
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

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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: _____

Title: _____ **Date:** _____

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:

Procurement Technical Representative

Responsible Line Manager: