

Non-conformance: 19392

Customer: PRINCETON PLASMA PHYSICS LAB
Serial Number:
Links: 1-Type:W: 65678/1.0 Sub: 2 Op: 60
Problem: The .469 +/- .005 dimension varies around part over and undersized, .240-.432

Occurred: 03/10/06 Identified By: 168-R.BACK
Reported: 03/10/06 By: 168-R.BACK
Part: /
Drawing ID: SE120-004 Rev 2
Vendor:

Where Detected 711-DURING MANUFACTURING PROCES
N/C Type: 1-STANDARD

Defect: 127-LINEAR DIMENSION
Target Dim: 0.6370 Max Dev:0.0050
Reference:
Document:

Last Edited: 03/10/06 By: 168-R.BACK

Disposition: 911-CUSTOMER - COMPLETE/REWORK

Submitted Doc: 19392
Act OK Due: 04/13/06 By: 709-K.APPLEBY

Due: 04/11/06 By: 775-D.MCCORKLE
Completed: 04/11/06 By: 775-D.MCCORKLE
Approval Due: 03/13/06 By: 927-M.MANUEL
Approved: 04/11/06 By: 927-M.MANUEL / Cft Leader

Rework: 1-Type:W Base:65678 Lot:1 Split:0 Sub: 247 Op: 20

Inspected: 04/24/06 By: 933-D.LEAPLEY

Instructions: REFERENCE DRAWING SE121-013, ZONE B5
REWORK LEG PROVIDED

Last Edited: 04/11/06 By: 927-M.MANUEL

Root Cause / Corrective Action

Due: 03/17/06 By: 775-D.MCCORKLE
Completed: 03/10/06 By: 775-D.MCCORKLE

Root Cause 1: 800-CUSTOMER

Resource: CUS-CUSTOMER (ROOT CAUSE)
Equipment:
Employee:

Approval Due: 03/13/06 By: 596-D.KNAUB
Approved: 03/12/06 By: 596-D.KNAUB

Description: THE HOLE WAS INSTALLED AT THE DETAIL STATE AND THE FACE WAS FINISHED AFTER WELDING THE FLANGE TO THE VESSEL END. NORMAL WELDING DISTORTION AND PART ALIGNMENT CAUSED THE RELATIONSHIP TO GO OUT OF THE CUSTOMER APPLIED TOLERANCE ZONE. IF THE FACE WAS MACHINED TO FINISH IN THE DETAIL STATE AS SPECIFIED ON THE DESIGN DRAWING, THE PART WOULD NOT MEET LATER REQUIREMENTS AND WOULD LIKELY NOT FUNCTION. THROUGH EARLIER CORRESPONDENCE WITH PPPL, MTM REALIZED THE HOLES ARE MERELY FOR AN ALIGNMENT JACKING DEVISE THAT IS ADJUSTABLE.

Corr Actn: 1:

Correction Due 03/17/06 By: 775-D.MCCORKLE
Action: 03/16/06 By: 775-D.MCCORKLE
Completed: 03/10/06

Description: NONE REQUIRED

Verify Due: 03/17/06 By: 927-M.MANUEL
Completed: 03/16/06 By: 927-M.MANUEL

Verify Notes: NONE REQUIRED

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

Documents: 1)

Last Edited: 05/05/06 By: 775-D.MCCORKLE

Closure:

Completed: 05/05/06 By: 596-D.KNAUB

Comments:
Last Edited: 05/05/06 By: 596-D.KNAUB