Major Tool & Machine, Inc.
1458 East 19th Street
Indianapolis, IN 46218-4289

MTM N/C: 18402

Date: 10/25/05
User ID: MCCORKLE

Customer: PRINCETON PLASMA PHYSICS LAB
Contact: Mike Viola
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Part: /
Drawing ID: SE120-004
Revision: 2
Customer P.O.: S005243-F/Ln:7
Serial No.: 2/7

Reported By: DOUG MCCORKLE
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Problem: Profile requirement of 0.188 (+ Unilateral) checks -0.110 / +0.258.

Proposed Disposition: This measurement represents the in-process check of Port 12B profile after welding and machining the flange (the sub-assy is structurally complete). The part is currently out of tolerance on the plus side as much as 0.087" along the straight sides. Both ends (radii) are within tolerance. This condition will likely remain to some extent after the port is installed and final inspected (without reworking the port sub-assy prior to installation).

Request "use as is" disposition if the condition will not create interference with mating components.

Number of additional pages:_____

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 NC18402.
This is for the port 12B out of tolerance condition on the first VVSA (MTM lot 7)

Project Disposition:

Use as is:

The data was taken on two fully welded port assemblies (port 12A and port 12B) that had not yet been welded to the vacuum vessel shell. Although there are a few points that are out of tolerance, recommendation is to accept the parts as is. The vast majority of out of tolerance points are away form the modular coil which should not impose significant problems. The VV heating/cooling mounting flange (se123-167) that will be welded to the vertical ports at final assembly at PPPL will need to have its inner flange surface trimmed to match the surface of the port.

Approvals:

Mike Viola

Digitally signed by Mike Viola
DN: CN = Mike Viola, C = US
Reason: I am approving this document
Date: 2005.11.10 15:39:46 -05'00'

Procurement Technical Representative

Brad Nelson

Digitally signed by Brad Nelson
DN: cn=Brad Nelson, c=US, o=ORNL, ou=FED, email=nelsonbe@ornl.gov
Date: 2005.11.10 17:09:20 -05'00'

Responsible Line Manager: