PPPL NONCO	NFORMANCE REPOR	T NO: 3699	Open D	ate 03/05/07	Rev #: 1 , 8/8/2007				
Status	5 - Corrective Action Neede	b. b	Trend						
Department	NCSX		Division	NCSX Project					
Source/Org	NCSX Project								
Item Dwg/Part#	MCWF A-1 & B-2	Procurement #	D-NCSX	-FPA-001	Cost Center				
RAP# 3268	Job Doc # D-NCSX-FP	A-001 Vendor	MAJOR TO	OL AND MACHINE	, INC.				
RAP Title Field Period Assembly Station One									
🗌 HoldTag Ap	plied								
Nonconforming	Nonconforming Condition (include requirement(s) violated):								
A threaded insert in threaded inserts on 0.005" above the fla Eight similar thread	the MCWF A-1 flange has pull A-1 in accordance with RFD-1- ange surface. (MTM confirmed ed inserts were installed on MC	ed up, compromising f 4-020. One of these pr that they'd expect this CWF B-2 (see Major To	the flange fl ulled up whe s magnitude ool & Machin	atness. Major Too en used to lift the of movement for e NCR NC20449).	bl & Machine (MTM) installed two casting and now extends roughly the threads to fully seat.)				
Lot Size Recd	0 Sample Siz Chrzanowski J Va	e Insp0 lidated By	_	Lot Rejected	# Rejected 0				
Disposition: Rewo	ork* Repair* Use As Is*_	Return To Vendo	or* Scrap	*	Rework				
Rework lifted insert	s by applying pre-load to inser-	/ remove bolt/ weld ir	nserts to loci	<pre>in place and plai</pre>	ne until surfaces are smooth. See				
Rework lifted insert attached document	s by applying pre-load to inser with photo.	:/ remove bolt/ weld ir	nserts to loci	< in place and plar	ne until surfaces are smooth. See				
Rework lifted insert attached document	s by applying pre-load to insert with photo. ir of vendor supplied equipm	:/ remove bolt/ weld ir ents, fill in information	nserts to loci	< in place and plar	ne until surfaces are smooth. See				
Rework lifted insert attached document	s by applying pre-load to insert with photo. ir of vendor supplied equipm \$Est Labc	:/ remove bolt/ weld ir ents, fill in information	on below:	< in place and pla	ne until surfaces are smooth. See				
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Disposition:	Rework	Repair	Use As Is	Return to Vendor	Scrap				
For rework or repair of vendor supplied equipment, fill in information below:									
# Hour	'S	\$ Est Lab	or	\$ G&A					
\$ Mate	rial	\$ Burden		\$ Total					
Disposition b	у								
Supervisor's	Concurrence								
Eng. Dept. He	ad Concurrent	ce							
Other (i.e., W	CO/FPE) Conci	urrence							
PQA/QC Mgr	Disposition Co	oncurrence							
QA Field Veri	fication by								
					p. 2				

Revised NCR 3699 Disposition for Modular Coil Threaded Inserts

(Affected Modular Coils are A-1 (2 inserts) and B-2 (8 inserts)

- 1. **PLACE** the Threaded Insert Plate (drawing SE142-489) over the insert to pre-loaded.
- 2. **INSERT** a 1 3/8" stud through the pre-load plate and fully engage in the affected threaded insert.
- 3. **INSTALL** a supernut on the 1 3/8" stud.
- 4. Using a star-pattern, incrementally **TORQUE** the supernut jacking bolts to 30 ft-lbs to "pre-load" the threaded inserts (clearance for any insert movement will be provided by the spotface on the bottom side of the plate).
- 5. **DRILL** hole then **WELD** per drawing NCSX SE141-603
- 6. Machinist "**PLANE**" the flange surface smooth.

