

TEXAS UTILITIES GENERATING COMPANY

SKYWAY TOWER • 400 NORTH OLIVE STREET, L.B. 81 • DALLAS, TEXAS 75201

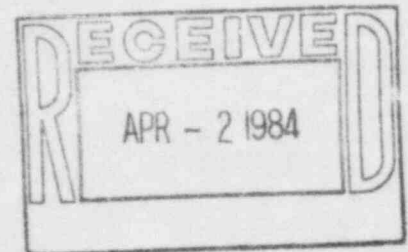
BILLY R. CLEMENTS
VICE PRESIDENT, NUCLEAR OPERATIONS

March 29, 1984
TXX-4139

Mr. E.H. Johnson, Chief
Reactor Project Branch 1
U.S. Nuclear Regulatory Commission
Office of Inspection and Enforcement
611 Ryan Plaza Drive, Suite 1000
Arlington, TX 76012

Docket Nos.: 50-445
50-446

COMANCHE PEAK STEAM ELECTRIC STATION
DEFICIENT LUG CRIMPING
QA FILE: CP-84-07, SDAR-131
FILE NO.: 10110



Dear Mr. Johnson:

In accordance with 10CFR50.55(e), we are submitting the enclosed report of actions taken to correct a deficiency regarding deficient lug crimping.

Supporting documentation is available at the CPSES site for your Inspectors review.

Very truly yours,

for *Richard E. Kehler*
B.R. Clements

BRC:mm

cc: NRC Region IV - (0 + 1 copy)

Director, Inspection & Enforcement (15 copies)
U.S. Nuclear Regulatory Commission
Washington, DC 20555

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ATTACHMENT
DEFICIENT LUG CRIMPING

Description

During routine inspection by quality control, several site nonconformance reports have been issued due to deficient lug crimps on field routed cable. In the process of assessing the concern, additional lugs were observed to be deficient in the termination cabinets. These terminations were provided by the supplier (Reliance).

Reinspection by supplier quality inspection personnel identified the following nonconforming conditions in terminal and connector pin crimps:

- a) Insufficient insertion into the terminal due to inadequate stripping of the conductor insulation;
- b) Insufficient insertion of the conductor/terminal into the crimping tool to allow full crimping;
- c) Excessive insulation removal on connector pins; and,
- d) Inadequate crimps which could be pulled loose with minimal force.

Due to extent of the concern in the termination cabinets, the reinspection effort was expanded to include more Class 1E equipment provided by the supplier. Similar concerns were observed for the control boards and handswitches, the Unit 1 alternate shutdown panel, and assorted vertical panels and local HVAC control panels. The Class 1E equipment examined performs an interface for control and operation of the plant.

Subsequent engineering evaluations have concluded lug crimping activities performed in the field do not adversely impact plant safety. The scope of this concern is limited to vendor crimping only.

Safety Implication

In the event the vendor terminal and pin crimping concerns had remained undetected, the reliability of the Class 1E equipment could not be assured during plant operation.

Corrective Action

All Class 1E equipment provided by Reliance on the jobsite will be inspected for proper terminal and connector pin crimping. Deficiencies will be documented and reworked per the vendor's program for control of nonconforming items. Efforts for Unit 1 and 2 equipment should be completed by March 30, 1984 and May 31, 1984 respectively.

During routine release inspections at the vendors facility, TUGCO QA personnel will provide additional emphasis on the terminal and pin crimping in termination cabinets which have not yet been shipped to CPSES.