

**Customer: PRINCETON PLASMA PHYSICS LAB**

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Part: /  
Drawing ID: SE120-003                      Revision: 0

Customer P.O.: S005243-F/Ln:2  
Qty: 1

Reported By: DOUG MCCORKLE  
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Problem: PORT NB HAS DEFORMATION TO HOLE PATTERN AFTER WELDING HAS BEEN COMPLETED ON PORT 4 A/B AND 12 A/B HOLES DO NOT ALIGN TO MATING THREADED HOLE IN NB COVER. HOLES DID ALIGN AFTER NB WAS WELDED IN. BUT DO NOT NOW THAT PORT 4 AND 12 IS COMPLETED. ALSO, THE FACE OF PORT NB HAS GONE OUT OF FLAT BY APPROXIMATELY 1/16".

**Proposed Disposition:**

This issue was originally grouped (all three lots) within NCR 19289.  
The creation of 19868 and 19869 separates each lot for individual attention.  
Recommend facing the port flange face flat and boring the holes to 5/8" diameter to provide necessary clearance.

Number of additional pages: 0

Customer Disposition:     Use As Is     Rework     Repair     Scrap     Replace

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

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

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

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

Major Tool Implemented By: DOUG MCCORKLE

Title: PROJECT ENGINING Date: 27 JUL 2006

**Nonconformance Report: Major Tool NC19868**

**This is for: SE120-003 VVSA # 2 NB port and flange**

**Problem:**

PORT NB HAS DEFORMATION TO HOLE PATTERN AFTER WELDING HAS BEEN COMPLETED ON PORT 4 A/B AND 12 A/B  
HOLES DO NOT ALIGN TO MATING THREADED HOLE IN NB COVER. HOLES DID ALIGN AFTER NB WAS WELDED IN,BUT DO NOT NOW THAT PORT 4 AND 12 IS COMPLETED.  
ALSO, THE FACE OF PORT NB HAS GONE OUT OF FLAT BY APPROXIMATELY 1/16".

**Major Tool recommended Disposition:**

This issue was originally grouped (all three lots) within NCR 19289.  
The creation of 19868 and 19869 separates each lot for individual attention.  
Recommend facing the port flange face flat (not to exceed 1/16") and boring the holes to 5/8" diameter to provide necessary clearance.

**Project Disposition:**

Proceed as recommended:  
"Recommend facing the port flange face flat (not to exceed 1/16") and boring the holes to 5/8" diameter to provide necessary clearance."

**Approvals:**

**Mike Viola**  
Digitally signed by Mike Viola  
DN: cn=Mike Viola, c=US  
Reason: I am approving this document  
Date: 2006.06.16 16:04:02 -04'00'

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Procurement Technical Representative

**Brad Nelson**  
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DN: cn=Brad Nelson, c=US,  
o=ORNL, ou=FED,  
email=nelsonbe@ornl.gov  
Date: 2006.06.16 16:22:31 -04'00'

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Responsible Line Manager: