

Customer: PRINCETON PLASMA PHYSICS LAB

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Part: /

Drawing ID: SE121-014 Revision: 2
 Links: 1-Type:W: 65678/1.0 Sub: 0 Op: 10

Customer P.O.: S005243-F/Ln:1
 Serial No./Qty:

Reported By: DOUG MCCORKLE
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Problem: THE OUTSIDE PROFILE OF THE SPACER FLANGES WERE CHAMFERED NEAR THE LOCATION OF THE SPACER PORT EXTENSION. CHAMFERS ARE APPROXIMATELY 1/4" DEEP X UP TO 45 DEG. NO CHAMFER ON DRAWING.
 REFER TO ATTACHED PICTURE

Proposed Disposition:

CUSTOMER DISPOSITION REQUIRED.

Number of additional pages:_____

Customer Disposition: [] Use As Is [] Rework [] Repair [] Scrap [] Replace

Technical Contact Approval:_____

Title:_____ **Date:**_____

Buyer Approval:_____

Title:_____ **Date:**_____

Major Tool Implemented By:_____

Title:_____ **Date:**_____

Root Cause 1: 802-MANAGEMENT DECISION

Resource: SILVER TEAM, ENGINEERING Equipment:

Description: THE AMOUNT OF EXCESS MACHINING STOCK LEFT ON THE OUTSIDE PROFILE OF EACH FLANGE CREATED ACCESS LIMITATIONS TO COMPLETE THE WELD AROUND THE PORT EXTENSION. THE DECISION WAS MADE BY MTM TO GRIND CLEARANCE CHAMFERS ON THE OUTSIDE OF THE FLANGES KNOWING IT COULD BE EASILY REPAIRED LATER IF CUSTOMER CONCERNS EXISTED.

Corr Actn: 1:

Action: 01/20/06 By: 775-D.MCCORKLE

Description: CURRENTLY MTM CONSIDERS THE ISSUE COSMETICAL AND NO FURTHER CORRECTIVE ACTION REQUIRED.

Verify Notes: COMPLETE

Nonconformance Report: Major Tool NC19108

This is for SE121-014

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CURRENTLY MTM CONSIDERS THE ISSUE COSMETICAL AND NO FURTHER CORRECTIVE ACTION

Doug McCorkle

Project Disposition:

Rework to bring into compliance with drawing – The project cannot determine a priori that the scallops cut from the back side of the flanges will leave sufficient stock in all cases for subsequent machining of the flanges prior to assembly of the three field periods. MTM is requested to fill in the scallops on the back side of the flanges via approved welding procedure.

Approvals:

Procurement Technical Representative

Responsible Line Manager:

Project Quality Assurance: