



Westinghouse Electric Corporation

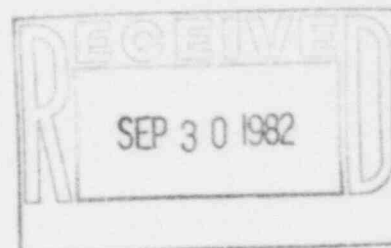
Industry Products Company

Medium Motor & Gearing Division

Box 225  
Buffalo New York 14240  
(716) 631 1000

September 24, 1982

United States Nuclear Regulatory Commission  
Region IV  
611 Ryan Plaza Drive  
Suite 1000  
Arlington, Texas 76011



Reference: Docket No. 99900294/82-01

Mr. Udis Potapous, Chief  
Vendor Program Branch

The following is in response to the findings from the audit conducted by Mr. W. M. McNeil on June 21-25, 1982.

- A. Pages from two customer specifications were missing from General Order NA40236.

Corrective Action: Copies of the two specifications were obtained from the district sales office and are on file in the General Order File.

Preventive Action: A letter has been sent by D.L. Hoover, Division General Manager, to the district sales offices requesting a copy of the customer's purchase order for any open Nuclear Safety Related Orders. These will be reviewed by MMG Marketing to verify that all applicable specifications are in the folder. Verification will be completed within one week of receipt of order.

- B. Error Correction Tags were not being stamped by the inspector after completion of the repair.

Corrective Action: This was reviewed with the inspectors by the QC Supervisors on 6/24/82.

A restatement of the requirements was given to the inspectors in a memo from R.F. McKeever dated 8/30/82.

Preventive Action: A special audit addressing the control of non-conformances will be conducted in all MMG manufacturing areas. Estimated completion date is 10/29/82.

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C. Document Control

The QCI Book #3 in Receiving Inspection was missing QCI number 7 and was one revision behind on QCI #1.

Corrective Action: The current documents were added to QCI Book #3 on 6/23/82.

Preventive Action: All QCI books will be reviewed by the QC Supervisors to assure the issued books are current. Estimated completion date is 10/1/82.

This item will be added to the section audits to assure an on-going check is made of the QCI books.

D. Purchased Material Documentation

The revisions of the PDS were not being included on the purchase orders.

Corrective Action: The revisions of the PD Specifications are being entered into the inventory file to assure that they appear on the purchase orders. Expected completion date is 12/31/82.

Preventive Action: The PDS revision is being entered into the inventory file on all newly authorized stock materials.

A review of the open purchase orders will be conducted to assure compliance with the corrective action. Estimated completion date is 12/31/82.

E. Control of Measuring and Test Equipment

One temperature control on oven number 6 was four weeks overdue for calibration.

Corrective Action: The control was calibrated on 6/25/82.

Preventive Action: The calibration recall and calibration program was reviewed and found to be adequate if followed.

The process gages under calibration will be added to the section gage list for regular monitoring during our monthly section audits. Estimated completion date is 10/30/82.

F. Process Control

1. The specifications for brazing (BMM291397) and dip and bake (BMM83334SC) did not define the applicable essential variables.

Corrective Action: The essential variables have been identified on the specification for dip and bake (BMM83334SC). The brazing specifications will be revised by 10/30/82.

Preventive Action: Process specifications and shop practices will be reviewed through section audits during our scheduled audits. This will be on-going and will commence with audits scheduled after September, 1982.

## 2. Shop Practice Sheets

- a. No shop practice sheet existed for brazing.

Corrective Action: A shop practice sheet will be prepared for brazing by 10/30/82.

- b. The shop practice sheet for dip and bake did not include the same tolerances as on the process specification.

Corrective Action: The shop practice sheet was revised 6/28/82 to agree with the process specification.

Preventive Action: The process specifications and shop practice sheets will be reviewed for agreement during our scheduled audits. This will be on-going and will commence with audits scheduled after September, 1982.

3. Shop practice sheets not fully implemented, in that masking of the stator cores was not accomplished.

Corrective Action: The masking was optional and this has been so stated in both the shop practice sheet #21 and process specification BMM83334SC. Completion date was 7/7/82.

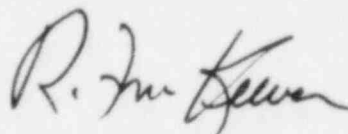
Preventive Action: Process specifications and shop practices will be reviewed through section audits during our scheduled audits. This will be on-going and will commence with audits scheduled after September, 1982.

4. Inspection criteria not fully implemented during varnish checks.

Corrective Action: The sediment and homogeneity checks are being made.

Preventive Action: The inspection criteria will be audited during the scheduled section audits. This will be on-going and commence with audits scheduled after September, 1982.

WESTINGHOUSE ELECTRIC CORPORATION



R. F. McKeever, Manager  
Quality Assurance