

**COGNIZANT INDIVIDUAL: Tom Brown**

**ECN TITLE: NCSX General Revisions for Manufacturing Intent**

**CC/WP/Job:9450-1\*\*\*-1803**

**AREA OR PROJECT: NCSX**

**LIMITATION OF SCOPE - NOTE: A Work Planning Form is NOT required if the total change to be accomplished (ENG-032):**

- Is not large or complex or does not represent a new installation into a usable space
- Does not have a significant ES&H impact
- Does not involve tritium or other radioactive contaminated or activated equipment
- Does not impact multiple projects, systems, or groups

OR does not change the scope or intent of the original design.

Responsible Line Manager CONCURRENCE: \_\_\_\_\_

(Signature indicates that no Work Planning form is required.)

If non-concurrence or associated with a work planning form, enter the WP number: \_\_\_\_\_

DRAWING(S) AFFECTED NUMBER:	Current Revision	TITLE
SE184-051	0	V.V. Support Assy Base Support Weldment
SE184-052	0	V.V. Support Assy Support "Tee" Bar Weldment
SE184-056	0	V.V. Support Assy Vertical Support Weldments
SE185-301	0	FPA Fixture Floor Mounted Roller Tracks and Screens
SE185-303	0	FPA Fixture Floor Mounted Roller Tracks w/ V.V. Base Supt
SE185-304	2	MCWF HPA w/ Sissco Lifting System for Positioning Over V.V.
SE185-314	1	MCWF Half Period Lifting Fixture Frame Assemblies
SE185-316	0	MCWF Half Period Lifting Fixture Frame Weldment
SE185-329	0	MCWF HP Lifting Fixture Frame Load Test Assemblies
SE186-200	0	Station 2 Rotation Fixture Assy – HP from Hor to Vert
SE186-306	0	MCWF Seg "A" Support Bracket Weldments
SE186-307	0	MCWF Seg "C" Support Bracket Type #1 Weldments
SE186-308	0	MCWF Seg "C" Support Bracket Type #2 Weldments
SE186-327	0	FPA Fixture Floor Mounted Anti-tipping Plate Weldments
SE186-331	1	MCWF Support Cart Misc. Details
SE186-332	0	Anti-Tip Channel Weldment
SE186-333	1	Adjuster Bar Support Structure Weldments and Details

**DESCRIPTION OF CHANGE:** (state drawing no., zone, group, or list attachments)  
 SE184-051: Delete McMaster-Carr # from callout, threaded rod, part #4. Revise weld callout.  
 SE184-052: Revise weld callout.  
 SE184-056: Add material thickness dimensions to parts 11 & 12. Revise weld callout.  
 SE185-301: Add V.V. Support Assy Outrigger to field of drawing.  
 SE185-303: Add V.V. Vertical Support Weldment and Outrigger Weldment.  
 SE185-304: Delete 1 ½" Lifting Shackle Link Weldment from Assembly.  
 SE185-314: Delete 1" split lock washers. Revise hex nut material to SAE J995 Grade 8.  
 SE185-316: Revise 1 1/8" diameter hole callout – 8 Req'd.  
 SE185-329: Revise Hex Nut Specification to SAE J9995 Grade 8.  
 SE186-200: Delete 1" split lock washer from assembly.  
 SE186-306: Revise weld callout.  
 SE186-307: Revise weld callout.  
 SE186-308: Revise weld callout.  
 SE186-327: Revise weld callout.  
 SE186-331: Add thickness dimension for Part 3, Floor Bolting Clip  
 SE186-332: Revise weld callout.  
 SE186-333: Revise weld callout. Revise drawing number callout of Part 12. SE186-326-4 was  
                     SE186-326-3

**REASON FOR CHANGE:**

SE184-051: McMaster-Carr cannot provide proper documentation for Grade B7 hardware. Manufacturer requested use of GMAW or FCAW weld technique.  
 SE184-052: Manufacturer requested use of GMAW or FCAW weld technique.  
 SE184-056: Missing material thickness dimension. Manufacturer requested use of GMAW or FCAW weld technique.  
 SE184-301: V.V. Support Assy Outrigger added to set up procedure.  
 SE185-303: Supports required at this assembly level. Related locating dimensions also required.  
 SE185-304: Opened up holes in actuator shafts to accept standard 17 ton shackle.  
 SE185-314: Split lock washers not required (nor desired) with pre-load. Incorrect spec for hex nut (ASTM A194).  
 SE185-316: Incorrect number of 1 1/8" diameter holes. 10 was shown; only 8 req'd.  
 SE185-329: Incorrect specification was ASTM A194.  
 SE186-200: Split lock washers not required with pre-load.  
 SE186-306: Manufacturer requested use of GMAW or FCAW weld technique.  
 SE186-307: Manufacturer requested use of GMAW or FCAW weld technique.  
 SE186-308: Manufacturer requested use of GMAW or FCAW weld technique.  
 SE186-327: Manufacturer requested use of GMAW or FCAW weld technique.  
 SE186-331: Dimension missing.  
 SE186-332: Manufacturer requested use of GMAW or FCAW weld technique.  
 SE186-333: Manufacturer requested use of GMAW or FCAW weld technique. Incorrect drawing number callout for part 12 was specified.

<b>ENGINEERING CHANGE NOTICE APPROVALS</b>	<b>:</b>	<b>DATE: 6/19/2008</b>
COGNIZANT INDIVIDUAL MAKING CHANGE:		
RESPONSIBLE LINE MANAGER:		