

<b>Workorder</b> 65678/1.0	<b>Part ID</b> SE120-002-PPPL NCSX VVSA	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /	<b>Engineer</b> SILVER/DOUG MCCORKLE
VVSA 120 DEGREE VESSEL				

<b>Sub ID</b> 247	<b>Part ID</b> REWORK-REWORK / REPAIR PER N/C	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /
Parent Sub:2 Op:90			

<b>Operation</b> Sub: 247 / Seq: 10 (Closed)	<b>Resource</b> 230-FAB MEDIUM SOUTH	<b>QtyPer</b> 1.00	<b>StartQty</b> 1.00	<b>EndQty</b> 1.00	<b>Drawing ID / Rev</b> 
INSTALL THE SPECIAL SET SCREWS INTO THE THREE HOLES THAT MEASURE BELOW NOMINAL. THESE THREE HOLES ARE LOCATED ON HALF B (CURRENTLY FACING EAST). THEY CAN BE IDENTIFIED BY MEASURING THE DISTANCE FROM THE FACE OF THE FLANGE TO A BOLT THREADED INTO THE HOLES. THE NON-CONFORMING HOLES MEASURE 0.230, 0.182, AND 0.219. CONTACT DOUG McCORKLE FOR CONFIRMATION PRIOR TO WELDING. WELD THE CUSTOM SET SCREWS IN PLACE WITH A MINIMUM 1/8" CAP WELD PER WPS. BLEND / POLISH THE SURFACE. CWI VISUAL INSPECTION REQUIRED.					

<b>Operation</b> Sub: 247 / Seq: 20 (Closed)	<b>Resource</b> 805-INPROCESS INSPECTION - PLANT	<b>QtyPer</b> 1.00	<b>StartQty</b> 1.00	<b>EndQty</b> 1.00	<b>Drawing ID / Rev</b> SE120-002 / 0
VERIFY REWORK AND COMPLETE NCR 19392 CWI VISUAL WELD INSPECT WELD SURFACE UNDER 8X MAGNIFICATION.					

<b>Sub ID</b> 248	<b>Part ID</b> REWORK-REWORK / REPAIR PER N/C	<b>Qty</b> 1	<b>Drawing ID / Rev</b> /
Parent Sub:247 Op:10			

<b>Operation</b> Sub: 248 / Seq: 10 (Closed)	<b>Resource</b> 405-SAWS- PLANT 3	<b>QtyPer</b> 1.00	<b>StartQty</b> 1.00	<b>EndQty</b> 1.00	<b>Drawing ID / Rev</b> 
SAW AND DEBURR PER MATERIAL CARD					
<b>Piece #</b> 10	<b>Part ID</b> INCONEL 625_233-BAR,ROUND,NICKEL ALLOY .438" DIA	<b>Qty</b> 3.0	<b>Drawing ID / Rev</b> 	<b>Vendor</b> 4434	<b>Dimensions</b> 3
Vendor Part ID: INCONEL 625_233 Mfg Part ID: INCONEL 625					
(C)	INCONEL 625 BAR,ROUND,NICKEL ALLOY .438" DIA				
Material Certification: Trace ID: 129238					

<b>Operation</b> Sub: 248 / Seq: 20 (Closed)	<b>Resource</b> 107-CNC TURNING (ROMI)	<b>QtyPer</b> 1.00	<b>StartQty</b> 1.00	<b>EndQty</b> 1.00	<b>Drawing ID / Rev</b> 
TURN / PART OFF THREE PIECES .375-16 UNC-2A X .375 AND DELIVER TO KENNY APPLEBY					