

## *DR's for Serial #*    **QXFA220**

<i>DR</i>	<i>Description</i>	<i>Status</i>	<i>Disp.</i>	<i>Action Req</i>	<i>Closed Date</i>
AM-187	Discovered metal chip protruding from threaded hole in L1 centerpost 2nd from LE	F	RWK	1/29/2021	1/29/2021
AM-189	Loose wire strand exists during winding of layer 2	F	RWK	1/26/2021	6/14/2021
AM-190	Strands out of register in turn 3, layer 2	F	RWK	1/29/2021	1/29/2021
AM-191	Chaffing in layer 2 coil insulation	F	RWK	2/26/2021	6/1/2021
AM-195	Short to pole. Coil exhibits discoloration in area of short	F	RPR	5/5/2021	6/1/2021

# MAGNET DISREPAANCY REPORT

DR NUMBER: AM-187

Preliminary: 12/9/20  
 Action Required: 1/29/21  
 Final: 1/29/21

Part No: F10115641	Rev B	Traveler No.: AUP - 110	Rev: E
Part Name: QXFA COIL ASSEMBLY		Traveler OP No.: 1240	
Qty: 1	Ser. No./Lot No.: QXFA 220	Operation: Layer 1 Winding	
Initiator: Glenn Jochen		Life No.: 15764	Date: 12/09/2020
Type of Problem: (Check) Mechanical <input checked="" type="checkbox"/> Electrical <input type="checkbox"/> Other <input type="checkbox"/>			

Description	Disposition <small>RWK, RPR, UAI, SCP</small>	CE	DQAR
Continue on reverse side if required			
Discovered metal chip protruding from a metric threaded hole in the L1 centerpost second from the lead end. The threaded hole is ~31-1/4" from the lead end splice block. One of the chips (long & thin) are ferrous.	RWK	<i>[Signature]</i>	<i>[Signature]</i>
The other two are not affected by the magnet.			

Instructions: Continue on additional sheets if required	Name	Life #	Date
Taped off surrounding coil turns and carefully removed the chip from the threaded hole. Captured the chip pieces with adhesive side of masking tape	<i>[Signature]</i>	15764	

Reason for Discrepancy: PART AS RECEIVED

Corrective Action: NOTIFIED AUP PROGRAM OFFICE

Report reviewed by CE *[Signature]* Date 1/29/21  
 DQAR *[Signature]* Date \_\_\_\_\_

Distribution:  
 Magnet Traveler Section Head, Electrical Systems  
 Section Head, Production Engineering  
 DQAR Cognizant Engineer *[Signature]*  
 Distributed by *[Signature]*  
 Date: 1/29/21

**MAGNET DISREPAncy REPORT  
(Continuation)**

Sketch:

Instructions:	Name	Life #	Date



# MAGNET DISREPAANCY REPORT

DR NUMBER: AM-189

Preliminary: 1-15-20  
 Action Required: 1-29-21  
 Final: 6/14/21

Part No: F10115641	Rev B	Traveler No.: AUP - 130	Rev: E	
Part Name: QXFA COIL ASSEMBLY		Traveler OP No.: 820		
Qty: 1	Ser. No./Lot No.: QXFA 220	Operation: Layer 2 Winding		
Initiator: Glenn Jochen		Life No.: 15764	Date: 01/13/2021	
Type of Problem: (Check) Mechanical <input checked="" type="checkbox"/> Electrical <input type="checkbox"/> Other <input type="checkbox"/>				
Description		Disposition <small>RWK, RPR, UAI, SCP</small>	CE	DQAR
Continue on reverse side if required				
Through out the winding of Layer 2 the cable had a loose wire strand that at times required manipulation back into cable register		ewk UAI	JJ	MB
Instructions: Continue on additional sheets if required		Name	Life #	Date
USE FINGER PRESSURE OR WINDING TOOL TO PUSH STRANDS BACK INTO PLACE AS NEEDED WHILE WINDING.		JJ	15764	6/14/21
Reason for Discrepancy:				
ONGOING ISSUE				
Corrective Action:				
MONITOR with AUP PROGRAM OFFICE				
Report reviewed by CE <u>J. Schmalz/E</u>		Date <u>1/29/21</u>		
DQAR <u>[Signature]</u>		Date _____		

**Distribution:**  
 Magnet Traveler Section Head, Electrical Systems  
 Section Head, Production Engineering

DQAR Cognizant Engineer Schmalz/E

Distributed by [Signature]  
 Date: 1-15-21

# MAGNET DISREPANCY REPORT (Continuation)

Sketch:

Instructions:	Name	Life #	Date

# MAGNET DISREPARANCY REPORT

DR NUMBER: AM-190

Preliminary: 1-15-20  
 Action Required: 1-29-21  
 Final: 1-29-21

Part No: F10115641		Rev B	Traveler No.: AUP - 130	Rev: E	
Part Name: QXFA COIL ASSEMBLY			Traveler OP No.: 610		
Qty: 1	Ser. No./Lot No.: QXFA 220		Operation: Layer 2 Winding		
Initiator: Glenn Jochen		Life No.: 15764	Date: 01/13/2021		
Type of Problem: (Check) Mechanical <input checked="" type="checkbox"/> Electrical <input type="checkbox"/> Other <input type="checkbox"/>					
Description			Disposition	CE	DQAR
Continue on reverse side if required			RWK, RPR, UAI, SCP		
While winding turn #3 around the lead end , several cable strands began to fall out of register. The result was several raised wires requiring manual manipulation to properly seat the loose wire strands.			RWK	JS	AG
Instructions: Continue on additional sheets if required			Name	Life #	Date
PAUSE WINDING, REDUCE TENSION, USE HANDS/ DUCKBILL PLIERS TO WORK STRANDS BACK INTO POSITION, INCREASE TENSION AND RESUME WINDING.			JS	15764	
Reason for Discrepancy:					
			UNKNOWN		
Corrective Action:					
			CONTINUE TO MONITOR w/ Production office		
Report reviewed by CE <u>[Signature]</u>			Date <u>1/29/21</u>		
DQAR <u>[Signature]</u>			Date _____		

Distribution:  
 Magnet Traveler Section Head, Electrical Systems  
 Section Head, Production Engineering

DQAR Cognizant Engineer Schmalz

Distributed by [Signature]  
 Date: 1-15-21

**MAGNET DISREPARCY REPORT  
(Continuation)**

Sketch:

Instructions:	Name	Life #	Date



# MAGNET DISREPCANCY REPORT

DR NUMBER: AM-191

*Shr 1/2*

Preliminary: 2/3/21  
 Action Required: 2.26.21  
 Final: 6-1-21

Part No: F10115641	Rev B	Traveler No.: AUP - 140	Rev: E
Part Name: QXFA COIL ASSEMBLY		Traveler OP No.: 770	
Qty: 1	Ser. No./Lot No.: QXFA 220	Operation: Layer 2 Post Cure Inspection	
Initiator: Glenn Jochen		Life No.: 15764	Date: 01/19/2021
Type of Problem: (Check) Mechanical <input checked="" type="checkbox"/> Electrical <input type="checkbox"/> Other <input type="checkbox"/>			

Description	Disposition <small>RWK, RPR, UAT, SCP</small>	CE	DQAR
Continue on reverse side if required			
Layer 2 coil lead insulation is chaffed along the major edge for ~ 1" adjacent to the lead end splice block. See sheet 2	RWK	<i>JS</i>	<i>[Signature]</i>

Instructions: Continue on additional sheets if required	Name	Life #	Date
SMOOTH OUT DISPLACED FIBERGLASS PRIOR TO REACTION.	<i>[Signature]</i>	15764	

Reason for Discrepancy: UNKNOWN

Corrective Action: CONTINUE TO MONITOR

Report reviewed by CE *[Signature]* Date 2/26/21  
 DQAR *[Signature]* Date \_\_\_\_\_

Distribution:  
 Magnet Traveler  
 Section Head, Electrical Systems  
 Section Head, Production Engineering

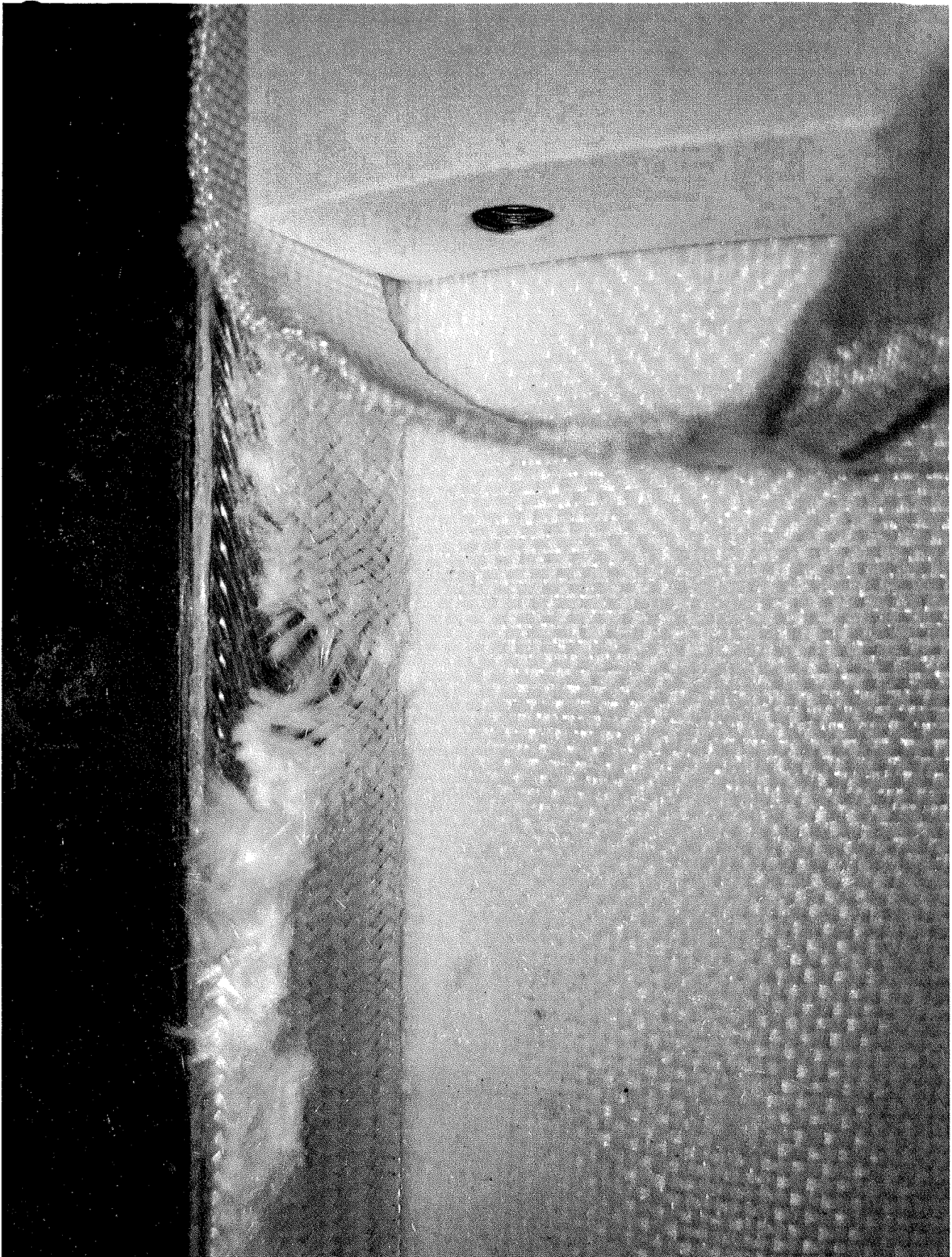
DQAR  
 Cognizant Engineer *[Signature]*

Distributed by *[Signature]*  
 Date: 2-1-21

**MAGNET DISREPARANCY REPORT  
(Continuation)**

Sketch:

Instructions:	Name	Life #	Date



# MAGNET DISREPARCY REPORT

DR NUMBER: AM-195

Preliminary: 2-18-21  
 Action Required: 5.5.21  
 Final: 6.1.21

Part No:	Rev	Traveler No.: AUP-160	Rev: F
Part Name: QXFA Coil		Traveler OP No.: 720	
Qty: 1	Ser. No./Lot No.: QXFA220	Operation: Impreg preg	
Initiator: T. Levine		Life No.: 21627	Date: 2/18/21
Type of Problem: (Check) Mechanical      Electrical <input checked="" type="checkbox"/> Other			

Description	Disposition <small>RWK, RPR, UAI, SCP</small>	CE	DQAR
Continue on reverse side if required			
Coil to pole short after reaction. Resistance of approx 380 Ohms measured during inner layer prep for impregnation. Area of short exhibits discoloration - See attached	RPR	9/5	

Instructions: Continue on additional sheets if required	Name	Life #	Date
REPAIR - SEE ATTACHED SUMMARY		21627	

Reason for Discrepancy: POSS. RES KAPTON REMNANT IN AREA

Corrective Action: REPAIRS REMENDED TO BE AWARE OF LOOSE KAPTON IN AREA

Report reviewed by CE  Date 5/5/21  
 DQAR  Date 6.1.21

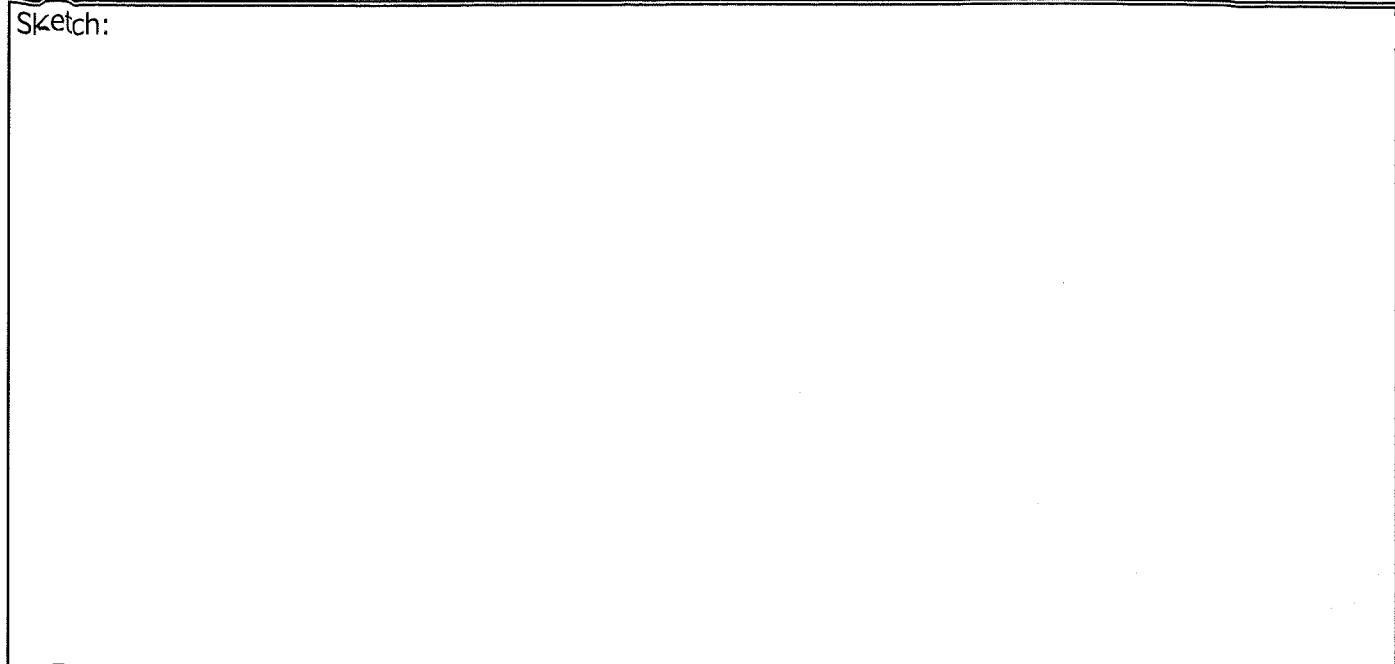
Distribution:  
 Magnet Traveler  
 Section Head, Electrical Systems  
 Section Head, Production Engineering

DQAR  
 Cognizant Engineer

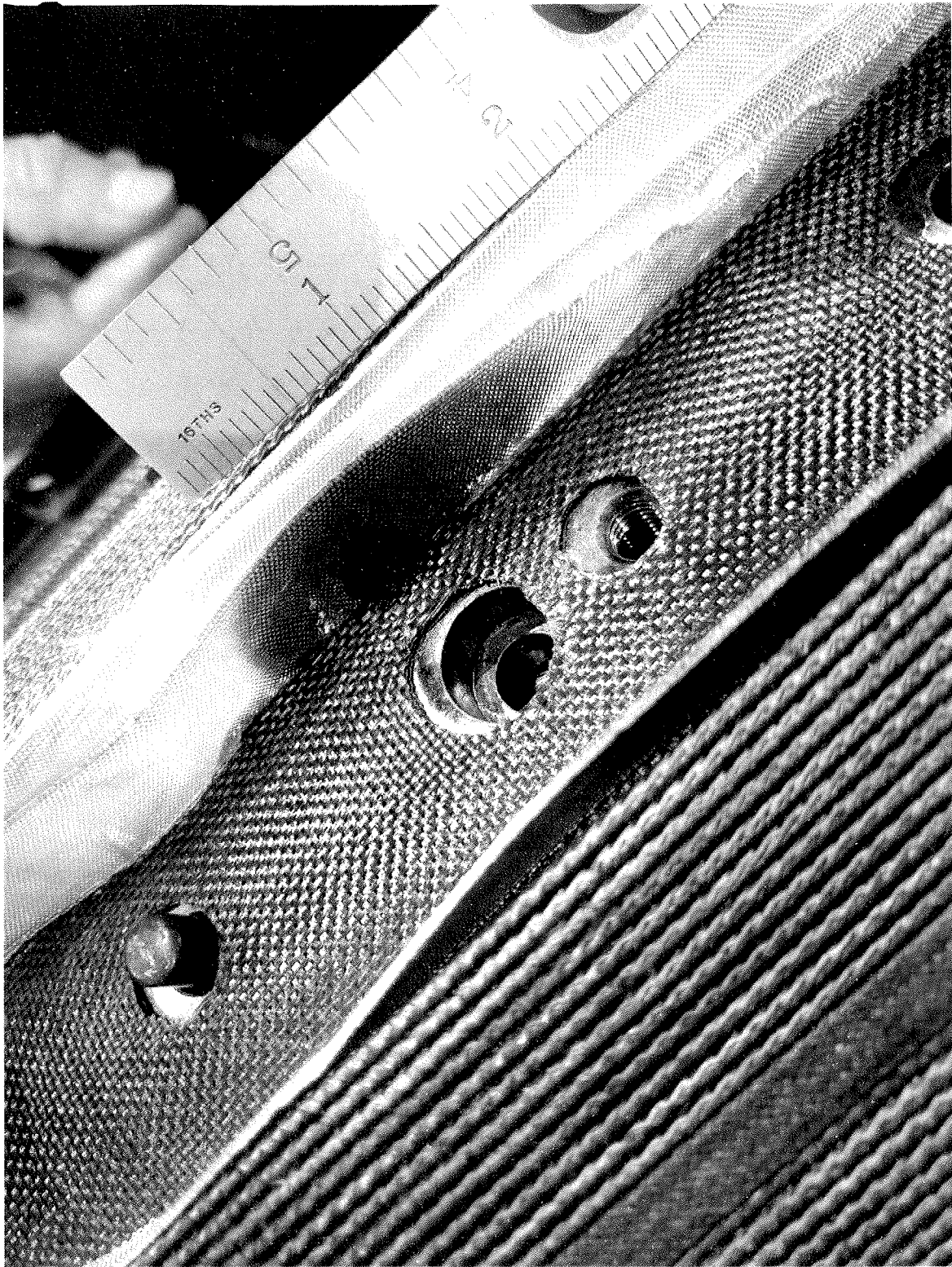
Distributed by   
 Date: 5.5.21

**MAGNET DISREPAncy REPORT  
(Continuation)**

Sketch:

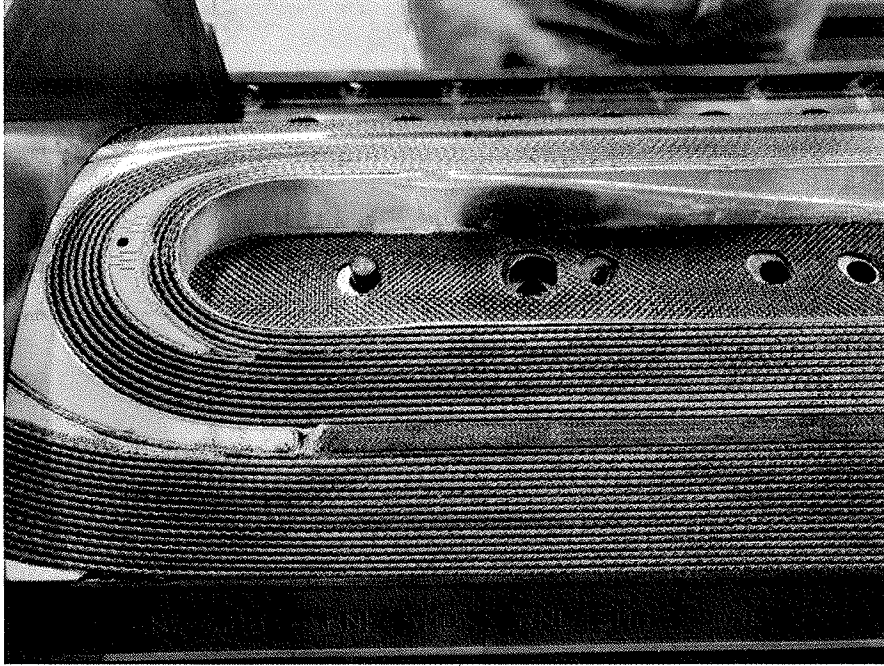


Instructions:	Name	Life #	Date

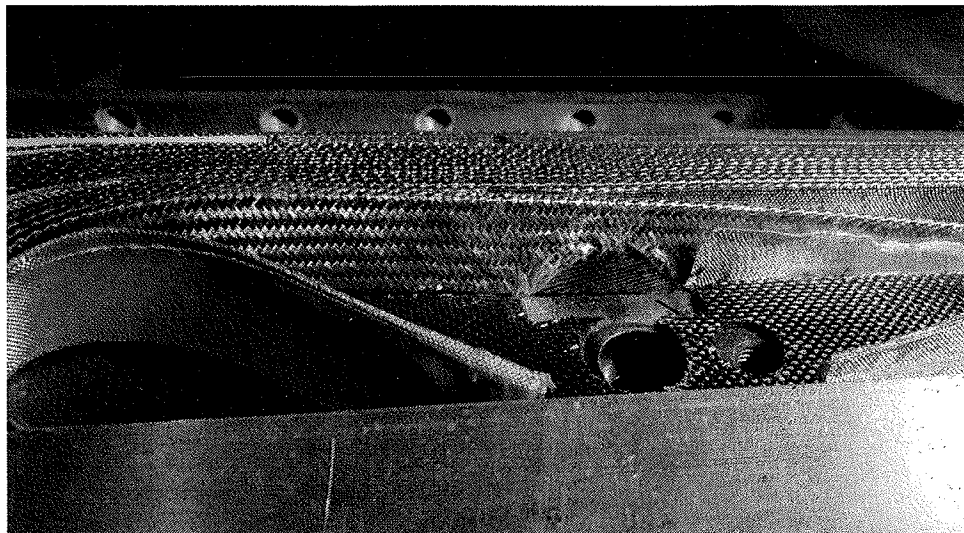


QXFA220 – Coil to pole short:

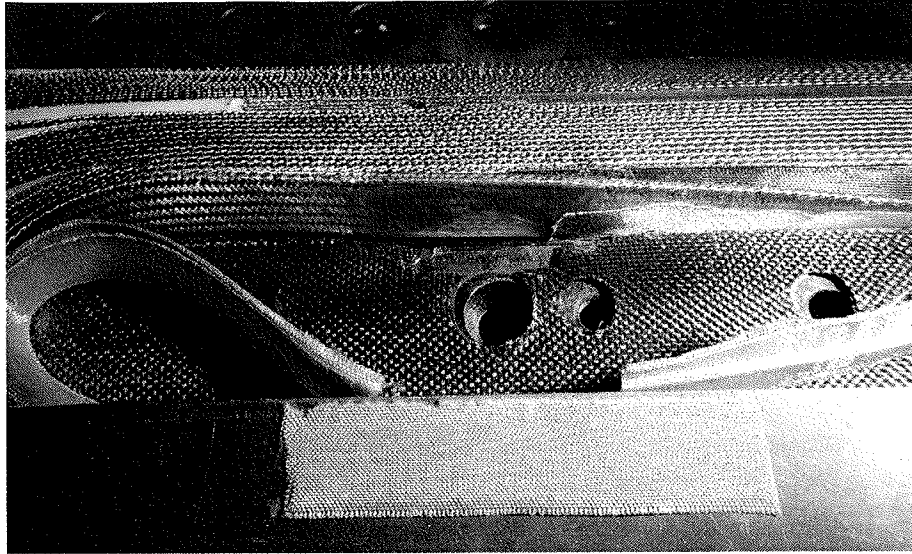
1. Removed 1<sup>st</sup> and 2<sup>nd</sup> outer layer pole segments.



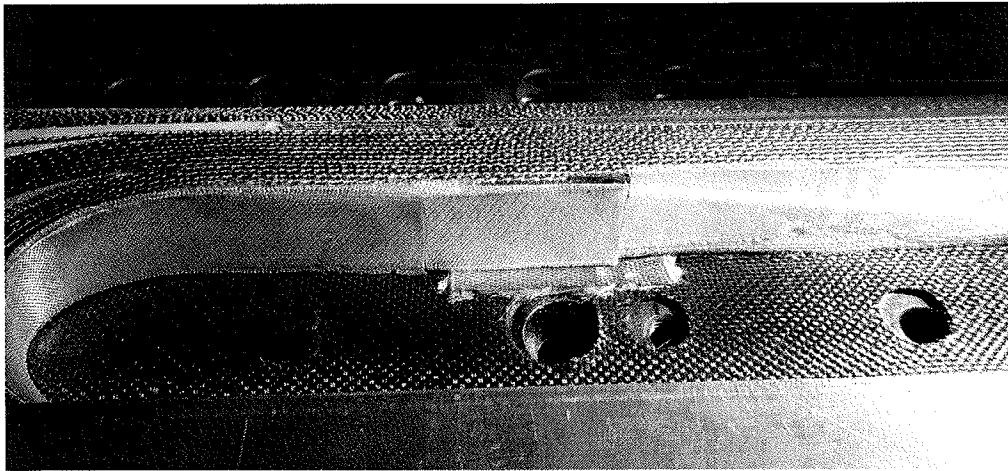
2. Removed contaminated fiberglass pole insulation.
3. Cut away contaminated area of interlayer insulation.
4. Cleaned up remaining residue.



5. Inserted 2 mil Kapton between first turn and pole, also between IL first turn and OL 1<sup>st</sup> turn.



6. Installed new fiberglass where interlayer was cut away.
7. Installed new fiberglass pole insulation.



8. Reinstalled 1<sup>st</sup> and 2<sup>nd</sup> outer layer pole segments.
9. Proceeded with prep for impregnation.