

PPPL NONCONFORMANCE REPORT NO: 3622 Open Date 10/24/05

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
RAP#	3207	Job Doc #	D-NCSX-MCF-001
RAP Title	Modular Coil Fabrication - Winding Form Preparation Activities		
<input type="checkbox"/> HoldTag Applied			

Nonconforming Condition (include requirement(s) violated):

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	Boscoe J	Validated Date	10/19/05	

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	Chrzanowski J	Date	01/05/06
Supervisor's Concur	Dudek L	Date	01/05/06
Eng. Dept. Head Concur	Williams M	Date	01/16/06
WCO/Other	N/A	Date	_____

PQA/QC Mgr Dispos Concur	Boscoe J	Date	01/17/06
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