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

MTM N/C: 20384

Date: 08/28/06
User ID: MCCORKLE

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

Part: /
Drawing ID: SE120-002 Revision: 1
Customer P.O.: S005243-F/Ln:3
Serial No./Qty: VVSA # 3

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

The profile of the vessel checks -0.414 / +0.537.
The position of boss "a" on half "a" checks 1.303.
The position of boss "b" on half "a" checks 1.290.
The position of boss "c" on half "a" checks 1.233.
The position of boss "d" on half "a" checks 1.054.
The position of boss "a" on half "b" checks 1.446.
The position of boss "b" on half "b" checks 1.381.
The position of boss "c" on half "b" checks 1.691.
The position of boss "d" on half "b" checks 0.895.
The nb port height checks from 98.502 / 98.598.
The parallelism of the flange face on prt 12b checks 0.115.
The profile of port 12a checks from -0.199 / +0.330.
The profile of port 12b checks from -0.488 / +0.489.
The profile of the nb port checks -0.150 / +0.218.

Proposed Disposition:

CUSTOMER DISPOSITION REQUIRED

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 NC20384

This is for: **VVSA # 3 Profile** SE120-002

Problem: See 060828 65678-3 FINAL NUMBERS.MC9; 060828 65678-3 VESSEL FINAL SCAN.xls; 060828 65678-3NB PORT.xls; 060828 65678-3PORT 12'S.xls at ftp://ftp.pppl.gov/pub/vio-vvsa/VVSA%203/

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4. The position of boss "c" on half "a" checks 1.233.
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8. The position of boss "c" on half "b" checks 1.691.
9. The position of boss "d" on half "b" checks 0.895.
10. The nb port height checks from 98.502 / 98.598.
11. The parallelism of the flange face on prt 12b checks 0.115.
12. The profile of port 12a checks from -0.199 / +0.330.
13. The profile of port 12b checks from -0.488 / +0.489.
14. The profile of the nb port checks -0.150 / +0.218.

Project Disposition:

After review by Mike Cole and Art Brooks, the project has determined that the shell geometry poses no hard interferences and the plasma encroachment is acceptable. The bosses had been reviewed and previously accepted. However, due to some discussion about the method of calculation of the boss true positions reported by Major Tool above, a second review was made along with further discussion with Major Tool. This review is summarized in the two attachments included with this NCR. “RE NCR20384 boss numbers.msg” and “Final data for review of VVSA3 NC 20384.msg” Therefore, project disposition is: use as is.

Approvals:

Mike Viola

Digitally signed by Mike Viola
DN: cn=Mike Viola, c=US
Reason: I have reviewed this document
Date: 2006.09.11 09:24:06 -04'00'

_____

Procurement Technical Representative

Brad Nelson

Digitally signed by Brad Nelson
DN: cn=Brad Nelson, c=US, o=ORNL, ou=FED, email=nelsonbe@ornl.gov
Date: 2006.09.13 09:34:36 -04'00'

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Responsible Line Manager: