

PPPL NONCONFORMANCE REPORT NO: 3618 Open Date 10/10/05

Status	5 - Corrective Action Needed		Trend	01-Deviation From Doc/Proc	
Department	NCSX		Division	NCSX Project	
Source/Org	VENDOR				
Item Dwg/Part#	DS141-03, Rev. 1	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):

(C-1 MCWF) DS141-03, Rev. 1 specifies a stud length of 9.50". The 7 installed poloidal break studs measure 9" (consistent with DS141-03, Rev. 0).
 NCSX-CSPEC-141-03-09, 3.1.1.5 specifies that local magnetic permeability shall not exceed 1.02. The poloidal break hardware (studs, nuts & washers) exceed the highest test reference (5.0) on-site.

Lot Size Recd 7 **Sample Size Insp** 7 ☒ **Lot Reje...** **# Rejected** 7
Reported By Raftop/Chrzanow **Validated By** Boscoe/Malinows **Validated Date** 10/06/05

Disposition:	Rework* <u> </u>	Repair* <u> </u>	Use As Is* <u> </u>	Return To Vendor* <u> </u>	Scrap* <u> </u>	Rework
---------------------	--------------------------	--------------------------	-----------------------------	------------------------------------	-------------------------	---------------

EIO purchased bolts to NCSX -CSPEC-141-03, Rev. 0. However Rev. 1 changed the bolt length from 9" to 9-1/2". Additionally, the permeability of these bolts exceeded 1.02 due to a misunderstanding of the bolt standard required. Accordingly, the poloidal break hardware requirements have been revised in NCSX-CSPEC-141-03, Rev. 10 and drawing #s DS-141-036 and DS-141-060. EIO was requested to provide a proposal to provide replacement hardware based on these. Until replacement bolts are available, EIO is requested to install the hardware on hand and torque the studs to 500 ft-lbs. PPPL will remove and replace them with the revised fasteners on any winding forms shipped prior to the availability of the revised hardware. (Note: Since the studs are short, they are easily identified). It should be noted that the anti-galling compound was changed to "Thred-Gard" and should be used beginning with the C3 casting. As soon as the new replacement hardware is available, EIO should begin to install these and torque them to the full specified value. Estimated cost of PPPL rework: 8 hrs @ \$85=\$680.00

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

#Hours	<u> </u>	\$Est Labor	<u> </u>	\$G&A	<u> </u>
\$Material	<u> </u>	\$Burden	<u> </u>	\$Total	<u>\$85</u>

Disposition By	<u>Heitzenroeder P</u>	Date	<u>11/29/05</u>
Supervisor's Concur	<u>Nelson B, NCSX Core Syst Mgr</u>	Date	<u>11/29/05</u>
Eng. Dept. Head Concur	<u>Williams M</u>	Date	<u>11/29/05</u>
WCO/Other	<u>N/A</u>	Date	<u> </u>

PQA/QC Mgr Dispos Concur	<u>Malinowski F</u>	Date	<u>11/29/05</u>
QC Field Verification By	<u> </u>	Date	<u> </u>

Distribution

Cog Heitzenroeder P
Insp Various
 Proj. Doc Control (when closed)
 QC Files
 Malsbury J
 Boscoe J
 Sutton L
 Malinowski F
 Williams M
 Reiersen W
 White A
 Lumberger J
 Nelson B
 Chrz J/Raftop S
 Tyrrell M