



Lawrence Berkeley National Laboratory
Nonconformance Report (NCR)
MQXFA-NCR-0109

LBNL Document #
SU-1012-6628

Rev
A

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Date: 7/3/20 QA Doc #: **MQXFA-NCR-00109**

Originator: Steven Graves Company: Precision Boring Company
Phone: (586)-463-3900 PO Number: 7473800
E-mail: steven@precisionboring.com Other: _____

Part Name: Load Pads Quantity Impacted: 57
27L223A, 27L224A, 27L227A,
27L228A, 27L229A, 27L230A,
27L250B, 27L251B, 27L252B, Serial No. (if
Part Number: 27L253B, 27L254C, 27L255B applicable):
Serial numbers are called
out in the Nonconforming
Characteristics field
Additional
Notes: _____

ITEM NO.	NONCONFORMING CHARACTERISTIC	DISPOSITION	REINSPECTION
1	Parts 27L223A-01 and -02 have profiles, balloon(s); 5 at depths of 3mm and 35mm, that are reporting an out of tolerance from -.004mm to -.002mm.	<input checked="" type="checkbox"/> ACCEPT AS-IS <input type="checkbox"/> REWORK <input type="checkbox"/> REJECT	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
2	Parts 27L224A-01 and -02 have profiles, balloon(s); 5 at depths of 3mm and 35mm, that are reporting an out of tolerance from -.000mm to -.003mm.	<input checked="" type="checkbox"/> ACCEPT AS-IS <input type="checkbox"/> REWORK <input type="checkbox"/> REJECT	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
3	Parts 27L227A-1, 10, 20, 30, 50, 60, 70, 80, 90, 100, 110, 120, 130, 140, 150, 160, 162 have profiles, balloon(s); 2, 3, 4, 5, 6, 7, 8, and 9 at depths of 3mm, 25mm, 47mm that are reporting an out of tolerance from -.007mm to +.012mm.	<input checked="" type="checkbox"/> ACCEPT AS-IS <input type="checkbox"/> REWORK <input type="checkbox"/> REJECT	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

Use continuation sheet if necessary. Attach red-lines, photos as necessary

APPROVAL: <u>[Signature]</u> <u>8/20/20</u>	CONCURRENCE: <u>[Signature]</u> <u>8/24/20</u>	CONCURRENCE:	CONCURRENCE:
Technical Lead	Date	QA Rep.	Stakeholder/CAM
		Date	PM (High Risk NCRs Only)

Indicate all follow-on or related processes: NONE CAR ECN HOLD



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ITEM NO.	NONCONFORMING CHARACTERISTIC	DISPOSITION	REINSPECTION
4	Parts 27L227A-130, 140 are reporting a parallelism out of tolerance of .003mm to .010mm.	<input checked="" type="checkbox"/> ACCEPT AS-IS <input type="checkbox"/> REWORK <input type="checkbox"/> REJECT	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
5	Parts 27L228A-01, 06 have profiles, balloon(s); 3, 5, 8, and 9 at depths of 3mm, 25mm, and 47mm that are reporting an out of tolerance from .000mm to +.005mm.	<input checked="" type="checkbox"/> ACCEPT AS-IS <input type="checkbox"/> REWORK <input type="checkbox"/> REJECT	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
6	Parts 27L229A-01, 10, 20, 30, 40, 50, 60, 70, 80, 90, 100, 110, 120, 130, 140, 150, 160, and 162 have profiles, balloon(s); 2, 3, 5, 6, 7, 8, and 9 at depths of 3mm, 25mm, and 47mm that are reporting an out of tolerance from -.005mm to +.012mm.	<input checked="" type="checkbox"/> ACCEPT AS-IS <input type="checkbox"/> REWORK <input type="checkbox"/> REJECT	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
7	Parts 27L230A-01 and 06 have profiles, balloon(s) 2, 3, 6, and 7 at depths of 3mm, 25mm that are out of tolerance from .000mm to +.008mm.	<input checked="" type="checkbox"/> ACCEPT AS-IS <input type="checkbox"/> REWORK <input type="checkbox"/> REJECT	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
8	Parts 27L250B-01 and 02 have profiles, balloon(s); 2, 3, 5, 8, and 9 at depths of 3mm, 25mm, and 47mm that are out of tolerance from .000mm to .013mm.	<input checked="" type="checkbox"/> ACCEPT AS-IS <input type="checkbox"/> REWORK <input type="checkbox"/> REJECT	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
9	Parts 27L251B-01, 10, 20, and 24 have profiles, balloon(s); 2, 3, 5, 6, 7, 8, and 9 at depths of 3mm, 25mm, and 47mm that are out of tolerance from -.009mm to .012mm.	<input checked="" type="checkbox"/> ACCEPT AS-IS <input type="checkbox"/> REWORK <input type="checkbox"/> REJECT	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
10	Parts 27L255B-01 and 02 have profiles, balloon(s); 1, 2, 6, 7, 8, and 9 at depths of 3mm that are reporting out of tolerance from -.011mm to .011mm.	<input checked="" type="checkbox"/> ACCEPT AS-IS <input type="checkbox"/> REWORK <input type="checkbox"/> REJECT	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
11	Part 27L253B-02 has profiles, balloon(s); 2, 3, 4, 5, and 8 at depths of 3mm, 25mm, and 47mm are out of tolerance from .001mm to .008mm.	<input checked="" type="checkbox"/> ACCEPT AS-IS <input type="checkbox"/> REWORK <input type="checkbox"/> REJECT	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO
12	Parts 27L254C-01, 10, 20, and 24 have profiles, balloons; 2, 3, 4, 6, 7, and 9 at depths of 3mm, 25mm, and 47mm are out of tolerance from -.011mm to .011mm.	<input checked="" type="checkbox"/> ACCEPT AS-IS <input type="checkbox"/> REWORK <input type="checkbox"/> REJECT	<input type="checkbox"/> YES



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			<input checked="" type="checkbox"/> NO	
13	Parts 27L252B-01 and 02 have profiles, balloon(s); 2, 3, 6, 7, 8, and 9 at depth of 3mm that are reporting out of tolerance from -.009mm to .006mm.	<input checked="" type="checkbox"/> ACCEPT AS-IS <input type="checkbox"/> REWORK <input type="checkbox"/> REJECT	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	

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