

Princeton University

Plasma Physics Laboratory
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9 December 2005

Ms. Nancy Horton
Energy Industries of Ohio
6100 Oak Tree Boulevard, Suite 200
Independence, Ohio 44131


SUBJECT: Subcontract S005242-F
Dispositioned PPPL Major Tool & Machine Non-Conformance
Report (NCR) 18776

Dear Ms. Horton:

Attached is Major Tool & Machine Non-Conformance Report 18776 with the disposition assigned by the Princeton Technical Representative Phil Heitzenroeder and approved by the Responsible Line Manager Brad Nelson on 12/09/05.

This NCR will remain open until the required corrective action is performed and verified by the DCMA representative. When corrective action is completed submit an updated copy of the NCR.

Regards,



Larry L. Sutton

Senior Subcontract Administrator

Attachment

cc: M. Tyrrell
F. Malinowski
P. Heitzenroeder

Customer: ENERGY INDUSTRIES OF OHIO

Contact: NANCY HORTON
E-Mail: NKHFlowen@aol.com

Telephone: 216-496-2314
Fax: 216-328-2001

Part: /
Drawing ID: SE141-116 Revision: 6

Customer P.O.: S005242-F/Ln:3
Serial No./Qty:

Reported By: MIKE GRIFFITH
E-Mail: mGriffith@MajorTool.com

Telephone: 317-636-6433
Fax: 317-634-9420

Problem: THERE ARE NUMEROUS INDICATIONS ON THE MACHINED SURFACE OF THE DATUM -D- FLANGE THAT EXCEED THE ALLOWABLE INDICATION SIZE PER ASTM A 903/A 903M LEVEL 1. SEE ATTACHED MAP FOR SIZE AND LOCATION OF INDICATIONS.

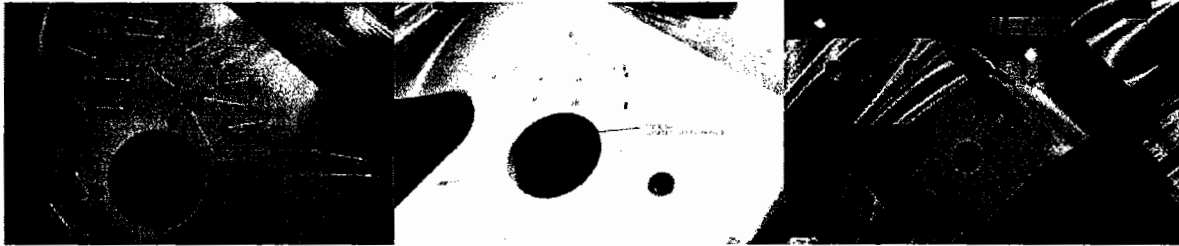
Proposed Disposition:

INDICATIONS WILL BE SUBMITTED TO CUSTOMER FOR REVIEW. CONTINUE MACHINING OF CASTING.

Number of additional pages: 3

Customer Disposition: Use As Is Rework Repair Scrap Replace

THIS REFERS TO THE C3 CASTING. Since these indications are in a low stress area, they can be accepted in this case. However, EIO is requested to radiograph ~18" of the adjacent flange region to assure that those regions do not have unacceptable indications also.. EIO is also requested to investigate why these defects were not identified during NDT testing at the foundry.



Technical Rep. Approval: Phil Heitzenroeder

Digitally signed by Phil Heitzenroeder
DN: CN = Phil Heitzenroeder, C = US,
O = PPPL, OU = Mech. Eng. Division
Reason: I am approving this document
Date: 2005.12.08 13:36:48 -05'00'

RLM Approval: Brad Nelson

Digitally signed by Brad Nelson
DN: cn=Brad Nelson, c=US,
o=ORNL, ou=FED,
email=nelsonbe@ornl.gov
Date: 2005.12.09 09:14:40 -05'00'

Major Tool Implemented By: _____ **Title:** _____ **Date:** _____