

PPPL NONCONFORMANCE REPORT NO: 3641 **Open Date 03/27/06**

Status	9 - Closed NCR	Trend	01-Deviation From Doc/Proc
Department	NCSX	Division	NCSX Project
Source/Org	FABRICATION, OPERATIONS & MAINTENANCE		
Item Dwg/Part#	N/A	Procurement #	D-NCSX-MCF-004-00
RAP#	3234	Job Doc #	D-NCSX-MCF-004
RAP Title	Modular Coil Fabrication - Post VPI Activities		
<input type="checkbox"/> HoldTag Applied			

Nonconforming Condition (include requirement(s) violated):

C1 MCWF - There is a coil winding clamp stud manually welded to the top of the poloidal break shim on the C1 modular coil that exhibits a permeability >1.2, <1.8. Maximum allowable magnetic permeability is 1.02 per NCSX-ASPEC-GRD-04 paragraph 3.3.1.1. This stud was broken off after VPI operations in an attempt to remove it from the assembly but some weld material remains which is why permeability is beyond the allowable limit.

Lot Size Recd <u>0</u>	Sample Size Insp <u>0</u>	<input type="checkbox"/> Lot Rejected	# Rejected <u>0</u>
Reported By <u>Chrzanowski J</u>	Validated By <u>Phelps C</u>	Validated Date <u>03/27/06</u>	

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

"Use as is". Art Brooks has reviewed and accepted this higher permeability stud located on the top edge of the poloidal break septum. See Art B. quotation below (4/14/06):
 "This looks OK. Even though its close to the plasma (~13") and sitting in a relatively high field (1.7T) the volume is fairly small (I assumed 3/8" dia. by 1/8" long and mu = 1.8) giving a field perturbation that is tiny (0.0017 Gauss)."

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

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

Disposition By	<u>Chrzanowski J</u>	Date	<u>04/19/06</u>
Supervisor's Concur	<u>Dudek L</u>	Date	<u>04/19/06</u>
Eng. Dept. Head Concur	<u>Williams M</u>	Date	<u>04/19/06</u>
WCO/Other	<u>N/A</u>	Date	_____

PQA/QC Mgr Dispos Concur	<u>Boscoe J</u>	Date	<u>04/19/06</u>
QC Field Verification By	<u>N/A</u>	Date	_____

Distribution

Cog J. Chrzanowski
Insp C. Phelps
 Proj. Doc Control (when closed)

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