

**PPPL NONCONFORMANCE REPORT NO: 3640      Open Date 03/21/06**

<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>	VENDOR		
<b>Item Dwg/Part#</b>	NCSX-CSPEC-141-03-11	<b>Procurement #</b>	S005242-F
		<b>Cost Center</b>	9450 1*** 1404
<b>RAP#</b>	3209	<b>Job Doc #</b>	S005242-F
		<b>Vendor</b>	Energy Industries of Ohio
<b>RAP Title</b>	NCSX - Modular Coil Winding Forms		

☐ HoldTag Applied

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

MCWF C3 - During the surface finish verification of the NCSX C3 MCWF a number of non-conforming details were discovered that were not reported by the vendor prior to shipment. See details below and attached pictures.

1. Inserts used for the vendor's CMM operation were left in the casting and were found to exhibit a magnetic permeability greater than 1.02 Mu which is unacceptable.
2. Two of the cooling tube clearance holes were not completely drilled through the casting leaving an obstruction which would interfere with the installation of the cooling tubes. The picture for this particular item shows cooling tubes after repair work was performed.
3. One of the slots for the lead block was not completely machined leaving an obstruction which would interfere with the installation of the lead block assembly.
4. A machining gouge at the junction of the bottom and web of tee winding surface was discovered.

**Lot Size Recd** 0      **Sample Size Insp** 0      ☐ Lot Rejected      **# Rejected** 0

**Reported By** Phelps C      **Validated By** Malinowski F      **Validated Date** 03/21/06

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

- 1) Inserts were removed.
  - 2) Cooling tube clearance holes and lead block slots were opened by grinding.
  - 3) The machining gouge was filled with air-cured epoxy (CTD540) and glass bead.
- (Hrs. = 8)

**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>	<u>Chrzanowski J</u>	<b>Date</b>	<u>04/19/06</u>
<b>Supervisor's Concur</b>	<u>Dudek I</u>	<b>Date</b>	<u>04/19/06</u>
<b>Eng. Dept. Head Concur</b>	<u>Williams M</u>	<b>Date</b>	<u>04/19/06</u>
<b>WCO/Other</b>	<u>N/A</u>	<b>Date</b>	_____

<b>PQA/QC Mgr Dispos Concur</b>	<u>Boscoe J</u>	<b>Date</b>	<u>04/19/06</u>
<b>QC Field Verification By</b>	<u>Phelps C</u>	<b>Date</b>	<u>04/20/06</u>

**Distribution**

**Cog** Chrzanowski J  
**Insp** Phelps C  
 Proj. Doc Control (when closed)  
 QC Files  
 Malsbury J  
 Boscoe J  
 Chrzanowski J  
 Sutton L  
 Malinowski F  
 Reiersen W  
 Nelson B  
 Tyrrell M