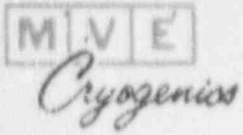


71-0583



MINNESOTA VALLEY ENGINEERING, INC.

407 SEVENTH STREET N.W., P.O. BOX 234
NEW PRAGUE, MINNESOTA 56071-0234

Ph.: 612-758-4484
Fax: 612-758-8293
Telex: 29-0571
Sales Ph.: 612-758-4400
Sales Fax: 612-758-8252

910128

Charles E. MacDonald, Chief
Transportation Branch
Division of Safeguards and
Transportation

Mr. MacDonald

I am requesting that our quality assurance program be renewed. I have enclosed a copy of our quality assurance program, Materials License, and the Quality Assurance Program Approval. There have been no changes in the (QA) program.

If you have any questions please call me at 612-758-4484.

Sincerely

Fred Bohnsack
Radiation Safety Officer

1/1
Rec'd 2/5/91
w/ck. # 56253
\$180.00

9102080131 910128
PDR ADOCK 07100583
C PDR

NT02

QUALITY ASSURANCE PROGRAM APPROVAL
FOR RADIOACTIVE MATERIAL PACKAGES

Pursuant to the Atomic Energy Act of 1954, as amended, the Energy Reorganization Act of 1974, as amended, and Title 10, Code of Federal Regulations, Chapter 1, Part 71, and in reliance on statements and representations heretofore made in Item 5 by the person named in Item 2, the Quality Assurance Program identified in Item 5 is hereby approved. This approval is issued to satisfy the requirements of Section 71.101 of 10 CFR Part 71. This approval is subject to all applicable rules, regulations, and orders of the Nuclear Regulatory Commission now or hereafter in effect and to any conditions specified below.

2. NAME Minnesota Valley Engineering			3. EXPIRATION DATE February 28, 1991
STREET ADDRESS 407 Seventh Avenue, NW			4. DOCKET NUMBER 71-0583
CITY New Prague	STATE MN	ZIP CODE 56971	

5. QUALITY ASSURANCE PROGRAM APPLICATION DATE(S)
February 11, 1986

6. CONDITIONS

- Activities authorized by this approval: procurement, maintenance, repair and use to be executed with regard to transportation packages in special form. All other shipping activities (i.e., design, fabrication, assembly, testing, and modification) shall be satisfied by obtaining certifications from package suppliers that these activities were conducted in accordance with an NRC-approved QA program. It shall remain the responsibility of the licensee-user that all transportation activities meet the requirements of 10 CFR 571.101.
- Records for each shipment of licensed material as required by 10 CFR 71.91(a) must be retained for a period of 2 years.

~~8603120486~~ IP.

FOR THE U.S. NUCLEAR REGULATORY COMMISSION

Charles E. MacDonald
Charles E. MacDonald

FEB 28 1986

CHIEF, TRANSPORTATION CERTIFICATION BRANCH
DIVISION OF FUEL CYCLE AND MATERIAL SAFETY
OFFICE OF NUCLEAR MATERIAL SAFETY AND SAFEGUARDS

DATE

MATERIALS LICENSE

Amendment No. 02

Pursuant to the Atomic Energy Act of 1954, as amended, the Energy Reorganization Act of 1974 (Public Law 93-438), and Title 10, Code of Federal Regulations, Chapter I, Parts 30, 31, 32, 33, 34, 35, 39, 40 and 70, and in reliance on statements and representations heretofore made by the licensee, a license is hereby issued authorizing the licensee to receive, acquire, possess, and transfer byproduct, source, and special nuclear material designated below; to use such material for the purpose(s) and at the place(s) designated below; to deliver or transfer such material to persons authorized to receive it in accordance with the regulations of the applicable Part(s). This license shall be deemed to contain the conditions specified in Section 183 of the Atomic Energy Act of 1954, as amended, and is subject to all applicable rules, regulations and orders of the Nuclear Regulatory Commission now or hereafter in effect and to any conditions specified below.

<p>Licensee</p> <p>1. Minnesota Valley Engineering, Inc.</p> <p>2. 407 Seventh Street, N. W. P. O. Box 234 New Prague, MN 56071-0234</p>		<p>In accordance with letter dated August 23, 1989, 3. License number 22-24393-01 is renewed in its entirety to read as follows:</p>	
		4. Expiration date	March 31, 1995
		5. Docket or Reference No.	030-18576
6. Byproduct, source, and/or special nuclear material	7. Chemical and/or physical form	8. Maximum amount that licensee may possess at any one time under this license	
A. Iridium-192	A. Sealed sources (Technical Operations Model A-424-9, Gamma Industries Model T-3-T, and Industrial Nuclear Model 7)	A. No single source to exceed 100 curies	
B. Cesium-137	B. Sealed sources (Technical Operations Model 77302)	B. One source not to exceed 165 millicuries	
9. Authorized Use			
A. For use in Technical Operations Model 660 exposure devices for industrial radiography and Technical Operations Model 650, Gamma Industries Model C-10, and Industrial Nuclear Model IR-50 source changers for storage and replacement of sources.			
B. For use in Technical Operations Model 773 instrument calibrator for calibration of licensee's own survey instruments.			

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MATERIALS LICENSE
SUPPLEMENTARY SHEET

License number

22-24393-01

Docket or Reference number

030-18576

Amendment No. 02

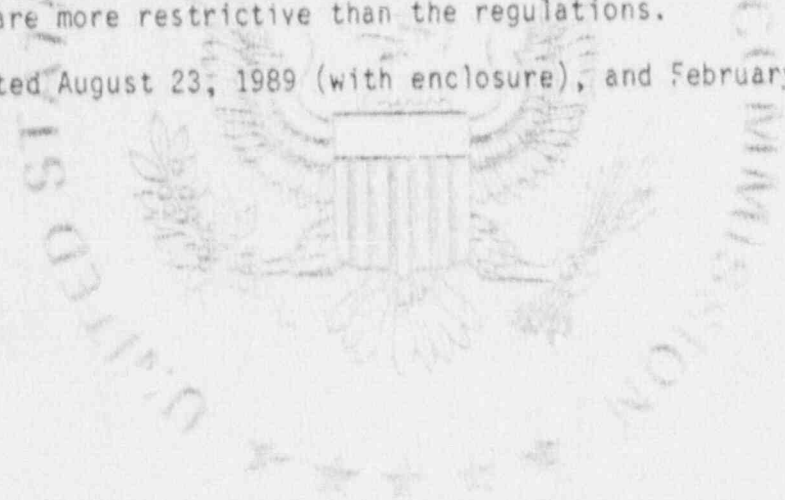
CONDITIONS

10. Licensed material shall be used only at the licensee's facilities located at 407 Seventh Street, N. W., New Prague, Minnesota.
11. Licensed material shall be used by, or under the supervision and in the physical presence of, Fred Bohnsack, Rick Minette, Dale Danielson, or individuals who have completed the training program described in enclosures to letters dated August 23, 1989 and February 9, 1990.
12. A. Notwithstanding the periodic leak test required by Section 34.25(b) of 10 CFR Part 34, such requirement does not apply to radiography sources that are stored and not being used. The sources excepted from this test shall be tested for leakage before use or transfer to another person.
B. Sealed sources authorized for a use other than radiography shall be tested as radiography sources in accordance with Section 34.25 of 10 CFR Part 34.
13. The licensee is authorized to receive, possess, and use sealed sources of iridium-192 or cobalt-60 where the radioactivity exceeds the maximum amount of radioactivity specified in this license provided:
 - A. Such possession does not exceed the quantity per source specified in Item 8 by more than 20% for iridium-192 or 10% for cobalt-60;
 - B. Records of the licensee show that no more than the maximum amount of radioactivity per source specified in this license was ordered from the supplier or transferor of the byproduct material; and
 - C. The levels of radiation for radiographic exposure devices and storage containers do not exceed those specified in Section 34.21 of 10 CFR Part 34.
14. Pursuant to 10 CFR Part 40, "Domestic Licensing of Source Material," the licensee is authorized to possess, use, transfer, and import up to 999 kilograms of uranium contained as shielding material in the radiography exposure devices and source changers authorized by this license.
15. Sealed sources containing licensed material shall not be opened.

MATERIALS LICENSE
SUPPLEMENTARY SHEET

License number	22-24393-01
Docket or Reference number	030-18576
Amendment No. 02	

16. The licensee may transport licensed material in accordance with the provisions of 10 CFR Part 71, "Packaging and Transportation of Radioactive Material."
17. The licensee shall limit the use of Booth 8 to Ir-192 sources having a maximum activity of 60 curies and, in addition, each time radiography is performed outside of a tank, a collimator of at least one-half value layer thickness shall be used to assure that radiation levels at roof areas above Booth 8 do not exceed 100 mR/hr.
18. The licensee shall maintain records of information important to safe and effective decommissioning at the address specified in Condition 10, per the provisions of 10 CFR 30.35(g) until this license is terminated by the Commission.
19. Except as specifically provided otherwise in this license, the licensee shall conduct its program in accordance with the statements, representations, and procedures contained in the documents including any enclosures, listed below. The Nuclear Regulatory Commission's regulations shall govern unless the statements, representations and procedures in the licensee's application and correspondence are more restrictive than the regulations.
 - A. Letters dated August 23, 1989 (with enclosure), and February 9, 1990.



For the U.S. Nuclear Regulatory Commission

Date: February 26, 1990

By Liam J. Huetter
Materials Licensing Section, Region III

APPENDIX H

1.0 A PROGRAM FOR TRANSPORTATION OF RADIOACTIVE MATERIALS

1.1 INTRODUCTION

- 1.1.1 This section identifies Minnesota Valley Engineering's Quality Assurance Program for the transportation of radioactive materials in accordance with 10 CFR Part 71. MVE is licensed under 10 CFR Part 34 for the use of IR-192 for purposes of industrial radiography.
- 1.1.2 This Section is applicable to any transportation package containing an IR-192 source in excess of 20 ci. delivered to a carrier.
- 1.1.3 MVE activities with respect to transportation packages includes: use, handling, inspection and maintenance. Design, fabrication, assembly and testing of transportation packages is by others. However, responsibility for compliance with Part 71 requirements is with MVE for those transportation packages which it utilizes and delivers to a carrier.

1.2 QA PROGRAM

- 1.2.1 This QA Program identifies the administrative controls to be followed to assure all requirements for transportation packages are being met. Written procedures needed for implementation of this program are identified in the Radiation Safety Manual. Control of this, including revision, will be as stated in Section 1.0 of the Radiation Safety Manual.
- 1.2.2 Attached to this section is a matrix identifying the requirements of the QA Program with the corresponding implementing procedures, and procurement of documentation and control of all NRC licensed equipment used by MVE. All certification and handling procedures will be on file in the Radiation Safety Office.
- 1.2.3 The company safety officer has over all administrative responsibility for this program. The radiation safety officer shall have specific implementing responsibility including training and certification of personnel, document control, and ensuring manufacturers design and QA program control.

1.3 ORGANIZATION

- 1.3.1 The organizational structure of MVE's Radiation Safety Program is depicted in figure 1. The specific individuals are as follows.
- 1.3.2 The President has overall responsibility and authority for the direction of MVE.

- 1.3.3 The company safety officer reports of the President and has overall responsibility and authority for the administration of the MVE Safety Program.
- 1.3.4 The Radiation Safety Officer has the authority and responsibility for the implementation of the Radiation Safety Program at MVE.

1.4 DOCUMENT CONTROL

- 1.4.1 Measures will be established to assure that documents relating to procurement, handling, storage, shipping and inspection of transportation packages are controlled. Changes to documents will be performed in accordance with written procedures.
- 1.4.2 The Radiation Safety Officer shall assure that QA functions are conducted in accordance with the latest approved requirements.

1.5 HANDLING, SHIPPING AND STORAGE

- 1.5.1 Measures shall be established to assure that handling, shipping, and storage requirements are completed and implemented in accordance with procedures prior to release of shipments.
- 1.5.2 Radiographers will implement the necessary activities.

1.6 INSPECTION

- 1.6.1 Measures shall be established to assure that appropriate inspections are completed and accepted prior to delivery of transportation packages to a carrier. The appropriate records shall be completed to indicate the inspection acceptance.
- 1.6.2 Nonconforming items shall be positively identified by use of status tags to prevent inadvertent use.
- 1.6.3 Radiographers will perform all necessary inspections directed by the Radiation Safety Officer.

1.7 RECORDS

- 1.7.1 A system shall be developed to assure appropriate records are maintained, identified, and easily retrievable.
- 1.7.2 The Radiation Safety Officer shall be responsible for implementing the records system in accordance with written procedures. These procedures shall identify the types of records under this program including manufacturer's Certificate of Compliance and reference drawing.

1.8 AUDITS

- 1.8.1 Measures shall be established to assure compliance to this program through audits utilizing written checklists.
- 1.8.2 Audits shall be conducted at least once a year and deficiencies evaluated and corrected. Auditors shall have no responsibility in the area audited.
- 1.8.3 Management shall be informed of audit results.