

Colt Industries
Fairbanks Morse Engine Division
Docket No. 99900300/81-01

NOTICE OF NONCONFORMANCE

Based on the results of an NRC inspection conducted on May 18-21, 1980, it appears that certain of your activities were not conducted in accordance with NRC requirements as indicated below:

Criterion V of Appendix B to 10 CFR Part 50 states: "Activities affecting quality shall be prescribed by documented instructions, procedures, or drawings, of a type appropriate to the circumstances and shall be accomplished in accordance with these instructions, procedures, or drawings. Instructions, procedures, or drawings shall include appropriate quantitative or qualitative acceptance criteria for determining that important activities have been satisfactorily accomplished."

Nonconformances with these requirements are as follows:

- A. Standard Practice No. 400.10, dated April 1976, contains the following requirements:
1. Paragraph 3.8 states in part, "The tool crib must submit standard measuring devices to one of the QC gage calibration during the calendar month the calibration due dates occur (sic)." Paragraph 2.1 identifies standard measuring devices as plug gages, micrometers for measuring outside diameters over 2 inches, plus other devices.
 2. Paragraph 4.5 states in part, "The employee, issued a standard measuring device shall, upon completion of use or by the end of the maximum time (three days) for short term issue, return the device to the tool crib for return of the signed check out ticket or for reissue"

Contrary to the above:

- a. The following standard measuring devices (Cylindrical Plug Gages) had not been submitted to one of the Q.C. calibration laboratories during the calendar month of the calibration due date:

| <u>Serial Number</u> | <u>Size</u> | <u>Due</u> | <u>Located at</u> |
|----------------------|---------------|------------|---------------------|
| 10008 | 1.6245/1.6255 | 4/81 | Dept. 201 Tool Crib |
| 10012 | 1.5005/1.501 | 4/81 | Dept. 201 Tool Crib |
| B233 | .312/.313 | 4/81 | Dept. 201 Tool Crib |

Additionally, the NRC inspector observed the return of a micrometer used for measuring outside diameters of 22-23 inches, to the Department 551 Tool Crib, on May 20, 1981. The S/N was JZ2 with a calibration due date of April 1981; this device was assigned to Department 201 Tool Crib.

- b. The following standard measuring devices had not been returned to the Department 551 Tool Crib by the end of the maximum three day period as evidenced by the signed check out tickets on file and absence of the tools from the tool crib:

| <u>Nonmenclature/Size</u> | <u>Serial Number</u> | <u>Date of Check out Ticket</u> |
|---------------------------|----------------------|---------------------------------|
| O. D. Micrometer/20-21" | FZ3 | April 21, 1981 |
| O. D. Micrometer/16-17" | DZ5 | April 22, 1981 |

- B. Item C. of the Electrode Ovens section of Quality Engineering Instruction No. 005b, dated January 10, 1979, states in part, "minimum accuracy checks: (3) readings on the thermometer, at 1/4 scale, 1/2 and 3/4 scale.

Readings to be compared to the Potentiometer with stat (sic) thermocouples. Sufficient time is to be allowed for temperatures to equalize for each setting and the correction factors for the thermostat settings and thermometer readings are to be placed on the front of the oven door."

Contrary to the above, correction factors for the thermostat settings and thermometer readings had not been placed on the electrode ovens located at Departments 201 and 551 Tool Cribs.

- C. Paragraphs 7.1 through 7.4 of Manufacturing Engineering Standard No. 03:54:02, dated April 30, 1980, requires the completion, signing, reviewing, approving and filing of Calibration Certificates (Form No. 4932) for welder power sources that had been calibrated.

Contrary to the above, calibration certificates had not been completed, reviewed, approved and filed for the following welder power sources which had been calibrated:

| <u>Asset No.</u> | <u>Date of Calibration</u> |
|------------------|----------------------------|
| 30030 | April 30, 1981 |
| 31248 | April 30, 1981 |
| 31019 | April 30, 1981 |
| 30012 | April 30, 1981 |
| 16714 | April 30, 1981 |