



COLUMBIANA HI TECH LLC

LTR #: REG-15-102

Date: June 5, 2015

Attn: Document Control Desk
Director, Division of Spent Fuel Management
Office of Nuclear Material Safety and Safeguards
U.S. Nuclear Regulatory Commission
Washington, D.C. 20555-0001

Subject: Application for Quality Assurance Program Approval for Columbiana Hi Tech Nuclear Quality Assurance Program Manual

References: (1) NRC Quality Assurance Program Approval No. 0179
(2) Columbiana Hi Tech Nuclear Quality Assurance Program Manual, Revision 1, dated April 4, 2005

Columbiana Hi Tech, LLC (CHT) herewith submits an application for approval of the Nuclear Quality Assurance Program Manual that is in compliance with 10 CFR 71.37. This manual had previously been submitted, reviewed and approved via NRC Quality Assurance Program Approval No. 0179.

CHT has also submitted for review via letter REG-15-101 dated May 8, 2015 an updated QA Program description; however, the submittal was not made within the 30 day minimum specified by 10 CFR 71.38(b). This discrepancy was due in part to a miscommunication between Quality Assurance and Licensing personnel and is being addressed within the CHT corrective action program to preclude recurrence. This issue is identified as Request for Corrective Action No. 15-016.

Should the NRC staff require additional information to support review of this application, please do not hesitate to contact the undersigned.

Sincerely,

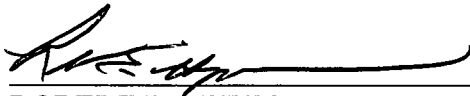
Robert E. Glazier
Vice President of EHS & Quality
Columbiana Hi Tech

Enclosure(s):

- 1) Columbiana Hi Tech Nuclear Quality Assurance Manual, Revision 1, dated 4/4/2005

NUCLEAR QUALITY ASSURANCE PROGRAM

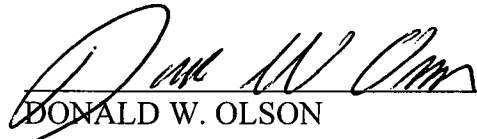
APPROVALS:



ROBERT E. HYPES
VICE PRESIDENT OF QUALITY
COLUMBIANA HI TECH LLC
GREENSBORO NC

4/4/2005

DATE



DONALD W. OLSON
PRESIDENT
COLUMBIANA HI TECH LLC

4/4/2005

DATE

"A"

Prepared By:
J. P. Burchfield

Released By:
R. E. Hypes

Release Date:
4/4/2005

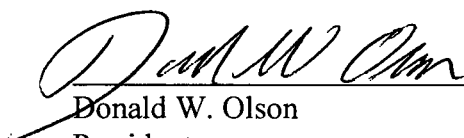
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STATEMENT OF POLICY & AUTHORITY

This manual is a description of the Nuclear Quality Assurance Program in effect at Columbiana Hi Tech LLC, Greensboro NC. This Manual complies with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71 Subpart H or 10 CFR Part 72 Subpart G.

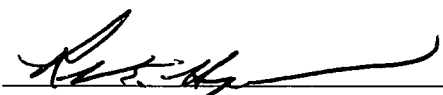
The executive management of this company is devoted to the support of this program and charge all employees involved in activities affecting the quality of Columbiana Hi Tech nuclear products with the responsibility of upholding and abiding by the Quality Assurance requirements in this manual. The Quality organization is authorized sufficient freedom to identify quality problems, initiate, recommend, or provide solutions, verify implementation of solutions and control further processing or delivery of a nonconforming item, deficiency or unsatisfactory condition until proper disposition has been completed.

In the event of disputes arising between managers of departments regarding the interpretation or fulfillment of the requirements in this manual, this shall be referred to and settled by one or any combination of the undersigned.



Donald W. Olson
President
Columbiana Hi Tech, LLC

4/4/05
Date



Robert E. Hypes
Vice President of Quality
Columbiana Hi Tech, LLC
Greensboro NC

4/4/05
Date

“B”

Table of Contents

Issue Date: April 2005Revision: 1Page: 1 of 1

TABLE OF CONTENTS

SUBJECT	SECTION NO.	REVISION (ISSUE DATE)
Title and Approval Page	"A"	04/05
Statement of Policy and Authority Letter	"B"	04/05
Table of Contents	"C"	04/05
Organization	N-1	04/05
Quality Assurance Program	N-2	04/05
Design Control	N-3	04/05
Procurement Document Control	N-4	04/05
Instructions, Procedures & Drawings	N-5	04/05
Document Control	N-6	04/05
Control of Purchased Material, Equipment & Services	N-7	04/05
Identification & Control of Material, Parts & Components	N-8	04/05
Control of Special Processes and Test	N-9	04/05
Inspection	N-10	04/05
Test Control	N-11	04/05
Measuring and Test Equipment	N-12	04/05
Handling, Storage, Shipping & Preservation	N-13	04/05
Inspection, Test and Operating Status	N-14	04/05
Nonconforming Items and Services	N-15	04/05
Corrective Action	N-16	04/05
Quality Assurance Records	N-17	04/05
Audits	N-18	04/05
	"C"	

Prepared By:
J. P. BurchfieldReleased By:
R. E. HypesRelease Date:
4/4/2005

NUCLEAR Q.A. MANUAL

N-1

ISSUE DATE: April 2005
REVISION: 1
PAGE 1 OF 4

ORGANIZATION

1.0 PURPOSE

- 1.1 To describe the organizational structure, functional responsibilities, levels of authority, and internal and external communications for managing, directing, and executing the Nuclear Quality Assurance Program.

2.0 SCOPE & APPLICABILITY

- 2.1 This section encompasses work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71 Subpart H, 10 CFR Part 72 Subpart G.
- 2.2 This section applies to all personnel within Columbiana Hi Tech performing activities affecting quality.

3.0 RESPONSIBILITY & AUTHORITY

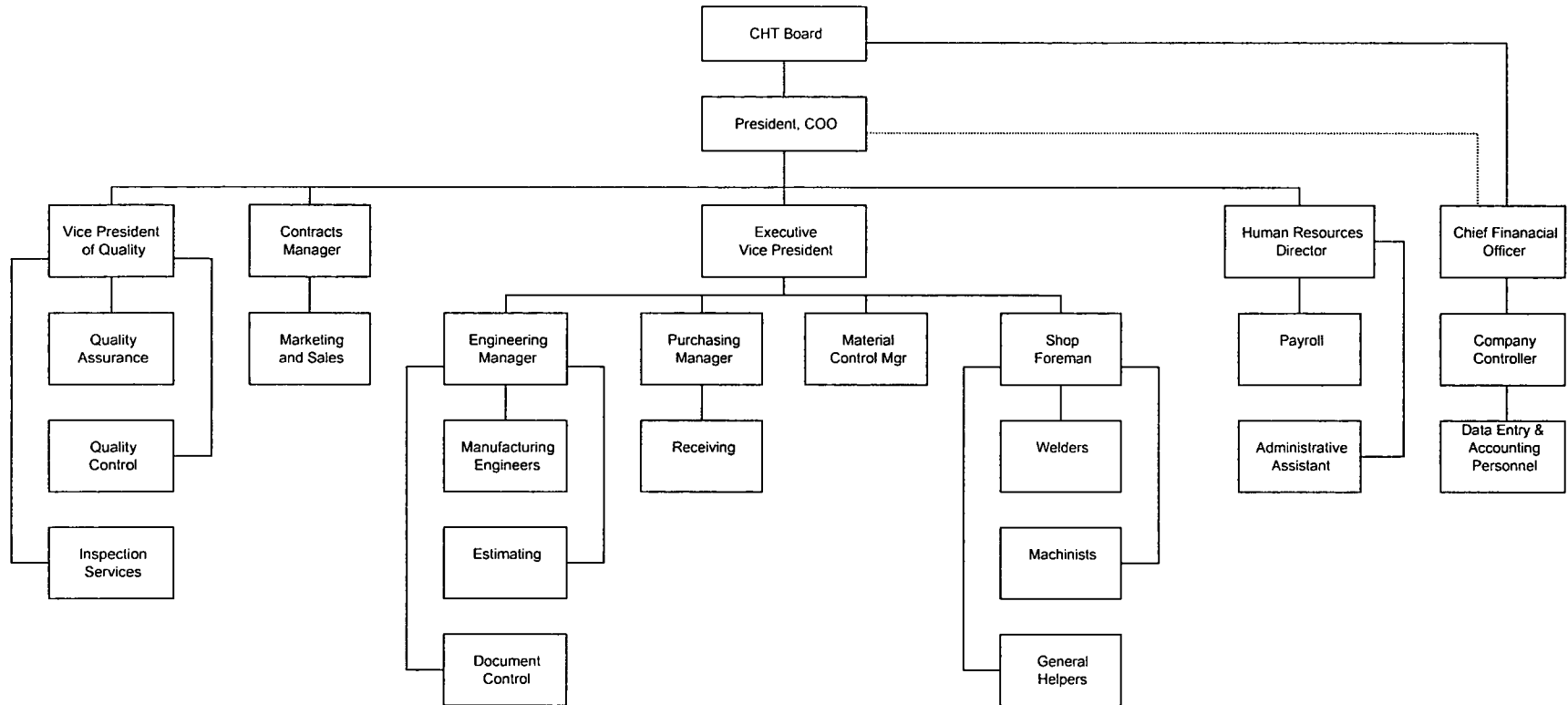
- 3.1 The Vice President of Quality is vested with the authority and responsibility to ensure that all elements of the Quality Assurance Program are designed, defined, implemented, maintained and assessed in a planned and systematic manner to provide confidence, including evidence, that all items are constructed in accordance with paragraph 2.1 of this procedure. The Vice President of Quality shall report to the President of Columbiana Hi Tech yearly on the overall effectiveness of the Quality Assurance Program.
- 3.2 The Vice President of Quality is vested with the authority and responsibility to assure that all elements of the Nuclear Quality Assurance Program dealing with the control and acceptance assessment functions of inspection, examination and testing described in this manual and associated procedures and instructions are carried out in accordance with this manual and established procedures.

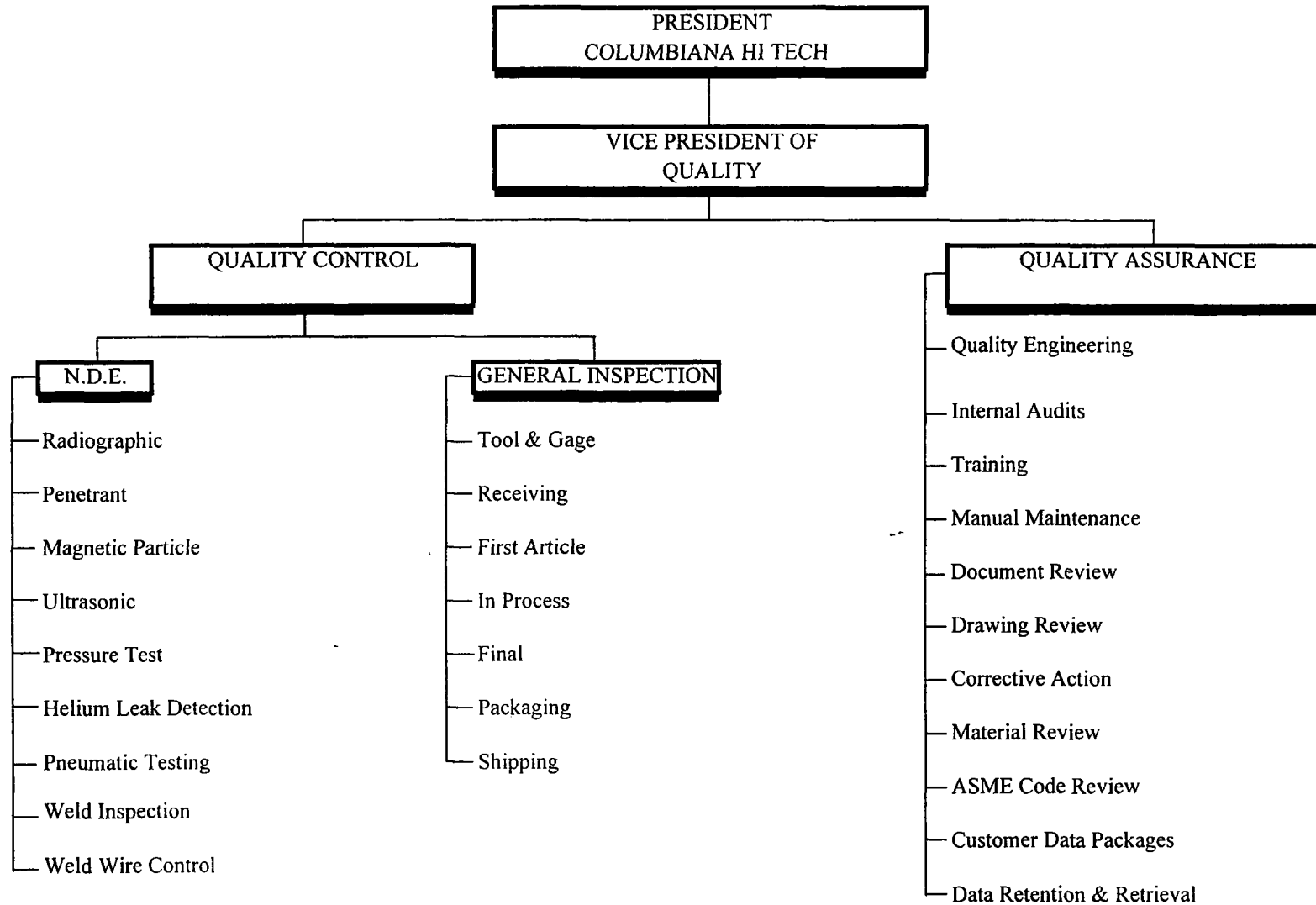
Prepared By:
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R. E. Hypes

Released Date:
4/4/2005

- 3.3 The Quality Organization is authorized sufficient freedom to a) identify quality problems; b) initiate, recommend, or provide solutions; c) verify implementation of solutions; d) control further processing or delivery of a nonconforming item, deficiency, or unsatisfactory condition until proper disposition has been completed. The various procedures comprising this manual and the executive management Statement of Policy and Authority covering this manual attest to this authority and freedom.
- 3.4 The responsibility for attainment of quality objectives is that of Columbiana Hi Tech departments and management performing those functions dealing in design engineering, manufacturing engineering, manufacturing material control (including production control and purchasing), contract administration and welding engineering. In addition to this manual, "Policy/Procedure" procedures are developed for various departments. Each department shall adhere to the procedure developed as applicable.
- 3.5 The responsibility for verification of conformance to these quality requirements is that of persons or organizations not having direct responsibility for performing the work. Verifications are the responsibility of the Quality organization. Delegation of verification activities may be assigned to personnel other than those in the quality organization. Such would be the case when a design engineer, other than the one who performed the original calculations, verifies design calculations.
- 3.6 Details of responsibilities and authorities involved in the attainment and verification of the Quality Assurance Program are contained in the various procedures and references comprising this manual.
- 3.7 The organizational position of the Quality organization, including reporting channels and lines of communication are depicted in the chart on Page 3 of this procedure.
- 3.8 The organizational structures and general areas of responsibilities of the Quality organization are depicted in the chart on Page 4 of this procedure.





NUCLEAR Q.A. MANUAL

	N-2
ISSUE DATE:	April 2005
REVISION:	1
PAGE	1 OF 8

NUCLEAR QUALITY ASSURANCE PROGRAM

1.0 PURPOSE

- 1.1 To describe the Nuclear Quality Assurance Program in effect at Columbiana Hi Tech.

2.0 SCOPE & APPLICABILITY

- 2.1 The scope of this section encompasses work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71 Subpart H, 10 CFR Part 72 Subpart G.
- 2.2 This section applies to all personnel within Columbiana Hi Tech performing activities affecting quality.

3.0 RESPONSIBILITY

- 3.1 The responsibility for the preparation, review, approval, maintenance and control of this manual is that of the Quality Assurance Department. Controls for the administration, revision, approval, and distribution of this manual are described in sub tier procedures.

4.0 SUBTIER PROCEDURES

- 4.1 Quality Assurance implementing procedures (Policy/Procedures) are generated for the various departments of Columbiana Hi Tech. Various procedures are referenced throughout this manual. Each department shall adhere to procedures developed for that particular department.
- 4.1.1.1 Policy/Procedures shall be prepared, reviewed, approved and controlled in accordance with established procedure(s).

Prepared By:
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Released Date:
4/4/2005

5.0 QUALIFICATION OF PERSONNEL

- 5.1 The training of all applicable personnel in the understanding and use of the Code, other standards and this manual is the responsibility of the Vice President of Quality, or designee.
- 5.2 Management training is a continuing function of Columbiana Hi Tech managers. They are kept current on ASME Code requirements and other industry standards, bulletins, and controversial matters by the Quality Department. Records of these indoctrinations and training are maintained on file by the Quality Assurance Department.
- 5.3 The indoctrination and training of all applicable Columbiana Hi Tech personnel prior to performing activities affecting quality is a recognized and practiced precept by all operating department managers.
- 5.4 The various department managers are responsible for assuring that the company policies and procedures covering the activities in their areas are treated in detail by bulletins and/or special instructions, and that their personnel are familiar with and proficient in these policies and procedures.
- 5.5 New employees are familiarized with Columbiana Hi Tech work, equipment, policies, procedures and standards by supervision of their assigned department. The evaluation of their competence and continued performance to required levels of quality and efficiency are, equally, the responsibility of the department managers and supervisors.
- 5.6 The training, examination, qualification and certification of nondestructive examination personnel is defined and controlled by established procedure(s), under the control of the Level III, which is in accordance with the written practice of the American Society of Nondestructive Testing SNT-TC-1A.
- 5.7 Principal QA/QC management personnel qualifications shall be in accordance with established procedure(s).

6.0 TRAINING

- 6.1 Training shall be performed in accordance with established procedure requirements. The procedure shall as a minimum, make provisions for:
 - 6.1.1 Minimum Q.A. Training requirements by job function.
 - 6.1.2 Retention of Training Records.
 - 6.1.3 Identification of applicable personnel.

6.1.4 Follow up Training to be conducted when QA system is changed.

6.1.5 Training of personnel prior to performing work affecting Quality.

7.0 GENERAL

7.1 Activities affecting quality shall be accomplished under suitably controlled conditions. Controlled conditions include the use of appropriate equipment, suitable environmental conditions for accomplishing the activity, such as, adequate cleanliness, and assurance that all prerequisites have been satisfied. Consideration shall be given for the need for special controls, processes, test equipment, tools, and skills to attain the required quality by inspection and test. Procedures shall be written for any identified controlled conditions beyond normal manufacturing parameters. Procedures shall also be developed as required that identify special controls, processes, test equipment, tools, and skills needed to attain the required quality by inspection and test.

7.2 The Vice President of Quality, or designee, shall oversee an effective industry experience and lessons learned program to ensure Columbiana Hi Tech's practices are consistent with current industry standards and expectations. This program is described in established procedure(s). This procedure shall, as a minimum, make provisions for:

7.2.1 Required evaluation of notices sent to Columbiana Hi Tech for necessary actions.

7.2.2 Defining the type of information to be evaluated for potential impact on Columbiana Hi Tech.

7.2.3 Defining the method for documenting the necessary actions

7.2.4 Defining the criteria for determining if a notice is applicable to Columbiana Hi Tech

7.2.5 Required documentation of all evaluations performed

8.0 DEFINITIONS/GLOSSARY OF TERMS

- **Acceptance Criteria** – specified limits placed on characteristics of an item, process, or service defined in codes, standards, or other requirement documents.
- **Audit** – a planned and documented activity performed to determine by investigation, examination, or evaluation of objective evidence the adequacy of and compliance with established procedures, instructions, drawings, and other applicable documents, and the effectiveness of implementation. An audit should not be confused with

surveillance or inspection activities performed for the sole purpose of process control or product acceptance.

- **Basic Component** – a structure, system, or component, or any part thereof that affects their safety function, that is directly procured by the licensee of a facility or activity subject to the regulations of 10 CFR 21, and in which a defect or failure to comply with any applicable regulation issued by the Nuclear Regulatory Commission could create a substantial safety hazard. In all cases, basic component includes safety-related design, analysis, inspection, testing, fabrication, replacement of parts, or consulting services that are associated with the component hardware, whether these services are performed by the component supplier or others.
- **Certificate of Conformance** – a document signed or otherwise authenticated by an authorized individual certifying the degree to which items or services meet specified requirements.
- **Certification** – the act of determining, verifying, and attesting in writing to the qualifications of personnel, processes, procedures, or items in accordance with specified requirements.
- **Characteristic** – any property or attribute of an item, process, or service that is distinct, describable, and measurable.
- **Columbiana Hi Tech** – General term used to describe one company known as Columbiana Hi Tech LLC (also known as CHT).
- **Code** - the code, as referenced to in this manual, is the American Society of Mechanical Engineers, Boiler & Pressure Vessel Code, Section III, Division I, Sub-section NA, “Nuclear Power Plant Components”, or other sections as required by customer contract.
- **Commercial Grade Item** – an item satisfying (a), (b), and (c) below:
 - (a) not subject to design or specification requirements that are unique to nuclear facilities;
 - (b) used in applications other than nuclear facilities;
 - (c) is to be ordered from the Manufacturer/Supplier on the basis of specifications set forth in the Manufacturer’s published product description (for example, catalog).
- **Computer Program** – a sequence of instructions suitable for processing by a computer. Processing may include the use of an assembler, a compiler, an interpreter, or a translator to prepare the program for execution, as well as to execute it.
- **Condition Adverse to Quality** – an all-inclusive term used in reference to any of the following: failures, malfunctions, deficiencies, defective items, and nonconformances. A significant condition adverse to quality is one that, if uncorrected, could have a serious effect on safety or operability.
- **Corrective Action** – measures taken to rectify conditions adverse to quality, and where necessary, to preclude repetition.
- **Credible Failure Mechanism** – the manner by which an item may fail, degrading the item’s ability to perform the component/system function under evaluation.

- **Critical Characteristics for Acceptance** – identifiable and measurable attributes/variables of an item that, once selected to be verified, provide reasonable assurance that the item will perform its design function.
- **Critical Characteristics for Design** – those properties or attributes that are essential for the item's form, fit, and functional performance. Critical characteristics for design are the identifiable and/or measurable attributes of an item that provides assurance that the item will perform its design function.
- **Customer Contract** - as used in this manual, refers to the formal purchase order (ordering document) received by Columbian Hi Tech from their Customer, including all referenced documents, such as, drawings, specifications, standards, special provisions, task authorization, etc.
- **Design Bases** – that information which identifies the specific functions to be performed by a structure, system, or component, and the specific values or ranges of values chosen for controlling parameters as reference bounds for design.
- **Design Change** – any revision or alteration of the technical requirements defined by approved and issued design output documents and approved and issued changes thereto.
- **Design Input** – those criteria, parameters, bases, or other design requirements upon which detailed final design is used.
- **Design Output** – drawings, specifications, and other documents used to define technical requirements of structures, systems, components, and computer programs.
- **Design Process** – technical and management processes that commence with identification of design input and that lead to an include the issuance of design output documents.
- **Deviation** – a departure from specified requirements.
- **Document** – any written or pictorial information describing, defining, specifying, reporting, or certifying activities, requirements, procedures, or results. A document is not considered to be a Quality Assurance Record until it satisfies the definition of a Quality Assurance Record as defined in this section.
- **Engineering Control Center** - a controlled access work center where drawings, specifications, standards, engineering reference material and documents, master work order files, quotations, etc. are retained controlled, issued and duplicated for use.
- **External Audit** – an audit of those portions of another organization's Quality Assurance Program not under the direct control or within the organizational structure of the auditing organization.
- **Failure Modes and Effect Analysis (FMEA)** – an evaluation of an item's credible failure mechanisms and their effect on system/component function.
- **Final Design** – approved design output documents and approved changes thereto.
- **Guideline** – a suggested practice that is not mandatory in programs intended to comply with a standard. The word *should* denotes a guideline; the word *shall* denotes a requirement.
- **Hold Points** - mandatory, preplanned, points during the sequence of manufacturing indicated on the traveler, at which witnessing or examination is required by the

Columbiana Hi Tech Inspector or Customer Inspector. The hold designation will be placed prior to the operation involved, and the work shall not proceed until cleared or released by the specified inspector(s) or is waived by the Vice President of Quality, based on Customer authorization.

- **Inspector** - a qualified employee of Columbiana Hi Tech, under the supervision of Columbiana Hi Tech Quality Department, who performs inspection activities to verify conformance to specific requirements.
- **Inspection** – examination or measurement to verify whether an item or activity conforms to specified requirements.
- **Internal Audit** – an audit of those portions of an organization’s Quality Assurance Program retained under its direct control and within its organizational structure.
- **Item** – an all-inclusive term used interchangeably with any of the following: appurtenance, assembly, component, equipment, material, module, part, structure, subassembly, subsystem, system, or unit.
- **Master Work Order** - a file, retained by Engineering in the Engineering Control Center, arranged by work order number, which contains, as applicable:
 - a) the Request for Quotation and Columbiana Hi Tech response
 - b) the Advance Work Release
 - c) the Customer Contract
 - d) Certified Design Specification and other specifications
 - e) Stress Reports
 - f) Design Review Records
 - g) Procedures
 - h) Purchase Order - Originator copies of Columbiana Hi Tech
 - i) Correspondence
 - j) Controlled Drawings
 - k) Obsolete drawings and specifications (so marked)
 - l) Change Request
 - m) Instruction Manuals
- **Measuring and Test Equipment (M&TE)** – devices or systems used to calibrate, measure, gage, test, or inspect in order to control or acquire data to verify conformance to specified requirements.
- **Nonconformance** – a deficiency in characteristic, documentation, or procedure that renders the quality of an item or activity unacceptable or indeterminate.
- **Notification Points** - non-mandatory, preplanned points during the sequence of manufacturing indicated on the traveler, at which witnessing or examination notification may be desired by the Customer inspector. The notification designation will be placed prior to the operation involved and is used to provide advance notice to the Customer inspector of an operation of interest, in order that witnessing may be conducted on an “as available” basis.
- **Objective Evidence** – any documented statement of fact, other information or record, either quantitative or qualitative, pertaining to the quality of an item or activity, based on observations, measurements, or tests that can be verified.

- **Owner** – the person, group, company, agency, or corporation who has, or will have title to the nuclear facility.
- **Procedure** – a document that specifies or describes how an activity is to be documented.
- **Procurement Document** – Purchase Requisitions, Purchase Orders, drawings, contracts, specifications, or instructions used to define requirements for purchase.
- **Purchaser** – the organization responsible for establishment of procurement requirements and for issuance, administration, or both of procurement documents
- **Qualification (Personnel)** – the characteristics or abilities gained through education, training, or experience, as measured against established requirements such as standards or tests that qualify an individual to perform a required function.
- **Quality Assurance** - all those planned or systematic actions necessary to provide adequate confidence that an item or a facility will perform satisfactorily in service.
- **Quality Assurance Record** – a completed document that furnishes evidence of the quality of an item and/or activities affecting quality.
- **Quality Control** - those Quality Assurance actions that provide a means to control and measure the characteristics of any item, process, or facility to established requirements.
- **Quality Requirements** – those requirements that, when specified, ensure the Supplier executes the necessary controls over design, manufacturing, etc., thus assuring that the technical requirements will be met.
- **Receiving** – taking delivery of an item at a designated location.
- **Repair** - the process of restoring a nonconforming characteristic to a condition such that the capability of an item to function reliably and safely is unimpaired even though that item does not conform to the original requirements.
- **Rework** - the process by which a nonconforming item is made to conform to a prior specified requirement by completion, remachining, reassembling or other means.
- **Right of Access** – the right of a Purchaser or designated representative to enter the premises of a Supplier for the purpose of inspection, surveillance, or quality assurance audit.
- **Service** – the performance of activities such as design, fabrication, inspection, nondestructive examination, repair, or installation.
- **Special Process** – a process, the results of which are highly dependent on the control of the process, the skill of the operators, or both, and in which the specified quality cannot be readily determined by inspection or test of the product.
- **Supplier** – any individual or organization that furnishes items or services in accordance with a procurement document. An all-inclusive term that may be used in place of any of the following: Vendor, Seller, Contractor, Subcontractor, Fabricator, Consultant, and their sub tier levels.
- **Surveillance** – the act of monitoring or observing to verify that an item or activity conforms to specified requirements.
- **Technical Requirements** – those parameters that, when specified, ensure an item meets its design and qualification requirements. Technical requirements are based on

the parent component's function, the function of the item being procured, FMEA, and critical characteristics.

- **Testing** – an element of verification for the determination of the capability of an item to meet specified requirements by subjecting the item to a set of physical, chemical, environmental, or operating conditions.
- **Traceability** – the ability to trace the history, application, or location of an item and like items or activities by means of recorded identification.
- **Traveler** – Manufacturing Plan and Quality Record (MPQR)
- **Use-As-Is** – a disposition permitted for a nonconforming item when it can be established that an item is satisfactory for its intended use.
- **Verification** – the act of reviewing, inspecting, testing, checking, auditing, or otherwise determining and documenting whether items, processes, services, or documents conform to specified requirements.
- **Waiver** – documented authorization to depart from specified requirements.

9.0 ABBREVIATIONS

M.P.Q.R. - Manufacturing Plan and Quality Record (Traveler)
P.O. - Purchase Order
W.O. - Work Order
NCR - Nonconformance Report

NUCLEAR Q.A. MANUAL

	N-3
ISSUE DATE:	April 2005
REVISION:	1
PAGE	1 OF 4

DESIGN CONTROL

1.0 PURPOSE

- 1.1 To describe the established measures to assure the correct translation of the applicable certified design specification into drawings, procedures, specifications, and instructions.

2.0 SCOPE & APPLICABILITY

- 2.1 The scope of this procedure encompasses work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71 Subpart H, 10 CFR Part 72 Subpart G.
- 2.2 This section applies to design activities, whether subcontracted or performed by qualified CHT personnel. Columbiana Hi Tech may sub-contract design work to qualified engineering sources. The engineering source shall be audited and approved by Quality Assurance as applicable.
- 2.3 This section applies to the Engineering and Quality Departments.

3.0 RESPONSIBILITY & AUTHORITY

- 3.1 The Quality Department of Columbiana Hi Tech is responsible for the surveillance and audit of all sub-contracted design work to ensure the requirements of contract, regulatory, code, specification and this procedure are satisfied. Audits shall be conducted and documented per Columbiana Hi Tech Quality Assurance Program requirements.
- 3.2 Engineering is responsible for defining, controlling, and verifying the design application.

Prepared By:
J. P. Burchfield

Released By:
R. E. Hypes

Release Date:
4/4/2005

4.0 GENERAL

- 4.1 The CHT design application is defined, controlled, and checked or verified. Design inputs are translated into design documents and design interfaces are identified and controlled. Design reviews are performed by persons other than those who designed the item, but who may be from the same organization. Design changes are governed by control measures commensurate with those applied to the original design.
- 4.2 Design control measures will apply to such items as:
- Criticality physics, radiation shielding, stress, thermal, hydraulic, and accident analyzes;
 - Compatibility of materials;
 - Accessibility for in-service inspection, maintenance, and repair;
 - Features to facilitate decontamination; and
 - Delineation of acceptance criteria for inspections and tests.
- 4.3 The completed design, including regulatory requirements, will be translated into specifications, drawings, operating procedures, and work instructions.
- 4.4 Requirements
- 4.4.1 Design Inputs
- If Columbiana Hi Tech personnel are to perform design activities, procedures will be established to identify, document, review, and approve design inputs. The procedures will assure that appropriate quality standards are included in the design, and that deviations from those standards are controlled.
- 4.4.2 Design Analyzes
- 4.4.2.1 Design Analyzes are performed in a planned, controlled, and documented manner, and include:
- Definition of the objective of the analyzes
 - Definition of design inputs and their sources
 - Identification of assumptions
 - Identification of computer calculations
 - Review and approval
- 4.4.2.2 Design Analyzes will also assure the suitability of materials, parts, equipment, and processes to the safety-related function of the product.

4.4.3 Design Verification

If Columbiana Hi Tech personnel are to perform design activities, design control measures will be applied to verify the adequacy of the design, and include:

- 4.4.3.1 The extent of design verification based on the importance to safety, complexity, degree of standardization, state of the art, and similarity with previously proven designs.
- 4.4.3.2 The method for checking or verifying the design to include one or more of the following: design reviews, alternate calculations, and qualification testing.
- 4.4.3.3 If testing is used to verify a specific design feature in lieu of other verifying or checking processes, the qualification testing will be conducted under the most adverse design conditions.

4.4.4 Change Control

4.4.4.1 Changes to final design, field changes, modifications to existing products and nonconforming items dispositioned use-as-is or repair, will be justified and subject to design control measures commensurate with original design.

- 4.4.4.1.1 Changes in the conditions specified in the package approval for 10 CFR 71/10 CFR 72 that require NRC approval, will receive NRC approval.

4.4.5 Interface Control

Design interfaces will be identified and controlled, and will include assignment of responsibility and the establishment of procedures for the review, approval, release, distribution, and revision of documents involving design interfaces.

4.4.6 Documentation and Records

Design documentation and records that provide evidence that the design and verification processes were appropriately performed will be retained in accordance with Columbiana Hi Tech QA Program requirements.

4.4.7 Additional Requirements

If the sub-tier documents related to product lines or projects contain additional requirements for design control, they will be met in addition to the requirements stated herein.

NUCLEAR Q.A. MANUAL

	N-4
ISSUE DATE:	April 2005
REVISION:	1
PAGE	1 OF 2

PROCUREMENT DOCUMENT CONTROL

1.0 PURPOSE

- 1.1 To describe the measures established to assure that applicable regulatory requirements, specification, drawing and contract requirements which are necessary to assure adequate quality requirements are included or referenced in the CHT Purchase Order for materials, items or service.

2.0 SCOPE & APPLICABILITY

- 2.1 The scope of this section encompasses work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71, Subpart H, 10 CFR Part 72, Subpart G.
- 2.2 This section applies to the Engineering, Quality Assurance and Purchasing Departments.

3.0 RESPONSIBILITY & AUTHORITY

- 3.1 It is the responsibility of Manufacturing Engineering and Welding Engineering or their designees, to translate the following requirements (as applicable): Customer contract, drawings, specifications and standards into the requirements of the Columbiana Hi Tech Purchase Order and purchase order changes for materials, items or services including those associated with weld filler materials.
- 3.2 It is the responsibility of the Engineering and Quality Assurance Departments to verify completeness, accuracy and to approve Columbiana Hi Tech Purchase Orders and purchase order changes. Additionally, Quality Assurance is responsible for the quality evaluation of sources, the determination of need for inspection, examination or test at the source and/or upon receipt and the conduct of necessary source audits, according to this procedure and its references.
- 3.3 It is the responsibility of the Purchasing Department to seek approved sources, as required and place the purchase orders and changes.

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Release Date:
4/4/2005

4.0 PROCEDURE

4.1 Materials, items or services shall be procured as described in established procedure(s). This procedure(s) shall, as a minimum, make provisions for:

- 4.1.1 Preparation, review, approval, and changes to Columbiana Hi Tech Purchase Orders.
- 4.1.2 Qualification and selection of suppliers of materials, items and services.
- 4.1.3 Identification of quality assurance requirements and the elements of the program applicable to the items or services procured.
- 4.1.4 Inclusion of basic technical requirements in Columbiana Hi Tech Purchase Orders.
- 4.1.5 Source inspection and audit.
- 4.1.6 Documentation requirements.
- 4.1.7 Lower tier procurements.

	N-5
ISSUE DATE:	April 2005
REVISION:	1
PAGE	1 OF 2

INSTRUCTIONS, PROCEDURES & DRAWINGS

1.0 PURPOSE

- 1.1 To delineate the use of instructions, procedures and drawings.

2.0 SCOPE & APPLICABILITY

- 2.1 The scope of this section encompasses work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71, Subpart H, 10 CFR Part 72, Subpart G.
- 2.2 This section applies to all personnel within Columbiana Hi Tech performing activities affecting quality.

3.0 RESPONSIBILITY & AUTHORITY

- 3.1 It is the primary responsibility of the Engineering Department to prepare and control all working instructions, specifications, sketches, procedures and standards except those for nondestructive examination.
- 3.2 Nondestructive Examination procedures are prepared, maintained and controlled by the Nondestructive Examination section of the Quality Control Department.
Nondestructive Examination procedures shall be approved by the Level III.
- 3.3 The verification responsibility for instructions, specifications, sketches, procedures and standards is that of the Quality Assurance Department.

4.0 GENERAL

- 4.1 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 the instructions, procedures, or drawings. Instructions, procedures or drawings shall contain appropriate quantitative or qualitative acceptance criteria for determining that important activities have been satisfactorily accomplished.

Prepared By:	Released By:	Release Date:
J. P. Burchfield	R. E. Hypes	4/4/2005

- 4.2 The basic document, used by Columbiana Hi Tech, to assure the accomplishment of all manufacturing and quality activities is the Traveler. This document, its attachments, lists and sketches contain the details and sequence of all operations, inspections, examinations or tests, or provides the reference to procedures, specifications or standards and their revisions, which are necessary to complete the products involved. The proper completion of this document and its references demands a full review and understanding of the contract, its references, its drawings, equipment/design specifications, Code provisions and standards associated with the order. Development of Traveler's shall be per established procedure(s).

NUCLEAR Q.A. MANUAL

	N-6	
ISSUE DATE:	April 2005	
REVISION:	1	
PAGE	1	OF 2

DOCUMENT CONTROL

1.0 PURPOSE

- 1.1 To describe the established measures for controlling the review, approval, issuance and recall of documents which prescribe activities affecting quality.

2.0 SCOPE & APPLICABILITY

- 2.1 The scope of this section encompasses work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71, Subpart H, 10 CFR Part 72, Subpart G.
- 2.2 This section applies to drawings, specifications, instructions, travelers, procedures and standards involved in activities affecting quality, including changes.
- 2.3 This section applies to all personnel within Columbiana Hi Tech performing activities affecting quality.

3.0 GENERAL

- 3.1 Established procedure(s) controls the issuance of documents, such as instructions, procedures, and drawings, including changes thereto, which prescribe activities affecting quality. These measures assure that documents, including changes are reviewed for adequacy and approved for release by authorized personnel and are distributed to and used at the location where the prescribed activity is performed. Changes to documents shall be reviewed and approved by the same organizations that performed the original review and approval unless other organizations are specifically designated.
- 3.2 The reviewing organizations shall have access to pertinent background information upon which to base its approval and shall have adequate understanding of the requirements and intent of the original document.
- 3.3 Established procedure(s) controls the issuance, preparation, review and approval of Policy/Procedures.

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Release Date:
4/4/2005

3.4 Document Control measures provide for:

- 3.4.1 Identification of individuals or organizations responsible for preparing, reviewing, approving, and issuing documents and revisions thereto;
- 3.4.2 identifying the proper documents to be used in performing the activity;
- 3.4.3 coordination and control of interface documents;
- 3.4.4 ascertaining that proper documents are being used;
- 3.4.5 establishing current and updated distribution lists.

CONTROL OF PURCHASED MATERIAL, EQUIPMENT & SERVICES

1.0 PURPOSE

- 1.1 To describe the established measures for assuring purchased material, items and services conform to procurement documents.

2.0 SCOPE & APPLICABILITY

- 2.1 The scope of this section encompasses work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10CFR Part 71, Subpart H, 10 CFR Part 72, Subpart G.
- 2.2 This section applies to the Purchasing, Engineering and Quality Departments.

3.0 RESPONSIBILITY & AUTHORITY

- 3.1 The Manufacturing Engineering section of the Engineering Department is responsible for translating the Customer contract and associated Code, regulations, specifications and standards into the requirements of the Purchase Order for materials, items or services.
- 3.2 The Quality Assurance Department is responsible for reviewing and approving content and accuracy of Purchase Orders according to established procedure(s). Additionally, Quality Assurance is responsible for the quality evaluation of sources, the determination of need for inspection examination or test at the source and/or upon receipt and the conduct of necessary source audits, according to this procedure and its references.

Prepared By:
J. P. Burchfield

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Release Date:
4/4/2005

- 3.3 The Purchasing Department is responsible for the selection and use of sources permitted according to established procedure(s), this procedure and references of both.
- 3.4 The Quality Control Department is responsible to inspect, examine and test purchased material, items and services at the source or upon receipt as directed by the Purchase Order.

4.0 GENERAL

- 4.1 All sources of materials, items and services are evaluated for quality performance by one or more of the following methods.
 - 4.1.1 Inspection, surveillance, examination or test at the source of supply, as specified by Quality Assurance in the Purchase Order & performed by Quality Control.
 - 4.1.2 Inspection, examination or test of materials or services upon receipt at Columbiana Hi Tech, as specified by Quality Assurance in the Purchase Order and performed and reported by Quality Control in accordance with established procedure(s).
 - 4.1.3 Evaluation by Quality Assurance on a scheduled basis, of the quality performance history developed from either 4.1.1 or 4.1.2 or both.
 - 4.1.4 Planned & scheduled on-site audits of intended & existing sources by Quality Assurance or designees.

5.0 PROCEDURE

- 5.1 The Manufacturing Engineer (or designee) prepares the Purchase Order or changes.
- 5.2 The Quality Department reviews and approves the Purchase Order or changes.
- 5.3 Purchasing processes the Purchase Order according to established procedure(s) and notifies the Columbiana Hi Tech Vice President of Quality, or designee, by written notice, of any intended source requiring qualification by audit.

- 5.4 The Vice President of Quality, or his designee, upon receipt of written notice on intent to use a new source requiring audit:
 - 5.4.1 Verifies the intended source is not shown on the current Qualified Vendor List (QVL) or is approved, awaiting inclusion on the list.
 - 5.4.2 Verifies that the intended use of the source, and the product or services to be ordered, require audit under the conditions outlined in established procedure(s).
 - 5.4.3 Arranges for an audit of the source by qualified personnel within Columbiana Hi Tech.
 - 5.4.4 Conducts or has conducted an audit according to prepared checklists or to specifications, standards or procedures applicable to the work being ordered.
 - 5.4.5 Evaluates audit results and, upon finding them satisfactory, approves the source for addition to the Qualified Vendor List. The list is maintained by Columbiana Hi Tech Quality Assurance and is issued each calendar quarter, unless no changes occur, and is distributed to Receiving Inspection, Purchasing and Manufacturing Engineering Departments, as a minimum.
- 5.5 Upon receipt inspection, the Inspector verifies evidence of Columbiana Hi Tech inspection at the source when the Purchase Order so indicates. Results of each receipt inspection are recorded in the Supplier Quality History Record. The Receiving Inspector forwards written notice of goods or services received from sources requiring approval but who do not appear on the Qualified Vendor List, and withholds them until disposition by Quality Assurance.
 - 5.5.1 Received material shall be inspected by Quality Control to ensure supplier compliance to purchase order requirements.
- 5.6 Quality Assurance takes action on reported receipts of material or services from sources requiring approval but who are not approved. This action may range from audit of the source to return of the material or items to the source.

Quality Assurance, on a semi-annual basis, evaluates the Supplier Quality History as described in applicable sub tier procedures.

Quality Assurance routinely evaluates corrective action replies. In the course of this evaluation (and approval, if replies are adequate) high evidence of repetitive discrepancies, poor response content, or lack of timely or any response are added causes for special written requests for action by Purchasing to improve source performance.

An unsatisfactory source for quality reasons, is reported in letter form to the applicable departments by the Quality Assurance Department to stop quote, procurement and Columbiana Hi Tech receipt inspection and release activities. This status can only be reversed by the Vice President of Quality or President of Columbiana Hi Tech.

- 5.7 Commercial grade items shall be procured and controlled per established procedure(s).

N-8

ISSUE DATE: April 2005

REVISION: 1

PAGE 1 OF 2

IDENTIFICATION & CONTROL OF MATERIAL, PARTS & COMPONENTS

1.0 PURPOSE

- 1.1 To delineate the requirements for identification and control of material, parts, and components.

2.0 SCOPE & APPLICABILITY

- 2.1 The scope of this section encompasses work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71, Subpart H, 10 CFR Part 72, Subpart G.
- 2.2 This section applies to all personnel within Columbiana Hi Tech performing activities affecting quality.

3.0 GENERAL

- 3.1 Established procedure(s) provides the working procedures used for the identification and control of materials, parts, and components including partially fabricated subassemblies. By virtue of this procedure, measures are established for assuring that only correct and accepted items are used, and installed, and relating an item of production at any stage, from initial receipt through fabrication, installation, repair, or modification to an applicable drawing, specification, or other pertinent technical document.
- 3.2 Physical identification shall be used to the maximum extent possible. Where physical identification is either impractical or insufficient, physical separation, procedural control, or other appropriate means shall be employed. Identification may be either on the item or on records traceable to the item, as appropriate.
- 3.3 Where identification marking is employed, the marking shall be clear, unambiguous, and indelible, and shall be applied in such a manner as not to affect the function of an item when subdivided and shall not be obliterated or hidden by surface treatment or coatings unless other means of identifications are substituted.

Prepared By:
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Release Date:
4/4/2005

3.4 Any special identification requirements shall be stated in travelers.

3.5 Material requiring shelf life controls shall also meet the requirements of established procedure(s).

	N-9	
ISSUE DATE:	April 2005	
REVISION:	1	
PAGE	1	OF 3

CONTROL OF SPECIAL PROCESSES & TESTS

1.0 PURPOSE

- 1.1 To describe the established measures for ensuring that special processes, such as welding, cleaning, nondestructive examination, coating and heat treatment; and tests, such as hydrostatic and pneumatic are accomplished under controlled conditions, in accordance with applicable Codes, Standards, Specifications, and other special requirements, using only qualified personnel and procedures.

2.0 SCOPE & APPLICABILITY

- 2.1 The scope of this section encompasses work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71, Subpart H, 10 CFR Part 72, Subpart G.
- 2.2 This section applies to:
- 2.2.1 Special Processes including (but not limited to):
- 2.2.1.1 Welding, including specifications, procedure and personnel qualification: weld identification, records and weld filler material control.
 - 2.2.1.2 Cleaning, including materials, procedures, controls, verification and certification.
 - 2.2.1.3 Coating including preparation, materials, procedures, controls, verification and certification.
 - 2.2.1.4 Heat Treatment, including preparation, thermocoupling, recording, controls and verification.
- 2.2.2 Nondestructive Examination, including procedures, controls and criteria for performance and personnel qualification and conduct of examination methods including (but not limited to):

Prepared By:
J. P. Burchfield

Released By:
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Release Date:
4/4/2005

- 2.2.2.1 Radiography
- 2.2.2.2 Penetrant
- 2.2.2.3 Magnetic Particle
- 2.2.2.4 Ultrasonic

2.3 This section applies to all personnel within Columbiana Hi Tech performing activities affecting quality.

3.0 RESPONSIBILITY & AUTHORITY

3.1 Welding Engineering is responsible for:

3.1.1 Preparation and initiation of tests of all Welding Procedure Specifications (WPS), supporting Procedure Qualification Records (PQR), and Manufacturer's Record of Welder or Welding Operator Qualification Tests, in accordance with the requirements of established procedure(s).

3.1.2 Ordering of testing of welding materials and/or welder qualification test plates in accordance with applicable sections of this manual.

3.2 Manufacturing Engineering is responsible for the preparation of:

3.2.1 Procedures for testing, cleaning, coating, handling, heat treatment, etc., or

3.2.2 Contract for the services including procedures, as necessary via purchase orders from qualified Vendors.

3.3 The Level III of the Nondestructive Examination section of the Quality Control department is responsible for the approval of nondestructive examination procedures. Additionally, the Level III is responsible for qualification and certification of all N.D.E. personnel in accordance with the requirements of established procedure(s).

3.4 The Quality Assurance Department is responsible for the review and approval of all procedures and acceptance standards.

3.5 Manufacturing, Material Control and Quality Control are responsible to ensure the work is immediately discontinued on jobs where the traveler is required to be removed from the work areas for up-grading, revision, Nonconformance report

processing or any other reason. Material Control is responsible to advise Quality Control and Manufacturing of such removal.

4.0 GENERAL

- 4.1 Qualification of personnel, procedures, and equipment shall comply with the requirements of applicable codes and standards.
- 4.2 Documentation shall be maintained for currently qualified personnel, processes, or equipment in accordance with the requirements of pertinent codes and standards.
- 4.3 For special processes not covered by existing codes or standards, or where item quality requirements exceed the requirements of established codes or standards, the necessary qualifications of personnel, procedures or equipment shall be defined.

5.0 PROCEDURE

5.1 Special processes and tests shall be controlled as described in established procedure(s). This procedure(s) shall provide for:

- 5.1.1 Welding procedure specification, preparation and qualification.
- 5.1.2 Weld joint identification and traceability to welder, weld filler material, and inspector, as required.
- 5.1.3 Weld wire receipt, control and issuance.
- 5.1.4 Preparation and control of other special processes and tests. (i.e. cleaning, heat treatment, coating, etc.)
- 5.1.5 Control of Nondestructive Examination Procedures to include preparation and approval.
- 5.1.6 Control of subcontracted examinations.

NUCLEAR Q.A. MANUAL

	N-10
ISSUE DATE:	April 2005
REVISION:	1
PAGE	1 OF 3

INSPECTION

1.0 PURPOSE

- 1.1 To describe the measures established for inspection of activities affecting quality including the activity of verifying conformance to documented instructions, procedures, and drawings.

2.0 SCOPE & APPLICABILITY

- 2.1 The scope of this section encompasses work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71, Subpart H, 10 CFR Part 72, Subpart G.
- 2.2 This section applies to all personnel within Columbiana Hi Tech performing activities affecting quality.

3.0 RESPONSIBILITY & AUTHORITY

- 3.1 All Columbiana Hi Tech personnel who perform inspections, examinations, tests and surveillance of activities affecting quality report directly to supervisors who are responsible only for Quality Control functions, and who in turn report to the Vice President of Quality.
- 3.2 Manufacturing Engineering or Welding Engineering is responsible for the complete description of purchased materials, items, and services, as well as the preparation and control of the Traveler and referenced procedures for the fabrication of contracted end-items. These Purchase Orders, Travelers, and Procedures form the basis of instructions and individually are inspection checklists for the activity covered.
- 3.3 Quality Assurance is responsible for ensuring that all design and Code characteristics, including dimensions, processes, examinations, tests, etc. are described or referenced in the combination of Purchase Orders and Travelers.

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Release Date:
4/4/2005

- 3.4 The Manufacturing and Material Control Departments are responsible to ensure that Purchase Orders, Travelers, referenced procedures and special instructions which specify inspection, examination, hold, test, or other verification operations/requirements are fully honored and never by-passed, without written authority of the Vice President of Quality.
- 3.5 All Columbiana Hi Tech personnel who perform inspections, examinations, tests and surveillance of activities affecting quality shall be qualified in accordance with established procedure(s).
- 3.6 The Quality Control Department is responsible for performing inspection, tests, examination, etc. in accordance with the approved procedures contained in this manual and those specified in Quality Assurance approved Purchase Orders, Travelers and special inspection procedures. Quality Control personnel have both the authority and responsibility to stop work on operations found to depart from procedure or specification.
- 3.7 Established procedure(s) shall be used in conjunction with this procedure for implementation.

4.0 GENERAL

- 4.1 Inspection and test records shall, as a minimum, identify the date of inspection or test, the inspector or data recorder, the type of observation, the results, the acceptability and the action taken in connection with any deficiencies noted.
- 4.2 Examinations, measurements, or tests of items processed shall be performed for each work operation where necessary to assure quality. The Traveler shall be used to designate such operations.
- 4.3 Unless otherwise provided for in Customer contract, purchase order, or specification, a 100% inspection of all items manufactured by and/or for Columbiana Hi Tech shall be imposed.
- 4.4 Where a sample is used to verify acceptability of a group of items, the sampling procedure shall be based on recognized standard practices and shall provide adequate justification for the sample size and selection process.
- 4.5 If inspection of processed items is impossible or disadvantageous, indirect control by monitoring of processing methods, equipment, and personnel shall be provided. Both inspection and process monitoring shall be provided when control is inadequate without both.

- 4.6 If mandatory inspection hold points, which require witnessing or inspecting by the Purchaser's designated representative and beyond which work shall not proceed without the consent of the purchaser's designated representative, are required, the specific hold points shall be indicated on travelers. Such consent shall be documented prior to the continuation of work beyond the designated hold point.

NUCLEAR Q.A. MANUAL

	N-11
ISSUE DATE:	April 2005
REVISION:	1
PAGE	1 OF 2

TEST CONTROL

1.0 PURPOSE

- 1.1 To delineate the procedure established to ensure that all testing required to demonstrate that the item will perform satisfactorily in service is identified and documented, and that the testing is performed in accordance with written test procedures which incorporate or reference the requirements and acceptance limits contained in applicable design documents.

2.0 SCOPE & APPLICABILITY

- 2.1 The scope of this section encompasses work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71, Subpart H, 10 CFR Part 72, Subpart G.
- 2.2 This section applies to all personnel within Columbiana Hi Tech performing activities affecting quality.

3.0 RESPONSIBILITY & AUTHORITY

- 3.1 Manufacturing Engineering is responsible to ensure that all testing requirements are extracted from Customer specifications, codes, and standards and develop any necessary procedures.
- 3.2 The Quality Control and Manufacturing departments are responsible to assure that only properly controlled, calibrated, adjusted and identified tools, gages, instruments and equipment are used in the conduct of activities affecting quality.
- 3.3 The Quality Control department is responsible to provide the control activities, in keeping with this procedure, to assure that tools, gages, instruments and equipment used for measuring and testing are calibrated, adjusted, as required, identified and recorded at the established frequencies.

Prepared By:	Released By:	Release Date:
J. P. Burchfield	R. E. Hypes	4/4/2005

- 3.4 Quality Assurance is responsible to identify the need, during work planning processes, for special tools, gages, instruments or test equipment for measuring and testing, beyond the known capability of existing Columbiana Hi Tech measuring and test equipment inventories. Should such need appear, procurement or fabrication actions will be initiated to provide them for Quality Control.

4.0 PROCEDURE

- 4.1 Test procedures shall include provisions for assuring that prerequisites for the given test have been met, that adequate instrumentation is available and used, and that necessary monitoring is performed. Prerequisites include such items as calibrated instrumentation, appropriate equipment, trained personnel, condition of test equipment and the item to be tested, suitable environmental conditions, and provisions for data acquisition. Test results shall be documented and evaluated by Quality Control to assure that test requirements have been satisfied.
- 4.2 Test requirements and acceptance criteria shall be provided by the organization responsible for the design of the item under test unless otherwise designated.
- 4.3 Manufacturing Engineering shall interpret Customer specifications and applicable codes and standards and formulate necessary procedures that comply with paragraph 4.1 and 4.2.
- 4.4 Quality Assurance shall review each procedure to ensure compliance to Customer specifications, codes, and standards and this procedure.
- 4.5 Quality Assurance shall review test results and records to assure that test requirements have been satisfied.
- 4.6 Quality Control shall perform test(s) in accordance with established procedures and document results per the requirements of same.
- 4.7 Quality Control shall document test results. These test records shall, as a minimum, identify the following:
- A. Item Tested
 - B. Date of Test
 - C. Tester or Data Recorder
 - D. Type of Observation
 - E. Results or Acceptability
 - F. Action taken in connection with any deviations noted
 - G. Person Evaluating Test Results

MEASURING & TEST EQUIPMENT

1.0 PURPOSE

1.1 To describe the established measures to assure that tools, gages, instruments and other inspection, measuring and testing equipment are:

1.1.1 of the proper range, type and accuracy to verify conformance to established requirements.

1.1.2 controlled, calibrated, adjusted and maintained at prescribed intervals, or prior to use, against certified equipment having valid traceability to nationally recognized standards, where such standards exist. When such standards do not exist, the basis for calibration shall be documented.

1.2 This requirement is not intended to imply a need for special calibration and control measures on rulers, tape measures, levels, and such other devices if normal commercial practices provide adequate accuracy.

2.0 SCOPE & APPLICABILITY

2.1 The scope of this section encompasses all work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71, Subpart H, 10 CFR Part 72, Subpart G.

2.2 This section applies to the Quality Assurance / Quality Control, Manufacturing and Manufacturing Engineering Departments.

3.0 RESPONSIBILITY & AUTHORITY

3.1 The Quality Control and Manufacturing Departments are responsible to assure that only properly controlled, calibrated, adjusted and identified tools, gages, instruments and equipment are used in the conduct of activities affecting Quality.

3.2 The Quality Control Department is responsible to provide:

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J. P. Burchfield

Released By:
R. E. Hypes

Release Date:
4/4/2005

- 3.2.1 The control activities, in keeping with this procedure, to assure that tools, gages, instruments and equipment used for measuring and testing are calibrated, adjusted, identified and recorded at the established frequencies.
- 3.2.2 For the suitable storage and protection of company owned inspection equipment.
- 3.3 Quality Assurance is responsible to identify the need, during work planning processes, for special tools, gages, instruments or test equipment for measuring and testing, beyond the known capability of existing Columbiana Hi Tech measuring and test equipment inventories. Should such need appear, procurement or fabrication actions will be initiated to provide them for Quality Control.
- 3.4 Quality Assurance shall insure that all calibration sources are audited and approved.

4.0 PROCEDURE

- 4.1 Control of measuring and test equipment shall be accomplished as described in established procedure(s). This procedure(s), as a minimum, shall provide for:
 - 4.1.1 Assurance that tools, gages, instruments, and other inspection, measuring and test equipment used in activities affecting quality are of the proper range, type, and accuracy to verify conformance to established requirements.
 - 4.1.2 Identification of inspection equipment, tools, gages.
 - 4.1.3 Calibration and adjustment of inspection tools, instruments, and gages to include: established methods and intervals of calibration against nationally recognized standards.
 - 4.1.4 Documented evaluation of validity of previous inspections/test, when inspection/test equipment is found to be suspect or out of calibration,
 - 4.1.5 Records documenting results and/or calibration history/status of measuring and test equipment.
- 4.2 The control of measuring and testing equipment for field applications shall be accomplished as described in established procedure(s). This procedure(s), as a minimum, shall provide for:

- 4.2.1 The definition of field application measuring and test equipment.
- 4.2.2 The recall of field application measuring and test equipment.
- 4.2.3 The notification of effected organizations when measuring and test equipment is found out of tolerance.

NUCLEAR Q.A. MANUAL

	N-13
ISSUE DATE:	April 2005
REVISION:	1
PAGE	1 OF 2

HANDLING, STORAGE, SHIPPING & PRESERVATION

1.0 PURPOSE

- 1.1 To describe the established measures to control handling, storage, shipping, cleaning, packaging and preservation of material and items.

2.0 SCOPE & APPLICABILITY

- 2.1 The scope of this section encompasses work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71, Subpart H, 10 CFR Part 72, Subpart G.
- 2.2 This section applies to all personnel within Columbiana Hi Tech performing activities affecting quality.

3.0 RESPONSIBILITY & AUTHORITY

- 3.1 Manufacturing Engineering is responsible for recognizing the need for, and prescribing the procedure, equipment, and controls necessary for special conditions, handling, storage, cleaning, preservation, packaging, packing and shipping in the Travelers, procedures or instructions referenced therein.
- 3.2 The Quality Assurance Department is responsible to assure that procedures and instructions are adequate for the situation and are provided when necessary.
- 3.3 The Manufacturing and Material Control departments are responsible for abiding by the procedures and instructions in the Travelers or referenced documents.
- 3.4 The Quality Control Department is responsible to verify procedures and instructions prescribed are properly abided by, and verified at Traveler operations involved.

4.0 GENERAL

- 4.1 The implementation of measures for the control of handling, storage, and shipping etc. has been delegated to the appropriate Columbiana Hi Tech departments for their

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Released By:
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Release Date:
4/4/2005

respective scope of work. Procedures, practices, and instructions are established and documented as necessary to provide control of handling, storage, cleaning, packaging, preservation, shipping release, and shipping of material and equipment to prevent damage, deterioration or loss during manufacture and shipment as required by the Customer specification.

5.0 PROCEDURE

- 5.1 When necessary for a particular item to have special identifications, coverings, handling, storage, special equipment, or special environmental conditions, such as inert gas atmosphere, specific moisture content levels, and temperature levels, etc. they are specified by Manufacturing Engineering in the Traveler and/or procedure, are reviewed by Quality Assurance, performed by Manufacturing and Material Control and are verified by Quality Control.
- 5.2 Inspection shall verify compliance to packaging, preservation, shipping and identification requirements in accordance with Procedure N-10 of this manual, per Customer and specification requirements referenced.

INSPECTION, TEST & OPERATING STATUS

1.0 PURPOSE

- 1.1 To describe the measures established to identify inspection and test status of items throughout the manufacturing process, up to and including, final inspection and shipment.

2.0 SCOPE & APPLICABILITY

- 2.1 The scope of this section encompasses work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71, Subpart H, 10 CFR Part 72, Subpart G.
- 2.2 This section applies to all personnel within Columbiana Hi Tech performing activities affecting quality.

3.0 RESPONSIBILITY & AUTHORITY

- 3.1 Manufacturing Engineering is responsible for preparation of shop travelers, which document manufacturing operations, inspections, and test to be performed.
- 3.2 It is the responsibility of Material Control to:
 - 3.2.1 Maintain stores or bond area.
 - 3.2.2 Place items with Travelers into work.
 - 3.2.3 Move items with travelers through the various stages of manufacturing and inspection.
 - 3.2.4 Assure that only accepted items which have passed required inspections are placed into work.

Prepared By:
J. P. Burchfield

Released By:
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Release Date:
4/4/2005

- 3.3 It is the responsibility of the Manufacturing Department to:
 - 3.3.1 Fabricate items per Travelers, procedures and drawings.
 - 3.3.2 Notify Quality Control of inspection points which are ready for inspection.
 - 3.3.3 Notify inspection of any dimensional errors which arise during fabrication.
 - 3.3.4 Assure that work is performed in the sequence and manner prescribed by Travelers, and discontinue such work when a Traveler is removed from the work area.
 - 3.3.5 Assure that only accepted items that have passed required inspections are placed into work.
- 3.4 Quality Assurance is responsible to review and verify that Travelers provide for performance of all required inspections and test and documentation of same.
- 3.5 It is the responsibility of the Quality Control Department to:
 - 3.5.1 Verify that only accepted items which have passed required inspections are placed into work.
 - 3.5.2 Verify that items are manufactured per Travelers and perform various inspections (dimensional, N.D.E. functional, etc.) as required, per Traveler, specification and drawing requirements.
 - 3.5.3 Notify applicable personnel or organizations of “Notify”, “Hold” and/or “Witness Points”.
 - 3.5.4 Attach or remove status indicator (tags) as required.
 - 3.5.5 Identify items, and issue nonconformance reports (NCR’s) per Quality Assurance Manual Section N-15, for items found to be nonconforming.

4.0 PROCEDURE

4.1 Identification of inspection and test status of items shall be accomplished as described in established procedure(s). This procedure(s), as a minimum, shall provide for:

- 4.1.1 Assurance that required inspections and test are performed and that the acceptability of items with regard to inspections and test performed is known throughout manufacturing and inspection processes.
- 4.1.2 Use and processing of status indicators such as, travelers, tags, markings, stamps, and inspection records. Additionally, measures shall include procedures for control of status indicators including the authority for application and removal of tags, markings, labels and stamps.
- 4.1.3 Identification of nonconforming items.

NUCLEAR Q.A. MANUAL

N-15

ISSUE DATE: April 2005

REVISION: 1

PAGE 1 OF 2

NONCONFORMING ITEMS & SERVICES

1.0 PURPOSE

- 1.1 To delineate the measures established to control items, services, or activities which do not conform to requirements.

2.0 SCOPE & APPLICABILITY

- 2.1 The scope of this section encompasses work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71, Subpart H, 10 CFR Part 72, Subpart G.
- 2.2 This section applies to all personnel within Columbiana Hi Tech performing activities affecting quality.

3.0 RESPONSIBILITY & AUTHORITY

- 3.1 It is the responsibility of the Quality Control department to:
- a) Identify nonconforming items and services and prevent further processing, delivery, or installation pending final disposition.
 - b) Report nonconforming conditions on a Nonconformance Report (NCR), and identify responsibility, i.e. Columbiana Hi Tech, Vendor or Customer.
 - c) Withhold the item in bond or in place until disposition is made on the NCR. Place a Withhold Tag on the item.
 - d) When the disposition of the discrepant item is completed, remove the item from bond or withhold status and verify the disposition is being carried out, as designated, and clear Nonconformance Report numbers on Traveler and/or P.O. Receiving Log, as applicable.
 - e) Apply and remove Withheld Tags.
- 3.2 It is the responsibility of the Manufacturing Department (on Columbiana Hi Tech responsibility NCR's) to:

Prepared By:
J. P. Burchfield

Released By:
R. E. Hypes

Release Date:
4/4/2005

- a) Verify the discrepancy as noted on the NCR.
- b) Complete the cause and corrective action blocks of the NCR when required.
- c) Carry out the disposition as required by the NCR.

3.3 It is the responsibility of Manufacturing Engineering to:

- a) Review NCR reported discrepancies against the Code, contract and drawing requirements.
- b) Contact the Customer and Vendor as required for additional information and recommendations.
- c) Complete the disposition and, if required, complete the rework Traveler.
- d) Forward reported deficiencies for Customer disposition, as required.

3.4 It is the responsibility of the Quality Assurance Department to:

- a) Review and approve the completed NCR for completeness, signatures, accuracy and conformity to Code, contract and drawing requirements.
- b) Maintain a log of all Nonconformance Reports generated.
- c) Forward documents to Manufacturing Engineering for transmittal to Customers.

3.5 It is the responsibility of Purchasing to coordinate the return of materials to the Vendors for replacement or rework.

4.0 GENERAL

4.1 Nonconforming Items and Services shall be processed as described in established procedure(s). This procedure(s) as a minimum shall provide for:

- 4.1.1 Identification, documentation, segregation, disposition, and notification to affected organizations as required.
- 4.1.2 The review and acceptance, rejection, rework, or repair of nonconforming items and services in accordance with documented procedures.
- 4.1.3 Review and evaluation of 10 CFR Part 21 applicability.

4.2 Reporting of defects and noncompliance in compliance with 10 CFR Part 21 (as applicable) shall be accomplished in accordance with established procedure(s).

NUCLEAR Q.A. MANUAL

N-16

ISSUE DATE:	April 2005		
REVISION:	1		
PAGE	1	OF	2

CORRECTIVE ACTION

1.0 PURPOSE

- 1.1 To delineate the measures established to assure that conditions adverse to quality, such as failures, malfunctions, deficiencies, deviations, defective material and equipment, and nonconformances, are promptly identified and corrected as soon as practical.

2.0 SCOPE & APPLICABILITY

- 2.1 The scope of this section encompasses work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71, Subpart H, 10 CFR Part 72, Subpart G.
- 2.2 This section applies to all personnel within Columbiana Hi Tech performing activities affecting quality.

3.0 RESPONSIBILITY & AUTHORITY

- 3.1 The Quality Department is responsible for determining and assigning responsibility for a condition reported on a Nonconformance Report and deciding the need for determination of cause and establishment of corrective action to preclude recurrence.
- 3.2 It is the responsibility of applicable department personnel to investigate and determine cause and corrective action taken for conditions found and reported within Columbiana Hi Tech, as Columbiana Hi Tech responsibility.
- 3.3 It is the responsibility and final authority of the Vice President of Quality, his designee, or the President to evaluate statements of cause and corrective action to determine their adequacy and to assure completeness.
- 3.4 Material Control / Purchasing is responsible for follow-up assistance to Quality Assurance in seeking and gaining effective cause and corrective action from Columbiana Hi Tech outside sources of material, items and services.

Prepared By:
J. P. Burchfield

Released By:
R. E. Hypes

Release Date:
4/4/2005

4.0 GENERAL

4.1 For conditions adverse to quality found during manufacturing processes and or audits, documentation as a minimum shall:

4.1.1 Contain the cause of the condition.

4.1.2 Delineate corrective action taken to preclude recurrence.

4.1.3 Report conditions adverse to quality to appropriate level of management.

4.2 Corrective Action measures shall be accomplished as described in established procedure(s).

NUCLEAR Q.A. MANUAL

	N-17
ISSUE DATE:	April 2005
REVISION:	1
PAGE	1 OF 3

QUALITY ASSURANCE RECORDS

1.0 PURPOSE

- 1.1 To describe the established measures, which assure that sufficient records are maintained to furnish evidence of activities affecting quality.
- 1.2 Records developed shall be consistent with the Code (lifetime and nonpermanent) standards, specifications and contract requirements.

2.0 SCOPE & APPLICABILITY

- 2.1 The scope of this section encompasses work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71, Subpart H, 10 CFR Part 72, Subpart G.
- 2.2 This section applies to all personnel within Columbiana Hi Tech performing activities affecting quality.
- 2.3 Quality Assurance Records are those records or statements documenting the quality of the material, equipment, parts, processes, operation, or activities for quality items. These records are generated during observations, measurements, test, reviews, analysis, audits, inspection, or surveillance of any of the activities associated with the design, procurement, construction, fabrication, erection, testing, operation, repair, or modification of quality related items. This documentation is dated and stamped or signed by the person or persons validating the Quality Assurance Records.

3.0 RESPONSIBILITY & AUTHORITY

- 3.1 Manufacturing Engineering or Welding Engineering is responsible to ensure the contract, Code, specification or standard, relating to records are recognized, interpreted and provided for in Travelers, referenced procedures and/or instructions.
- 3.2 Quality Assurance is responsible to ensure the Traveler and references comply with contract, Code, and specifications requirements.

Prepared By:	Released By:	Release Date:
J. P. Burchfield	R. E. Hypes	4/4/2005

- 3.3 The Quality Control, Manufacturing and Material Control Departments are responsible to ensure those sequential operations of the Traveler, referenced procedures, instructions and Purchase Order requirements are properly completed, examined, acceptance stamped/initialed and dated.

4.0 GENERAL

- 4.1 Inspection and test records shall contain the following where applicable:

- 4.1.1 A description of the type of observation.
- 4.1.2 The date of the inspection or test.
- 4.1.3 Information related to conditions adverse to quality.
- 4.1.4 Inspector or Data Recorder identification.
- 4.1.5 Evidence as to the acceptability of the results.
- 4.1.6 Action taken to resolve any discrepancies noted.

- 4.2 Records shall be legible, identifiable, and retrievable.

- 4.3 The Vice President of Quality, or designee, is responsible for preparation of a Certificate of Conformance, when required, per established procedure(s).

5.0 PROCEDURE

- 5.1 Manufacturing Engineering, in the course of review of the Customer contract and associated specifications, Code and standards shall determine and specify required reporting documents (including the Traveler itself) which constitute records of work performance and verification. This may be accomplished through preparation of Travelers, inspection and test procedures, etc.
- 5.2 Quality Assurance shall ensure records are maintained as specified throughout manufacturing and storage.
- 5.3 The Quality Department shall assure that all required documents and data released and specified are properly completed, identified and approved prior to final assembly of data packages and reproduction of required copies. A facsimile package to that used for presentation and shipment shall be maintained for the period required by the specifications.

- 5.4 The retention period for the records is as follows: 1) Transportation Packaging – Life of the packaging plus three years, or three years after termination of NRC QA Program Approval (if applicable), whichever is longer; 2) Spent Fuel Storage Packaging – Shall be maintained by or under the control of the licensee until the commission (NRC) terminates the license. Additionally, records of use for all transport packages shall be maintained for a period of three years after the shipment.
- 5.4 Records deemed necessary by Columbiana Hi Tech or Customers shall be retained for periods as specified and shall be indexed, filed, and maintained in facilities that provide a suitable environment to minimize deterioration or damage and to prevent loss.
- 5.5 Storage and maintenance of quality records shall be accomplished as described in established procedure(s).

NUCLEAR Q.A. MANUAL

N-18

ISSUE DATE: April 2005
REVISION: 1
PAGE 1 OF 2

AUDITS

1.0 PURPOSE

- 1.1 To describe the method and controls employed in planning, scheduling, conducting and documenting the results of audits used to verify compliance with significant aspects of the Quality Assurance Program.

2.0 SCOPE & APPLICABILITY

- 2.1 The scope of this section encompasses work requiring compliance with ASME NQA-1, 10 CFR Part 50 Appendix B, 10 CFR Part 71, Subpart H, 10 CFR Part 72, Subpart G.
- 2.2 This section applies to the Quality Department and any other department, within Columbian Hi Tech, assigned responsibility for audit functions, by the Vice President of Quality.

3.0 RESPONSIBILITY & AUTHORITY

- 3.1 Quality Assurance is responsible for defining the plan, sequence, content and reporting of results of quality assurance program audits. To this objective, the President or Vice President of Quality, is authorized to select and assign personnel qualified per established procedure(s) but not having responsibilities in the areas being audited.
- 3.2 Audit results shall be documented by auditing personnel and shall be reviewed by management having responsibility in the area audited. Responsible management shall take necessary action to correct the deficiencies revealed by the audit.
- 3.3 Personnel performing audits shall be qualified in accordance with established procedure(s).

4.0 GENERAL

- 4.1 Audits shall be performed in accordance with established procedure(s). This procedure(s) shall as a minimum provide for:

Prepared By:	Released By:	Release Date:
J. P. Burchfield	R. E. Hypes	4/4/2005

- 4.1.1 An objective evaluation of compliance with established requirements, methods, and procedures:
- 4.1.2 Assessment of progress in assigned tasks:
- 4.1.3 Determining adequacy of Quality Assurance Program performance; and
- 4.1.4 Verifying implementation of recommended corrective action.
- 4.2 Deficiencies shall be documented (as applicable) and follow up performed to verify that corrections have been accomplished.
- 4.3 Audits shall be conducted periodically or on a random, unscheduled basis or both. It is desirable to conduct audits when one or more of the following conditions exist:
 - 4.3.1 When it is necessary to determine the capability of a Vendor's Quality Assurance Program prior to awarding contract or purchase order.
 - 4.3.2 When significant changes are made in functional areas of the Quality Assurance Program, including significant reorganizations and/or procedure revisions.
 - 4.3.3 When it is suspected that safety, performance, or reliability of the item is in jeopardy due to deficiencies and nonconformances in the Quality Assurance Program.
 - 4.3.4 When a systematic, independent assessment of program effectiveness or item quality or both is considered necessary.
 - 4.3.5 When it is considered necessary to verify implementation of required corrective actions.
- 4.4 The President shall regularly review the status and adequacy of this program by examination of audit results received from the Vice President of Quality, by personal assessment of various program elements, by audit and documentation of same; by review of Columbiana Hi Tech Customer audits/reports. Results of the above shall be discussed with the Vice President of Quality, and documented by letter, memo, etc. on an annual basis.