

PPPL ENGINEERING CHANGE NOTICE (ECN) ECN # 4961 R1

COGNIZANT INDIVIDUAL: Paul Goranson	
ECN TITLE: Relax tolerances on port extensions	
ASSOCIATED ECP: 019	
CC/WP/Job: 9450-1***-1250	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:	NEW Revision	TITLE
SE120-003, sht 1	2	Vacuum Vessel Period Inspection and Leak Check Assembly
SE120-003, sht 5	2	Vacuum Vessel Period Inspection and Leak Check Assembly
SE120-004, sht 1	2	Vacuum Vessel Period Inspection and Leak Check Assembly
SE120-004, sht 13	2	Vacuum Vessel Period Inspection and Leak Check Assembly
SE120-004, sht 15	2	Vacuum Vessel Period Inspection and Leak Check Assembly
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<p>DESCRIPTION OF CHANGE(S): (State Drawing No., Zone/Group, or List Attachments)</p> <ul style="list-style-type: none"> • SE120-003, sht 1: Correct callout of next assembly's se122-006 and se122-007. • SE120-003, sht 5: Correct port 4 thickness and geometry (as required) and update its corresponding STEP file.

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DESCRIPTION OF CHANGE(S):

- SE120-004, sht 1 Revise note 6 to state that port length dimensions shown are final dimensions after ports are cut off and reassembled. Tolerance of length is +/- 0.125". Inspected dimensions shall be as shown on drawing plus 0.50". Also relaxed port tolerance per request by vendor.
- SE120-004, sht 13 Added tolerance of $\pm .125$ to Port 12 dimension and changed dimension from basic to dimensional. Also added missing dimensions.
- SE120-004, sht 15 Add missing dimensions. Eliminate conflicting tolerances. Added tolerance of $\pm .125$ to NB Port and changed dimension from basic to dimensional. Changed dimensions to basic in Section K-K. Added dimension to flange in Detail Y.

REASON(S) FOR CHANGE: Discussions between MTM and PPPL identified several omissions/errors or areas needing clarification. The above changes reflect resolution of those changes.

ENGINEERING CHANGE PROPOSAL: 019

DATE: 3/23/2005

COGNIZANT INDIVIDUAL MAKING THE CHANGE:

RESPONSIBLE LINE MANAGER:

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