

**Status** 9 - Closed NCR **Trend** 07-Out Of Tolerance  
**Department** NCSX **Division** NCSX Field Period Assembly  
**Source/Org** VENDOR  
**Item Dwg/Part#** SE120-005 Rev. 0 **Procurement #** S005243-F **Cost Center** \_\_\_\_\_  
**RAP#** 3245 **Job Doc #** S005243-F **Vendor** MAJOR TOOL AND MACHINE, INC.  
**RAP Title** Vacuum Vessel Subassembly Component Receipt Inspection

HoldTag Applied

**Nonconforming Condition (include requirement(s) violated):**

VVSA-3, The following ports have dimensions that are beyond the allowable tolerance on the drawing.

- Port 8A - drawing calls for an overall length of 17.06" +/- 0.13" - port measures 17.38"
- Port 9B - drawing calls for an overall length of 23.78" +/- 0.13" - part measures 23.56"
- Port 11A - drawing calls for an overall length of 20.77" +/- 0.13" - part measures 21.31"

The measurement above is from the face of the conflat flange to the back edge of the backing/alignment collar, though this is not the best dimension to use it the only length dimension found for the ports.

**Lot Size Recd** 0 **Sample Size Insp** 0  Lot Rejected **# Rejected** 0  
**Reported By** Phelps C **Validated By** Malinowski F **Validated Date** 11/02/06

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

Similar to NCR 3670  
Dimension indicates that the collar is higher but the port length is acceptable.

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

<b>#Hours</b> _____	<b>\$Est Labor</b> _____	<b>\$G&amp;A</b> _____
<b>\$Material</b> _____	<b>\$Burden</b> _____	<b>\$Total</b> _____

  

<b>Disposition By</b> <u>Viola M</u>	<b>Date</b> <u>12/01/06</u>
<b>Supervisor's Concur</b> <u>Nelson B</u>	<b>Date</b> <u>12/06/06</u>
<b>Eng. Dept. Head Concur</b> <u>Williams m</u>	<b>Date</b> <u>12/07/06</u>
<b>WCO/Other</b> <u>N/A</u>	<b>Date</b> _____

  

<b>PQA/QC Mgr Dispos Concur</b> <u>Malinowski F</u>	<b>Date</b> <u>12/07/06</u>
<b>QC Field Verification By</b> <u>N/A</u>	<b>Date</b> _____

**Distribution**

**Cog** M. Viola  
**Insp** Phelps C  
 Proj. Doc Control (when closed)  
 QC Files  
 Malsbury J  
 Boscoe J  
 Malinowski F  
 Edwards J  
 Nelson B  
 Reiersen W  
 Williams M  
 Tyrrell M