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**Customer: PRINCETON PLASMA PHYSICS LAB**

Contact: Mike Viola  
E-Mail: mviola@pppl.gov

Telephone: 609-243-3655  
Fax: 609-243-2021

**Part: /**

Drawing ID: SE121-013

Revision: 0

Customer P.O.: S005243-F/Ln:3  
Serial No./Qty: 1 (VVSA # 3)

Reported By: DOUG MCCORKLE

E-Mail: dMcCorkle@MajorTool.com

Telephone: 317-636-6433  
Fax: 317-634-9420

Problem: 1. Zone G4: 0.637 +/- .005 DIM CHECKS .587 TO .910  
2. Zone B5: 0.469 +/- .005 DIM. CHECKS .400 TO .490  
3. Zone G4: 0.75 (+/-0.010") HALF A FLANGE CHECKS 0.620 - 0.650 (HALF B IS  
WITHIN TOLERANCE)

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**Proposed Disposition:**

1. Propose grinding the flange seal weld prep to ensure 0.62" minimum flange face (as done with VVSA 1 & 2)
- 2&3. Propose Use as is

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Number of additional pages: 0

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**Customer Disposition:**    ☐ Use As Is    ☐ Rework    ☐ Repair    ☐ Scrap    ☐ Replace

**Technical Contact Approval:** \_\_\_\_\_

**Title:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Buyer Approval:** \_\_\_\_\_

**Title:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Major Tool Implemented By:** \_\_\_\_\_

**Title:** \_\_\_\_\_ **Date:** \_\_\_\_\_

## Nonconformance Report: Major Tool NC20282

This is for: **VVSA # 3 Profile** SE121-013

### Problem:

1. Zone G4: 0.637 +/- .005 DIM CHECKS .587 TO .910
2. Zone B5: 0.469 +/- .005 DIM. CHECKS .400 TO .490
3. Zone G4: 0.75 (+/-0.010") HALF A FLANGE CHECKS 0.620 - 0.650 (HALF B IS WITHIN TOLERANCE)

### MTM Recommended Disposition:

Use as is.

### Project Disposition:

Use as is.

### Approvals:

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Procurement Technical Representative

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Responsible Line Manager:

## McCorkle, Doug

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**From:** Appleby, Kenny  
**Sent:** Monday, September 11, 2006 10:17 AM  
**To:** McCorkle, Doug  
**Subject:** RE: Drawing SE121-013 Dimension 0.637

Doug,  
Yes. We ground into the seal and added weld to achieve this dimension.

Kenny

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**From:** McCorkle, Doug  
**Sent:** Monday, September 11, 2006 10:05 AM  
**To:** Appleby, Kenny  
**Subject:** Drawing SE121-013 Dimension 0.637

Kenny, please confirm that during the Flange Seal installation (SE121-095), VVSA # 1, 2, and 3 seal to flange weld preps were ground as necessary to ensure solid material was achieved for a minimum of 0.62" in the applicable region after welding.

Thanks,  
Doug Mc.