

PPPL NONCONFORMANCE REPORT NO: 3661 **Open Date 07/05/06**

Status	9 - Closed NCR		Trend	01-Deviation From Doc/Proc	
Department	NCSX		Division	NCSX Project	
Source/Org	VENDOR				
Item Dwg/Part#	D-NCSX-MCF-001 Rev. 03	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				
<input type="checkbox"/> HoldTag Applied					

Nonconforming Condition (include requirement(s) violated):

C-5, During the magnetic permeability verification of the NCSX C5 modular coil winding form a total of nineteen (19) areas were found to exhibit a permeability above the maximum allowed. NCSX-CSPEC-141-03-11 paragraph 3.1.1.5.1 states "the local relative magnetic permeability of any point in the winding form (including base metal and weld repairs) shall not exceed 1.02." All of these areas found are on the as cast surface and appear to fit into one of three characterizations below.

1. Oxidized, rusted appearance in the form of a scrape or a ding, see areas 2b "ID of hole".
2. Dark areas that have the appearance of lead or dark substance smeared on the surface, see areas 1, 11, 12, 13, 14, 15, 16, 18.
3. Pock mark impressions in the as cast surface with no distinct color variation, see areas 4, 5, 6, 7, 8, 9, 17.

Lot Size Recd	0	Sample Size Insp	0	<input type="checkbox"/> Lot Rejected	# Rejected	0
Reported By	Phelps C	Validated By	Boscoe J	Validated Date	07/05/06	

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

The indicated areas will be ground to remove the high permeability contamination and re-tested. Jim Chrzanowski will coordinate this work.

For rework or repair of vendor supplied equipments, fill in information below:				Distribution	
#Hours	_____	\$Est Labor	_____	\$G&A	_____
\$Material	_____	\$Burden	_____	\$Total	\$850
Disposition By	Heitzenroeder P	Date	07/06/06		
Supervisor's Concur	Nelson B	Date	07/06/06		
Eng. Dept. Head Concur	Williams M	Date	07/06/06		
WCO/Other	N/A	Date	_____		
PQA/QC Mgr Dispos Concur	Boscoe J	Date	07/10/06		
QC Field Verification By	Phelps C	Date	07/12/06		
Cog Heitzenroeder P Insp Phelps C Proj. Doc Control (when closed) QC Files Malsbury J Boscoe J Chrzanowski J Heitzenroeder P Sutton L Lumberger J Reiersen W Nelson B Williams M Malinowski F					

A2 permeability pictures













