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**Customer: PRINCETON PLASMA PHYSICS LAB**

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**Part: /**

Drawing ID: SE120-004

Revision: 2

Customer P.O.: S005243-F/Ln:2  
Serial No.: VVSA 2

Reported By: DOUG MCCORKLE  
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Problem: THE RESULT OF PROFILE DEVIATION ON THE VESSEL ENDS CAUSES A MIS-ALIGNMENT TO THE VESSEL FLANGES. REFER TO PHOTOS FOR ADDITIONAL DESCRIPTION.

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**Proposed Disposition:**

CUSTOMER DISPOSITION REQUIRED  
RECOMMEND LEAVING THE VESSEL WALL IN ITS CURRENT POSITION AND ALTERING THE WELD SCHEME TO BLEND THE TWO SURFACES TOGETHER IF NO ASSEMBLY OR PLASMA INTERFERENCE EXIST.

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Number of additional pages: 0

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**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 NC19562

This is for SE120-004 VVSA #2 end flange fit up and weld.

Problem:

THE RESULT OF PROFILE DEVIATION ON THE VESSEL ENDS CAUSES A MIS-ALIGNMENT TO THE VESSEL FLANGES. REFER TO PHOTOS FOR ADDITIONAL DESCRIPTION.

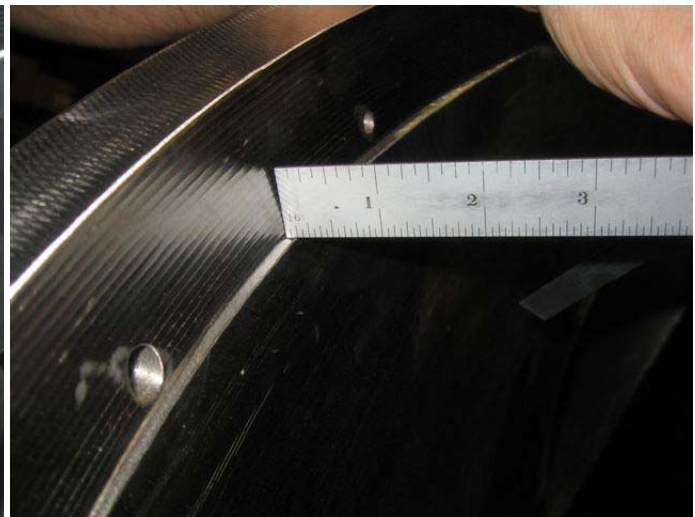
**MTM Recommended Disposition:**

RECOMMEND LEAVING THE VESSEL WALL IN ITS CURRENT POSITION AND ALTERING THE WELD SCHEME TO BLEND THE TWO SURFACES TOGETHER IF NO ASSEMBLY OR PLASMA INTERFERENCE EXIST

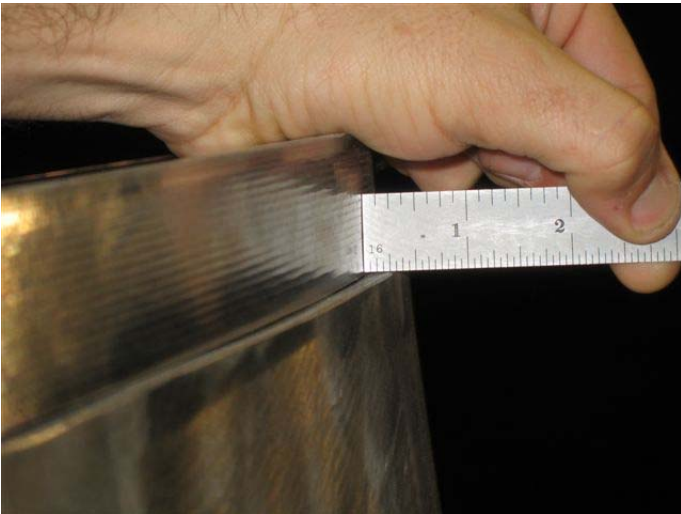
See pictures below:



8 O'clock Inside of Flange B



8 O'clock Inside of Flange B



2 O'clock Outside of Flange B



**8 O’Clock Inside of Flange A (nearly flush)**



**10 O’clock outside of Flange A**

**Project Disposition:**

Rework as Recommended by MTM.  
Ensure weld size is equal or greater to original.

**Approvals:**

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Procurement Technical Representative

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Art Brooks, Technical Assurance

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Responsible Line Manager:

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Project Quality Assurance: