

PPPL NONCONFORMANCE REPORT NO: 3620 Open Date 10/10/05

Status	9 - Closed NCR	Trend	01-Deviation From Doc/Proc
Department	NCSX	Division	NCSX Project
Source/Org	VENDOR		
Item Dwg/Part#	SE141-078, Rev. 1	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):

(C-1 MCWF) The poloidal break shim does not follow the contours of the casting as shown on SE141-078, Rev. 1 and in the corresponding model.

Lot Size Recd	1	Sample Size Insp	1	<input checked="" type="checkbox"/> Lot Reje...	# Rejected	1
Reported By	Nelson B	Validated By	Malinowski F	Validated Date	10/06/05	

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

The shims for C1 and C2 are both machined similarly (i.e., not following casting contours) due to the unavailability of STEP files when these parts are machined. Consequently, the shims for C1 and C2 will be accepted "as is" and NCSX will compensate for this condition when winding these coils. CAD files for machining the shims for all three casting types are now available and posted; all remaining shims are to be machined to follow the casting contours per these files.
 Cost of rework: Shimming of the windings to compensate is estimated to take 4 hrs. @ \$85/hr=\$340.

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

#Hours	_____	\$Est Labor	_____	\$G&A	_____
\$Material	_____	\$Burden	_____	\$Total	\$340

Disposition By	Heitzenroeder P	Date	11/30/05
Supervisor's Concur	Nelson B, NCSX Core Systems Mg	Date	11/30/05
Eng. Dept. Head Concur	Williams M	Date	11/30/05
WCO/Other	N/A	Date	_____
PQA/QC Mgr Dispos Concur	Malinowski F	Date	11/30/05
QC Field Verification By	Malinowski F	Date	11/30/05

Distribution
 Cog Heitzenroeder P
 Insp Various
 Proj. Doc Control (when closed)
 QC Files
 Malsbury J
 Boscoe J
 Heitzenroeder P
 Sutton L
 Malinowski F
 Williams M
 Reiersen W
 Nelson B
 Lumberger J
 Chrzan J/Raftop
 Tyrrell M