

**NCSX Preliminary Design Cost Estimate Summary Form  
(Attachment 1a)**

**SUMMARY DESCRIPTION**

<b>WBS Number: 185</b>	<b>Title: Assemble Field Periods</b>
<b>Originator: Jim Chrzanowski</b>	
<p><u>Description:</u> This WBS element consists of those activities associated with the assembly of the three individual field periods in the TFTR Test Cell. The work scope includes:</p> <ul style="list-style-type: none"><li>• Assembly and alignment of the TF/Modular coils with 1/3 of the vacuum vessel;</li><li>• Installation of magnetic diagnostics, cooling tubes, and insulation onto the VV segment;</li><li>• Positioning and welding port extensions onto the VV segment;</li><li>• Completing bakeout of the VV segment to 150 degrees C;</li><li>• Vacuum leak checking of the vessel segment and port extensions;</li><li>• Transportation of each field period to the NCSX Test Cell for final assembly.</li></ul>	
<p><u>Description of Existing Equipment/Facilities to be Reused:</u>   <b>None</b></p>	
<p><u>Description of Major Modifications Required to Existing Equipment/Facilities:</u>   <b>None</b></p>	