

KRŠKO NUCLEAR POWER PLANT
MECHANICAL MAINTENANCE DEPARTMENT

Organization unit TO.VZST

TECHNICAL SPECIFICATION
FOR INSPECTION OF REACTOR VESSEL FLANGE AND
REACTOR VESSEL HEAD FLANGE GROOVES SEALING
SURFACES DURING 2027 OUTAGE

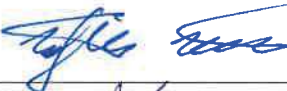
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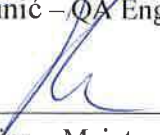
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CONTENTS

1. ACTIVITY	3
2. SCOPE	3
3. SAFETY CLASSICATION	6
4. TYPE OF SERVICE	7
5. CODES, STANDARDS AND PROCEDURES	7
6. IDENTIFICATION OF EQUIPMENT AND COMPONENTS	8
7. TECHNICAL REQUIREMENTS	9
8. LABOR QUALIFICATION REQUIREMENTS	10
9. DETAILED SCHEDULE	11
10. SUPPLIER'S LIABILITIES	11
11. NEK'S LIABILITIES	13
12. SPECIAL REQUIREMENTS	13
13. QA REQUIREMENTS	14
14. APPENDICES	14

1. ACTIVITY

The Specification gives a scope of maintenance services to be performed by a Contractor during our regular refueling and maintenance outage scheduled to start on April 1st, 2027. The Suppliers scope consists of Inspection of the NEK Reactor Vessel (RV) Flange Sealing Surfaces and Reactor Vessel Head (RVCH) Flange Grooves Sealing Surfaces by laser scanning, RV O ring visual inspection, etc. Sealing surfaces treatment recommendation shall be provided based on inspection and analysis performed. There are currently no presence of the RV sealing surface leak in NEK.

Abbreviations:

NEK	Nuclear Power Plant Krško,
RV	Reactor Vessel,
RVCH	Reactor Vessel Closure Head,
RB	Reactor Building,
FME	Foreign Material Exclusion (preventing foreign material to enter into systems and components),
ALARA	As Low As Reasonable Achievable,
ANSI	American National Standards Institute,
ASME	American Society of Mechanical Engineers
QA	Quality Assurance
QC	Quality Control
QPR	Qualification Personal Record
FAT	Factory acceptance test
SAT	Site acceptance test

2. SCOPE

2.1 Pre-outage Activities

Pre-outage activities of supplier consists of all needed activities for successful service performance. The Supplier shall provide qualified personnel, procedures, tools and material for performance of the whole scope of works. The pre-outage activities shall include but not be necessarily limited to the following:

1. Pre-Service documentation package (defined in item 2.4)
2. Personnel qualification,
3. Tools preparation and qualification,
4. Tools and material transportation to site,
5. General employee training.

2.2 Outage scope

The scope of NEK 2027 outage services on the Reactor Vessel includes the following:

- a. Inspection of the RV Flange Sealing Surfaces by visual testing and laser scanning,

- b. Inspection of the RVCH Flange Grooves Sealing Surfaces by visual testing and laser scanning,
- c. Visual inspection of used RVCH O-rings during their removal.

Clear description of those methods, benefits and tools, machines with technical characteristics shall be specified in the quotation.

2.3 Information required with the Proposal

Information to be submitted with the Proposal shall include, but is not necessarily limited to the following:

- a. Title of service, proposal designation and Table of content;
- b. Description of Scope (inspection methods, tools, service prerequisites etc.);
- c. List of Supplier and personnel references for the same or similar, successfully performed services. List of machines references;
- d. Supplier Evidence of capabilities (facilities, equipment, trained and qualified personnel etc.) ;
- e. QA Program Manual. QA Program shall satisfy NCA-4000 and 10CFR50 Appendix B requirements. QA Program review and acceptance by the NEK shall be a prerequisite for selection of a Supplier as a Contractor;
- f. List of applicable documents (Codes, Standards (with specified Edition), Specifications (with specified Edition), Drawings, Procedures of inspection);
- g. Sealing surface Acceptance criteria;
- h. Organizational chart;
- i. Service schedule – detailed;
- j. Alara plan;
- k. Description of FME assurance;
- l. Prices;
- m. A list of chemicals which are planned to be used by the Supplier and quantities;
- n. List of Tools, equipment, measurement tools and gauges with tool dimensions and weights;
- o. Written Acceptance or all deviations or exceptions to these Specification requirements.

2.4 Pre-Service documentation package

Complete Pre-Service documentation package shall be prepared by Supplier and submitted to NEK for review and approval, not later than 60 days prior to the starting of outage.

NEK will review the package and provide comments to the Supplier. Supplier shall provide the Pre-Service documentation package corrections, if needed on NEK review, 30 days prior to the outage start. It shall be provided in hard copy and in electronic version.

Pre-Service documentation package shall include, but is not necessarily limited to the following:

Technical specification for inspection of reactor vessel flange and reactor vessel head flange grooves sealing surfaces during 2027 outage

- a. Title of service, Designation, Revision, Contents and Introduction;
- b. List of applicable documents (Codes, Standards, Specifications, Drawings, Service, handling, packaging, transportation procedures, Inspection and QA/QC Procedures);
- c. General description of planned work;
- d. Service schedule - detailed;
- e. Integrated work sequence and quality control plan with reference documents and its steps, acceptance criteria, defined supplier control points and place for NEK H(old), W(itnes), R(ecord) points;
- f. Service applicable working procedures, qualification records, NDE Procedures and NDE personnel qualification records, and other documentation;
- g. Alara plan;
- h. Supplier Organization chart with responsibilities and NEK interfaces;
- i. Personal Qualification Records, HP Record and Medical Exam Certificate, etc.;
- j. List of Tools, equipment, measurement tools and gauges with calibration Exam Certificates and other certificates where applicable;
- k. List of used materials with their Material Safety Data Sheets.

2.5 Preliminary Report

Preliminary Report shall be submitted by the Contractor during the exit meeting at the latest at NEK site in hard copy and in electronic version on the portable disc or USB flash drive.

The Preliminary Documentation Package shall include, but is not necessarily limited to the following:

- a. Document Title, Designation, Revision, Contents and Introduction;
- b. List of applied documents;
- c. General description of performed work;
- d. Conclusions and recommendation;
- e. Completed Work Sequence and Quality Control Plan with references to applicable procedures, acceptance criteria, Inspection & test Records/Reports;
- f. Inspection and test Records /Reports;
- g. List of Non-conformance reports (NCR) and reports as well as methods of their resolving and NCR issued with corrective action verification;
- h. Organization chart, List of Personnel involved in service with qualification Records;
- i. List of Tools, equipment, measurement and gauges used during performance of activities, with calibration Certificates.
- j. Laser scans, films and photos.

2.6 Final Report

Final Report shall be prepared, reviewed and approved by Contractors responsible engineer and QA personnel and submitted to NEK in two hard copies and in electronic version on the portable disc or USB flash drive thirty (30) days upon submittal of Preliminary Report.

The Final Documentation Package shall include, but is not necessarily limited to the following:

- a. Document Title, Designation, Revision, Contents and Introduction;
- b. Certificate of conformance that the service has been performed in accordance with the purchase order, this specification, referenced codes and standards and license documents, guarantee statement;
- c. Description of Work performed (with reference documents). It is comprised of a description of component and subcomponents status, status of actions which were performed and results;
- d. Analyses and evaluation reports;
- e. Conclusions and recommendation;
- f. Completed Work Sequence and Quality Control Plan with references to applicable procedures, acceptance criteria, Inspection & test Records/Reports;
- g. Inspection and test Records/Reports;
- h. List of applied documents (Inspection and QA/QC Procedures, Codes, Standards, Specifications, Drawings, handling and transportation procedures);
- i. Service applied procedures and documentation;
- j. Organization chart, List of Personnel involved in service with qualification Records;
- k. List of Tools, equipment, measurement and gauges used during performance of activities, with calibration Certificates;
- l. List of Non-conformance (NCR) reports as well as methods of their resolving and NCR issued with corrective action verification;
- m. Laser scans, films and photos.

3. SAFETY CLASSIFICATION

3.1. SR - "Safety Related"

The Reactor Vessel is classified as "Safety Related" in accordance with ASME and ANSI standards. The services are classified as Safety Related. For the work on such components the Contractor shall be familiar with original technical regulations for design. The services shall be rendered according to contractors QA Program and the procedures approved by NEK.

4. TYPE OF SERVICE

Type of service is the defined/fixed scope of supply for fixed price.

All activities shall be performed in accordance with the Contractor technological documentation, procedures and specifications which shall be approved by NEK 30 days prior to the outage beginning. The Contractor shall be defined on the list of NEK approved suppliers and shall meet requirements defined in item 13 of this technical specification.

5. CODES, STANDARDS AND PROCEDURES

The Contractor shall perform the services in accordance with:

- a. ASME B&PV Code - edition specified in item 6,
- b. ASME B&PV Code section XI, Edition 2017,
- c. ASME B&PV Code section IX,
- d. 10CFR50 App. B Quality Assurance Criteria for Nuclear Power Plants and Fuel Reprocessing Plants,
- e. SNT-TC-1 A 1988 Recommended Practice for Non-destructive Testing,,
- f. ANSI/ASNT CP-189 Standard for Qualification and Certification of Non destructive Testing Personnel, edition 2006 or new,
- g. C.E. Book No.19273 Instruction Manual Reactor Vessel (revised), Krsko Nuclear Power Plant,
- h. 19273-121-002 Upper vessel machining (dwg),
- i. 19273-126-002 Vessel flange machining and cladding (dwg),
- j. 10 CFR Part 21, Reporting of Defects and Noncompliance,
- k. ASME NQA-1-2008, Add. 2009/2011 Quality Assurance Requirements for Nuclear Facility Applications.
- l. ISO 17025 Testing and calibration laboratories
- m. ISO 10304-1 Water quality — Determination of dissolved fluoride, chloride, nitrite, orthophosphate, bromide, nitrate and sulfate ions, using liquid chromatography of ions - Part 1: Method for water with low contamination;
- n. ISO 17294-2 Water quality — Application of inductively coupled plasma mass spectrometry (ICP-MS)
- o. ADP-1.1.101 Preprečitev vnosa tujkov (FME),
- p. ADP-1.1.128 Upoštevanje in dokumentiranje preventivnih ukrepov preprečitve vnosa tujkov (PVT) ob odprtih sistemih ali komponentah,
- q. ADP-1.1.033 Varnost in zdravje pri delu v Nuklearni elektrarni Krško,
- r. ADP-1.1.051 Vstop, izstop in gibanje v tehnološkem delu NEK,
- s. ADP-1.1.105 Priročna skladišča in kontrolirano odložena oprema v tehnološkem delu NEK,
- t. ADP-1.7.004 ALARA planiranje dela (ALARA planing of works),

Technical specification for inspection of reactor vessel flange and reactor vessel head flange grooves sealing surfaces during 2027 outage

u.	ADP-1.7.007	Vnos opreme, rezervnih delov orodja in drugih materialov v radiološko kontrolirano območje,
v.	ADP-1.6.703	Ravnanje z nevarnimi odpadki,
w.	ADP-1.6.701	Kontrola in vstop nevarnih kemikalij v NEK,
x.	ADP-1.8.005	Vstop delavcev zunanjih izvajalcev v NEK,

The Contractor shall perform services in accordance with his own procedures for work and control of the performance of services harmonized with QA Program of his own. He shall also possess other procedures if required by technological process offered in Bidder's proposal.

6. IDENTIFICATION OF EQUIPMENT AND COMPONENTS

Reactor Pressure Vessel:

System:	RC
Funct. Desc:	REACTOR VESSEL
Equipment No.:	RCPCR01
Building:	RB
Bldg Elev:	107.62
Equip Elev:	107.62
Room:	02B
ASME:	1
ANSI:	1
SR:	Y
Maintenance rule:	Y
RV Manufacturer.:	COMBUSTION ENG. INC.
RV Manuf. Part No.:	E-19273-171-004
Manufacturing code:	ASME Boiler & Pressure Vessel Code, Section III Rules for Construction of Nuclear Vessels, 1971 Edition including Winter 1972 Addenda,

Reactor Pressure Vessel Head:

RVCH Manufacturer:	ENSA
RVCH Manuf. Part No.:	1EA1
Manufacturing code:	ASME Boiler & Pressure Vessel Code, Section III Rules for Construction of Nuclear Vessels, 1998 through Addenda 2000,
Instruction Manual:	C.E. Book No.19273,
Drawing:	19273-171-004 1188E09

Reactor Pressure Vessel O-ring:

Manufacturer;	Galock Helicoflex
Diameter:	0,525''
Drawing:	U-210381

Technical specification for inspection of reactor vessel flange and reactor vessel head flange grooves sealing surfaces during 2027 outage

7. TECHNICAL REQUIREMENTS

The services shall be performed according to related procedures and instructions for work. Special attention shall be paid to the following:

- a. Assurance of all preconditions for the performance of services,
- b. Tolerances, setups and measured values shall not exceed the prescribed values,
- c. The tools & equipment, procedures and labor provided by the supplier shall be qualified for performance of complete scope of supply at NEK site components,
- d. The supplier shall have valid accreditation for the service inspection and testing methods in accordance with ISO 17025.
- e. The upper internals (UI) is placed on the UI stand in the refueling cavity and lower internals is placed in the RV during the RV flange inspection. RCS water level is below RV sealing flange. The RVCH is placed on the RVCH stand during service performance. Width of the inspection machine shall be less than width of RV flange sealing surface to enable its travel during inspection.
- f. The sealing flange laser scanning inspections have to be performed by a Visual Testing and other specialists who are qualified for scope performance, for result evaluation and to provide NEK recommendation for further treatment of the inspected sealing surfaces in the written report.

All indications or defects such as pits, scratches, flaws, corrosion etc. of the sealing surfaces have to be measured, indicated, evaluated, documented in report which shall be delivered to NEK. For all indications the report has to contain at least following information: number of each indication, inner/outer O-ring sealing surface, location (number of bolt, distance from bolt etc.), indication shape, indication surface dimensions, indication depth, indication orientation (parallel direction with sealing surface, perpendicular to sealing surface), indication affect to the seal trace (in %), type of indication degradation mechanism etc. Indication further treatment or repair process and information about indication treatment urgency shall be specified in report too. The report of the inspected zones has to be supported by photographs, films and laser scans with clear indication of the contact sealing surface.

As found state of the used O-rings, RV and RVCH sealing surfaces has to be compared with as found state of 2024 year inspections and with defined acceptance criteria. The conclusion of the report has to give NEK clear current state of the defined sealing surfaces and it has to provide guidance for further use, monitoring and treatment of the sealing surfaces. Preliminary results of inspection performed by laser scanning shall be provided to NEK not later than 12 hours after laser scanning inspection on the RV flange sealing surface with machine is finished,

- g. Measurement accuracy shall be 10µm,
- h. The Supplier's equipment and process shall ensure precise recognition of flange contact sealing surfaces which shall be clearly shown and marked on photos of the report for whole contact sealing surfaces. All indications including with their location, shape and dimensions shall be shown on report photos too,
- i. The tools and equipment provided by supplier shall ensure successful performance of all scope of services on the NEK Reactor Vessel (RV) and Reactor Vessel Head (RVCH) sealing flanges. The dimensions of NEK equipment are as follows:
 1. outside diameter of RVCH flange 3994,2 mm (157,25'')
 2. outside diameter of RVCH inner O-ring groove 3336.11 mm (131,343'')

3.	outside diameter of RVCH outer O-ring groove	3418.66 mm (134,593'')
4.	width of RVCH O-ring grooves	15.82 mm (0,623'')
5.	depth of RVCH O-ring grooves	12.01 mm (0,473'')
6.	RVCH flange thickness	589,8 mm (23,22'')
7.	RVCH flange + sealing surface thickness	618,5 mm (24,35'')
8.	RVCH flange stud hole centerline diameter	3689.4 mm (145,25'')
9.	RVCH flange stud hole diameter	162,1 mm (6.38'')
10.	RV flange sealing surface outside diameter	3498,9 mm (137,75'')
11.	RV flange sealing surface inside diameter	3259,1 mm (128,31'')
12.	Diameter of silver coated O-rings	13,33 or 12,7 mm (0.525'' or 0,5'')

Tolerances of dimensions above and other dimensions are available to contractor at NEK site,

- j. RV flange base material: SA 508, Class 2,
- k. RV flange sealing surface stainless steel clad material: P-8 (E309+E308),
- l. Leakage Tube Monitor locations clad material: P-43 (ENiCrFe-3).

8. LABOR QUALIFICATION REQUIREMENTS

NDE personnel shall be qualified and certified in accordance with ANSI/ASNT CP-189 Edition 2006 or later.

The supplier shall provide qualified labor and equipment for performance of complete scope of services on NEK's type RV and RVCH sealing flanges. Appropriate knowledge and qualification shall be proved with certificates of attending relevant trainings and with references of works performed on the said equipment.

The Supplier shall have at least three references in last six years of successfully performed services as defined in this technical specification on NEK type RV and RVCH sealing flanges.

The Supplier site Team leader, Specialists and Non Destructive Examination (NDE) personnel shall have at least three references in last six years of successfully performed services as defined in this specification. References including personnel reference list shall be included in proposal.

Prior to the start of services the Supplier labor shall pass NEK trainings for job performance at NEK site. They shall get familiar with the house rules concerning NEK's basic regulations on the movement on site, treatment of equipment, the requirements of safety at work, as well as with the requirements of radiological and fire protection, etc.

The Supplier shall perform services in accordance with relevant procedures, prescriptions and regulations as stated in item 5. He shall be familiar with NEK's method of work and shall follow NEK's procedures,

The Supplier shall ensure qualified work leaders that will be present on the field during activities performance.

The Supplier personnel shall be qualified for work in Foreign Material Exclusion (FME) area.

The Security vetting of supplier labor shall be successfully performed.

The Supplier shall submit to NEK all necessary documents for the Contractor personnel which enables them to work in NEK radiation controlled area at least 30 days prior to start of outage 2027.

9. DETAILED SCHEDULE

The beginning of 2027 year outage is scheduled for April 1st. Services shall be performed according to NEK 2027 year Outage Time Schedule. The Reactor Vessel (RV) flange inspection is going to be performed on the critical path of NEK outage, that means at any time of outage day. It is preliminary scheduled for 24th of April, 2027 (night shift). The Upper Internals will not be placed in the RV during RV flange inspection. It is going to be placed on its storage stand in the reactor cavity.

The Reactor Vessel Head (RVCH) flange groove sealing surfaces inspection is preliminary scheduled from 24th to 26th of April and is not critical path activity. It is going to be performed during morning outage working shift or other suitable part of the outage day.

The Bidder has to submit his detailed schedule of all activities with their prerequisites in the Bid. The Schedule has to be harmonized with NEK integral 2027 outage schedule. The detailed harmonized time schedule will be submitted to the Bidder at a later date, when clearly determined.

As mentioned, special attention shall be paid to exact order of the performance of the service. Coordination of the services performance shall be made between Contractor site team leader and NEK's coordinator responsible for the said scope of services.

For employee to be mobilized during NEK 2027 Outage the Contractor shall submit the documentation to NEK one month before the start of the outage.

10. SUPPLIER'S LIABILITIES

The Supplier shall fully meet the said scope of services but shall first of all:

- a. Follow NEK's rules and procedures including documents specified in item 5,
- b. The Supplier and his personnel shall be qualified for work in Radiological controlled area. They shall be fit for duty and to perform the services in accordance with NEK's Radiological Protection Requirements,
- c. During the work the supplier personnel shall do their best to produce as little radioactive waste as possible,
- d. The Supplier shall have his own procedures for the performance of the whole scope of services,
- e. Provide all tools and goods needed for successful completion of the service. Their preparation, installation, manipulation and removal shall be performed by supplier. Tools, materials, goods and hazardous materials used during service performance shall be specified in the bid. Their quantities shall be specified too,
- f. Provide transportation of all needed tools and materials to NEK site and back to supplier's facility,

Technical specification for inspection of reactor vessel flange and reactor vessel head flange grooves sealing surfaces during 2027 outage

- g. All hazardous material provided by Supplier shall be on list of NEK approved materials. Approval for use of hazardous material at NEK site per ADP 1.6.701 shall be acquired by Supplier 30 days prior to outage 2027 start,
- h. All preconditions (as water level in RX cavity, condition of inspected surface prior to inspection, electric power, compressed air, crane etc.) to be met for successful performance of the subject services shall be specified in quotation and in Pre-service documentation package,
- i. The Supplier Time Schedule is to be part of the quotation. Duration of each separate activity with its prerequisites shall be defined. The Supplier Time Schedule will be suited to NEK integral outage activities schedule. NEK outage schedule is not fully fixed. The Supplier has to adapt his activity to current NEK 2027 outage schedule during service performance,
- j. The Supplier shall ensure all measures needed to prevent Foreign material entry to the systems (FME) during service performance. RV flange inspection will be performed in FME zone 1. FME shall be fully ensured. FME inspection points shall be specified in quality plan. Works in FME zones shall be notified with written documents. The Supplier shall perform FME verification of tools and personnel which will work in FME zone prior to entrance to the FME zone and during exit from FME zone,
- k. Supplier's work leader is responsible for the quality of all performed jobs, health and safety at work, FME, organization of work, etc. Work performance shall be in accordance with NEK internal rules. Responsible work leader shall be present at work area for the whole time during work performance,
- l. All Supplier tools needed for work at NEK site and supplied by contractor shall be faultless and inspected by qualified tool verifier. Certificate of supplier tool qualified verifier inspection shall be provided to NEK during tool entrance to NEK,
- m. Instruction for handling and rigging of tools, tool boxes /containers with lifting plans shall be part of the Pre-service documentation package. It shall contain list of tool / box content, their weight and location of center of gravity, dimension etc. All boxes/containers or heavier tools shall be equipped with transportation eye bolts, lugs and hand handles to ensure safe work performance.
- n. The Service activities or use of tools or materials shall not cause any negative impact or damage to the RV sealing flange or other NEK equipment,
- o. The Supplier shall provide personal protective equipment for work in non-radiological controlled area including safety goggles,
- p. The Supplier shall ensure all measures to prevent fire hazard,
- q. The Supplier shall ensure safety at work, respect safety at work requirements and use required protective equipment,
- r. The Supplier shall ensure tidiness and cleanliness of work places,
- s. English or Slovene shall be used as official communication language. Bid and documentation shall be provided in English language,
- t. Supplied documents, drawings etc. shall be legible.
- u. The Supplier's team at NEK site shall have support of their company engineering department during the service performance,
- v. The Supplier shall submit all IT equipment (computers, tablets, data storage devices, etc.) that will be used at NEK technological area to NEK process information system department for malware check,

- w. If NEK tools are going to be used, the Supplier shall use it in a proper way, get appropriate qualification for related work and successful performance of services.

11. NEK'S LIABILITIES

NEK shall provide following:

- a. Issue all work orders,
- b. Submit to the Contractor NEK 2027 Outage Time Schedule,
- c. Harmonize the performance of particular activities with NEK 2027 Time Schedule and communicate with the control room,
- d. Carry out radiation survey,
- e. Perform RV flange cleaning by machines currently available at NEK site if applicable,
- f. Perform RVCH O-ring removal,
- g. Provide personal protective equipment for work in radiological controlled area available at NEK site. Equipment which is not available at NEK site is Suppliers scope.

12. SPECIAL REQUIREMENTS

Requirements for materials

If any special materials will be used, following shall be respected:

Lead, mercury, and other low melting point materials, their alloys and/or their compounds, sulphur, lead, low melting point metals, their alloys, and their compounds are prohibited from use.

Certified Product Report shall be obtained by the Contractor for each lot of consumable material and shall include as a minimum:

- a. Manufacturer's name and designated product,
- b. Actual results of the required tests reported in ppm (halogens, water leachable chlorides, sulphur, etc.),
- c. Identification of low melting point constituents.

For expendable materials, the following limits shall apply. Engineering approval is required for use of an expendable material whenever the chemical analyses exceed these limits.

- | | | |
|----|---------------------------|----------|
| a. | Water leachable chlorides | 100 ppm |
| b. | Halogenated compounds | 1000 ppm |
| c. | Sulphur and its compounds | 1000 ppm |

13. QA REQUIREMENTS

All services shall be performed in accordance with a Quality Assurance Program that complies with NCA-4000, 10CFR50 App.B, 10CFR Part 21 and satisfies the requirements of the NEK specification QS 610 rev.2 (App. 1). QA Program review and acceptance by the Purchaser shall be a prerequisite for selection of a Supplier as a Contractor. All proposed changes to the program shall be submitted to and approved by the Purchaser prior to implementation.

The Supplier shall pass the requirements of this specification to its subcontractor(s) and shall retain full responsibility for their performance in accordance with the requirements of this specification.

If Supplier already submitted to NEK current revision of the QA Manual, written statement about present status (title and revision number) and applicability of QA Program & Software shall also be handover in the proposal.

14. APPENDICES

Appendix 1: QS 610 Generic Quality Assurance Program Requirements rev.2,