

Status 5 - Corrective Action Needed 9 - Closed 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-FPA-001 Vendor MAJOR TOOL AND MACHINE, INC.  
 RAP Title Field Period Assembly Station One

HoldTag Applied

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

A threaded insert in the MCWF A-1 flange has pulled up, compromising the flange flatness. Major Tool & Machine (MTM) installed two threaded inserts on A-1 in accordance with RFD-14-020. One of these pulled up when used to lift the casting and now extends roughly 0.005" above the flange surface. (MTM confirmed that they'd expect this magnitude of movement for the threads to fully seat.) Eight similar threaded inserts were installed on MCWF B-2 (see Major Tool & Machine NCR NC20449).

Lot Size Recd 0 Sample Size Insp 0  Lot Rejected # Rejected 0  
 Reported By Chrzanowski J Validated By \_\_\_\_\_ Validated Date 03/05/07

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

Rework lifted inserts by applying pre-load to insert/ remove bolt/ weld inserts to lock in place and plane until surfaces are smooth. See attached document with photo.

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

#Hours _____	\$Est Labor _____	\$G&A _____
\$Material _____	\$Burden _____	\$Total <u>\$1000</u>
Disposition By _____	Date _____	
Supervisor's Concur _____	Date _____	
Eng. Dept. Head Concur _____	Date _____	
WCO/Other _____	Date _____	
PQA/QC Mgr Dispos Concur _____	Date _____	
QC Field Verification By _____	Date _____	

**Distribution**

- Cog J. Chrzanowski  
 Insp Boscoe/Phelps  
 Proj. Doc Control (when closed)  
 QC Files  
 Malsbury J  
 Boscoe J  
 J. Edwards  
 L. Dudek  
 B. Nelson  
 M. Viola  
 M. Tyrrell  
 L. Sutton  
 F. Malinowski

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

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

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

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Disposition by \_\_\_\_\_

Supervisor's Concurrence \_\_\_\_\_

Eng. Dept. Head Concurrence \_\_\_\_\_

Other (i.e., WCO/FPE) Concurrence \_\_\_\_\_

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PQA/QC Mgr Disposition Concurrence \_\_\_\_\_

QA Field Verification by \_\_\_\_\_

# 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.

