

Users to complete steps 1-27 and distribute in accordance with line 1. Note: Signatures are not required if this document is distributed via an review process. Contact LCLS QA Rep. Tom Barsz at 630-252-9177 for assistance.

1. REPORT DISTRIBUTION: T.Barsz, M. Oprondek, M. White, E. Trakhtenberg, G. Lawrence

		2. Report Date 1/23/2007	3. REPORT NO: 491
Report of Nonconformance		4. PAGE <u>1</u> of <u>1</u>	
5. ITEM, SERVICE, OR PROCESS Strongback Machining Inspected by Hi-Tech		6. BUILDING & ROOM WHERE INSPECTED Hi-Tech Mfg.	
7. PROJECT NO. UN33_DL087	8. SYSTEM or ACTIVITY NAME Undulator System	9. DRAWING OR PART NO. L143-100700-07	10. REJECTION CRITERIA Drawing
12. LOT SIZE 15	13. SAMPLE SIZE 1	14. QTY. ACCEPTED 1	15. QTY. NOT ACCEPTED 0
19. SUPPLIER NAME Dial Machine, Inc		16. P.O. NUMBER 5A-04889	17. P.O. LINE #'s 1
		11. REQ./ACL NO. E5-020020.1	
21. ITEM NO.	22. NONCONFORMANCE CONDITIONS (Brief statement of fact describing the conflict with contract requirements)	23. ACTIONS TO BE TAKEN ON NONCONFORMANCE (ex: "Accept As Is", "Reject", "Return", "Rework", "Reinspect", or other)	
1	The 4X 60.0 +0.1/-0 mm dimension is up to .24 mm undersize at 2 locations.	<i>Accept as is. LCLS to arrange for rework of the mating parts to accommodate the undersized conditions. Request ANL Buyer to enter a receiving exception to prevent payment of Dial Machine and to investigate the possibility of receiving monetary compensation from Dial</i>	
2	The 2X 30.0 +.0/-0.1mm hole locations are up to .02 mm undersize.	<i>Same as item 1.</i>	

<i>Simon Sorsher</i>	<u>12/6/2006</u>
24. NAME OR SIGNATURE OF PERSON WHO DISCOVERED NONCONFORMANCE CONDITION	DATE
<i>E. Trakhtenberg</i>	<u>11/28/2006</u>
25. NAME OR SIGNATURE OF PERSON WHO PROVIDED ACTIONS TO BE TAKEN	DATE
<i>M. White</i>	<u>12/5/2006</u>
26. NAME OR SIGNATURE OF RESPONSIBLE LCLS ACCOUNT MANAGER	DATE
<i>T. Barsz</i>	<u>11/29/2006</u>
27. NAME OR SIGNATURE OF PROJECT LCLS QUALITY ASSURANCE COORDINATOR	DATE

28. REINSPECTION REQUIRED <input type="checkbox"/>	QTY. ACC	QTY. NOT ACCEPTED	NEW REPORT NO.	BLDG./ROOM	RE-INSPECTED BY/DATE
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29. CAUSE OF NONCONFORMANCE: Cause External to LCLS **Cause Internal to LCLS**

Machining error caused by Dial Machine and failure by ANL to include a request for the supplier to document all inspections in the Statement of Work. ANL to request Hi-Tech and Metalex to inspect for the the nonconforming conditions on existing Strongbacks at their facilities. ANL to perform or witness dimensional inspection of the 60.00 mm dimension when accepting Undulator Assemblies from now on.

<i>T. Barsz</i>	<u>12/1/2006</u>
SIGNATURE OR NAME OF PERSON WHO IDENTIFIED CAUSE	DATE