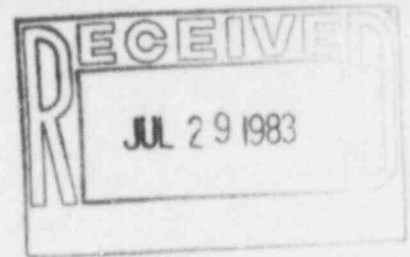


**Kaman
Instrumentation**

A KAMAN COMPANY



July 26, 1983
KI-GEN-83-017

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

Reference: NRC letter of July 8, 1983, Docket No. 99900802/83-01

Gentlemen:

In response to the Notice of Violation sent to us in your letter of July 8, 1983, be advised that we have done the following:

1. An amendment was issued to purchase order 5045 specifying that the provisions of 10CFR21 apply (Attachment A). This was done April 14, 1983.
2. To prevent recurrence, we have begun issuing purchase requisitions from our division to the division responsible for purchasing the mineral insulated cable. These purchase requisitions specify that the provisions of 10CFR21 apply. In addition, Kaman departments involved were told that all purchase orders for items designed specifically for nuclear applications were required to specify that the provisions of 10CFR21 apply. These departments included General Management and Material. Action to prevent recurrence was completed July 13, 1983.

8308160413 830811
PDR GA999 EMVKAMAN
99900802 PDR

July 26, 1983

With regard to your Notice of Nonconformance, the following corrective action has been accomplished:

Nonconformance A

KNP 30-1 has been revised on Page 5 to reflect the bonding and torquing specifications of drawing 952447-001 (Attachment B). This was done May 2, 1983.

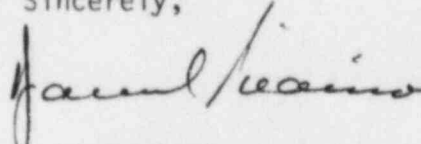
Nonconformance B

Engineering Operating Procedure 1.1, Exhibit 6.2 has been revised to reflect the contents of the Engineering Operating Procedures Manual (Attachment C). This action was completed May 4, 1983.

To prevent recurrence of documentation errors represented by nonconformances A and B above, document reviewers are being informed to be more thorough in their review of such documents, under the provisions of Quality Operating Procedure QOP 7-01. This action will be completed by August 29, 1983.

We hope that this letter satisfies your requirements. If you have any questions we will be happy to address them.

Sincerely,



Daniel Piraino
Vice President/General Manager
Engineered Systems Division

MG:tt

Kaman Instrumentation

Date: April 14, 1983

ARI Industries
381 ARI Court
Addison, IL 60101

Attn: S. Steinberg
D. Malcolm

SUBJECT: Kaman Instrumentation Purchase Order No. 5045

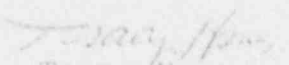
Dear Sir,

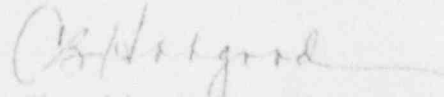
This letter serves as a change notice on the following items on the above subject purchase order:

The following is added to the P.O.: The requirements of Title 10, Chapter 1, Code of Federal Regulations, Part 21 "Reporting of Defects and Non-Compliance" applies to this order. A copy of this document and Public Law 93-438 Sect. 206, Oct., 11, 1974 are provided with this amendment for your convenience.

Please sign the acknowledgment copy of this letter and return to me.

Sincerely,


Tracy James
Buyer


Charlie Hoggood
Quality Assurance

cc: Accounting
Receiving
File

Acknowledgment: Accepted and agreed to by _____
this _____ day of _____.

4. Disconnect and remove the high range GM tube detector assembly, and return to Kaman.
5. Rework gas chamber brackets (See II A 3.b.) as follows and per attached sketches B and C.
 - a) Remove screws and washers from bracket assembly.
 - b) Carefully remove cushion (front) from long bracket 912846-001.
 - c) Apply front cushion to GM tube/cable mounting assembly 952785-001 with glue.
[820334-003 adhesive RTV 108/GE]
 - d) With screws and washers from step (a) assemble GM tube/cable mounting assembly 952785-001 to short bracket back cushion assembly 912847-001/912844-001.
[Torque screws to 32 in. lbs.]
6. Reinstallation
 - a) Reinstall gas detector retainer 912958-001
 - b) Install new gas chamber bracket assembly.
 - 1) With screw and washers from II A 3.a., attach new bracket to gas shield.
[Torque screw to 6 ft. lbs.]
 - 2) Insure sample tubes are spread to allow installation of new bracket.
 - c) Install new GM Tube, see 1.B.1(a)
 - 1) Remove nuts and washers from GM tube mounting bracket and install GM tube (as per sketch D).
 - 2) Route cable from both GM tube detectors through existing cable clamps.
 - 3) Reinstall nuts and washers on PEM studs on GM tube mounting bracket.
 - 4) Reconnect GM tube detector cable to electronics encl.

ATCH C



ENGINEERING OPERATING PROCEDURES

TITLE: PREPARATION OF ENGINEERING OPERATING PROCEDURES	APPROVED BY: <u>P. McMillin</u>
NUMBER: 1.1	ENGINEERING
REVISION: B	QUALITY ASSURANCE <u>MSJax 5-4-83</u>
DATE: May 4, 1983	PREPARED BY: <u>P. McMillin</u>
Exhibit 6.2	PAGE 3 OF 3

<u>SECTION</u>	<u>SUBJECT TITLES</u>
1.0	MANUALS AND PROCEDURES
2.0	ENGINEERING ORGANIZATION AND FUNCTION
3.0	PROPOSAL ACTIVITY
4.0	DESIGN CONTROL ACTIVITIES
5.0	DESIGN VERIFICATION AND QUALIFICATION
6.0	CHANGE CONTROL