

Nonconformance # N-00089		Created by Broadbent, Andrew on Feb 14, 2018 10:09:52 AM	
Initiation	Disposition Recommendation	Quality Representative Concurrence	Final Disposition
		Access Control	All Tabs

Initiation

Last Comment

Broadbent, Andrew [2569], Feb 15, 2018 5:20:08 PM, Final Disposition:

NC Number N-00089	Created by Broadbent, Andrew	Created on Feb 15, 2018
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GENERAL INFORMATION

Source of Nonconformance Equipment	Mode of Discovery In-Process	Receipt Type BNL Production
Discovered by Broadbent, Andrew	Phone Extension 631/344-7103	Discovery Date Feb 14, 2018 10:10:00 AM
Affected Department Photon Sciences Department	Dept Quality Representative NSLS II QReps	
Owner Broadbent, Andrew	Owner's Phone 631/344-7103	Owner's Department Photon Sciences Department
Type of Nonconformance Out of Spec/Tolerance		
General Item Description Various small survey discrepancies on SST beamline radiation safety components		
Description of Nonconformance		
<ol style="list-style-type: none"> 1. Mask 1: L-branch inboard aperture edge is 1mm wider than specified. 2. SBS#1: width is 5mm less than specified and height is ~5mm less than specified. 3. WBS: height of the back edge of the stop is greater than specified. This is good. 4. BSS: positioned further inboard than specified by 3mm, and this is 1mm low. 5. SBS#2: width is 5mm less than specified and height is ~5mm less than specified, and Z is 5mm upstream. 6. BRS: Width is 2mm greater than designed, primarily on the inboard side. 7. FM3: Installed 50 microns high. 8. PBS on L-branch: tope edge is 600 microns high. 9. FM4: Mis-positioned by 5 microns 10. PGM ZOM: Vertical aperture is smaller than designed. 11. PGM Mis-steer mask: Bottom edge is 600 microns low. 		
Quantity Delivered 1	Quantity with NC 1	

ITEM INFORMATION

General Item Information

Supplier Name	Supplier Name 2
Requisitioner	Item Type / Category
Vendor Item ID	
Lot # / Serial #	Supplier Part #
BNL Part #	
Manufacturer	Rev Level
Attachments	

PROJECT INFORMATION

Select a Project
SSTBMM

WBS Number
7.02.01

WBS Description
SST 1&2 Management

WBS Project Manager
Broadbent, Andrew

PM Phone Extension
631/344-7103

PM E-mail Address
broadbent@bnl.gov

Level 2 Cost Account Manager
Zhong, Zhong

CAM Phone Extension
631/344-2117

CAM E-mail Address
zhong@bnl.gov

Traveler #

Traveler Rev

Traveler Operation #

Disposition Recommendation

DISPOSITION RECOMMENDATION INFO

Disposition Recommended By
Broadbent, Andrew

Recommendation Date
Feb 15, 2018

Disposition Type Section

Disposition Type Use As Is (UAI)	Quantity 1
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Justification

1. Mask 1: L-branch inboard aperture edge is 1mm wider than specified. Use as-is. Simple analysis of the ray tracing indicates that the extremal ray hitting the WBS moves 1mm towards the aperture from 6.8mm. This is ok.
2. SBS#1: width is 5mm less than specified and height is ~5mm less than specified. Use as-is. Calculation performed by S Chitra indicates this is acceptable.
3. WBS: height of the back edge of the stop is greater than specified. Use as-is. This is acceptable since the height of the downstream back edge / top of the stop is greater than designed: beam passes to the side, no adverse impact. The lateral location is also misplaced by 160 microns which is acceptable given the dimensions of the stop, the beam size and the clearances to the apertures.
4. BSS: positioned further inboard than specified by 3mm, and this is 1mm low. Use as-is up to 125mA. Calculation performed by Sunil Chitra indicates this is acceptable, higher currents may be acceptable following further analysis.
5. SBS#2: width is 5mm less than specified and height is ~5mm less than specified, and Z is 5mm upstream. Use as-is. Calculation performed by S Chitra indicates this is acceptable.
6. BRS: Width is 2mm greater than designed, primarily on the inboard side. Use as-is: this is oversized and acceptable. Inboard bottom corner is also lower (60 microns) than specified and so provides additional shielding.
7. FM3: Installed 50 microns high. Use as-is. This mask ensures that beam hits the DCM first crystal, this position error is still acceptable given the beam and DCM crystal size.
8. PBS on L-branch: top edge is 600 microns high. Use as-is. This provides additional clearance from the beam to the edge of the stop, but will not impede the exiting monochromatic beam.
9. FM4: Mis-positioned by 5 microns. Use as-is. Such a small adjustment is not feasible and is within the measurement error. This will not create problems for the PGM (beam size ~10mm).
10. PGM ZOM: Vertical aperture is smaller than designed, bottom edge is higher by 2.7mm. Use as-is. The ZOM lower edge has no impact on the transmitted rays and a smaller aperture is acceptable. X direction is 200 microns misplaced to make the aperture smaller. This is acceptable.
11. PGM Mis-steer mask: Bottom edge is 600 microns low. Use as-is. analysis of the ray tracing with M2 at minimum value of 1 degree indicates this is not a problem.

Attachment(s)

Total Quantity with NC
1

Responsible for Nonconformance
 BNL Supplier

Significance of Defect

Is CAPA Required?
 Yes
 No

Is SCAR Required?
 Yes
 No

Comments

Quality Representative Concurrence

QUALITY REPRESENTATIVE INFO

Please review the information contained in the sections labeled "Initiation", and "Disposition Recommendation" by clicking on the tabs above. Return to this tab to record your concurrence.

Concurrence

- Concur
- Recommend Adjustments

Comments

Final Disposition

FINAL DISPOSITION INFO

CAPA Link

SCAR Link

Close Nonconformance

Date Closed

Comments

Attachment(s)

Access Control

Phase Tracking

Assigned To	Phase	Submitted Date	Due Date	Completed Date	Due Date Extension/Reassignment Link
Broadbent, Andrew	Initiation	Feb 14, 2018	Feb 22, 2018	Feb 14, 2018	
Broadbent, Andrew	Disposition Recommendation	Feb 14, 2018	Feb 22, 2018	Feb 14, 2018	
Cheswick, Edward Zipper, Joseph	Quality Representative Concurrence	Feb 14, 2018	Feb 22, 2018	Feb 14, 2018	
Chitra, Sunil	Additional Approvals	Feb 14, 2018	Feb 22, 2018	Feb 15, 2018	
Cheswick, Edward Zipper, Joseph	Quality Representative Concurrence	Feb 15, 2018	Feb 23, 2018	Feb 15, 2018	
Chitra, Sunil	Additional Approvals	Feb 15, 2018	Feb 23, 2018	Feb 15, 2018	
Broadbent, Andrew	Final Disposition	Feb 15, 2018	Feb 23, 2018	Feb 15, 2018	
	Closed	Feb 15, 2018		Feb 15, 2018	

Additional Document Security

Last Edited by Broadbent, Andrew on Feb 15, 2018 5:20:08 PM