

Princeton University

Plasma Physics Laboratory
James Forrestal Campus
P.O. Box CN17
Princeton, N.J. 08543

3 December 2004

Ms. Teresa Hubbard
Major Tool & Machine, Inc.
1458 E. 19th Street
Indianapolis, IN 46218

SUBJECT: **Specification Addendum Letter No. 3-1** to Subcontract S005243-F's NCSX Product Specification for Vacuum Vessel System Sub-Assembly NCSX-CSPEC-121-02-03

Dear Ms. Hubbard:

A copy of NCSX PRODUCT SPECIFICATION FOR THE VACUUM VESSEL SYSTEM SUB-ASSEMBLY, NCSX-CSPEC-121-02-03, dated 24 November 2004, was forwarded to you by letter dated 26 November 2004 with guidance that it was effective for implementation immediately upon receipt.

It is the NCSX Project's intention to update the Specification frequently.

In the interest of clarity and immediate communication to Major Tool of NCSX Project approval or acceptance of Major Tool requests and recommendations that will either directly or indirectly impact on the Subcontract Specification and or drawings, the Project will issue periodically, as appropriate, serial numbered **Specification Addendum Letters**. Specification and drawing errors or omissions identified by the NCSX Project and the Project "fix" will also be addressed in these letters.

This **Specification Addendum Letter No. 3-1** (first Addendum letter issued for Revision 3 of the Specification) is the first of the series of letters that will be issued.

Specification and drawing revisions identified in this letter are effective for implementation upon receipt of the letter and will be incorporated into the next revision of the Specification, now projected to be issued about 1 March 2005, and revised drawings.

The Princeton Technical Representative for Subcontract S005243-F, Michael Viola, reports the following have been accepted / approved by the NCSX Project effective immediately and will be formally incorporated, as appropriate, in the next revision of the Specification and or drawings.

1. Re D. McCorkle communication to M. Viola 11/20/2004 9:23 A.M. On drawing SE122-104 section F-F (zone E4) the "2X .63" dimension from the datum -A- surface to the center of the NPT hole is a two place, untoleranced dimension. This requires a lineal location of the hole to be within +/- 0.010" (no problem). The "2X .125" (x .625 deep) would require a depth tolerance of +/- 0.005". It is dimensioned to the center of the NPT hole and cannot be checked. This type of feature would normally be a dimension something like: 2X Dia. 0.125 break through Dia. 0.25 hole. The .625 depth will not have an inspection record in the data book. NCSX Project response: Three place dimensioning was a ProE default; we will change the "2x .125" dimension to two place. This specific dimension does not require verification.
2. Re: D. McCorkle communication to M. Viola 11/20/2004 10:21 A.M. The holes located by a basic bolt circle radius are toleranced with a true position feature control frame. NCSX Project response: The .271 typical dimension in Drawing SE122-019 zone G4 (Detail X) will be changed to reference only.
3. Vacuum vessel drawings fail to call out the weld detail of the Dome feature. This will be added to the drawings.

ADDITIONAL INFORMATION

The Segmentation Scheme, a deliverable required by Section 5.1.1 of the Subcontract Statement of Work, has been received and accepted by the NCSX Project.

If there are any questions pertaining to this matter, I may be contacted at (609) 243-2441, telefax (609) 243-2021, or by e-mail lsutton@pppl.gov.

Regards,



Larry L. Sutton

Senior Subcontract Administrator

Please Sign and Return by Telefax (609) 243-2021

Receipt of **SPECIFICATION ADDENDUM LETTER 3-1** to Subcontract S005243-F's NCSX SPECIFICATION - PRODUCT SPECIFICATION FOR THE VACUUM VESSEL SYSTEM SUB-ASSEMBLY, NCSX-CSPEC-121-02-03, dated 24 November 2004 is acknowledged.

Signature

Date

Title

Major Tool & Machine Company
1458 E. 19th Street
Indianapolis, IN 46218

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