

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

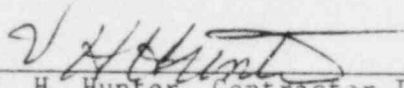
Report No. 99900344/80-01

Program No. 51300

Company: ABEX Incorporated
Remco Hydraulics Division
934 South Main Street
Willits, California 95490

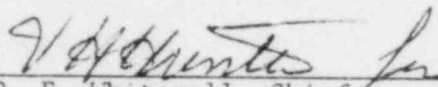
Inspection Conducted: June 9-12, 1980

Inspector:


V. H. Hunter, Contractor Inspector
Components Section I
Vendor Inspection Branch

7-1-80
Date

Approved:


D. E. Whitesell, Chief
Components Section I
Vendor Inspection Branch

7-1-80
Date

Summary:

Inspection on June 6-9, 1980 (99900344/80-01)

Areas Inspected: Implementation of 10 CFR 50, Appendix B, Criteria and applicable codes and standards, including action on previous findings, design document control, audits, special processes, and records. The inspection involved twenty-seven (27) inspector-hours on site.

Results: In the five (5) areas inspected there were no apparent deviations or unresolved items identified.

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DETAILSA. Principal Persons Contacted

E. E. Berry, General Manager
M. L. Russell, Quality Assurance Manager
G. C. Johnston, Chief Engineer

All of the above listed personnel attended the exit interview meeting.

B. General

The ABEX Corporation is a division of Remco Hydraulics, Incorporated, employing 240 technical and administrative personnel. The facility covers approximately 125,000 square feet and is self contained in that most all ASME required services, i.e., design, welding (when required), machining, hydrostatic testing, NDE (MT and LP), and special coating processes, are provided. When required by contract, RT and UT is performed by an independent certified agency.

ABEX division maintains ASME certification No. N-1440 (NPI) Class 1, 2, 3, and MC Component Supports. The certificate expires on June 25, 1982.

ABEX division has manufactured such components as:

1. Hydraulic Snubbers
2. Fuel Rack Dampers
3. Spray and Surge Lines
4. Valve Actuators

The above components comprise 25% of ABEX capacity and have been supplied to approximately 23 commercial nuclear power plants.

C. Action on Previous Inspection Findings

1. (Closed) Deviation (Report No. 99900344/79-01): Calibration not maintained. It was verified that the referenced calibration procedure has been incorporated into the control system and that all revisions issued are controlled in accordance with the approved program.
2. (Closed) Deviation (Report No. 99900344/79-01): Measures had not been established to require management to regularly review the status and adequacy of the QA program. It was verified that the required measures have been established and implemented.

3. (Closed) Deviation (Report No. 99900344/79-01): One individual conducted an audit of functions for which he was responsible. It was verified that the procedure for selection and qualification of auditors has been revised and implemented to prevent inadvertant audit of functional areas of responsibility.

D. Audit Control

1. 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 16.0, 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 prepared by the designated authority, approved by management, and reviewed by quality assurance.
- d. 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.
- e. 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.
- f. 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

There were no apparent deviations or unresolved items identified.

E. Control of Special Processes1. Inspection Objectives

The objectives of this inspection were to verify that special processes such as welding, nondestructive testing and heat treating are controlled and accomplished by qualified personnel using qualified procedures in accordance with applicable regulatory, code and contract requirements.

2. Objectives Accomplished By:

The preceding objectives were accomplished by:

- a. Review of Cleaning Procedure No. 690367A, Revision A.
- b. Review of Chrome Plating Procedure No. A-690402-D, dated March 12, 1976.
- c. Review of impact test procedure No. A-690540-A, dated July 14, 1977.
- d. Review of U.T. Procedure No. A-690722 dated July 12, 1977.
- e. Review of Electroless Nickel Coating Procedure No. A-702580, Revision A.
- f. Observation of Final Inspection of Snubber Barrells 760, 764, and 759 as Identified by job no. 32980.

3. Inspection Findings

There were no apparent deviations or unresolved items identified.

F. Quality Assurance Records1. 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 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 15.0 "Record Control" of the ASME accepted QA Manual.
- b. Review of randomly selected QC plans and checklists.
- c. Review of completed data packages for shop orders 32872 and 32873 which included the following documents;
 - (1) ASME Code Data Reports
 - (2) Stress Reports
 - (3) Design Specifications
 - (4) As-built Drawings
 - (5) Material Certifications
 - (6) Audit Reports
 - (7) Functional test results

3. Inspection Findings

There were no apparent deviations as or unresolved items identified.

G. Design Document Control

1. Objectives

The objectives of this area of the inspection were to ascertain whether procedures had been developed and properly implemented to control the review, approval, release and issuance, of design documents in a manner consistent with NRC rules and regulations, ASME Code requirements, and the vendor's QA program commitments.

2. Method of Accomplishment

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

- a. Review of Section 4.0 of the ASME accepted QA Manual, titled "Design Control" to verify that the vendor had established procedures which prescribes a system for control of design documents.
- b. Reviewed the following drawings:
 - (1) D-271534, Revision B
 - (2) D-240343, Revision C
 - (3) D-290603, Revision A
 - (4) D-261530, Revision C

to verify that they had been reviewed for adequacy, approved by management, reviewed by QA, and released for production in a manner which is consistent with the NRC rules and regulations, code requirements and contract commitments.

- c. Review of design reports A-690640, A-690957, and A-690813 to verify that it provided for identification of personnel responsible for preparing, reviewing, approving, and issuing design documents; and that the review and approval of significant changes were performed by the same personnel. Also to ascertain whether minor changes to design documents, that do not require review and approval, are identified.
- d. Review of in-process shop travelers, to verify that the distribution lists are current and that the proper documents are identified, accessible, and are being used.
- e. Interviewed personnel to verify whether they are knowledgeable in the procedures applicable to design document control.

3. Findings

There were no deviations or unresolved items identified.

H. Exit Interview

The inspector met with management representatives at the conclusion of the inspection on June 12, 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.