



UNITED STATES  
NUCLEAR REGULATORY COMMISSION  
REGION III  
799 ROOSEVELT ROAD  
GLEN ELLYN, ILLINOIS 60137

October 6, 1983

MEMORANDUM FOR: J. J. Harrison, Chief, Midland Section  
FROM: B. L. Burgess, Resident Inspector, Midland  
SUBJECT: DOCUMENTATION OF MIDLAND CONCERNS

Per our phone conversation of September 29, 1983, I am writing to document past concerns associated with various topics provided to me by Midland Site employees during the last several months. These concerns are not allegations, and each individual was queried several times during our discussions to verify whether or not their concerns were to be treated as allegations.

- A. On July 26, 1981, I was approached at the Midland NRC trailers by a member of Bechtel Field Engineering to discuss a concern with the installation of shims in High Energy Line Break Accident (HELBA) whip restraints. The field engineer indicated at the five plants he had been associated with, whip restraint shims had been installed prior to Hot Functional Testing (HFT). At Midland, the HELBA whip restraints were not to be installed until after HFT. As whip restraint coordinator for Bechtel at Midland, the field engineer stated he had two concerns associated with not installing the shims before HFT: (1) a personnel safety concern in that someone could be seriously injured during an unexpected pipe movement caused by a bound pipe giving way due to thermal growth, and (2) an equipment safety concern - with a pipe break during HFT, the damage caused by lack of installed shims could be beyond that analyzed in the FSAR.

These concerns were relayed by myself to Consumers Power Company (CPCo) on July 27, 1983. On September 29, 1983, the licensee responded verbally to the concerns, and I relayed the CPCo response to the field engineer. CPCo has committed to installing procedural controls into HFT procedures to control excessive growth, binding, etc., and to insure that cognizant test personnel are aware of potential safety problems. In addition, a specification change is under consideration by project engineering in Ann Arbor to install shims in small bore piping HELBA whip restraints where anticipated growth of the piping is less than one sixteenth of an inch.

- B. On August 2, 1983, at the Midland NRC trailers, two Midland Plant Quality Assurance Department (MPQAD) QCEs relayed a concern involving the change of a welding specification M-326. The concern was about the recent change in the allowable undercut on 2 inch welds or greater to 1/8 inch. Prior to the change, 1/32 inch was the

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maximum undercut allowed on any size weld, according to the AWS code. When the QCE questioned Bechtel management as to the basis for the change, a code case was mentioned; however, specific details of the code case were not provided. Both individuals stated their concern had been passed to their management and to project engineering in Ann Arbor, and an acceptable response had not been received as to the basis for the specification change.

Just prior to the conclusion of the discussion, an additional concern was raised that a major change to Project Quality Control Instruction (PQCI) P-2.30 "Reinspection of Pipe (Component) Supports" had been implemented without sufficient retraining of Quality Assurance/Quality Control personnel.

The change to the undercut specification concern has been verbally transmitted to the region and preliminary investigation revealed that other operational and construction sites have changed their specifications on undercut of welds. A code case has not yet been identified as the basis for the undercut specification change. The major change to the PQCI is under review by the Midland Inspection Site Team and will be documented in a future report.



B. L. Burgess  
Resident Inspector  
Midland Site

cc: RIII File

DAILY REPORT RIII

DATE 10/07/83

FACILITY/LICENSEE	NOTIFICATION	ITEM OR EVENT	REGIONAL ACTION
OFFICE OF SPECIAL CASES			
MIDLAND		ON 10/11/83 RIII WILL HOLD AN ENFORCEMENT CONFERENCE WITH CONSUMERS POWER COMPANY MANAGEMENT TO DISCUSS THE RESULTS OF THE OI INVESTIGATION OF THE ALLEGED VIOLATION OF THE BOARD ORDER AND PROPOSED ESCALATED ENFORCEMENT ACTION.	INFORMATION.
ZIMMER		ON 10/11/83 MR. R. E. BUERGER, DAYTON POWER AND LIGHT COMPANY, WILL BE IN RIII TO DISCUSS FUTURE ACTIONS AT ZIMMER. HE WILL MEET WITH MESSRS. A. B. DAVIS, S. LEWIS, AND R. WARNICK.	INFORMATION.
MIDLAND 1 & 2	TELECON FROM SRI ON 10/05/83	BABCOCK & WILCOX (B&W), THE NUCLEAR STEAM SYSTEM SUPPLIER AND INSTALLATION CONTRACTOR FOR MIDLAND, PLACED A STOPWORK ON ALL CLASS I PIPE HANGER AND SNUBBER ACTIVITIES. THE STOP WORK WAS THE RESULT OF IDENTIFIED DEFICIENCIES (WELDING, BOLTING, ETC.) IN INSTALLED PIPE HANGERS AND SNUBBERS, MOST OF WHICH HAD BEEN PREVIOUSLY QC INSPECTED AND TURNED OVER TO CPCO. AS A RESULT OF THE STOP-WORK, 132 CRAFT AND SUPPORT PERSONNEL WERE LAID OFF. CORRECTIVE ACTIONS REQUIRED PRIOR TO RESUMING WORK INCLUDE THE DEVELOPMENT OF AN ADEQUATE TRAINING PROGRAM AND THE TRAINING OF B&W PERSONNEL TO THIS PROGRAM.	FOLLOWUP PER MC 2512.

OCT 20 1983



**Consumers Power Company**



General Offices: 212 West Michigan Avenue  
Jackson, Michigan 49201 (517) 788-0333

MIDLAND, MI, October 7, 1983 -- A comprehensive program to provide the planning and management for completion of the Midland Nuclear Plant has been approved by the US Nuclear Regulatory Commission.

Approval of the construction completion plan was announced late Thursday from NRC headquarters in Washington, D.C. The confirmatory order issued by the Commission culminates months of development and review of the plan by Consumers Power Company and Bechtel Power Corporation, members of the public and NRC staff. The order directs the Company to adopt and carry out the CCP.

"The Construction Completion Program will enable us to put into place a new set of objectives and procedures to complete the plant and meet all regulatory requirements and expectations to assure licensibility of the plant when construction is complete" said James W Cook, Consumers Power Company vice president for projects, engineering and construction.

"We will begin immediately with our plans to complete the Midland Nuclear Plant. Over the past ten months we have developed a detailed plan to assure the plant is completed successfully. We now will begin to carefully implement these plans, step by step as documented in our submittals to the NRC.

The overall plan for completing the Midland Plant has been developed in two major phases.

The first phase includes organization of workers from all project segments into teams to determine present installation and inspection status. A quality verification program (QVP) of completed work will proceed in parallel and includes a complete reinspection of accessible work, using recertified inspectors. The QVP will be carried out solely by the Midland Project Quality Assurance Department.

The second phase includes work completion under the team organization.

Following Phase 1 completion of the first verification and status assessment, a management review will be made of the results and of the process and procedures for the construction completion in Phase 2.

Another important part of the CCP is the third party review of work being performed. On October 3, the NRC approved the Stone & Webster Engineering Corporation to provide third party independent overview of work done at the Midland Plant.

Consumers Power announced in December 1982 that it was suspending most construction being performed by Bechtel Power Corporation on safety related equipment and would be proposing to the NRC a new plan to guide completion of the two-unit nuclear project. Today's announcement culminated the extensive development process necessary to initiate implementation of the plan.

As the warm weather continues and construction activity increases on the site, more visitors are expected to be touring the site. Groups from various engineering societies in the Saginaw Valley area, industrial development representatives, government officials, and other power company's employees have either toured or are planning on visits in the next few months.

In addition Consumers Power's Speakers

Power's project success community earned about the plant." Many of its members have also providing some of being used in co added another the nuclear plant is payroll for the core

# BETWEEN THE LINES

GM-0119

MIDLAND, October 13, 1983 --A new senior management team for Consumers Power Company's Midland Nuclear Plant has been announced jointly by James W Cook, vice president for projects, engineering and construction, and Russell B DeWitt, vice president, nuclear operations department.

Dean L Quamme has been named site manager and Joseph F Firlit has been named plant general manager. The two managers will share responsibilities to direct the completion, testing and initial operation of the Midland Nuclear Plant. Quamme succeeds Donald B Miller, who has left the Company, and Firlit succeeds Gerald B Slade, who has been named executive director of nuclear activities in the Company's nuclear operations department.

"The appointment of our new senior management team provides us with two men of proven experience, skills and ability in the nuclear energy industry," Cook said. "The Company's commitment to successfully complete the Midland Plant will be served well by these appointments. Working as a team they will direct the daily activities to complete construction and testing and prepare the plant for initial operation. These two men will join Roy Wells, executive director of Midland Project Quality Assurance Department, to direct all Company activities on site.

As site manager, Quamme will have overall administrative and management responsibility for the Midland site.

Quamme, 47, joined the Midland Project this summer in a project management staff position to vice president Cook. He previously had an extensive career in responsible management assignments with the General Electric Company Nuclear Energy Division and Ebasco Services, Inc., an engineer-contractor. His professional career has included management experience in craftsman supervision, nuclear plant operations, project engineering, marketing, construction and project management.

From 1977 to 1983 he worked for Ebasco Services at the Washington Public Power Supply System Nuclear Project 3 and 5. He was Ebasco construction manager from 1977 until 1980, when he assumed the role of project general manager. In that role, he was responsible for engineering and design, construction management and startup services.

Prior to his duties with Ebasco, he had worked from 1960 until 1977 for General Electric in its nuclear energy division. Included in these assignments were site manager on construction of the Tokai-2 project in Tokai-Mura Japan, construction engineer on the AKM project in Bern, Switzerland, and project engineer responsibilities with GE nuclear division in San Jose, CA.

Quamme received his bachelor of science degree in chemical engineering from Oregon State University and also attended the General Electric Company management training program.

He is a veteran of the US Army.

Quamme and his wife, Suzanne and child Tricia will soon be relocating to the Midland area.

(OVER)

Firlit, 46, joined Consumers Power Company in 1965 and held progressively more responsible positions, being named general supervisor of the research and testing lab in 1970.

In March, 1976 Firlit was promoted to general supervisor of special studies and resources. Later that year, he was named director of management and budget for the Company's nuclear operations department (NOD). Firlit was named director of NOD quality assurance in late 1980, a post he has held until today's appointment.

A native of Holland, Michigan, Firlit graduated from the University of Michigan in 1963 with a bachelor of science degree in electrical engineering. He received a master's degree in business administration from Wayne State University in 1972. Previous to his employment with the Company, Firlit was an electrical engineer with General Motors and was associated with the Apollo space program.

A veteran of the US Navy, Firlit, his wife Carol and two children will soon be relocating to the Midland area.

10/13/83

# New n-plant site manager selected

By PAUL RAU  
Daily News News Editor

A new site manager for the Midland nuclear plant has been selected by Consumers Power Co., which also announced a change in the plant's general manager.

The new site manager is Dean L. Quamme, who replaces Donald B. Miller Jr. Miller resigned from Consumers Power in late August to take a job with another utility, but is staying on until Oct. 21.

The site manager is the highest-ranking utility employee at the plant during the construction phase. After the plant is built and operating, the general manager will be in charge.

The new general manager is Joseph F. Firlit. He replaces Gerald B. Slade, who has been named executive director of nuclear activities in Consumers Power's nuclear operations department. The promotion of Slade into the newly created job means he will move from Midland to the utility's headquarters in Jackson.

The two managers will share responsibilities for plant completion, testing



Dean L. Quamme

and initial operation. The appointments were jointly announced this morning by CPCo Vice President James W. Cook and Russell B. DeWitt, vice president of the nuclear operations department.



Joseph F. Firlit

"THE APPOINTMENT of our new senior management teams provides us with two men of proven experience, skills and ability in the nuclear energy industry," Cook said.

He said Quamme and Firlit will join

Roy Wells, executive director of the nuclear plant's quality assurance unit, in directing all utility activities on site.

Quamme, 47, joined the Midland team this summer on Cook's staff. Before that, he had extensive experience with nuclear projects in General Electric Co.'s nuclear energy division and with Ebasco Services, an engineering/contracting firm.

From 1977-83, Quamme worked for Ebasco at the Washington Public Power Supply System nuclear units 3 and 5. His roles included construction manager and general manager.

With GE, he worked as site manager of the Tokai-2 plant in Tokai-Mura, Japan, and construction engineer on the AKM project in Bern, Switzerland.

Quamme has a bachelor of science degree in chemical engineering from Oregon State University and also attended GE's management training program.

He is a U.S. Army veteran. Quamme, his wife Suzanne and child Tricia soon will be relocating to Midland.

FIRLIT, 46, joined Consumers Power

# Kelley says EPA dioxin study invalid

MIDLAND (AP) — A federal plan for studying contamination by dioxin and other chemicals at Midland and other sites around the nation will leave "no proper scientific basis for drawing any reliable conclusions," Michigan's attorney general said Thursday.

Frank Kelley said the U.S. Environmental Protection Agency's strategy would allow too much variation be-

in the studies, and fragments the effort between so many offices of the EPA that continuity and scientific comparability will be virtually impossible," Kelley said in a speech prepared for delivery to the Midland Rotary club.

He said the plan calls for testing Midland soil, air and water samples for dioxin and 132 other chemicals at parts per trillion levels, while testing only will seek to detect parts per billion

know?" Kelley said.

However, Robert Hartian, a spokesman for the EPA's Midwest region, said Kelley's interpretation of the agency's strategy was incorrect.

According to Hartian, only dioxin will be measured at parts per trillion levels at Midland. The other chemicals will be measured at parts per billion levels at Midland and all the other test sites, he said.

The EPA began taking soil samples at Midland on Monday as part of its \$12 million national dioxin study.

Dioxin, specifically the form known as 2,3,7,8-TCDD, is one of the most toxic chemicals known. It is a byproduct of the production of certain herbicides, and has caused cancer and other ailments in test animals, although its known effect on humans has been limited to chloracne, a serious skin in-

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# STOP WORK ORDER

PROJECTS, ENGINEERING AND CONSTRUCTION -  
QUALITY ASSURANCE DEPARTMENT

PAGE 1 OF 3

<p>9. PROJECT: MIDLAND ENERGY CENTER Bechtel FSO MPOAD Soils</p>	<p>10. SUBJECT OF STOP WORK ORDER: All "Q" work to Bechtel Dwgs. and Spec.'s</p>	<p>1. STOP WORK ORDER NO: FSW-38</p>
<p>11. ORAL STOP WORK ORDER GIVEN: TO: AJBoos BY: RAWells DATE: 10-21-83 TIME: 9:50 P.M.</p>	<p>12. WORK STOPPED: DATE: 10-21-83 TIME: 10:30 P.M.</p>	<p>2. PREPARED BY: RLOliver <i>RLOliver</i></p> <p>3. DATE: 10-22-83 TIME: 5:40 P.M.</p>
<p>3. DESCRIPTION OF CONDITION REQUIRING STOP WORK ACTION:</p> <p>Problems with referencing of drawings and specifications in the BPCo FCR/FCN process have created an indeterminate condition with respect to work that has been or could be performed to "Q" listed drawings and specifications (Ref: Audit MSA-83-32).</p> <p>As a result of this condition the following stop work is being issued:</p> <ol style="list-style-type: none"> <li>1) BPCo Field or Project Engineering approval of FCR/FCN.</li> <li>2) Fabrication, installation and inspection of "Q" listed work in the Soils Area.</li> </ol> <p>(continued)</p>		<p>4. APPROVED BY: <i>Donald A. ...</i></p> <p>5. DATE: 10-22-83 10-22-83</p> <p>6. FILE: 16.13</p> <p>7. THIS STOP WORK ORDER ISSUED TO: Bechtel FSO Management (DHLavelle) MPQAD Soils (JKMeisenheimer)</p> <p>8. DISTRIBUTION:  see page 3 of 3</p>
<p>4. CORRECTIVE ACTION TAKEN:</p>		
<p>5. METHOD OF CORRECTIVE ACTION VERIFICATION:</p>		

## BLOCK 13 Cont'd

3) Allowable exceptions to the above items are as noted below:

- A) Actions to maintain safe plant working conditions.
- B) Actions to maintain calibrated instruments.
- C) Actions to implement the storage and maintenance program.
- D) Receipt of materials (no inspection for receipt acceptance to be performed).
- E) U.S. Testing activities.
- ? F) Surveying. *monitoring only*
- G) Freeze Wall operations and maintenance.
- H) Instrumentation monitoring.
- I) Maintenance of jacking system, wedge ringing, monitoring of jacking loads, routine jacking and non-routine jacking.
- J) Operation and maintenance of the Dewatering System.
- K) Backfilling in the area of 36"  $\emptyset$  casing.
- L) Training and certification of QA and QC inspection personnel.
- M) Training of PSO personnel.
- N) Continue with routine FIVP bolt monitoring.
- O) Maintenance of temporary electrical facilities.
- P) Maintenance and erection of temporary ventilation systems.
- Q) Routine maintenance and housekeeping.
- R) Work as required to secure all work areas and maintain all work areas including but not limited to:
  - a) Weather Protection
  - b) Backpacking
  - c) Slope Stabilization
  - d) Breastboarding
  - e) Concrete/Grouting - (Stripping/Curing)
  - f) Backfilling of shallow surface trenches

4) As a minimum, the following actions shall be taken prior to lifting this stop work order in part or totally:

- A) Perform a review and analysis to evaluate the extent of the problem.
- B) Take appropriate programatic action based on the results of Item 4A.
- C) Reinstruct BPCo - Project Engineering, Field Engineering and Document Control personnel in the generation, approval and distribution of the FCR/PCN forms to prevent the problem from recurring.
- D) Establish a mechanism for the lifting of this stop work on a partial basis.

FSW-38

Page 3 of 3  
Block 8 (Continued)

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General Offices: 212 West Michigan Avenue  
Jackson, Michigan 49201 (517) 788-0333

JACKSON, November 9, 1983 -- Preliminary indications from a study

being conducted by Consumers Power Company are that the commercial operation date of Unit 2, the all electric unit at its Midland Nuclear Plant, may be delayed until mid-1986.

Unit 2 had been scheduled to begin commercial operation in February 1985.

On October 6, 1983, the Company received notification from the Nuclear Regulatory Commission that it had approved the Company's Construction Completion Plan for the remaining work on the Midland Plant. The Plan, designed to overcome perceived quality assurance problems, is a comprehensive program for completion of the facility. NRC approval of the plan had been expected in the spring of 1983.

Consumers Power has been conducting a study to determine the impact of several factors on the estimated commercial operation date and cost of the all electric unit. The factors include the delay in NRC approval of the completion plan, implementation of that plan, the expanded reinspection required by the NRC in connection with implementation of the plan, plus the effect of decoupling construction of the second unit due to Dow Chemical Company's attempted withdrawal from a contract to purchase steam from Unit 1 of the plant.

The study is expected to be completed by the end of 1983.

The construction schedule for Unit 1 will be revised based on Company cash-flow requirements, the need for power, final cost estimates and the construction schedule for Unit 2.

The Company estimates that through 1983 approximately \$3.4 billion of costs will have been incurred for the Midland Plant. Expenditures after 1983 which are still under review are expected to increase substantially due to the delay in commercial operation.

CLIPPED FROM The Saginaw News page B4CLIPPED BY KL PockrandtDATE OF ISSUE 11/30/83 CITY Midland

# Soils work under NRC scrutiny

*Agency questions way Midland project tested for settlement*

BY KEITH NAUGHTON  
News Staff Writer

A federal agency is questioning the design of a soils underpinning project intended to support the building which will be the nerve center of the Midland Nuclear Plant.

Region III of the Nuclear Regulatory Commission is unhappy with the method of testing Consumers Power Co. has been using to determine how far the plant's auxiliary building and control tower can safely settle, according to J. Jay Harrison of the NRC. The auxiliary building will house equipment to operate the nuclear reactors when the plant goes on line.

An NRC memo released Monday states, "The NRC received additional information which calls into question the validity of the assumptions upon which the (NRC) staff's acceptance of the underpinning design was based."

The "additional information" comes from a review of soils work beneath the auxiliary building conducted by Region III. Following the review, the regional office in Chicago ordered a hold on further hydraulic jacking of supporting piers, said Harrison, chief of the Midland Section of the Office of Special Cases.

However, all soils work was stopped at the plant when Consumers Power issued nine stop-work orders Oct. 22 because of problems with design documents.

Consumers Power Co. spokesman Norman Saari said Tuesday the stop-work orders are expected to be lifted within a week. But Harrison said Consumers Power cannot lift the soils related stop-work orders until problems with mapping stress cracks at the auxiliary building are corrected. Stress cracks can be attributed to building settlement.

Region III of the Nuclear Regulatory Commission is unhappy with the method of testing Consumers Power Co. has been using to determine how far the plant's auxiliary building and control tower can safely settle, according to J. Jay Harrison of the NRC.

Saari said the utility is aware of the crack issue and is working toward a resolution.

Because soils beneath the auxiliary building were improperly compacted originally, 57 concrete piers are being placed underneath the building to support it. As each pier is completed, a hydraulic jack is placed on top of the pier. The jacks serve as a kind of shock absorber to handle the building's weight.

So far, 16 piers are installed and two are partially installed, according to NRC inspector Ross Landsman.

What is in question is the amount of pressure the jacks can withstand before the building will settle to an unsafe level, Harrison said.

"You don't want parts of the building sinking while they are going underneath the building," Harrison said.

If a section of the building sank, it would present a serious danger to the Mergentime Corp. workers involved in the largest underpinning of any structure ever, Harrison said.

Serious settlement also would cause additional stresses on the building, which would create cracks in the structure, he added. Those cracks could inhibit the safe operation of the plant's nerve center.

Consumers Power had allowed testing at the center of the auxiliary building, rather than at the edge where the most settlement is expected, Harrison said.

"We (Region III) don't think what they (Consumers Power) did is acceptable," he added.

Saari said Consumers Power will send a response to the NRC Dec. 9. The response will address the concerns Region III has about the pressure on the jacks, he added.

Region III has sent its assessments along to the NRC in Washington, D.C., and is waiting for the commission to make a determination on how to proceed with the underpinning, Harrison said.

In the meantime, the jacking process can only be performed now with approval from Region III, Harrison said.

"Jacking as a normal work activity at this point is not allowed," he said.

However, if jacking is a necessity to keep normal soil settlement in check, the NRC will allow it on a case-by-case basis, Landsman said.

October 31, 1983  
EN 83-69A

OFFICE OF INSPECTION AND ENFORCEMENT  
NOTIFICATION OF SIGNIFICANT ENFORCEMENT ACTION

Licensee: Consumers Power Company  
Midland Nuclear Power Plant, Units 1 and 2  
Docket Nos. 50-329 and 50-330

Subject: MODIFICATION TO EN 83-69

This is to inform the Commission that the Notice of Violation and Proposed Imposition of Civil Penalty discussed in EN 83-69 was not issued on October 26, 1983. Another enforcement conference is scheduled for November 4, 1983 to discuss the excavation and fire-line relocation activities. A decision on whether to propose enforcement action will be made after that meeting.

Contact: G. Klingler, IE 24923 J. Axelrad, IE 24909

Distribution:

H St <u>1:20</u>	MNBB <u>mail</u>	Phillips <u>1:25</u>	EW _____	Willste <u>1:23</u>
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