

# ANL LCLS Nonconformance Status Report 12/20/2007

The purpose of this report is to inform LCLS Project Management of the status of nonconformance issue. This report was generated by ANL LCLS QA Coordinator Tom Barsz using the ANL LCLS QA Database.

**System:** Vacuum      **Subsystem:** Chamber Support      **Item Name or Description:** Tubing Support Assy      **Drawing or Part No:** L1440202-10010      **Rev or Date:**

**Report or Ref number:** SDR 7A-08156-0      **Tracking NO:** 518

**Issue Type:**     **Nonconformance Issue**       **Deviation Request**       **Corrective Action Request**

**Person reporting:** M. Vejvoda      **Reporting Organization:** Walco Tool      **Date reported:** 12/10/2007

**Issue :** *Part measures 76.204/76.422, .022 mm oversize. Walco is requesting to open the tolerance on the 76.2 dimension to a one place decimal or callout as material stock size.*

*Note: This issue can be closed by providing a resolution using the lines below and returning to Tom Barsz, B401, B4192*

**Resolution:**    Drawing will be revised as requested

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**Disposition by:** S. Lee      **Disposition date:** 12/11/2007

**Issue Status:** Open      **Followup owner:** Lee, Soon-Hong

**Follow up required:** SDR Dispositon

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**System:** Vacuum      **Subsystem:** Chamber Support      **Item Name or Description:** Tubing Support Assy      **Drawing or Part No:** L1440202-10020      **Rev or Date:**

**Report or Ref number:** SDR 7A-08156-0      **Tracking NO:** 517

**Issue Type:**     **Nonconformance Issue**       **Deviation Request**       **Corrective Action Request**

**Person reporting:** M. Vejvoda      **Reporting Organization:** Walco Tool      **Date reported:** 12/10/2007

**Issue :** *Walco is request to open the tolerance on the top view centerline tolerances to a one place decimal .0. The bottom view centerline can be reduced to a two place decimal .00.*

*Note: This issue can be closed by providing a resolution using the lines below and returning to Tom Barsz, B401, B4192*

**Resolution:**    Drawing will be revised as requested

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**Disposition by:** S. Lee      **Disposition date:** 12/11/2007

**Issue Status:** Open      **Followup owner:** Lee, Soon-Hong

**Follow up required:** SDR Dispositon

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**System:** Vacuum      **Subsystem:** Vacuum Chamber      **Item Name or Description:** Aluminum Vacuum Chamber      **Drawing or Part No:**      **Rev or Date:**

**Report or Ref number:** 8A-00222-0      **Tracking NO:** 506

**Issue Type:**     **Nonconformance Issue**       **Deviation Request**       **Corrective Action Request**

**Person reporting:** D. Fulcher      **Reporting Organization:**      **Date reported:** 11/19/2007

**Issue :** Unable to provide a Program Schedule

*Note: This issue can be closed by providing a resolution using the lines below and returning to Tom Barsz, B401, B4192*

**Resolution:**

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**Disposition by:**      **Disposition date:**

**Issue Status:** Open      **Followup owner:** Engineering Finishing Corp

**Follow up required:** Submit production schedule following 1st Article Acceptance

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**System:** Undulator      **Subsystem:** Pedestals      **Item Name or Description:** Pedestal Interface Plate      **Drawing or Part No:**      **Rev or Date:**

**Report or Ref number:**      **Tracking NO:** 514

**Issue Type:**     Nonconformance Issue       Deviation Request       Corrective Action Request

**Person reporting:** D. Schafer      **Reporting Organization:**      **Date reported:** 11/20/2007

**Issue :** *In the bolt pattern to mount the Cam Mover on the Pedestal Interface Plate, one of the holes only has approx. 1 thread, due to a larger threaded hole from the underside of plate. The hole is on the Single Cam side of the Double Cam Interface plate.*

**Note:** *This issue can be closed by providing a resolution using the lines below and returning to Tom Barsz, B401, B4192*

**Resolution:** Taking into account that the whole load is downwards, 3 holes will be sufficient to attach the cam shaft movers. (G. Pile thinks insert plate should be added.)

**Disposition by:** E. Trakhtenberg      **Disposition date:** 11/27/2007

**Issue Status:** Open      **Followup owner:** Trakhtenberg, Emil

**Follow up required:** G. Pile thinks insert plates should be provided.

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**System:** Undulator      **Subsystem:** Pedestals      **Item Name or Description:** Und Assy Mfg Label      **Drawing or Part No:**      **Rev or Date:**

**Report or Ref number:**      **Tracking NO:** 513

**Issue Type:**     Nonconformance Issue       Deviation Request       Corrective Action Request

**Person reporting:** C. Rago      **Reporting Organization:**      **Date reported:** 11/1/2007

**Issue :** 1 manufacturer has applied adhesive label on filed side of assy that interferes with tuning.

*Note: This issue can be closed by providing a resolution using the lines below and returning to Tom Barsz, B401, B4192*

**Resolution:** Remove and clean

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**Disposition by:**      **Disposition date:**

**Issue Status:** Open      **Followup owner:** Trakhtenberg, Emil

**Follow up required:** Provide improved control on label location on future pedestals. Determine wich manufacter chose this label location. Provide Engineering signature on SLAC QA Report.

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**System:** Undulator      **Subsystem:** Support Mover      **Item Name or Description:** Positioning Stages      **Drawing or Part No:** 206821, Rev.F      **Rev or Date:**

**Report or Ref number:**      **Tracking NO:** 512

**Issue Type:**     Nonconformance Issue       Deviation Request       Corrective Action Request

**Person reporting:** E. Trakhtenberg      **Reporting Organization:**      **Date reported:** 12/13/2007

**Issue :**

(1) The .343" diameter thru holes located on the bottoms of the stages were measured to be .313"  
(2) The slide heights do not meet the 2.960 +/- .001" requirement specified in the drawing.  
(3) The slides are not flat and must be bolted to a specially designed and manufactured flat metal plate to permit accurate inspection of the 2.960 +/- .001" dimension.

**Note:** *This issue can be closed by providing a resolution using the lines below and returning to Tom Barsz, B401, B4192*

**Resolution:** Accept as is in order to meet project schedule. Have the .313" holes reworked by Support Mover Assembly Contractor prior to assembly. Inspect the remaining stages for the same condition. IMAC to consider providing ANL with monetary compensation for the cost of inspecting the hole size and stage height, and for fabrication the special inspection fixture.

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**Disposition by:** E. Trakhtenberg      **Disposition date:** 12/13/2007

**Issue Status:** Open      **Followup owner:** IMAC

**Follow up required:** Cause and corrective action identification.

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**System:** Undulator      **Subsystem:** Support Mover      **Item Name or Description:** 003 Girder Assy Grease      **Drawing or Part No:**      **Rev or Date:**

**Report or Ref number:**      **Tracking NO:** 509

**Issue Type:**     Nonconformance Issue       Deviation Request       Corrective Action Request

**Person reporting:** C. Rago      **Reporting Organization:**      **Date reported:** 12/6/2007

**Issue :** Protective Grease was found under both slides.

*Note: This issue can be closed by providing a resolution using the lines below and returning to Tom Barsz, B401, B4192*

**Resolution:** Document, clean/sove surface and reinstall slide assy.  
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**Disposition by:**      **Disposition date:**

**Issue Status:** Open      **Followup owner:** Trakhtenberg, Emil

**Follow up required:** Provide Engineering signature of SLAC QA Report.

# ANL LCLS Nonconformance Status Report 12/20/2007

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**System:** Undulator      **Subsystem:** Support Mover      **Item Name or Description:** Positioning Stages      **Drawing or Part No:** 206821, Rev.F      **Rev or Date:**

**Report or Ref number:**      **Tracking NO:** 511

**Issue Type:**     Nonconformance Issue       Deviation Request       Corrective Action Request

**Person reporting:** E. Trakhtenberg      **Reporting Organization:**      **Date reported:** 11/30/2007

**Issue :** *Emil Trakhtenberg (APS), Simon Sorsher ("Hi-Tech"), Dave Montesano (IMAC) and Greg Wolf ("LinTech") have inspected together 15 translation stages delivered by "LinTech" namely the stage height which should be according to the drawing 2.960±.001.*

*We inspected stages bolting them to the specially designed 1" thick plate made of steel with the flatness better then 5 microns. From 15 inspected stages 9 were out of the specification and will be returned to "LinTech" for the correction and new inspection.*

*It was the second inspection. The same translation stages were inspected 2 days earlier. Both times the results were identical.*

*Everybody agreed that it is the right way to inspect the translation stages. We hope that the next delivery from "LinTech" will have no such surprises, but nevertheless I have requested "Hi-Tech" to inspect each slide before assembly.*

**Note:** *This issue can be closed by providing a resolution using the lines below and returning to Tom Barsz, B401, B4192*

**Resolution:** Return 9 Stages to "LinTech" for correction and re- inspection. "Hi-Tech" to inspect each slide before assembly.

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**Disposition by:** E. Trakhtenberg      **Disposition date:** 11/30/2007

**Issue Status:** Open      **Followup owner:** IMAC

**Follow up required:** Cause and corrective action identification

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**System:** Undulator      **Subsystem:** Support Mover      **Item Name or Description:** M8 Cap Screw - SS      **Drawing or Part No:**      **Rev or Date:**

**Report or Ref number:**      **Tracking NO:** 508

**Issue Type:**     Nonconformance Issue       Deviation Request       Corrective Action Request

**Person reporting:** C. Rago      **Reporting Organization:**      **Date reported:** 10/2/2007

**Issue :** Bolt failure during tune, Repeat occurance. Und Assy #37

*Note: This issue can be closed by providing a resolution using the lines below and returning to Tom Barsz, B401, B4192*

**Resolution:** Magnet Base to Strong Back Bolts.  
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**Disposition by:**      **Disposition date:**

**Issue Status:** Open      **Followup owner:** Marsh, Darren.

**Follow up required:** Does ANL have to respond to this issue? It seems like the disposition has already been performed by SLAC.

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**System:** Diagnostics      **Subsystem:** Beam Finder Wire      **Item Name or Description:** Shaft Plate Weldment      **Drawing or Part No:** L14506-103110      **Rev or Date:**

**Report or Ref number:**      **Tracking NO:** 499

**Issue Type:**     Nonconformance Issue       Deviation Request       Corrective Action Request

**Person reporting:** J. Bailey      **Reporting Organization:**      **Date reported:** 9/5/2007

**Issue :**

- (1) The supplier reported that the acceptance dimensions were verified with the flange in the restrained condition. ASME Y14.5M-1994 section 1.4(l) requires tolerances to be applied in the free state.
- (2) The supplier reported the flatness of the sealing flange was within .001" but when the flange is un-restrained the flatness is .009".
- (3) The supplier First Article Report indicates that .002" Diametrical Position of the (2) 4.765mm holes is .0046/.0060".
- (4) The supplier First Article Report indicates that .002" Diametrical Position of the (2) 6.337mm holes is .0020/.0040".
- (5) The supplier reported that one of the electrical feedthroughs failed leak testing and may be replaced.
- (6) The supplier did not report the out-of-tolerance conditions using an ANL-311 form as required by section 4.18 of the ANL -407 form.
- (7) The supplier did not report the out of tolerance conditions to LCLS QA Rep. as required by the purchase order.

**Note:** This issue can be closed by providing a resolution using the lines below and returning to Tom Barsz, B401, B4192

**Resolution:**

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**Disposition by:**      **Disposition date:**

**Issue Status:** Open      **Followup owner:** Bailey, James L.

**Follow up required:** Report status to T. Barsz

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**System:** Diagnostics      **Subsystem:** Beam Finder Wire      **Item Name or Description:** Shaft Frame Weldment      **Drawing or Part No:** L14506-00050      **Rev or Date:**

**Report or Ref number:**      **Tracking NO:** 500

**Issue Type:**     Nonconformance Issue       Deviation Request       Corrective Action Request

**Person reporting:** T. Barsz      **Reporting Organization:**      **Date reported:** 5/11/2007

**Issue :** (1) The supplier did not submit a copy of their QA Manual plan as required by section 4.1 of the ANL-407 form.  
(2) The supplier did not submit copies of their Process Sheets/Travelers and required by section 4.5 of the ANL-407 fom.

*Note: This issue can be closed by providing a resolution using the lines below and returning to Tom Barsz, B401, B4192*

**Resolution:**

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**Disposition by:**      **Disposition date:**

**Issue Status:** Open      **Followup owner:** Bailey, James L.

**Follow up required:** Report status of supplier ANL-407 deliverable to T. Barsz

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**System:** Diagnostics      **Subsystem:** RFBPM      **Item Name or Description:** RF Windows      **Drawing or Part No:** MA1332, Rev.C      **Rev or Date:**

**Report or Ref number:**      **Tracking NO:** 510

**Issue Type:**     Nonconformance Issue       Deviation Request       Corrective Action Request

**Person reporting:** L. Morrison      **Reporting Organization:** AES      **Date reported:** 12/11/2007

**Issue :** (1)The dimensions of 8 Window were found to be undersize. (see attached report)  
(2) Blisters were observed on the surface of the nickel plating of 3 Windows after they were heated to 450 degees Centigrade. (see attached report)  
(3) Plating pull back was observed on 2 Windows after they were heated to 450 degees Centigrade. (see attached report)  
(4) Serial No. 87 cracked??

**Note:** *This issue can be closed by providing a resolution using the lines below and returning to Tom Barsz, B401, B4192*

**Resolution:** Reject 5 windows for blistering and pull back issues and return to the supplier for replacement. Return all unused windows to the supplier for sintering. Accept the undersize windows and match with mating part. Report conconformance to the supplier for replacement windows and cause and corrective action identification in accordance with its ISO 9001 procedures. ANL to oerform dimensonal inspection of all incoming windows for size and flatness.

**Disposition by:** L. Morrison      **Disposition date:**

**Issue Status:** Open      **Followup owner:** Morrison, Leonard H.

**Follow up required:** Revise NCR report as appropriate and return to Tom Barsz so he can send it to CPI for cause and corrective action identification.

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**System:** Diagnostics      **Subsystem:** Short Break      **Item Name or Description:** CeFIX Aluminum Gaskets      **Drawing or Part No:** 34.663.105      **Rev or Date:**

**Report or Ref number:**      **Tracking NO:** 501

**Issue Type:**     Nonconformance Issue       Deviation Request       Corrective Action Request

**Person reporting:** W. Berg      **Reporting Organization:**      **Date reported:** 9/23/2007

**Issue :**

Unable to obtain a vaccum seal after tightening to manufacturer's torque specifications.

**Note:** *This issue can be closed by providing a resolution using the lines below and returning to Tom Barsz, B401, B4192*

**Resolution:**

Reject entire lot for replacement parts and Request supplier to provide a documented cause and corrective action evaluation. Perform dimensional inspection on other Evac Flanges and Gaskets to evaluate if there may be a systematic problem with Evac components. Perform receipt inspection on future Evac orders to ensure the components meet specifications. Evaluate potential impact on LCLS BFW and Aluminum Vacuum Chamber, rf bpms and drift vacuum bellows procurements. Evaluate applicability of reporting this incident to the D.O.E. Lessons Learned Database so that other DOE facilities will aware of this problem.

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**Disposition by:** D. Walters      **Disposition date:** 10/3/2007

**Issue Status:** Open      **Followup owner:** Barsz, Thomas R.

**Follow up required:** Provide summary section of EVAC supplier evaluation form.