



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

Docket No 99900080

MEMORANDUM: Uldis Potapovs, Section Chief  
Reactive Inspection Section No. 1  
Vendor Inspection Branch

FROM: Larry L. Campbell, Team Leader  
Reactive Inspection Section No. 1  
Vendor Inspection Branch

SUBJECT: INSPECTION PLAN FOR COPEs VULCAN, INC.  
LAKE CITY, PENNSYLVANIA

INSPECTIONS DATES: August 31-September 4, 1992

VENDOR LOCATION: Copes Vulcan, Inc. (CV)  
P.O. Box 577 (Martin and Rice Avenue)  
Lake City, Pennsylvania 16423

CONTACTS: Jim Scarpelli, Director of Quality Assurance  
(814) 774-1518

DOCKET NO.: 99900080

INSPECTION REPORT NO.: 99900080/92-01

UNANNOUNCED INSPECTION: No

INSPECTION TEAM MEMBERS: Ken Battige, NRR/DRIS/VIB  
Larry L. Campbell, Team Leader, NRR/DRIS/VIB

VENDOR PRODUCTS: CV is a manufacturer and supplier of ASME  
Section III Code Class 1, 2, and 3 valves and  
valve parts for commercial nuclear plant  
applications.

INSPECTION BASES: 10 CFR Part 50, Appendix B; 10 CFR Part 21

INSPECTION SCOPE: Evaluate CV's quality program for safety-related  
items, design control including configuration  
control, control of sub-vendors, 10 CFR Part 21  
and corrective action, and commercial grade  
dedication activities required to produce and  
supply safety-related valve parts. The  
inspection will include but be limited to the  
following reviews:

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PDR GA999 EMVCOPES  
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1. Quality Assurance (QA) Program for Non-Code Safety-Related Items

Review CV's QA program for the manufacturing and supply safety-related items with emphasis on the following areas:

- a. Evaluate CV's controls for sub-vendors (i.e. audits, surveillances, source inspections, commercial grade surveys). Specifically review controls for the supplier(s) of the replacement valve internals, bolting, and pins, addressed in References B, C and D, respectively (see Section 3 of this plan).
- b. Evaluate CV's control for purchasing and accepting safety-related items including imposed material and quality specifications and requirements on sub-vendors, specifically:  
  
Review CV's purchase of the replacement valve internals, bolting, and pins. Determine if the items were manufactured and/or supplied in accordance with the licensee's purchase requirements (see References B, C, and D).
- c. Determine if CV purchases non-Code items as commercial grade and then supplies them as dedicated safety-related items. Evaluate CV's program for dedication of commercial grade items.
- d. Evaluate the activities required to fabricate non-Code valve parts.

2. Design Control

Evaluate the design controls and design interface requirements between CV and their suppliers and the overall compliance with the requirements of Criteria III, "Design Control," of Appendix B to 10 CFR Part 50.

- a. Specifically evaluate the design interface between CV and Pacific Gas and Electric for the replacement of valve internals for the Diablo condenser steam dump valves (see Reference B).
- b. Review CV's analysis and evaluation of their alleged design misapplication of the use of small diameter lockwire in lieu of a locking pin as report by Portland General Electric Company (see Reference D),
- c. Review the methodology used by CV for classifying valve parts as safety-related or nonsafety-related.

3. 10 CFR Part 21 and Corrective Action

Evaluate the procedures for evaluating deviations and/or notifying customers. Also determine if CV is implementing 10 CFR Part 21 requirements such as passing on Part 21 to sub-vendors when required, adequate Part 21 posting location and documents, and incorporation of recent changes to Part 21 (Reference: NRC IN 91-76). Also specifically

review CV's evaluation and corrective actions for the conditions identified in References A, B, C, and D.

#### INSPECTION BACKGROUND

1. Last inspection Report:
  - a. 99900080/88-01, Inspection Conducted November 7-11, 1988, Lake City, Pennsylvania
2. Follow up items from Previous Inspection Report-Item B.4 from Inspection Report 99900080/88-01
  - a. Notice of Violation - Verify that commercial nuclear customers have been notified of incorrect center-of-gravity and weight data provided on valve assembly drawings.
  - b. Notice of Nonconformance -Verify that center-of-gravity and weight calculations were independently verified by qualified individual(s) independent of those performing the original calculations.
3. Reference Items:
  - A. Carolina Power and Light Company Licensee Event Report 91-001, H.B. Robinson Steam Electric Plant, Unit No. 2, Inoperable Pressurizer Power Operated Relief Valves, dated February 18, 1991.
  - B. Pacific Gas and Electric Company Revised Licensee Event Report 1-90-017-01, Diablo Canyon Unit 1, Reactor Trip Resulting From Failed Open Pressurizer Spray Valve Due to Incorrect Screw Installation, dated October 23, 1991.
  - C. Texas Utilities 10 CFR Part 21 Report No. P21R-92-002 "Comanche Peak Steam Electric Station (CPSES), Docket Nos. 50-445 and 50-446, Yoke to Bonnet Bolting Material," dated February 13, 1992.
  - D. Portland General Electric Company Licensee Event Report 92-02, Trojan Nuclear Plant, Inadequate Disc Nut Locking Device Results in Residual Heat Removal Pump Discharge Check Valve Failure, dated February 27, 1992.
  - E. NRC Information Notice 91-76: 10 CFR Parts 21 and 50.55 (e) Final Rules, dated November 26, 1991.
4. Other Information

Accommodations: Reservations are in L. Campbell' name

Days Inn  
I-90, Exit 7  
7400 Schultz Ave  
Erie, PA 16509  
(814) 868-8521

Entrance Meeting: Approximately 1:00 p.m.  
Monday, August 31, 1992  
Copes Vulcan, Inc.  
Martin and Rice Avenue  
Lake City, Pennsylvania 16423

Exit Meeting: Mid-morning, Friday, September 4, 1992.

SIGNATURE:

Larry L. Campbell  
Larry L. Campbell, Team Leader

08/19/92  
Date

APPROVAL:

Uldis Potapovs  
Uldis Potapovs, Section Chief

8/19/92  
Date