

Princeton University

Plasma Physics Laboratory

James Forrestal Campus

P.O. Box CN17

Princeton, N.J. 08543

1 December 2005

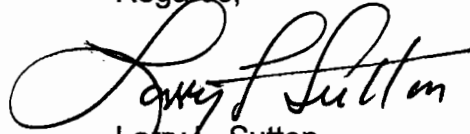
Ms. Nancy Horton
Energy Industries of Ohio
6100 Oak Tree Boulevard, Suite 200
Independence, Ohio 44131

SUBJECT: Subcontract S005242-F
Dispositioned MTM Non-Conformance Report (NCR) 18315

Dear Ms. Horton:

Attached for your file and appropriate action is Major Tool & Machine NCR 18315, dated 3 October 2005, dispositioned by the Princeton Technical Representative for Subcontract S005242-F and the NCSX Responsible Line Manager 29 November 2005.

Regards,



Larry L. Sutton

Senior Subcontract Administrator

Attachment

cc: M. Tyrrell
F. Malinowski
P. Heitzenroeder

Major Tool & Machine, Inc.
1458 East 19th Street
Indianapolis, IN 46218-4289

MTM N/C: 18315

Page: 1
Date: 10/03/05
User ID: BOWLINK

Customer: ENERGY INDUSTRIES OF OHIO
Contact: NANCY HORTON
E-Mail: NKHFlowen@aol.com

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

Part: SE141-116 / MODULAR COIL WINDING FORM TYPE
Drawing ID: SE141-116 Revision: 6

Customer P.O.: S005242-F/Ln:1
Serial No./Qty: C1

Reported By: KEVIN BOWLING
E-Mail: kBowling@MajorTool.com

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

Problem: THE FOLLOWING INSPECTION STEPS PER MTM SUBMITTED IDC REPORT DID NOT HAVE
SUPPORTING DIMENSIONAL DATA FROM THE CMM:

510, 520, 530, 540, 620, 630, 640, 670, 690, 700, 710, 720, 730, 740, 900, 910, 940, 950,

ALSO ONE OF THE FLANGE FACES DID NOT HAVE THE 2" X 2" GRID POINTS IN THE IGES FILE AS
REQUIRED BY THE PRODUCT SPECIFICATION.

Proposed Disposition:

SUBMIT TO CUSTOMER CONTINUE MANUFACTURING.

Customer Disposition: Use As Is Rework Repair Scrap Replace

MTM is to take corrective actions to provide all supporting data from the CMM on subsequent winding forms. To address the situation in the flanges which resulted in inadequate dimensional information, Rev. 10 of NCSX-CSPEC-141-03 has been revised as indicated below:

4.2.5 Verification of Dimensions and Tolerances

All cast surfaces, machined surfaces and features such as holes, ports, supports, etc. shall be dimensionally checked to assure compliance with Section 3.2.2. Cast surfaces shall be checked with measurements taken to approximate 4" x 4" grid; machined surfaces shall be checked with measurements taken to approximate a 2" x 2" grid; features such as holes, ports, supports, etc. shall be verified per standard machine shop practices. On the winding tee flange, where a 2" x 2" grid would result in a single line of measurements, a minimum of 2 readings (two lines of measurements) shall be recorded.

Phil
Heitzenroeder

Digitally signed by Phil Heitzenroeder
DN: CN = Phil Heitzenroeder, C = US, O
= PPPL, OU = Mech. Eng. Division
Reason: I agree to 'specified' portions of
this document
Date: 2005.11.28 20:11:23 -05'00'

Brad Nelson

Digitally signed by Brad Nelson
DN: cn=Brad Nelson, c=US,
o=ORNL, ou=FED,
email=nelsonbe@ornl.gov
Date: 2005.11.29 08:22:00 -05'00'

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

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