

# Limatorque Corporation

Automated Valve Actuators and Jacks for Industry

5114 Woodall Road P.O. Box 11318 Lynchburg, VA 24506-1318  
 Telephone—804-528-4400 • Telex—82-9448 • FAX—804-845-9736



October 19, 1990

Nuclear Regulatory Commission  
 Vendor Inspection Branch  
 Division of Reactor Inspection and Safeguards  
 Office of Nuclear Reactor Regulation  
 Washington, DC 20555

ATTENTION: E. William Brach, Chief  
 Vendor Inspection Branch

SUBJECT: NRC Inspection Report 99900100/90-01  
 Notice of Non-Conformance Response

Gentlemen:

The following response is submitted for your consideration regarding the above referenced notice of non-conformance.

**DESCRIPTION OF THE STEPS THAT WILL BE TAKEN TO CORRECT THIS ITEM:**

- During the vendor branch inspection, Immediate Revision Notice (IRN) #1 was generated, approved and presented to the inspector as noted in the vendor branch inspection report . At the completion of the NRC inspection, Immediate Revision Notice #1 to QCP-10 was distributed on control distribution as an implemented revision to the procedure. A copy of the IRN and QCP-10 are attached for your information and use.

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 PDR GA999 EMVLMIT  
 99900100 PDC

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Page 2  
October 19, 1990  
NRC Inspection Report 99900100/90-01  
Notice of Non-Conformance Response

**DESCRIPTION OF THE STEPS WHICH HAVE BEEN TAKEN TO PREVENT RECURRENCE:**

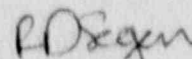
- QCP-10 has been revised by Immediate Revision Notice to prevent recurrence of the noted deficiency. In addition, IRN #1 to QCP-10 was distributed for training to insure implementation of the additional requirements. A copy of the Required Reading for Training documentation is attached for your information and use. Also attached are sample copies from the control distribution file for IRN #1 to provide objective evidence supporting the implementation of controlled copy distribution and acknowledgement.

**THE DATES THAT CORRECTIVE ACTIONS AND PREVENTIVE MEASURES WERE COMPLETED:**

IRN #1 to QCP-10 was approved and issued on June 14, 1990. Controlled distribution of IRN #1 to QCP-10 was completed on June 18th and all acknowledgements were received by 7/2/90. IRN #1 to QCP-10 training was completed on 7/2/90.

If you have any questions concerning the above corrective action and the implementation of the same, please do not hesitate to contact me directly.

Very truly yours,



R. D. Segen  
Quality Assurance Manager

LIMITORQUE CORPORATION

RDS/lab

Attachment

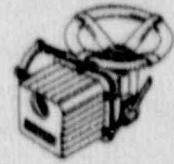
cc: Mr. Mignogna  
Mr. Kornsey  
Mr. Wilkinson  
NRC File

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## REVISION RECEIPT FORM

I hereby certify that the Quality Control Procedure revisions have been received and entered into the manual and all obsolete or superceded pages have been destroyed.

IRN #01 to QCP-10 REVISION NO. 7 DATED 05/30/87

COPY NO. 008

NAME Ken Maurer

TITLE Materials Manager

DEPARTMENT Purchasing Department

SIGNATURE *Ken Maurer*

DATE 6/22/90

NO SUBSEQUENT REVISIONS WILL BE ISSUED UNLESS THIS RECEIPT IS RETURNED

RETURN RECEIPT TO: Limitorque Corporation  
5114 Woodall Road  
Lynchburg, Virginia 24506

Attn: R. D. Segen  
Quality Assurance Manager

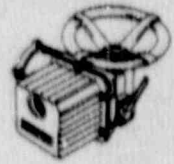


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IRN #01 to QCP-10 REVISION NO. 7 DATED 05/30/87

COPY NO. 011

NAME R. D. Segen

TITLE Quality Assurance Manager

DEPARTMENT Quality Assurance

SIGNATURE *R. D. Segen*

DATE 6-18-90

NO SUBSEQUENT REVISIONS WILL BE ISSUED UNLESS THIS RECEIPT IS RETURNED

RETURN RECEIPT TO: Limitorque Corporation  
5114 Woodall Road  
Lynchburg, Virginia 24506

Attn: R. D. Segen  
Quality Assurance Manager

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IRN #01 to QCP-10 REVISION NO. 7 DATED 05/30/87

COPY NO. 039

NAME Wm. J. Miluszusky

TITLE Quality Control Manager

DEPARTMENT Quality Control

SIGNATURE Wm J Miluszusky

DATE 6-30-90

NO SUBSEQUENT REVISIONS WILL BE ISSUED UNLESS THIS RECEIPT IS RETURNED

RETURN RECEIPT TO: Limitorque Corporation  
5114 Woodall Road  
Lynchburg, Virginia 24506

Attn: R. D. Segen  
Quality Assurance Manager

REQUIRED READING FOR TRAINING

OK  
GD

PURCHASING DEPARTMENT

IRN #1 to QCP-10 Revision 7 Dated 05/30/87  
 Titled: Purchasing Department Procedure

The attached QCP is being routed for Training. Please sign in the area provided indicating you have read, understand and will comply with the requirements of the attached procedure. Any discrepancies should be brought to the attention of your department manager.

PLEASE SIGN AND FORWARD TO NEXT INDIVIDUAL

NAME	SIGNATURE	DATE
Bill Kitusky	<i>Bill Kitusky</i>	6/21/90
Bobby Brown	<i>Bobby Brown</i>	6/27/90
Steve Farmer	<i>Steve Farmer</i>	6/27/90
Gladys Burley	<i>Gladys Burley</i>	6/27/90
Janice Wade	<i>Janice Wade</i>	6-27-90
Brenda Frazier	<i>Brenda Frazier</i>	6-28-90
Bruce Messner	<i>Bruce Messner</i>	6/27/90
Ken Maurer	<i>Ken L. Maurer</i>	7/2/90



REQUIRED READING FOR TRAINING

OK  
87

QUALITY ASSURANCE/QUALITY CONTROL

IRN #1 to QCP-10 Revision 7 Dated 05/30/87

Titled: Purchasing Department Procedure

The attached QCP is being routed for Training. Please sign in the area provided indicating you have read, understand and will comply with the requirements of the attached procedure. Any discrepancies should be brought to the attention of your department manager.

PLEASE SIGN AND FORWARD TO NEXT INDIVIDUAL

NAME	SIGNATURE	DATE
Rory Segen	<i>Rory Segen</i>	6-25-90
John Allen	<i>John Allen</i>	6/25/90
Frank Napoli	<i>Frank Napoli</i>	6/25/90
Wm. Miluszusky	<i>Wm. Miluszusky</i>	6-25-90
Ricky Pritt	<i>Ricky Pritt</i>	6-25-90
Dave Repass	<i>D. Repass</i>	6-25-90
Jim Harpe	<i>J Harpe</i>	6-25-90

RETURN TO: LOIS BARKSDALE, QUALITY ASSURANCE DEPARTMENT WHEN COMPLETED

IMMEDIATE REVISION NOTICE

QCP Number 10

Revision 7

TITLE Purchasing Department Procedure

IRN Number 01

Reason for the Change or Revision:

See Attachment

Procedure Revision (indicate exact point of change and wording to be inserted or deleted).

See Attachment

Originator Frank Nyot

Date 6/14/90

Approvals: James C. [Signature]  
Vice President - Manufacturing

Date 6-14-90

[Signature]  
Materials Manager

Date 6-14-90

[Signature]  
Quality Assurance Manager

Date 6-14-90

UNCONTROLLED  
COPY



Reason for the Change or Revision:

To address procedures established to assure the technical and quality requirement content of purchase orders for services which affect quality as it relates to supply of nuclear safety related actuators.

Procedure Revision (exact change):

Add the following to Page 19 section 4.0 (INSTRUCTIONS)

4.16 Purchase requisitions for services shall be prepared by the organization requesting the service.

(a) The preparer shall include, as a minimum, the following requirements for the type of service involved:

1. Requisitions for testing services shall include, as a minimum:
  - The approved vendor name and address.
  - Address the type of testing to be performed including the applicable ASTM, AISI, IEEE, etc. governing requirement, year, edition, class and grade.
  - Documentation required as a result of the testing such as: Certified Lab Test Report or Certificate of Compliance.
  - Identification of the item to be tested in such a manner to ensure traceability to the original lot or heat being tested.
2. Requisitions for services which relate to calibration shall, as a minimum, contain the following requirements:
  - The approved vendor name and address.
  - Reference to the instrument to be calibrated by model number, manufacturer and Limitorque QC number/serial number.
  - A statement requiring traceability to National Institute of Standards and Technology (NIST) formerly NBS. Require certification of calibration.

- Reference to any applicable code or standard.
- Identification of the "as found" and "as calibrated" data.

(b) Upon completion of the requisition, the preparer shall obtain his/her department manager's approval and forward the requisition to purchasing for issuance of a Purchase Order.

- 4.17 Any service not covered by the above requirements shall be prepared by the department requesting the service and the requisition forwarded to the Quality Assurance Manager for review and approval. The Quality Assurance Manager shall review the requisition for content to ensure that the proper technical and quality requirements are contained to assure that any service requested, which relates either directly or indirectly to the supply of Nuclear Safety Related actuators in accordance with Limitorque's 10 CFR 50 Appendix B program, are properly addressed.
- 4.19 All changes to issued purchase orders shall be reviewed and approved in the same manner as the original and shall not remove any of the requirements specifically specified by this procedure without approval of the Quality Assurance Manager.