



Westinghouse
Electric Corporation
July 7, 1982

Electrical Systems Division

Hunt Valley Plant
1111 Schilling Plaza
Hunt Valley Maryland 21031
(301) 667 1000

U.S. Nuclear Regulatory Commission
Office of Inspection and Enforcement
Region IV
611 Ryan Plaza Drive, Suite 1000
Arlington, Texas 76011

Subject: W ESD Quality Assurance Program Inspection Response

Attention: Mr. J. H. Tillou, Chief
Vendor Inspection Branch

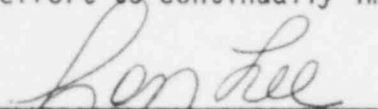
Dear Sir:

I have reviewed the inspection report dated 04/19-22/82 which documents the results of the visitation by W.M. McNeill of your office to the Westinghouse Electrical Systems Division on April 19-22, 1982.

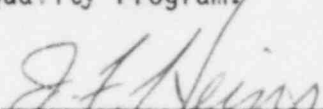
I appreciate the fact that your representative identified the nonconformance identified in B.5, however, these items would have been detected by our inspection, in as much as the inspection procedure requires review of all documentation prior to acceptance.

We have investigated your findings relative to the Quality Assurance Program and have addressed our response to these findings in the attached pages.

I want to assure you that we will continue to be responsive to the findings and recommendations of NRC representatives in an effort to continually improve our Quality Program.



R.W. Lee
Product Assurance Manager
Hunt Valley Plant



J.F. Heins
General Manager
Hunt Valley Plant

cc: W.M. McNeill, Reactive & Components
Programs Section (R&CPS)
Contractor Inspector
IV Branch

DESIGNATED ORIGINAL
Certified By Kheanne Joubert

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W ESD RESPONSE TO THE
NUCLEAR REGULATORY COMMISSION
QUALITY ASSURANCE PROGRAM
INSPECTION CONDUCTED ON
APRIL 19-22, 1982

FINDING A

No Quality Assurance Procedure established to address the qualification of the wire wrap process and personnel.

W ESD RESPONSE

Quality Assurance Procedure 10.3 has been written to address this finding. Quality Assurance Engineering will perform an internal audit of the special processes being performed. Each manufacturing supervisor has been provided with a list of those operators who have been certified to perform solderless wire wrap and termi-point wiring. Q.A.P. 10.3 was released 6/30/82. Internal audit will be performed during month of July 1982.

FINDING B

One operator performing termi-point wiring was found to not be certified in accordance with the procedure.

W ESD RESPONSE

All work performed by this operator was immediately inspected and found to be acceptable. Since this was the operators first day back to work from a maternity leave there is no concern of her having performed this operation on equipment recently shipped. As stated in response to Finding A an internal audit of this process is scheduled for July, 1982.

FINDING C

Process Specification (PS 82355HA) was not maintained at the Inspection Station.

W ESD RESPONSE

Quality Assurance Procedure 13.3 was revised to Revision B on March 31, 1982 which imposed the requirement for the inspector to maintain those process specs most frequently used at the station. The inspectors in the PC Board area are certified for the wire wrap process and the acceptance criteria. The process specification has been added to the log book at this inspection station.

FINDING D

Request for Engineering Action (REA's) forms did not have the assigned serial number entered.

W ESD RESPONSE

The subject REA's were generated by Engineering to permit the use of alternate parts. The date was intended to identify the break-in point. Both REA's have been corrected and now reference the applicable unit serial numbers. Those engineers who generate REA's have been made aware of this finding and instructed to use serial numbers when one has been assigned. During the internal audit of Document Control (82.17) scheduled for July, 1982, random REA's will be selected to verify similar conditions do not exist.

FINDING E

The following deficiencies were noted on equipment which had not been through the assembly inspection function.

1. Control tag did not reference the latest configuration.

W ESD RESPONSE

This was an oversight by the material control department. There were (21) assemblies involved of which (1) was not updated. Each material control person has been made aware of the deficiency and instructed as to the importance of keeping the configuration up to date on all equipment. Random sample of control tags did not reveal any similar conditions. Configuration verifications are a constant area that is audited and one of the major responsibilities of the inspector prior to acceptance.

2. Recording of operators signatures and dates was not accomplished.

W ESD RESPONSE

Tags have been corrected. A training session conducted on July 7, 1982 by the manager of Training and Development discussed in detail the Quality Assurance Procedure 14.0, Control Tag. This session instructed the manufacturing operators as to which blocks must be completed prior to inspection submittal.

3. Shortages were not identified on the control tag.

W ESD RESPONSE

The recording of these shortages was an oversight by the manufacturing operator.

A workplace meeting was held on July 2, 1982 to identify and discuss this finding with responsible manufacturing personnel. Additional assemblies waiting for inspection were reviewed and similar conditions did not exist.

4. Defective Article Report number was not entered on the control tag. Two non-applicable REA's had been recorded on the tags.

W ESD RESPONSE

This unit was going through the circuit check process by the test technician who was also assigned to perform the operating tests, which explains why the item was grouped under the test heading. The Defective Article Report is generated when defective parts are identified and require replacement during test. The subject components were the wrong parts which indicate a manufacturing error and the D.A.R. is not generated for this condition.

Test technicians and inspectors are required by Procedure Q.A.P. 14.4 to verify that D.A.R. tags are documented when applicable.

The two nonapplicable REA's were voided from the control tag. The responsible material control person entered the REA's in error.