

**Status** 2 - Disposition Needed 9 - Closed **Trend** 01-Deviation From Doc/Proc  
**Department** NCSX **Division** NCSX Project  
**Source/Org** FABRICATION, OPERATIONS & MAINTENANCE  
**Item Dwg/Part#** D-NCSX-MCF-001 Rev. 02 **Procurement #** D-NCSX-MCF-001 **Cost Center** 9450-1\*\*\*-1451  
**RAP#** 3207 **Job Doc #** D-NCSX-MCF-001 **Vendor** \_\_\_\_\_  
**RAP Title** Modular Coil Fabrication - Winding Form Preparation Activities

HoldTag Applied

**Nonconforming Condition (include requirement(s) violated):**

The lead block mounts for the A1 modular coil are beyond the maximum magnetic permeability of 1.02 Mu as stated in NCSX-ASPEC-GRD-04 paragraph 3.3.1.1. These parts were manufactured by PPPL and made from 316 stainless steel. The remaining A type lead block mounts have yet to be made and will most likely have a similar amount of magnetic permeability. At the time of this report six pieces have been made.  
 Inside diameter (machined threads) = greater than 1.3 Mu and less than 1.7 Mu  
 NCR #3628 was written on the C type lead block mounts and accepted as is with a magnetic permeability of greater than 1.02 Mu and less than 1.8 Mu on 1/16/06.

Rev 1: Further inspection reveals that the lead block mounts for the A2 & A3 coils are above the maximum magnetic permeability of 1.02 Mu. A2 = >1.2 Mu <1.8 Mu, A3 = >1.3 Mu <1.7 Mu. With three of the six coils having this condition it will most likely affect the A4 thru A6 coils as well. When dispositioning this NCR please consider this issue for all of the A coils.

Rev 2: A4 lead block mounts range from >1.3 to <1.5 Mu and are installed, A5 and A6 lead block mounts range from >1.4 to <1.5 Mu and are not installed.

**Lot Size Recd** 6 **Sample Size Insp** 4  Lot Rejected **# Rejected** 6  
**Reported By** Phelps C **Validated By** Boscoe J **Validated Date** 3/14/07

Disposition: Rework\*\_\_ Repair\*\_\_ Use As Is\*\_\_ Return To Vendor\*\_\_ Scrap\*\_\_

NOTE, Rev 0: Awaiting test results from outside laboratory to determine whether the permeability of the 316ss parts can be used as is without further work.  
 12/08/06: Status unchanged.

*Please use p. 2 for disposition and approvals.*

~~For rework or repair of vendor supplied equipments, fill in information below:~~

|                       |                  |                        |                  |                      |                  |
|-----------------------|------------------|------------------------|------------------|----------------------|------------------|
| <del>#Hours</del>     | <del>_____</del> | <del>\$Est Labor</del> | <del>_____</del> | <del>\$G&amp;A</del> | <del>_____</del> |
| <del>\$Material</del> | <del>_____</del> | <del>\$Burden</del>    | <del>_____</del> | <del>\$Total</del>   | <del>_____</del> |

|                                   |                  |                 |                  |
|-----------------------------------|------------------|-----------------|------------------|
| <del>Disposition By</del>         | <del>_____</del> | <del>Date</del> | <del>_____</del> |
| <del>Supervisor's Concur</del>    | <del>_____</del> | <del>Date</del> | <del>_____</del> |
| <del>Eng. Dept. Head Concur</del> | <del>_____</del> | <del>Date</del> | <del>_____</del> |
| <del>WCO/Other</del>              | <del>_____</del> | <del>Date</del> | <del>_____</del> |

|                                     |                  |                 |                  |
|-------------------------------------|------------------|-----------------|------------------|
| <del>PQA/QC Mgr Dispos Concur</del> | <del>_____</del> | <del>Date</del> | <del>_____</del> |
| <del>QC Field Verification By</del> | <del>_____</del> | <del>Date</del> | <del>_____</del> |

**Distribution**

**Cog** J. Chranowski

**Insp** Phelps C

Proj. Doc Control (when closed)

QC Files

Malsbury J

Boscoe J

T. Meighan

Dudek L

Reiersen W

Williams M

Tyrrell M

Disposition: Rework\_\_\_ Repair \_\_\_ Use As Is\_\_\_ Return to Vendor\_\_\_ Scrap\_\_\_



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For rework or repair of vendor supplied equipment, fill in information below:

# Hours \_\_\_\_\_ \$ Est Labor \_\_\_\_\_ \$ G&A \_\_\_\_\_  
\$ Material \_\_\_\_\_ \$ Burden \_\_\_\_\_ \$ Total \_\_\_\_\_

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Disposition by \_\_\_\_\_

~~Supervisor's Concurrence~~ \_\_\_\_\_

Eng. Dept. Head Concurrence \_\_\_\_\_

Other (i.e., WCO/FPE) Concurrence \_\_\_\_\_

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PQA/QC Mgr Disposition Concurrence \_\_\_\_\_

QA Field Verification by \_\_\_\_\_