

# HOPKINSONS

VALVES ACTUATORS BOILER MOUNTINGS SOOT BLOWERS

HOPKINSONS LIMITED  
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Huddersfield  
England  
HD2 2UR

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Nuclear Regulatory Commission,  
Region IV,  
611 Ryan Plaza Drive, Suite 1000,  
Arlington,  
Texas 76011.

For the attention of Mr. U. Potapovs, Chief, Vendor Inspection Branch

Our ref: P/PEH/JL

Your ref:

Tuesday,  
13th January, 1981.

Subject:

Dear Sirs,

Docket 99900086/80-02

Thank you for your letter of December 4th 1980 giving the results of the QA programme inspection conducted October 20th-24th 1980. We list below the actions taken to correct the findings, and trust that you will find this information satisfactory.

## Deviation A1

The subject design concession was not being used to specify radii for manufacture, but to provide information for Inspection Department as to the size of acceptable radii. However, it is accepted that this use of a Design Concession is not covered by our Q.A. Manual. The drawings without specified radii (all imperial) for all components which had not completed machining have therefore been amended to specify the permissible size of radii. This instruction was issued on 7th November 1980 (Exhibit A1) and all drawings were modified by mid November.

It is to be noted that all metric drawings did already specify the appropriate radii, and after the original deviation identified in June 1980, all components have been machined and inspected to the dimensions specified on the drawings.

## Deviation A2

Rework order for 12SM5635 did specify Rev F of the appropriate drawing, although the correct revision was Rev G which was in fact specified by the original manufacturing order and was correctly attached to the order. This mistake was a human error which resulted from the method of recording drawing amendments on the manufacturing order. A clearer method for recording such changes on the manufacturing order had already been agreed with the appropriate Department - see Exhibit A2 - and should help to prevent such errors in future.

Additionally, instructions were issued as part of a note dated 27.10.80 to those Q.A. staff who issue rework orders, that drawing revisions must be checked against drawing and manufacturing order - see Exhibit A3.

8104020883

Tuesday,  
13th January, 1981.Deviation B

For nonconformity 208, it was established while your inspector was present at the "Hold Area" that the "Hold Tag" had become detached during transit of the component, and the tag was located and replaced immediately.

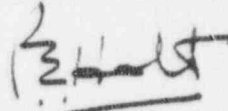
For nonconformity 207, no evidence was found to indicate that a Hold tag had ever been present, and one was therefore completed, and attached to the component. The inspector concerned was disciplined for failure to comply with the required system and also given additional training in the requirements. - See exhibit B1 - to provide the necessary preventive action.

Deviation C

For the subject valve, the operation which had not been signed off was for drying the valve and fitting a new packing. The operation had been completed, but, as noted by the NRC inspector, had not been stamped off by the Hopkinson inspector before the valve was moved to the next operation. Although in contravention of Q.A. Manual requirements, this did not affect the quality of the valve, and no action was therefore necessary on the valve.

With regard to preventive action, a note was issued to production and inspection management on 27th October 1980, pointing out the facts and requesting adherence to procedure in future - exhibit C1. Additionally, this aspect of process control was included as part of a training lecture given to production and inspection personnel at management and foreman level. Copies of sample training register records for two of these sessions are included as exhibits C2 and C3.

Yours faithfully,  
for HOPKINSONS LIMITED.,



P. B. Holt.  
Quality Assurance Executive.

Inc.

RW/FCB



## INTERNAL MEMORANDUM

TO: R. A. Grimston FROM: R. Watson

DATE: 7th November, 1980 COPIES TO: P. E. Holt  
D. Croft  
D. Fryer  
P. M. Etches

SUBJECT: W.P.P.S.S. 3 & 5

Will you please carry out the following corrective action required as a result of the audit by the N.R.C.

Drawings for lids to be modified to include radii on the backs of the body and pillar flanges where the machining ends. The orders which require this modification are SA's 5631, 5632, 5231, 5646, 5234, 5235, 5630, 6095, 5633, 6066, 5637, 5638, 6068, 6069, 5641, 6070 and 5642.

Will you please modify the drawings and issue amendment special specification sheets for these SA's.

R. Watson

Enc. Copy of position of Lids. 6.11.80



JP/AE

## INTERNAL MEMORANDUM

FROM: J. PRATT TO: MR. K. ELLIOT  
DATE: 24th July, 1980 COPIES TO: Mr. F. W. Caudwell  
SUBJECT: W.P.P.S.S. CONTRACT No. X903/585 Mr. P. E. Holt

A recent Audit has criticised the method of amending drawing issues on to Manufacturing Orders.

It was agreed with Mr. Holt that in future we would use "whiting out" fluid to obliterate the previous drawing issues - so that only the current issue is visible.

Mr. Holt also suggested that in certain cases it may be necessary to use a white adhesive patch, and this would be acceptable.

J. Pratt  
Production Control Manager.

Additionally when rework orders are being raised by Q.A. Department, it is essential that the correct drawing revision is checked both on the manufacturing order and also on the drawing to ensure that the issues are correct and are correctly listed on the rework order.

DW/AB/DF

HOPKINSONS LIMITEDTRAINING RECORDLECTURE GIVEN BY: H. ROBINSON.DATE OF LECTURE 28.10.80 DURATION OF LECTURE 30 MINS.LECTURE SUBJECT TITLE  
NON-CONFORMING MACHINED PARTSREFERENCE MATERIALPROCEDURES NH-1 REV 4 2.6  
N12-2 REV 2 5.2, 6.2.1PERSONNEL ATTENDEDJ. BOOTH. 604016.  
Q.C INSPECTORSIGNATURE H. RobinsonTITLE Chief GC RepDATE 28.10.80Copies to: A. A. Manager  
Training Officer

1. The valve on 68SM5228 was seen set up on the horizontal borer for machining of the weld end profiles at operation 230, without the proceeding operation 220 for drying the valve having been stamped-off by the inspector. This was one out of only five orders which were checked for process control, and it therefore appears that 20% of manufacturing orders show deviations from the requirement for operation sequence control. Action HR and DC.

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HOPKINSONS LIMITEDTRAINING RECORDLECTURE GIVEN BY:

P. E. HOLT

DATE OF LECTURE

9.12.80

DURATION OF LECTURE

1 hour

LECTURE SUBJECT TITLE

Company Q. A. Requirements  
To be used as basis for management talks  
to supervisory staff.

REFERENCE MATERIAL

P. E. H. lecture notes dated 8/12/80  
+ Q. A. Manual.

PERSONNEL ATTENDED

K. Pycroft	Foundries Mgr
S. Palmer	Steel Fdy Mgr
H. Bottill	Plat Fdy Mgr.
D. Craft	Works Mgr.
H. Robinson	Ch. Inspector

SIGNATURE

P. E. Holt

TITLE

Q. A. Executive

DATE

9/12/80.

Copies to: Q. A. Manager  
Training Officer



HOPKINSONS LIMITEDTRAINING RECORDLECTURE GIVEN BY: D CROFT WORKS MANAGERDATE OF LECTURE 5/1/81 DURATION OF LECTURE 30 mins.LECTURE SUBJECT TITLE

Company QA requirements

REFERENCE MATERIAL

P.E.H. Lecture notes dated 8/12/80.

PERSONNEL ATTENDED

<u>Davis</u>	FORBMAN	5-1-81
Reelings	"	
PA Edward	"	
Kayle	"	
Priveaux	"	
C. B. B. B.	"	
C. B. B. B.	"	
S. Taylor	"	
L. Nelson	"	

SIGNATURE

D Croft

TITLE WORKS MANAGER

5/1/81

Copies to: G. A. Manager  
Training Officer