

Frank A. Malinowski

From: Manuel, Mike [manuel@majortool.com]
Sent: Friday, May 05, 2006 3:12 PM
To: Frank A. Malinowski; McCorkle, Doug
Cc: Michael E. Viola; Larry L. Sutton; Phil Heitzenroeder; Bradley E. Nelson
Subject: RE: MTM NCR 19392 completed and closed.

Frank,
Our direction was to plug only the bad ones (that was 3 of them)
Mike

From: Frank A. Malinowski [mailto:fmalinow@pppl.gov]
Sent: Friday, May 05, 2006 2:43 PM
To: McCorkle, Doug
Cc: Manuel, Mike; Michael E. Viola; Larry L. Sutton; Phil Heitzenroeder; Bradley E. Nelson
Subject: RE: MTM NCR 19392 completed and closed.

Doug,

We noted the difference between the PPPL disposition, fill all holes, and the MTM work instruction, fill 3 holes. We are presuming that only the 3 presented any possibility of breaking through. If that's the case, this NCR will be changed to Closed in the PPPL system.

Frank

--

Frank Malinowski - MS01

The DOE Princeton Plasma Physics Lab

PO Box 451

Princeton, NJ 08543-0451

=====

PH (609) 243-2203 FAX (609) 243-3366 <http://www.pppl.gov/>

=====

From: McCorkle, Doug [mailto:dmccorkle@majortool.com]
Sent: Friday, May 05, 2006 9:56 AM
To: Frank A. Malinowski
Cc: manuel-majortool-com-offsite; Michael E. Viola

Subject: MTM NCR 19392 completed and closed.

Frank,

Please find the attached files regarding the completion and closure of NCR 19392.
<<NCR 19392 mttravlr.pdf>> <<NCR 19392 Closed.pdf>>

Doug McCorkle

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

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

Operation Sub: 247 / Seq: 10 (Closed)	Resource 230-FAB MEDIUM SOUTH	QtyPer 1.00	StartQty 1.00	EndQty 1.00	Drawing ID / Rev /
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.					

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

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

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

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