



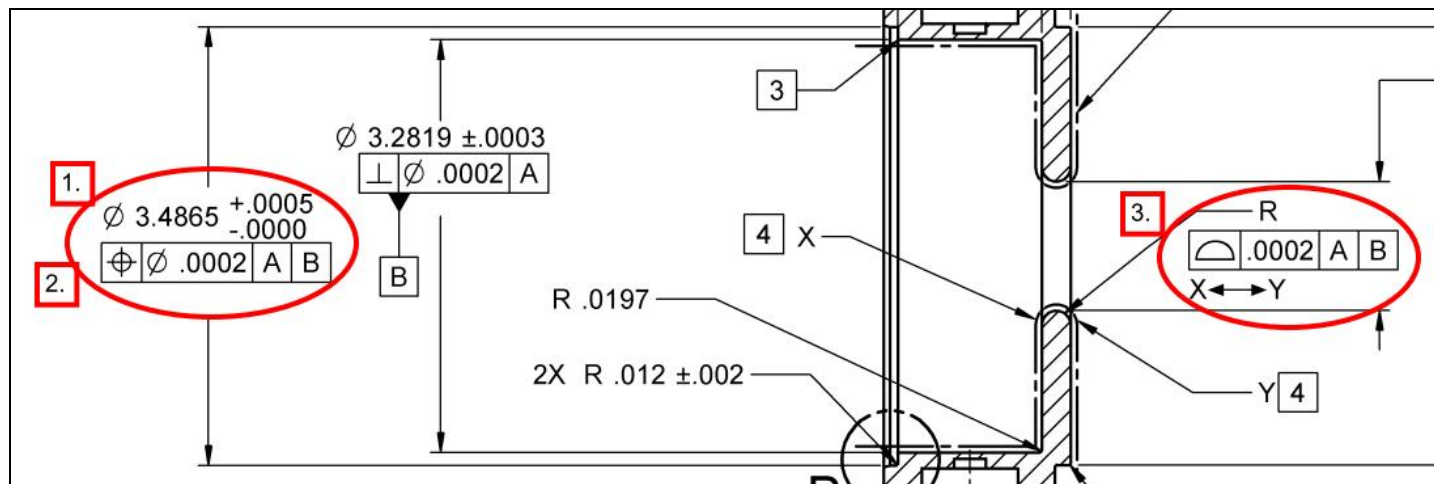
## NONCONFORMANCE REPORT (NCR)

SUBSYSTEM MFD 28932-27	DESCRIPTION OF ITEM CUP 3	DATE 11/02/12
ORIGINATOR K. Caban	PART NO. & REV. PF-380-805-20 R1	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  $3.4865 +0.0005/-0.0000$  measures  $3.48646 (-0.00004$ " undersized).
2. Position of  $0.0002$  of Diameter  $3.4865$  measures  $0.00029 (+0.00009$ " out of position).
3. 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

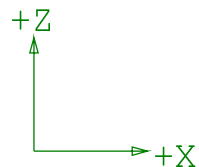
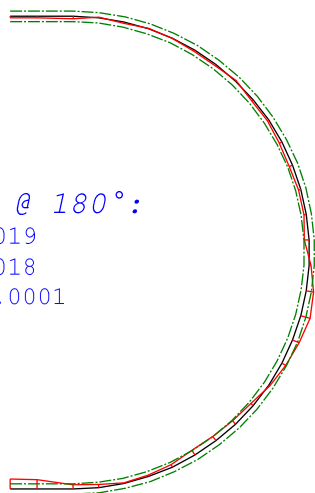
FOLLOW UP BY:

DATE

# XZ PLANE

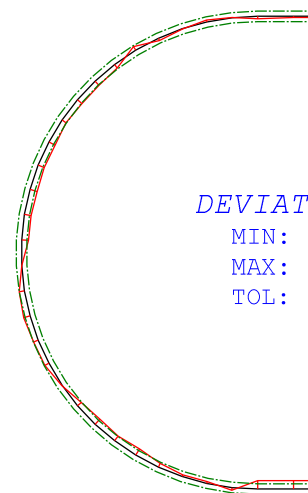
DEVIATIONS @ 180°:

MIN: -0.00019  
MAX: 0.00018  
TOL: +/- 0.0001



DEVIATIONS @ 0°:

MIN: -0.00016  
MAX: 0.00013  
TOL: +/- 0.0001

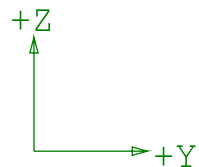
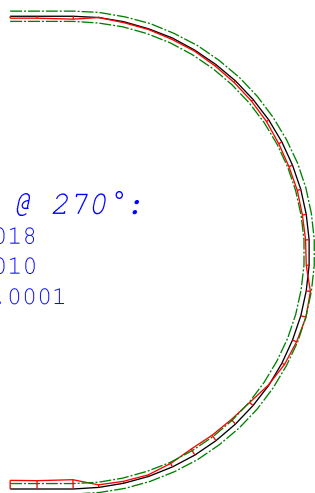


IRIS 2D-XZ DIST.: 1.02508

# YZ PLANE

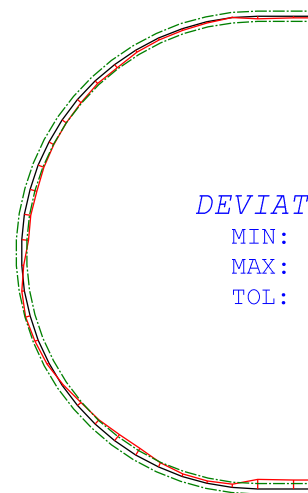
DEVIATIONS @ 270°:

MIN: -0.00018  
MAX: 0.00010  
TOL: +/- 0.0001



DEVIATIONS @ 90°:

MIN: -0.00018  
MAX: 0.00009  
TOL: +/- 0.0001



IRIS 2D-YZ DIST.: 1.02517



IRIS PROFILE  
DRAWING NO.: PF-380-805-20 R1  
SERIAL NO.: 101

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