

Status 2 - Disposition Needed **Trend** 01-Deviation From Doc/Proc
Department NCSX **Division** WBS 114
Source/Org FABRICATION, OPERATIONS & MAINTENANCE
Item Dwg/Part# SE142C-270 Rev. 0 **Procurement #** _____ **Cost Center** _____
RAP# 3234 **Job Doc #** D-NCSX-MCF-004 **Vendor** VARIOUS
RAP Title Modular Coil Fabrication - Post VPI Activities

HoldTag Applied

Nonconforming Condition (include requirement(s) violated):

The following additional parts for the NCSX modular coil final winding clamp assemblies exhibit a magnetic permeability higher than the maximum allowed per NCSX-ASPEC-GRD-03 paragraph 3.3.1.1 (permeability shall not exceed 1.02). See NCR 3634 for list of additional final winding clamp parts that are over the magnetic permeability limit.
 PART #s 3 AND 6 (SEE ATTACHED FOR DETAILS.)

The following parts were found to be acceptable.
 PART #9 (SEE ATTACHED FOR DETAILS.)

REV 1: ADDITIONAL PARTS RECEIVED AND INSPECTED. SEE ATTACHMENT.
 REV 2: Final winding clamp assembly redesigned, see attachment for revision details. Also see NCR 3634 as it deals with this same issue.

Lot Size Recd 0 **Sample Size Insp** 0 Lot Rejected **# Rejected** 0
Reported By Phelps C **Validated By** Boscoe J **Validated Date** 04/16/07

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

Awaiting test results from outside laboratory to determine whether the permeability of the 316ss parts can be used as is without further work.

Please use p. 2 for disposition and approvals .

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

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

Disposition By _____	Date _____
Supervisor's Concur _____	Date _____
Eng. Dept. Head Concur _____	Date _____
WCO/Other _____	Date _____

PQA/QC Mgr Dispos Concur _____	Date _____
QC Field Verification By _____	Date _____

Distribution

Cog J. Chrzanowski
Insp C. Phelps
 Proj. Doc Control (when closed)
 QC Files
 Malsbury J
 Boscoe J
 T. Meighan
 Dudek L
 Williams M
 Tyrrell M

Disposition: Rework___ Repair ___ Use As Is___ Return to Vendor___ Scrap___



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

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

Disposition by _____

~~Supervisor's Concurrence~~ _____

Eng. Dept. Head Concurrence _____

Other (i.e., WCO/FPE) Concurrence _____

PQA/QC Mgr Disposition Concurrence _____

QA Field Verification by _____

NCR 3639 ATTACHMENT, R2 (p. 1 of 1)

The following additional parts for the NCSX modular coil final winding clamp assemblies exhibit a magnetic Permeability higher than the maximum allowed per NCSX-ASPEC-GRD-03 paragraph 3.3.1.1 (permeability shall not exceed 1.02). See NCR 3634 for a list of additional final winding clamp parts that are over the magnetic permeability limit.

<u>Part #</u>	<u>Part Type</u>	<u>Quantity</u>	<u>Sample Size</u>	<u>Results</u>
3	Bushing Spacer (silver plated 316)	805	30	(5) >1.06, <1.08 (23) >1.08, <1.09 (2) >1.09, <1.10
6	Keeper Screw (silver plated 316)	1756	40	(21) >1.02, <1.03 (7) >1.03, <1.04
		1464 (2nd shipment)	80	(4) <1.02 (36) >1.02, <1.03 (24) >1.03, <1.04 (14) >1.04, <1.05 (1) >1.05, <1.06

The following parts were found to be acceptable:

<u>Part #</u>	<u>Part Type</u>	<u>Quantity</u>	<u>Sample Size</u>	<u>Results</u>
9	Flat Washer (316)	1980	40	(40) <1.02

REV 2: The final winding clamp has been redesigned requiring new Part 3, the new shipment of Part 3 are below 1.02 Mu (see sampling results below). Part 6 remains unchanged and cannot be annealed due to the silver plating. See results above and NCR 3634 for additional permeability readings on the balance of Part 6.

<u>Part #</u>	<u>Part Type</u>	<u>Quantity</u>	<u>Sample Size</u>	<u>Results</u>
New - 3	Bushing Spacer	910	72	(72) <1.02 Mu