

**PPPL NONCONFORMANCE REPORT NO: 3630**      **Open Date 02/02/06**

<b>Status</b>	9 - Closed NCR	<b>Trend</b>	01-Deviation From Doc/Proc
<b>Department</b>	NCSX	<b>Division</b>	NCSX Project
<b>Source/Org</b>	FABRICATION, OPERATIONS & MAINTENANCE		
<b>Item Dwg/Part#</b>	SE142C-134R2&SE142-135R	<b>Procurement #</b>	PE006055-W
<b>RAP#</b>	3207	<b>Job Doc #</b>	D-NCSX-MCF-001
<b>RAP Title</b>	Modular Coil Fabrication - Winding Form Preparation Activities		

HoldTag Applied

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

The lower lead block parts for the C-Type NCSX modular coils are not in accordance with the drawing details. See Attachment 1 for details.

(For QA reference: JP Pattern, PE006055-W)

<b>Lot Size Recd</b>	12	<b>Sample Size Insp</b>	7	<input checked="" type="checkbox"/> <b>Lot Rejected</b>	<b># Rejected</b>	7
<b>Reported By</b>	Phelps C	<b>Validated By</b>	Zatz I	<b>Validated Date</b>	02/01/06	

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

The manufacturer fabricated the parts correctly to the revision of the drawing that he was given. Sometime during the manufacturing process, NCSX made drawing changes that never got to the vendor. Parts are to be modified in-house to revised drawings.

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

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

<b>Disposition By</b>	Chrzanowski J	<b>Date</b>	03/02/06
<b>Supervisor's Concur</b>	Dudek L	<b>Date</b>	03/02/06
<b>Eng. Dept. Head Concur</b>	Williams M	<b>Date</b>	03/02/06
<b>WCO/Other</b>	N/A	<b>Date</b>	_____

<b>PQA/QC Mgr Dispos Concur</b>	Boscoe J	<b>Date</b>	03/09/06
<b>QC Field Verification By</b>	Phelps C	<b>Date</b>	05/10/06

**Distribution**

**Cog** J. Chrzanowski  
**Insp** Phelps/Boscoe  
 Proj. Doc Control (when closed)  
 QC Files  
 Malsbury J  
 Boscoe J  
 T. Meighan  
 Heitzenroeder P  
 Williams M  
 Tyrrell M

**NCR 3630 Details - Attachment 1**

**SE142C-134 Rev. 2 “Modular Coil Type-C Side A Lower Lead Block Detail”**

**Area C-3**

1. Drawing calls for two 0.63” dia. holes with a tolerance of +/- 0.01”, holes measure 0.60”.
2. Drawing calls for 1.0” dia. holes for a depth of 0.375” with a tolerance of +/- 0.01”, holes measure 0.90” with a depth of 0.563”.

**Section A-A**

1. Drawing calls for a thickness of 0.69” with a tolerance of +/- 0.01”, thickness measures 0.94”.

**Section D-D**

1. Drawing calls for a thickness of 1.02” with a tolerance of +/- 0.01”, thickness measures 0.94”.

A sampling of four out of the six pieces received were measured and all four were found to be out of tolerance as detailed above.

**SE142C-135 Rev. 1 “Modular Coil Type-C Side B Lower Lead Block Detail”**

**Area D-5**

1. Drawing calls for two 0.63” dia. holes with a tolerance of +/- 0.01”, holes measure 0.59”.
2. Drawing calls for 1.0” dia. holes for a depth of 0.375” with a tolerance of +/- 0.01”, holes measure 0.90” with a depth of 0.563”.

**Section A-A**

1. Drawing calls for a thickness of 0.69” with a tolerance of +/- 0.01”, thickness measures 0.94”.

A sampling of three out of the six pieces received were measured and all three were found to be out of tolerance as detailed above.