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**Customer: PRINCETON PLASMA PHYSICS LAB**

Contact: Mike Viola  
E-Mail: S-04286-F

Telephone: 609-243-2441  
Fax: 609-243-2021

**Part: /**

Drawing ID: SE120-004

Revision: 2

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

Reported By: DOUG MCCORKLE  
E-Mail: dMcCorkle@MajorTool.com

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

Problem: The true position of lifting boss "a" on half "a" of the vessel checks 0.275 or 0.025 out of tolerance.

The true position of lifting boss "c" on half "a" of the vessel checks 0.451 of 0.201 out of tolerance.

The true position of lifting boss "c" on half "b" of the vessel checks 0.361 or 0.111 out of tolerance.

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**Proposed Disposition:**

CONTINUE MANUFACTURING  
SUBMITTING TO PPPL FOR DISPOSITION

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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 NC18888

This is for SE122-004 Bosses

Mike, please review the attached Non-conformance and provide disposition. According to our fabricators, the Clevis Boss details have proven to be much more difficult to control (position) than we expected.

**Problem:**

The true position of lifting boss "a" on half "a" of the vessel checks 0.275 or 0.025 out of tolerance.

The true position of lifting boss "c" on half "a" of the vessel checks 0.451 of 0.201 out of tolerance.

The true position of lifting boss "c" on half "b" of the vessel checks 0.361 or 0.111 out of tolerance.

Best Regards,  
Doug McCorkle

**Clarification (Viola):**

Per SE122-004 Sheet 1, Bosses labeled "A" thru "D" correspond to Items 48-51 respectively. Half "a" and "b" refer to half of the 120 degree section. The values indicated are maximums relative to TPT of datum B and C (X Y Plan view). I have asked if there is any tilt involved and they will get back to me.

**Project Disposition:**

Bosses A & B are alignment features. If the hole has been bored in the boss, the boss will have to be redone; otherwise we can accept the correctly drilled hole in a misplaced boss.

Boss C is a handling hole and may be used as is.

**Project Disposition Revision 1:**

After further consideration Boss A may be accepted as is because it is just slightly out of tolerance and the risk to repair it is greater than the alignment risk. Major Tool stated that additional care will be placed on the remaining boss installations.

Boss C is a handling hole and may be used as is.

**Approvals:**

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Procurement Technical Representative

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Responsible Line Manager:

