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

MTM N/C: 20120

Date: 07/27/06
User ID: MCCORKLE

Customer: PRINCETON PLASMA PHYSICS LAB
Contact:
E-Mail: mviola@pppl.gov
Telephone: 609-243-3655
Fax: 609-243-2021

Part: / VVSA # 2
Drawing ID: SE120-004 Revision: 2
Customer P.O.: S005243-F/Ln:2
Qty: 1

Reported By: DOUG MCCORKLE
E-Mail: dMcCorkle@MajorTool.com
Telephone: 317-636-6433
Fax: 317-634-9420

Problem: 1.25 +.01 / -.0725 Port NB flange thickness checks 1.220 to 1.280. (after 19868)
Drawing SE121-013: 0.469 +/- .005 checks .645 - .810.
Drawing SE121-013: 0.637 +/- .005 checks .600 - .750.

Proposed Disposition:
Propose: USE AS IS

Number of additional pages: 0

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

Technical Contact Approval: _____ **Title:** _____ **Date:** _____

Buyer Approval: _____ **Title:** _____ **Date:** _____

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

Nonconformance Report: Major Tool NC20120

This is for: **VVSA # 2 Profile** SE120-004

Problem:

1.25 +.01 / -.0725 Port NB flange thickness checks 1.220 to 1.280. (after 19868)
Drawing SE121-013: 0.469 +/- .005 checks .645 - .810.
Drawing SE121-013: 0.637 +/- .005 checks .600 - .750.

MTM Proposed Disposition: Use as is.

Project Disposition:

Use as is.

From: Thomas G. Brown
Sent: Thursday, July 27, 2006 12:12 PM
To: Michael E. Viola; Phil Heitzenroeder; Cole, Michael J.; Paul Goranson (goransonpl@ornl.gov); Bradley E. Nelson
Subject: VVSA2 NCR review

NCR 20120:

1. 1.25 +.01 / -.0725 Port NB flange thickness checks 1.220 to 1.280. (after 19868)

2. Drawing SE121-013: 0.469 +/- .005 checks .645 - .810. (Located at B5 on drawing)
3. Drawing SE121-013: 0.637 +/- .005 checks .600 - .750. (Located at G5 on drawing)

Comment:
We agree with item 1 (change in NB flange thickness). Use as is. There is some confusion on items 2 and 3 covering se121-013. A PDF drawing is attached. Item 2 covers the locating holes which we thought were to be welded closed or omit, but maybe we're wrong. It appears that the .645 -.810 dimension inspected would make the whole break through the .75" thick part. We agree with the "Use as is" on item 3. This inspection must have been made on the individual part before the flange was welded on the vessel as the seal plate would be welded to the flange; Right?

Further comment from Mike Viola below explaining Item 2 and 3.
This was accepted by Tom Brown and Mike Cole.

From: Michael E. Viola
Sent: Friday, July 28, 2006 10:10 AM
To: Thomas G. Brown; 'Cole, Michael J.'
Cc: 'McCorkle, Doug'; Bob Simmons; Brad Nelson; Frank A. Malinowski; Larry L. Sutton; Lawrence E. Dudek; Marianne Tyrrell; Paul Goranson; Phil Heitzenroeder; Wayne T. Reiersen
Subject: Pictures showing end flange thickness and features

Here are some pictures of the end flange which show why the dimension to the hole features in the end flanges are further from the face. The flanges are an inch thick in places.

The flanges were 1.5" original stock. The flange features were put on by translating the measurement to the back side (shell side) of the flange and then machined. The additional material remained on the front side (flange face) for final machining. Evidently the shell was trimmed back a bit too far. When the flange faces were machined to final dimensions extra flange thickness was present therefore the flange features are deeper – further from the face than expected.

Approvals:

Mike Viola

Digitally signed by Mike Viola
DN: cn=Mike Viola, c=US
Reason: I am approving this document
Date: 2006.07.28 11:03:22 -04'00'

_____

Procurement Technical Representative

_____

Responsible Line Manager: