

<i>NCSX RFD</i>	Number:	RFD Description: NCSX Vessel port manufacture
Initiator: Doug McCorkle		Organization: Major Tool and Machine
List of Impacted Documents: NCSX-CSPEC-121-02		
Cost Impact: (If none, so state) NONE		
Schedule Impact: (If none, so state) NONE		
Impact on Interfaces with Other WBS Elements/Items: (If none, so state) None		
<p>Full Description of the Deviation Requested: As defined in the MTM Process Outline, the method of pre-assembly and blank-off for vacuum testing will be performed slightly different that depicted on the design drawings. The plan is to complete and assemble all components for a single thermo-cycle and vacuum test of each 120 D Period simultaneously. The Vessel and Spacer flanges (SE120-013, and SE121-014-3) will be machined to finish dimensions after the testing is completed. This will allow the parts to be temporary welded together utilizing the excess machining stock on the flange faces (with a seal weld similar to the welds shown on SE121-020 detail C). This eliminates the need for the following detail components: SE121-091, SE121-095, SE121-099, SE121-102</p> <p>The open ends of the Vessel and Spacer will be blanked for vacuum testing using temporary (300 series stainless steel) blank plates.</p>		
Attachments: N/A		
Initiator Signature: 		Date: <u>02 JUN 2005</u>
(Doug McCorkle)		
Project Disposition (Include ECP Number):		

Controlled Document

THIS IS AN UNCONTROLLED DOCUMENT ONCE PRINTED. Check the NCSX Engineering Web
prior to use to assure that this document is current.