those Persons Whose Activities Affect Quality of Nuclear Products.

Deviation B

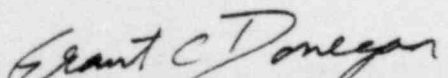
Quality Procedure Directive

Q.P.D. No. 5-7 Requirements for and Mechanics of performing Visual Inspection of Welds and Visual Inspection of Welds prior to Performing Liquid Penetrant or Magnetic Particle Examination.

If you have any questions, please contact me at (713)- 668-0631, Extension 4560.

Sincerely yours,

ANDERSON, GREENWOOD & CO.


Grant C. Donegan
Quality Assurance Manager

GCD/br

8007300315

Q.P.D. NO.1-2
REVISION: 0
DATE: 6-24-80

QUALITY PROCEDURE DIRECTIVE

TRAINING PROGRAM OUTLINE FOR THOSE PERSONS WHOSE
ACTIVITIES AFFECT QUALITY OF NUCLEAR PRODUCTS

PREPARED BY:

Grant Donegan
GRANT C. DONEGAN

APPROVED BY:

Frank Pizzitola
FRANK PIZZITOLA

Q.P.D. NO. 1-2
REVISION: 0
DATE: 6-24-80
PAGE 1 of 2

TRAINING PROGRAM OUTLINE FOR THOSE PERSONS WHOSE
ACTIVITIES AFFECT QUALITY OF NUCLEAR PRODUCTS

1.0 PURPOSE

To establish a program of indoctrination training for personnel whose activities affect quality of nuclear products. To attain an effective quality team and conform to the requirements of regulatory codes and agency restrictions.

2.0 SCOPE

This procedure is applicable to all personnel whose activities affect quality of nuclear products.

3.0 RESPONSIBILITY

The Director of Quality Assurance shall initiate training outlines and programs and specific training courses to qualify those persons whose activities affect quality to meet corporate objectives and code and regulatory requirements.

4.0 PROCEDURE

- 4.1 Personnel whose activities affect quality shall be divided into convenient training groups whose work activities are similiar so that group training can be accomplished effeciently and effectively.
- 4.2 Training program outlines shall be prepared for each group. (EXHIBIT # 1)
 - 4.2.1 Groups at Anderson, Greenwood & Co. are as follows:
 - 4.2.1.1 Power Plant Valves Sales (Nuclear)
 - 4.2.1.2 Design Engineering
 - 4.2.1.3 Office Services (Document Control)
 - 4.2.1.4 Manufacturing Methods
 - 4.2.1.5 Production Control & Projects Management
 - 4.2.1.6 Quality Assurance Section
 - 4.2.1.7 Quality Control Section
 - 4.2.1.8 Nondestructive Examination Personnel
 - 4.2.1.9 Purchasing Department
 - 4.2.1.10 Welding Department

Q.P.D. NO. 1-2
REVISION: 0
DATE: 6-24-80
PAGE 2 of 2

- 4.3 Training sessions shall be held twice per year, after review of the code addendas. Additional special sessions shall be held when new personnel are added or when the need is indicated.
- 4.4 Attendance at training sessions shall be recorded by the attendees signing a QA Training Session Report. (EXHIBIT #2). QA Training Session Reports shall be filed in the QA training log.
- 4.5 Departmental manning charts shall be reviewed by the QA Manager to insure that instruction has been given to all required personnel. Make up sessions shall be scheduled for personnel who missed the scheduled sessions.

DATE: 6-24-80

TRAINING PROGRAM OUTLINE
FOR THE
QUALITY CONTROL SECTION

PREPARED BY:

Grant C Donegan
GRANT C. DONEGAN

APPROVED BY:

Frank Pizzitola
FRANK PIZZITOLA

TRAINING PROGRAM OUTLINE FOR THE
QUALITY CONTROL SECTION

- I. Job Titles/personnel receiving training:
 - A. Manager of Quality Control
 - B. Receiving Inspector
 - C. Line Inspectors
 - D. Manufacturing Inspectors
 - E. Shipping Inspectors
- II. Purpose of training is to assure that personnel are familiar with:
 - A. Origin and reason for ASME Code.
 - B. Requirements of Code
 1. QA Manual/Program (Section 18)
 - a. Definition of AGCO compliance to Code
 - b. Distribution and revisions to Manual are controlled
 - c. Administered by QA Department
 - d. Internal Audits of all departments (Section 17)
 - (1) QAD audits departments
 - (2) Methods audits QAD
 - (3) Management audits QA Program
 2. Authorized Nuclear Inspector (Section 13)
 - a. Inspector for Buyer's insurance company
 - b. Free access to witness the conformance to Code and QA Manual
 - c. Semi-annual audits of all AGCO departments
 3. Training of personnel to Code and QA Manual/Program
 - a. Training conducted by desingee of QA Manager
 - b. Training given upon being assigned tasks covered by the Code and QA Manual
 - c. Training given to assure understanding of revisions to Code and QA Manual
 - d. Training given to correct deficiencies found in audits by QAD or ANI
 - e. Recorded in QA Manual Training Log maintained by QAD
 - C. The importance of careful work and attention to detail to achieve and maintain:
 1. Quality product
 2. Conformance to customers design specification requirements
 3. Traceability as specified by the Code
 4. Accurate nuclear documents (para. 3.4.2)

- III. Training is to cover the following sections, paragraphs, and sub-paragraphs in the AGCO Nuclear QA Manual.
- A. Section 1: ORGANIZATION
 - 1. Paragraph 1.4
 - (a) Discuss duties and responsibilities of QA Manager, Chief Inspector, and QA Specialist and the QA Coordinator.
 - B. Section 4: DOCUMENT CONTROL
 - 1. Paragraph 4.5.2.3.1
 - (a) Work Order and drawing remain together until order is finished.
 - 2. Paragraph 4.5.3
 - (a) Handling Nuclear Quality Procedures Manual
 - C. Section 5: PRODUCTION CONTROL PROCESS
 - 1. Paragraph 5.6.5
 - (a) Preparation of Pressure Retaining Materials List at pre-assembly inspection
 - 2. Paragraph 5.6.7
 - (a) Duties of shipping inspector
 - D. Section 6: MATERIAL STOCKING AND ISSUING
 - 1. Paragraph 6.5
 - (a) Maintaining traceability through use of color codes, stamping, and identification numbers prior to issuing stock
 - E. Section 8: RECEIVING INSPECTION
 - 1. Paragraph 8.4
 - (a) Handling incoming material and test documents
 - 2. Paragraph 8.5
 - (a) Storing and marking acceptable material
 - F. Section 9: PROCESS INSPECTION
 - 1. Paragraph 9.4
 - (a) Line inspectors check material and sign fabrication sheet before any machining is done
 - (b) Inspects each operation and notes acceptance on fabrication control sheet
 - 2. Paragraph 9.5
 - (a) Manufacturing Inspector inspects all material
 - (b) Prepares NPIR, MRA, or Receipt on Production as necessary

- G. Section 10: WELDING
 - 1. Paragraph 10.8.6
 - (a) Manufacturing Inspectors checks welding. Signs and dates fabrication control sheet
 - 2. Paragraph 10.9
 - (a) Weld repair inspection, disposition and documentation
 - 3. Paragraph 10.10 and 10.13
 - (a) Weld material receipt and acceptance
 - 4. Paragraph 10.11
 - (a) Weld material issuance
- H. Section 11: HEAT TREATMENT CONTROL PROCESS
 - 1. Paragraph 11.5
 - (a) Inspector checks hardness
 - (b) Chief Inspector sign/date Heat Treat Certificate
- I. Section 14: INSPECTION, EQUIPMENT, CALIBRATION AND CONTROL
 - 1. Calibration frequency, procedures and records for instruments and equipment
- J. Section 19: ASSEMBLY TESTING, NAMEPLATE/CODE STAMPING AND SHIPPING
 - 1. Paragraph 19.5
 - (a) Inspection prior to shipping
- K. Section 20: NONCONFORMING ITEMS
 - 1. Identification, segregation, disposition of nonconforming items
 - 2. Material Review Board, Corrective Action
- IV. Discussion of Code Changes brought about by the latest Code Addendas.

Q.A. TRAINING SESSION

A training session was held in the _____
on _____ from _____ am/pm till _____ am/pm. The train-
ing material used in this session was Section(s) _____
_____ and _____ of the AGCO Nuclear Q.A. Manual.
Training was conducted by _____.

The following employees attended:

BY: _____

QUALITY PROCEDURE DIRECTIVE

REQUIREMENTS FOR AND MECHANICS OF PERFORMING
VISUAL INSPECTION OF WELDS PRIOR TO PERFORMING
LIQUID PENETRANT OR MAGNETIC PARTICLE EXAMINATIONS

PREPARED BY: *Grant C. Donegan*
GRANT C. DONEGAN

APPROVED BY: *Frank Pizzitola*
FRANK PIZZITOLA

Q.P.D. NO. 5-7

REVISION: 0

DATE:

PAGE 1 of 2

Requirements for and mechanics of performing visual inspection of welds and visual inspection of welds prior to performing Liquid Penetrant or Magnetic Particle Examinations.

1.0 PURPOSE

To establish uniform methods for the performance of visual inspection of welds and weld test samples.

2.0 SCOPE

This procedure is applicable to visual inspection of all welded and seal welded nuclear products.

3.0 TECHNICAL REQUIREMENTS

3.1 Surface Preparation

- 3.1.1 Any surface condition or irregularity which could mask or be confused with an unacceptable indication must be removed by blend grinding or other suitable method.
- 3.1.2 The surface to be examined must be cleaned so that it is free of water, dirt, grease, wax, paint, oil, welding flux, weld spatter or other extraneous matter that could or tend to otherwise be confused with or mask an unacceptable indication. Cleaning shall be performed with acceptable cleaning solvents and methods as specified in approved cleaning procedures as specified on the applicable part drawing and/or Fabrication control sheet.

3.2 Illumination

- 3.2.1 The surface to be examined shall be illuminated so that a light meter measures 200 foot candles when it's sensor is laid on the surface pointing toward the light source.

3.3 Personnel

- 3.3.1 Persons who perform visual inspections must be able to read the J-I Letters on a Vaegers Reading chart, corrected or uncorrected using one or both eyes. Examinations shall be conducted annually and documented on an eye examination report. (EXHIBIT # 1).

3.4 Magnification

3.4.1 Product surfaces to be examined shall be scanned utilizing 5X Magnifier.

3.4.2 Surfaces of weld performance samples shall be scanned utilizing 10X to 15X Magnifier.

3.5 Acceptance Criteria

3.5.1 The acceptance standards and rejection criteria to be utilized shall be those specified on the part drawing or as stated in procedures referenced on the part drawing or Fabrication Control Sheet.

Anderson, Greenwood & Co.

MAILING ADDRESS
P O BOX 1097
BELLAIRE, TEXAS 77401

TEL: 713-668-0631
TWX: 910-881-2652
TELEX: 77-5219

INDUSTRIAL PRODUCTS
SAFETY RELIEF VALVES
HAND & GAGE VALVES
INSTRUMENT MANIFOLDS
CHECK VALVES
PRESSURE REGULATORS
NUCLEAR VALVES

MAIN OFFICE AND PLANT
5425 SOUTH RICE AVE
HOUSTON, TEXAS 77081

EXHIBIT # 1

ACCOUNTING
5234 GLENMONT
HOUSTON, TEXAS 77081

AEROSPACE PRODUCTS
TARGET TOW EQUIPMENT

EYE EXAMINATION REPORT

NAME _____

CLOCK NO. _____

NONDESTRUCTIVE EXAMINATION METHODS

	LEVEL	
	I	II
<input type="checkbox"/> MT	<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> PT	<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> RT	<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> UT	<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> LEAK TEST	<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> THICKNESS MEASUREMENT	<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> VALVE TEST	<input type="checkbox"/>	<input type="checkbox"/>
<input type="checkbox"/> VISUAL INSPECTION		

Is capable of reading J-1 letters on Jaeger's eye chart

	EYE	CORRECTED	UNCORRECTED
RIGHT	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
LEFT	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
ACCEPT	<input type="checkbox"/>		REJECT <input type="checkbox"/>

BY _____

DATE _____

19 MAY 1980

Docket No. 999002T4/80-01

Anderson-Greenwood and Company
Attn: Mr. J. H. Elder, Jr.
President
5425 South Rice Avenue
Houston, Texas 77036

Gentlemen:

Thank you for your letter of May 9, 1980, in response to our letter dated April 16, 1980, with an enclosure. We have no further questions at this time. We will review your corrective action during a future inspection.

Sincerely,

Original Signed By:
Uldis Potapovs
Uldis Potapovs, Chief
Vendor Inspection Branch

bcc:
Central Files
PDR HQS
WEVetter
WDKelley

POOR ORIGINAL

Dupe of 8006030155

OFFICE	RIV WDKelley/ng	DEWhitesell	UPotapovs	WEVetter	
SURNAME	5/16/80	5/16/80	5/16/80	5/16/80	
DATE	<i>[Signature]</i>			<i>[Signature]</i> (SS)	

Anderson, Greenwood & Co.

MAILING ADDRESS:
P O. BOX 1097
BELLAIRE, TEXAS 77401

TEL: 713-668-0631
TWX: 910-881-2652
TELEX: 77-5219

INDUSTRIAL PRODUCTS
SAFETY RELIEF VALVES
HAND & GAGE VALVES
INSTRUMENT MANIFOLDS
CHECK VALVES
PRESSURE REGULATORS
NUCLEAR VALVES

MAIN OFFICE AND PLANT
5425 SOUTH RICE AVE
HOUSTON, TEXAS 77081

ACCOUNTING
5234 GLENMONT
HOUSTON, TEXAS 77081

AEROSPACE PRODUCTS
TARGET TOW EQUIPMENT

May 9, 1980

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

Attn: Mr. Uldis Potapovs, Chief
Vendor Inspection Branch

Reference: Docket No. 99900214/80-01

Dear Mr. Potapovs,

The deviations listed in the referenced Docket, will both be resolved by the preparation, issuance and implementation of two (2) internal implementing procedures called "Quality Procedure Directives" as follows:

Deviation A

Quality Procedure Directive

Q.P.D. No. 1-2 Training Program Outline for those Persons Whose Activities Affect Quality of Nuclear Products.

Implementation Date: July 1, 1980

Deviation B

Quality Procedure Directive

Q.P.D. No. 5-7 Requirements for and Mechanics of performing Visual Inspection of Welds and Visual Inspection of Welds prior to Performing Liquid Penetrant or Magnetic Particle Examinations.

Implementation Date: July 1, 1980

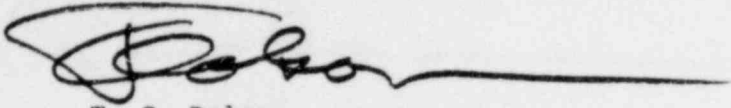
Dupe of
8006030162

United States Nuclear Regulatory Commission
Region IV
May 9, 1980
Page 2

Copies of the above will be transmitted to you for review, as they are completed.

Sincerely,

ANDERSON, GREENWOOD & CO.

A handwritten signature in black ink, appearing to read 'T. C. Dolson', with a long horizontal flourish extending to the right.

T. C. Dolson
Vice President, Planning & Operations

TCD/br