

**Non-conformance: 19108**

Occurred: 01/20/06 Identified By: 775-D.MCCORKLE  
Reported: 01/20/06 By: 775-D.MCCORKLE

Customer: PRINCETON PLASMA PHYSICS LAB  
Serial Number:

Part: /  
Drawing ID: SE121-014 Rev 2

Links: 1-Type:W: 65678/1.0 Sub: 0 Op: 10

Vendor:

Problem: THE OUTSIDE PROFILE OF THE SPACER FLANGES WERE CHAMFERED NEAR THE LOCATION OF THE SPACER PORT EXTENSION. CHAMFERS ARE APPROXIMATELY 1/4" DEEP X UP TO 45 DEG. NO CHAMFER ON DRAWING. REFER TO ATTACHED PICTURE

**Where Detected 704-IN-PROCESS INSPECTION**

**Defect: 125-THICKNESS**

N/C Type: 1-STANDARD

Target Dim: 1.0000 Max Dev:0.2500

Reference:

Last Edited: 01/20/06 By: 775-D.MCCORKLE

Document:

**Disposition: 901-COMPLETE/REWORK**

Due: 02/27/06 By: 775-D.MCCORKLE

Submitted Doc: 19108

Completed: 02/27/06 By: 775-D.MCCORKLE

Act OK Due: 03/01/06 By: 771-B.SCHULTZ

Approval Due: 01/23/06 By: 927-M.MANUEL

Rework: 1-Type:W Base:65678 Lot:1 Split:0 Sub: 238 Op: 20

Approved: 02/27/06 By: 927-M.MANUEL / Cft Leader

Inspected: 03/11/06 By: 771-B.SCHULTZ

Instructions: Customer requires the chamfers to be restored per attached correspondence.

Last Edited: 03/11/06 By: 771-B.SCHULTZ

**Root Cause / Corrective Action**

Due: 01/27/06 By: 775-D.MCCORKLE

Completed: 01/20/06 By: 927-M.MANUEL

**Root Cause 1: 802-MANAGEMENT DECISION**

Resource: 715-SILVER TEAM, ENGINEERING

Approval Due: 01/23/06 By: 927-M.MANUEL

Equipment:

Approved: 01/20/06 By: 927-M.MANUEL

Employee: 927-M.MANUEL

Description: THE AMOUNT OF EXCESS MACHINING STOCK LEFT ON THE OUTSIDE PROFILE OF EACH FLANGE CREATED ACCESS LIMITATIONS TO COMPLETE THE WELD AROUND THE PORT EXTENSION. THE DECISION WAS MADE BY MTM TO GRIND CLEARANCE CHAMFERS ON THE OUTSIDE OF THE FLANGES KNOWING IT COULD BE EASILY REPAIRED LATER IF CUSTOMER CONCERNS EXISTED.

**Corr Actn: 1:**

Correction Due 01/27/06 By: 775-D.MCCORKLE

Action: 01/20/06 By: 775-D.MCCORKLE

Completed: 01/20/06

Description: CURRENTLY MTM CONSIDERS THE ISSUE COSMETICAL AND NO FURTHER CORRECTIVE ACTION REQUIRED.

Verify Due: 01/27/06 By: 927-M.MANUEL

Completed: 01/20/06 By: 927-M.MANUEL

Verify Notes: COMPLETE

RC Last Edited 01/20/06 By: 927-M.MANUEL

CA Last Edited By:

**Documents: 1)**

Last Edited: 02/27/06 By: 775-D.MCCORKLE

**Closure:**

Completed: 03/12/06 By: 596-D.KNAUB

Comments:

Last Edited: 03/12/06 By: 596-D.KNAUB