

Status	9 - Closed NCR	Trend	07-Out Of Tolerance
Department	NCSX	Division	WBS 121
Source/Org	FABRICATION, OPERATIONS & MAINTENANCE		
Item Dwg/Part#	SE121-004, R1, Part #6	Procurement #	D-NCSX-FPA-001
RAP#	3268	Job Doc #	D-NCSX-FPA-001
RAP Title	Field Period Assembly Station One		

HoldTag Applied

Nonconforming Condition (include requirement(s) violated):

VVSA Nos. 1, 2, and 3: The following welds exceed allowable magnetic permeability of 1.02 mu per C-Spec 185-01-00 3.2.1.4.6. The weld joint is where the two halves of the Cryostat Interface Mounting Flange weld together which is 316 stainless. There are two welds per mounting flange 1/4" thick, 1/8" wide by 2-1/2" long.

VVSA #1 - Port 12 bottom >1.8 mu to isolated spots 2.0 mu narrow and wide ends
 Port 12 top >1.3 mu <1.4 mu narrow and wide ends

VVSA #2 - Port 12 bottom - narrow end >1.2 mu <1.3 mu wide end >1.3 mu <1.4 mu.
 Port 12 top narrow end >1.8 mu <2.0 mu wide end >1.5 mu <1.6 mu.

VVSA #3 - Port 12 bottom - narrow end >1.3 mu <1.4 mu wide end 1.4 mu to 1.5 mu.
 Port 12 top - narrow end >1.5 mu <1.6 mu wide end >1.8 mu <2.0 mu.

Lot Size Recd	0	Sample Size Insp	0	<input type="checkbox"/> Lot Rejected	# Rejected	0
Reported By	Boscoe J	Validated By	Phelps C	Validated Date	12/12/06	

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

From: Arthur W. Brooks
 Sent: Friday, January 05, 2007 12:04 PM
 To: Michael E. Viola
 Subject: RE: two permeability NCR 3688 & 3689

Mike,
 The high permeability values stated for parts covered in NCR's 3688 and 3689 are acceptable given their location on Port 12 and the amount of material involved. The base material is within the 1.2 threshold set for port 12 and the higher values for the welds are confined to a small amount of material.
 Art

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

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

Disposition By	Viola M	Date	01/05/07
Supervisor's Concur	Dudek L	Date	01/09/07
Eng. Dept. Head Concur	Williams M	Date	01/09/07
WCO/Other	N/A	Date	_____
PQA/QC Mgr Dispos Concur	Boscoe J	Date	01/11/07
QC Field Verification By	N/A	Date	_____

Distribution

Cog M. Viola
Insp Boscoe J

Proj. Doc Control (when closed)
 QC Files
 Malsbury J
 Boscoe J
 J. Edwards
 L. Dudek
 Reiersen W
 Williams M
 Tyrrell M
 Phelps C