

Status	9 - Closed NCR	Trend	01-Deviation From Doc/Proc
Department	NCSX	Division	NCSX Project
Source/Org	FABRICATION, OPERATIONS & MAINTENANCE		
Item Dwg/Part#	N/A	Procurement #	D-NCSX-MCF-004
RAP#	3234	Job Doc #	D-NCSX-MCF-004
RAP Title	Modular Coil Fabrication - Post VPI Activities		

HoldTag Applied

Nonconforming Condition (include requirement(s) violated):

MCWF C2 thru C5, There is a coil winding clamp stud welded to the top of the polodial break shim on the C2 thru C5 modular coils that exhibits a permeability greater than the maximum of 1.02 Mu allowed by NCSX-ASPEC-GRD-04 paragraph 3.3.1.1. These studs are in a sensitive area near the winding pack and complete removal is risky. Details of the condition of each coil are listed below. These studs are 3/8" in diameter and are 316 stainless steel.

- C2 - Stud has been cut off approximately 0.5" above polodial break shim and has a magnetic permeability of >1.08 Mu, <1.09 Mu.
- C3 - Stud has been ground flush to polodial break shim and has a magnetic permeability of >1.10 Mu, <1.15 Mu.
- C4 - Stud has been ground flush to polodial break shim and has a magnetic permeability of >1.08 Mu, <1.09 Mu.
- C5 - Stud has been cut off approximately 0.5" above polodial break shim and has a magnetic permeability of >1.09 Mu, <1.10 Mu.

The C1 coil had a similar condition that was documented on NCR 3641 and was dispositioned "use as is" with a magnetic permeability of >1.2 Mu, <1.8 Mu.

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	10/23/06	

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

"Use as is". This is the same disposition that was used and accepted on NCR 3641 for the C1 coil. There is a significant risk in damaging the coil in any efforts to remove the weld stud base. Future coils are using Inconel studs which eliminates the permeability issues.

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

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

Disposition By	Chrzanowski J	Date	11/14/06
Supervisor's Concur	Dudek L	Date	11/14/06
Eng. Dept. Head Concur	Williams m	Date	11/15/06
WCO/Other	N/A	Date	_____
PQA/QC Mgr Dispos Concur	Boscoe J	Date	11/15/06
QC Field Verification By	N/A	Date	_____

Distribution

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