



Mu2e TS - FERMILAB (ASG job n.2124) - NON CONFORMITY REPORTS

12/6/19

DocDB-302

#	COMPONENT	ID n.	NCR n.	REV.	DocDB	DESCRIPTION	STATUS					REMARKS
							ISSUED	SOLVED	APPROVED BY FNAL	ACTION DONE	CLOSED	
1	cable	12	RNC160705A	1	64-v1	DeAngeli - wrapping of cable TS-1540m-#12	x	x	x	x	x	
2	coil	8-9-12-13-15	RNC161109A	0	164-v1	tension of cable during winding	x	x	x	x	x	
3	housing	TS-7	RNC161118A	0	91-v1	slot position	x	x	x	x	x	
4	coil	15-40	RNC170124B	0	167-v4	coil outer diameter	x	x	x	x	x	
5	coil	47	RNC170220A	0	173-v2	grinding of inner side of coil	x	x	x	x	x	
6	coil	46	RNC170223A	0	154-v2	thermal shield without straps	x	x	x	x	x	ASG proposal not accepted, coil re-wound
7	components		RNC170317A	0	176-v1	supplied shoulder bolts	x	x	x	x	x	
8	coil	12	RNC170405A	0	162-v2	lack of G10 insulation	x	x	x	x	x	
9	housing	TS-5	002-2017	0	197-v1	ITALMEC - rugosity after machining	x	x	x	x	x	
10	housing	TSMD-6	003-2017	0	191-v1	ITALMEC - wrong holes position	x	x	x	x	x	
11	coil	48	RNC170503C	0	179-v1	lack of insulation between lead and thermal shield	x	x	x	x	x	FNAL and ASG agreed that coil shall be re-wound (ref. e-mail 04-02-2019)
12	coil	34	RNC170503D	0	182-v1	lack of G10 insul. flange & insul. between lead -thermal shield	x	x	x	x	x	annex repairing proc.100RM21857 rev.0
13	coil	14	RNC170512D	0	188-v2	resin voids	x	x	x	x	x	
14	housing	TSMD-7	RNC170922C	0	254-v1	misalignments during blank assembly	x	x	x	x	x	
15	housing	TSMD-7	RNC171019D	1	268-v2	dimensional out-of-tolerances - incoming inspection	x	x	x	x	x	annex test report MA174219 rev.4
16	module	TSMD-7	RNC171219A	0	288-v1	misalignments during assembling after coils shrink fitting	x	x	x	x	x	
17	module	TSMD-7	RNC180220A	0	308-v1	spilce realization	x	x	x	x	x	
18	module	TSMD-3	005-2018	0	324-v1	ITALMEC - wrong dimater hole for lifting - M16 instead of M14	x	x	x	x	x	
19	module	TSMD-5	RNC180613A	0	379-v1	dimensional out-of-tolerances - incoming inspection	x	x	x	x	x	annex test report MA182402 rev.3
20	module	TSMD-6	RNC180711A	0	385-v1	dimensional out-of-tolerances - incoming inspection	x	x	x	x	x	annex test report MA182808 rev.3
21	module	TSMD-6	RNC180808A	0	391-v1	Al straps misalignment	x	x	x	x	x	annex test report MA174219 rev.4
22	housing	TSMD-4	RNC181130A	0	357-v2	dimensional out-of-tolerances - incoming inspection	x	x	x	x	x	annex test report MA184808 rev.4
23	coil	33	RNC181213A	0	540-v1	lack of G10 insulation	x	x	x	x	x	annex pictures and electr. Test report MA192705
24	housing	TSMD-3	RNC190114A	0	483-v1	dimensional out-of-tolerances - incoming inspection	x	x	x	x	x	annex test report MA190301 rev.5
24	housing	TSMD-1	RNC190221A	0	501-v1	dimensional out-of-tolerances - incoming inspection	x	x	x	x	x	annex test report MA190708 rev.1
25	housing	TSMD-2	RNC190228F	0	504-v1	dimensional out-of-tolerances - incoming inspection	x	x	x	x	x	
26	coil	50	RNC190405B	0	543-v1	coil 50 first turn out-of-position	x	x	x	x	x	coil REJECTED, to be re-wound
27	housing	9	RNC190418A	0	375-v1	housing dimension out-of-tolerance	x	x	x	x	x	annex test report MA11604 rev.1
28	unit	6	RNC190509A	0	489-v1	leak on cooling pipe of UNIT 6	x	x	x	x	x	annex leak test reports before and after weld repair
29	coil	51	RNC190514B	0	597-v1	dimension out-of-tolerance (cylindricity)	x	x	x	x	x	annex test report MA192001 & MA193206
30	unit	6	RNC190514C	0	495-v1	protusion of cooling pipe wrt outer side of module connection flange	x	x	x	x	x	annex pictures
31	coil	24-33-34-52	RNC190528A	0	549-v1	coils having low AXIAL insulation	x	x	x	x	x	analysis/resolution on FNAL report "MEMO about reduced axial and radial ground insulation of TS coils"
32	coil	25-27	RNC190530A	0	562-v1	coils having low AXIAL + RADIAL insulation	x	x	x	x	x	analysis/resolution on FNAL report "MEMO about reduced axial and radial ground insulation of TS coils" - annex test report MA192913-MA192914
33	coil	23-36	RNC190530B	0	565-v1	coils having low AXIAL insulation	x	x	x	x	x	analysis/resolution on FNAL report "MEMO about reduced axial and radial ground insulation of TS coils"
34	coil	48-bis	RNC190612A	0	568-v1	coil having low AXIAL insulation	x	x	x	x	x	analysis/resolution on FNAL report "MEMO about reduced axial and radial ground insulation of TS coils"
35	coil	47-51	RNC190612B	0	571-v1	coils having low AXIAL + RADIAL insulation	x	x	x	x	x	analysis/resolution on FNAL report "MEMO about reduced axial and radial ground insulation of TS coils" - annex test report MA192810
36	coil	25	RNC190702A	0	577-v1	low AXIAL insulation AFTER machining of additional flange @ Italmec	x	x	x	x	x	annex test report MA192810
37	coil	52	RNC190723B	0	600-v1	dimension out-of-tolerance (cylindricity)	x	x	x	x	x	annex test report MA193005 & MA193207
38	housing	8	RNC190715A	0	612-v1	dimension out-of-tolerance and wrong machining of coil slots (reverse position !!!)	x	x	x	x	x	annex test report MA192901 rev.2, proposal spec. 700RM23884 rev.1 issued
39	housing	22	RDC-2019-006	0	459-v1	MMI - wrong machining of holes on FACE 1	x	x	x	x	x	Annex to MMI_RDC_2019-006
40	housing	24	RDC-2019-010	0	465-v1	MMI - Holes d67 wrong position	x	x	x	x	x	Doc. issued by MMI supplier
41	coil	23	RNC191107A	0	625-v1	Coil #23 fell down during shrink fitting process	x	x	x	x	x	annex pictures of damaged current leads
42	housing	14	RNC191118B	0	631-v1	TS-14 housing dimension out-of-tolerance	x	x				annex test report MA194701
43	housing	15	RNC191120B	0	637-v1	TS-15 housing lugs wrong position	x	x				
44	housing	24	RDC-2019-019	0	640-v1	MMI - TS-24 housing cylindricity out-of-tolerance for face 2/ coil 46 housing (ovalization)	x					waiting for results of ASG investigation at its premises