

PPPL NONCONFORMANCE REPORT NO: 3645 **Open Date 03/31/06**

Status	9 - Closed NCR		Trend	01-Deviation From Doc/Proc	
Department	NCSX		Division	NCSX Project	
Source/Org	VENDOR				
Item Dwg/Part#	NCSX-CSPEC-141-03-11	Procurement #	S005242-F	Cost Center	9450 1*** 1404
RAP#	3209	Job Doc #	S005242-F	Vendor	Energy Industries of Ohio
RAP Title	NCSX - Modular Coil Winding Forms				

HoldTag Applied

Nonconforming Condition (include requirement(s) violated):

MCWF-C4, During the magnetic permeability verification of the NCSX C4 modular coil winding form a total of fifty seven (57) areas were found to exhibit a permeability above the maximum allowed. NCSX-CSPEC-141-03-11 paragraph 3.1.1.5.1 states "the local relative magnetic permeability of any point in the winding form (including base metal and weld repairs) shall not exceed 1.02." All of these areas found are on the as cast surface and appear to fit into one of four characterizations below.

1. Oxidized, rusted appearance in the form of a scrape or a ding, see areas 1, 2, 7, 9, 10, 11, 12, 27, 28, 29.
2. A shiny smear or scrape where the foreign material can be seen flaking up from the surface. These areas are very similar to what was seen on the B1 casting at Major Tool on 3/23/06. See areas 30, 31, 32.
3. Dark areas that have the appearance of lead or dark substance smeared on the surface, see areas 26, 56.
4. Pock mark impressions in the as cast surface with no distinct color variation, see areas 8, 14, 15, 50, 51, 52, 53.

A picture of each area is attached.

Lot Size Recd	0	Sample Size Insp	0	<input type="checkbox"/> Lot Rejected	# Rejected	0
Reported By	Phelps C	Validated By	Malinowski F	Validated Date	03/31/06	

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

These higher permeability areas will be handled by surface grinding to remove the questionable material. Areas will then be rechecked to verify acceptable reading.

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

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

Disposition By	Chrzanowski J	Date	04/12/06
Supervisor's Concur	Dudek L	Date	04/12/06
Eng. Dept. Head Concur	Williams M	Date	05/04/06
WCO/Other	N/A	Date	_____

PQA/QC Mgr Dispos Concur	Boscoe J	Date	05/04/06
QC Field Verification By	Phelps C	Date	05/04/06

Distribution

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