

Status	5 - Corrective Action Needed	Trend	01-Deviation From Doc/Proc
Department	NCSX	Division	WBS 141
Source/Org	VENDOR		
Item Dwg/Part#	D-NCSX-MCF-001 Rev. 03	Procurement #	S005242-F
		Cost Center	9450 1*** 1404
RAP#	3209	Job Doc #	S005242-F
		Vendor	Energy Industries of Ohio
RAP Title	NCSX - Modular Coil Winding Forms		

HoldTag Applied

Nonconforming Condition (include requirement(s) violated):

MCWF-B2, During the magnetic permeability verification of the NCSX B2 modular coil winding form a total of nine (9) areas were found to exhibit a permeability above the maximum allowed. NCSX-CSPEC-141-03-11 paragraph 3.1.1.5.1 states "the local relative magnetic permeability of any point in the winding form (including base metal and weld repairs) shall not exceed 1.02." Eight areas were found on the as cast surface, one area was found on a machined surface, area #4.

Representative pictures are attached.

Revision 1 (11/20/06): All areas ground per disposition, all areas re-tested below 1.02 Mu except area #4 which is on the machined flange surface. Area #4 has had approximately 1/16" of material removed and still exhibits a magnetic permeability >3.5 Mu. CFPhelps 11/20/06

Lot Size Recd	0	Sample Size Insp	0	<input type="checkbox"/> Lot Rejected	# Rejected	0
Reported By	Phelps C	Validated By	Malinowski F	Validated Date	11/02/06	

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

Once the coil has been VPI'd, additional grinding will be made in area #4 to further reduce the permeability and bring the winding form into compliance.

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

#Hours	_____	\$Est Labor	_____	\$G&A	_____
\$Material	_____	\$Burden	_____	\$Total	\$200
Disposition By	Chrzanowski J	Date	01/22/07		
Supervisor's Concur	N/A	Date	_____		
Eng. Dept. Head Concur	Williams M	Date	01/29/07		
WCO/Other	Nelson B (RI M)	Date	01/24/07		
PQA/QC Mgr Dispos Concur	Malinowski F	Date	01/29/07		
QC Field Verification By	_____	Date	_____		

- Distribution**
- Cog** Heitzenroeder P
 - Insp** Various
 - Proj. Doc Control (when closed)
 - QC Files
 - Malsbury J
 - Boscoe J
 - Chrzanowski J
 - Heitzenroder P
 - Sutton L
 - Malinowski F
 - Nelson B E
 - Reiersen W
 - Williams M
 - Lumberger J
 - Tyrrell M

NCSX B2 MCWF Pictures









