



October 25, 1996

US Nuclear Regulatory Commission
Region III
801 Warrenville Road
Lisle, IL 60532-4351

Attention: Mr. James L. Cameron

Dear Mr. Cameron:

Subject: October 7, 1996 NRC Inspection - 3M Brookings, SD Facility
NRC License 22-00057-61

In our October 16, 1996 letter to you, we committed to providing you information on our records audit. This letter provides a copy of that audit plus the additional information we have discussed in subsequent telephone conversations with members of your office.

Audit Summary

The records audit was conducted on October 9, 10, 11 and 15, 16, 1996. A complete copy is enclosed as Attachment 1. A review of records, including the gamma sterilizer control room door Key Log and the Gamma Sterilizer Log for the period August 1, 1995 through October 11, 1996, has identified three weekends for which it appears that an Authorized User was not onsite for limited time periods while the sterilizer was being operated. These precise times are as follows:

- December 23, 1995 for the time period 11:55 am to 2:53 p.m.
- July 27, 1996 for the time period 11:47 am to 4:00 p.m.
- The weekend of August 17 & 18, 1996.
 - August 17 for the period 6:31 p.m. to 11:49 p.m.
 - August 18 for the periods 8:00 am to 8:38 am and 8:06 p.m. to 11:52 p.m.

The records review showed that the circumstances surrounding each of these occurrences differed.

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Pre Inspection Actions

On August 20, an Authorized User issued a "Fix It Ticket" after noting the apparent operation of the gamma sterilizer on the weekend of August 17 & 18, 1996 without an Authorized User present. A copy is shown in Attachment 2. Following evaluation by the facilitator, the requirement to always have an Authorized User present when the sterilizer is in operation was communicated to the Authorized Users in a September 5, 1996 electronic mail message shown in Attachment 3. The required onsite presence of an Authorized User was again discussed at the S-8 (gamma sterilizer) Team meeting held on September 26, 1996 as evidenced by a copy of the September 27, 1996 electronic mail message enclosed as Attachment 4.

All operation of the gamma sterilizer since August 18, 1996 has been conducted with an Authorized User present. The facility has absolutely committed to maintain compliance with this requirement. To further ensure certainty, new procedures have been implemented to log passing of the control room key from the outgoing to the incoming Authorized User.

Post Inspection Actions

On October 9, 1996, Health Physics Services personnel held an onsite meeting with the sterilizer Radiation Safety Officer, key plant management personnel and "Authorized Users" to underscore the requirement for "Authorized User" onsite presence during sterilizer operation. Additionally, new procedures have been implemented to document passing of the control room key from the outgoing to the incoming operator.

Analysis and Corrective Actions

3M recognizes its responsibility to maintain strict compliance with each and every applicable regulation. Part of this responsibility involves:

- establishing appropriate operational systems to ensure full compliance with the regulations;
- establishing appropriate documentation systems to document compliance; and
- regularly auditing the documentation systems.

The root cause of 3M's failure to have an Authorized User on site at all times was that 3M did not have an effective operational or documentation system in place to ensure compliance.

3M is correcting this problem by establishing new procedures and documenting that they have been performed.

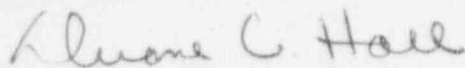
- The Authorized User on site during one shift is required to physically hand-off the control room access key to an Authorized User who will be on site during the subsequent shift. The Authorized User will shut down the sterilizer if the hand-off does not take place. This procedure has already been implemented.
- The hand-off of the control room key is recorded in the Gamma Sterilization log. The Gamma Sterilization records will be regularly reviewed by the Radiation Safety Officer on site.
- 3M will review its current operational and documentation systems and redesign as necessary to ensure that the appropriate procedures and systems are in place to ensure compliance with all regulations.

In addition, 3M will implement the following actions:

- Two additional employees will be trained and certified as Authorized Users by December 1, 1996.
- Training documents and exams will be reviewed by key Brookings gamma sterilizer personnel and Health Physics Services personnel to improve assurance that regulatory requirements are effectively communicated.
- Contract sterilizers have been identified to sterilize overflow product as required.
- Additional Cobalt-60 is scheduled to be loaded in early 1997 to reduce cycle time.

We believe that the above actions will ensure our full and continuous compliance with all applicable NRC regulations. We shall continue to fully cooperate with your office in this matter. Please direct any questions to me at 612/733-7316.

Sincerely,



Duane C. Hall, Manager
Health Physics Services

c: J.M. Ditlefsen, Plant Mgr., Brookings, 01/036
R.A. Christianson, Sterilizer Facilitator, Brookings, 01/036
D.A. Loeser, Health Physics, 220-3W-06
J. A. Nichol, Mfg. Dir., Medical Products Technology Div., 275-5E-01
Dr. F.J. Palensky, Div. VP, Medical Products Technology Div., 275-4W-02
R.J. Stangeland, Radiation Safety Officer, Brookings, 01/036
K.E. Welke, Group VP, Medical Markets Group, 220-14E-16
L.R. Zobel, M.D., Director, Medical Dept., 220-2E-02

ATTACHMENT 1

3M BROOKINGS, SD GAMMA STERILIZER RECORDS AUDIT

OCTOBER 9, 10, 11, 15 & 16, 1996

3M Internal Correspondence

To: M. P. Carey - Med Prdcts Grp Qual Assur - 275-3E-08
D. C. Hall - Health Physics Services - 220-3W-06

From: R. R. Hedlund - Health Physics Services - 220-3W-06
A. C. Kosmerl - Med Prdcts Grp Qual Assur - 275-3E -08

Subject: Records Audit (Limited) of 3M Brookings Plant Gamma Sterilizer

Date: October 21, 1996

BACKGROUND

On October 9, 10, 11 and 15, 16, 1996 A. C. Kosmerl and R. R. Hedlund, reviewed records of the S-8 Gamma Sterilizer at the 3M Brookings, SD plant. The objective of the review was to determine whether the sterilizer had been operated at any time without an Authorized User on the site during the period of August 1, 1995 to the present. The records reviewed were: the S-8 Operators Key Sign In and Sign Out Sheet, the 3M Gamma Sterilizer Log, the Employee Register and an Employee Training Record.

The S-8 Operators Key Sign In and Sign Out Sheet (Key Log) was reviewed to determine the times when an Authorized User was not on site. This key controls the control room door, the equipment room door, the roof access door, and the penthouse door which is where the source rack control mechanism is located. The sterilizer is normally operated with three shifts for 24 hour operation and the key is passed to the relieving Authorized User. When there is no relief the Operators key is turned into the Security Guard at the Employee Entrance with an entry of the time and date with signatures of both the Authorized User and the Security Guard in the "Key In" column of the Key Log. When the next operator arrives at the plant they receive the Operators Key from the security guard and enter the time and date with signatures of both the Authorized User and the Security Guard in the "Key Out" column of the Key Log.

The 3M Gamma Sterilizer Log was reviewed to determine the dates and times the sterilizer was operated. Events such as startup and shutdown are recorded with dates and times. In addition, the cumulative Source Up Clock reading is recorded on this log.

The Employee Register is used by shift employees that enter or leave the plant at other than their normal times.

The Employee Training Record was reviewed to verify an Authorized User was on site during a particular period. The Training Record is used for recording attendance of plant training sessions and signed by those in attendance.

The Authorized Users of the S-8 Gamma Sterilizer are: G. E. Pavsek, L. I. Moller, T. K. McLagan, K. J. Leisinger, M. J. Hallan, D. R. Sorensen, T. J. Meyer, R. A. Christianson, R. J. Stangeland and J. A. Hoffman. R. J. Stangeland and R. A. Christianson have their own operator key for the sterilizer. All other Authorized Users use the Operators Key controlled by the Key Log.

FINDINGS

After determining the time and dates the key was in the security guard's possession we then reviewed the 3M Gamma Sterilizer Log and determined the sterilizer had been operated with no documentation of an "Authorized User" on site during the following times:

- On Saturday December 23, 1995 the Key Log and 3M Gamma Sterilizer Log indicates no Authorized User was on site from 11:55 AM to 2:53 PM and the sterilizer was operating. See attachment A.
- On Saturday July 27, 1996 from 11:47 AM to 4:00 PM the Key Log and the 3M Gamma Sterilizer Log indicates there was no Authorized User on site while the sterilizer was operating. See attachment B.
- On Saturday August 17, 1996 from 6:31 PM to 11:49 PM and Sunday August 18, 1996 from 8:00 AM to 8:38 AM and from 8:06 PM to 11:52 PM, the Key Log and the Gamma Sterilizer Log indicates there was no Authorized User on site while the sterilizer was operating. See attachment C.

For Monday September 23, 1996 from 4:05 PM to 5:00 PM the Key Log does not show an Authorized User was on site. However, Ron Stangeland was on site during this time. This was verified by personal interviews with:

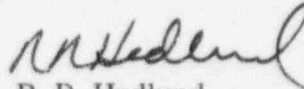
- Mary Hallan said she had kidded Ron Stangeland later for not unloading the totes during this time.
- Ron Stangeland's Franklin Planner indicated he was meeting until 5:00 PM on this date with Greg Anderson.
- Greg Anderson is Ron's supervisor and at the time had only been in this new assignment about two weeks. Greg said they met at this time so that Ron could teach him about the sterilizer.
- Bob Christianson said that he had been asked if he would be in the plant during this time, for the purpose of covering the sterilizer, but he had a previous commitment and could not, but had suggested checking with Ron.
- Karen Leisinger said she had broken into the meeting between Ron and Greg in Greg's office to ask Ron if he could cover the Sterilizer during this time and Ron said that he would.

See attachment D

Two other times during the period in question do not show an Authorized User on site. However, they are clearly a matter of writing in the wrong date in the logs.

- An entry in the 3M Gamma Sterilizer Log following the "07:43 August 20, 1995" entry is "2:21 August 20, 1995." The next entry is "4:35 August 21, 1995" and the "Source Up Clock Reading" indicated the sterilizer had run for 2.2 hours between the last two entries. This shows that the "2:21 August 20, 1995" date should have been entered as "2:21 August 21, 1995." See attachment E
- An entry in the Key Log in the "Key In" column by an Authorized User is 8:48 AM May 9, 1996. The next entry in the "Key Out" column by an Authorized User is 10:03 June 9, 1996. The following entries on this page of the Key Log are for May 1996. This indicates the June 9, 1996 entry should have been May 9, 1996. Further, the Employee Register indicates the Authorized User that made the entry in the "Key In" column signed out of the plant at the same time. An Employee Training record indicates the Authorized User that made the entry in the "Key Out" column attended a training session in the plant from 8:00 AM to 10:00 AM on May 9, 1996. This verifies that there was an Authorized User on site during the period in question on May 9, 1996. See Attachment F


A. C. Kosmerl


R. R. Hedlund

RRH

Attachments A through F

3M Gamma Sterilizer Log

Entry must be made every time source is raised or lowered or a timer change is made.

Date	Time of Day	Cycle Time	Source Up Clock Reading	Box Number	Source Up Freq. Number	Run Start Total # Spins at Run #	Reason For Shutdown	Restart (3)	Timer Chg. (Set g)	Oper. Init.	Co - 60 Monitor On	Zero
12-22	2:30	4:30	816322	250084	104588	13 931		✓		CP		
12-22	2:50	4:30	816326	250089	104589	931	safety Top			CP		
12-22	3:20	4:30	816326	250089	104590	118 931		✓		CP		
12-23	1:35	4:30	816428	250221	104590	931	T.C.		4:40	TM	✓	2
12-23	5:32	4:30	816467	250076	104590	931	TC		4:42	MAI	✓	2
12-23	11:31	4:42	816528	250354	104590	931	TC		4:48	MAI		
12-23	2:56	4:48	81656.1	250395	104591	34 931	Shutdown 1 hr. cleanup info. 2 hrs. frozen air line	✓		MH	✓	2
12-21-95	3:03	4:48	81656.1	250395	104592	931	elevator switch			TM		
12-21-95	3:10	4:48	81656.2	250397	104593	36 931				TM		
12-21-95	3:16	4:48	81656.3	250397	104594	931		✓		TM		
12-21-95	3:38	4:48	81656.5	250401	104595	40 931	elevator switch			TM		
12-21-95	3:52	4:48	81656.5	250401	104596	931		✓		TM		
12-21-95	3:53	4:48	81656.5	250401	104597	931	Pass			MH		
12-21-95	4:15	4:48	81656.5	250401	104598	931		✓		TM		
12-21-95	4:43	4:48	81657.0	250407	104599	40 931	total jam			TM		
12-21-95	4:52	4:48	81657.0	250407	104600	931		✓		TM		
12-21-95	5:35	4:48	81657.5	250414	104601	53 931	elev switch			TM		
12-21-95	5:46	4:48	81657.5	250414	104602	931		✓		TM		
12-21-95	5:55	4:48	81657.6	250416	104603	931	elev cylinder			TM		

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3M Gamma Sterilizer Log

Entry must be made every time source is raised or lowered or a timer change is made.

Date	Time of Day	Cycle Time	Source Up Clock Reading	Box Number	Source Up Freq. Number	Run Start Total # SPL #1 Run #	Reason For Shutdown	Restart (3)	Timer Chg. (Setg)	Oper. Inlt.	Co - 60 Monitor On	Zero
7/27/96	10:22	4:42	85976.6	312217	106200	16	test jam coil #3	✓		MH	✓	.2
7/27/96	4:00	4:42	85982.1	312288	106201	16				RAC	✓	.2
7/27/96	4:13	4:42	85982.1	312288	106202	16	hole pin (1st up)	✓		RAC		
7/27/96	4:21	4:48	85982.3	312290	106202		change timer #11115		4:48	RAC		
7/27/96	5:35	4:48	85983.5	312305	106203		shut down till the 12-8-96			RAC		
7/28/96	4:48	4:48	85983.5	312305	106204	16	space - one	✓		MH	✓	.2
7/28/96	3:00	4:48	85983.7	312332	106204	16	TC shut down jackpot 8hr.		4:54	MH		
7/28/96	3:56	4:54	85994.6	312443	106205	16				MH	✓	.
7/28/96	12:03	4:54	85994.6	312443	106206	16	start-up	✓		MH		
7/29/96	7:35	4:54	86002.1	312533	106207	16	Safety Timer			MH		
7/29/96	7:44	4:54	86002.1	312533	106208	16	?	✓		MH		
7/29	9:30	4:54	86003.8	312555	106209	16	input came #3			GP	✓	.2
7-29	9:40	4:54	86003.8	312555	106210	98 16		✓		GP		
7-29	3:35	4:54	86008.8	312628	106211	16	Exit gate stays open			GP		
7/29/96	3:45	4:54	86009.8	312628	106212	43 16	adjusted sys coiled manufar	✓		GP		
7/29/96	9:01	4:54	86015.1	312693	106213	108 16				GP	✓	.2
7/29/96	9:10	4:54	86015.1	312693	106214	108 16	B-N-P	✓		GP		
7/30/96	3:42	4:54	86021.7	312713	106214	59 16	TC		5:00	GP	✓	.2
7/30/96	8:16	4:54	86026.3	312827	106215	114 16	PM .2			GP	✓	.2

SIGN IN AND SIGN OUT SHEET

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3M Gamma Sterilizer Log

Entry must be made every time source is raised or lowered or a timer change is made.

Date	Time of Day	Cycle Time	Source Up Clock Reading	Box Number	Source Up Freq. Number	Run Start Total # of Runs	Reason For Shutdown	Restart (3)	Timer Chg. (Set/g)	Oper. Inlt.	Co - 60 Monitor On Zero
8/17/96	6:56a	4:00	86443.8	318857	106325	23	No Totes			Xg2	
8/17/96	7:07a	4:00	86443.8	318857	106326	32 23	Section C Out off of Cylinder			Xg2	
8/17/96	9:30a	4:00	86446.1	318891	106327	23	Checking Air Conditioning			Xg2	
8/17/96	10:01a	4:00	86446.1	318891	106328	66 23	Air Valve Shut off in Equipment Room			Xg2	✓
8/17/96	11:42a	4:00	86447.8	318916	106329	23	Reset Low Air			Xg2	
8/17/96	11:49a	4:00	86447.8	318916	106330	91 23	Safety Stop			Xg2	
8/17/96	1:00p	4:00	86449.0	318934	106330	110 23	Tote Jammed.			Xg2	
8/17/96	10:30p	4:06	86458.5	319012	106331	117 23	Timer Change		4:06	Xg2	
8/17/96	11:50	4:00	86458.5	319072	106332	23	Restarted			Xg2	✓
8/18/96	12:08	4:00	86458.7	319074	106333	119 23	dis			Xg2	✓
8/18/96	12:14	4:00	86458.7	319074	106334	18 23	dis			Xg2	
8/18/96	1:35	4:00	86460.0	319093	106335	23	dis			Xg2	
8/18/96	1:38	4:00	86460.0	319093	106334	23				Xg2	
8/18/96	1:40	4:06	86460.0	319095	106336	23	T.C.		4:02	Xg2	
8/18/96	2:01	4:12	86460.4	319099	106337	14 23	dis			Xg2	
8/18/96	2:14	4:12	86460.4	319099	106338	23				Xg2	
8/18/96	4:24	4:12	86460.7	319132	106338	23	T.C.		4:18	Xg2	
8/18/96	5:54	4:18	86464.0	319151	106339	66 23	Twisted tote			Xg2	
8/18/96	6:01	4:18	86464.0	319151	106340	23				Xg2	

3M Gamma Sterilizer Log

Entry must be made every time source is raised or lowered or a timer change is made.

Date	Time of Day	Cycle Time	Source Up Clock Reading	Box Number	Source Up Freq. Number	Run Start Total # Spins Run #	Reason For Shutdown	Restart (3)	Timer Chg. (Setg)	Oper. Inlt.	Co - 60 Monitor On	Co - 60 Monitor Zero
8/18/96	8:56	4:18	86466.9	319191	106340	23	Co-60 Monitor			kg8	✓	.2
8/18/96	4:44	4:18	86474.8	319299	106340	23	Co-60 Monitor			kg8	✓	.2
8/18/96	6:27	4:18	86476.5	319323	106341	23				kg8		
8/18/96	6:42	4:18	86476.5	319323	106342	108 23	corner jammed input	✓		kg8		
8/19/96	12:12	4:18	86480.5	319378	106344	23	Co-60 monitor start-up	✓		kg8	✓	.2
8/19/96	12:18	4:18	86480.5	319378	106345	23		✓		kg8	✓	.2
8/19/96	12:19	4:18	86480.5	319379	106346	23				kg8		
8/19/96	12:23	4:18	86480.5	319379	106347	34 23	P3's	✓		kg8		
8/19/96	12:30	4:18	86480.6	319380	106348	23		✓		kg8		
8/19/96	12:34	4:18	86480.6	319380	106349	36 23	P3's	✓		kg8		
8/19/96	12:42	4:18	86480.6	319381	106350	23	Box n- Post.	✓		kg8		
8/19/96	12:51	4:18	86480.6	319381	106351	38 23	Box n- Post.	✓		kg8		
8/19/96	12:58	4:18	86480.6	319381	106352	23	P3D	✓		kg8		
8/19/96	1:38	4:18	86480.6	319382	106353	39 23	Micro-switch	✓		kg8		
8-19-96	7:41	4:18	86486.7	319466	106354	123 23	106 jam corner 3 input			kg8		
8-19-96	7:49	4:18	86486.7	319466	106355			✓		kg8		
8-19-96	8:29	4:18	86487.4	319474	106356	1 23	tot jam			kg8	✓	.2
8-19-96	8:34	4:18	86487.4	319474	106357	23		✓		kg8		
8-19-96	9:30	4:18	86500.4	319455	106357	23			4:24	kg8	✓	.2

THE S-8 KEY WILL BE KEPT IN THE KEY CABINET ON THE WALL

S-8 OPERATORS KEY

SIGN IN AND SIGN OUT SHEET

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Gamma Sterilizer Log

Entry must be made every time source is raised or lowered or a timer change is made.

Date	Time of Day	Cycle Time	Source Up Clock Reading	Box Number	Source Up Freq. Number	Run Start Total # Spins Run #	Reason For Shutdown	Restart (3)	Timer Chg. (Set g)	Oper. Inlt.	Co - 60 Monitor On	Zero
1/21/96	7:58	4:00	87248.8	329997	106674	34 127	Corner #3 Tote Stuck Output	✓		Kg3		
1/21/96	8:08	4:00	87248.8	329997	106675	34	Corner #3 Tote Stuck Bottom	✓		Kg3		
1/21/96	10:45	4:00	87251.5	330036	106676	34	Corner #3 Tote Stuck Top	✓		Kg3		
1/21/96	11:07	4:00	87251.5	330036	106677	34	T.C.			Kg3	✓	
1/22/96	9:07	4:06	87261.5	330154	106677	34	T.C.			Kg3	✓	
1/22/96	3:28	4:12	87267.9	330275	106677	34	T.C.			Kg3	✓	
1/22/96	6:30p	4:12	87270.9	330317	106677	34	Timer Change			Kg3	✓	
1/22/96	9:30p	4:24	87274.0	330358	106678	34	Corner #3 Output			Kg3		
1/22/96	9:57p	4:24	87274.0	330358	106679	34	Tightened 3 screws small bin	✓		Kg3		
1/23	12:46	4:24	87274.8	330376	106680	34	Box in pass	✓		Kg3	✓	
1/23	12:55	4:24	87276.8	330396	106681	34				Kg3		
1/23	1:50	4:24	87277.7	330409	106682	34	B.I.P. change from ous sed. "D" input	✓		Kg3		
1/23	3:10	4:24	87277.7	330409	106683	34	T.C.			Kg3	✓	
1/23	10:32	4:24	87285.2	330510	106683	34				Kg3		
1/23	1:03	4:30	87287.7	330543	106685	34	B.I.P. to be gone input	✓		Kg3		
1/23	1:12	4:30	87287.7	330543	106685	34	T.C.			Kg3		
1/23	1:00	4:30	87287.7	330543	106685	34	Safety Stop to 101	✓		Kg3	✓	
1/23	8:43	4:36	87289.2	330642	106686	34				Kg3		

3M Gamma Sterilizer Log

Entry must be made every time source is raised or lowered or a timer change is made.

Date	Time of Day	Cycle Time	Source Up Clock Reading	Box Number	Source Up Freq. Number	Run Start Total # SPM #1 Run #	Reason For Shutdown	Restart (3)	Timer Chg. (Set'g)	Oper. Infr.	Co - 60 Monitor On Zero
8-19-95	3:50	4:06	79319.1	215284	102871	67 827	tighten f3c disc			tm	
8-19-95	3:56	4:06	79319.1	215284	102872	387				tm	
8-19-95	3:19	4:06	79330.4	215450	102873	887	P3's TC		4:12	mth	✓
8-19-95	3:26	4:12	79330.4	215450	102874	103 887	loose disk P3D	✓		MH	
8-19-95	7:12	4:12	79334.2	215503	102874	887	TC		4:18	mg8	✓
8-19-95	11:16	4:18	79338.2	215560	102875	887	Elevator			mg8	
8-19-95	11:30	4:18	79338.2	215560	102876	887	Elevator did not make switch connection	✓		mg8	
8-19-95	11:53	4:18	79338.6	215566	102877	887	TC & Shut down for Power Trip/Ex. Lockend-Sm. Can Fail/F. Power Reset		4:24	mg8	
8-20-95	07:43	4:24	79338.6	215566	102877					Rq8	✓
8-21-95	2:21	4:24	79338.6	215566	102878	887	Start up. Clean air	✓		MTH	✓
8-21-95	4:35	4:24	79346.8	215596	102879	887				CP	✓
8-21-95	4:35	4:24	79346.8	215596	102880	887	P3's Band scold	✓	4:30	CP	
8-21-95	2:55	4:30	79350.8	215730	102881	887	Dish			CP	
8-21-95	3:50	4:30	79350.8	215730	102882	123 887	Fix safety Eys	✓		CP	
8-21-95	6:33	4:30	79353.5	215767	102883	30 887	Low Plant air			ADJ	✓
8-21-95	6:39	4:30	79353.5	215767	102884			✓		ADJ	
8-22-95	3:10	4:30	79362.0	215879	102885	887	Discharge			MTH	✓
8-22-95	3:25	4:30	79362.0	215879	102886	887	Adjusted switch	✓		MTH	

ATTACHMENT F
PAGE 1 OF 5

SIGN IN AND SIGN OUT SHEET

[illegible]

3M Gamma Sterilizer Log

Entry must be made every time source is raised or lowered or a timer change is made.

Date	Time of Day	Cycle Time	Source Up Clock Reading	Box Number	Source Up Freq. Number	Run Start Total Spent Run #	Reason For Shutdown	Restart (3)	Timer Chg. (Setg)	Oper. Inlt.	Co - 60 Monitor On	Zero
5-7-96	12:57	3:48	842003	287722	105698	91 989	working on output			TM		
5-7-96	1:51	3:48	842003	287722	105699	93 989				TM		
5-7-96	1:58	3:48	842004	287724	105700					TM		
5-7-96	2:16	3:48	842004	287724	105701	989				TM		
5-7-96	2:19	3:48	842004	287725	105701	989	TC		3:54			
5-7-96	3:45	3:54	842019	287747	105702	118 989	P35			PPS		
5-7-96	3:52	3:54	842019	287747	105703					PPS		
5-7-96	5:28	3:54	842035	287771	105707	10 989	TC		4:08	PPS		2
5-7-96	9:25	4:06	842074	287829	105764	68 989	Yole gun conn. 3			PPS		
5-7-96	9:32	4:06	842074	287829	105765					PPS		
5-8-96	3:09	4:06	842130	287910	105706	989	replace output cylinder			tm		2
5-8-96	3:59	4:06	842130	287910	105707	989				MH		
5-8	12:45	4:06	842218	288039	105707	989			4:12	GP		
5-8	2:15	4:12	842233	288060	105707	989			4:18	GP		
5-8-96	5:01	4:18	842261	288097	105708	78 989	low Air			PPS		2
5-8-96	5:07	4:18	842261	288099	105709					PPS		
5-4-96	12:02	4:18	842330	288195	105709	44 989	TC		4:24	MH		2
5-9-96	11:03	4:24	842340	288345	105709	989	1060 mark			TM		2
5-9-96	8:07	4:24	842531	288468	105709	57 989	TC		4:30	PPS		2

Employee Register

Form 30314 - A - PWO

Name	Date		Page Number
	Dept. No.	Time In	Time Out
S. Nelson	1739		7:08
B. Bartness	1748		7:10
Shannon	1717	7:13	
S. Christensen	1746	7:16	
D. Kuttly	1708	7:18	
B. Hark	1708	7:38	
M. C. Beck	1712		7:44
Jack Longart	1708	7:52	
C. B. May	1710	7:52	
D. J. J. J.	1701	7:54	
E. Jones	1723		8:00
C. Englund	1728	8:01	
A. Knutson	1717	8:03	
DeLone Moe	1708	8:12	9:08
K. J. J. J.	1708	8:13	
P. J. J. J.	1709	8:14	
Karen J. Leisinger	1705	8:17	
E. J. J. J.	1712		8:26
S. Bultman	1709	8:34	
M. Palm	1709		8:40
T. L. L. L.	1738	8:47	
T. M. Lagan	1749		8:50
M. J. J. J.	1727		9:00
W. R. Van Maanen	1201		9:00
W. H. L. L.	1727		9:00
M. J. J. J.	1744		9:00
B. K. K. K.	1706		9:01
Karen J. Leisinger	1705		9:03

EMPLOYEE TRAINING RECORD

ATTACHMENT F
PAGE 4 OF 5
5/10/96

FOR: Plt Meeting
(NAME OF TRAINING SESSION)

DATE: 5/9/96
page 1 of 2 8-10 AM

PRESENTER: _____

TRAINING CODE: INW114
1 1/2 HR

NAME	DEPT#	EMPLOYEE #	NAME	DEPT#	EMPLOYEE #
1. Shirley Hagerfeld	1746	258667	26. Tan Englund	1744	295279
2. Kay Owens	1748	53031	27. Kelly Lee	1736	269811
3. Susan Brunsman	1746	280614	28. Kurt Nelson	1728	228323
4. Bob McFarland	1746	109024	29. Dave Koch	1708	63355
5. Barb Housley	1746	258647	30. Paul Remarche	1741	166949
6. Jens C Holm	1737	258666	31. Terry Nelson	1741	10111
7. Warner Stoker	1729	75774	32. ROGER D. SELLER	1802	316959
8. Ruth Milroy	1724	50268	33. Don Stream	1743	86969
9. Rich Herrig	1724	050280	34. Ron Menden	1741	10349
10. Roger Gomes	1708	269772	35. Mark Hansen	1740	228320
11. Dan Bell	1708	283386	36. Kathy Walker	1716	239257
12. Norrell Mac	1708	58798	37. Bobir Lindson	1748	200053
13. Brad Hark	1708	295260	38. Sherril Rupp	1748	269810
14. GREG SWENSON	1708	96145	39. Kayleen Blecker	1748	258678
15. Lyle Hawkinson	1708	283354	40. Tony Busch	1717	2410
16. Bob Lutz	1739	258708	41. RANDY FLASKEY	1717	063287
17. Ruth Arnesen	1706	4883	42. S. Christianson	1746	215989
18. Roger Owens	1712	50199	43. D. Mein	1746	227172
19. Gary Karher	1748	317052	44. Karl Nelson	1746	295273
20. Jack Langston	1708	283357	45. Lucille Hanson	1746	253829
21. DAVE HERNIMSTAD	1733	66468	46. L. L. Langston	1746	259663
22. Danny Holter	1739	269909	47. Lauren Buchheit	1746	279364
23. Ed Lantz	1748	9068	48. Jane Hundt	1746	213930
24. John Langland	1739	4967	49.		
25. RICH THORESON	1740	60376	50.		

EMPLOYEE TRAINING RECORD

ATTACHMENT F
PAGE 5 OF 5

FOR: _____
(NAME OF TRAINING SESSION)

DATE: _____

page 2 of 2 8-10 AM

PRESENTER: _____

TRAINING CODE: _____

NAME	DEPT#	EMPLOYEE #	NAME	DEPT#	EMPLOYEE #
1. Sue Ann Hesby	1730	312019	26.		
2. Linda Page	1746	76135	27.		
3. Linda Margaretta	1746	295283	28.		
4. Mary Leab	1746	280616	29.		
5. Jane Haufschell	1737	317053	30.		
6. Connie Langland	1701	83811	31.		
7. Jerry Pavek	1749	283409	32.		
8. Scott Hall	1730	295346	33.		
9. Donna M. TolK	1744	213958	34.		
10. Donna M. TolK	1744	213958	35.		
11. Lou Morris	1744	317054	36.		
12. Anne Schmidt	1737	66442	37.		
13. Gerald Colvers	1735	103382	38.		
14. Jimmy Brown	1738	239389	39.		
15. Kim Doeschel	1735	212222	40.		
16. Dave Matthews	1708	258640	41.		
17. Theresa Bennett	1742	223350	42.		
18. L. Z. Rysse Jak	1745	253765	43.		
19. Oliver Strubbe	1745	293504	44.		
20. Paul Solheim	1725	057933	45.		
21. Rena Larsen	1745	258651	46.		
22. Devin Brunsting	1742	31696	47.		
23. Dorothy Tipton	1746	312004	48.		
24.			49.		
25.			50.		

ATTACHMENT 2

BROOKINGS PLANT FIX IT TICKET

BROOKINGS PLANT

NO:

49-96-40



3M

[illegible]

BROOKINGS PLANT

NO:

NO: 400-omit

☒ **QUALITY**



Assigned to:

[illegible]

ATTACHMENT 3

SEPTEMBER 5, 1996 ELECTRONIC MAIL MESSAGE

CHRISTIANSON, BOB A-BRKG / L01036/01 - OpenDesk print.

Message.

Dated: 09/05/96 at 1203.

Subject: running S-8 unattended

Sender: Bob A-Brkg CHRISTIANSON / L01036/01

Contents: 2.

FROM: Bob A-Brkg CHRISTIANSON / L01036/01

Part 1.

FROM: Bob A-Brkg CHRISTIANSON / L01036/01

TO: Mary B BERG / L01036/01
Mary J HALLAN / L01036/01
Teresa K MCLAGAN / L01036/01
TERRY J MEYER / L01036/01
Lavonne I MOLLER / L01036/01
Gerry E PAVEK / L01036/01
Doug R SORENSEN / L01036/01

CC: Linda A KROGMAN / L01036/01
Bob T OHLSEN / L01036/01
Marilyn H SCHULLO / L01036/01
Ron J STANGELAND / L01036/01

Part 2.

Two weeks ago we had a meeting to discuss machine loadings and through the discussions we talked about S-8 running without an Authorized User on site. When I was not assigned to S-8, this must have been an issue. According to what I have been told was that our position back then, was with having the supervisory system provided "attended operation, especially when we had shift supervisors that were former Authorized Users, available around the clock. This was firmly disputed by the NRC. The NRC define "attended operation as having a current/Authorized User on the premises whenever the source is up or if the sterilizer is going to be entered. So in the future the only S-8 will run is to have a Auth/User on site. Sorry for the confusion!

if you have questions pls ask thxs Bob C.

ATTACHMENT 4

SEPTEMBER 27, 1996 ELECTRONIC MAIL MESSAGE

CHRISTIANSON, BOB A-BRKG / L01036/01 - OpenDesk print.

Message.

Dated: 09/27/96 at 1351.

Subject: S-8 SDWT Meeting Minutes

Sender: Bob A-Brkg CHRISTIANSON / L01036/01

Contents: 2.

TO: Bob A-Brkg CHRISTIANSON / L01036/01

Part 1.

TO: Mary B BERG / L01036/01
Bob A-Brkg CHRISTIANSON / L01036/01
Mary J HALLAN / L01036/01
Karen J LEISINGER / L01036/01
Teresa K MCLAGAN / L01036/01
Tammy J MEYER / L01036/01
Lavonne I MOLLER / L01036/01
Jerry E PAVEK / L01036/01
Doug R SORENSEN / L01036/01
Ron J STANGELAND / L01036/

CC: Greg J ANDERSON / L01036/01
Sandy L ANDERSON / L01036/01
Linda A KROGMAN / L01036/01
Deborah A LOESER / ALLIN1
Marilyn H SCHULLO / L01036/01
Rick A VANSAMBECK / L01036/01

Part 2.

The S-8 Team met and discussed:

1. goal results
2. 10CFR36 items
3. misc discussion

The S-8 Team's goal results from August were:

1. runtime goal 93% August was 95%
2. goal for reaction time was to monitor it, August was 1.1%
3. goal for NCN's was to monitor them, August there was 1 operator controlah
4. The Team said that they would review and discuss maint costs, we reviewed the August and YTD costs. Those results were::

1993	107,000
1994	80,000
1995	87,000
August	5,085
1996 ytd	59,400

If you project out the maint cost for 1996 it would be 89,100 for the year, that's with a \$12,000 rewiring co

The 10CFR36 items were:

1. Reviewed the Plant Health Physics Survey, dated Aug 14th, 1996
2. Asked if there was any questions on the subject of running S-8 with-out a Authorized User on site? (noted dated 9/5/96) there wasn't any question
3. Reviewed the Qtrly Audit of S-8 note, written by Deb Loeser on 8/7/96

The misc items discussed:

1. Talked about the NCN Fads at S-8, Mary was going to ask Dan Chapman on the status.
2. Ron updated the Team on the E-beam sterilizer project
3. Discussed the S-8 machine loadings and what drapes are not coming to

- Bkgs for sterilization. Ron also talked about a possible cobalt loading to reduce the machine load 20% to 25%.
4. Reviewed the letter summarizing noise exposures in the S-8 area.
 5. Talked about the missing dosimeters in the packages and to continue to watch for them!
 6. Discussed the Facilitator position at S-8
 7. The Team asked about on-line report training so the Operators could send F/G's to the WH. In talking to Pat Vincent, this may happen after the on-line update, about 6 weeks. Today it's felt that the Operators have the time if loads would need to be sent out to the WH but if there's a cobalt loading this may not be the case!
 8. Talked about getting some pages of reports that are not needed, Pat Vincent will be talking to Mary Berg.
 9. Talked about H wh and I mentioned to the Team that Duane Willms was assigned the task in helping us out in H in freeing up slots.
 10. Talked about SRF's coming from Pro/Pak, I'll follow up on those.
recorder: Mary Berg
members absent: Doug Sorensen, Doug I'll send you the 10CFR36 items for your review.

thxs Bob C>