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# CENTER FOR NUCLEAR WASTE REGULATORY ANALYSES

## DEVIATION AND NONCONFORMANCE REPORT

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PURCHASE ORDER NO.	PROJECT NO. 20-3704-042	JOB REQUEST NO.	DNR NO. 90-006
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ITEM NAME OR ACTIVITY machining	ACTIVITY PERFORMED BY Texas Toolmakers
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ITEM DESCRIPTION (S/N, MODEL, WELD, SITE, ELEMENT NAME, REGULATION, TEST, ETC.)

Cylindrical Electrochemical Sample, design # 20-3704-042-2  
ASTELLON C-22 Mt. No. 3175 Log # 2798B

DESCRIPTION OF DEVIATION OR NONCONFORMANCE

Four of 34 parts exceeded length tolerance - same as DNR No. - 90-005

PROBABLE CAUSE OF DEVIATION OR NONCONFORMANCE

machinist error - (parts were not inspected by Texas Toolmakers)

ORIGINATOR (NAME) R.D. BRIENT	DATE 4/27/90
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ACTION TO CORRECT DEFICIENCY

NONE required - use as is

ACTION TO PREVENT RECURRENCE

Subsequent parts are to be inspected by Texas Toolmakers prior to release

CORRECTIVE ACTION TO BE TAKEN BY (NAME) N/A	TARGET DATE FOR INITIATION N/A
OR COMPLETION	

DISPOSITION

ACCEPT     REWORK     SCRAP     RETURN TO VENDOR     HOLD     OTHER (SPECIFY)

BASIS FOR DECISION OR NOTES

Prior to tests, all parts should be measured and surface area calculated on that basis

LIST OF ATTACHMENTS Inspection Report	STATUS: <input type="checkbox"/> OPEN <input checked="" type="checkbox"/> CLOSED
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ELEMENT MANAGER (SIGNATURE) <i>Rasna Jari</i>	DATE 4/27/90	DISTRIBUTION: DIRECTOR OF QA ORIGINATOR ELEMENT MANAGER (PROJECT FILES) P. NAIR PERSON RESPONSIBLE FOR CORRECTIVE ACTION N/A N. Sridhar
DIRECTOR OF QA (SIGNATURE) <i>Soumitra Nair</i>	DATE 4/27/90	

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
DIMENSIONAL INSPECTION RECORD				Page <u>1</u> of <u>1</u>
Project: <b>20-3704</b>		Drawing /Part No.: <b>20-3704-042-2</b>		Part Name: <b>Cyl Sample</b>
Serial No.: (Single Part)		E. O.:		Procedure: <b>OP-10-30-102</b>
No. of Articles Inspected: <b>4</b>		DACs Required: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No		Location: Bldg. 162 Machine Shop
Drawing Zone	B/P Dim.	Accept	Reject	Comments
<b>1</b>	<b>#38</b>	<b>APR 24 1990</b>		<b>Micromete 5056-1</b>
<b>2</b>	<b>.250</b>	<b>APR 24 1990</b>		<b>Thick Edge 1R-11</b>
<b>3</b>	<b>.38</b>	<b>APR 24 1990</b>		
<b>4</b>	<b>.750</b>	<b>APR 24 1990</b>		<b>.750±.003 Act Range for .7534± .7506 AS marked!</b>
				<b>HASTELLOY C-22 Ht. No 3175 Log # 2798B</b>
No. of Articles Accepted: <b>0</b>	No. of Articles Rejected: <b>4</b>	Inspector Signature: 		Date: <b>APR 24 1990</b>

Figure 1. Dimensional Inspection Record

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DIMENSIONAL INSPECTION RECORD				Page <u>1</u> of <u>1</u>
Project: <u>20-3704-042-</u>		Drawing /Part No.: <u>20-3704-042-2</u>		Part Name: <u>Cyl. Sample</u>
Serial No.: (Single Part)		E. O.:		Procedure: <u>OP-10-30-102</u>
No. of Articles Inspected: <u>30</u>		DACS Required: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No		Location: <u>Bldg. 162 Machine Shop</u>
Drawing Zone	B/P Dim.	Accept	Reject	Comments
<u>1</u>	<u>#38</u>	<u>APR 24 1990</u>		<u>Micrometer 5056-1</u>
<u>2</u>	<u>.250</u>	<u>APR 24 1990</u>		<u>Thd Gauge IR-11</u>
<u>3</u>	<u>.38</u>	<u>APR 24 1990</u>		
<u>4</u>	<u>.750</u>	<u>APR 24 1990</u>		
				<u>HASTEUDYC-22 Ht.No. 3175</u>
				<u>Log.No. 27986</u>
No. of Articles Accepted: <u>30</u>	No. of Articles Rejected: <u>0</u>		Inspector Signature: 	
			Date: <u>APR 24 1990</u>	

SwRI Form QA-114-0

Figure 1. Dimensional Inspection Record