SUPPLIER DISPOSITION REQUEST (SDR)

(Form ANL-311 includes instructions and continuation sheet.)

Page 1 of 1

(CHECK ONE)

☐ 1A. Deviation Request

☑ 1B. Nonconformance Action Request

2. SDR No. 3801-005

3. SDR Date 10/14/2005

4. Supplier Name, Address, Telephone, Fax

Metalex Manufacturing, Inc.
5750 Cornell Road
Cincinnati, OH 45242
(513) 489-0507
(513) 489-3128 ATTN: Todd Caudill

5. Purchase Order No. 5A-06990

6. Related Documents

6.1 L143-110700 Rev. 07 Date 09/21/2005

Part Number: L143-110700 Part Name: Strongback

Serial Number: 5A-06990-02

7. Qty.	8. Describe Nonconforming Condition	9. Identify Requirement	10. Cause & Corrective Action
1	Break edge around 15.0 mm counterbore (Zone E1), measures 0.5 mm (.2 mm oversize) 134 places.	Drawing note #2 remove all burrs & break sharp edges .3 mm max	TBD
	Slot checks 167.043 - 167.053 (.003 mm oversize)	167.00 mm +.05/-.00 Dwg L143-11070(Zone C2)	TBD
	True position checks .1 mm - .22 mm (up to .12 mm out of position) 14 places.	.1 mm true position Dwg L143-11070(Zone D8)	TBD
	(2) M6 x 1.0 tapped holes accept NO-GO gage (snug fit) located on Datum -C- end of shaft 2 places.	M6 x 1.0 mm -6H Dwg L143-11070(Zone C2)	TBD
	Counterbores depth "too deep". C'bores located on 56 basic check 28.90 mm (.3 mm too deep) & 32.00 dim. check 29.41 mm (.81 mm too deep). Note: 304.8 dia. currently checks 306.07 - 306.17.	28.4 mm +/- .2 mm Dwg L143-11070(Zone E1)	TBD TBD

SUPPLIER'S COMMENTS (IF YES, EXPLAIN):

11. Affects Form, Fit or Function

☑ Yes ☐ No To be determined by ANL

12. Affects Price

☐ Yes ☑ No

13. Affects Delivery

☐ Yes ☑ No

14. Recommended Disposition and Comments:

[signature] Project Manager 10/17/05

15. SUPPLIER REPRESENTATIVE – TITLE – DATE

16. ANL REPRESENTATIVE – DATE

17. ANL Disposition and Remarks: Accept these first article deviations only

18. Approved

[signature] 10/17/05

TECHNICAL REPRESENTATIVE – DATE

[signature] 10/17/05

QUALITY ASSURANCE REPRESENTATIVE – DATE

[signature] 10/17/05

PROCUREMENT REPRESENTATIVE – DATE

ANL-311 (4-94)

Job Number: 2005-3801
Customer: Argonne Nat'l Laboratory
Drawing: L143-110700
Part Name: STRONGBACK,ARGONNE N.LAB
Qty Rej: 1 of 1 Oper#: 130
S/N(s): 5A06990-02

NCR#: NCR-0004640
Customer NCR#:
Issued By: HUBBARD, BRUCE
Date Found: 10/17/2005
Owned By: HUBBARD, BRUCE
Sub-tier PO#:

Router# 3024926
Job No. 2005-3801
Drawing/Part No. NCR-0004640

Specifications
Blueprint: .3mm max edge break on entire part
Actual: Edge break measures .5mm around 15mm c'bores
Additional: Operator deburred with pc. of carbide

Loc Found: Final Inspection
Est Repl Hrs: 1.00
Est Matl Cost:

Employee(s) Cause Codes	Cause Descriptions	Emp#	Initial	Location Generated
CHHOEUN, CHHAN		458		Deburr and Stamp
ICI	Not Lean MFG. - Failed to follow print, router, or work instr/De			

Business Unit Leader Signoff: Cell Leader Signoff:

Disposition: submit Disposition Tag Attached: N/A

Comments

DISPOSITION WORK INSTRUCTIONS

00003 DEFAULT NONCONFORMANCE OPERATION

Work Instructions
deviation has been submitted to customer

Work Completed by: Date:

Corrective Action

Job Number: 2005-3801
Customer: Argonne Nat'l Laboratory
Drawing: L143-110700
Part Name: STRONGBACK ARGONNE N.LAB
Qty Rej: 1 of 1 Oper#: 130
S/N(s): 5A06990-02

NCR#: NCR-0004640
Customer NCR#:
Issued By: HUBBARD, BRUCE
Date Found: 10/17/2005
Owned By: HUBBARD, BRUCE
Sub-tier PO#:

Router#	Job No.	Drawing/Part No.
3024926	2005-3801	NCR-0004640

Corrective Action

Operator instructed to use a wood wheel to break edges around c.bore's instead of carbide

**IF YOU HAVE ANY QUESTIONS REGARDING THESE WORK INSTRUCTIONS CONTACT THE ISSUED BY OR OWNER LISTED ABOVE

Job Number: 2005-3801
Customer: Argonne Nat'l Laboratory
Drawing: L143-110700
Part Name: STRONGBACK,ARGONNE N.LAB
Qty Rej: 1 of 1 Oper#: 120
S/N(s): 5A06990-02

NCR#: NCR-0004641
Customer NCR#:
Issued By: HUBBARD, BRUCE
Date Found: 10/17/2005
Owned By: HUBBARD, BRUCE
Sub-tier PO#:

Router#	Job No.	Drawing/Part No.
3024927	2005-3801	NCR-0004641

Specifications

Blueprint: 1.)167.043 -.05/-.00 slot size (zone C-2)
2.).1mm true position of M6 tapped holes (zone D-8)
3.)M6 X 1.0 tapped holes (6X) (zone C-2)
4.)28.4mm +/- .2mm depth of c'bores (zone E-1)

Actual: 167.043 - 167.053 (.003mm oversize)
.1mm - .22mm true position up to .12 out of location.
2 tapped holes accept NO-GO gage
c'bores located on 56mm basic check 28.9 (.3mm too deep)
32.00mm dim checks 29.41 (.81mm too deep)

Additional: 1.) slot size being over is due to first pc. learnings.
2.) .1mm true position of M6 tapped holes being out of tolerance is because a drill was used instead of an endmill.
3.) M6 tapped holes that the threads are oversize is currently undetermined.
4.) 28.4 c'bore depth being to deep on the holes located at 32mm is due to tool being set wrong by .3mm. & the holes located at 56mm is because the program came off center of roll instead of o.d.

Loc Found: Final Inspection

Est Repl Hrs: 4.00
Est Matl Cost:

Employee(s)	Emp#	Initial	Location Generated
VOGLER, BRETT R	657		Horizontal Boring Mill

Cause Codes	Cause Descriptions
R10	Other/Define

Business Unit Leader Signoff: Cell Leader Signoff:

Disposition: submit Disposition Tag Attached: N/A

Comments

DISPOSITION WORK INSTRUCTIONS

#0000#)DEFAULT NONCONFORMANCE OPERATION

Job Number: 2005-3801
Customer: Argonne Nat'l Laboratory
Drawing: L143-110700
Part Name: STRONGBACK.ARGONNE N.LAB
Qty Rej: 1 of 1 Oper#: 120
S/N(s): 5A06990-02

NCR#: NCR-0004641
Customer NCR#:
Issued By: HUBBARD, BRUCE
Date Found: 10/17/2005
Owned By: HUBBARD, BRUCE
Sub-tier PO#:

Router# 3024927

Job No. 2005-3801

Drawing/Part No. NCR-0004641

Work Instructions
Deviations have been submitted to customer.

Work Completed by: _____ Date: _____

Corrective Action
1.)Operator learned on the slot size that all is needed to bring into print is to take a spring pass after he finishes the slot. Operator made note of this in lear learnings manual
2.)Program was updated by Konrad on 10/14/05 to use an endmill instead of a drill for the M6 tapped holes (14X).
3.)Chip possibly loaded up on tap while tapping the 2 M6 holes. All other holes were good. No corrective action needed.
4.)Operator instructed to check all tool lengths on the c'bore holes & always check the first hole, to verify everything is set correctly.

**IF YOU HAVE ANY QUESTIONS REGARDING THESE WORK INSTRUCTIONS CONTACT THE ISSUED BY OR OWNER LISTED ABOVE