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

MTM N/C: 18888

Date: 12/19/05
User ID: MCCORKLE

Customer: PRINCETON PLASMA PHYSICS LAB
Contact: Mike Viola — Telephone: 609-243-2441
E-Mail: S-04286-F — Fax: 609-243-2021

Part: / — Customer P.O.: S005243-F/Ln:1
Drawing ID: SE120-004 — Revision: 2 — Serial No./Qty: Lot 1 Vessel

Reported By: DOUG MCCORKLE — Telephone: 317-636-6433
E-Mail: dMcCorkle@MajorTool.com — Fax: 317-634-9420

Problem: The true position of lifting boss "a" on half "a" of the vessel checks 0.275 or 0.025 out of tolerance.

The true position of lifting boss "c" on half "a" of the vessel checks 0.451 of 0.201 out of tolerance.

The true position of lifting boss "c" on half "b" of the vessel checks 0.361 or 0.111 out of tolerance.

Proposed Disposition:
CONTINUE MANUFACTURING
SUBMITTING TO PPPL FOR DISPOSITION

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: _____ **Title:** _____ **Date:** _____

Nonconformance Report: Major Tool NC18888

This is for SE122-004 Bosses

Mike, please review the attached Non-conformance and provide disposition. According to our fabricators, the Clevis Boss details have proven to be much more difficult to control (position) than we expected.

Problem:

The true position of lifting boss "a" on half "a" of the vessel checks 0.275 or 0.025 out of tolerance.

The true position of lifting boss "c" on half "a" of the vessel checks 0.451 of 0.201 out of tolerance.

The true position of lifting boss "c" on half "b" of the vessel checks 0.361 or 0.111 out of tolerance.

Best Regards,
Doug McCorkle

Clarification (Viola):
Per SE122-004 Sheet 1, Bosses labeled “A” thru “D” correspond to Items 48-51 respectively. Half “a” and “b” refer to half of the 120 degree section. The values indicated are maximums relative to TPT of datum B and C (X Y Plan view). I have asked if there is any tilt involved and they will get back to me.

Project Disposition:

Bosses A & B are alignment features. If the hole has been bored in the boss, the boss will have to be redone; otherwise we can accept the correctly drilled hole in a misplaced boss.

Boss C is a handling hole and may be used as is.

Approvals:

Mike Viola
Digitally signed by Mike Viola
DN: CN = Mike Viola, C = US
Reason: I am approving this document
Date: 2005.12.20 14:00:39 -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: 2005.12.20 16:12:57 -05'00'

Responsible Line Manager: