

<b>Status</b>	5 - Corrective Action Needed		<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>	DS141-03, Rev. 1	<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):**

(C-1 MCWF) DS141-03, Rev. 1 specifies a stud length of 9.50". The 7 installed poloidal break studs measure 9" (consistent with DS141-03, Rev. 0).

NCSX-CSPEC-141-03-09, 3.1.1.5 specifies that local magnetic permeability shall not exceed 1.02. The poloidal break hardware (studs, nuts & washers) exceed the highest test reference (5.0) on-site.

<b>Lot Size Recd</b>	7	<b>Sample Size Insp</b>	7	<input checked="" type="checkbox"/> Lot Rejected	<b># Rejected</b>	7
<b>Reported By</b>	Raftop/Chrzanow	<b>Validated By</b>	Boscoe/Malinows	<b>Validated Date</b>	10/06/05	

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

**Rework**

EIO purchased bolts to NCSX -CSPEC-141-03, Rev. 0. However Rev. 1 changed the bolt length from 9" to 9-1/2". Additionally, the permeability of these bolts exceeded 1.02 due to a misunderstanding of the bolt standard required. Accordingly, the poloidal break hardware requirements have been revised in NCSX-CSPEC-141-03, Rev. 10 and drawing #s DS-141-036 and DS-141-060. EIO was requested to provide a proposal to provide replacement hardware based on these. Until replacement bolts are available, EIO is requested to install the hardware on hand and torque the studs to 500 ft-lbs. PPPL will remove and replace them with the revised fasteners on any winding forms shipped prior to the availability of the revised hardware. (Note: Since the studs are short, they are easily identified). It should be noted that the anti-galling compound was changed to "Thred-Gard" and should be used beginning with the C3 casting. As soon as the new replacement hardware is available, EIO should begin to install these and torque them to the full specified value. Estimated cost of PPPL rework: 8 hrs @ \$85=\$680.00

Note: Closed 9/9 prior to verification that nonconforming hardware has been replaced. Reopened 9/11. See FAM email on QA Server.

**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>	\$85

<b>Disposition By</b>	Heitzenroeder P	<b>Date</b>	11/29/05
<b>Supervisor's Concur</b>	Nelson B, NCSX Core Syst Mgr	<b>Date</b>	11/29/05
<b>Eng. Dept. Head Concur</b>	Williams M	<b>Date</b>	11/29/05
<b>WCO/Other</b>	N/A	<b>Date</b>	_____

<b>PQA/QC Mgr Dispos Concur</b>	Malinowski F	<b>Date</b>	11/29/05
<b>QC Field Verification By</b>	_____	<b>Date</b>	_____

**Distribution**
**Cog** Heitzenroeder P
**Insp** Various

Proj. Doc Control (when closed)

QC Files

Malsbury J

Boscoe J

Sutton L

Malinowski F

Williams M

Reiersen W

White A

Lumberger J

Nelson B

Chrz J/Raftop S

Tyrrell M