

SUPPLIER NONCONFORMANCE REPORT

Date 5/15/08

Number: n/a

Company: Vulcan Products Co.

PPPL PO# PE007982-W

Item Drawing/Part# SE185-332, Sht Part 2

Job Description: NCSX FPA Station 3 Anti Tip Channel Weldment

Hold Tag Applied? Yes

NONCONFORMING CONDITION (include requirement(s) violated):

Drawing specified 45 deg. x .060" chamfer was omitted. Vulcan successfully test fit the parts without the chamfer.

Reported By D. Barber - Vulcan

Date 5/15/08

RECOMMENDED DISPOSITION (include actions to prevent recurrence):

Use-As-Is

Repair

Rework

Scrap

Disposition By: _____

Date _____

PPPL Concurrence _____

Cognizant Engineer (COG)

Date _____



PPPL Concurrence _____

Responsible Line Manager (RLM)

Date _____

DISTRIBUTION

PRINCETON UNIVERSITY
PLASMA PHYSICS LABORATORY—PPPL

PRODUCT QUALITY CERTIFICATION AND SHIPPING RELEASE					
PROJECT	ITEM DESCRIPTION			SHIPMENT NUMBER	
SE 186-332	Anti Tip Channel weld't				
PPPL SUBCONTRACT/ ORDER NO.	REV.	ITEM NO.	SUPPLIER REFERENCE NO.	REV.	QUANTITY SHIPPED
PE007982-W	-	18	w/o 030326-018	-	2
SUPPLIER'S CERTIFICATION					
<p>This is to certify that the products and services identified herein have been produced under a controlled quality assurance program and are in conformance with the procurement requirements including applicable codes, standards and specifications as identified in the above-referenced documents unless noted below. Any supporting documentation will be retained in accordance with the procurement requirements.</p>					
SIGNED: <u>Neil M. Rh</u> 		DATE: <u>05-15-08</u>			
TITLE: <u>Quality Manager</u>		COMPANY: <u>Vulcan Products Company</u>			
PPPL (AUTHORIZED REPRESENTATIVE) SHIPPING RELEASE					
<p>This is to certify that evidence supporting the above Supplier's Certification statement has been audited and no product/service nonconformances from procurement requirements have been found unless noted below. This product/service is hereby released for shipment.</p>					
<p>This section serves as the Quality Assurance release for the above described product for shipment. It does not constitute an acceptance thereof and does not relieve the Vendor, Manufacturer or Contractor of any and all responsibility or obligation imposed by the purchase contract. It does not waive any rights the Purchaser may have under the purchase contract, including the Purchaser's right to reject the above described material upon discovery of any deviations from requirements of the purchase contract, drawings and specifications.</p>					
<p>NONCONFORMANCES FROM PROCUREMENT QUALITY REQUIREMENTS: <u>Part # SE186-331-2 is missing the 45°.060 chamfer. Typical all pcs. (Inspection Point G on SE186-331-2.) VPC did test fit and function with Bolt. dtd 5-15-08</u> </p>					
REMARKS/PRODUCT SERIAL NUMBERS: <u>NONE</u>					
BY PPPL QA REPRESENTATIVE (OR DESIGNEE)				DATE	

CERTIFICATE OF CONFORMANCE

Customer Name: Princeton Plasma Physics Lab	Customer P.O. Number: PE007982-W
Part Number: SE186-332 Revision: 0	Quantity Shipped: 2 Date: TBD
Shipper Number: n/a	Work Order Number: 030326-018

The material, parts and assemblies furnished on this shipment were produced in accordance with all applicable specification required by the referenced contract or subcontract as listed below. Any non-conformances are listed at the bottom of this page.

Drawing or Specification No.:

1. SE186-332 rev. 0

SE186-332 rev. 0

PPPL Document: RDF 18-004

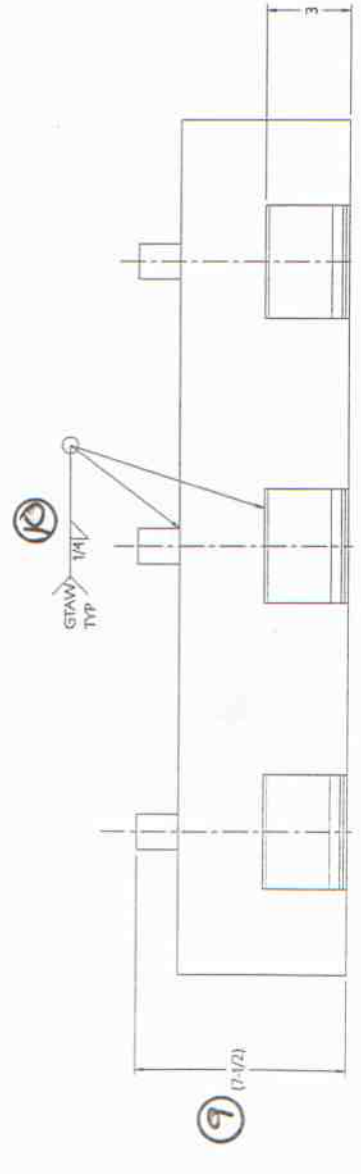
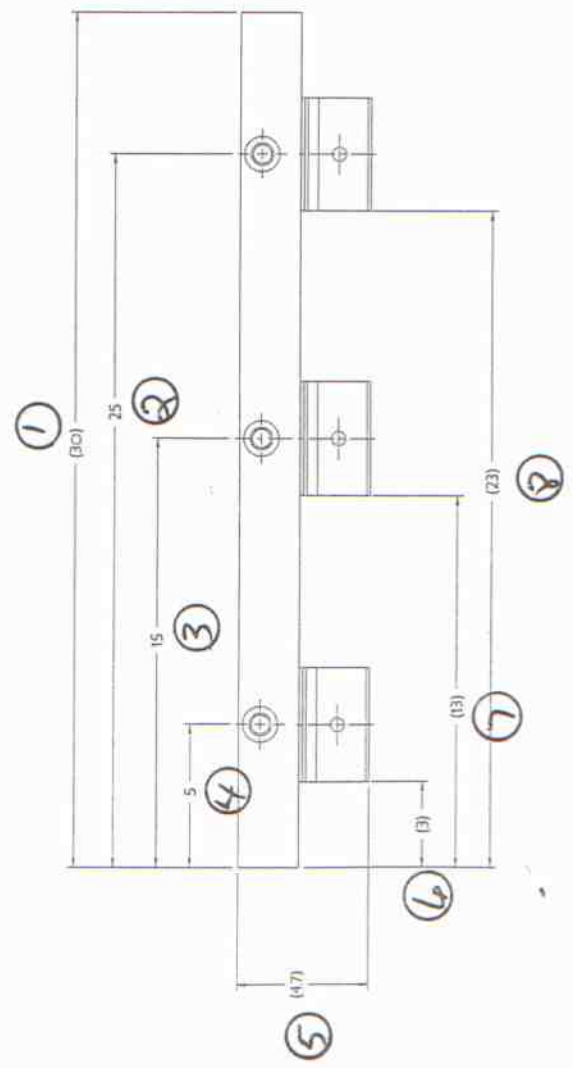
Nonconformance exception – Drawing SE186-331, item 2, inspection point 6. 45°x.060 chamfer is missing on all parts manufactured.

Material test reports, material certifications and process certifications covering the above listings, are on file and available for examination.

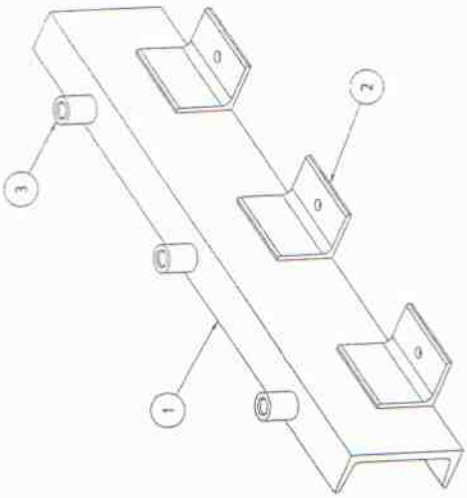
Executed By: David M. Rh  Date: 05-15-08

Title: Q.A Manager

13 14 15
 REVISED BY DATE
 APPROVED BY DATE



(2) ASSEMBLIES REQ'D w/o 030326-018



NOTE
 WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF AWS D11 SECTION 6 OR PPPL PROCEDURE NO. ENG-37.
 VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D11.
 NOTE ORIENTATION OF ALL PARTS PRIOR TO WELDING.
 SAND BLAST AND APPLY 2 COATS "SAFETY YELLOW" PAINT.

RFD-18-004 replaced either "GMAW or GTAW" welds with either "GMAW or FCAW" welds wherever appearing on this drawing. See RFD-18-004 for details

RELEASED FOR FABRICATION/INSTALLATION
 1978 (Rev. 10/11/77)

REV	DATE	DESCRIPTION	BY	CHKD	APP'D
1	11-18-77	REVISED TO REFLECT CHANGES TO RFD-18-004			
2	11-18-77	REVISED TO REFLECT CHANGES TO RFD-18-004			
3	11-18-77	REVISED TO REFLECT CHANGES TO RFD-18-004			

REV	DATE	DESCRIPTION	BY	CHKD	APP'D
1	11-18-77	REVISED TO REFLECT CHANGES TO RFD-18-004			
2	11-18-77	REVISED TO REFLECT CHANGES TO RFD-18-004			
3	11-18-77	REVISED TO REFLECT CHANGES TO RFD-18-004			

REV	DATE	DESCRIPTION	BY	CHKD	APP'D
1	11-18-77	REVISED TO REFLECT CHANGES TO RFD-18-004			
2	11-18-77	REVISED TO REFLECT CHANGES TO RFD-18-004			
3	11-18-77	REVISED TO REFLECT CHANGES TO RFD-18-004			

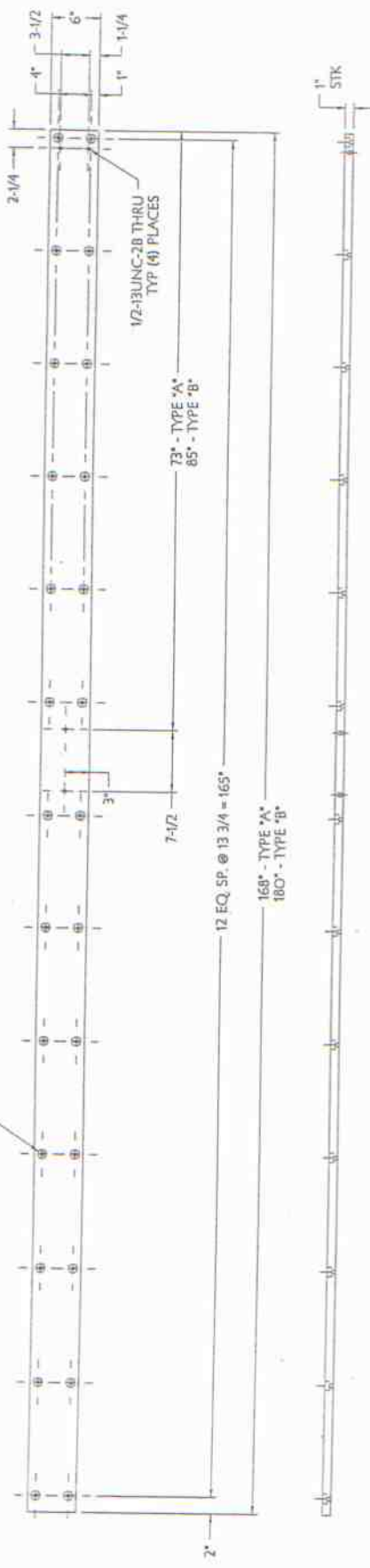
WEIGHT	38.0 LBS
MODEL NAME	SE188-332
RELEASE LEVEL	Fabrication
DWG VERSION NO.	6

REV	DATE	DESCRIPTION	BY	CHKD	APP'D
1	11-18-77	REVISED TO REFLECT CHANGES TO RFD-18-004			
2	11-18-77	REVISED TO REFLECT CHANGES TO RFD-18-004			
3	11-18-77	REVISED TO REFLECT CHANGES TO RFD-18-004			

12	13	14	15
REVISED	BY	DATE	APPROVED

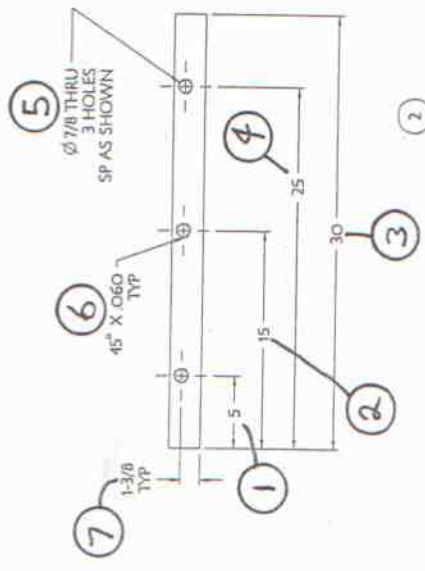
VPC QA COPY

Ø 7/16 THRU AND
Ø 1/25 CBORE x 9/16 DEEP
TYP (18) PLACES



- ① FLOOR MOUNTED ROLLER TRACK - TYPE 'A'
- ⑦ FLOOR MOUNTED ROLLER TRACK - TYPE 'B'

MAKE FROM 1 X 6 BAR



ANTI-TIP CHANNEL
MAKE FROM 6" X 13.0# CHANNEL

© Jerry Siegel

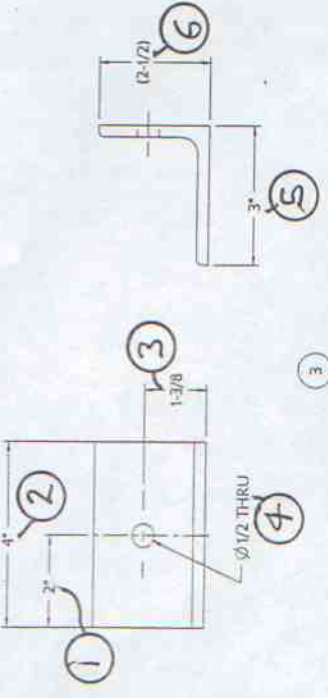
QTY	DESCRIPTION	UNIT	MATERIAL
1	FLOOR MOUNTED ROLLER TRACK - TYPE 'A'	104" B"	ASTM A36
1	SUPPORT GUSSET	104" B"	ASTM A36
1	TOP BLOCK	104" B"	ASTM A36
1	CLAMP FOR ROLLER BOLTS	104" B"	ASTM A36
1	FLOOR MOUNTED ROLLER	104" B"	ASTM A36
1	ANTI-TIP CHANNEL	104" B"	ASTM A36
1	FLOOR MOUNTED ROLLER TRACK - TYPE 'B'	104" B"	ASTM A36
1	NONSLIPER	104" B"	ASTM A36
1	STOP	104" B"	ASTM A36

QTY	DESCRIPTION	UNIT	MATERIAL
1	ANTI-TIP CHANNEL	104" B"	ASTM A36
1	CLAMP FOR ROLLER BOLTS	104" B"	ASTM A36
1	FLOOR MOUNTED ROLLER	104" B"	ASTM A36
1	TOP BLOCK	104" B"	ASTM A36
1	SUPPORT GUSSET	104" B"	ASTM A36
1	FLOOR MOUNTED ROLLER TRACK - TYPE 'A'	104" B"	ASTM A36
1	FLOOR MOUNTED ROLLER TRACK - TYPE 'B'	104" B"	ASTM A36
1	NONSLIPER	104" B"	ASTM A36
1	STOP	104" B"	ASTM A36

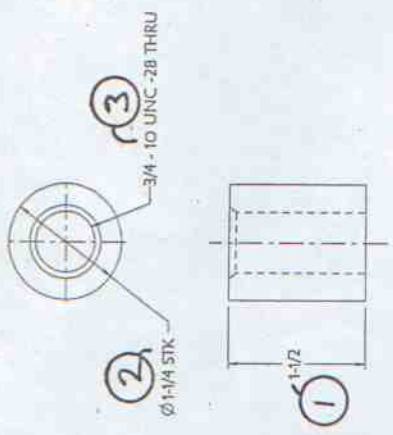
RELEASE LEVEL - Fabrication
DWG VERSION PAGE II

100-1001-331

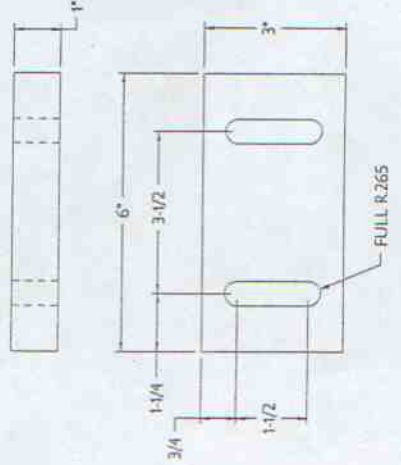
NO.	REVISION	BY	CHK	DATE



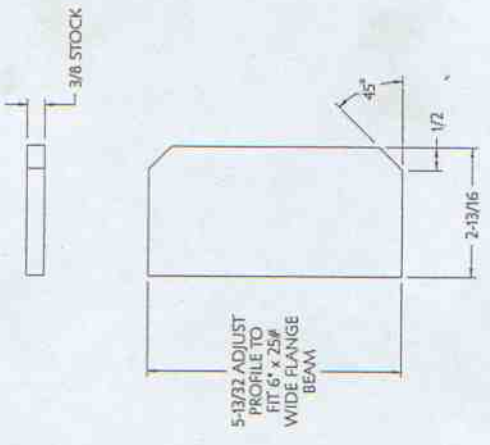
FLOOR BOLTING CLIP
MAKE FROM 3" X 2 1/2" ANGLE



CLAMPING THREADED BOSS
MAKE FROM 1 1/4" Ø STK.



STOP BLOCK
MAKE FROM 3 x 6 x 1" BAR.




SUPPORT GUSSET



20 days typical 25"

FOR NOTES AND BILL OF MATERIAL SEE SHEET 1

COMPANY REPORT DRAWING NO. 11C-90125-5128 DATE 02/18/2010 PROJECT TITLE SHEET NO. 4 DWG VERSION NO. 4	DRAWING NO. 11C-90125-5128 DATE 02/18/2010 PROJECT TITLE SHEET NO. 4 DWG VERSION NO. 4	PROJECT NATIONAL COMPACT VIBRATION LABORATORY NATIONAL COMPACT VIBRATION EQUIPMENT 100 LOG DESIGN AND FABRICATION WORK SUPPORT CASE NUMERICALS DETAILS DATE 02/18/2010 SHEET 2 OF 2
--	--	---

Vulcan Products Co., Inc. INSPECTION AND TEST REPORT

Drawing No.: SEE BELOW IN RPT. Rev.: 0		Part/Assembly Name: ANTI TIP CH. WELD'T		Spec/Standard No. & Name: N/A		Customer's Name: PPPL		Customer's PO/Contract No.: PE007982-W		Work Order/Job No.: 030326-018	
First Article: <input type="checkbox"/>	In-Process: <input type="checkbox"/>	Final: <input checked="" type="checkbox"/>	Receiving: <input type="checkbox"/>	Authorized by QA Manager: D. Barber		Lot-Qty.: 2		Total Qty Accepted: 1 Total Qty Rejected: 0		MRB <input type="checkbox"/> Rework <input type="checkbox"/>	
Sampling per MIL Std.105/ANSI-Z 1.4-1993 Yes <input type="checkbox"/> No <input checked="" type="checkbox"/> By Attributes: <input type="checkbox"/> By Variables: <input type="checkbox"/> Inspection Level: _____ AQL: _____ %						D1-8007 Sampling Plan Used? Yes <input type="checkbox"/> No <input checked="" type="checkbox"/> Type: _____		Engineering Change Order No.(ECO): N/A			
Advanced Drawing Change Notice (ADCN): RFD-18-004				Final Review by Q.A. Mgr./Chief Inspector: Accept: Yes <input checked="" type="checkbox"/> No: <input type="checkbox"/> Name: <i>D. Barber</i>  Date: 05-15-08							



Item No.:	Drawing or Test Characteristics:	Tolerance Limits:	Measurement Test Results:	Inspection/Test Instrument Used:	Measurement or Test Procedures:	Qty. Accepted:	Qty. Rejected:	I Stamp & Date:
SE186-332 ASSY – ANTI TIP CHANNEL WELD'T - #1								
1	(30)	N/A	30	TAPE	N/A	1	0	5/14/08
2	25	± 1/8	25	TAPE	N/A	1	0	5/14/08
2	25	± 1/8	25	TAPE	N/A	1	0	5/14/08
3	15	± 1/8	15	TAPE	N/A	1	0	5/14/08
3	15	± 1/8	15	TAPE	N/A	1	0	5/14/08
4	5	± 1/16	5	TAPE	N/A	1	0	5/14/08
4	5	± 1/16	5	TAPE	N/A	1	0	5/14/08
5	(4.7)	N/A	4.607	HEIGHT GAGE	N/A	1	0	5/14/08
6	(3)	N/A	3	TAPE	N/A	1	0	5/14/08
7	(13)	N/A	13	TAPE	N/A	1	0	5/14/08
8	(23)	N/A	23	TAPE	N/A	1	0	5/14/08
9	(7-1/2)	N/A	7.600	HEIGHT GAGE	N/A	1	0	5/14/08
10	SEE WELD REPORT	-----			N/A	1	0	5/14/08
								

Comments: (Refer to Item No.) _____

Drawing No.: SEE BELOW IN RPT. Rev.: 0	Part/Assembly Name: ANTI TIP CH. WELD'T	Spec/Standard No. & Name: N/A	Customer's Name: PPPL	Customer's PO/Contract No.: PE007982-W	Work Order/Job No.: 030326-018
--	--	----------------------------------	--------------------------	--	---

Item No.:	Drawing or Test Characteristics:	Tolerance Limits:	Measurement Test Results:	Inspection/Test Instrument Used:	Measurement or Test Procedures:	Qty. Accepted:	Qty. Rejected:	I Stamp & Date:
SE186-331-2 ANTI TIP CHANNEL								
1	5	± 1/16	5	TAPE	N/A	1	0	5/14/08
2	15	± 1/8	15	TAPE	N/A	1	0	5/14/08
3	30	± 1/8	30	TAPE	N/A	1	0	5/14/08
4	25	± 1/8	25	TAPE	N/A	1	0	5/14/08
5	Ø 7/8 THRU	± 1/16	Ø 7/8 THRU	TAPE	N/A	1	0	5/14/08
5	Ø 7/8 THRU	± 1/16	Ø 7/8 THRU	TAPE	N/A	1	0	5/14/08
5	Ø 7/8 THRU	± 1/16	Ø 7/8 THRU	TAPE	N/A	1	0	5/14/08
6	45° x .060	± 0°-15' x .010	MISSING	N/A	N/A	0	1	5/14/08
6	45° x .060	± 0°-15' x .010	MISSING	N/A	N/A	0	1	5/14/08
6	45° x .060	± 0°-15' x .010	MISSING	N/A	N/A	0	1	5/14/08
7	1-3/8	± 1/16	1-3/8	TAPE	N/A	1	0	5/14/08
7	1-3/8	± 1/16	1-3/8	TAPE	N/A	1	0	5/14/08
7	1-3/8	± 1/16	1-3/8	TAPE	N/A	1	0	5/14/08
8	(6)	N/A	6	TAPE	N/A	1	0	5/14/08
SE186-331-3 – FLOOR BOLTING CLIP #1								
1	2	± 1/16	2	TAPE	N/A	1	0	5/14/08
2	4	± 1/16	4	TAPE	N/A	1	0	5/14/08
3	1-3/8	± 1/16	1-3/8	TAPE	N/A	1	0	5/14/08
4	Ø 1/2 THRU	± 1/16	Ø 1/2	TAPE	N/A	1	0	5/14/08
5	3"	± 1/16	3	TAPE	N/A	1	0	5/14/08
6	(2-1/2)	N/A	2-1/2	TAPE	N/A	1	0	5/14/08

Drawing No.: SEE BELOW IN RPT. Rev.: 0	Part/Assembly Name: ANTI TIP CH. WELD'T	Spec/Standard No. & Name: N/A	Customer's Name: PPPL	Customer's PO/Contract No.: PE007982-W	Work Order/Job No.: 030326-018
---	--	----------------------------------	---------------------------------	---	--

Item No.:	Drawing or Test Characteristics:	Tolerance Limits:	Measurement Test Results:	Inspection/Test Instrument Used:	Measurement or Test Procedures:	Qty. Accepted:	Qty. Rejected:	I Stamp & Date:
SE186-331-2 ANTI TIP CHANNEL								
1	5	± 1/16	5	TAPE	N/A	1	0	5/14/08
2	15	± 1/8	15	TAPE	N/A	1	0	5/14/08
3	30	± 1/8	30	TAPE	N/A	1	0	5/14/08
4	25	± 1/8	25	TAPE	N/A	1	0	5/14/08
5	Ø 7/8 THRU	± 1/16	Ø 7/8	TAPE	N/A	1	0	5/14/08
5	Ø 7/8 THRU	± 1/16	Ø 7/8	TAPE	N/A	1	0	5/14/08
5	Ø 7/8 THRU	± 1/16	Ø 7/8	TAPE	N/A	1	0	5/14/08
6	45° x .060	± 0°-15' x .010	MISSING	N/A	N/A	0	1	5/14/08
6	45° x .060	± 0°-15' x .010	MISSING	N/A	N/A	0	1	5/14/08
6	45° x .060	± 0°-15' x .010	MISSING	N/A	N/A	0	1	5/14/08
7	1-3/8	± 1/16	1-3/8	TAPE	N/A	1	0	5/14/08
7	1-3/8	± 1/16	1-3/8	TAPE	N/A	1	0	5/14/08
7	1-3/8	± 1/16	1-3/8	TAPE	N/A	1	0	5/14/08
8	(6)	N/A	6	TAPE	N/A	1	0	5/14/08
								
SE186-331-3 – FLOOR BOLTING CLIP #1								
1	2	± 1/16	2	TAPE	N/A	1	0	5/14/08
2	4	± 1/16	4	TAPE	N/A	1	0	5/14/08
3	1-3/8	± 1/16	1-3/8	BOLT	N/A	1	0	5/14/08
4	Ø 1/2 THRU	± 1/16	Ø 1/2	TAPE	N/A	1	0	5/14/08
5	3"	± 1/16	3	TAPE	N/A	1	0	5/14/08
6	(2-1/2)	N/A	2-1/2	BOLT	N/A	1	0	5/14/08

