

Status 2 - Disposition Needed **Trend** 01-Deviation From Doc/Proc
Department NCSX **Division** WBS 123
Source/Org FABRICATION, OPERATIONS & MAINTENANCE
Item Dwg/Part# SE121-008 rev.1 **Procurement #** _____ **Cost Center** _____
RAP# 3268 **Job Doc #** D-NCSX-FPA-001 **Vendor** _____
RAP Title Field Period Assembly Station One

HoldTag Applied

Nonconforming Condition (include requirement(s) violated):

VVSA-2 & 3, On vacuum vessel sub-assembly #2 & #3 there are dimensional deviations with the placement of the heating and cooling lines, see details below.

Deviation #1 - Drawing SE121-008 R1 page 1 of 5 states "Spacing between tubing runs not to exceed 8" max." Spacings of up to 12" found, see attached pictures 1, 2, 3, & 8.
 Deviation #2 - Procedure D-NCSX-FPA-001 R1 paragraph 6.7.1 calls for a 5" spacing between H/C stud locations with a tolerance of +/- 1" along the length of the hose. Areas found to be as great as 14.5", see attached pictures 4, 5, 9, 10, & 11.
 Deviation #3 - Procedure D-NCSX-FPA-001 R1 paragraph 6.7.2 states "Use heating cooling saddle foot print as a guide to maintain a minimum distance of 1/4 inch from the flux loops." In some areas the heating cooling saddles (clamps) are touching the flux (diagnostic) loops, see attached pictures 6, 7, 12, & 13.

This situation exists on VVSA-1 and was accepted "use as is" via NCR 3710.

Lot Size Recd 0 **Sample Size Insp** 0 Lot Rejected **# Rejected** 0
Reported By Phelps C **Validated By** Boscoe J **Validated Date** 10/15/07

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

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 M. Viola
Insp Boscoe/Phelps
 Proj. Doc Control (when closed)
 QC Files
 Malsbury J
 Boscoe J
 J. Edwards
 L. Dudek
 Williams M
 Simmons B
 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 _____

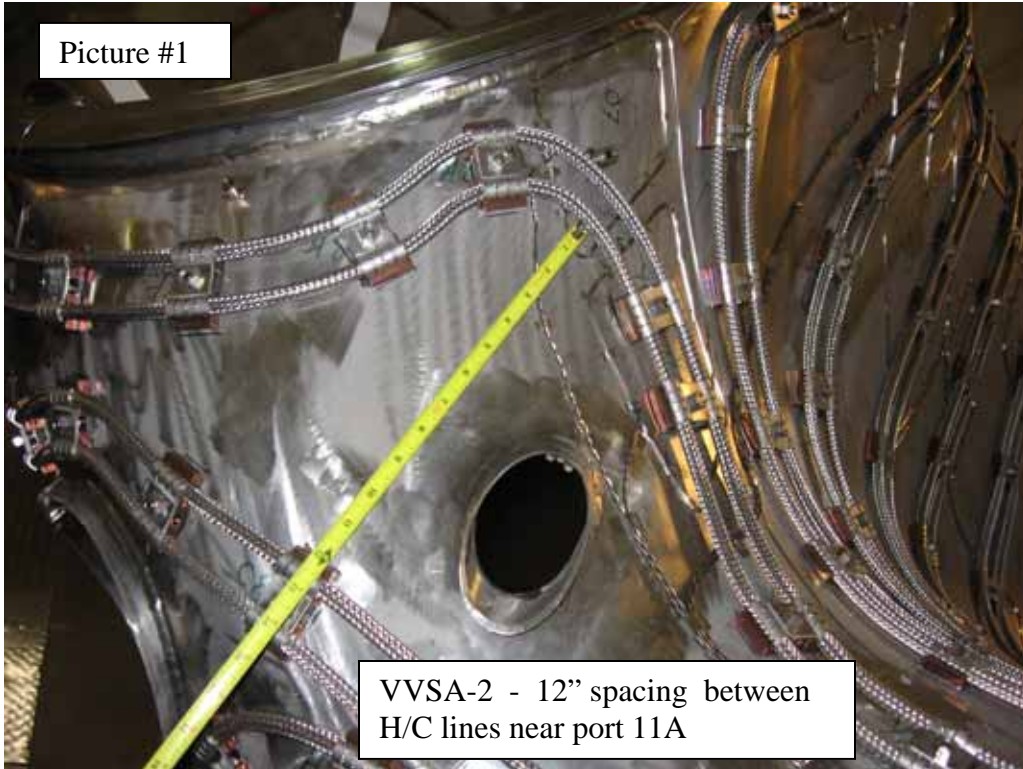
Other (i.e., WCO/FPE) Concurrence _____

PQA/QC Mgr Disposition Concurrence _____

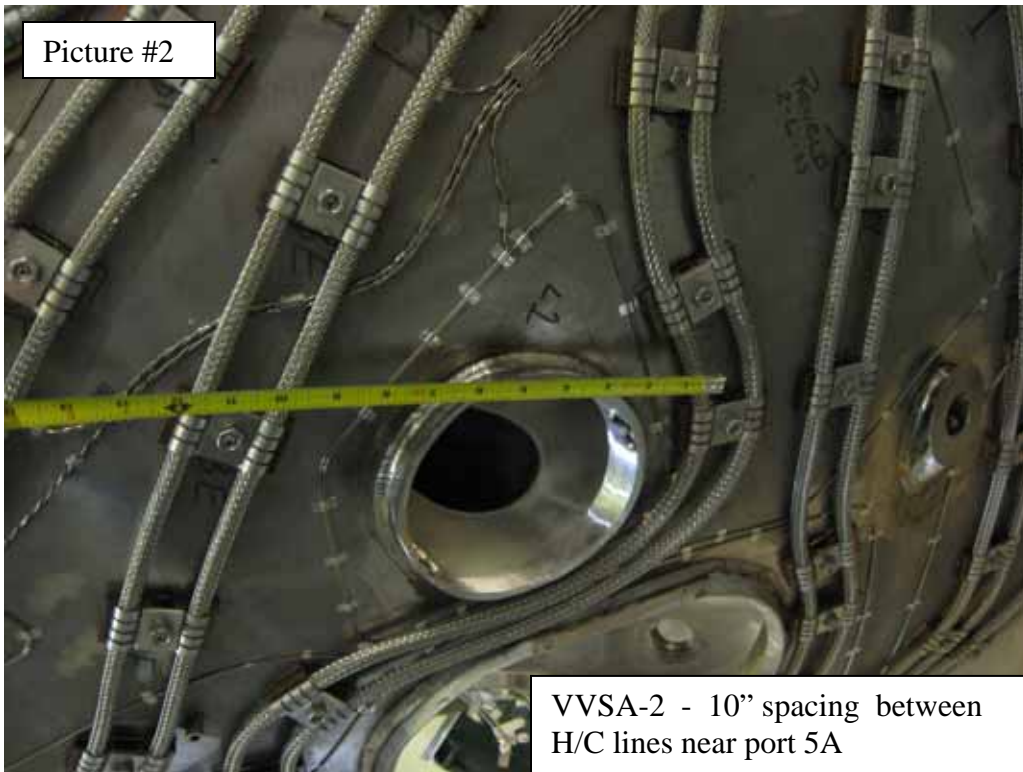
QA Field Verification by _____

NCR 3729 – Attachment 1 – Pictures – 10/15/07

Picture #1



Picture #2

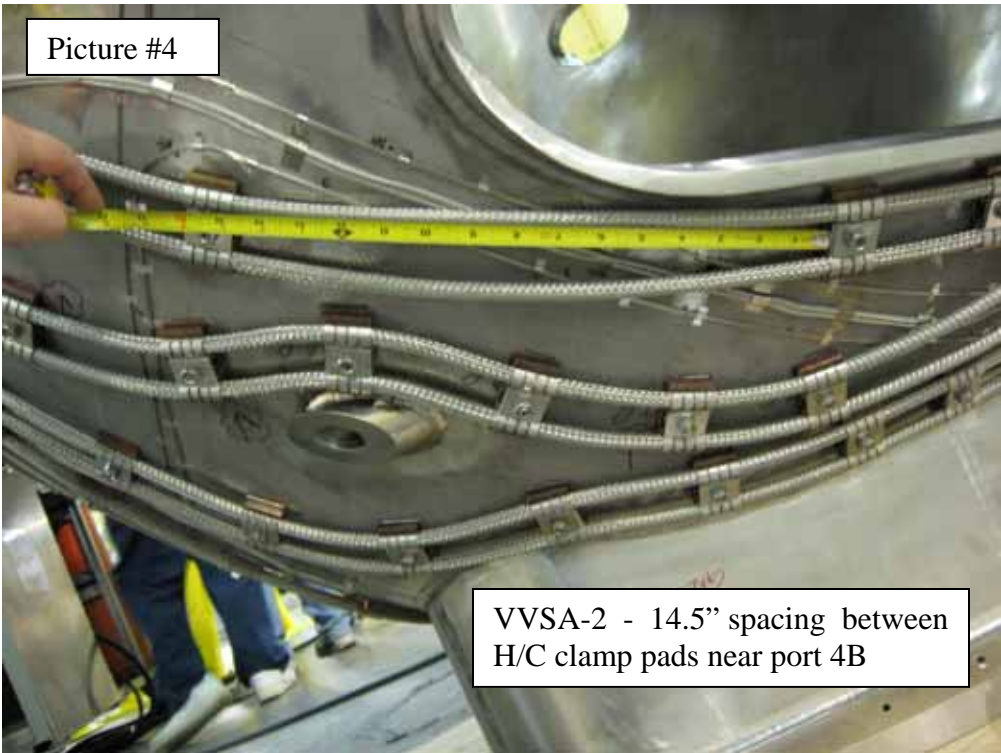


Picture #3



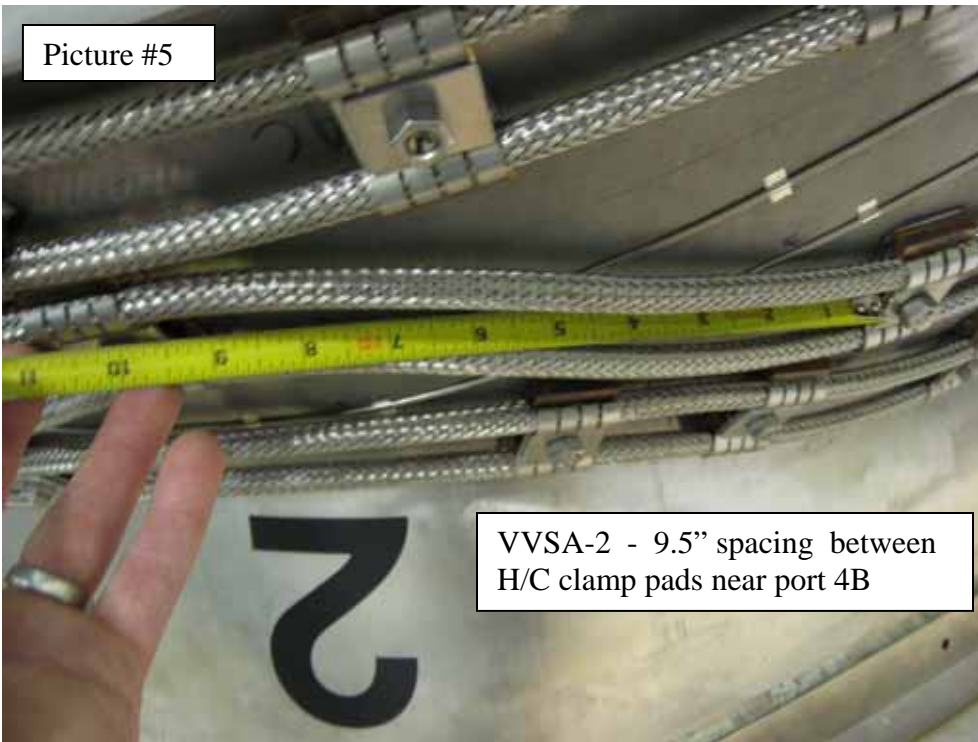
VVSA-2 - 11.5" spacing between H/C lines near port 11B

Picture #4



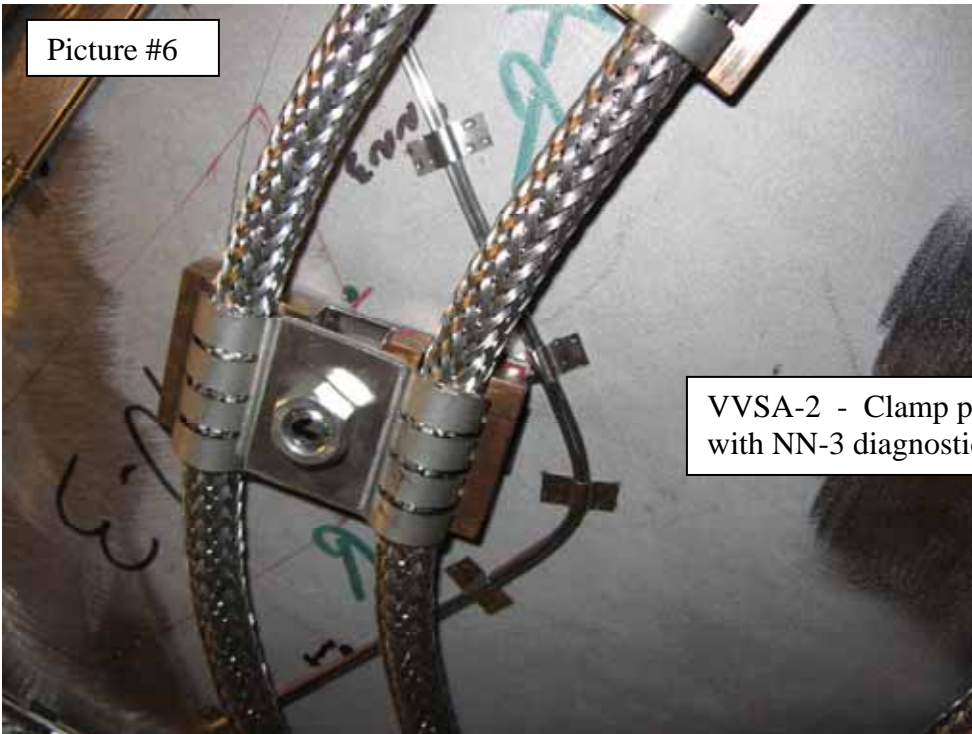
VVSA-2 - 14.5" spacing between H/C clamp pads near port 4B

Picture #5



VVSA-2 - 9.5" spacing between H/C clamp pads near port 4B

Picture #6

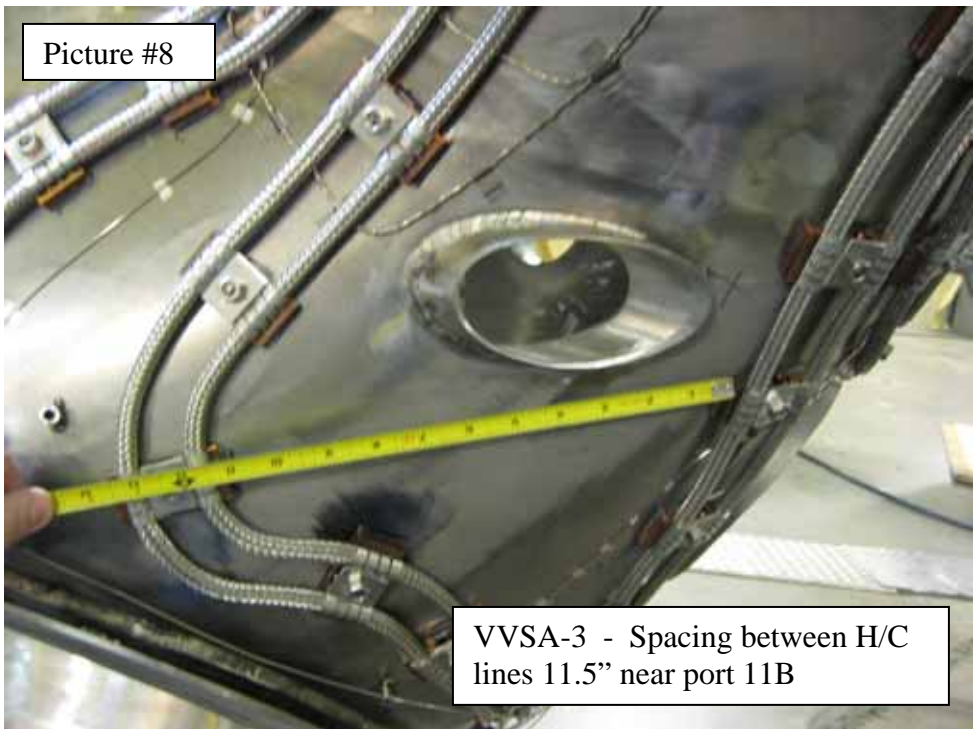


VVSA-2 - Clamp pad in contact with NN-3 diagnostic loop



Picture #7

VVSA-2 - Clamp pad ~1/16" away from THO-5 diagnostic loop



Picture #8

VVSA-3 - Spacing between H/C lines 11.5" near port 11B

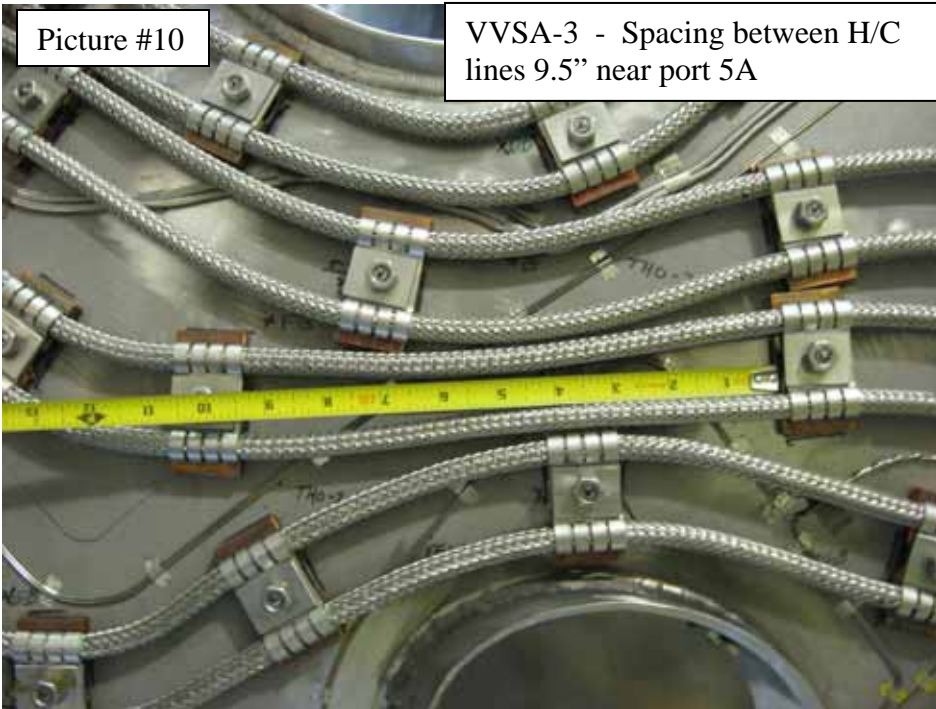
Picture #9

VVSA-3 - Spacing between H/C lines 11" near port 4B



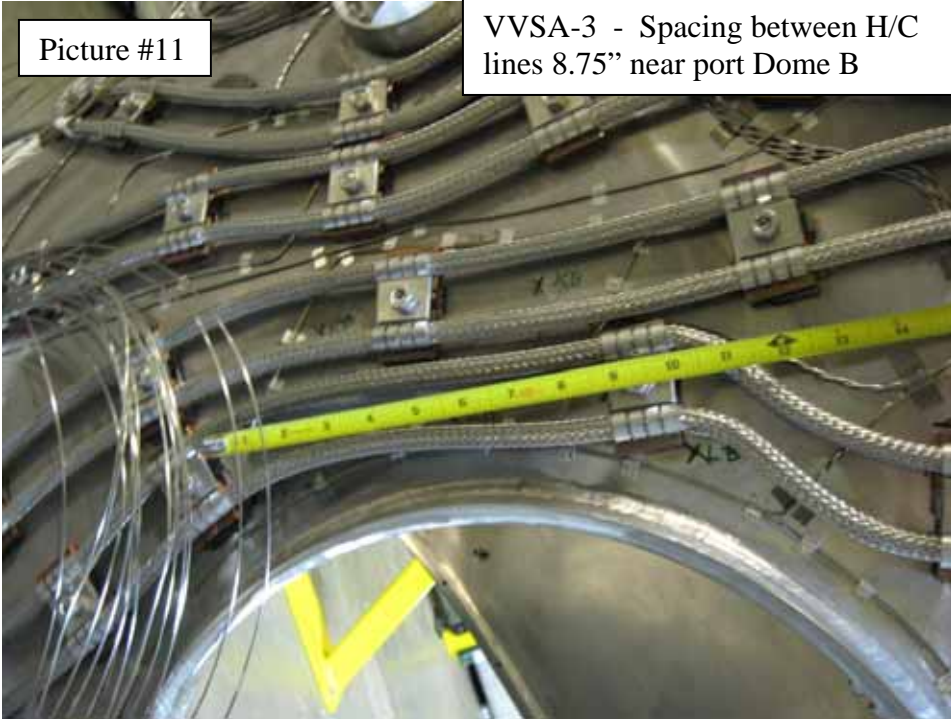
Picture #10

VVSA-3 - Spacing between H/C lines 9.5" near port 5A



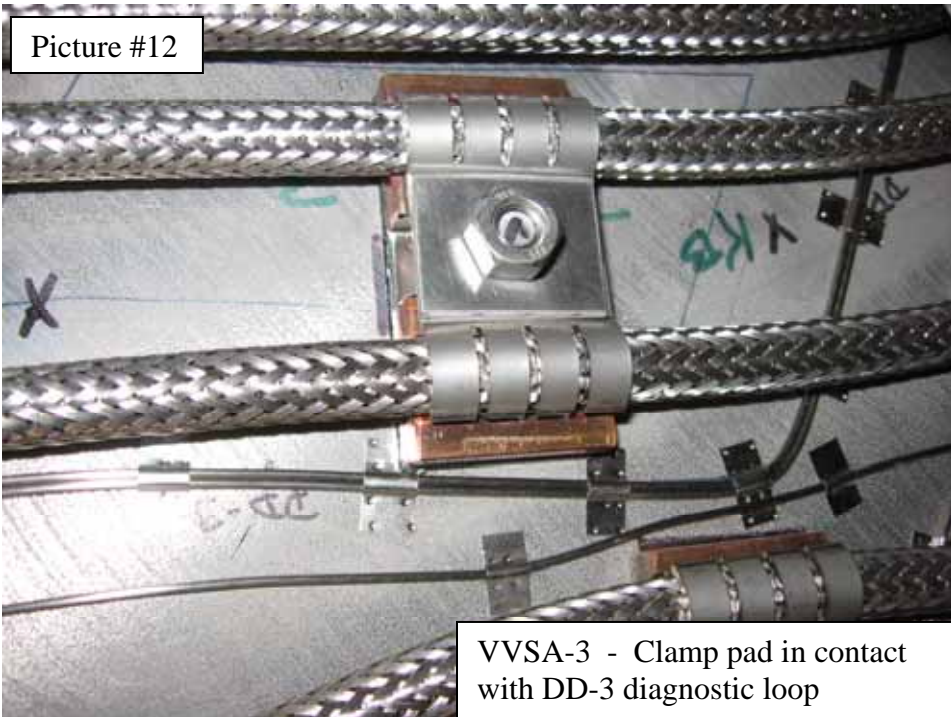
Picture #11

VVSA-3 - Spacing between H/C lines 8.75" near port Dome B



Picture #12

VVSA-3 - Clamp pad in contact with DD-3 diagnostic loop



Picture #13

VVSA-3 - Clamp pad in contact with GG-6 diagnostic loop

