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**Customer: PRINCETON PLASMA PHYSICS LAB**

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**Part: /**

Drawing ID: SE122-072

Revision: 1

Customer P.O.: S005243-F/Ln:3  
Serial No./Qty: 1 (VVSA 3)

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.

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**Proposed Disposition:**

The flange has been reworked in the same manner as unit 1 & 2. The NB flange face was re-cut to restore flatness. The holes were opened up to 5/8" dia. The flange thickness now checks 1.228-1.241.

Number of additional pages: 0

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**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 NC19869

This is for: **VVSA # 3 Profile** SE122-072

**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.

**MTM Recommended Disposition:**

The flange has been reworked in the same manner as unit 1 & 2. The NB flange face was re-cut to restore flatness. The holes were opened up to 5/8" dia. The flange thickness now checks 1.228-1.241.

Use as is.

**Project Disposition:**

Use as is.

**Approvals:**

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Procurement Technical Representative

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Responsible Line Manager: