

<i>NCSX RFD</i> <i>Part I</i>	<b>Number: 14-006</b>	<b>RFD Description: Deletion of Erroneous Requirement in Section 3.1.1.6.1 of the Modular Coil CSPEC (NCSX-CSPEC-141-03-09)</b>
<b>Initiator: Phil Heitzenroeder</b>		<b>Organization: PPPL</b>
<b>List of Impacted Documents: (<i>Specification, MIT/QA Plan, SOW, drawing, etc.</i>)</b> <ul style="list-style-type: none"> <li>• <b>Production Modular Coil Specification (NCSX-CSPEC-141-03)</b></li> </ul>		
<b>Cost Impact: (<i>If none, so state</i>): NONE</b>		
<b>Schedule Impact: (<i>If none, so state</i>): NONE</b>		
<b>Quality Impact: (<i>If none, so state</i>): NONE</b>		
<b>State Requirement Deviation is Requested For: (<i>Specification, MIT/QA Plan, SOW, drawing, etc.</i>): Specification</b>		
<b>Full Description of the Deviation Requested: (<i>Use continuation pages, e-mails, letter, sketches, etc. as needed and include amplifying information as appropriate to support deviation request.</i>):</b> Cast surface visual examination using SCRATA reference comparators need only be done at the foundry. After machining, visual examination of the cast surfaces need only be done to ensure that no gouges, etc. were added during handling and machining which may need to be addressed prior to shipping the casting.  During the next spec, revision, PPPL will remove the sentence from Section 3.1.1.6.1: “Machined surfaces shall be free of visual external defects... using SCRATA graded references...”, from Section 3.1.6.1. In accordance with Section 4.2.4, machined surfaces are to be examined using surface profilometers or comparators, as they should be. Machined surfaces should not have been referenced to SCRATA comparators.		
<b>Attachments:</b> Revised Section 3.1.1.6.1 of NCSX-CSPEC-141-03		
<b>Initiator Signature: _____ Date: _____</b>		

## **Attachment**

Section 3.1.6.1 shall be revised to read:

Cast surfaces shall be free of visual external defects as defined in ASTM A802/A802M (using SCRATA graded reference comparators) Level III. ~~Machined surfaces shall be free of visual external defects as defined in ASTM A802/A802M (using SCRATA graded reference comparators).~~ Level II Discontinuities not meeting the evaluation criteria shall be repaired per Section 3.2.3.2. (Repairs).

<i>NCSX RFD Part III</i>	Number: 14-006	RFD Description: Deletion of Erroneous Requirement in Section 3.1.1.6.1 of the Modular Coil CSPEC (NCSX-CSPEC-141-03-09)
RLM: Brad Nelson		Organization: ORNL
Impact on Interfaces with Other WBS Elements/Items: <i>(If none, so state):</i> NONE		
<p><b>RLM Recommendation:</b></p> <p><input checked="" type="checkbox"/> Approve   <input type="checkbox"/> Do Not Approve</p> <p><b>Additional remarks:</b></p>		
RLM Signature: _____		
<p><b>Project Disposition:</b></p> <p><input type="checkbox"/> Approved. No ECP required. _____ NCSX Systems Engineering Support Manager</p> <p><input checked="" type="checkbox"/> Approved. An ECP will be assigned and processed when the next revision to the CSPEC is made, but not later than October 31st.</p> <p><input type="checkbox"/> Not Approved. Reason(s) for disapproval:</p>		