# PPPL NONCONFORMANCE REPORT NO:   3694   Open Date   01/04/07

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|---|---|---|---|
| **Status** | 9  - Closed NCR | **Trend** | 07-Out Of Tolerance |
| **Department** | NCSX | **Division** | NCSX Project |
| **Source/Org** | FABRICATION, OPERATIONS & MAINTENANCE | | |

**Item Dwg/Part#**  N/A     **Procurement #**  D-NCSX-MCF-004     **Cost Center**

**RAP#**  3234     **Job Doc #**  D-NCSX-MCF-004     **Vendor**

**RAP Title**  Modular Coil Fabrication - Post VPI Activities

☐ HoldTag Applied

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

MCWF-C5,  On the C5 NCSX modular coil five (5) of the twelve (12) liquid nitrogen cooling tubes are in electrical contact with the casting/winding form.  Paragraph 6.14.1 of procedure D-NCSX-MCF-004-02 states "Verify that cooling tubes are electrically isolated from all other cooling tubes and from the modular coil winding form using a multi-meter."  The cooling tubes found to be in contact with the winding form are listed below, tubes not listed were determined to be electrically isolated from the winding form.  These tubes were found during post VPI operations, all of the cooling tubes were verified as isolated from the winding form prior to VPI operations.

Side A - Zone 3 - Inner - 0.3 ohms
Side B - Zone 1 - Inner - 1.36 ohms
Side B - Zone 1 - Outer - 1.26 ohms
Side B - Zone 2 - Inner - 3.56 ohms
Side B - Zone 3 - Outer - 0.16 ohm

**Lot Size Recd**  0     **Sample Size Insp**  0     ☐ Lot Rejected     **# Rejected**  0

**Reported By**  Phelps C     **Validated By**  Boscoe J     **Validated Date**  01/04/07

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

Since the coil has already been potted [VPI] repairs cannot be made to correct these cooling tube shorts.  Some shifting of the chill plates must occur during the installation of the mold and VPI process to cause this change.  Shorts similar to these were accepted or earlier coils [example: NCR 3647 & 3654]

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**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** | 02/26/07 |
| **Supervisor's Concur** | Dudek L | **Date** | 02/26/07 |
| **Eng. Dept. Head Concur** | Williams M | **Date** | 02/26/07 |
| **WCO/Other** | N/A | **Date** | |

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|---|---|---|---|
| **PQA/QC Mgr Dispos Concur** | Boscoe J | **Date** | 03/06/07 |
| **QC Field Verification By** | N/A | **Date** | |

09/01