

805 281 4065

To: Brad Nelson	From: Mike Viola
Fax: 765 574 2829	Fax:
Phone:	Phone: 609 243 3655

Subject:

NCR's from Rohwedder

6/3/2004

Comments:

Brad,

Date:

Please sign these NCR's as the Responsible Line Manager.

And FAX back to Frank at 609 243 3366

Thanks,

Mike

1 this to 576 79 25 at

FINAL ACCEPTANCE

MAY.18 2004 11:36 506 363 3851 #148/ F 004/005 PRECISION METAL WORKS <u>PRECISION</u> ADITECH Metal works menule maining 17.00 The Iboten of Spolity and benevalism. Figure P043 MONCONFORMANCE REPORT Revision: 0 **的域籍**中国,1028年/1984年 DESCRIPTION PART No.: NCR No. Seamen 6 EE HMY TO DRAWINGNO JOB No.: LOT No.: 03-8083 SUFFLIER P.O. Na.: DATE: MAY 17/04 CHOON FORMANCE DETAILS QUANTITIES AFICE EXISSIVE LEDOK RECEIVED THE SCANNED INSPECTED HELD Preliminary (4 Disposition USE AS IS VELE. ACCEPTABLE : REPAIR PERD REWORK REJECT DOCUMENTS OPERATOR DESPOSITION INSTRUCTIONS O Dane USE AS IS AFFEL ZYSCUSSION WITH DAVE KLOUN REPAIR TIME MINS REWORK RESECT to FURHER & DOCUMENTS CHARGE SUPPLIER YES NO G CORRECTIVE/ACTION REQUIRED YES 🔲 NO 🔼 CUSTOMER REPRESENTATIVE DATE QA MANAGER DATE MAL DATE OPERATIONS MANAGER LIMPREDURED . . y the same RE-INSPECTION COMMENTS

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DATE

DATE:

NCR#	DESCRIPTION	MITP#	MITP STEP	DISPOSITION DATE
04	SEGMENT B	MITP04B	407	APRIL 30, 2004
MAY	DIMENSIONAL			
33	TOLERANCE			

DISPOSITION REASONING/INSTRUCTIONS

Based on phone conversations with PPPL / RI decision was made to get fitting edges into tolerance so that project could be moved forward since rework seemed to only chase out of tolerance area around. This out of tolerance could be attributed to die rib movement. It could also be a result of the lack of ability to get the 3D contouring necessary out of the 1" ribs. It is recommended that the rib design be thoroughly evaluated and changes made. Some changes might include more ribs closer together, thinner ribs making a solid forming surface, more segments (4 or 5 instead of 3), better reinforcements, and increased forming area bigger than surface area of segment to be formed.

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PRECISION metal works

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NCR#	DESCRIPTION	MITP#	MITP STEP	DISPOSITION DATE
04	SEGMENT C	MITP04C	407	APRIL 30, 2004
MAY	DIMENSIONAL			
34	TOLERANCE	İ		

DISPOSITION REASONING/INSTRUCTIONS

Based on phone conversations with PPPL / RI decision was made to get fitting edges into tolerance so that project could be moved forward since rework seemed to only chase out of tolerance area around. This out of tolerance could be attributed to die rib movement. It could also be a result of the lack of ability to get the 3D contouring necessary out of the 1" ribs. It is recommended that the rib design be thoroughly evaluated and changes made. Some changes might include more ribs closer together, thinner ribs making a solid forming surface, more segments (4 or 5 instead of 3), better reinforcements, and increased forming area bigger than surface area of segment to be formed.

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NCR#	DESCRIPTION	MITP#	MITP STEP	DISPOSITION DATE
04	SEGMENT A1	MITP04A1	407	APRIL 30, 2004
MAY	DIMENSIONAL			
35	TOLERANCE			

DISPOSITION REASONING/INSTRUCTIONS

Based on phone conversations with PPPL / RI decision was made to get fitting edges into tolerance so that project could be moved forward since rework seemed to only chase out of tolerance area around. This out of tolerance could be attributed to die rib movement. It could also be a result of the lack of ability to get the 3D contouring necessary out of the 1" ribs. It is recommended that the rib design be thoroughly evaluated and changes made. Some changes might include more ribs closer together, thinner ribs making a solid forming surface, more segments (4 or 5 instead of 3), better reinforcements, and increased forming area bigger than surface area of segment to be formed. Also, this segments length was shorter by 2.5" than what it was suppose to be. This is due to the unforeseen need to have to form this segment, which use to be Segment A, in two pieces meaning Segment A had to be cut in half. This was done in hopes that material would be able to be gained when reforming these halves A1 and A2, which was not the case. This issue resulted from the failure to press segment A due to the complexity and size of this segment. In the future, segments will be divided up so that the size and complexity is minimized but will not compromise other process steps.

> 9B 6/1/04 Mleok 6/3/04

MAY.18 2004 11:35 506 363 3851

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NCR#	DESCRIPTION	MITP#	MITP STEP	DISPOSITION DATE
04	SEGMENT A2	MITP04A2	407	APRIL 30, 2004
MAY	DIMENSIONAL			
36	TOLERANCE			

DISPOSITION REASONING/INSTRUCTIONS

Based on phone conversations with PPPL / RI decision was made to get fitting edges into tolerance so that project could be moved forward since rework seemed to only chase out of tolerance area around. This out of tolerance could be attributed to die rib movement. It could also be a result of the lack of ability to get the 3D contouring necessary out of the 1" ribs. It is recommended that the rib design be thoroughly evaluated and changes made. Some changes might include more ribs closer together, thinner ribs making a solid forming surface, more segments (4 or 5 instead of 3), better reinforcements, and increased forming area bigger than surface area of segment to be formed. Also, this segments length was shorter by 2.5" than what it was suppose to be. This is due to the unforeseen need to have to form this segment, which use to be Segment A, in two pieces meaning Segment A had to be cut in half. This was done in hopes that material would be able to be gained when reforming these halves A1 and A2, which was not the case. This issue resulted from the failure to press segment A due to the complexity and size of this segment. In the future, segments will be divided up so that the size and complexity is minimized but will not compromise other process steps.

> 9B 6/1/04 6/1/04

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NCR#	DESCRIPTION	MITP#	MITP STEP	DISPOSITION DATE
04	Magnetic Permeability of	MITP05	208	MAY 10, 2004
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37				

DISPOSITION REASONING/INSTRUCTIONS

This inspection was done using a reference flange and not the actual flange on the PVVS so there was no disposition required since final flange on PVVS was within spec. In the future, all incoming parts will have their magnetic permeability measured and passing inspection prior to next process step (stopping points).

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NCR#	DESCRIPTION	MITP#	MITP STEP	DISPOSITION DATE
04 MAY 38	Radiography and LP	MITP05	315, 334, 513, 603	MAY 19, 2004

DISPOSITION REASONING/INSTRUCTIONS

Densometer calibration not required due to experience of technician, and LP tests failed were only stitch welds for reinforcement. Tube reattachment weld failing was believed to be caused by backing ring, it was agreed between PPPL/PMW that this could go on as is knowing that we can get it right for VVSA. Practice welds will be done simulating penetration weld with backing ring prior to doing any of these welds. This will ensure that a full penetration weld can be achieved.

45 6/1/04 MUliona 6/3/9

RECEIVED INSPECTED HELD INSPECTOR

DATE

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MAY.26'2004 15:36 506 363 3651

COMMENTS

THE WASHINGTON

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PRECISION METAL WORKS ADTECH TOWN THE COURT THE PRECISION metal works das Mister al Guntier mit Janeustien NONCOMFORNANCE REPORT Poster FO13 1.40 NCK No.: PART No.: PESCENTION AVVS ASSY MAGNETIC LOT No.: JOB No.: DRAWING No.: 03-8083 Mmp-05 DATE: 7.O. No.: MAY 26/04 SUPPLIER QUANTITIES NONCONFORMANCE DETAILS RECEIVED NICKEL ERMERBILITY FOR INSPECTED HELD □ USE A5 75 REPAIR REWORK REJECT DOCUMENTS OFERATOR 7 DISPOSITION INSTRUCTIONS USE AS ES CARBY INGERT REPAIR DPTOS A: BEVORK and the A REJECT DOCUMENTS ATTACHMENT A See 61 $c_{1} = c_{2}^{-1} \cdot c_{3}^{-1} \cdot c_{3}^{-1} \cdot c_{3}^{-1}$ YES I NO E CORRECTIVE ACTION REQUIRED CHARGE SUPPLIER YES NO L DATE QA MANAGED CLETOWER REPERSENTATIVE DATE HOL MICHELL DATE OFERATIONS MANAGER DATE THE REQUIRED RE-INSPECTION QUANTITIES

DATE FINAL ACCEPTANCE

NCR#	DESCRIPTION	MITP#	MITP STEP	DISPOSITION DATE
04	Magnetic	MITP05	312, 333,	MAY 27, 2004
MAY	Permeability		512, 602	
40	Reference		<u>.</u>	

DISPOSITION REASONING/INSTRUCTIONS

1.01 mu reference not available with our instrument so PVVS was checked to 1.02 and passed, after discussion with PPPL/RI/PMW it was decided to send instrument out for recalibration and recheck PVVS.

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MAY.26'2004 15:36 506 363 3851

PRECISION WEIGH MONUS

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NCR#	DESCRIPTION	MITP#	MITP STEP	DISPOSITION DATE
04 MAY 41	Splice Addition to Assembly	MITP05	102	APRIL 20, 2004

DISPOSITION REASONING/INSTRUCTIONS

Segment A2 was wrongly cut to earlier model (before cut line of segment was relocated), material was still available from formed segment for A2. This issue resulted from the failure to press segment A due to the complexity and size of this segment. In the future, segments will be divided up so that the size and complexity is minimized but will not compromise other process steps. In addition, proper document handling and revision incorporations will be used to prevent potential wrong work from happening.

4B 6/1/64 MV/eik 6/3/4