

APPENDIX A

Westinghouse Electric Corporation
Docket No. 99900294/82-01

NOTICE OF NONCONFORMANCE

Based on the results of an NRC inspection conducted on June 21-25, 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. Westinghouse Medium Motor and Gearing (MMG) Quality Assurance Manual, Section 2.0, "Organization," Revision 0, states in part: "Marketing Responsibilities assure that requirements are clearly and completely defined, and communicated to those responsible for meeting these requirements."

Contrary to the above, one of four general orders reviewed, namely NA 40236, was incomplete in that missing pages from two customer specifications were found; i.e., only the first two pages of the documents (Motor Specifications Sheet Numbers 1 and 2) were on file, although the documents were, respectively, four and five pages in length.

- B. Westinghouse Medium Motor and Gearing (MMG) Quality Control Instruction, Number 19, "Error Correction Tag (Form 18117)," dated October 16, 1970, states in part: "After the item has been satisfactorily repaired or corrected the Inspector stamps the back of the hardback copy and forwards it to his supervisor to clear the tag."

Contrary to the above, a review of current Error Correction Tags issued by assembly area B-8, showed that the hardback copies were not being stamped by the inspector after completion of satisfactory repair and reinspection.

- C. Westinghouse MMG Quality Assurance Manual, Section 5.0, "Document Control," Revision 0, requires document control measures to assure use of the latest revisions.

Contrary to the above, the Quality Control Instruction Book Number 3, on file at receiving inspection, did not contain Quality Control Instruction (QCI) Number 7, and the latest revision; (i.e., No. 2) of QCI Number 1.

- D. The Westinghouse corrective action response letters to NRC Inspection Report Nos. 99900294/81-01 and 99900294/78-01 commit to corrective and preventive action of automatically having the updated revision of a drawing or specification entered on applicable stock purchase orders.

Contrary to the above, none of the stock purchase orders reviewed during the inspection identified the revision of the referenced Purchase Department Specification.

- E. Westinghouse MMG Quality Assurance Manual, Section 6.0, "Measuring and Test Equipment," Revision 0, requires the calibration of measuring and test equipment to be controlled.

Contrary to the above, the temperature controller for oven number 6 in the "dip and bake" area was found to be in use and overdue for calibration. The calibration sticker indicated it was overdue as of May 31, 1982.

- F. Westinghouse MMG Quality Assurance Manual, Section 16.0, "Process Control," Revision 0, requires that process specifications identify essential variables and parameters to be controlled, Shop Practice Sheets to be issued with respect to operation of equipment in manufacturing processes, and inspectors and operators to use the inspection criteria identified in specifications.

Contrary to the above, the QA Manual was not fully implemented in the area of process control, as evidenced by the following examples:

1. The specifications for brazing (BMM 291397) and "dip and bake," (BMM 83334SC) did not define the applicable essential variables.
2. A Shop Practice Sheet was not issued for brazing, although the specifications contained very specific information on torch flame requirements for brazing. Furthermore, the Shop Practice Sheet for "dip and bake" did not contain the applicable tolerances identified in the process specification with respect to prebake time, temperature for removal from oven, baking temperature, and position of cores during "dip and bake."
3. The Shop Practice Sheets were not fully implemented in that the masking identified in Shop Practice Sheet Number 21 for the B-66 area was not performed.
4. Inspection criteria were not fully implemented in that the sediment checks and homogeneity checks were not performed as required by the specifications for "dip and bake." It was also noted that applicable process specifications were neither on file at operator's work location nor identified by work instructions.