

CENTER FOR NUCLEAR WASTE REGULATORY ANALYSES

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50/93

NONCONFORMANCE REPORT

Project No. 20-01402-571

NCR No. 2001-07

PART 1: DESCRIPTION OF NONCONFORMANCE

Purchase order 183724S from Metal Samples Inc. received 3/23/01 was found to have 8 of 8 compact tension specimens out of tolerance per CNWRA drawing 06-2795-1. The dimensional tolerance was specified as ± 0.001 inches. Specimens found to be out of tolerance had dimensional measurements ± 0.003 inches to the specifications provided in CNWRA drawing 06-2795-1. Detail C of CNWRA drawing 06-2795-1 specifies an included angle of 60° with a dimensional tolerance of $\pm 0^\circ 30'$. Inspection of the specimens revealed that 6 of the 8 specimens were out of tolerance with respect to the included angle specification.

Initiated by: Darrell Dunn

Date: 4/25/2001

PART 2: PROPOSED DISPOSITION AND CORRECTIVE ACTION

Disposition:

Accept all specimens as is.

Basis of Disposition:

The specified dimensional tolerance for CNWRA drawing 06-2795-1 is ± 0.001 inches for dimensions under 6 inches with dimensional specifications to 3 decimal places. This tolerance is unnecessarily tight. Dimensional specification tolerances for compact tension specimens provided in American Society for Testing and Materials (ASTM) Designation E399-90, Standard Test Method for Plane-Strain Fracture Toughness Testing are ± 0.005 inches.

Action to Correct Nonconformance:

The dimensional specification tolerances in CNWRA drawing 06-2795-1 will be revised and the drawing will be updated to reference the 0.005" tolerance. The tolerances of the included angles have been revised to $\pm 1^\circ$.

Darrell Dunn 5/4/2001

Target date for completion: 5/9/2001

Proposed by: Darrell Dunn

Date: 5/4/2001

PART 3: APPROVAL

Element Manager: *[Signature]* Date: 5/4/2001

Director of QA: *[Signature]* Date: 5/4/2001

Comments/Instructions:

PART 4: CLOSE OUT

Comments:

Drawing 06-2795-1 has been revised and identifies revised tolerances.

Verified by: *Nash R. Ehnstrom* Date: 4/May/2001

Distribution:

- QA Records - Original*
- D. Dunn*
- Element Managers*
- M. Ehnstrom / 30*
- S. Crossia, P. Bertetti*
- B. Sagar, H. Garcia*

Alabama Specialty Products, Inc.

5/13

QF 10.2-B

Inspection and Test Report

Revision 15-May-97

Part Number	Rev.	Job	179394	Operation	2 of 7
Customer		Customer	SW RESEARCH 01482		
ASPI	CU014820154	ASPI Insp.	9	Date Insp.	3/21/01
Description	C22 C/T SPEC		Cust. Insp.	Date Insp.	
Order Quantity	Sample Size	Quantity Accepted	Quantity Rejected		
8	8	8			

Inspection Equipment ID	Characteristic	Findings					
		1	2	3	4	5	6
96-58	1 2.50	2.50	2.50	2.50	2.50	2.50	2.50
96-58	2 2.40	2.40	2.40	2.40	2.40	2.40	2.40
96-58	3 .50	.50	.50	.50	.50	.50	.50
91-102	4 ϕ .503/.505	.503	.503	.503	.503	.503	.503
91-102	5 ϕ .375/.376	.375	.375	.375	.375	.375	.375
96-58	6 2.00	2.00	2.00	2.00	2.00	2.00	2.00
96-58	7 1.250	1.253	1.242	1.250	1.250	1.250	1.250
96-58	8 .625	.626	.623	.625	.625	.627	.625
96-58	9 1.20	1.20	1.20	1.20	1.20	1.20	1.20
93-100	10 .500	.503	.503	.503	.503	.503	.503
91-102	11 .125	.125	.125	.124	.125	.125	.125
93-100	12 R .030	.028	.032	.031	.030	.031	.030
93-100	13 60°	60°	61°	61°	61°	61°	60°
93-100	14 .080	.080	.080	.079	.080	.081	.079
93-100	15 30°	30°	30°	30°	30°	30°	30°
93-100	16 R .003	.004	.004	.004	.005	.004	.004
91-102	17 .200	.201	.200	.200	.200	.201	.201
93-100	18 .050/.060	.054	.054	.055	.053	.054	.054
93-100	19 60°	60°	60°	61°	61°	61°	61°
93-100	20 90°	90°	91°	91°	91°	91°	91°

Comments

Alabar Specialty Products, Inc.

52/53 QF 10.2-B

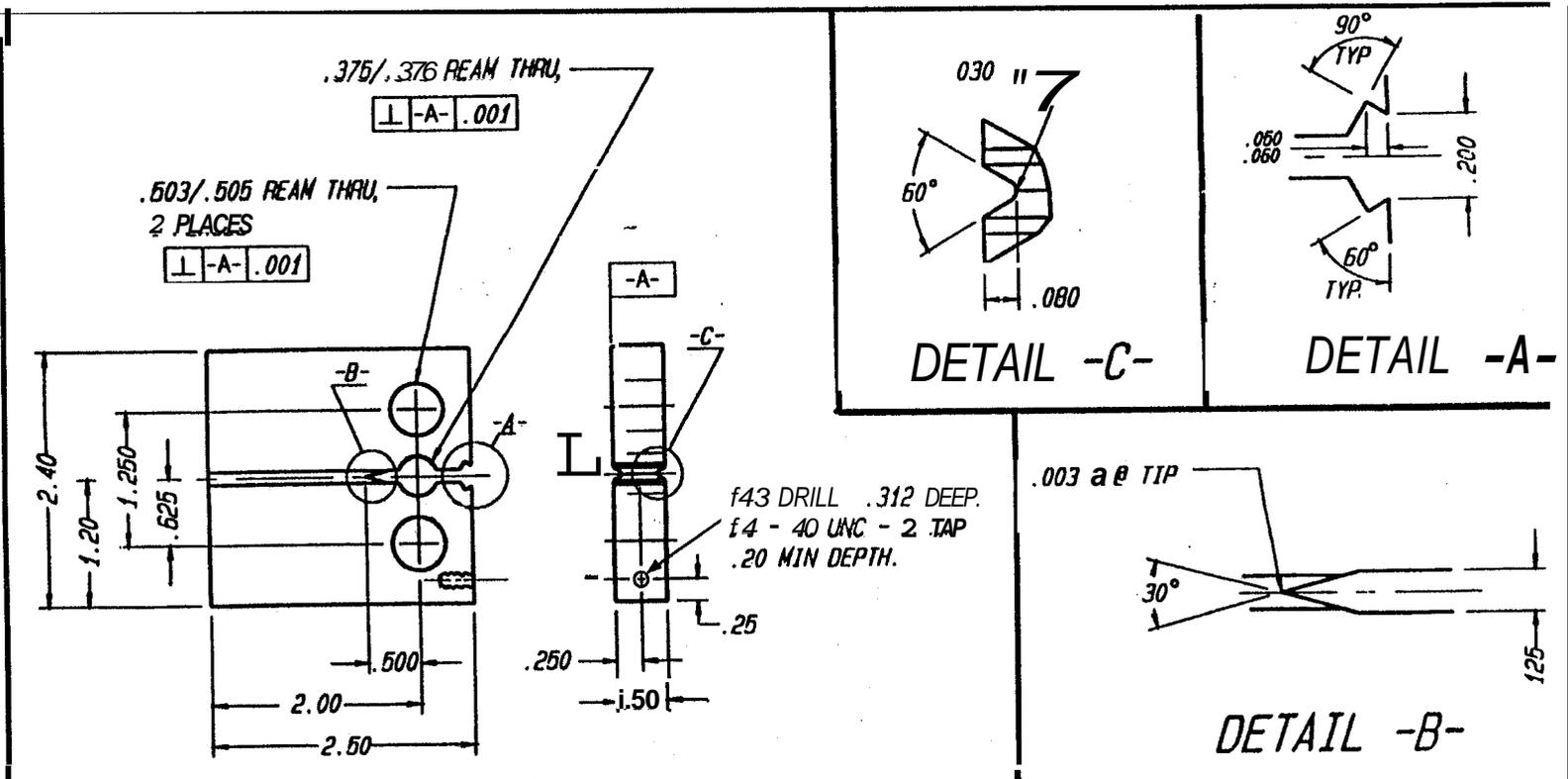
Inspection and Test Report

Revision 15-May-97

	Part Number	Rev.	Job	179394	Operation	3 of 7
Customer			Customer	SW RESEARCH 01482		
ASPI	C22 C/T SPEC		ASPI Insp.		Date Insp.	
Description	C22 C/T SPEC		Cust. Insp.		Date Insp.	
Order Quantity		Sample Size		Quantity Accepted		Quantity Rejected

Inspection Equipment ID	Characteristic	Findings			
		7	8		
96-58	1	2.50	2.50	2.50	
96-58	2	2.40	2.40	2.40	
96-58	3	.50	.50	.50	
91-102	4	∅ .502 / .505	.503	.503	
91-102	5	∅ .375 / .376	.375	.375	
96-58	6	2.00	2.00	2.00	
96-58	7	1.250	1.251	1.251	
96-58	8	.625	(.627)	.626	
96-58	9	1.20	1.20	1.20	
93-100	10	.500	(.503)	(.503)	
91-102	11	.125	.125	.125	
93-100	12	R.030	.030	.031	
93-100	13	60°	(61°)	(61°)	
93-100	14	.080	.080	.081	
93-100	15	30°	30°	30	
93-100	16	.R.003	.004	.004	
91-102	17	.200	.201	.201	
93-100	18	.050 / .060	.054	.053	
93-100	19	60°	61°	60°	
93-100	20	90°	91°	91°	

Comments



FIND NO.	QTY REQ.	SIZE	CODE IDENT. NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION	
					PARTS LIST	
					SOUTHWEST RESEARCH INSTITUTE	
					1T PLAN C(T) SPECIMEN: W/4 THICK	
					DRAWING NUMBER 06-2795-1 REV I	
					SCALE 1=1 SHEET	

BASIC DIMENSIONS	DECIMALS		FRAC	CONTRACT	
	2 PLACE	3 PLACE		DWN	
UNDERS	± .01	± .005	± 1/32	2-7-1995	A.NAGY
6-24 INCL	± .03	± .010	± 1/16		
OVER 24	± .06	± .01	± 1/8		
ANGLES	± 1°		± 1°	05-03-01	D.DUNN

MATERIAL	
FINISH	ALL SURFACES 16 RMS
USED ON	QTY. REQ.
D:\SPEC1\TW4SPC	

Darrell Dunn 5/3/2001
 Originated by: Darrell Dunn Date

Reviewed by: Vijay Jain Date

QA Approval: Bruce Mabrito Date

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QUOTE

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Metal Samples Company
P.O. Box 8
152 Metal Samples Road
Munford, AL 36268

Phone: (256)358-4202
Fax: (256)358-4515

Quote Number: 26874
Page: 1

<p>Quote To: DARRELL DUNN SOUTHWEST RESEARCH INSTITUTE P.O. BOX 285 10 SAN ANTONIO TX 78228-0510 USA</p>	<p>Date: 02/28/01 Expires: 03/30/01 Reference: Sales Person: BENJAMIN J. LACKEY</p>
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Line	Part Number	Description	Revision	Drawing#
1	CU014820154	C22(CSM) I T PLAN C/T SPEC		
Lead Time: SHIP : 2 WEEKS ARO				
<i>IT PLAN COMPACT TENSION SPECIMEN, PER SwRI DR WG#06-2795-1</i>				
<i>- TO BE MACHINED FROM HASTELLOY C22 CUSTOMER SUPPLIED MATERIAL (CSM).</i>				
			Quantitv UM	Unit Price UM
			8.00 EA @	280.00 EA

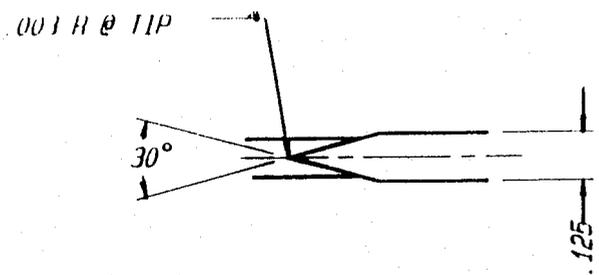
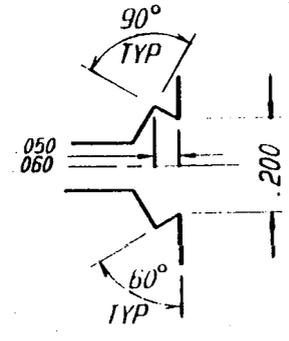
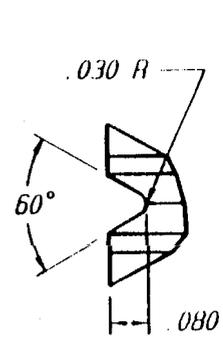
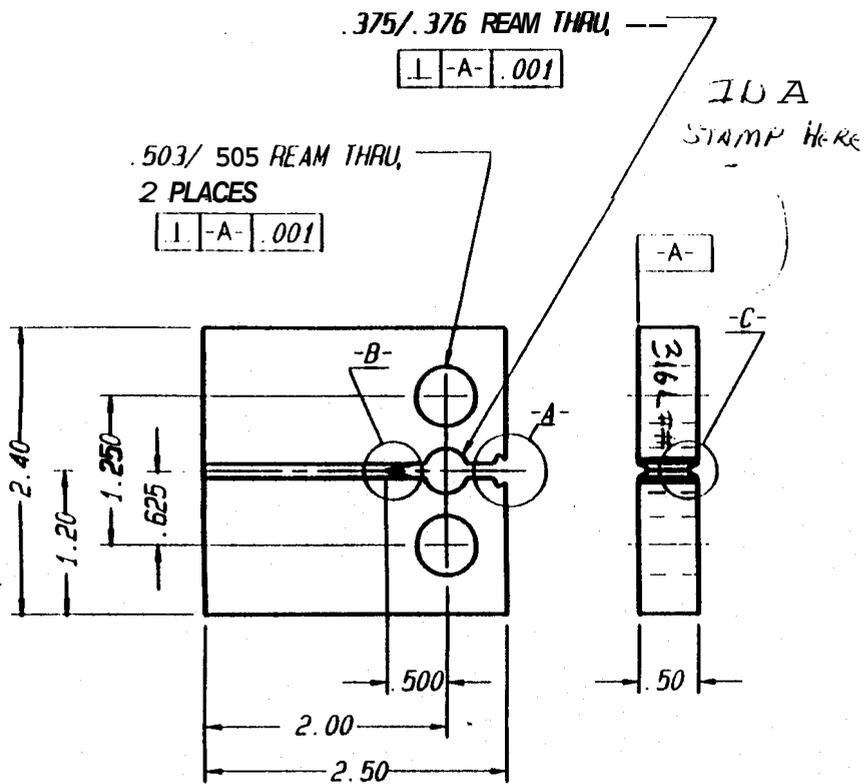
AVAILABLE TO SHIP 2 WEEKS AFTER RECEIPT OF ORDER AND MATERIAL.

THANK YOU FOR YOUR INQUIRY IF YOU HAVE ANY QUESTIONS, PLEASE LET ME KNOW.

Please check the above information for accuracy. Standard terms and conditions apply if this quote becomes an order. Following industry standard, quantities listed above may vary within plus or minus ten percent. Thank you for the opportunity to present this quotation.



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FIND NO.	QTY. REQ.	SIZE	CODE IDENT NO.	PART OR IDENTIFYING NO.	NOMENCLATURE OR DESCRIPTION
PARTS LIST					
BASIC DIMENSIONS			DECIMALS	FRACTIONS	CONTRACT
			2 PLACE	3 PLACE	DWN 2-7-1995
UNDER 8			2 .01	3 .001	1/32
8-24 INCL			3 .03	3 .010	1/16
OVER 24			3 .06	3 .015	1/8
ANGLES			3 0° 30'	3 1° 0'	
USED ON			D: \SPEC\1TH4SPC		
MATERIAL					SOUTHWEST RESEARCH INSTITUTE
FINISH					1T PLAN C (1) SPECIMEN: W/4 THICK
ALL SURFACES 16 RMS					DRAWING NO. 06-2795-1
QTY. REQ.					SCALE 1 = 1
					SHEET

REVIEW: *Darrell L...* 6/8/2000 EM: *N. Slick* 4/8/2000

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