


**Status** 5 - Corrective Action Needed **Trend** 07-Out Of Tolerance  
**Department** NCSX **Division** NCSX Project  
**Source/Org** VENDOR  
**Item Dwg/Part#** NCSX-CSPEC-121-02-06 **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-1, The attached items were found to have a magnetic permeability greater than the 1.02 Mu maximum allowed by NCSX-CSPEC-121-02-06, par. 3.2.4.  
 Rev, 1 replaces ASPEC reference with CSPEC reference and clarifies the attachment. 

**Lot Size Recd** 0 **Sample Size Insp** 0  Lot Rejected **# Rejected** 0  
**Reported By** Phelps C **Validated By** Boscoe J **Validated Date** 07/05/06

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

Port 4B Cover, 4A Flange, 4A Cover, 12A Cover, and 12B Cover, are acceptable as is per Art Brooks Thu 9/7/2006 4:30 PM attached.   
 All flange hardware permeability shall be less than 1.02μ; however, due to the distance of ports 6A, 6B, 10A, 10B, and 11A from the magnetic fields, permeability values may be accepted up to 1.09μ for these ports only. Hardware listed for these 5 ports that have permeability values that exceed 1.09μ are rejected per Art Brooks Fri 9/8/2006 8:37 AM. "For port 6A, 6B, 10A, 10B, and 11A hardware, accept only those less than 1.09μ, which are comparable to the cover plates which we are accepting." This hardware shall be saved for use on the outboard port extensions being added in the future. Port 11A hardware is acceptable; however, new hardware must be purchased for the 6A, 6B, 10A, and 10B port locations. 384 pieces of .312-24 x 2.00" lg. hex head bolts with nuts and flat washers are required which conform to NCSX-CSPEC-121-02-06 paragraph 3.3.2.6 Bolts.

**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> <u>\$4000</u>	
<b>Disposition By</b>	<u>Viola M</u>	<b>Date</b>	<u>09/20/06</u>
<b>Supervisor's Concur</b>	<u>Dudek L</u>	<b>Date</b>	<u>09/21/06</u>
<b>Eng. Dept. Head Concur</b>	<u>Williams M</u>	<b>Date</b>	<u>09/20/06</u>
<b>WCO/Other</b>	<u>Nelson B (RI M)</u>	<b>Date</b>	<u>09/22/06</u>
<b>PQA/QC Mgr Dispos Concur</b>	<u>Malinowski F</u>	<b>Date</b>	<u>10/02/06</u>
<b>QC Field Verification By</b>	_____	<b>Date</b>	_____

**Distribution**

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