PPPL NONCONFORMANCE REPORT NO: 3751 **Open Date** 03/12/08

Status ~~2 Disposition Needed~~ 9-Closed **Trend** 07-Out Of Tolerance

Department NCSX **Division** Construction

Source/Org Fab, Ops and Maint

Item Dwg/Part# Coils A1 and C1 **Procurement #** D-NCSX-FPA-002

Cost Center **WBS/Other** WBS 185

RAP# 3317 **Job Doc #** D-NCSX-FPA-002 **Vendor**

RAP Title Field Period Assembly Station Two

☐ HoldTag Applied

Nonconforming Condition (include requirement(s) violated):

Step 6.4.16 of D-NCSX-FPA-002 requires coil racking alignment measurements with a maximum .005" RMS deviation. The actual measurements for A1 and C1 are .012".

Lot Size Recd 0 **Sample Size Insp** 0 ☐ Lot Rejected **# Rejected** 0

Reported By Ellis R **Validated By** Boscoe J John E. Boscoe Digitally signed by John E. Boscoe DN: cn=John E. Boscoe, c=US, o=PPPL Date: 2008.03.12 10:50:18 -04'00' **Validated Date**

Distribution **Cog** M. Viola **Insp** J. Boscoe

Proj. Doc Control (when closed) QC Files Malsbury J Boscoe J

Edwards J Dudek L Ellis R Williams M Chrzanowski J Heitzenroeder P

Simmons R Tyrrell M

NCR 3751

Disposition: Rework___ Repair ___ Use As Is ✓ Return to Vendor___ Scrap___

Absence of conical seats on A1 & C1 coils forced us to rely on a single Romer arm measurement of tooling balls. We obtained our best possible alignment by racking the coils perpendicular to one flange. In-plane deviations, which we cannot control, made the RMS exceed our goal (est. deviation ±0.010"). This is within a tolerable range of uncertainty.

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

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

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

Disposition by [signature] 3/13/08

Supervisor's Concurrence P. Heitzenroder 3/26/08

Eng. Dept. Head Concurrence [signature] 4/3/08

Other (i.e., WCO/FPE) Concurrence N/A

PQA/QC Mgr Disposition Concurrence John E. Boese

QA Field Verification by N/A (CY 4-4-08)