
Customer: PRINCETON PLASMA PHYSICS LAB

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Part: /

Drawing ID: SE122-072

Revision: 1

Customer P.O.: S005243-F/Ln:3
Serial No./Qty: 1 (VVSA 3)

Reported By: DOUG MCCORKLE

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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:

The flange has been reworked in the same manner as unit 1 & 2. The NB flange face was re-cut to restore flatness. The holes were opened up to 5/8" dia. The flange thickness now checks 1.228-1.241.

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 NC19869

This is for: **VVSA # 3 Profile** SE122-072

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.

MTM Recommended Disposition:

The flange has been reworked in the same manner as unit 1 & 2. The NB flange face was re-cut to restore flatness. The holes were opened up to 5/8" dia. The flange thickness now checks 1.228-1.241.

Use as is.

Project Disposition:

Use as is.

Approvals:

Procurement Technical Representative

Responsible Line Manager: