

St. 37-73

APR 22 1998 ENGINEERING DATA TRANSMITTAL

2. To: (Receiving Organization) Distribution		3. From: (Originating Organization) PFP Transition Engineering		4. Related EDT No.: N/A	
5. Proj./Prog./Dept./Div.: W-460		6. Cog. Engr.: DW Nelson		7. Purchase Order No.: N/A	
8. Originator Remarks: This project-specific Quality Assurance Program Plan is being issued for Project W-460, Plutonium Stabilization & Handling.				9. Equip./Component No.: N/A	
11. Receiver Remarks:				10. System/Bldg./Facility: PFP	
				12. Major Assm. Dwg. No.: N/A	
				13. Permit/Permit Application No.: N/A	
				14. Required Response Date: 4/10/98	

15. DATA TRANSMITTED					(F)	(G)	(H)	(I)
(A) Item No.	(B) Document/Drawing No.	(C) Sheet No.	(D) Rev. No.	(E) Title or Description of Data Transmitted	Approval Designator	Reason for Transmittal	Originator Disposition	Receiver Disposition
1	HNF-SD-W460-QAPP-001	ALL	0	Plutonium Stabilization and Handling, Quality Assurance Program Plan, Project W-460	Q	I		

16. KEY			
Approval Designator (F)	Reason for Transmittal (G)		Disposition (H) & (I)
E, S, Q, D or N/A (see WHC-CM-3-5, Sec.12.7)	1. Approval 2. Release 3. Information	4. Review 5. Post-Review 6. Dist. (Receipt Acknow. Required)	1. Approved 2. Approved w/comment 3. Disapproved w/comment 4. Reviewed no/comment 5. Reviewed w/comment 6. Receipt acknowledged

(G)		(H)		17. SIGNATURE/DISTRIBUTION (See Approval Designator for required signatures)								(G)	(H)
Reason	Disp.	(J) Name	(K) Signature	(L) Date	(M) MSIN	(J) Name	(K) Signature	(L) Date	(M) MSIN	Reason	Disp.		
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1	1	Cog. Mgr TE Huber	<i>T. Huber</i>	4/21/98	TS-50	FDH QA S. A. Byers	<i>S. A. Byers</i>	4/22/98					
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1	1	FDNW QA JW Schultz	<i>JW Schultz</i>	4-12-98	TS-15								

18. <i>EV Weiss</i> EV Weiss Signature of EDT Originator Date: 4-12-98		19. <i>EV Weiss</i> EV WEISS Authorized Representative for Receiving Organization Date: 4-12-98		20. <i>T. Huber</i> Cognizant Manager Date: 4/22/98		21. DOE APPROVAL (if required) Ctrl. No. <input type="checkbox"/> Approved <input type="checkbox"/> Approved w/comments <input type="checkbox"/> Disapproved w/comments	
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# Plutonium Stabilization and Handling Quality Assurance Program Plan

Evelyn V. Weiss

B&W Hanford Co., Richland, WA 99352

U.S. Department of Energy Contract DE-AC06-96RL13200

EDT/ECN: 617726

UC: 721

Org Code: 15C00

Charge Code: K6182

HAN97400

B&R Code: EW7003000

Total Pages: 32

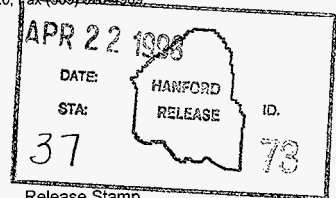
**Key Words:** Plutonium, PFP, Stabilization, Handling, SNM, W-460, Storage, Vault, PuSH, 94-1, Quality, QAPP

**Abstract:** This Quality Assurance Program Plan (QAPP) identifies project quality assurance requirements for all contractors involved in the planning and execution of Hanford Site activities for design, procurement, construction, testing and inspection for Project W-460, Plutonium Stabilization and Handling. The project encompasses procurement and installation of a Stabilization and Packaging System (SPS) to oxidize and package for long term storage remaining plutonium-bearing special nuclear materials currently in inventory at the Plutonium Finishing Plant (PFP), and modification of vault equipment to allow storage of resulting packages of stabilized SNM.

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*V. L. Burkland* 4/22/98  
Release Approval Date



**Approved for Public Release**

BWHC-9853379AR3

ATTACHMENT

CONSISTING OF 34 PAGES INCLUDING COVER SHEET

**Project Hanford Management Contract**

**QUALITY ASSURANCE PROGRAM PLAN**

*B&W Hanford Co.*  
*and*  
*Fluor Daniel NorthWest*

*Plutonium Stabilization and Handling*


**Project W-460**

HNF-SD-W460-QAPP-001  
Revision 0

B&W HANFORD Co.  
February 1998


**B&W Hanford Co.**  
**Plutonium Finishing Plant**  
**QUALITY ASSURANCE PROGRAM PLAN**  
**Plutonium Stabilization and Handling**  
**Project W-460**

**Approvals:**


  
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L. J. Olguin, Director  
Facility Transition Projects  
Fluor Daniel Hanford

4-22-98  
\_\_\_\_\_  
Date

Prepared by:

  
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E. V. Weiss, W460 Project Manager  
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B&W Hanford Co.

4-12-98  
\_\_\_\_\_  
Date

PER TELEPHONE  
  
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J. W. Schultz  
Quality Assurance Engineer  
Fluor Daniel Northwest

4-12-98  
\_\_\_\_\_  
Date

Balance of Approvals are Located on EDT 617726

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## Acronyms

A-E	Architect-Engineering
AI	Acceptance Inspection
ASME	American Society of Mechanical Engineers
BNFL	British Nuclear Fuels Limited, Incorporated
BR	Basic Requirement [... of ASME standard NQA-1]
BWHC	B&W Hanford Co.
CFR	Code of Federal Regulation
CM	Construction Management
DOE-RL	Department of Energy, Richland Operations Office
ENCO	Enterprise Company
FDC	Functional Design Criteria
FDH	Fluor Daniel Hanford
FDNW	Fluor Daniel NorthWest
GS	General Service
MSC	Major Subcontractor
NQA	Nuclear Quality Assurance
OC	Operating Contractor
PEP/PPM	Project Execution Plan/Project Procedures Manual
PHMC	Project Hanford Management Contractor
PHPP	Project Hanford Policies and Procedures
PFP	Plutonium Finishing Plant
PM	Project Management
PMP	Project Management Plan
PuSH	Plutonium Stabilization and Handling
PSE	Preliminary Safety Evaluation
PuSAP	Plutonium Stabilization and Packaging
QA	Quality Assurance
QAPD	Quality Assurance Program Description
QAPP	Quality Assurance Program Plan
SAR	Safety Analysis Report
SC	Safety Class
SPS	Stabilization and Packaging System
SRID	Standards/Requirements Identification Document
SS	Safety Significant
SSC	Structures, Systems, and Components
WBS	Work Breakdown Structure
WHC	Westinghouse Hanford Company

## 1 Introduction

1.1 Project W-460, Plutonium Stabilization and Handling, encompasses several related actions which will implement the provisions of Department of Energy (DOE) Standard DOE-STD-3013-96 (3013) for special nuclear material inventories of plutonium and plutonium/uranium oxides at Hanford's Plutonium Finishing Plant (PFP), and will comply with the commitments of Defense Nuclear Facilities Safety Board Recommendation 94-1 to stabilize and package remaining plutonium by May 2002 for safe secure storage for up to fifty years. The Project will consolidate stabilization, packaging and storage functions into a single location within the PFP facility, the 2736-Z Complex. This will allow eventual deactivation of other PFP facility areas no longer needed while maintaining all functions required for safe storage. In addition to facility modifications to be designed, constructed and installed at the 2736-Z Storage Complex, the Project provides funding for a Stabilization and Packaging System (SPS) to be procured as part of a national procurement contract administered via the DOE Oakland Operations Office (DOE Contract DE-AC03-96SF20948, more commonly the PuSAP contract).

## 2 Scope

- 2.1 This Quality Assurance Program Plan (QAPP) identifies Project Quality Assurance (QA) program requirements for Fluor Daniel NorthWest (FDNW), an Enterprise Company (ENCO), and B&W Hanford Co. (BWHC), a Major Subcontractor (MSC) under the Project Hanford Management Contractor (PHMC). This QAPP is prepared based upon the requirements identified in the PHMC Procedure, HNF-PRO-261, "Quality Assurance Program Plans" and shall be used as the consolidated QA Program document for BWHC and FDNW. These two contractors are involved in the planning and execution of Hanford Site activities for design, procurement, demolition, construction, installation, inspection and testing for Project W-460. These efforts are for the infrastructure that will be modified, fabricated, installed, and/or constructed in order to incorporate the new SPS in the 2736-Z Complex.
- 2.2 For new project related structures, systems, and components, other than the SPS equipment procurement, specific quality requirements will be incorporated into the definitive design media and procurement documents that will be prepared, approved and issued by FDNW and BWHC, as applicable, to subtier contractors and vendors. Procurement documents will incorporate those applicable quality requirements that are required to be passed down to design, fabricate, inspect, and/or test the procured structure, system, and/or component.
- 2.3 For the interfaces between the facility and the SPS, the quality requirements will be incorporated into the BWHC definitive design media to be used by onsite and/or subtier contractors.
- 2.4 For the SPS, the applicable quality requirements will be incorporated into the FDNW



prepared procurement documents that DOE will be issuing for the SPS design, fabrication, and installation. As determined by BWHC Project Management, evaluations by BWHC and/or FDNW will be performed to ensure quality requirements have been incorporated into the SPS documentation.

### 3 Organization Responsibilities and Authority

3.1 BWHC, the Operating Contractor (OC) is responsible for overview of all quality related documentation for Project design, procurement, fabrication, installation, and construction, with exception of the SPS contract, unless assigned this responsibility by the Project Manager. This overview will ensure conformance with the requirements of the Functional Design Criteria (FDC) based upon approved OC procedures.

3.2 Responsible organizations performing Definitive Design Engineering, Engineering and Inspection during Construction, Procurement, Construction, and Project Management shall be identified within the confines of the Work Breakdown Structure (WBS) located in the Project Management Plan (PMP) prepared by the Project Manager. Specific responsibilities and interfaces are further defined in the PMP. If responsibilities are changed during the course of the project, these changes shall be made per approved OC procedures.

3.2.1 Fluor Daniel Hanford (FDH) Acceptance Inspection (AI) provides independent construction inspection for DOE-RL to verify and document the effectiveness of the construction project's quality control program. The Acceptance Inspection Plan identifies the required inspection events and AI hold points for the project. Acceptance Inspection performs the independent construction inspection/testing and source inspection/testing of construction workmanship, materials, and equipment for the purpose of evaluating conformity or nonconformity to the approved drawings and specifications. An Acceptance Inspection Plan will be required for the W-460 construction project. It is generated by FDH Acceptance Inspection and submitted to the DOE-RL Project Office for approval and subsequent transmittal to the BWHC Project Integrator prior to initiation of construction.

3.3 The Construction Contractor(s) and Vendor(s) are responsible and held accountable for their assigned work regarding project and procurement quality. The Construction Contractor and/or Vendor shall perform, or have performed, assigned quality verification activities as specified in procurement documents and identified in drawings, specifications and other approved Project documents.

### 4 Quality Assurance Program Requirements

4.1 Quality Assurance Program requirements are derived or based upon HNF-MP-599, "Project Hanford Quality Assurance Program Description" (QAPD), which defines the implementation of 10 CFR 830.120 and DOE Order 5700.6C. As this project affects a

Nuclear Facility, the "Enforcement Applicability" of 10 CFR 830.120 is required and is addressed in the Forward of the QAPD. The ten basic sections of the QAPD form the foundation for the requirements for all quality assurance activities. Each of these QAPD sections are identified further in paragraph 4.7. Application of the quality assurance program is based on the graded approach as noted in paragraphs 4.3 and 4.4. The Project Hanford Policy and Procedures (PHPP) are the site wide policy and procedures which are utilized for BWHC activities. The QAPD, PHPPs, company level procedures, facility level documents, and this project QAPP provide specific controls for work performance. The QAPD Implementation Matrix (Attachment D) identifies applicable implementing Project Hanford/BWHC procedures for performing work on Project W-460. References to FDNW procedures are also included in the matrix. Note that only minimal QA related procedures are identified. The remaining FDNW procedures to be used are identified and/or included in the FDNW Project Execution Plan/Project Procedures Manual. The applicability of these procedures is a selective process dependent upon the work being performed and the safety significance of the activities.

#### 4.2 Quality Assurance Requirements Flowdown

Applicable QA requirements shall be passed down from BWHC to sub-tier contractors (FDNW and Construction Contractors) through statements of work, task orders, definitive design media, and/or procurement documents, as applicable. Further instruction as to the extent of QA requirements derived from the QAPD, and the implementation of these requirements, based upon a graded approach are noted in paragraphs 4.3, 4.4, and 4.6.

#### 4.3 Application of the Graded Approach

The quality management programs focus on the controls and systems necessary to ensure the output quality as required by 10 CFR 830.120 and DOE Order 5700.6C. Quality controls and systems will be applied to Project W-460 activities using a graded approach. The graded approach will be used to determine the scope and degree of rigor of the application of these requirements i.e., a process by which the level of analysis, level of documentation, level of verification and actions necessary to comply with requirements are defined. The graded application of the QA Program requirements will be achieved through an a varying combination of the following:

- (1) The nuclear safety application of the item or activity.
- (2) The level of risk and impact associated with a failure or deficiency.
- (3) The age, status, and condition of a facility, process, or an item.
- (4) The history of problems at a facility, with a process, or an item.
- (5) The adequacy of existing controlling documentation.
- (6) The complexity of products or activities involved.
- (7) The control of potential project delays and cost if failures or deficiencies occur.

#### 4.4 Exceptions to the QAPD

No specific exceptions are taken to the requirements established by the QAPD, however, the applicability of elements of the QAPD, based upon a graded approach, has been identified in Attachment C, "Quality Assurance Requirements Matrix". Each of the QAPD, Part 2, Quality Management Processes, Implementing Requirements paragraphs identified within the QAPD have been evaluated for applicability to Project W-460 in five main areas: Project Management (PM) by BWHC, Architect-Engineering (A-E) by FDNW, Construction Management (CM) by FDNW, Construction Contractor activities by FDNW and/or a Fixed Price Contractor, and the SPS Procurement by British Nuclear Fuel Limited (BNFL). In addition, applicable references to a national standard, American Society of Mechanical Engineers, Nuclear Quality Assurance (ASME NQA-1), have been identified in the matrix for assistance in invoking specific quality requirements. These evaluations are at a high level which will require further decision making based upon the applicable structure, system, or component's Safety Class, Safety Significant, or General Service designation. As such, the more explicit applicability to each QAPD paragraph will be made during the definitive design process.

#### 4.5 QAPD Implementation Matrix

The QAPD Implementation Matrix (Attachment D) provides a roadmap from HNF-MP-0599 (QAPD) requirements to selected Project Hanford Policy and Procedures, BWHC and FDNW procedures which may be utilized as part of the Project W-460 QAPP to perform applicable work activities. Application of PHPP, BWHC, and/or FDNW procedures will be based upon the type of work being performed and the safety significance of the work.

#### 4.6 Critical characteristics of products and safety classification

As part of the safety analysis process, a preliminary safety evaluation (PSE), "Preliminary Safety Evaluation for Project W-460, Plutonium Stabilization and Handling (PuSH)," HNF-SD-W460-PSE-001, has been prepared for Project W-460. The PSE identifies critical structures, systems, and components (SSCs) which are important to the safety functions (safety class or safety significant) of the project. From the PSE, critical characteristics of the SSC's are identified which will receive more rigorous quality controls and appropriate quality codes and standards selected and applied (i.e., application of graded approach). The critical characteristics will be incorporated into applicable design or operations documents, verified, inspected or tested as appropriate and results evaluated and documented.

#### 4.7 Elements of the Quality Assurance Program Description

##### 4.7.1 Program

---

Quality Assurance Programs (QAPs) shall be developed, implemented, and maintained where identified within contract documents such as: statements of work, task orders, procurement documents, and definitive design media.

Quality Assurance Program requirements for Project W-460 are to comply with applicable portions of QAPD Part 2, Section 1, "Program".

#### 4.7.2 Personnel Training and Qualifications

Personnel shall be adequately trained and qualified to perform their assigned tasks.

Training and qualification program requirements for Project W-460 are to comply with applicable portions of QAPD, Part 2, Section 2, "Personnel Training and Qualification".

#### 4.7.3 Quality Improvement

Management shall ensure quality improvement processes are instituted for the prevention and detection of quality problems.

Quality improvement processes established for Project W-460 are to comply with applicable portions of QAPD, Part 2, Section 3, "Quality Improvement".

#### 4.7.4 Documents and Records

Documentation and records control processes shall be employed for documents which control quality affecting activities.

Documents and records generated, processed, and maintained for Project W-460 are to comply with applicable portions of QAPD Part 2, Section 4, "Documents and Records".

#### 4.7.5 Work Processes

Work processes shall be established which are defined and controlled by written policies, plans, procedures, drawings, or other means to ensure the quality required for Project W-460.

Implementing procedures used on Project W-460 shall comply with applicable portions of QAPD Part 2, Section 5, "Work Processes".

#### 4.7.6 Design

Design activities shall be adequately controlled so that structures, systems, and

components meet the applicable requirements and performance criteria established for Project W-460.

Design processes instituted for Project W-460 shall comply with applicable portions of QAPD Part 2, Section 6, "Design".

#### 4.7.7 Procurement

Procurement processes shall adequately ensure structures, systems, components, or other items and services procured meet the appropriate technical and quality requirements established for Project W-460.

Procurement processes established for Project W-460 shall comply with applicable portions of QAPD Part 2, Section 7, "Procurement".

#### 4.7.8 Inspection and Acceptance Testing

Inspection and acceptance testing processes shall adequately ensure structures, systems, components, or other items procured, fabricated, or installed meet established design performance and quality requirements.

Processes for inspection and acceptance testing for Project W-460 shall comply with applicable portions of QAPD Part 2, Section 8, "Inspection and Acceptance Testing".

#### 4.7.9 Management Assessment

Management assessment processes shall be established to adequately address the achievement of strategic goals and the meeting of applicable standards related to Project W-460.

Management assessment processes for Project W-460 shall comply with the applicable portions of QAPD Part 2, Section 9. "Management Assessment".

#### 4.7.10 Independent Assessment

BWHC, FDNW and applicable sub-tier contractor personnel are responsible for cooperating with FDH independent assessment personnel in planning, preparation, and performance of assessments. BWHC and lower tier contractor management, as applicable, are responsible for promptly correcting problems found by independent assessments and ensuring corrective action is effective.

Independent assessment processes for Project W-460 shall comply with the applicable portions of QAPD Part 2, Section 10. "Independent Assessment".

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## 5 References

- DNFSB, 1994, "Recommendation 94-1 to the Secretary of Energy, pursuant to 42 USC §2286 a(5) Atomic Energy Act of 1954, as amended," Defense Nuclear Facilities Safety Board, Washington, D.C.
- DOE, 1996b, "Stabilization and Packaging System," Contract DE-AC03-96SF20948 as amended, U. S. Department of Energy - Oakland Operations Office, Oakland, California.
- DOE, 1996c, DOE-STD-3013-96, "Criteria for Safe Storage of Plutonium Metals and Oxides," U. S. Department of Energy, Washington, D.C.
- DOE Order 4700.1, "DOE Project Management System," U. S. Department of Energy, Washington, D.C.
- DOE Order 5700.6C, "Quality Assurance," U. S. Department of Energy, Washington, D.C.
- FDH, 1998, Project Hanford Management Contract, "Project Hanford Policy and Procedure System Reference Map," HNF-MD-034, Revision 0, Fluor Daniel Hanford, Inc., Richland, Washington.
- FDH, 1997, Project Hanford Management Contract, "Project Hanford Quality Assurance Program Description," HNF-MP-599, Revision 0, Fluor Daniel Hanford, Inc., Richland, Washington.
- FDH, 1997, Project Hanford Management Contract, "Quality Assurance Program Plans," HNF-PRO-261, Revision 0, Fluor Daniel Hanford, Inc., Richland, Washington.
- FDH, 1996, "Functional Design Criteria for Project W-460, Plutonium Stabilization and Handling (PuSH)," HNF-SD-W460-FDC-001, Revision 0, Fluor Daniel Hanford Company, Richland, Washington.
- FDH, 1997, "Preliminary Safety Evaluation for Project W-460, Plutonium Stabilization and Handling (PuSH)," HNF-SD-W460-PSE-001, Revision 0, Fluor Daniel Hanford Company, Richland, Washington.

FDNW, 1997, "Facility Stabilization Project Execution Plan and Project Procedures Manual," B&W Hanford Company, Facility Stabilization Project, Contract 651002, Revision 0, Fluor Daniel NorthWest, Richland, Washington.

United States Code of Federal Regulations 10 CFR 830.120, "Nuclear Safety Management Quality Assurance," Washington, D.C.

WHC, 1994, "Plutonium Finishing Plant Standards/Requirements Identification Document," WHC-SD-MP-SRID-003, Westinghouse Hanford Company, Richland, Washington.

WHC, 1995, "Plutonium Finishing Plant Final Safety Analysis Report," WHC-SD-CP-SAR-021, Westinghouse Hanford Company, Richland, Washington.

ATTACHMENTS



## ATTACHMENT A

PROJECT CRITICAL CHARACTERISTICS  
FOR PROJECT W-460, PuSH

ITEM ID	STRUCTURE, SYSTEM, OR COMPONENT **	PRELIM. SAFETY CLASSIFICATION	TYPE OF INSPECTION			COMMENTS
			F	G	D	
1	2736-ZB Building Structure	SC			X	
2	2736-Z Building Structure	SC			X	
3	2736-Z Building Storage Cubicles and Canister Holders	SC			X	
4	SPS Glovebox Structure and Floor Anchors	SC			X	Design, fabrication and installation criteria for the SPS shall be designated in Procurement Specification for DOE Contract.
5	SPS Exhaust System HEPA Filters, HEPA Filter Housing and Ductwork up to 2736-ZB Roof Penetration	SC			X	
6	2736-ZB Building Final HEPA Filters, HEPA Filter Housing, and Ductwork up to HEPA Filter Housing	SC			X	
7	2736-Z Building exhaust System HEPA Filters, HEPA Filter Housing, and Ductwork up to HEPA Filter Housing	SC			X	
8	Vault Ventilation Supply Backdraft Damper or Supply Filters	SC			X	
9	Construction Door on East Wall of 2736-ZB	SC			X	
10	Cutting Tools and Electrical Equipment Inside the SPS Material Preparation Area	SC	X			
11	Facility CAMs and Vault Air Sampling System	SS	X			
12	Furnace Cooling Jacket, IF Water Cooling is used	SS	X			
13	Moisture Detection in SPS Gloveboxes	SS	X			
14	Drier on SPS Supply Air	SS	X			
15	Criticality Alarms	SS	X			

ITEM ID	STRUCTURE, SYSTEM, OR COMPONENT **	PRELIM. SAFETY CLASSIFICATION	TYPE OF INSPECTION			COMMENTS
			F	G	D	
16	SPS Glovebox Ventilation Kicker Fan and Controls	SS	X			
17	SPS Glovebox Confinement Boundary (e.g., Windows, Gloveports, Sphincter Seals, Entry Isolation Doors and their Controls)	SS			X	
18	SPS Glovebox Pressure Indication and Alarms	SS	X			
19	SPS Dump Valves and Interlocks to Glovebox Pressure Transducers	SS	X			
20	Regulators and Pressure Relief Valves (PRVs) on Compressed Utility Gas Supplies to SPS	SS	X			
21	Separate Process Exhaust Stack	SS			X	
22	Stack Monitoring	SS	X			Government Furnished Equipment
23	Calorimeters/Equilibration Bath	TBD	X			Government Furnished Equipment

**LEGEND:**

D Detailed (Inspection) See Attachment B  
 F Functional (Inspection) See Attachment B  
 G General (Inspection) See Attachment B  
 GS General Service  
 SC Safety Class  
 SS Safety Significant  
 TBD To Be Determined

**NOTES:**

- 1) \*\* Information based upon the SSC identified in the Preliminary Safety Evaluation, HNF-SD-W460-PSE-001, Rev. 0.
- 2) Unless Specified Otherwise, Remaining Structures, Systems, and/or Components are considered as General Service (e.g., Robotics for Handling/Transport of 3013 Containers, Modular Office Trailer: Including Structural Components, Utilities, etc.)

## ATTACHMENT B

## TYPES OF INDEPENDENT VERIFICATION AND INSPECTION

Specific rules covering all phases of inspection cannot be prescribed due to the variety and types of contracts and subcontracts, and the degree of responsibility assigned to the operating contractor, architect-engineer, construction contractors, and individual vendors. In general, inspection activities are divided into three categories: Functional, General and Detailed.

1. Functional Inspection. Performed to determine overall compliance with contract drawings and specifications. Functional Inspection may vary from inspection of minor items to extensive testing of operating equipment (which must be provided for in the contract). It may also serve in making initial determination of the adequacy of the design effort. The field element and the operating contractor participate in functional inspections from the viewpoints of owner and user.
2. General Inspection. The fundamental and comprehensive inspection to ascertain that workmanship and kind and quality of materials conform to the contract specifications.
3. Detailed Inspection. Includes, but is not limited to, verification of details, such as checking location and size of reinforcing bars, maintaining records of concrete batching operations, verifying the use of proper welding rods, checking riveting and welding, and performing other inspection for quality assurance purposes. Detailed inspections are carried out from initial construction operations and extend through all construction stages.

ATTACHMENT C  
QUALITY ASSURANCE REQUIREMENTS MATRIX

HNF-MP-599 QAPD Part 2 Requirements by Paragraph Including Keywords		Related Standard NQA-1	PROJECT PARTICIPANTS				
			PM BWHC	A-E FDNW	CM FDNW	Construction Contractor	SPS Procurement BNFL
						FDNW/Fixed Price	
<b>SECTION 1</b>							
3.1 **	Structure, QA Program						
3.2	QA Procedures		✓				
3.3.1	QA Program Plans		✓				
3.3.2		Basic Requirement (BR) 2	✓	✓	✓	✓	
3.3.3			✓	✓	✓	✓	✓
3.3.4 **							
3.3.5				✓	✓	✓	✓
3.4.1 **	QA Requirements Flowdown						
3.4.2			✓	✓	✓	✓	✓
3.5	Quality Planning		✓				
3.6.1	Organization, Responsibilities, Interfaces	BR 1	✓	✓	✓	✓	✓
3.6.2		1S-1 2.1	✓	✓	✓	✓	✓
3.6.3		1S-1 3.2	✓				
3.7	Readiness Review		✓				

HNF-MP-599 QAPD Part 2 Requirements by Paragraph Including Keywords		Related Standard NQA-1	PROJECT PARTICIPANTS				
			PM BWHC	A-E FDNW	CM FDNW	Construction Contractor	SPS Procurement BNFL
						FDNW/Fixed Price	
3.8.1	Stop Work Authority		✓	✓	✓	✓	✓
3.8.2			✓		✓		
3.9.1	Graded Application	BR 2	✓	✓	✓	✓	✓
3.9.2 (all)			✓	✓	✓	✓	✓
3.9.3			✓	✓	✓	✓	✓
3.9.4			✓	✓	✓	✓	✓
3.9.5			✓				
3.9.6			✓				
<b>SECTION 2</b>							
3.1	Training and Qualification Program		✓				
3.2.1	Training and Indoctrination	BR 2	✓	✓	✓	✓	✓
3.2.2		BR 2	✓	✓	✓	✓	✓
3.2.3							
3.2.4		BR 2, 2S-4	✓	✓	✓	✓	✓
3.2.5							
3.2.6							
3.2.7							
3.2.8							
3.3.1	Qualification and Certification						

HNF-MP-599 QAPD Part 2 Requirements by Paragraph Including Keywords		Related Standard NQA-1	PROJECT PARTICIPANTS				
			PM BWHC	A-E FDNW	CM FDNW	Construction Contractor	SPS Procurement BNFL
						FDNW/Fixed Price	
3.3.2			✓	✓	✓	✓	✓
3.3.3		2S-1, 2S-2 2.3		✓		✓	✓
3.3.4		2S-1 2.1		✓		✓	✓
3.4	Training and Qualification Records		✓	✓	✓	✓	✓
<b>SECTION 3</b>							
3.1.1	Deficiency Identification	BR 16	✓	✓	✓	✓	✓
3.1.2							
3.2.1	Corrective Action Management	BR 16	✓	✓	✓	✓	
3.2.2		BR 16	✓	✓	✓	✓	
3.3.1	Nonconformance Control	BR 15, 15S-1 4.1, 1S-1 2.3	✓		✓	✓	✓
3.3.2					✓	✓	✓
3.3.3		15S-1 2(a)			✓	✓	✓
3.3.4		15S-1 3			✓	✓	✓
3.3.5		15S-1 4.3	✓	✓	✓	✓	✓
3.3.6		15S-1 4.4		✓	✓	✓	✓
3.3.7		15S-1 4.5			✓	✓	✓
3.3.8					✓	✓	✓
3.3.9				✓	✓	✓	

HNF-MP-599 QAPD Part 2 Requirements by Paragraph Including Keywords		Related Standard NQA-1	PROJECT PARTICIPANTS				
			PM BWHC	A-E FDNW	CM FDNW	Construction Contractor	SPS Procurement BNFL
						FDNW/Fixed Price	
3.4.1 **	Performance Data Analysis						
3.4.2 **							
3.4.3 **							
3.4.4		BR 16	✓				
3.4.5			✓				
3.4.6		BR 16	✓				
<b>SECTION 4</b>							
3.0	Documents and Records		✓				
3.1.1	Documents	6S-1 2	✓	✓	✓	✓	✓
3.1.2		BR 6	✓	✓	✓	✓	✓
3.1.3		BR 6	✓	✓	✓	✓	✓
3.1.4		6S-1 3	✓	✓	✓	✓	✓
3.1.5				✓			

HNF-MP-599 QAPD Part 2 Requirements by Paragraph Including Keywords		Related Standard NQA-1	PROJECT PARTICIPANTS				
			PM BWHC	A-E FDNW	CM FDNW	Construction Contractor	SPS Procurement BNFL
						FDNW/Fixed Price	
3.2.1	Records	BR 17	✓	✓	✓	✓	✓
3.2.2					✓	✓	✓
3.2.3		17S-1, 2.8, 2.9, 4, 5	✓	✓	✓	✓	✓
3.2.4			✓				
3.2.5				✓		✓	✓
<b>SECTION 5</b>							
3.1.1	Work Process Documents	BR 5	✓	✓	✓	✓	✓
3.1.2				✓	✓	✓	✓
3.1.3					✓	✓	✓
3.1.4				✓	✓	✓	✓
3.1.5				✓	✓	✓	✓
3.2	Special Processes	BR 9				✓	✓
3.3.1	Identification and Control of Items	BR 8, 8S-1 3.1			✓	✓	✓
3.3.2		BR 14			✓	✓	✓
3.3.3		8S-1 2.3			✓	✓	✓



HNF-MP-599 QAPD Part 2 Requirements by Paragraph Including Keywords		Related Standard NQA-1	PROJECT PARTICIPANTS				
			PM BWHC	A-E FDNW	CM FDNW	Construction Contractor	SPS Procurement BNFL
						FDNW/Fixed Price	
3.4.1	Handling, Shipping, and Storing	BR 13			✓	✓	✓
3.4.2		13S-1 2			✓	✓	✓
3.4.3		13S-1 4			✓	✓	✓
3.5	Process Monitoring or Data Collection Instruments	BR 12		✓		✓	✓
3.6	Control of Computer Software	11S-2	✓	✓	✓	✓	✓
<b>SECTION 6</b>							
3.1	Design Input		✓	✓			✓
3.1.1		BR 3, 3S-1 2	✓	✓			✓
3.1.2		BR 3	✓	✓			✓
3.1.3		3S-1 2	✓	✓			✓
3.2.1	Design Process			✓			✓
3.2.2				✓			✓
3.2.3		3S-1 6		✓			✓
3.2.4			✓				
3.2.5		3S-1 6	✓	✓	✓	✓	✓
3.2.6			✓	✓			✓
3.2.7		3S-1 3		✓			✓
3.2.8		(con't) Design Process	3S-1 3.1		✓		

HNF-MP-599 QAPD Part 2 Requirements by Paragraph Including Keywords		Related Standard NQA-1	PROJECT PARTICIPANTS				
			PM BWHC	A-E FDNW	CM FDNW	Construction Contractor	SPS Procurement BNFL
						FDNW/Fixed Price	
3.2.9		3S-1 3.1		✓			✓
3.2.10				✓			✓
3.2.11				✓			✓
3.3.1	Design Verification	3S-1 4.2		✓			✓
3.3.2		3S-1 4		✓			✓
3.3.3		BR 3, 3S-1 4		✓			✓
3.3.4		3S-1 4.1		✓			✓
3.4.1	Design Changes	BR 3, 3S-1 5	✓	✓	✓	✓	✓
3.4.2			✓	✓	✓	✓	✓
3.5	Design Documentation and Records	3S-1 7	✓	✓			✓
3.6	Computer Software	3S-1 3.1	✓	✓		✓	✓
<b>SECTION 7.</b>							
3.1	Procurement Planning	7S-1	✓	✓	✓	✓	✓
3.2.1	Content of Procurement Documents	4S-1 2	✓	✓	✓	✓	✓
3.2.2		4S-1 3	✓	✓	✓	✓	✓
3.2.3		7S-1 7, 4S-1 4	✓	✓	✓	✓	✓

HNF-MP-599 QAPD Part 2 Requirements by Paragraph Including Keywords		Related Standard NQA-1	PROJECT PARTICIPANTS				
			PM BWHC	A-E FDNW	CM FDNW	Construction Contractor	SPS Procurement BNFL
						FDNW/Fixed Price	
3.3.1	Supplier Evaluation and Selection	7S-1 3.1	✓	✓	✓	✓	✓
3.3.2			✓	✓	✓	✓	✓
3.3.3		7S-1 5	✓	✓	✓	✓	✓
3.4	Control of Supplier Nonconformance	7S-1 9	✓	✓	✓	✓	✓
3.5.1	Acceptance of Items and Services	7S-1 8.1	✓	✓	✓	✓	✓
3.5.2		7S-1 8.1	✓	✓	✓	✓	✓
3.6	Commercial Grade Items	7S-1 10	✓	✓	✓	✓	✓
3.6.1			✓	✓	✓	✓	✓
3.6.2			✓	✓	✓	✓	✓
3.6.3			✓	✓	✓	✓	✓
3.7	Control of Supplier-Generated Documents	7S-1 6	✓	✓	✓	✓	✓
<b>SECTION 8</b>							
3.1.1	Inspection and Acceptance Testing Planning	10S-1 2, 11S-1 3		✓	✓	✓	✓
3.1.2		10S-1 2, 11S-1 2		✓			✓
3.1.3		10S-1 2, 11S-1 2	✓	✓	✓	✓	✓
3.2.1	Inspection and Acceptance Testing Process	10S-1 3.2		✓		✓	✓
3.2.2		BR 10, 10S-1 2		✓		✓	✓

HNF-MP-599 QAPD Part 2 Requirements by Paragraph Including Keywords		Related Standard NQA-1	PROJECT PARTICIPANTS				
			PM BWHC	A-E FDNW	CM FDNW	Construction Contractor	SPS Procurement BNFL
						FDNW/Fixed Price	
3.3	Inspection and Acceptance Testing Records	BR 10, 10S-1 8, BR 11, 11S-1 4 & 5		✓		✓	✓
3.4	Inspection and Acceptance Testing Status	BR 14				✓	
3.5	Calibration of Measuring and Test Equipment	BR 12		✓		✓	✓
<b>SECTION 9</b>							
3.1 (all)	Management Assessments	BR 2	✓	✓	✓	✓	✓
3.2	Corrective Actions	BR 16	✓	✓	✓	✓	✓
<b>SECTION 10</b>							
3.1.1	Focus of Independent Assessments	BR 18	✓				
3.1.2			✓				
3.2.1	Performance of Independent Assessments	BR 1, 18S-1 3.2	✓				
3.2.2			✓				
3.2.3			BR 18	✓			

**Notes:**

- 1) Paragraph references which are missing from Matrix have been determined to not have applicable requirements, hence they have been eliminated.
- 2) Items identified with "\*\*\*" have been determined to apply at a higher level and will not apply at the Project level.
- 3) Related Standard (NQA-1) is to be used as a Guide for applying the specific QAPD paragraph reference.
- 4) The use of the Matrix is as a Guide towards applying Quality Requirements to Safety Class Items. The Graded Approach shall be used for these features, as determined by the particular structure, system, or component involved. Further evaluation by a Graded Approach is to be used when evaluating Quality Requirements to be applied to Safety Significant or General Service structures, systems, or components.

**ATTACHMENT D  
QAPD IMPLEMENTATION MATRIX**

NOTE: This implementation matrix is based on a cross-reference between the Controlled Manual (CM) System and the Project Hanford Policy and Procedure (PHPP) System (ref.: HNF-MD-034, *Project Hanford Policy and Procedure System Reference Map*). This cross-reference is referred to as the CM-Map. The procedures in this matrix may change; therefore, it may be necessary for the user of this document to check the accuracy of these references, as this listing is not all-inclusive. Several Quality Assurance specific Contractor Procedures (FDNW) have been identified; for more complete information, it may be necessary for the user of this document to review the BWHC Contract 651002, Facility Stabilization Project, *Project Execution Plan/Project Procedures Manual*.

<b>QAPD IMPLEMENTATION MATRIX</b>		
<b>PROJECT HANFORD QAPD PART 2</b>	<b>IMPLEMENTING PROCEDURES</b>	
	<b>Project Hanford Procedures</b>	<b>Contractor Procedures</b>
<b>SECTION 1, PROGRAM</b> Quality Assurance Program Plans Project Hanford QA Requirements Flowdown Quality Planning Organization, Responsibilities, and Interfaces Readiness Reviews Stop Work Authority Graded Application of Project Hanford QA Program	HNF-PRO-055, <i>Startup and Restart of Facilities</i> HNF-PRO-261, <i>Quality Assurance Program Plans</i> HNF-PRO-704, <i>Hazard and Accident Analysis Process</i>  FDH-MD-035, <i>Shutdown and Stop-Work Direction</i>	134.042.0110, <i>Risk Evaluation and Graded Corrective Action</i> 134.042.0125, <i>Stop Work Orders</i> 134.042.0135, <i>Quality Assurance Financial Planning</i> 134.042.0145, <i>Project Specific Quality Assurance Program Plan</i> 134.042.0140, <i>Projects/Quality Assurance Interface</i>  Note: See FDNW PEP/PPM for Other Procedures
<b>SECTION 2, PERSONNEL TRAINING AND QUALIFICATION</b> Project Hanford Training and Qualification Program Training and Indoctrination Qualification and Certification Training and Qualification Records	HNF-PRO-056, <i>Drill Program Policy</i> HNF-PRO-263, <i>Qualification and Certification of Inspection and Test Personnel</i>  HNF-PRO-329, <i>Radiological Training</i> HNF-PRO-347, <i>Employee Fire Protection Training</i> HNF-PRO-538, <i>Criticality Safety Training</i>	134.042.0032, <i>Training/Qualification of Audit and Surveillance Personnel</i> 134.042.0160, <i>Qualification of Quality Engineer Personnel</i>  Note: See FDNW PEP/PPM for Other Procedures

QAPD IMPLEMENTATION MATRIX			
PROJECT HANFORD QAPD PART 2	IMPLEMENTING PROCEDURES		
	Project Hanford Procedures		Contractor Procedures
SECTION 3, QUALITY IMPROVEMENT Deficiency Identification Corrective Action Management Nonconformance Control Performance Data Analysis Control of Suspect/Counterfeit Items	HNF-PRO-006,	<i>Identifying/Reporting a DOE Nuclear Safety Requirement Noncompliance</i>	134.042.0031, <i>Corrective Action Management</i>
	HNF-PRO-052,	<i>Corrective Action Management</i>	134.042.0110, <i>Risk Evaluation and Graded Corrective Action</i>
	HNF-PRO-058,	<i>Critique Procedure</i>	134.042.0115, <i>Lessons Learned</i>
	HNF-PRO-060,	<i>Reporting Occurrences and Processing Operations Information</i>	134.042.0120, <i>Corrective Action Requests</i>
	HNF-PRO-063,	<i>Deficiency Tracking System</i>	
	HNF-PRO-298,	<i>Nonconforming Item Reporting and Control</i>	<b>Note: See FDNW PEP/PPM for Other Procedures</b>
	HNF-PRO-301,	<i>Control of Suspect/Counterfeit Items</i>	
SECTION 4, DOCUMENTS AND RECORDS Documents Records	HNF-PRO-208,	<i>Records Management - General</i>	134.042.0185, <i>Inspection Document Reviews</i>
	HNF-PRO-210,	<i>Records Management Program</i>	134.042.0190, <i>Final Acceptance Review</i>
	HNF-PRO-214,	<i>Record Inventory and Disposition Schedules</i>	000.100.1212, <i>Project Close-out</i>
	HNF-PRO-222,	<i>Quality Assurance Records</i>	
	HNF-PRO-224,	<i>Document Control</i>	
	HNF-PRO-232,	<i>Project and Task Document Management</i>	<b>Note: See FDNW PEP/PPM for Other Procedures</b>
	HNF-PRO-233,	<i>Review and Approval of Documents</i>	
HNF-PRO-460,	<i>Software Document Control</i>		

<b>QAPD IMPLEMENTATION MATRIX</b>		
PROJECT HANFORD QAPD PART 2	IMPLEMENTING PROCEDURES	
	Project Hanford Procedures	Contractor Procedures
<b>SECTION 5, WORK PROCESSES</b> Work Process Documents Identification and Control of Items Handling, Shipping, and Storing	HNF-PRO-062, <i>Identifying and Resolving Unreviewed Safety Questions</i> HNF-PRO-072, <i>Plant Instrumentation and Equipment Status Labeling</i> HNF-PRO-129, <i>Controlling Spare Parts and Spare Equipment Inventory</i> HNF-PRO-134, <i>Identifying and Controlling Materials, Parts and Components</i> HNF-PRO-135, <i>Receiving, Inspection, Storage, Issuance and Return of Contractor Procured ASME Code Material</i> HNF-PRO-229, <i>Technical Procedure Standard</i> HNF-PRO-297, <i>Inspection, Test, and Operating Status</i> HNF-PRO-334, <i>Criticality Safety: General Requirements</i> HNF-PRO-351, <i>System Testing/Inspecting and Maintenance Frequencies</i> HNF-PRO-443, <i>Facility Deactivation Requirements</i> HNF-PRO-488, <i>Repair of ASME-Coded Pressure Systems</i> HNF-PRO-551, <i>Construction Program</i>	Note: See FDNW PEP/PPM for Other Procedures
<b>SECTION 6, DESIGN</b> Design Input Design Process Design Verification Design Changes Design Documentation and Records Computer Software	HNF-PRO-097, <i>Engineering Design and Evaluation</i> HNF-PRO-227, <i>Engineering Document Identification</i> HNF-PRO-239, <i>Design Analysis Reports</i> HNF-PRO-240, <i>Engineering TBDs/HOLDS</i> HNF-PRO-241, <i>Engineering Specification Requirements</i> HNF-PRO-242, <i>Engineering Drawing Requirements</i> HNF-PRO-243, <i>Interface Control Requirements</i> HNF-PRO-244, <i>Engineering Data Transmittal Requirements</i> HNF-PRO-265, <i>Developing and Maintaining SRIDs</i> HNF-PRO-317, <i>Engineering Release and Approval Requirements</i>	134.042.0150, <i>Quality Engineering-Design Review</i> 134.042.0155, <i>Developing Quality Assurance Criteria for Design Documents</i>  Note: See FDNW PEP/PPM for Other Procedures

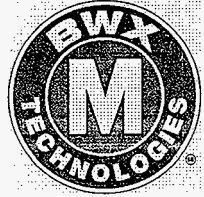
QAPD IMPLEMENTATION MATRIX		
PROJECT HANFORD QAPD PART 2	IMPLEMENTING PROCEDURES	
	Project Hanford Procedures	Contractor Procedures
(continued) SECTION 6, DESIGN Design Input Design Process Design Verification Design Changes Design Documentation and Records Computer Software	HNF-PRO-430, <i>Safety Analysis Program</i> HNF-PRO-431, <i>Verification and Validation</i> HNF-PRO-432, <i>Testing</i> HNF-PRO-437, <i>Software Application</i> HNF-PRO-439, <i>Supporting Document Requirements</i> HNF-PRO-440, <i>Engineering Document Change Control Requirements</i> HNF-PRO-441, <i>Engineering Procurement Waiver Requirements</i> HNF-PRO-442, <i>Development Control Requirements</i> HNF-PRO-445, <i>Design Verification Requirements</i> HNF-PRO-446, <i>Testing Requirements</i> HNF-PRO-447, <i>Procurement of Safety Class Items and Management of Spares</i> HNF-PRO-448, <i>Interim Design Authority/Design Agent Engineering Process Requirements</i> HNF-PRO-464, <i>Software Control</i> HNF-PRO-561, <i>Functional Design Criteria</i> HNF-PRO-569, <i>Baseline Change Control</i> HNF-PRO-700, <i>Safety Analysis and Technical Safety Requirements</i> HNF-PRO-701, <i>Safety Analysis Process - Existing Facility</i> HNF-PRO-702, <i>Safety Analysis Process - Facility Change or Modification</i> HNF-PRO-703, <i>Safety Analysis Process - New Project</i> HNF-PRO-704, <i>Hazard and Accident Analysis Process</i> HNF-PRO-705, <i>Safety Basis Planning, Documentation, Review and Approval</i>	



<b>QAPD IMPLEMENTATION MATRIX</b>			
PROJECT HANFORD QAPD PART 2	IMPLEMENTING PROCEDURES		
	Project Hanford Procedures		Contractor Procedures
<b>SECTION 7, PROCUREMENT</b> Procurement Planning Content of Procurement Documents Supplier Evaluation and Selection Control of Supplier Nonconformance Acceptance of Items and Services Commercial Grade Items Control of Supplier-Generated Documents Control of Suspect/Counterfeit Items	HNF-PRO-123, <i>The Written Requisition Process</i> HNF-PRO-183, <i>Preacquisition Planning Requirements</i> HNF-PRO-186, <i>Preparing a Statement of Work for Services</i> HNF-PRO-268, <i>Control of Purchased Items and Services</i> HNF-PRO-301, <i>Control of Suspect/Counterfeit Items</i> HNF-PRO-441, <i>Engineering Procurement Waiver Requirements</i> HNF-PRO-444, <i>Vendor Information Requirements</i> HNF-PRO-447, <i>Procurement of Safety Class Items and Management of Spares</i> HNF-PRO-706, <i>PHMC Acquisition System Requirements</i> HNF-PRO-707, <i>PHMC Acquisition Authority</i>	134.042.0165, <i>Supplier Evaluation (Project Hanford Work)</i> 134.042.0170, <i>Source Surveys</i> 134.042.0175, <i>Procurement Document Review</i> 134.042.0195, <i>Procurement Support Planning</i>	<b>Note: See FDNW PEP/PPM for Other Procedures</b>
<b>SECTION 8, INSPECTION AND ACCEPTANCE TESTING</b> Inspection and Acceptance Planning Inspection and Acceptance Process Inspection and Acceptance Testing Results Inspection and Testing Status Calibration of Measuring and Test Equipment	HNF-PRO-263, <i>Qualification and Certification of Inspection and Test Personnel</i> HNF-PRO-283, <i>Control of Inspections</i> HNF-PRO-286, <i>Test Control</i> HNF-PRO-446, <i>Testing Requirements</i> HNF-PRO-489, <i>Third Party Inspections</i> HNF-PRO-490, <i>Control of Measuring and Test Equipment and Non-Data Test Equipment</i>	134.042.0155, <i>Developing Quality Assurance Criteria for Design Documents</i>	<b>Note: See FDNW PEP/PPM for Other Procedures</b>
<b>SECTION 9, MANAGEMENT ASSESSMENT</b> Management Assessments Corrective Action	HNF-PRO-052, <i>Corrective Action Management</i> HNF-PRO-246, <i>Management Assessment</i>	134.042.0130, <i>Management/Self-Assessments</i>	<b>Note: See FDNW PEP/PPM for Other Procedures</b>

# B&W Hanford Co.

a McDermott company



To

Mr. L. J. Olguin, Project Director  
Facility Stabilization, FDH

N1-26

From

F. R. Crawford, Senior Director *F.R. Crawford*  
Plutonium Finishing Plant Project T5-50

File No.  
Or Ref:

BWHC-9853379AR3

Subj

SUBMITTAL OF HNF-SD-W460-QAPP-001, PLUTONIUM  
STABILIZATION and HANDLING QUALITY ASSURANCE  
PROGRAM PLAN

Date:

April 22, 1998

This letter forwards B & W Hanford Company's "PLUTONIUM STABILIZATION and HANDLING QUALITY ASSURANCE PROGRAM PLAN", HNF-SD-W460-QAPP-001, Rev.0.

This Quality Assurance Program Plan (QAPP) identifies project quality assurance requirements for all contractors involved in the planning and execution of Hanford Site activities for design, procurement, construction, testing and inspection for Project W-460, Plutonium Stabilization and Handling.

If you have any questions, please contact the W-460 project manager, Ms. E. V. Weiss, on 372-1109.

Attachment

evw:dg

# CORRESPONDENCE DISTRIBUTION COVERSHEET

Author: E. V. Weiss, BWHC                      Addressee: L. J. Olguin, FDH                      Correspondence No.: BWHC-9853379AR3

Subject: SUBMITTAL OF HNF-SD-W460-QAPP-001, PLUTONIUM STABILIZATION and HANDLING QUALITY ASSURANCE PROGRAM PLAN

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