Initiator: Mike Griffith Organization: Major Tool List of Impacted Documents: (Specification, MIT/QA Plan, SOW, drawing, etc.): SE141-114 Cost Impact: (If none, so state): NONE Schedule Impact: (If none, so state): NONE Quality Impact: (If none, so state): NONE State Requirement Deviation is Requested For: (Specification, MIT/QA Plan, SOW, drawing, etc.): SE141-114 Full Description of the Deviation Requested: (Use continuation pages, e-mails, letter, sketches, etc. as needed and include amplifying information as appropriate to support deviation request.): Major Tool noted casting interference at the bolt locations shown in the attached figures for the Type A MCWFs. (See Attachment 1). RFD-14-018 addressed the resolution for the Type A2 through A6 MCWFs. This casting interference is similar to what was noted on the type C winding forms, but more severe in these areas. After some discussion (teleconference the evening of March 29 th), it was decided that this interference condition will be accepted "as is" for these locations on the A1 MCWF. NCSS will need to weld in "pucks" with centrally located threaded holes for the studs). Howevee the one exception to this is as shown on the annotation on SE141-114 for two holes which will be converted to tapped holes with threaded inserts as shown in Attachment 2 by MTM prior to shipment. Attachments: (1) Pictures showing interference details. (1) Pictures showing interference details. (2) Annotated SE141-114 indicating the two holes which will be converted to tapped holes at MTM and the threaded insert that will be used.	NCSX RFD Number: 14-020 Parti I	RFD Description: Type A1 MCWF Flange Hole Modifications
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Initiator Signature: <u>Mike Griffith/Phil Heitzenroeder</u>	Initiator Signature: <u>Mike Griffith/F</u>	Phil Heitzenroeder

Attachment (1) <u>Type A MCWF Interferences</u>



Relief area cut into cast wall

The pictures below illustrate how much casting wall interference there will be on the type A casting. The current machining models for all three winding forms have this interference problem to some degree. The models have a 3" counterbore that extends .75" from the face and the remainder of the feature is a 1.5" radius (see below). This is why Major Tool had to perform the grinding around the counterbores on C4 in order to get the 3" diameter gage to fit.







Attachment (2) <u>Proposed Resolution to Type A MCWFs</u>

SE141-114 MCWF TYPE-A1

Proposed change to 1.885 thru holes



Mike Griffith

Page 1 of 1

5/9/2006





NCSX IRFID Number: 14 IPairít III	4-020	RFD Description: Type A1 MCWF Flange Hole Modifications	
RLM: Brad Nelson	Organiz	zation: ORNL	
Impact on Interfaces with Other WBS Elements/Items: (If none, so state): NONE			
RLM Recommendation:			
Approve Do Not Approve			
Additional remarks:			
These modifications will be incorporated in a future revision to this drawing. In the interim that "stamp" process will be used to annotate SE141-114.			
Does this Change Impact Material Already Procured or Parts/Assemblies Already Assembled/Manufactured using this Material: 🛛 Yes 🗌 No			
If "Yes", what is the recommended disposition of this material/part/assembly? A1 Casting will be accepted "as is" with the exception of the two holes shown.			
RLM Signature:			
Project Disposition:			
Approved. No ECP required.			
NCSX Systems Engineering Support Manager			
Not Approved. Reason(s) for disapproval:			