

APPENDIX A

Rosemount, Inc.  
Docket No. 99900271/82-01

NOTICE OF NONCONFORMANCE

Based on the results of an NRC inspection conducted on June 7-11, 1982, 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. Paragraph 4.1.5 of Quality Implementation Procedure (QIP) 21(I), Revision D, dated May 21, 1981, "TITLE: Manufacturing Engineering Document Control," states, "Manufacturing Engineering will have the authority to red line the production copy of the detailed instructions, provided the red line copy is signed and dated. Red lined detailed instructions should be replaced within 30 days by an updated detailed instruction and cannot be used by Production more than 90 days."

Contrary to the above, Inspection Step 2.3 of Inspection Procedure 3799-2, Revision B, dated June 18, 1981, used for the Final Inspection of 1152 Pressure Transmitters, was noted to be in use with a 100-day old red line.

- B. Paragraph 4.1.5.1 of QIP 21(I), Revision D, states, "For Nuclear products all red lined instructions must be approved by the same groups responsible for the original document review unless another group has been designated. Red lined documents must be initialled and dated by the responsible groups near the changes."

Contrary to the above, "Nuclear Assembly Operations Sheet" Operation No. 3935-N, Revision B, Part Name "1153A - Series Header Assembly" step 3 had been red lined (changing cleaning method) without being initialled or dated.

- C. Section 4.5.6 of the Industrial Division Quality Assurance Manual, Revision G, dated February 26, 1982, states in part, "Manufacturing Engineering shall write and control current manufacturing procedures . . . ."

Contrary to the above, control of Travel Cards (Form 61024 Revision C), which are currently used in the final assembly of MODEL 1153 Pressure Transmitters, is not covered by a written procedure.

- D. Paragraph 4.2.2 of QIP 21(I), Revision D, states in part, "The traveller serves as a vehicle to specify, record and control the following: . . . Sequential listing of all operations, special processes, work stations, and latest applicable process specification and revision . . . ."

Contrary to the above, the Traveller for Part No. 01152-0033-0004, Revision F, Bill of Materials (BOM) Revision A, did not list the revision level of any of the listed Process Specifications.

- E. BOM 01153-0259-0052, Revision D, Run Date, September 8, 1981, for a sensor assembly requires Process Procedure 01153-3032, Revision D, "TITLE: Form and Serialize Procedure" for operational use.

Contrary to the above, the Nuclear Traveller for Part No. 01153-0259-0052, Revision E, for BOM Revision D, required Process Procedure 01153-3034, Revision D, for Operation No. 30. "Form and Serialize."

- F. Step 7 of Tig Center Weld Set-up in Stretch Weld Procedure 1153-3030, Revision B, dated October 12, 1979, and Step A of Verify Diaphragm Stretch require that data be logged on figure (2) "weld log" and figure (3) "verification log" of the respective steps.

Contrary to the above, the standard weld log and the sensor operation log had been used to record data, and not the figures as required by the procedure.

- G. Paragraph 4.2.2 of QIP 21(I), Revision D, states in part, "The traveller serves as a vehicle to specify, record and control the following: . . . Record of any rejects within the lot or serial number . . . ."

Contrary to the above, Nuclear Traveller for Part No. 01153-0259-0052, Revision E, for BOM, Revision D (Serial Nos. 749000-749199) whose final inspection was completed on June 9, 1982, did not indicate that 6 NB52 sensor cells had been rejected; i.e., Serial Nos. 749005, 749015, 749051, 749122, 749169, and 749176.