PPPL NONCONFORMANCE REPORT NO: 3659 Open Date 07/05/06 Rev #: 1, 10/23/2006

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

Department NCSX **Division** NCSX Project

Source/Org FABRICATION, OPERATIONS & MAINTENANCE

Item Dwg/Part# D-NCSX-MCF-001 Rev. 02 **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

☐ HoldTag Applied

Nonconforming Condition (include requirement(s) violated):

The lead block mounts for the A1 modular coil are beyond the maximum magnetic permeability of 1.02 Mu as stated in NCSX-ASPEC-GRD-03 paragraph 3.3.1.1. These parts were manufactured by PPPL and made from 316 stainless steel. The remaining A type lead block mounts have yet to made and will most likely have a similar amount of magnetic permeability. At the time of this report six pieces have been made.
Inside diameter (machined threads) = greater than 1.3 Mu and less than 1.7 Mu
NCR #3628 was written on the C type lead block mounts and accepted as is with a magnetic permeability of greater than 1.02 Mu and less than 1.8 Mu on 1/16/06.

Rev 1: Further inspection reveals that the lead block mounts for the A2 & A3 coils are above the maximum magnetic permeability of 1.02 Mu. A2 = >1.2 Mu <1.8 Mu, A3 = >1.3 Mu <1.7 Mu. With three of the six coils having this condition it will most likely affect the A4 thru A6 coils as well. When dispostiioning this NCR please consider this issue for all of the A coils.

Lot Size Recd 6 **Sample Size Insp** 4 ☑ Lot Rejected **# Rejected** 6

Reported By Phelps C **Validated By** Boscoe J John Boscoe Digitally signed by John Boscoe DN: CN = John Boscoe, C = US, O = PPPL, OU = QA Date: 2006.10.24 07:45:56 -04'00' **Validated Date** 10/20/06

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

NOTE, Rev 0: Awaiting test results from outside laboratory to determine whether the permeability of the 316ss parts can be used as is without further work.

Please use p. 2 of NCR for disposition and approvals.

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
T. Meighan
Dudek L
Reiersen W
Williams M
Tyrrell M

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,
email=lyager@pppl.gov
Date: 2006.10.23 11:33:04 -04'00'

PQA/QC Mgr Disposition Concurrence _____

QA Field Verification by _____