

VENDOR INSPECTION REPORT

U.S. NUCLEAR REGULATORY COMMISSION
OFFICE OF INSPECTION AND ENFORCEMENT
REGION IV

Report No. 99900248/78-02

Program No. 44030

Company: Union Pump Company
87 Capitol Avenue
Battle Creek, Michigan 49016

Inspection Conducted: July 18-21, 1978

Inspector: *D. M. Hunnicutt*
for L. E. Ellershaw, Contractor Inspector, Vendor
Inspection Branch

8/1/78
Date

Approved by: *D. M. Hunnicutt*
D. M. Hunnicutt, Chief, Components II, Vendor
Inspection Branch

8/1/78
Date

Summary

Inspection conducted July 18-21, 1978 (99900248/78-02)

Areas Inspected: Implementation of 10 CFR 50, Appendix B Criteria, and applicable codes and standards including: control of nonconforming material, parts or components; corrective action; handling storage and shipping; design control; document control; and previous inspection findings. The inspection involved twenty-eight (28) inspector-hours on site.

Results: In the six (6) areas inspected, six (6) deviations from commitment were identified.

Deviations: Control of Nonconforming Material, Parts or Components - certain nonconforming report numbers were not referenced on hold tags, and hold tag numbers were not referenced on nonconformance reports as required by Criterion XV of Appendix B to 10 CFR 50 (Enclosure, Item A); Handling, Storage and Shipping - quarterly inspection schedule checklists of handling equipment were not available and dye penetrant examinations of crane hooks have not been performed, which is contrary to Criterion XIII of Appendix B to 10 CFR 50 (Enclosure, Item B); Design Control -

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certain customer quality requirements were not incorporated into Union Pump Company's bill-of-material and process sheets, thus a required inspection was not performed, which is contrary to Criterion III of Appendix B to 10 CFR 50 (Enclosure, Item C); Document Control - certain drawings did not have Quality Control approval as required by Criterion VI of Appendix B to 10 CFR 50 (Enclosure, Item D); Previous Inspection Findings (Material Identification and Control) - certain material, observed in the hold area, was not identified with the required nuclear part tags and one which was, was incorrectly identified with the required nuclear part tags and one which is contrary to Criterion VIII of Appendix B to 10 CFR 50 (Enclosure, Item E), and a bill-of-material, purchase order and material certification, identified certain material as SA-182 whereas the nuclear process sheet identified the same material as SA-240, which is contrary to Criterion VIII of Appendix B to 10 CFR 50 (Enclosure, Item F).

DETAILS SECTION

(Prepared by L. E. Ellershaw)

A. Persons Contacted

- *W. Bakkila, Quality Control Coordinator
- *W. Bramble, Inspection Supervisor
- R. Elliot, Manager, Manufacturing Planning
- *F. Evans, Quality Control Coordinator
- *T. J. Joy, Project Engineer
- *G. Law, Nuclear Sales Engineer
- R. Nelson, Safety Officer
- *P. D. Woods, Manager, Quality Control

*Denotes those attending the Exit Interview (See Paragraph I).

B. Action on Previous Inspection Findings

1. (Closed) Deviation A. (Report No. 78-01): This item dealt with non-conformity reports not being reviewed by the Material Review Board (MRB) or the Authorized Nuclear Inspector (ANI).

Union Pump Company (UPC) has implemented their committed corrective action, in that a review of non-conformity reports revealed that all had been reviewed by MRB and the ANI.

2. (Closed) Deviation B. (Report No. 78-01): This item dealt with the lack of distribution identification for Corrective Action Requests (CAR), and conflict between a QA Manual exhibit and the CAR form.

UPC has implemented their committed corrective action, in that CAR distribution has been identified, and the CAR form has been revised.

3. (Closed) Deviation C. (Report No. 78-01): This item dealt with the failure to document the cause of conditions adverse to quality or the action's taken to preclude repetition.

UPC has implemented their committed corrective action by revising the Corrective Action Request form to include the cause and the action taken.

4. (Closed) Deviation D. (Report No. 78-01): This item dealt with the failure to re-mark parts in which the original identification had been removed during a machining operation.

UPC has implemented their committed corrective action in that a letter was issued to Manufacturing Management regarding re-marking of parts. Additionally, observation of in-process parts showed them to be re-identified after machining operations.

5. (Closed) Deviation E. (Report No. 78-01): This item dealt with a drawing not indicating where the part was to be marked, and parts being marked in locations other than what the drawings called for.

UPC has implemented their committed corrective action in that corrective action requests were issued. Also, a review of drawings and observation of parts showed that drawings did indicate part marking locations, and parts were marked according to drawing requirements.

6. (Closed) Deviation F. (Report No. 78-01): This item dealt with the identification of a casing with the incorrect heat number.

UPC has implemented their committed corrective action in that a corrective action request was issued. Also, observation of parts and their associated paperwork, indicated correct heat number identification.

7. (Closed) Unresolved Item (Report No. 78-01): This item dealt with the filler metal control procedure not addressing the recording of issuance and return of weld filler metal in order to be in compliance with the four (4) hour time limitation regarding electrodes being out of the ovens.

UPC has implemented their committed corrective action in that the procedure has been revised, and it now reflects their actual practice.

C. Control of Nonconforming Material, Parts or Components

1. Objectives

The objectives of this area of the inspection were to verify that UPC had implemented the requirements for the control of nonconforming material, parts or components in accordance with the QA Manual and applicable NRC and ASME Code requirements.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of QA Manual Section 10, Revision 1, dated January 27, 1977.
- b. Review of non-conformity reports (NCR).
- c. Review of Material Review Board activities.
- d. Observation of material and its identity, in the designated hold area.
- e. Discussions with cognizant personnel.

3. Findings

- a. Deviation from Commitment
See Enclosure, Item A.
- b. Unresolved Item
None.

D. Handling, Storage and Shipping

1. Objectives

The objectives of this area of the inspection were to verify that UPC had implemented the requirements for handling, storage and shipping in accordance with the QA Manual and applicable NRC and ASME Code requirements.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of QA Manual Section 18, Revision 1, dated January 27, 1977.
- b. Review of storage areas and protective measures used for material/parts.

- c. Review of packaging and shipping procedures and practices.
- d. Review of Procedure MFU-1004-2, dated April 16, 1975 - "Material Handling Procedure."
- e. Review of Procedure QCR-4413-0, dated March 31, 1975 - "Handling Equipment Inspection Procedure."
- f. Discussions with cognizant personnel.

3. Findings

a. Deviation from Commitment

See Enclosure, Item B.

b. Unresolved Item

None.

E. Design Control

1. Objectives

The objectives of this area of the inspection were to verify that UPC had implemented the requirements for design process management and design document control in accordance with the QA Manual and applicable NRC and ASME Code requirements.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of QA Manual Sections 3, 4 and 7, Revision 2, dated January 27, 1977.
- b. Review of QA Manual Section 12, Revision 1, dated January 27, 1977.
- c. Review of Procedure "QCR-4410-4, "Design Control Procedure," dated April 30, 1976.
- d. Review design documentation of Nuclear Order N770777.
- e. Discussions with cognizant personnel.

3. Findings

a. Deviation from Commitment

See Enclosure, Item C.

b. Unresolved Item

None.

F. Document Control

1. Objectives

The objectives of this area of the inspection were to verify that UPC had implemented the requirements for the control of instructions, procedures and drawings in accordance with the QA Manual and applicable NRC and ASME Code requirements.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of QA Manual Sections 4 and 7, Revision 2, dated January 27, 1977.
- b. Review of instructions, procedures and drawings for the appropriate approvals.
- c. Review of Drawing Issue Notices and the logs maintained to show distribution.
- d. Discussions with cognizant personnel.

3. Findings

a. Deviation from Commitment

See Enclosure, Item D.

b. Unresolved Item

None.

G. Material Identification and Control

1. Objectives

The objectives of this area of the inspection were to verify that UPC had implemented the corrective action for commitments as delineated in their response letters to NRC dated April 4, 1978, and June 27, 1978.

2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of QA Manual Sections 7, 11, 12 and 13, dated January 27, 1977.
- b. Observation of in-process parts and material in hold areas and review of associated documentation.
- c. Review of Procedure QCR-4407-1, "Preparation, Review and Coordination of Nuclear Process Sheets," dated July 18, 1975.
- d. Discussions with cognizant personnel.

3. Findings

a. Deviations from Commitment

- (1) See Enclosure, Item E.
- (2) See Enclosure, Item F.

b. Unresolved Item

None.

H. Corrective Action

1. Objectives

The objectives of this area of the inspection were to verify that UPC had implemented the requirements for correcting conditions adverse to quality in accordance with the QA Manual and applicable NRC and ASME Code requirements.



2. Method of Accomplishment

The preceding objectives were accomplished by:

- a. Review of QA Manual Section 10, Revision 1, dated January 27, 1977.
- b. Review corrective action requests to assure that corrective action is documented, the causes are determined, and steps were taken to prevent recurrence.
- c. Discussions with cognizant personnel.

3. Findings

a. Deviation from Commitment

None.

b. Unresolved Item

None.

I. Exit Interview

A meeting was held at the conclusion of this inspection on July 21, 1978, with the following management, Authorized Inspection Agency, and customer representatives:

- M. Blumentrath, Director of Engineering
- E. Bolz, General Foreman
- V. F. Claar, Methods and Standards
- R. J. Craig, Authorized Nuclear Inspector, The Hartford Steam Boiler Inspection and Insurance Company
- G. DeSantis, National Sales Manager
- P. Flach, Manager, Product Engineering
- J. B. Freed, President
- T. Gossard, Production Control
- J. Johnson, Manager, Purchasing
- L. Ludy, Methods and Standards
- D. C. McHolme, Assistant to the President
- M. Rush, Application Manager
- D. Seymour, Nuclear Project Engineer
- M. Shook, Production Control
- H. Tobiasz, Manager, Centrifugal Pump Engineering
- D. Webster, Methods and Standards
- R. A. White, Manager, Production Control

R. Wheeler, QC Coordinator
W. Winslow, Manager, Manufacturing
J. Wooten, Quality Control Representative General Electric Company

Additional attendees are identified by an asterisk in paragraph A.

The scope and findings of this inspection were summarized. Management acknowledged the statements relative to the findings.