

The purpose of this form is to provide SLAC with a brief summary of deviations from drawings or specifications for each undulator assembly being delivered by ANL.

Undulator Assembly No. 3

Name of Assembly Organization: Hi-Tech Manufacturing Inc.

ANL PO#: 5A-13624

No.	Deviation	Reported by	Reporting method	Disposition	Disposition by
1	(4) 5/16-18 mounting holes on top of part are tapped M8.	Dial Machine, S. Lewis	Supplier Disposition Request #4	Rework and replace with 5/16-18 Helicoil inserts.	G. Lawrence
2	The outside diameter of the Strongback is 2.8 MM oversize.	Dial Machine, S. Lewis	Supplier Disposition Request #5	Accept as is.	G. Lawrence
3	The 11.050 mm location of one mounting pad is 11.055 mm.	Dial Machine, S. Lewis	Supplier Disposition Request #6	Dust mill to correct location.	G. Lawrence
4	<p>The supplier has not provided certification that the forgings have been inspected or tested in accordance with ASTM B381 Grade F2 as required by section 4.1.1 of the SOW.</p> <p>The supplier has not provided certification that the forgings were annealed according to AMS-H-81200A or provided copies of the temperature profiles as required by section 4.1.2.2 of the SOW.</p> <p>The heat number on the mill certificate provided by the supplier is not clear because the language on the mill certificate is Russian.</p>	T. Barsz, LCLS QA	ANL Report of Nonconformance #473	<p>Accept as is. Supplier unable to provide certification or reconcile in accordance with the SOW. The SOW calls for a forging made from, the Dial's material was forged from a bar material and should have no effect.</p> <p>Accept as is.</p> <p>Accept as is. T. Barsz reviewed the mill certificate with E. Trakhtenberg and found it to be acceptable.</p>	<p>G. Lawrence</p> <p>G. Lawrence</p> <p>T. Barsz</p>