NCSX RFD Part I	**Number:** 14-004	**RFD Description:** Add fillets to Modular Coil Lower Lead Blocks to aid machining

Initiator: John Puhl	**Organization:** JP Pattern

List of Impacted Documents: ***(Specification, MIT/QA Plan, SOW, drawing, etc.)***
Drawing: SE142C-134-r0
Drawing: SE142C-135-r0

Cost Impact: ***(If none, so state)***
NONE

Schedule Impact: ***(If none, so state)***
NONE

Quality Impact: ***(If none, so state)***
NONE

State Requirement Deviation is Requested For*: (Specification, MIT/QA Plan, SOW, drawing, etc.)*
Drawing: SE142C-134-r0
Drawing: SE142C-135-r0

Full Description of the Deviation Requested: ***(Use continuation pages, e-mails, letter, sketches, etc. as needed and include amplifying information as appropriate to support deviation request.)***
The following changes are requested to to aid in machining (see attached sketches).

- C02a_fillet-n-rnds_se142c-134-r0
  - 1/16 fillet added to posts due to surface not being planar. Is this acceptable? If not area could be filed out.(red)
  - 1/16 fillet added to inner rib.(red)
  - 1/64 round added due to area being extremely thin. (Cyan)
  - 1/32 round added to ribs due to area being thin also (yellow)
- C02a_fillet-n-rnds_se142c-135-r0
  - 1/16 fillet added to posts due to surface not being planar. Is this acceptable? If not area could be filed out.(red)
  - 1/64 round added due to area being extremely thin. (Cyan)

Attachments:
[1] C02a_fillet-n-rnds_se142c-134-r0.gif
[2] C02a_fillet-n-rnds_se142c-135-r0.gif
[3] E-mail dated July 12, 2005 from James Woznicki (JPP) to Dudek and Nelson

Initiator Signature: See Attachment [3] Date: July 20, 2005

NCSX RFD Part II	**Number: 14-004**	**RFD Description: Add fillets to Modular Coil Lower Lead Blocks to aid machining**
RLM: Brad Nelson	**Organization: ORNL**	

Impact on Interfaces with Other WBS Elements/Items: ***(If none, so state)***
None

RLM Recommended Disposition:

☒ **Approve** ☐ **Do Not Approve (If recommendation is to approve, ECP will be assigned)**

Additional remarks:

WBS Manager (D. Williamson) –

PTR (L. Dudek) –

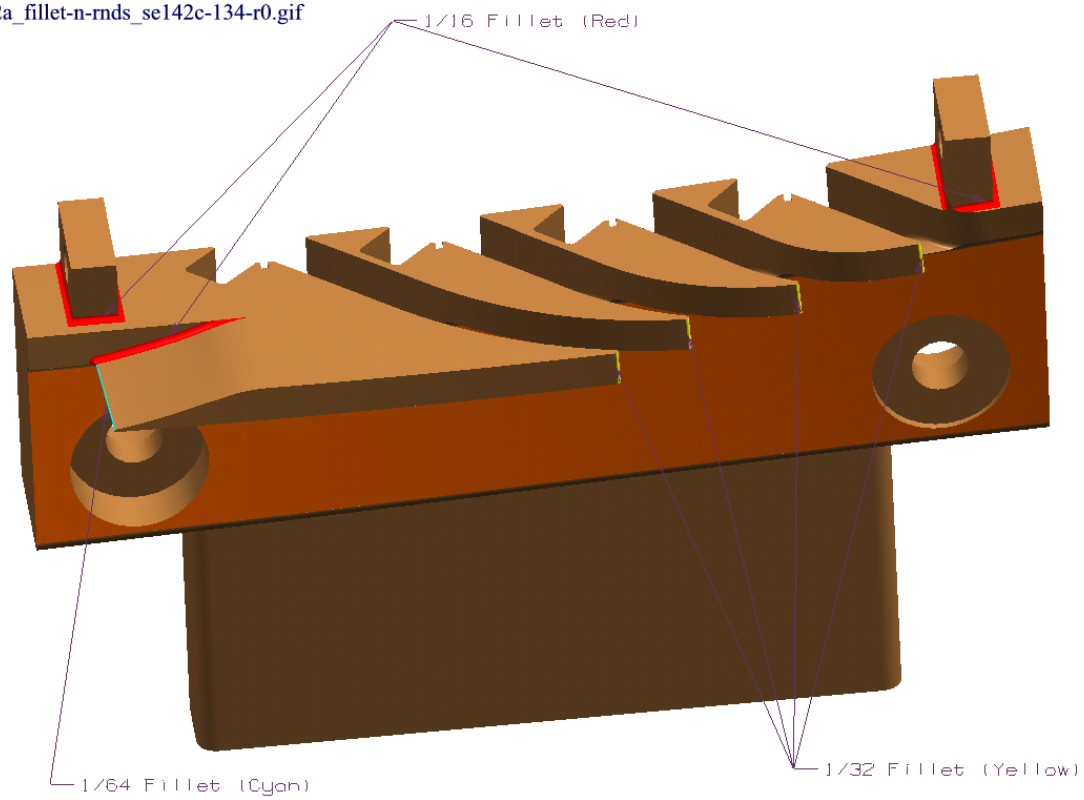
RLM Disposition: Approve with caveat that mating parts be chamfered to clear added fillets.

RLM Signature: Brad Nelson Digitally signed by Brad Nelson DN: cn=Brad Nelson, c=US, o=ORNL, ou=FED, email=nelsonbe@ornl.gov Date: 2005.07.25 20:48:25 -04'00'

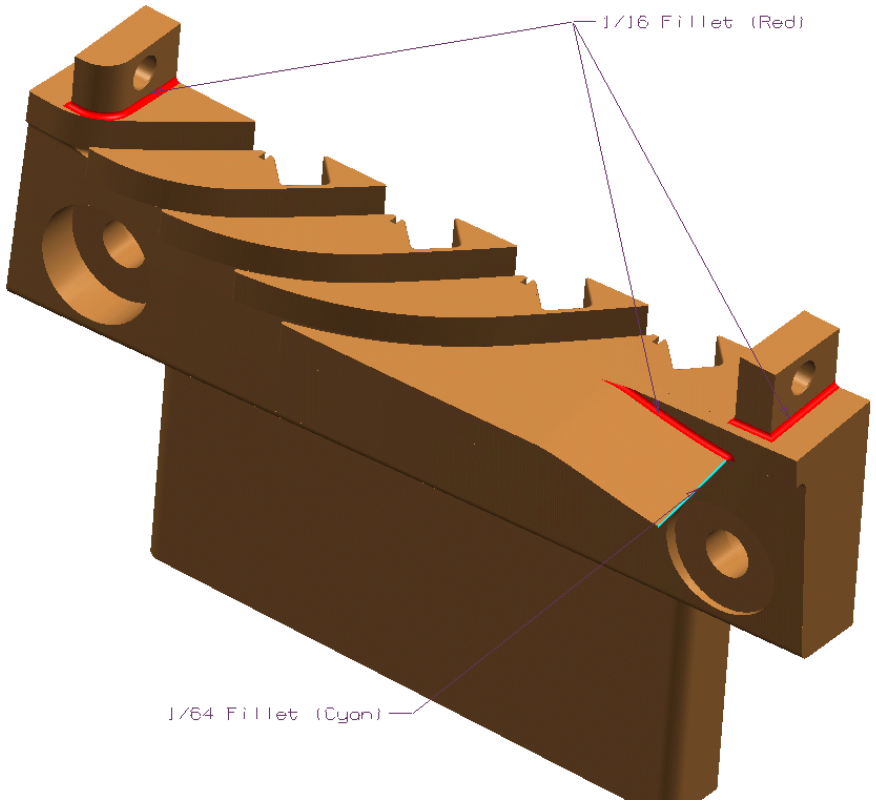
Project Disposition: (Include ECP Number): Approve with caveat that mating parts be chamfered to clear added fillets.

Wayne Reierse n Digitally signed by Wayne Reiersen DN: CN = Wayne Reiersen, C = US, O = PPPL Reason: I attest to the accuracy and integrity of this document Date: 2005.07.25 09:26:28 -04'00'

Attachment [1]
c02a_fillet-n-rnds_se142c-134-r0.gif



Attachment [2]
c02a_fillet-n-rnds_se142c-135-r0.gif



Attachment [3]

From: James Woznicki [mailto:jimw@jppattern.com]
Sent: Tuesday, July 12, 2005 8:00 AM
To: Nelson, Brad E.; ldudek@pppl.gov
Cc: Johnp@jppattern.com; Jobfile Notes
Subject: NcSX Lead Supports Fillets-n-Rnds (JP20051092)

Brad/Lawrence,

I have reviewed the lower lead support data for preparation of machining. Attached are a few images with fillets and rounds added to aid in machining.

* C02a_fillet-n-rnds_se142c-134-r0

  * 1/16 fillet added to posts due to surface not being planar. Is this acceptable? If not area could be filed out.(red)
  * 1/16 fillet added to inner rib.(red)
  * 1/64 round added due to area being extremely thin. (Cyan)
  * 1/32 round added to ribs due to area being thin also (yellow)

* C02a_fillet-n-rnds_se142c-135-r0

  * 1/16 fillet added to posts due to surface not being planar. Is this acceptable? If not area could be filed out.(red)
  * 1/64 round added due to area being extremely thin. (Cyan)

Please review images and reply if these added fillets and rounds are acceptable.

Thanks,

James C. Woznicki
J.P.Pattern Inc.
262-781-2040 Ext 19.