

APR 1 1985

MEMORANDUM FOR: Vincent S. Noonan, Director
for the Comanche Peak Task Force
Division of Licensing
Office of Nuclear Reactor Regulation

FROM: Gary G. Zech, Chief
Vendor Program Branch
Division of Quality Assurance, Vendor
and Technical Training Center Programs
Office of Inspection and Enforcement

SUBJECT: ALLEGATION CONCERNING VENDORS USED AT
COMANCHE PEAK

In January 1985, the VPB performed inspections of Litton-Veam and Weidmuller Terminations in response to your memorandum dated December 7, 1984. The Inspection Report Nos. 99900896/85-01 and 99900897/85-01 for the above organizations have been issued and we are sending you copies for transmittal to the allegor. This action is taken in accordance with the policy outlined in proposed NRC manual chapter 517, "Management of Allegations."

Should you have any questions with regard to this matter please contact Messrs. E. W. Merschhoff (492-9045) or R. E. Oller (492-4638).

ORIGINAL SIGNED BY:
GARY G. ZECH

Gary G. Zech, Chief
Vendor Program Branch
Division of Quality Assurance, Vendor
and Technical Training Center Programs
Office of Inspection and Enforcement

cc: E. Fox, IE

Distribution
Roller, IE
EMerschhoff, IE
GZech, IE
VPB Reading
DMB-IE:09

VPB/IE
Roller:gmK
3/27/85

SC/VPB/IE
EMerschhoff
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GZech
3/28/85

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UNITED STATES
NUCLEAR REGULATORY COMMISSION
WASHINGTON, D. C. 20555

FEB 22 1985

Docket No. 99900896/85-01

Veam, Division of Litton
Systems Inc.
ATTN: Dorine K. Sweet
Quality Control Manager
100 New Wood Road
Watertown, Ct. 06795

Gentlemen:

This refers to the inspection conducted by Mr. R. E. Oller of this office on January 7-8, 1985, of your facility at Watertown, Connecticut, and to the discussions of our findings with Mr. A. J. Bernardini and members of the plant staff at the conclusion of the inspection.

This inspection was made as a result of an allegation concerning inadequacies in your QA program as it might affect the quality of electrical equipment furnished to Comanche Peak Station. Areas examined during the inspection and our findings are discussed in the enclosed report. Within these areas, the inspection consisted of an examination of procedures and representative records, interviews with personnel, and observations by the inspector.

During the inspection it was found that the implementation of your QA program failed to meet certain NRC requirements. The specific findings and references to the pertinent requirements are identified in the enclosures to this letter.

Please provide us within 30 days from the date of this letter a written statement containing: (1) a description of steps that have been or will be taken to correct these items; (2) a description of steps that have been or will be taken to prevent recurrence; and (3) the dates your corrective actions and preventive measures were or will be completed. Consideration may be given to extending your response time for good cause shown.

The responses requested by this letter are not subject to the clearance procedures of the Office of Management and Budget as required by the Paperwork Reduction Act of 1980, PL 96-511.

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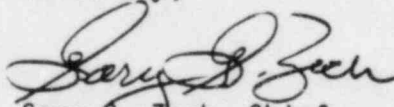
Veam, Division of
Litton Systems, Inc.

- 2 -

In accordance with 10 CFR 2.790 of the Commission's regulations, a copy of this letter and the enclosed inspection report will be placed in the NRC's Public Document Room. If this report contains any information that you believe to be exempt from disclosure under 10 CFR 9.5(a)(4), it is necessary that you (a) notify this office by telephone within 10 days from the date of this letter of your intention to file a request for withholding; and (b) submit within 25 days from the date of this letter a written application to this office to withhold such information. If your receipt of this letter has been delayed such that less than 7 days are available for your review, please notify this office promptly so that a new due date may be established. Consistent with Section 2.790(b)(1), any such application must be accompanied by an affidavit executed by the owner of the information which contains a full statement of the reasons on the basis which it is claimed that the information should be withheld from public disclosure. This section further requires the statement to address with specificity the considerations listed in 10 CFR 2.790(b)(4). The information sought to be withheld shall be incorporated as far as possible into a separate part of the affidavit. If we do not hear from you in this regard within the specified periods noted above, the report will be placed in the Public Document Room.

Should you have any questions concerning this inspection, we will be pleased to discuss them with you.

Sincerely,



Gary G. Zech, Chief
Vendor Program Branch
Division of Quality Assurance, Vendor
and Technical Training Center Programs
Office of Inspection and Enforcement

Enclosures:

1. Appendix A - Notice of Nonconformance
2. Appendix B - Inspection Report No. 99900896/85-01
3. Appendix C - Inspection Data Sheets (4 Pages)

APPENDIX A

NOTICE OF NONCONFORMANCE

Based on the results of an NRC inspection conducted on January 7-8, 1985 it appears that certain of your activities were not conducted in accordance with NRC requirements.

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. Paragraph 2.3.1 of Part 2 of the Veam QA manual, Revision A, dated July 1981, with regard to internal audits, states in part, "... The audit is performed by an impartial person.... The auditors have no line responsibilities in the area involved...."

Contrary to the above, the lead auditor who performed the annual QA program audit in April 1983 held the official position of QA Manager. The lead auditor who performed the February 1984 annual QA program audit held the official position of QC Manager.

- B. Paragraph 3.1.4 of Section 13 of the Veam QA manual, Revision A, dated July 1981, with regard to the responsibilities of the Quality Control Department, states, "... assure that outside laboratories used for calibration services are on the Approved Vendors List."

Contrary to the above, Gage Lab Company calibration service was not on the Approved Vendor List.

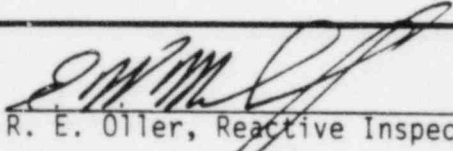
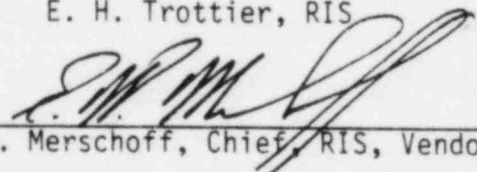
- C. Paragraph 2.1 of Section 13 of the Veam QA manual, Revision A, dated July 1981, states, "Measuring and testing equipment will be calibrated against certified equipment having known valid relationship to nationally recognized standards."

Contrary to the above, no evidence was available to verify that the temperature controls on the two ovens used to cure connector insert adhesives had ever been calibrated.

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ORGANIZATION: VEAM, DIVISION OF LITTON SYSTEMS INC.
WATERTOWN, CONNECTICUT

REPORT NO.: 99900896/85-01	INSPECTION DATE(S): 1/7-8/85	INSPECTION ON-SITE HOURS: 35
CORRESPONDENCE ADDRESS: Veam, Division of Litton Systems Inc. ATTN: Dorine K. Sweet Quality Control Manager 100 New Wood Road Watertown, Ct 06795		
ORGANIZATIONAL CONTACT: Dorine K. Sweet, QC Manager TELEPHONE NUMBER: (203) 274-9681		
PRINCIPAL PRODUCT: Electrical Multipin Cylindrical Metal Shell Connectors NUCLEAR INDUSTRY ACTIVITY: Approximately 10%		
ASSIGNED INSPECTOR:  FOR R. E. Oller, Reactive Inspection Section (RIS)		2/13/85 Date
OTHER INSPECTOR(S): J. J. Petrosino, RIS E. H. Trottier, RIS		
APPROVED BY:  E. W. Merschhoff, Chief, RIS, Vendor Program Branch		2/13/85 Date
INSPECTION BASES AND SCOPE: A. <u>BASES</u> : 10 CFR Part 21 and Appendix B to 10 CFR Part 50. B. <u>SCOPE</u> : This inspection was made as a result of an allegation concerning inadequacies in the contents of the vendor's QA program as it applies to furnishing of electrical equipment for use in Comanche Peak Station. Concurrently, selected areas of the QA program and the vendor's compliance with 10 CFR Part 21 requirements were inspected.		
PLANT SITE APPLICABILITY: QA program deficiencies 50-445.		

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ORGANIZATION: VEAM, DIVISION OF LITTON SYSTEMS INC.
WATERTOWN, CONNECTICUT

REPORT
NO.: 99900896/85-01

INSPECTION
RESULTS:

PAGE 2 of 4

A. Violations:

None

B. Nonconformances:

1. Contrary to Criterion V of Appendix B to 10 CFR Part 50 and paragraph 2.3.1 of Part 2 of the Veam QA manual Revision A, the lead auditor who performed the annual QA program audit in April 1983, held the official position of QA Manager, and the lead auditor who performed the February 1984, annual QA program audit held the official position of QC Manager.
2. Contrary to Criterion V of Appendix B to 10 CFR Part 50 and paragraph 3.1.4 of Section 13 of the Veam QA manual Revision A, the Gage Lab Company calibration service was not on the Approved Vendor List.
3. Contrary to Criterion V of Appendix B to 10 CFR Part 50 and paragraph 2.1. of Section 13 of the Veam QA manual, Revision A, no evidence was available to verify that the temperature controls on the two ovens used to cure connector insert adhesives had ever been calibrated.

C. Unresolved Items:

None

D. Other Findings or Comments:

1. Initial Management Meeting and Exit Interview:

The Litton Veam management representatives were provided background information on the allegation which was the reason for the inspection. They were also given an overview of the NRC organization activities and responsibilities. They were informed of the NRC's authority and responsibility as described in Section 206 of the Energy Reorganization Act of 1974 and its implementing regulation 10 CFR Part 21. The scope of the inspection and its required documentation were explained. During the exit meeting, the written responses required of the vendor to the Notice of Nonconformance were explained, as well as the inspection findings.

REPORT
NO.: 99900896/85-01

INSPECTION
RESULTS:

PAGE 3 of 4

2. Allegation:

a. Introduction:

On November 28, 1984, the NRC received information with regard to potential deficiencies in the quality assurance program of the Litton Veam plant located in Watertown, Connecticut, as it applies to the manufacture and furnishing of terminations for electrical cable for possible use in safety-related systems at Comanche Peak Station. As a result of this allegation, an NRC inspection was performed at the Litton Veam plant on January 7-8, 1985.

b. Findings:

The Litton-Veam plant is a manufacturer of electrical multipin cylindrical metal shell connectors for cables. From December 1977 through June 1981, their QA program was documented in a manual called "Litton Precision Products International Quality Procedure", dated December 1977. This manual contained statements of: (a) quality and reliability assurance policy, (b) a quality assurance plan, and (c) quality assurance status reporting, and ten (10) quality control procedures. The QA statement addressed the requirements of Mil-Standards No. Mil-I-45208 (for inspection), No. Mil-C-45662 (for calibration) and No. Mil-Q-9858 (for the quality program) and a statement that the plan met Quality and Reliability Standards of 10 CFR 50. However, the QA manual did not meet all of the requirements of the 18 criteria of Appendix B to 10 CFR 50, nor did it address them. In July 1981, the manual was revised and issued as the "Veam Quality Assurance Manual", Revision A. This QA manual addresses all of the 18 criteria of Appendix B to 10 CFR 50, and the requirements of ANSI N45.2. Implementing procedures are contained in the shop procedure manual.

c. Conclusion:

Based on the above review, it was determined that the allegation of deficiencies in the Veam QA program with regard to Appendix B to 10 CFR 50 was valid as it applied to the QA program prior to July 1981. However, the quality program in effect prior to 1981 appeared to provide an adequate process quality control program.

ORGANIZATION: VEAM, DIVISION OF LITTON SYSTEMS INC.
WATERTOWN, CONNECTICUT

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NO.: 99900896/85-01

INSPECTION
RESULTS:

PAGE 4 of 4

3. Other QA Program Areas Inspected

Concurrently with the allegation followup, an inspection was made of the following areas of the current QA program: (a) procurement document control; (b) quality assurance records; (c) internal audits; (d) measuring and testing equipment calibration, and (e) compliance with 10 CFR Part 21. This inspection was accomplished by review of procedures and records related to electrical connectors furnished for Comanche Peak Station; programmatic records; observations in the shop, and discussions with cognizant management personnel.

As a result of this inspection, three nonconformances were identified. These items included: (a) failure to use internal audit personnel who were free of line responsibility for the areas audited; (b) the use of a calibration contractor who was not on the Approved Vendor List, and (c) failure to calibrate the controls on two ovens used to cure connector insert adhesives.

INSPECTOR OliverSCOPE All DocumentsLitton Veam

DOCUMENTS EXAMINED

DOCKET NO. 99900896REPORT NO. 85-01PAGE 1 OF 1

ITEM NO.	TYPE OF DOCUMENT	DOCUMENT NO.	REV.	DATE	TITLE / SUBJECT
1.	QCD	-		Dec 1977	"Litton Precision Products International Quality Procedure" manual.
2	QAM	-	A 781		"Veam Quality Assurance Manual"
3.	INM	-	-	-	Management Policy For The Quality Program
4	PRO	Various	-	Various	Relan shop QC procedures, Nos 167, 181, 182, 183, 184, 186, 190, 191, 192, 193 and 196
5	QCD	-	-	1983	Approved Vendor List
6	QCD	-		Apr 1983	Records of Internal Audit of QA Program
7	QNM	-		4-2-83	Memo concerning status of QA Manager who performed as official auditor for 1982-83 QA program audit.
8	QCD	-	-	2-13-84	Records of Internal Audit of QA Program
9	QCD	-	-	Various	Lead auditor training records

TYPE OF DOC.:

DWG - DRAWING
SPEC - SPECIFICATION
PRO - PROCEDURE
QAM - QA MANUAL
QCD - QC DOCUMENT
P.O. - PURCHASE ORDER
INM - INTERNAL MEMO

LTR - LETTER

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-
-
-
-

INSPECTOR G. H. TROTTER
 SCOPE ALL Documents
Letter - VEA

DOCKET NO. 99900896
 REPORT NO. 85 - 01
 PAGE 1 OF 1

DOCUMENTS EXAMINED

ITEM NO.	TYPE OF DOCUMENT	DOCUMENT NO.	REV.	DATE	TITLE / SUBJECT
1	QAM		A	7/81	VEAM Quality Assurance Manual
2	P.O.	CPF-1538	-	6/7/83	Order from TVACo for 6 Connectors + Potting Compound (Resorcin)
3	B of M	-	-	-	Bill of Material for P/N C1R03TV-24-28P-TC and C1R06GH & 285-TC
4	Cal Cert	-	-	8/29/84	Calibration Certificate (Traceable to NBS) for Bravis Sharp 50 Blocker
5				5/5/83	
6				6/2/82	
7	Cal Recd	-	-	6/8/84	Calibration Record of Depth Gauge # 2416-10 (Mfg by Mitutoyo)
8	Cal Recd	-	-	4/4/83	Calibration Record of Dial Vernier # 008 (Mfg by Starrett)
9	Cal Recd	-	-	4/4/84	
10	Cal Recd	-	-	8/1/84	Calibration Record of Plug Gauges # 025A+B (Size 1.1250)
11	Cal Recd	-	-	6/4/84	Calibration of 60-1060 Thread Ring Gauges # 014A+B
12	QCD	-	-	7/14/81	Inspection History Card (Form QC-22) for Jan NUT
13	QCD	-	-	7/31/81	Inspection History Card (Form QC-22) for Jan NUT
14	QCD	-	-	5/19/82	Inspection History Card (Form QC-22) for Jan NUT

TYPE OF DOC:

DWG - DRAWING
 SPEC - SPECIFICATION
 PRO - PROCEDURE
 QAM - QA MANUAL
 QCD - QC DOCUMENT
 P.O. - PURCHASE ORDER
 IIM - INTERNAL MEMO

LTR - LETTER
 BOM - Bill of Material
 Cal Cert - Calibration Certificate
 Cal Recd - Calibration Record

INSPECTOR Retrosino
 SCOPE VEAM - Allegation
All documents

DOCKET NO. 99008%
 REPORT NO. 85 - 01
 PAGE 1 OF 2

DOCUMENTS EXAMINED

ITEM NO.	TYPE OF DOCUMENT	DOCUMENT NO.	REV.	DATE	TITLE / SUBJECT
1	Vendor History	- Memo -	-	4/4/84	Outside Vendor history records
2	Vendor History	- Memo -	-	6/5/84	" " " "
3	Outside Audit	-	82	9/12/83	Vendor Audit of an Engineering & manufacturing firm
4	Outside Audit	-	82	10/3/83	" " " Rubber Molding Manufacture
5	Supplier Self Audit	19332	-	10/1/81	Self audit Quality Report of above Rubber Mfg
6	P.O.	2-0232	-	1/19/81	Cable Mfg PO To Veam - CoC required
7	CoFC	12179-21896	-	12/17/84	A/E was supplied CoFC backed by VEAM report # 0041
8	CoFC	12179-20717	-	10/11/84	" " " " " " " "
9	VEAM PO	4US-7486	-	10/13/81	VEAM To Vendor #00600 - Composite Back.
10	CoFC	4US-7489	-	10/30/81	Vendor #00600 CoFC
11	VEAM PO	4US-7489	-	10/21/81	" #00600 VSO-1378
12	VEAM PO	4US-7478	-	10/13/81	" #00600 - (Westinghouse Backshell)
13	VEAM PO	4US-7436	-	10/6/81	" #00600 - (VSO-1372)
14	CoFC	4US-7436 (0028)	-	11/10/81	" #00600 - " PO Composite " Pwy # 47133-18-04-98-LH - Metric & JTB
15	Veam PO	4US-7393	N/A	9/23/81	Veam PO To Vendor # 000230 - Amendment A was written & attached - Clause 1 & 2

TYPE OF DOC:

DWG - DRAWING
 SPEC - SPECIFICATION
 PRO - PROCEDURE
 QAM - QA MANUAL
 QCD - QC DOCUMENT
 P.O. - PURCHASE ORDER
 INM - INTERNAL MEMO

LTR - LETTER

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SCOPE VEAM. Allegation

ALL DOCUMENTS

DOCUMENTS EXAMINED

Docket No. 999 00896

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PAGE 2 OF 2

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TYPE OF DOC:

DWG - DRAWING
SPEC - SPECIFICATION
PRO - PROCEDURE
QAM - QA MANUAL
QCD - QC DOCUMENT
PO - PURCHASE ORDER
INH - INTERNAL MEMO

LTR - LETTER

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PERSONS CONTACTED

Company Lifton Veam

Dates January 7-8, 1985

Docket/Report No. 99900896/85-01

Inspector Allen/Trotter/Petro

Page 1 of 1

* Attended exit meeting.

NAME(Please Print)

TITLE(Please Print)

ORGANIZATION(Please Print)

[illegible]



UNITED STATES
NUCLEAR REGULATORY COMMISSION
WASHINGTON, D. C. 20555

FEB 26 1985

Docket 99900897/85-01

Weidmuller Termination Inc.
ATTN: Mr. John Tyler
Vice President and
QA Manager
821 Southlake Blvd.
Richmond, Virginia 23236

Gentlemen:

This refers to the inspection conducted by Mr. R. E. Oller of this office on January 9-11, 1985, of your facility at Richmond, Virginia, and to the discussions of our findings with Mr. H. H. Renner and other members of the plant staff at the conclusion of the inspection.

This inspection was made as a result of an allegation concerning possible deficiencies in the contents of your QA program as it applies to the furnishing of Class 1E terminal blocks to Comanche Peak station.

Areas examined during the inspection and our findings are discussed in the enclosed report. Within these areas, the inspection consisted of an examination of procedures and representative records, interviews with personnel, and observations by the inspector.

During the inspection it was found that the implementation of your QA program failed to meet certain NRC requirements. The specific findings and references to the pertinent requirements are identified in the enclosures to this letter.

Please provide us within 30 days from the date of this letter a written statement containing: (1) a description of steps that have been or will be taken to correct these items; (2) a description of steps that have been or will be taken to prevent recurrence; and (3) the dates your corrective actions and preventive measures were or will be completed. Consideration may be given to extending your response time for good cause shown.

The response requested by this letter is not subject to the clearance procedures of the Office of Management and Budget as required by the Paperwork Reduction Act of 1980, PL 96-511.

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Weidmuller Terminations Inc.

- 2 -

In accordance with 10 CFR 2.790 of the Commission's regulations, a copy of this letter and the enclosed inspection report will be placed in the NRC's Public Document Room.

Should you have any questions concerning this inspection, we will be pleased to discuss them with you.

Sincerely,

Gary G. Zech, Chief
Vendor Program Branch
Division of Quality Assurance, Vendor
and Technical Training Center Programs
Office of Inspection and Enforcement

Enclosures:

- 1 Appendix A - Notice of Nonconformance
- 2 Appendix B - Inspection Report No. 99900897/85-01
- 3 Appendix C - Inspection Data Sheets (7 pages)

Distribution

R. Oller, IE
E. Merschoff, IE
G. Zech, IE
R. Vollmer
J. Stone, IE
VPB Reading
DMB-IE:09
RMartin, RIV
RStark, NRR
SRI, Comanche Peak
MSpence, TUGCO
C. Fox, IE

*See previous pages for concurrences

*VPB/IE *RCO*
ROller:gmk
2/26/85

*SC/VPB/IE
EMerschoff
2/ /85

*BC/VPB/IE
GZech
2/ /85

*DD/DQAVTTC/IE
BKGrimes
2/ /85

APPENDIX A

Weidmuller Terminations Inc.
99900897/85-01

NOTICE OF NONCONFORMANCE

Based on the results of an NRC inspection conducted on January 9-11, 1985, it appears that certain of your activities were not conducted in accordance with NRC requirements.

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."

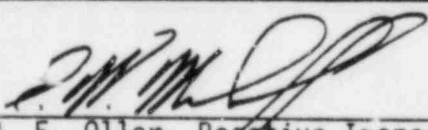
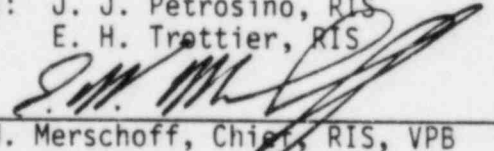
The nonconformance with these requirements is as follows: Section 9, Appendix H, "Final Inspection," of the Weidmuller Terminations Inc. Quality Assurance Manual, Revision dated November 21, 1983, states in part, "...When specified in the customer's purchase order or specification, terminal block assemblies shall be subjected to a dielectric withstand test. This dielectric test, unless otherwise specified, shall be in accordance with Underwriters (UL) Standard 1059 Terminal Blocks. Results of the test shall be recorded on MUS-1"

Contrary to the above, the UL Standard 1059 dielectric withstand test results were not entered on seven MUS-1 records as required by Brown & Root Procurement Specification CPSES, Revision 0 & 1, for Class 1E terminal blocks furnished for Comanche Peak Station.

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ORGANIZATION: WEIDMULLER TERMINATIONS INCORPORATED
RICHMOND, VIRGINIA

REPORT NO.: 99900897/85-01	INSPECTION DATE(S): 1/9-11/85	INSPECTION ON-SITE HOURS: 39
CORRESPONDENCE ADDRESS: Weidmuller Terminations Inc. ATTN: Mr. John Tyler Vice President-Technical & Quality Assurance Manager 821 Southlake Boulevard Richmond, Virginia 23236		
ORGANIZATIONAL CONTACT: Mr. John Tyler, V.P. & QA Manager TELEPHONE NUMBER: (804) 794-2877 PRINCIPAL PRODUCT: Electrical Railmounted Terminal Blocks NUCLEAR INDUSTRY ACTIVITY: Approximately 1/2%		
ASSIGNED INSPECTOR:  For R. E. Oiler, Reactive Inspection Section (RIS)		<u>2/13/85</u> Date
OTHER INSPECTOR(S): J. J. Petrosino, RIS E. H. Trottier, RIS		
APPROVED BY:  E. W. Merschhoff, Chief, RIS, VPB		<u>2/13/85</u> Date
INSPECTION BASES AND SCOPE: A. <u>BASES</u> : 10 CFR Part 21 and Appendix B to 10 CFR Part 50. B. <u>SCOPE</u> : This inspection was made as a result of an allegation concerning possible deficiencies in the contents of the vendor's QA program as it applies to furnishing of electrical equipment for use in Comanche Peak station. Concurrently, selected areas of the program and the vendor's compliance with 10 CFR Part 21 requirements were inspected.		
PLANT SITE APPLICABILITY: QA program deficiencies 50-445		

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ORGANIZATION: WEIDMULLER TERMINATIONS INCORPORATED
RICHMOND, VIRGINIA

REPORT
NO.: 99900897/85-01

INSPECTION
RESULTS:

PAGE 2 of 3

A. VIOLATIONS:

None

B. NONCONFORMANCES:

Contrary to Criterion V of Appendix B to 10 CFR Part 50, and Section 9, Appendix H, "Final Inspection" of the vendor's QA Manual Revision dated November 21, 1983, the UL Standard 1059 dielectric withstand test results were not entered on seven MUS-1 records, as required by Brown & Root procurement specification CPSES, Revision 0 & 1, for Class 1E terminal blocks furnished for Comanche Peak station.

C. UNRESOLVED ITEMS:

None

D. OTHER FINDINGS OR COMMENTS:

1. Initial Management Meeting and Exit Interview: The Weidmuller Terminations Inc. (WTI) management representatives were informed of the authority and responsibility contained in Section 206 of the Energy Reorganization Act of 1974 and its implementing regulation 10 CFR Part 21. The scope of the inspection and its required documentation were explained. During the exit meeting, the inspection findings and the written responses required of the vendor to the Notice of Nonconformance were explained.
2. Allegation:
 - a. Introduction: On November 28, 1984, the NRC received information with regard to potential deficiencies in the content of the Quality Assurance Program of the Weidmuller Terminations Inc. (WTI) plant located in Richmond, Virginia, as it applies to the manufacture and furnishing of terminations for electrical cable for possible use in safety-related systems at Comanche Peak Steam Electric Station. As a result of this allegation, an NRC inspection was performed at the WTI plant on January 9-11, 1985.
 - b. Findings: Weidmuller Terminations Inc. (WTI) is a manufacturer of electrical railmounted terminal blocks of which certain models have been qualified for 1E service in accordance with IEEE Standard 323-1974, for both in-containment and outside-containment

REPORT
NO : 99400897/85-01

INSPECTION
RESULTS:

PAGE 3 of 3

service. Terminal blocks have been furnished by WTI to Comanche Peak station since 1979.

The WTI plant has been located in Richmond, Virginia since 1975. It was relocated to the present address in 1980. Terminal blocks were first furnished for Comanche Peak in 1979, at which time WTI sent their QA manual to Brown & Root. During this NRC inspection, the earliest edition of the QA Manual was not available. The revision reviewed by the NRC inspectors was dated March 18, 1980. This issue was found to include a quality assurance statement identification of foreign suppliers of component parts, and procedures, record forms and an organization chart. The contents can be categorized as meeting 11 of the 18 criteria of Appendix B. In February 1981, the manual was revised to satisfy the requirements of Appendix B. In November 1983, certain criteria and procedures in the manual were revised. This revision continues to satisfy all the requirements of Appendix B and the requirements of ANSI N45.2.

- c. Conclusions: Based on the above review the allegation was partially substantiated in that prior to February 1981, the QA program did not fully address the requirements of Appendix B to 10 CFR 50. However, the quality program in effect prior to 1981 appeared to provide an adequate process quality control program. The current QA program addresses and/or meets all of the requirements of Appendix B to 10 CFR 50 and ANSI N45.2.

3. OTHER QUALITY ASSURANCE PROGRAM AREAS INSPECTED

Concurrently with the allegation followup, an inspection was made of the following areas of the current QA program: (a) inspection; (b) test control; (c) QA records; (d) QA program; (e) organization; (f) non-conforming items; (g) corrective action; (h) procurement document control, and (i) compliance with 10 CFR Part 21. The inspection was accomplished by review of procedures and records related to the electrical terminal blocks furnished for Comanche Peak station; programmatic records; observations in the shop, and discussions with cognizant shop personnel.

As a result of this inspection, one nonconformance was identified. This item concerned WTI's failure to include UL-1059 standard dielectric withstand test results on MUS-1 records as required by the QA manual, and Brown & Root Procurement Specification, Revision 0 & 1 for Class 1E terminal blocks furnished for Comanche Peak station.

PERSONS CONTACTED

Company Weidmuller Terminations Inc.

Dates 1/10-11/85

Docket/Report No. 99900897/85-01

Inspector all/retrosino/trattie

* Attended the Exit meeting.

Page 1 of 1[illegible]

INSPECTOR OfficerSCOPE All Documents
Weidmuller Terminations, Inc.

DOCUMENTS EXAMINED

DOCKET NO. 99900897REPORT NO. 85 - 01PAGE 1 OF 3

ITEM NO.	TYPE OF DOCUMENT	DOCUMENT NO.	REV.	DATE	TITLE / SUBJECT
1	QAM	-	1	11-2-83	Weidmuller Terminations Inc. ^(WTI) Quality Assurance Manual
2	QAM	-	0	3-19-80	WTI Quality Assurance Manual
3	LTR	-	-	8-17-79	WTI letter to Brown & Root, Glen Rose, Texas concerning transmittal of the WTI QA manual.
4	LTR	-	-	5-19-80	WTI letter to ^{domestic} molding subsupplier covering receipt and approval of the supplier's QA program manual
5	QAM	-	Issue 3	6/80	QA manual of a major supplier of terminal block parts, located in England.
6	QAM	-	Ed. 1	2/77	QA manual of a major supplier of terminal block parts, located in West Germany
7	P.D.	-	1	8-22-79	Brown & Root ^{Oct. 19, 1978} Procurement Specification for Class 1E Terminal Blocks for CPSES (Comanche Peak Steam Elec. Sta.)
8	PD	35-1195 -189	-	12-11-78	Brown & Root Request to WTI for a quotation ^{and or change orders}
9	P.D.	-	-	Various	BAR and TUGCO annual blanket P.O.s for 1983 1983-1984

TYPE OF DOC.:

DWG - DRAWING
SPEC - SPECIFICATION
PRO - PROCEDURE
QAM - QA MANUAL
QCD - QC DOCUMENT
P.O. - PURCHASE ORDER
T.M. - INTERNAL MEMO

LTR - LETTER
PD - Procurement Document

INSPECTOR Oliver
SCOPE All Documents
Weidmüller Terminations Inc.

SCOPE All Documents
Weidmüller Terminations Inc.

DOCUMENTS EXAMINED

DOCKET NO. 9900897
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PAGE 2 OF 2

Item No.	Type of Document	Document No.	Rev.	Date	Title / Subject
10	QCD	TWT-1	-	2-28-83	TUGCO Audit Summary, Attachment A.
11	LTR	-	-	6-2-83	WTI's response letter to TUGCO concerning the findings in TUGCO's February 1983 Audit summary.
12	LTR	-	-	8-10-83	TUGCO letter covering evaluation and acceptance of WTI's response to TUGCO's Audit findings.

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[illegible]

ITEM NO.	TYPE OF DOCUMENT	DOCUMENT NO.	REV.	DATE	TITLE / SUBJECT
16	INM	-	-	9/20/83	QTRly Report (QAR) to President on EFFECTIVENESS
17	INM	-	-	5/27/83	of QA Program
18	INM	-	-	2/11/83	
19	INM	-	-	11/19/82	
20	INM	-	-	7/30/82	
21	INM	-	-	4/29/82	
22	INM	-	-	1/20/82	1
23	QCD	-	-	-	Return Material Authorizations #381, 384, 377, 413 and 447

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DOCUMENTS EXAMINED

ITEM NO.	TYPE OF DOCUMENT	DOCUMENT NO.	REV.	DATE	TITLE / SUBJECT
1	P.O.	35-1195-30092	N/A	8/23/79	Imposes BTR P.O. Spec CPSES
2	P.O. Spec.	CPSES	0	10/19/78	Brown & Root P.O. - Class 1E Terminal Blocks for Conando Pack
3	P.O. Spec	CPSES	1	8/22/79	BTR Procurement Spec for Class 1E Terminal Blocks
4	P.O.	CPF-10892-S	3	12/19/84	" " " " " " "
5	P.O.	CPF-10892-S	2	12/3/84	TEXAS UTILITIES Generating Companies - "All original requirements remain in effect..."
6	P.O.	CPF-10892-S	1	12/8/83	" " " " " " "
7	P.O.	CPF-10892-S	-	6/18/83	" " " " " " "
8	INM	NONE	-	8/2/84	change Sampling practice for Molding Inspection from a
9	Make up Sheet	Internal Reference # R-572 Customer	-	4/3/81	To QC Form 9A101. single To a Double sampling per MIL Spec 1050 Table 1.11119
10	QCD	PA #20726	-	9/11/84	Make Up Sheet for Terminal Block Configuration on each rail
11	QCD	P.O. # 2150	N/A	1/9/85	Final Inspection of Phenolic Blocks - per Appendix H, Form QA103
12	QCD	P.O. # 1983	N/A	1/2/85	Appendix J - Assembly #1004 - Block #6942.0 - Form QA102 - Quantity 3201
13	Inspection Sheet	-	-	3/3/83	" " " "1003 - Block #1283.2 - " " 5700
14	Inspection Sheet	-	-	1/9/85	SAK6W(6942.0) QC Insp # 2 - Assembly # 1009
15	Make Up Sheet	R-250 Item # 1	-	9/11/79	" " " "1 - " " # 1084
					MUS-1 - Conando Pack - Assembly/Configuration instructions

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INSPECTOR Petrosino
SCOPE Weidmuller-Allegation

DOCUMENTS EXAMINED

DOCKET NO. 49900891
REPORT NO. 85-01
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ITEM NO.	TYPE OF DOCUMENT	DOCUMENT NO.	REV.	DATE	TITLE / SUBJECT
16	Make up sheet	R-250 Item 2	-	9/11/79	Brown Root MUS-form prepared by int only (WH, TC, T) Assembly & configurations For Make up of Terminal Block
17	Make up sheet	R-250 Item 3	-	9/11/79	Brown Root (same as #16 above)
18	Make up sheet	R-572 Item 6	-	4/3/81	Brown Root 10066 (QTE 5338) (same as #16 above) assembled 1-24-82 & inspected
19	Make up sheet	R-572 Item 7	-	4/3/81	Brown Root (same as #16 above) assembled 1-24-82 & inspected
20	Make up sheet	R-572 Item 8	-	4/3/81	Brown Root (same as #16 above) assembled 1-24-82 & inspected
21	Make up sheet	R-572 Item 9	-	4/3/81	Brown Root (same as #16 above) assembled 1-24-82 & inspected
22	QCD	-	-	1/24/83	Appendix L5 - Block assembly record for # 35-1195-30092 (2009 serial)
23	CofC	-	-	1/27/83	B & E Comanche Pack For PO 35-1195-30092
24	CofC	-	-	1/27/83	B & E Comanche Pack For cert use cert & FCC 523/304

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