

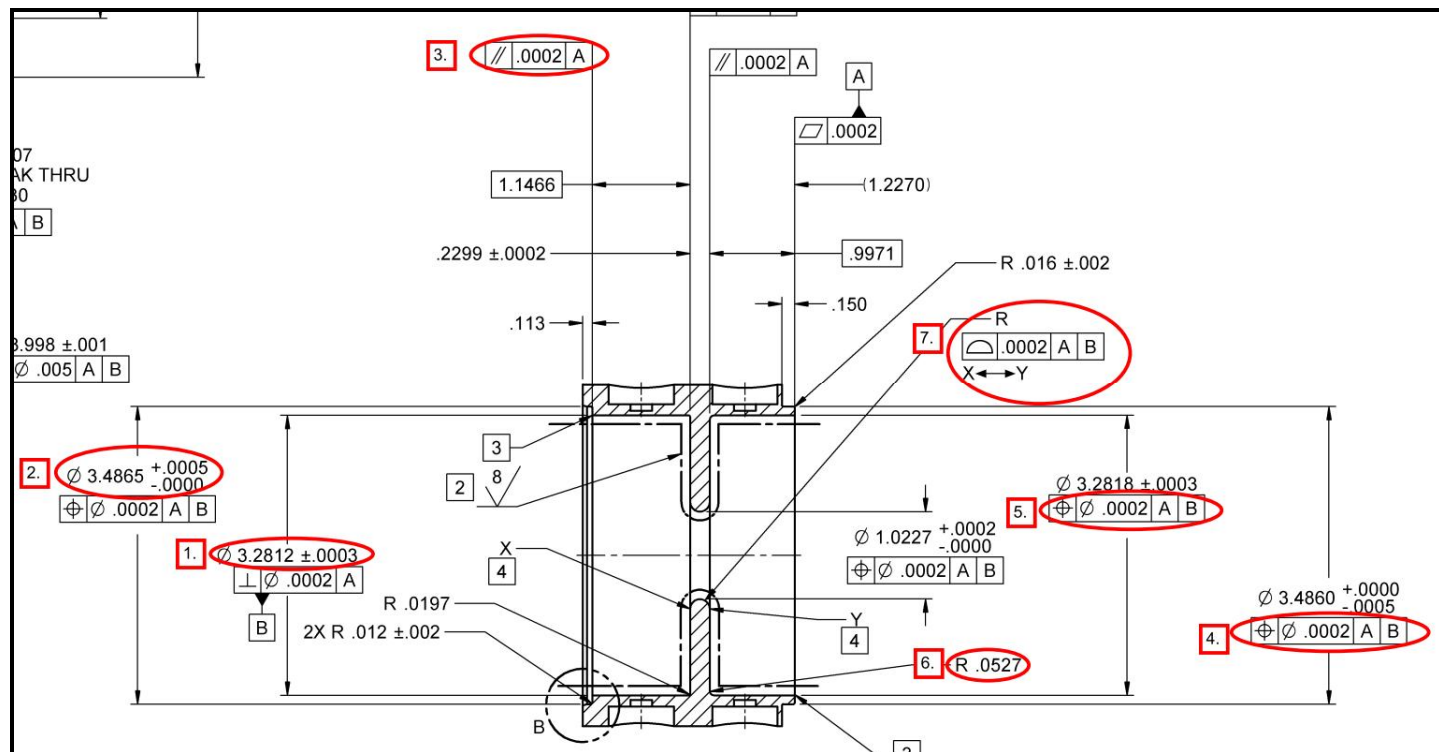
NONCONFORMANCE REPORT (NCR)

SUBSYSTEM MFD 28932-28	DESCRIPTION OF ITEM CUP 4A/4B	DATE 11/07/12
ORIGINATOR K. Caban	PART NO. & REV. PF-380-805-11 R2	SERIAL NO.(s) 101

NONCONFORMANCE DESCRIPTION

Nonconformance Description (Describe the nonconformance; ensure the applicable requirements, planned activities, procedures, specifications, drawing, standards, serial numbers, etc. are noted. Indicate who documented the nonconformance.)

1. Diameter 3.2812 ± 0.0003 measures 3.28078 (-0.00012 " undersized).
2. Diameter $3.4865 + 0.0005 / - 0.0000$ measures 3.48630 (-0.00020 " undersized).
3. Parallelism $.0002$ of distance 1.1466 measures 0.00024 ($+0.00004$ " out of parallel).
4. Position of 0.0002 of Diameter 3.4860 measures 0.00027 ($+0.00007$ " out of position).
5. Position of 0.0002 of Diameter 3.2818 measures 0.00025 ($+0.00005$ " out of position).
6. Radius $.0527 \pm 0.0005$ measures 0.05110 (-0.00110 " undersized).
7. Profile 0.0002 X-Y is out of surface profile (see attached profile plot).



DISPOSITION

Disposition: (Describe for each cause what action(s) will be taken with the item or process, including, as applicable, the completion dates, disposition of material, and responsible staff for each action. The completion dates, disposition of material, and responsible staff for each action.)

CORRECTIVE/PREVENTIVE ACTION

| ASSIGNED TO:

Corrective/Preventive Action: Describe, as applicable, what actions are needed to prevent recurrence of the identified nonconformance, such as process improvement, procedure revisions, training plan, etc., and include completion dates and responsible staff for each action.)

FOLLOW-UP REQUIRED: ρ Yes ρ No

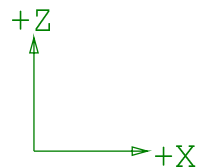
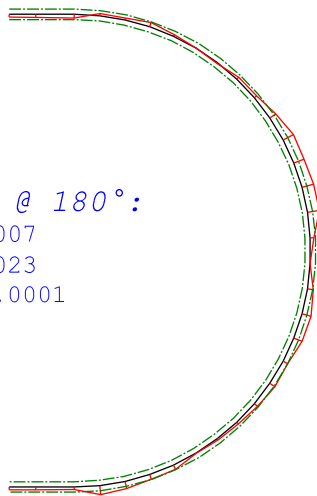
NCR CLOSEOUT APPROVALS

LCLS-II TECHNICAL REPRESENTATIVE	DATE	LCLS-II QUALITY ASSURANCE	DATE
FOLLOW UP EFFECTIVE ρ Yes ρ No	FOLLOW UP BY:		DATE

XZ PLANE

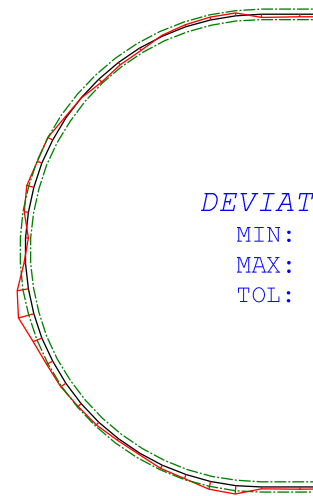
DEVIATIONS @ 180°:

MIN: -0.00007
MAX: 0.00023
TOL: +/- 0.0001



DEVIATIONS @ 0°:

MIN: -0.00008
MAX: 0.00030
TOL: +/- 0.0001

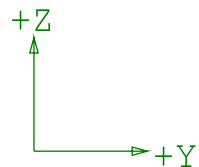
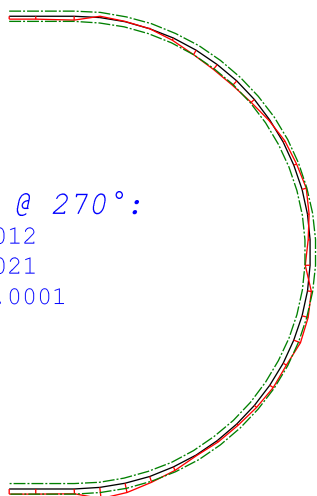


IRIS 2D-XZ DIST.: 1.02274

YZ PLANE

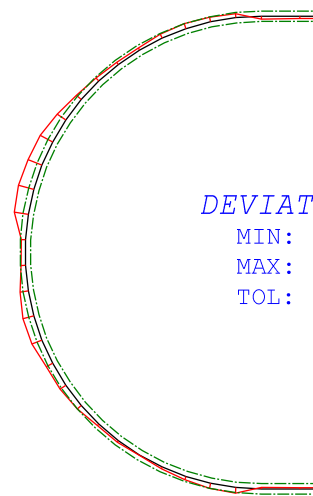
DEVIATIONS @ 270°:

MIN: -0.00012
MAX: 0.00021
TOL: +/- 0.0001



DEVIATIONS @ 90°:

MIN: -0.00005
MAX: 0.00030
TOL: +/- 0.0001



IRIS 2D-YZ DIST.: 1.02277



IRIS PROFILE
DRAWING NO.: PF-380-805-11 R2
SERIAL NO.: 101

BLACK = NOMINIAL
RED = ACT-NOM CRV
GREEN = TOLERANCE
INSP.: kcaban
05-NOV-2012