

PPPL NONCONFORMANCE REPORT NO: 3622		Open Date 10/24/05		Rev #: 1 , 9/1/2006	
Status	5 - Corrective Action Needed		Trend	01-Deviation From Doc/Proc	
Department	NCSX		Division	NCSX Project	
Source/Org	NCSX Project				
Item Dwg/Part#	SE141-123 Rev. 0 / Part #5	Procurement #	D-NCSX-MCF-001	Cost Center	
RAP#	3207	Job Doc #	D-NCSX-MCF-001	Vendor	
RAP Title Modular Coil Fabrication - Winding Form Preparation Activities					
<input type="checkbox"/> HoldTag Applied					

Nonconforming Condition (include requirement(s) violated):

C1 through C5 Modular coils - The modular coil winding clamp stud welds are required to have a magnetic permeability of less than 1.02 per paragraph 6.13.9 of procedure D-NCSX-MCF-001 rev. 2. The welded studs exhibit a permeability of greater than 1.07 but less than 1.10. Upon further investigation the studs themselves, prior to welding, exhibit the same level of magnetic permeability. Material test reports for the studs state that they are made of 316L stainless steel.

Lot Size Recd	400	Sample Size Insp	80	<input checked="" type="checkbox"/> Lot Rejected	# Rejected	400
Reported By	Phelps C	Validated By		Validated Date		

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

Use As Is

The studs are used for tooling purposes only and will be removed following final VPI of the coil.

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

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

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 Phelps C
Proj. Doc Control (when closed)
QC Files
Malsbury J
Boscoe J
Reiersen W
Williams M
Heitzenroeder P
Tyrrell M
Dudek L

Disposition: Rework____ Repair ____ Use As Is____ Return to Vendor____ Scrap____

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

Hours _____ \$ Est Labor_____ \$ G&A_____

\$ Material _____ \$ Burden _____ \$ Total _____

Disposition by _____

Supervisor's Concurrence _____

Eng. Dept. Head Concurrence _____

Other (i.e., WCO/FPE) Concurrence _____

PQA/QC Mgr Disposition Concurrence _____

QA Field Verification by _____