
Customer: PRINCETON PLASMA PHYSICS LAB

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Part: /

Drawing ID: SE120-004

Revision: 2D

Customer P.O.: S005243-F/Ln:2
Serial No./Qty:

Reported By: DOUG MCCORKLE
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Problem: The profile of the flange on half A checks -0.194 / +0.190 or 0.006 under low limit and 0.002 over high limit.

The profile of the flange on half B checks -0.248 / +0.117 or 0.059 under the low limit.

Proposed Disposition:

This information is being provided as a supplement to the recently submitted high resolution scan of the vessel ends. Because the installation and welding of the seal plates blocks the lasers line of sight, it should be considered the final profile condition in these areas. The final profile check will include all laser visible surfaces. The condition is slightly different that the previous submittal because the flanges were removed, prepped and reattached.

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 NC19697

This is for: **VVSA # 2 end flanges** SE120-004

Problem:

The profile of the flange on half A checks $-0.194 / +0.190$ or 0.006 under low limit and 0.002 over high limit.
The profile of the flange on half B checks $-0.248 / +0.117$ or 0.059 under the low limit.

MTM Recommended Disposition:

This information is being provided as a supplement to the recently submitted high resolution scan of the vessel ends. Because the installation and welding of the seal plates blocks the lasers line of sight, it should be considered the final profile condition in these areas. The final profile check will include all laser visible surfaces. (inside measurements will be provided where surfaces are not visible to the laser on the outside)
The condition is slightly different that the previous submittal because the flanges were removed, prepped and reattached. If the flange profile condition encroaches on the $.637$ ($.62$) flange face dimension, the outside will be re-surfaced by welding after the vacuum test cover plate is installed (at MTM).

Project Disposition:

Concur with CA – Add Inconel weld material to outside profile of area that is inside tolerance as evidenced by the encroachment of the $.637$ ($.62$) dimension.

Approvals:

Procurement Technical Representative

Responsible Line Manager: