Discrepancy Reports - By Serial No. LQXB01

DR Number	*Device SN* *Subassembly 1 SN* *Subassembly 2 SN* *Assembly SN*	*Discrepancy Description*	*Originator* *Date* *Disposition by* *Date*	*Disposition Verified by* *Date* *Reviewed by* *Date*	*DR Classification* *1-Material* *2-Manpower* *3-Method* *4-Machine* *5-Measurement*
HGQ-0164	MQXBO-019 MQXB01 LQXB01	THE OUTER WEDGE ASSEMBLY MC-369692 USES A 220 WEDGE INSTEAD OF PRECUT WEDGES	Paul Mayer 1/26/2001 Rodger Bossert 1/26/2001	 Bob Jensen 2/26/2001	3
HGQ-0168	MQXBI-021 MQXB01 LQXB01	THE INNER WEDGE MC- 369393 USES 220 WEDGE INSEAD OF PERCUT WEDGE	Paul Mayer 1/26/2001 Rodger Bossert 1/26/2001	 Bob Jensen 2/26/2001	3
HGQ-0169	MQXBI-022 MQXB01 LQXB01	THE INNER WEDGE MC-369693 USES 220 WEDGE INSTEAD OF PRECUT WEDGE	Paul Mayer 1/26/2001 Rodger Bossert 1/26/2001	 Bob Jensen 2/26/2001	3
HGQ-0171	LHC-3-A00774 LQXB01	A dent in the Cable at 661'	Jim Rife 2/20/2001 Rodger Bossert 2/20/2001	 Bob Jensen 2/26/2001	3
HGQ-0183	MQXBi-021 MQXB01 LQXB01	Cable for this coil had been previously insulated to the insulation scheme detailed in the traveler. Due to the cured inner coil size change the cable will be stripped of insulation and re-insulated to a new scheme.	Jim Rife 3/30/2001 Rodger Bossert 3/30/2001	 Bob Jensen 4/16/2001	3
HGQ-0184	MQXBi-022 MQXB01 LQXB01	Cable for this coil had been previously insulated to the insulation scheme detailed in the traveler. Due to the cured inner coil size change the cable will be stripped on insulation and re-insulated to a new scheme.	Jim Rife 3/30/2001 Rodger Bossert 3/30/2001	 Bob Jensen 4/16/2001	3

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DR Number	*Device SN* *Subassembly 1 SN* *Subassembly 2 SN* *Assembly SN*	*Discrepancy Description*	*Originator* *Date* *Disposition by* *Date*	*Disposition Verified by* *Date* *Reviewed by* *Date*	*DR Classification* *1-Material* *2-Manpower* *3-Method* *4-Machine* *5-Measurement*
HGQ-0185	MQXBi-021 MQXB01 LQXB01	The preform on this insulated unit length of cable will be cut off and re-made after cable is re-insulated to new insulation scheme.	Jim Rife 3/30/2001 Jim Rife 3/30/2001	 Bob Jensen 4/16/2001	3
HGQ-0186	MQXBi-022 MQXB01 LQXB01	The preform on the insulated unit length of cable will be cut off and re-made after cable is re-insulated to new insulation scheme.	Jim Rife 3/30/2001 Rodger Bossert 3/30/2001	 Bob Jensen 4/16/2001	3
HGQ-0187	MQXBi-021 MQXB01 LQXB01	The wedges for this assembly had been previously insulated to the scheme detailed in the traveler. Due to an insulation scheme change the wedges will be stripped of insulation and re-insulated to a new scheme.	Jim Rife 3/30/2001 Rodger Bossert 3/30/2001	 Bob Jensen 4/16/2001	3
HGQ-0188	MQXBi-022 MQXB01 LQXB01	The wedges for this assembly had been previously insulated to the scheme detailed in the traveler. Due to an insulation scheme change the wedges will be stripped of insulation and re-insulated to a new scheme.	Jim Rife 3/30/2001 Rodger Bossert 3/30/2001	 Bob Jensen 4/16/2001	3
HGQ-0190	MQXBi-022 MQXB01 LQXB01	Inner part of shrink wrapped section of lead has discolored areas.	Damon Bice 4/17/2001 Rodger Bossert 4/17/2001	 Jamie Blowers 7/5/2001	1
HGQ-0192	MQXBo-019 MQXB01 LQXB01	The pressure on the lower pressure gauge was -3000 psi.	Donald Nurczyk 4/18/2001 Rodger Bossert 4/18/2001	 Bob Jensen 6/5/2001	3

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HGQ-0193	MQXBi-023 MQXB01 LQXB01	Copper stabilizer of double lead ruined while removing from soldering fixture. Superconducter side also slightly disformed.	Damon Bice 4/23/2001 Rodger Bossert 4/23/2001	 Bob Jensen 6/5/2001	3
HGQ-0194	MQXBi-023 MQXB01 LQXB01	The kapton insulation had many shorts during the insulating process. From 37' to 120' was the problem area.	Steve Gould 4/23/2001 Rodger Bossert 4/23/2001	 Jamie Blowers 7/5/2001	3
HGQ-0195	MQXBi-023 MQXB01 LQXB01	Inner section of ramp up insulation was cut.	Damon Bice 4/25/2001 Rodger Bossert 4/25/2001	 Bob Jensen 6/5/2001	3
HGQ-0196	MQXBi-024 MQXB01 LQXB01	Due to non functional maesurment table, these measurements were performed using a measuring tape.	Damon Bice 5/8/2001 Rodger Bossert 5/8/2001	 Bob Jensen 6/5/2001	5
HGQ-0197	MQXBo-022 MQXB01 LQXB01	Due to coil size data discrepancies this coil was re-measured per step 5.0 in traveler.	Jim Rife 5/10/2001 Rodger Bossert 5/10/2001	 Bob Jensen 6/5/2001	5
HGQ-0198	MQXBi-021 MQXB01 LQXB01	Due to non functional measurement table, these measurements were performed using a measuring tape and caliper.	Steve Gould 5/11/2001 Rodger Bossert 5/11/2001	 Bob Jensen 6/5/2001	5

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DR Number	*Device SN* *Subassembly 1 SN* *Subassembly 2 SN* *Assembly SN*	*Discrepancy Description*	*Originator* *Date* *Disposition by* *Date*	*Disposition Verified by* *Date* *Reviewed by* *Date*	*DR Classification* *1-Material* *2-Manpower* *3-Method* *4-Machine* *5-Measurement*
HGQ-0199	MQXBi-022 MQXB01 LQXB01	During the lead end end compression test, a drop in resistance was noticed at 3300 pump pressure and progressively got worse to the allotted pressure allowed. There seems to be a turn to turn short on this coil. The "Q" reading also affirms this problem. The short was	Steve Gould 5/14/2001 Rodger Bossert 5/14/2001	 Bob Jensen 6/5/2001	5
HGQ-0200	MQXBi-023 MQXB01 LQXB01	On the b-side of the coil 6' 7" to 6' 10", the outer layer of the cable insulation is cut and peeling up. Also the power lead has pulled away from the coil on the lead end.	Steve Gould 5/15/2001 Rodger Bossert 5/15/2001	 Jamie Blowers 7/5/2001	3
HGQ-0201	MQXBo-021 MQXB01 LQXB01	Measuring table not functional. Measure by measuring tape.	Damon Bice 5/15/2001 Rodger Bossert 5/15/2001	 Bob Jensen 7/18/2001	4
HGQ-0202	MQXBo-022 MQXB01 LQXB01	Measuring table not functional. Have to measure using measuring tape.	Damon Bice 5/15/2001 Rodger Bossert 5/15/2001	 Bob Jensen 7/18/2001	4
HGQ-0204	MQXBi-022 MQXB01 LQXB01	As a result of numerous end compressions to locate and identify suspected turn to turn short per DR #HGQ-0199 the coil has the following: A. Numerous pin holes in cable insulation as a result of turn to turn resistance testing, (underside of coil lead end)	Jim Rife 5/21/2001 Rodger Bossert 5/21/2001	 Bob Jensen 6/5/2001	5
HGQ-0205	MQXBi-025 MQXB02 LQXB01	Had to resize coil due to variance in the resistance that was seen around 150" from the end of the return end saddle	Damon Bice 5/23/2001 Rodger Bossert 5/23/2001	 Jamie Blowers 8/13/2001	5

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DR Number	*Device SN* *Subassembly 1 SN* *Subassembly 2 SN* *Assembly SN*	*Discrepancy Description*	*Originator* *Date* *Disposition by* *Date*	*Disposition Verified by* *Date* *Reviewed by* *Date*	*DR Classification* *1-Material* *2-Manpower* *3-Method* *4-Machine* *5-Measurement*
HGQ-0206	MQXBi-021 MQXB01 LQXB01	Step 7.0 reflects the installation of voltage taps. Voltage taps are not to be installed on this coil.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 7/18/2001	3
HGQ-0207	MQXBi-021 MQXB01 LQXB01	End shimming on end saddles on both lead and return ends to be modified. The last approx. 1/2" towards the ends of the coils to be cut off.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 6/5/2001	3
HGQ-0208	MQXBi-022 MQXB01 LQXB01	Step in the traveler dictates to install voltage taps. Voltage taps will not be installed on this coil.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 6/5/2001	3
HGQ-0209	MQXBi-023 MQXB01 LQXB01	Step 7.0 dictates the installation of voltage taps. Voltage taps are not to be installed on this coil.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 6/5/2001	3
HGQ-0210	MQXBi-024 MQXB01 LQXB01	Step 7.0 dictates the installation of voltage taps. Voltage taps are not to be installed on this coil.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 6/5/2001	3
HGQ-0211	MQXBi-022 MQXB01 LQXB01	End shimming on end saddles on both lead and return ends of coil to be modified. The last approx. 1/2" towards the ends of the coil to be removed.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 6/5/2001	3

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DR Number	*Device SN* *Subassembly 1 SN* *Subassembly 2 SN* *Assembly SN*	*Discrepancy Description*	*Originator* *Date* *Disposition by* *Date*	*Disposition Verified by* *Date* *Reviewed by* *Date*	*DR Classification* *1-Material* *2-Manpower* *3-Method* *4-Machine* *5-Measurement*
HGQ-0212	MQXBi-023 MQXB01 LQXB01	End shimming on end saddles on both lead and return ends of coil to be modified. The last approx 1/2" of insulation towards the ends of the coil to be removed.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 6/5/2001	3
HGQ-0213	MQXBi-024 MQXB01 LQXB01	End shimming on end saddles on both lead and return ends of coil to be modified. The last approx. 1/2" of insulation towards the ends of the coil to be removed.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 6/5/2001	3
HGQ-0214	MQXBo-019 MQXB01 LQXB01	Step 7.0 dictates the installation of the voltage taps. Voltage taps are not be installed on this coil.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 6/11/2001	3
HGQ-0215	MQXBo-020 MQXB01 LQXB01	Step 7.0 dictates the installation of the voltage taps. Voltage taps are not to be installed on this coil.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 6/11/2001	3
HGQ-0216	MQXBi-021 MQXB01 LQXB01	Incorrect parting plane part issued and installed. Parting plane part #MD-344469 was issued and installed. Part #MD-344469 rev. A should have been issued and installed. Installed insulation will be removed and correct insulation installed.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 6/5/2001	3
HGQ-0217	MQXBo-021 MQXB01 LQXB01	Step 7.0 dictates the installation of voltage taps. Voltage taps are not to be installed on this coil.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 6/11/2001	3

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DR Number	Device SN / Subassembly 1 SN / Subassembly 2 SN / Assembly SN	Discrepancy Description	Originator / Date / Disposition by / Date	Disposition Verified by / Date / Reviewed by / Date	DR Classification (1-Material 2-Manpower 3-Method 4-Machine 5-Measurement)
HGQ-0218	MQXBo-022 MQXB01 LQXB01	Step 7.0 dictates the installation of voltage taps. Voltage taps are not to be installed on this coil.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 6/11/2001	3
HGQ-0219	MQXBo-019 MQXB01 LQXB01	End shimming on end saddles on both lead and return end to be modified. The last approx. 1/2" towards the ends of the coils to be cut off.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 6/5/2001	3
HGQ-0220	MQXBo-020 MQXB01 LQXB01	End shimming on end saddles on both lead and return end to be modified. The last approx. 1/2" towards the ends of the coil to be removed.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 6/5/2001	3
HGQ-0221	MQXBo-021 MQXB01 LQXB01	End shimming on end saddles on both lead and return end to be modified. The last approx. 1/2" towards the ends of the coil to be cut off.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 6/5/2001	3
HGQ-0222	MQXBo-022 MQXB01 LQXB01	End shimming on end saddles on both lead and return end to be modified. The last approx. 1/2" towards the ends of the coil to be removed.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 6/5/2001	3
HGQ-0224	MQXBi-025 MQXB02 LQXB01	Step 7.0 in traveler dictates the installation of voltage taps. Voltage taps are not to be installed on this coil.	Jim Rife 5/24/2001 Rodger Bossert 5/24/2001	 Bob Jensen 6/11/2001	3

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HGQ-0225	MQXBi-022 MQXB01 LQXB01	The inspection table is not being used for coil lengths.	Steve Gould 5/25/2001 Rodger Bossert 5/25/2001	 Bob Jensen 6/11/2001	5
HGQ-0226	MQXBi-023 MQXB01 LQXB01	The inspection table is not being used for the coil lengths.	Steve Gould 5/25/2001 Rodger Bossert 5/25/2001	 Bob Jensen 6/11/2001	5
HGQ-0227	MQXBC-001 MQXB01 LQXB01	Coil installation was done out of sequence.	Steve Gould 6/4/2001 Rodger Bossert 6/4/2001	Rodger Bossert 6/4/2001 Jamie Blowers 8/13/2001	3
HGQ-0228	MQXBC-001 MQXB01 LQXB01	The inner ramp lead is longer than the outer g-11 keys.	Steve Gould 6/5/2001 Rodger Bossert 6/5/2001	 Jamie Blowers 7/5/2001	3
HGQ-0229	MQXBC-001 MQXB01 LQXB01	Step 6.5 dictates the installation of the IORS voltage tap. The installation of the 1/4 coil voltage taps has changed.	Jim Rife 6/6/2001 Rodger Bossert 9/21/2001	Rodger Bossert 9/21/2001 Bob Jensen 10/1/2001	3
HGQ-0230	MQXBC-001 MQXB01 LQXB01	The Ls and Q measurements for all of the individual inner and outer coils are outside of the specified limits given.	Damon Bice 6/12/2001 Rodger Bossert 6/12/2001	 Bob Jensen 7/18/2001	5

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HGQ-0231	MQXBC-001 MQXB01 LQXB01	Heater Strip 2/3 resistance is well above given limits. After testing a fourth time, resistance came to within limits. Movement of return end of heater strip seems to affect resistance.	Damon Bice 6/12/2001 Rodger Bossert 6/12/2001	 Bob Jensen 8/20/2001	5
HGQ-0232	MQXBC-001 MQXB01 LQXB01	Collar packs not installed per assembly drawing. Inner and Outer cap gage packs installed at lead end. Cap gage packs installed approximately 2.5" from the back of the lead end keys.	Jim Rife 6/14/2001 Rodger Bossert 6/14/2001	 Bob Jensen 7/18/2001	3
HGQ-0233	MQXBC-001 MQXB01 LQXB01	During hipot testing, the coil was found to have a coil to ground short at 4.5 kV.	Jim Rife 6/21/2001 Rodger Bossert 6/26/2001	Rodger Bossert 6/26/2001 Bob Jensen 7/18/2001	5
HGQ-0234	MQXBC-001 MQXB01 LQXB01	The inner coils are much longer than the outer coils in length.	Steve Gould 6/4/2001 Rodger Bossert 6/4/2001	 Jamie Blowers 8/13/2001	4
HGQ-0235	MQXBC-001 MQXB01 LQXB01	Inductance and "Q" readings are out of the limits set for them.	Steve Gould 6/27/2001 Rodger Bossert 6/27/2001	 Jamie Blowers 7/5/2001	5
HGQ-0236	MQXBC-001 MQXB01 LQXB01	During the coil to ground hipot, Coil No. MQXBO-022 shorted to ground at 1.1 kV.	Steve Gould 7/17/2001 Rodger Bossert 7/17/2001	Rodger Bossert 7/17/2001 Jamie Blowers 8/13/2001	5

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HGQ-0237	MQXBC-001 MQXB01 LQXB01	During the disassembly of groundwrap on the MQXBO-022 coil, a cut in the strip heater was found.	Steve Gould 7/18/2001 Rodger Bossert 7/18/2001	Rodger Bossert 7/18/2001 Jamie Blowers 8/13/2001	3
HGQ-0238	MQXBC-001 MQXB01 LQXB01	L & Q readings are out of the predetermined limits.	Steve Gould 7/23/2001 Rodger Bossert 7/23/2001	 Jamie Blowers 8/13/2001	5
HGQ-0239	MQXBC-001 MQXB01 LQXB01	Fuji film was not used on the lead end end can installation as per Rodger Bossert.	Steve Gould 7/23/2001 Rodger Bossert 7/23/2001	Rodger Bossert 7/23/2001 Jamie Blowers 8/13/2001	3
HGQ-0240	MQXBC-001 MQXB01 LQXB01	The gap measured was greater than the .010" allowed.	Steve Gould 7/24/2001 Rodger Bossert 7/24/2001	Rodger Bossert 7/24/2001 Bob Jensen 8/20/2001	5
HGQ-0241	MQXBC-001 MQXB01 LQXB01	IORS tap wires will not fit through the End Ring on the Lead End. IORS = 1/8 coil taps	Steve Gould 7/24/2001 Rodger Bossert 7/24/2001	Rodger Bossert 7/24/2001 Bob Jensen 10/1/2001	3
HGQ-0242	MQXBC-001 MQXB01 LQXB01	The inner return end key in Quadrant 3 is protruding into the bore of the magnet.	Steve Gould 8/6/2001 Rodger Bossert 8/6/2001	Rodger Bossert 11/19/2001 Bob Jensen 11/20/2001	3

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HGQ-0244	MQXBo-027 MQXB02 LQXB01	Lead pulled away from the coil during the electrical.	Steve Gould 8/16/2001 Rodger Bossert 8/16/2001	 Bob Jensen 8/16/2001	3
HGQ-0246	MQXBi-026 MQXB02 LQXB01	Modifications to previously installed End Shimming not reflected in the traveler or assembly drawings. Prior to the installation of Inner Coil Cap/Parting Plane Side Kapton (MC-344469), End Shimming (lead and return ends) needs to be modified. The outside ends of the first layers	Jim Rife 8/24/2001 Rodger Bossert 10/5/2001	Rodger Bossert 10/8/2001 Bob Jensen 10/8/2001	3
HGQ-0247	MQXBi-025 MQXB02 LQXB01	Modifications to previously installed End Shimming not reflected in the traveler or assembly drawings. Prior to the installation of Inner Coil Cap/Parting Plane Side Kapton (MC-344469), End Shimming (lead and return ends) needs to be modified. The outside ends of the first layers	Jim Rife 8/24/2001 Rodger Bossert 10/5/2001	Rodger Bossert 10/8/2001 Bob Jensen 10/8/2001	3
HGQ-0248	MQXBi-027 MQXB02 LQXB01	Modifications to previously installed End Shimming not reflected in the traveler or assembly drawings. Prior to the installation of Inner Coil Cap/Parting Plane Side Kapton (MC-344469), End Shimming (lead and return ends) needs to be modified. The outside ends of the first layers	Jim Rife 8/24/2001 Rodger Bossert 10/5/2001	Rodger Bossert 10/8/2001 Bob Jensen 10/8/2001	3
HGQ-0249	MQXBi-028 MQXB02 LQXB01	Modifications to previously installed End Shimming not reflected in the traveler or assembly drawings. Prior to the installation of Inner Coil Cap/ Parting Plane Side Kapton (MC-344469), End Shimming (lead and return ends) needs to be modified. The outside ends of the first layers	Jim Rife 8/24/2001 Rodger Bossert 10/5/2001	Rodger Bossert 10/8/2001 Bob Jensen 10/8/2001	3
HGQ-0250	MQXBC-002 MQXB02 LQXB01	The Inductance and Q readings for the outer coils are out of range. The Amp selector knob setting is wrong. It should be 1A.	Steve Gould 9/5/2001 Rodger Bossert 9/5/2001	Rodger Bossert 9/5/2001 Bob Jensen 9/5/2001	5

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HGQ-0251	MQXBC-002 MQXB02 LQXB01	The bare ends of the inner/outer splice has been insulated with .003" adhesive backed kapton to insulate the splice from the last lamination of the collar packs to be installed later. The current step dictates insulating bare splice up to and stopping at the ends of the splice.	Jim Rife 9/6/2001 Rodger Bossert 10/5/2001	Rodger Bossert 10/5/2001 Bob Jensen 10/8/2001	3
HGQ-0252	MQXBC-002 MQXB02 LQXB01	Incorrect part number called out in steps 8.3, 9.3 and 10.3 for Pole Ground Wrap Layer #2. Part number should be (MC-369624).	Jim Rife 9/10/2001 Bob Jensen 10/1/2001	Bob Jensen 10/1/2001 Bob Jensen 10/1/2001	3
HGQ-0253	MQXBC-002 MQXB02 LQXB01	While inserting the Outer Lead End Keys, there was a gap found to be between the G-11 Outer Lead End Spacer and the Ramp Splice that could not be taken out.	Steve Gould 9/11/2001 Rodger Bossert 10/5/2001	Rodger Bossert 10/5/2001 Bob Jensen 10/8/2001	3
HGQ-0254	MQXBC-001 MQXB01 LQXB01	During warm bore testing the collared coil was found to have a coil to ground short to the lead end end can. Further investigation of the short found that the Q3 voltage tap wire from the inner/outer splice was the cause.	Jim Rife 9/19/2001 Rodger Bossert 10/5/2001	Rodger Bossert 10/5/2001 Bob Jensen 10/8/2001	3
HGQ-0255	MQXBC-002 MQXB02 LQXB01	All electrical results are out of the limits set for them.	Steve Gould 9/24/2001 Rodger Bossert 10/5/2001	Rodger Bossert 10/5/2001 Bob Jensen 10/8/2001	5
HGQ-0256	MQXBC-002 MQXB02 LQXB01	During collaring massaging the assembly developed a Q2 coil to heater to tooling short. Short is to tooling only and not body collars.	Jim Rife 9/26/2001 Rodger Bossert 9/26/2001	Rodger Bossert 10/5/2001 Bob Jensen 10/8/2001	5

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HGQ-0257	MQXBo-024 MQXB02 LQXB01	The return end end saddle is no longer adhered to the coil.	Jim Rife 9/28/2001 Rodger Bossert 10/5/2001	Rodger Bossert 10/8/2001 Bob Jensen 10/8/2001	3
HGQ-0258	MQXBC-002 MQXB02 LQXB01	During collaring it was noticed that the gap between outer layers of ground wrap between quadrants #2 & #3 is no longer apparent. The "long" leg of the ground wrap in quadrant 2 appears to be longer than specified. (The long leg of ground wrap measures approx. 2.053" - 2.103". -	Jim Rife 10/5/2001 Rodger Bossert 10/5/2001	Rodger Bossert 10/5/2001 Bob Jensen 10/8/2001	3
HGQ-0259	MQXBC-002-1 MQXB02 LQXB01	Assembly developed a quadrant 2 coil to collaring tooling short upon completion of the massaging of collars for keying. Short appeared after completion of the 1800 pump psi massage and prior to beginning of partial insertion of tapered keys.	Jim Rife 10/9/2001 Rodger Bossert 10/9/2001	Rodger Bossert 10/9/2001 Bob Jensen 11/20/2001	5
HGQ-0260	MQXBC-002-1 MQXB02 LQXB01	Deviated from collar keying procedure in traveler per following: 1. Partial insert keys from LE to RE, 3000 pump psi main cylinders, 700 pump psi key pushers, first set of keys stick above collar pack ~1/2".	Jim Rife 10/11/2001 Rodger Bossert 10/11/2001	Rodger Bossert 11/10/2001 Bob Jensen 11/20/2001	3
HGQ-0261	MQXBC-002 MQXB02 LQXB01	Heater #2/3 (Heater strip on Quadrant #3) has a dead short to ground and also shorts to coil at a low voltage. Coil to ground also shorted out at a low voltage.	Steve Gould 10/16/2001 Rodger Bossert 10/16/2001	Rodger Bossert 10/16/2001 Bob Jensen 11/20/2001	5
HGQ-0262	MQXB01 MQXB01 LQXB01	Step dictates to install yoke packs into assembly with a 1.650" gap between the straight section yoke pack and non-lead end yoke stack for routing wires. This assembly does not have any wires that need to be routed through this gap as in previous assemblies.	Jim Rife 10/17/2001 Rodger Bossert 12/11/2001	Rodger Bossert 12/11/2001 Bob Jensen 5/22/2002	3

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DR Number	Device SN / Subassembly 1 SN / Subassembly 2 SN / Assembly SN	Discrepancy Description	Originator / Date / Disposition by / Date	Disposition Verified by / Date / Reviewed by / Date	DR Classification (1-Material 2-Manpower 3-Method 4-Machine 5-Measurement)
HGQ-0263	MQXB01 MQXB01 LQXB01	A sixth pass of weld was added to the cold mass.	Steve Gould 10/26/2001 Rodger Bossert 10/26/2001	Rodger Bossert 10/26/2001 Bob Jensen 5/22/2002	3
HGQ-0265	MQXB01 LQXB01	The lead end skin was cut to the specified dimension given in the traveler. Upon setting up to cut the return end skin it was found that the lead end skin appears to have been cut to an incorrect dimension.	Jim Rife 10/29/2001 Jim Kerby 10/29/2001	 Bob Jensen 11/8/2001	3
HGQ-0267	MQXB01 MQXB01 LQXB01	Overall length of skin will be .500" short if skin length is cut per traveler.	Jim Rife 10/30/2001 Jim Kerby 10/30/2001	 Bob Jensen 11/8/2001	3
HGQ-0268	MQXB01 MQXB01 LQXB01	During the hipotting procedure of coil to ground, the magnet shorted out at 4 KV. It was determined that the Q3 ramp splice tap was shorting to the end can.	Steve Gould 11/1/2001 Rodger Bossert 11/1/2001	Rodger Bossert 11/1/2001 Bob Jensen 11/8/2001	5
HGQ-0269	MQXBC-002-2 MQXB02 LQXB01	Coil to Coil short in Q3 - Q4 at Return End.	Damon Bice 11/8/2001 Rodger Bossert 11/8/2001	Rodger Bossert 11/8/2001 Bob Jensen 1/11/2002	5
HGQ-0270	MQXB01 MQXB01 LQXB01	The non-lead end outer saddles are cracked in the center of each saddle and they are bulging out from the face of the magnet.	Steve Gould 11/9/2001 Rodger Bossert 11/9/2001	Rodger Bossert 11/9/2001 Bob Jensen 5/22/2002	1

Discrepancy Reports - By Serial No. LQXB01

DR Number	*Device SN* *Subassembly 1 SN* *Subassembly 2 SN* *Assembly SN*	*Discrepancy Description*	*Originator* *Date* *Disposition by* *Date*	*Disposition Verified by* *Date* *Reviewed by* *Date*	*DR Classification* *1-Material* *2-Manpower* *3-Method* *4-Machine* *5-Measurement*
HGQ-0271	MQXB01 MQXB01 LQXB01	Through holes in bullet pusher plate do not line up with tapped holes in coil saddles.	Jim Rife 11/9/2001 Jim Kerby 11/9/2001	Rodger Bossert 11/9/2001 Bob Jensen 11/16/2001	3
HGQ-0273	MQXB01 MQXB01 LQXB01	There are no provisions in the bullet pusher plate to allow the heater wire voltage tap wires to pass through.	Jim Rife 11/12/2001 Rodger Bossert 11/12/2001	Bob Jensen 3/20/2002 Bob Jensen 3/20/2002	3
HGQ-0274	MQXBC-002 MQXB02 LQXB01	During the electrical it was found that the magnet has a Q2/3 heater to Q3 outer coil short. The short has been located and is repairable.	Jim Rife 11/13/2001 Rodger Bossert 11/13/2001	Rodger Bossert 11/13/2001 Bob Jensen 2/8/2002	5
HGQ-0275	MQXBC-002 MQXB02 LQXB01	1. Coil to Ground short noted in Quadrant #1. 2. Coil to End Can short noted in Quadrant #3.	Damon Bice 11/14/2001 Rodger Bossert 11/14/2001	Rodger Bossert 4/5/2002 Bob Jensen 5/22/2002	5
HGQ-0281	MQXB01 MQXB01 LQXB01	1. Step dictates to assemble bullet assemblies MD-369293 assembly number should be MD-369731. 2. During the assembly of the Bullet Assemblies it was found that the 4-40 x 1/4" slotted flat head machine	Jim Rife 11/29/2001 Rodger Bossert 11/29/2001	Rodger Bossert 11/29/2001 Bob Jensen 3/20/2002	3
HGQ-0282	MQXBC-002-2 MQXB02 LQXB01	Leakage of heater to ground is above acceptable leakage requirements.	Damon Bice 11/30/2001 Rodger Bossert 1/20/2002	Rodger Bossert 1/20/2002 Bob Jensen 2/8/2002	5

Discrepancy Reports - By Serial No. LQXB01

DR Number	*Device SN* *Subassembly 1 SN* *Subassembly 2 SN* *Assembly SN*	*Discrepancy Description*	*Originator* *Date* *Disposition by* *Date*	*Disposition Verified by* *Date* *Reviewed by* *Date*	*DR Classification* *1-Material* *2-Manpower* *3-Method* *4-Machine* *5-Measurement*
HGQ-0283	MQXBC-002-2 MQXB02 LQXB01	Heaters have shorted to coil leads at 4 KV.	Damon Bice 11/30/2001 Rodger Bossert 11/30/2001	Rodger Bossert 11/30/2001 Bob Jensen 2/8/2002	5
HGQ-0284	MQXB01 MQXB01 LQXB01	One of the support block bases has been changed. Need the new base.	Steve Gould 12/7/2001 Rodger Bossert 12/7/2001	Rodger Bossert 12/7/2001 Bob Jensen 3/20/2002	3
HGQ-0285	MQXB01 MQXB01 LQXB01	Part No. 369875 has a bored hole for a cap screw that is too shallow.	Steve Gould 12/7/2001 Rodger Bossert 12/7/2001	Rodger Bossert 12/7/2001 Bob Jensen 2/13/2002	1
HGQ-0286	MQXB01 MQXB01 LQXB01	Fastener for the support block top does not fit for base #369875.	Steve Gould 12/7/2001 Rodger Bossert 12/7/2001	Rodger Bossert 12/7/2001 Bob Jensen 2/13/2002	1
HGQ-0287	MQXB01 MQXB01 LQXB01	The support block bolt for quadrant 1 & 2 outer coils interferes with power lead support bracket being installed.	Jim Rife 12/10/2001 Rodger Bossert 12/10/2001	Rodger Bossert 12/10/2001 Bob Jensen 2/13/2002	3
HGQ-0288	MQXB01 MQXB01 LQXB01	Support Blocks are installed and power wires need to be attached to stabilizers and insulated. Insulation scheme needs to be specified on drawings and in traveler.	Jim Rife 12/10/2001 Rodger Bossert 12/10/2001	Rodger Bossert 12/10/2001 Bob Jensen 3/20/2002	3

Discrepancy Reports - By Serial No. LQXB01

DR Number	*Device SN* *Subassembly 1 SN* *Subassembly 2 SN* *Assembly SN*	*Discrepancy Description*	*Originator* *Date* *Disposition by* *Date*	*Disposition Verified by* *Date* *Reviewed by* *Date*	*DR Classification* *1-Material* *2-Manpower* *3-Method* *4-Machine* *5-Measurement*
HGQ-0289	MQXB01 MQXB01 LQXB01	During the installation of the splice support blocks it was noticed that the ends of the splices are cut flush with the ends of the blocks. This may cause problems during future assembly as to the proximity of the ends of the un-insulated splices and the end dome.	Jim Rife 12/10/2001 Rodger Bossert 12/10/2001	Rodger Bossert 12/10/2001 Bob Jensen 5/22/2002	3
HGQ-0290	MQXB01 MQXB01 LQXB01	Magnet was found to have a circuit A heater to ground failure at 3 kV.	Jim Rife 12/11/2001 Rodger Bossert 1/8/2002	Rodger Bossert 1/8/2002 Bob Jensen 1/8/2002	5
HGQ-0292	MQXBC-002 MQXB02 LQXB01	Inner Q1 lead is protruding into the bore of the magnet.	Steve Gould 12/13/2001 Rodger Bossert 12/13/2001	Rodger Bossert 12/13/2001 Bob Jensen 2/8/2002	3
HGQ-0294	MQXBC-002 MQXB02 LQXB01	The measured gaps between the lead end filler cones and collar packs are out of tolerance per travelers.	Jim Rife 12/14/2001 Rodger Bossert 12/14/2001	Rodger Bossert 12/14/2001 Bob Jensen 5/22/2002	3
HGQ-0298	MQXB01 MQXB01 LQXB01	Due to replacing endplate the bullets stick out of endplate. Splice Support blocks now rest upon bullets, not flat end plate surface. (Entered into Database on 7/11/02 - John Szostak)	Donald Nurczyk 1/8/2002 Rodger Bossert 1/8/2002	Rodger Bossert 1/8/2002 Bob Jensen 1/8/2002	3
HGQ-0302	MQXB02 MQXB02 LQXB01	Grooves are not in the collets to putty heater wires into them.	Steve Gould 1/30/2002 Rodger Bossert 4/1/2002	John Szostak 9/11/2002 Bob Jensen 9/17/2002	3

Discrepancy Reports - By Serial No. LQXB01

DR Number	*Device SN* *Subassembly 1 SN* *Subassembly 2 SN* *Assembly SN*	*Discrepancy Description*	*Originator* *Date* *Disposition by* *Date*	*Disposition Verified by* *Date* *Reviewed by* *Date*	*DR Classification* *1-Material* *2-Manpower* *3-Method* *4-Machine* *5-Measurement*
HGQ-0307	MQXB02 MQXB02 LQXB01	One hole for the MB-369875 was not counter bored deep enough for a cap screw.	Steve Gould 2/20/2002 Rodger Bossert 4/1/2002	John Szostak 8/2/2002 Bob Jensen 8/12/2002	1
HGQ-0308	MQXB02 MQXB02 LQXB01	The three support block bases are not cut out enough so the soldered leads fit into the slot provided.	Steve Gould 2/20/2002 Rodger Bossert 4/11/2002	Rodger Bossert 4/11/2002 Bob Jensen 5/22/2002	1
HGQ-0311	MQXB02 MQXB02 LQXB01	Part No. MC-369843 needs to be tapered for the power leads that get tied to them.	Steve Gould 2/21/2002 Rodger Bossert 4/1/2002	Rodger Bossert 6/5/2002 Bob Jensen 6/10/2002	3
HGQ-0313	MQXB02 MQXB02 LQXB01	During the standard 30 second wait at 5000 volts, the hipotter tripped out.	Steve Gould 2/26/2002 Rodger Bossert 2/26/2002	Rodger Bossert 2/26/2002 Bob Jensen 5/22/2002	5
HGQ-0315	MQXB02 MQXB02 LQXB01	Support block 369215 is no longer used.	Steve Gould 2/27/2002 Rodger Bossert 4/1/2002	John Szostak 4/22/2002 Bob Jensen 5/22/2002	3
HGQ-0316	MQXB02 MQXB02 LQXB01	Welds on the skins had to be filed down to allow Part No. MC-390112B to fit properly. A step is needed in the traveler to allow this to be done every magnet. Thirty four inches from the non-lead end was filed so Part No. MC-390112B would fit properly.	Steve Gould 2/28/2002 Rodger Bossert 4/1/2002	John Szostak 6/10/2001 Bob Jensen 6/10/2002	3

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DR Number	*Device SN* *Subassembly 1 SN* *Subassembly 2 SN* *Assembly SN*	*Discrepancy Description*	*Originator* *Date* *Disposition by* *Date*	*Disposition Verified by* *Date* *Reviewed by* *Date*	*DR Classification* *1-Material* *2-Manpower* *3-Method* *4-Machine* *5-Measurement*
HGQ-0338	MQXBC-002-1 MQXB02 LQXB01	The Inner Coil Leads dropped into the Bore.	John Szostak 5/24/2002 Rodger Bossert 5/24/2002	John Szostak 7/9/2002 Bob Jensen 7/10/2002	3
HGQ-0349	LQXB01 LQXB01	During the electrical to the hypertronics, the hipot failed coil to ground at 2611 volts.	Steve Gould 8/5/2002 Rodger Bossert 10/24/2002	John Szostak 10/24/2002 Jamie Blowers 8/14/2003	5