Static Control Systems/3M
TCAAP 590
New Brighton, MN 55112

3M

QUALITY PLAN	85-1.32 1 Sep 1981

Rev. No.	Date	By	Change Description	Auth.	Date
A	10 Dec 81	RRH	Added Subparagraphs 4.3.4.3, 6.6, 8.3, 8.4, 8.5. Revised Paragraph 9.0 thru 9.3.4.	JWJ JMP RRH	12-15-81 12/15/81 12/15/81

Prepared By: R R Hedlund 15 DEC 81 Date

Approvals:
John W Johnson — Plant Manager — 12-15-81 Date
J M R Peterson — Q.C. Supervisor — 12/15/81 Date
Robert G Wiesnet — Chmn., Isotope Committee — 12/15/81 Date

Static Control Systems/3M
TCAAP 590
New Brighton, MN 55112

4. At lease one member of the Isotope Committee reviews and approves copies of purchase requisitions for radioactive material. If it appears that full Committee review is necessary, a meeting is held to review the intended use of radionuclides.

5. The Health Physicists on the Committee formally and informally audit the overall Radiation Safety Program and report to the Committee any observation of noncompliance activities as they pertain to NRC regulations or the 3M Health Physics Manual.

6. The Committee reviews and approves proposed amendments and revisions to the Health Physics Manual and USNRC License 22-00057-06 prior to their incorporation.

4.0 VENDOR PURCHASE ORDER

4.1 Scope

This policy applies to the selection of vendors of Type B transport containers.

4.2 Qualified Vendor Selection

Materials Control shall select all vendors from the Quality Control Approved Vendor List which is based on:

4.2.1 The ability of the vendor to conform to 10 CFR 71, Appendix E.

4.2.2 Vendor surveys

4.2.3 Past experience

4.3 Purchase Order Minimum Requirements

4.3.1 This is to include all purchase orders for rental, new equipment, repair or parts.

4.3.2 The user supervisor shall review with Quality Control the specification requirements.

4.3.3 All purchase orders will be sent to Quality Control for approval.

4.3.4 The Quality Control Supervisor will ensure the purchase order includes:

4.3.4.1 Any special inspection and/or tests required.

4.3.4.2 Certifications to be furnished.

4.3.4.3 Identification of applicable 10 CFR 71, Appendix E requirements.

4.4 Vendor Surveys

4.4.1 Vendor surveys will be performed by the Quality Control group, paying particular attention to the vendor's capability of complying with the elements of 10 CFR 71, Appendix E.

4.4.2 The Quality Control group will present a copy of the New Brighton Plant Vendor Manual to the vendor and use as a guide for survey.

4.4.3 The Quality Control group will complete Vendor Quality System Survey, Form 85-21.84.

Static Control Systems/3M
TCAAP 590
New Brighton, MN 55112

6.4 All conditions of the NRC package approval and the U.S. Department of Transporation shipping requirements shall be met.

6.5 All necessary shipping papers will be prepared as required. Departure, arrival time and route will be established and monitored consistent with safe transportation practices.

6.6 Modification of the shipping containers is not covered by this Q.A. program. However, if in the future, modification is planned this Q.A. program will be revised to address design control and submitted to the NRC for approval.

7.0 CALIBRATION

7.1 Scope

This section applies to all test and survey equipment used for Type B containers.

7.2 Calibration of all test and survey equipment shall be performed in accordance with Section 21.0 of the New Brighton Plant Quality Control Manual.

8.0 RECORDS

8.1 Scope

It is the purpose of this section to describe the manner in which final documentation is defined, assembled, retained and verified.

8.2 Where applicable, records must contain the following:

8.2.1 A description of the type of operation.

8.2.2 Evidence of completing the verified inspection or test operation.

8.2.3 Test Technician signature and date.

8.2.4 Information, related to conditions adverse to quality.

8.2.5 Identification of person reviewing results.

8.2.6 Evidence as to the acceptability of the results.

8.3 It is the responsibility of the Q.C. Supervisor to maintain a list of current revisions of instructions, procedures, specifications, drawings and procurement documents.

8.4 All records pertinent to the Q.A. program will be identified by the container serial number and retained for the life of the container.

8.5 Records controlled by this program:

Acceptance Test Data Sheet	85-2.4
Q.C. Specification	85-21.87
Q.C. Specification	85-21.88
Q.C. Specification	85-21.89
Q.C. Specification	85-21.90
Q.C. Specification	85-21.69
Equipment Calibration	85-21.66
Equipment Calibration	85-17.42
Discrepancy Report	85-1.24

Static Control Systems/3M
TCAAP 590
New Brighton, MN 55112

Vendor Survey	85-21.84
Container Audit Checklist	85-17.50
External Audit Records	
Training Records	

9.0 AUDITS

9.1 Scope

This section applies to all audits to ascertain compliance with this Manual.

9.2 Internal Audits

9.2.1 Internal audits will be performed by the Quality Control Supervisor periodically to insure compliance with the Q.A. program.

9.2.2 Deficiencies will be reported to the cognizant supervisor and the Static Control Systems Plant Manager.

9.2.3 The cognizant supervisor reports corrective action to the Plant Manager.

9.3 External Audits

9.3.1 External audits will be performed by the Health Physics Services resident Health Physicist on a semiannual basis.

9.3.2 The resident Health Physicist does not have direct responsibilities in this Type "B" Quality Program (refer to Section 3.2).

9.3.3 Results of the external audits will be reported to the Isotope Committee for action as necessary.

9.3.4 Deficiencies will be reaudited on a timely basis to verify corrective action.

10.0 TRAINING

10.1 Scope

This section applies to training of personnel performing activities affecting quality of Type B containers.

10.2 Training sessions will be held periodically to review program requirements for the area of responsibility of the personnel involved.

10.3 Training will be directed toward improved understanding of the requirements of this Manual.

11.0 APPENDICES

Vendor Quality Manual
85-21.84 - Vendor Quality System Survey
85-21.85 - Quality Control Specification - DOT 6M-15 Container
85-21.86 - Quality Control Specification - DOT 6M-15 Container
85-21.87 - Quality Control Specification - DOT 6M-15 Container
85-21.88 - Quality Control Specification - Spec 55 - R/A Container Return
85-21.89 - Quality Control Specification - Spec 55 - R/A Container Preparation & Release
85-21.90 - Quality Control Specification - R/A Material Container Checkout Procedures

Static Control Systems/3M
TCAAP 590
New Brighton, MN 55112

85-21.69, Rev. A - Quality Control Specification - DOT 6400 (Super Tiger) & DOT 6679 (Half-Super Tiger)
Section 21.0 - New Brighton Quality Control Manual
85-11.4, Rev. E - Shipping Checklist
85-17.50 - Q.C. Container Audit Checklist
85-3.1 - Smear Test Standard