# PPPL NONCONFORMANCE REPORT NO: 3684 Open Date 11/30/06

**Status** 9 - Closed NCR **Trend** 01-Deviation From Doc/Proc

**Department** NCSX **Division** WBS 141

**Source/Org** VENDOR

**Item Dwg/Part#** SE141-114, r8 - MCWF A-4 **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

☐ HoldTag Applied

**Nonconforming Condition (include requirement(s) violated):**

MCWF A-4 shows the following conditions (photos attached) exceeding the tolerances of SE141-114, R8:
1) Between Holes #86 to #94 the legs of the Tee (septum) have a step down area that dips, on the long leg, .008" to .028" from the flat portion of the leg. MTM's measurements of the long leg in this area show it .002" to .003" above nominal, so the "gully" ranges from .010", just at the upper limit of the tolerance of .020" profile equally distributed bilaterally (+/- .010"), to as much as .020" below that tolerance. There is a similar, though more shallow, "gully" on the short leg.
2) Between Holes #48 & #52 the radius between the long and short legs of the Tee exceeds the specified .11" +/- .01".

**Lot Size Recd** 1 **Sample Size Insp** 1 ☐ Lot Rejected **# Rejected** 1

**Reported By** Phelps C **Validated By** Malinowski F **Validated Date** 11/27/06

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

The "gully" areas should be filled in with CTD 540 epoxy / glass bead to provide an even surface and support for the winding. This condition will be discussed with EIO/MTM during the next Quality call to avoid this condition with future castings.

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

**#Hours** _____ **$Est Labor** _____ **$G&A** _____

**$Material** _____ **$Burden** _____ **$Total** $425

**Disposition By** Heitzenroeder P **Date** 11/30/06

**Supervisor's Concur** Nelson B **Date** 11/30/06

**Eng. Dept. Head Concur** Williams M **Date** 12/01/06

**WCO/Other** N/A **Date** _____

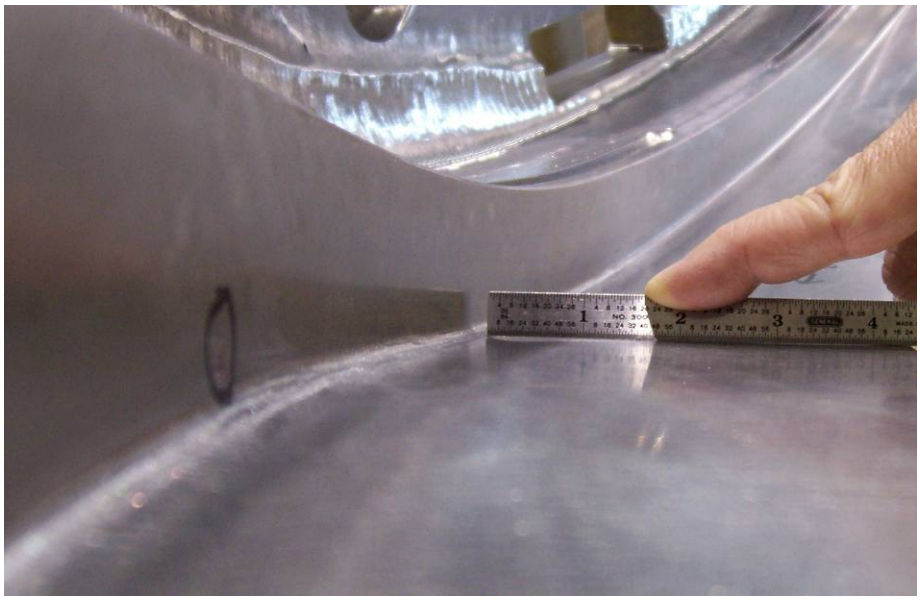
**PQA/QC Mgr Dispos Concur** Malinowski F **Date** 12/08/06

**QC Field Verification By** Phelps C **Date** 01/18/06

**Distribution**

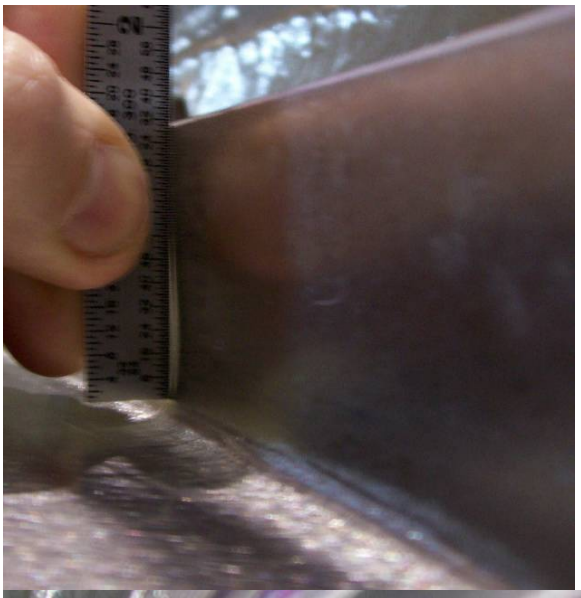
**Cog** Heitzenroeder P
**Insp** Chrzanowski
Proj. Doc Control (when closed)
QC Files
Malsbury J
Boscoe J
Sutton L
Nelson B
Reiersen W
Williams m
Lumberger J
Tyrrell M
Malinowski F
Phelps C

This photo shows the location - between Holes #86 to #94 on the side of the casting facing up on the shipping skid.

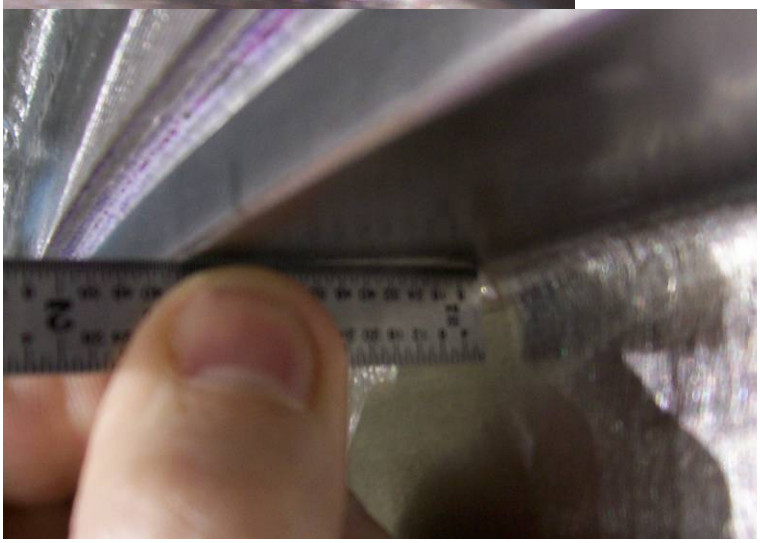


The next one shows a straight edge reference.

Note in both photos the shadow along the base of the tee. This is step, readily detected by hand, from the flat of the tee down toward the radius.



More shots of the straight edge on the long and short legs of the tee.



The first photo shows a 5/32" gauge. The second is the required 1/8" radius gauge

These photos show a short area, between holes #48 & #52 on the bottom side (as-shipped) of the casting, where the radius did not pass the gage check.

The first shows the required 1/8" gauge and the second shows the next size bigger 5/32" gage.