PPPL NONCONFORMANCE REPORT NO: 3634 Open Date 03/13/06 Rev 1 , 5/15/06

Status 2 - Disposition Needed **Trend** 01-Deviation From Doc/Proc

Department NCSX **Division** NCSX Project

Source/Org FABRICATION, OPERATIONS & MAINTENANCE

Item Dwg/Part# SE142C-270 Rev. 0 **Procurement #** D-NCSX-MCF-004 **Cost Center**

RAP# 3234 **Job Doc #** D-NCSX-MCF-004 **Vendor** VARIOUS

RAP Title Modular Coil Fabrication - Post VPI Activities

☐ HoldTag Applied

Nonconforming Condition (include requirement(s) violated):

The first shipment of NCSX modular coil final winding clamp assemblies, and related purchased hardware exhibits a magnetic permeability higher than the maximum allowed per NCSX-ASPEC-GRD-03 paragraph 3.3.1.1 (permeability shall not exceed 1.02). Unless otherwise noted all material is type 316 stainless steel See attached list for details.

REV 1: Parts 3 and 6 are silverplated and were verbally reported as not being able to be annealed without damage.

SEE PAGE 2 FOR ADDITIONAL REVISIONS.

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

Reported By Phelps C **Validated By** Boscoe J **Validated Date** 03/10/06

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

(Rev. 0) Rework by removing permeability using vacuum oven cycle 800-1000 deg. C @ 1 hour. (Labor = 40 hours)

Please use Page 2 of NCR for disposition and approvals for Rev. 1.

~~**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 C. Phelps
Proj. Doc Control (when closed)

QC Files
Malsbury J
Boscoe J
T. Meighan
Williams M
Dudek L
Tyrrell M
Heitzenroeder P
Reiersen W

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 N/A _____

Digitally signed by N/A
DN: CN = N/A, C = US, O = QA, OU = QA
Date: 2006.05.15 15:11:07 -04'00'

PQA/QC Mgr Disposition Concurrence _____

QA Field Verification by _____

Part #	Part Type	Quantity	Sample Size	Results
2	Bar, Clamp	175	21	(12) >1.10, <1.15 (4) >1.15, <1.2 (5) >1.2, <1.8
3	Bushing Spacer (Silver Plated 316)	1	1	(1) >1.06, <1.08
4	Washer, Convex	1610	100	(40) <1.02 (60) >1.02, <1.03
5	Washer, Concave	1610	100	(6) >1.02, <1.03 (9) >1.03, <1.04 (30) >1.04, <1.05 (30) >1.05, <1.06 (25) >1.06, <1.08
6	Keeper Screw (Silver Plated 316)	4	4	(1) >1.02, <1.03 (1) >1.03, <1.04 (2) >1.04, <1.05
7	Clamp Swivel	1	1	(1) >1.03, <1.04
10	3/8-16 x 1 ¼ SH	882	44	(41) >1.02, <1.03 (3) <1.02
11	3/8 x 3/8 shoulder	188	20	(1) >1.02, <1.03 (1) >1.03, <1.04 (3) >1.04, <1.05 (6) >1.05, <1.06 (6) >1.06, <1.08 (3) >1.08, <1.09

The following parts were found to be acceptable.

Part #	Part Type	Quantity	Sample Size	Results
8	Belleville Washers	~10,000	~200	(~200) <1.02 (Inconel)
12	¼-20 x ½ BH	1850	100	(100) <1.02