

# ANL LCLS Nonconformance Status Report 1/21/2008

The purpose of this report is to inform LCLS Project Management of the status of nonconformance issues and to provide a method for closing them. This report was generated by ANL LCLS QA Coordinator Tom Barsz using the ANL LCLS QA Database.

**System:** Vacuum      **Subsystem:** Vacuum Chamber      **Item Name or Description:** Bi-Metal Flanges      **Drawing or Part No:** L1440202-20005      **Rev or Date:** 00

**Report or Ref number:** \_\_\_\_\_      **Tracking NO:** 525

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

**Person reporting:** M. Erdmann      **Reporting Organization:** AES-MED      **Date reported:** 12/28/2007

**Issue :** The flanges do not meet the tolerance for the 15 degree angle shown in section 3-D of the drawing included with the purchase order.

**Issue Status:** Open

**Followup owner:** Atlas Technolgies

**Follow up required:** The supplier's corrective action report stating that the supplier was going to work to drawings provided by the ANL engineer via email is not acceptable for a DOE project of this magnitude.

Supplier to revise suggested actions on the Corrective and Preventative Action form to "Atlas will manufacture only to drawings provided by ANL Procurement" and resubmit.

**\*\*\*\*\* Use the following sections to provide and resolution or comment and returning to Tom Barsz, B401, B4192 to update or close the status of an issue \*\*\*\*\***

**Resolution:** Accept as is in order to maintain LCLS Project Schedule. E. Trakhtenberg to have the 15 degree angle reworked.

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**Resolution provided by:** Trakhtenberg, E.      **Disposition date:** 1/3/2008

**Comments on this issue:**

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**Comments provided by:** \_\_\_\_\_      **Date:** \_\_\_\_\_

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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:** EFC      **Date reported:** 11/19/2007

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

**Issue Status:** Open

**Followup owner:** Weimerslage, G

**Follow up required:** Inform T. Barsz if production schedule is needed. Tom will leave open per Greg's request.

**\*\*\*\*\* Use the following sections to provide and resolution or comment and returning to Tom Barsz, B401, B4192 to update or close the status of an issue \*\*\*\*\***

**Resolution:**

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**Resolution provided by:** \_\_\_\_\_

**Disposition date:** \_\_\_\_\_

**Comments on this issue:**

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**Comments provided by:** \_\_\_\_\_

**Date:** \_\_\_\_\_

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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:** SLAC      **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.

**Issue Status:** Open

**Followup owner:** Trakhtenberg, Emil

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

\*\*\*\*\* Use the following sections to provide and resolution or comment and returning to Tom Barsz, B401, B4192 to update or close the status of an issue \*\*\*\*\*

**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.)

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

**Comments on this issue:**

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**Comments provided by:** \_\_\_\_\_ **Date:** \_\_\_\_\_

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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:** SLAC      **Date reported:** 11/1/2007

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

**Issue Status:** Open

**Followup owner:** Trakhtenberg, Emil

**Follow up required:** Inform T. Barsz of the method for providing improved control on label location on future pedestals so he can list the issue as closed. Determine wich manufacter chose this label location. Provide Engineering signature on SLAC QA Report.

**\*\*\*\*\* Use the following sections to provide and resolution or comment and returning to Tom Barsz, B401, B4192 to update or close the status of an issue \*\*\*\*\***

**Resolution:** Remove and clean

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**Resolution provided by:** \_\_\_\_\_ **Disposition date:** \_\_\_\_\_

**Comments on this issue:**

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**Comments provided by:** \_\_\_\_\_ **Date:** \_\_\_\_\_

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**System:** Undulator      **Subsystem:** Quadrupole      **Item Name or Description:** Magnet Tooling Ball holes      **Drawing or Part No:**      **Rev or Date:**

**Report or Ref number:**      **Tracking NO:** 527

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

**Person reporting:** Rago/LeCocq      **Reporting Organization:** SLAC      **Date reported:** 1/11/2008

**Issue :** The existing tooling holes are not tolerance sufficient when used with SLAC tooling balls. The 'x' tooling hole location does not clear a 1.75 inch SLAC tooling ball base. The manufactured tooling holes are not sufficiently round to be used for magnetic center fiducialization and or field position location of the quad.

**Issue Status:** Open

**Followup owner:** Jaski, Mark S.

**Follow up required:** Add SLAC tooling ball sockets to future magnet assemblies if SLAC prototype is successful.

**\*\*\*\*\* Use the following sections to provide and resolution or comment and returning to Tom Barsz, B401, B4192 to update or close the status of an issue \*\*\*\*\***

**Resolution:** SLAC will add standard SLAC tooling to a prototype magnet and evaluate alignment performance for both operations. SLAC will relocate the 'x' tooling location in such a way to clear a SLAC 1.75 o.d. tooling ball base.

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**Resolution provided by:** C. Rago      **Disposition date:** 1/8/2008

**Comments on this issue:**

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**Comments provided by:** \_\_\_\_\_ **Date:** \_\_\_\_\_

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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:** APS      **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.

**Issue Status:** Open

**Followup owner:** Trakhtenberg, Emil

**Follow up required:** Tell Tom whether the waive the monetary compensation. Lintech wants to rework the holes. Holes already reworked by Hi-Tech. If Emil waives compensation issue, Tom will request IMAC to identify cause and close the NCR.

**\*\*\*\*\* Use the following sections to provide and resolution or comment and returning to Tom Barsz, B401, B4192 to update or close the status of an issue \*\*\*\*\***

**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 hieght, and forfacrication the special inspection fixture.

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

**Comments on this issue:**  
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**Comments provided by:** \_\_\_\_\_      **Date:** \_\_\_\_\_

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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:** SLAC      **Date reported:** 12/6/2007

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

**Issue Status:** Open

**Followup owner:** Trakhtenberg, Emil

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

\*\*\*\*\* Use the following sections to provide and resolution or comment and returning to Tom Barsz, B401, B4192 to update or close the status of an issue \*\*\*\*\*

**Resolution:** Document, clean/soe surface and reinstall slide assy.

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**Resolution provided by:** \_\_\_\_\_      **Disposition date:** \_\_\_\_\_

**Comments on this issue:**

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**Comments provided by:** \_\_\_\_\_      **Date:** \_\_\_\_\_

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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:** APS      **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.

**Issue Status:** Open

**Followup owner:** IMAC

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

**\*\*\*\*\* Use the following sections to provide and resolution or comment and returning to Tom Barsz, B401, B4192 to update or close the status of an issue \*\*\*\*\***

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

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

**Comments on this issue:**  
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**Comments provided by:** \_\_\_\_\_      **Date:** \_\_\_\_\_

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**System:** Undulator      **Subsystem:** Support Mover      **Item Name or Description:** Undulator "Roll Away" Slides      **Drawing or Part No:**      **Rev or Date:**

**Report or Ref number:**      **Tracking NO:** 515

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

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

**Issue :** - Undulator Slides are out of height & parallelism tolerance specified in EDS 1.4-112 r0 section 4.4. "Height +/-12.5 um from the bottom of the stage to the top of the Carriage Mounting Plate"  
- (Test Fixture) Flat, stiff mounting plates need to be fabricated to mount slides to CMM @ SLAC MMF building so slides can be measured under load to determine magnitude of correction needed.

**Issue Status:** Open

**Followup owner:** White, Marion M.

**Follow up required:** Provide a decision of the following issue to C. Rago and T. Barsz.: After talking to Ben this morning SLAC currently has 13 Girder Assemblies. #'s 3,10,11 have had their slides removed for test by Lundahl. #'s 2,4,5,6,7,8,9,12,13,14 are with Poling. (Their slides have not been touched.) My hope is that Eric will identify slides that need to be replaced (via Emil's test) and or all slides will be removed and returned to Hi-Tech for replacement. C. Rago would like Marion too formally to approve which path we will take. C. Rago would like to make Ben sole responsible for hipping between SLAC and ANL and or Hi-Tech. C. Rago requests ANL to correct this status as necessary.

**\*\*\*\*\* Use the following sections to provide and resolution or comment and returning to Tom Barsz, B401, B4192 to update or close the status of an issue \*\*\*\*\***

**Resolution:** The test fixture has been received today. It will be used to measure the flatness and height precisely. Based on the measurements, selective assembly will be done to achieve the required tolerance in the ESD.

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

**Comments on this issue:**  
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**Comments provided by:** \_\_\_\_\_      **Date:** \_\_\_\_\_

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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:** NE      **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.

**Issue Status:** Open

**Followup owner:** Bailey, James L.

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

\*\*\*\*\* Use the following sections to provide and resolution or comment and returning to Tom Barsz, B401, B4192 to update or close the status of an issue \*\*\*\*\*

**Resolution:**

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**Resolution provided by:** \_\_\_\_\_ **Disposition date:** \_\_\_\_\_

**Comments on this issue:**

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**Comments provided by:** \_\_\_\_\_ **Date:** \_\_\_\_\_

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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:** NE      **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.

**Issue Status:** Open

**Followup owner:** Bailey, James L.

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

**\*\*\*\*\* Use the following sections to provide and resolution or comment and returning to Tom Barsz, B401, B4192 to update or close the status of an issue \*\*\*\*\***

**Resolution:**  
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**Resolution provided by:** \_\_\_\_\_      **Disposition date:** \_\_\_\_\_

**Comments on this issue:**  
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**Comments provided by:** \_\_\_\_\_      **Date:** \_\_\_\_\_

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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 11 Windows 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. 85 from shipment #2 received 11/13/2007 has poor quality plating ans is skewed on the kovar.

**Issue Status:** Open

**Followup owner:** CPI

**Follow up required:** CPI to send cause and corrective action to T. Barsz

**\*\*\*\*\* Use the following sections to provide and resolution or comment and returning to Tom Barsz, B401, B4192 to update or close the status of an issue \*\*\*\*\***

**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 and inspection of the plating surface. Accept the undersize windows and match with mating part. Report conformance to the supplier for replacement of 5 windows and for cause and corrective action identification in accordance with its ISO 9001 procedures. ANL to perform dimensonal inspection of all incoming windows for length, width, thickness and flatness.

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**Resolution provided by:** L. Morrison      **Disposition date:** 1/7/2008

**Comments on this issue:**  
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**Comments provided by:** \_\_\_\_\_      **Date:** \_\_\_\_\_

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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:** APS      **Date reported:** 9/23/2007

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

**Issue Status:** Open

**Followup owner:** Barsz, Thomas R.

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

**\*\*\*\*\* Use the following sections to provide and resolution or comment and returning to Tom Barsz, B401, B4192 to update or close the status of an issue \*\*\*\*\***

**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 bpm's 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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**Resolution provided by:** D. Walters      **Disposition date:** 10/3/2007

**Comments on this issue:**  
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**Comments provided by:** \_\_\_\_\_      **Date:** \_\_\_\_\_