

PPPL NONCONFORMANCE REPORT NO: 3759 **Open Date** 05/05/08
Status ~~2-Disposition Needed~~ 9-Closed **Trend** 07-Out Of Tolerance
Department NCSX **Division** Construction
Source/Org Fab, Ops and Maint
Item Dwg/Part# Coil A2 **Procurement #** D-NCSX-FPA-002
Cost Center **WBS/Other** WBS 185
RAP# 3317 **Job Doc #** D-NCSX-FPA-002 **Vendor**
RAP Title Field Period Assembly Station Two
 HoldTag Applied

Nonconforming Condition (include requirement(s) violated):

Step 6.4.16 of D-NCSX-FPA-002 requires coil racking alignment measurements with a maximum .005" RMS deviation. The actual measurements for A2 is .008".

The conical seats had been removed from this coil, and we were forced to rely on the Romer arm measurements of the tooling balls that were taken when conical seats were installed. The additional uncertainty degraded the alignment, but ^{by $0.003/\sqrt{3}$} this was our best, and only, way of getting back to the as-wound shape of the coil, and is acceptable.

-JEB

Lot Size Recd 0 **Sample Size Insp** 0 Lot Rejected **# Rejected** 0
Reported By Ellis R **Validated By** Boscoe J **Validated Date** 05/05/08

Distribution **Cog** M. Viola **Insp** J. Boscoe
 Proj. Doc Control (when closed) QC Files Malsbury J Boscoe J
 Edwards J Dudek L Ellis R Brooks A Williams M Chrzanowski J
 Heitzenroeder P Tyrrell M Simmons R

Disposition: Rework ___ Repair ___ Use As Is Return to Vendor ___ Scrap ___

Complete disposition on P.1 beneath
nonconforming condition.
Ly 5/1/08

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

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

Disposition by

Robert [Signature]

Supervisor's Concurrence

P. Weitzelwider 5/5/08

Eng. Dept. Head Concurrence

R. Miller 5/6/08

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

N/A

PQA/QC Mgr Disposition Concurrence

John E. Boer 5-7-09

QA Field Verification by

N/A JEB 5-7-09