

Status 5 - Corrective Action Needed Trend 01-Deviation From Doc/Proc
 Department NCSX Division NCSX Project
 Source/Org FABRICATION, OPERATIONS & MAINTENANCE
 Item Dwg/Part# SE142C-270 Rev. 0 Procurement # D-NCSX-MCF-004 Cost Center _____
 RAP# 3234 Job Doc # D-NCSX-MCF-004 Vendor VARIOUS
 RAP Title Modular Coil Fabrication - Post VPI Activities

HoldTag Applied

Nonconforming Condition (include requirement(s) violated):

The first shipment of NCSX modular coil final winding clamp assemblies, and related purchased hardware exhibits a magnetic permeability higher than the maximum allowed per NCSX-ASPEC-GRD-03 paragraph 3.3.1.1 (permeability shall not exceed 1.02). Unless otherwise noted all material is type 316 stainless steel See attached list for details.

REV 1: Parts 3 and 6 are silverplated and were verbally reported as not being able to be annealed without damage.

SEE PAGE 2 FOR ADDITIONAL REVISIONS.

Lot Size Recd 0 Sample Size Insp 0 Lot Rejected # Rejected 0
 Reported By Phelps C Validated By Boscoe J Validated Date 03/10/06

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

(Rev 0) Rework by removing permeability using vacuum oven cycle 800-1000 deg. C @ 1 hour. (Labor = 40 hours)
 (Rev 1) Awaiting test results from outside laboratory to determine whether the permeability of the 316ss parts can be used "as is" without further work.

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

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

Disposition By <u>Chrzanowski J</u>	Date <u>09/06/06</u>
Supervisor's Concur <u>Dudek L</u>	Date <u>09/06/06</u>
Eng. Dept. Head Concur <u>Williams M</u>	Date <u>09/06/06</u>
WCO/Other <u>N/A</u>	Date _____

PQA/QC Mgr Dispos Concur <u>Boscoe J</u>	Date <u>09/06/06</u>
QC Field Verification By _____	Date _____

Distribution
 Cog J. Chrzanowski
 Insp C. Phelps
 Proj. Doc Control (when closed)
 QC Files
 Malsbury J
 Boscoe J
 T. Meighan
 Williams M
 Dudek L
 Tyrrell M
 Heitzenroeder P
 Reiersen W

<u>Part #</u>	<u>Part Type</u>	<u>Quantity</u>	<u>Sample Size</u>	<u>Results</u>
2	Bar, Clamp	175	21	(12) >1.10, <1.15 (4) >1.15, <1.2 (5) >1.2, <1.8
3	Bushing Spacer (Silver Plated 316)	1	1	(1) >1.06, <1.08
4	Washer, Convex	1610	100	(40) <1.02 (60) >1.02, <1.03
5	Washer, Concave	1610	100	(6) >1.02, <1.03 (9) >1.03, <1.04 (30) >1.04, <1.05 (30) >1.05, <1.06 (25) >1.06, <1.08
6	Keeper Screw (Silver Plated 316)	4	4	(1) >1.02, <1.03 (1) >1.03, <1.04 (2) >1.04, <1.05
7	Clamp Swivel	1	1	(1) >1.03, <1.04
10	3/8-16 x 1 ¼ SH	882	44	(41) >1.02, <1.03 (3) <1.02
11	3/8 x 3/8 shoulder	188	20	(1) >1.02, <1.03 (1) >1.03, <1.04 (3) >1.04, <1.05 (6) >1.05, <1.06 (6) >1.06, <1.08 (3) >1.08, <1.09

The following parts were found to be acceptable.

<u>Part #</u>	<u>Part Type</u>	<u>Quantity</u>	<u>Sample Size</u>	<u>Results</u>
8	Belleville Washers	~10,000	~200	(~200) <1.02 (Inconel)
12	¼-20 x ½ BH	1850	100	(100) <1.02