

EXCELCO DEVELOPMENTS, INC.

MILL STREET • SILVER CREEK, N. Y. 14136 • AREA CODE 716-934-2651

September 18, 1978

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

Subject: Docket #99900331/78-02

Reference: Q.A. Inspection W.M. McNeill

Attention: V. Potapovs - Chief

Gentlemen:

The following are the answers and actions taken to correct the criticisms of the above inspection.

A - Criterion 2 - All parts, including the one stainless steel part machined and using Habcool 318 are and were cleaned according to the cleaning procedure for NAC 1 Cask prior to installation.

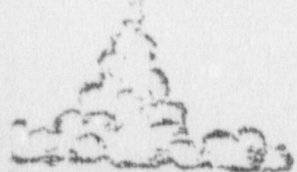
The proper cutting oil was purchased and in the plant the next day. Instructions were issued by the supervisor to all machine hands regarding proper use of cutting coolants.

B - No response required.

C - The weld procedure WS-5-10 was qualified using 304 material and 308 wire. (See paragraph L)

Paragraph El states: Selection of the proper filler metal shall include consideration of the compatibility of the filler metal's chemical and physical properties with those of the base material. The proper filler wire for 321 stainless is 347 and the weld parameter reflects this.

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C - cont'd. -

The 75 amp. current on the weld parameter sheet was the welders error; it should have read 175 amps. The weld parameter sheet at the time of the audit was not complete and had not been reviewed or approved by Q.A.

D - Purchase orders were issued reflecting order requirements of the code not realizing that 10 CFR 71 appendix E were also required. Future P.O.'s that require the incorporation of 10CFR71 appendix E will be adhered to.

E - (D-3) Items purchased from three vendors not on the qualified vendors list were catalog items normally supplied by retail sources.

The Balsa wood used for impact service was certified by document to the proper density requirements. This is another case of limited suppliers; who are not interested in qualifying to be a nuclear supplier.

The modification of the fire valves on NAC license agreement is optional. Excelco will modify the valves (drilling a drain hole) if requested by our customer.

In order to purchase the safety heads, we had to order them to the suppliers stock number which had to appear on our P.O. The part sold and received is identical to the customers drawing E10080.

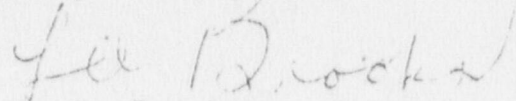
F. Items such as noted, are catalog manufacturers products and are inspected to the extent of visual identification and that required on the purchase order. The manufacturer certifies his product; the purchaser rarely has access to the manufacturers proprietary drawings.

G - A system of planned and periodic audits for one cask was not feasible at the time of the NRC audit as parts were just coming on line. Some unscheduled audits were made to satisfy manufacturing operations. Further audits were planned and put in operation.

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With regards to the question of qualifications of
personnel for auditing; our people are well qualified
by extensive education and years of experience.
Records will be generated to reflect these qualifications.

Very truly yours,

A handwritten signature in cursive script, appearing to read "L. A. Brooks".

L. A. Brooks

LAB/mab