
Customer: PRINCETON PLASMA PHYSICS LAB

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Part: /

Drawing ID: SE120-003

Revision: 0

Customer P.O.: S005243-F/Ln:2
Qty: 3

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Problem: PORT NB HAS DEFORMATION TO HOLE PATTERN AFTER WELDING HAS BEEN COMPLETED ON PORT 4 A/B AND 12 A/B HOLES DO NOT ALIGN TO MATING THREADED HOLE IN NB COVER. HOLES DID ALIGN AFTER NB WAS WELDED IN,BUT DO NOT NOW THAT PORT 4 AND 12 IS COMPLETED.

Proposed Disposition:

CUSTOMER DISPOSITION REQUIRED.
THE FLANGE IS ALSO OUT OF FLAT UP TO 1/16".
UNIT # 1 HOLES WERE OPENED UP TO 5/8" DIAMETER TO PROVIDE THE NECESSARY CLEARANCE FOR ASSEMBLY PRIOR TO VACUUM TESTING. THE EXTRA WELDING ON UNIT # 1 WAS SUSPECTED TO BE THE CAUSE OF THE EXCESS DISTORTION. THIS PROVED INCORRECT AFTER UNIT # 2 FLANGE ALSO DISTORTED. UNIT # 3 HAS NOT BEEN INSTALLED YET, BUT IS EXPECTED TO REACT THE SAME. MTM RECOMMENDS OPENING ALL NB FLANGE HOLES UP TO 5/8" AND RE-FACING THE FLANGE FLAT AFTER ALL PORTS ARE WELDED IN PLACE (A MINIMUM THICKNESS WILL BE NEEDED).

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 NC19289

This is for SE120-003

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Doug McCorkle

Project Disposition:

Rework as proposed – Out of flat flanges are not acceptable. The project agrees that the flanges should be faced off after welding. Since hole pattern errors would require custom mating parts in the future, the project accepts the proposal to open up the holes to 5/8 diameter.

Approvals:

Procurement Technical Representative

Responsible Line Manager:

Project Quality Assurance: