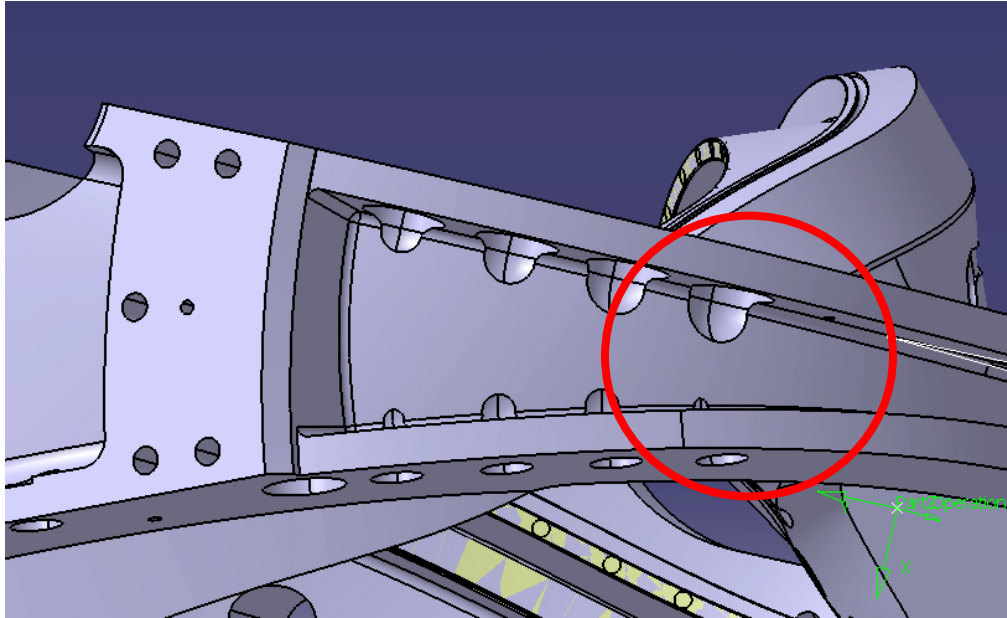


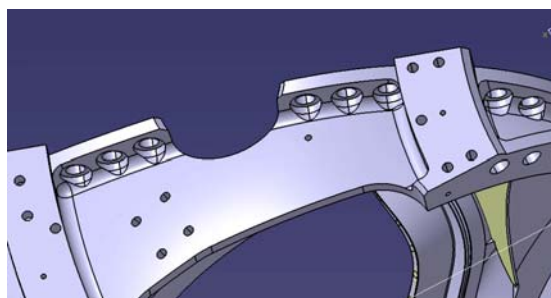
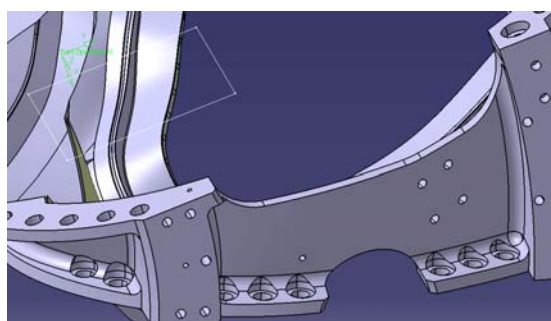
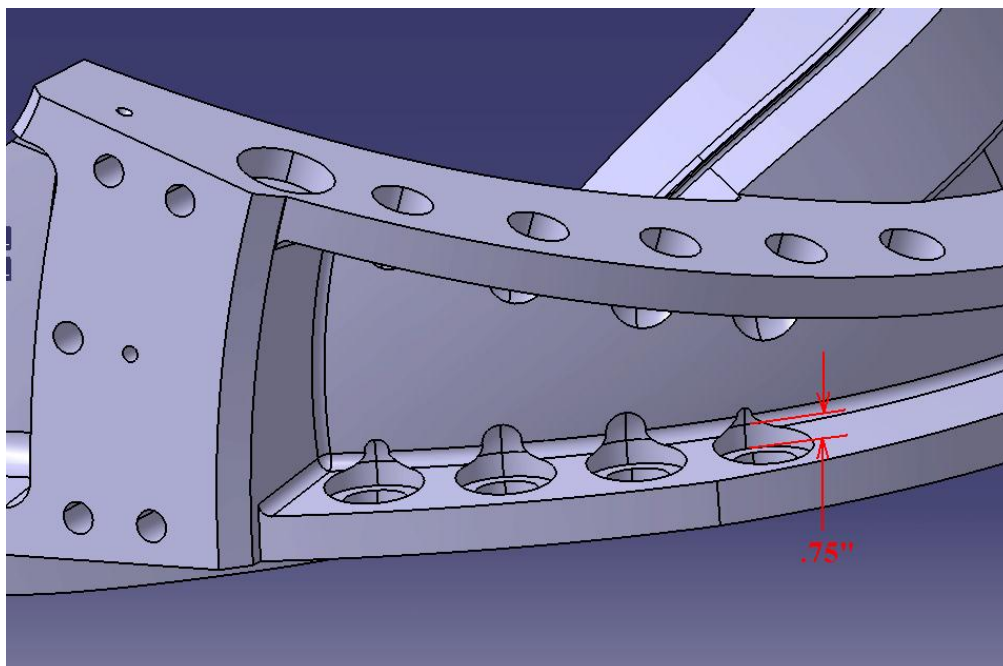
<i>NCSX RFD</i> <i>Part I</i>	Number: 14-020	RFD Description: Type A1 MCWF Flange Hole Modifications
Initiator: Mike Griffith		Organization: Major Tool
List of Impacted Documents: <i>(Specification, MIT/QA Plan, SOW, drawing, etc.):</i> SE141-114		
Cost Impact: <i>(If none, so state):</i> NONE		
Schedule Impact: <i>(If none, so state):</i> NONE		
Quality Impact: <i>(If none, so state):</i> NONE		
State Requirement Deviation is Requested For: <i>(Specification, MIT/QA Plan, SOW, drawing, etc.):</i> SE141-114		
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> 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 29th), it was decided that this interference condition will be accepted “as is” for these locations on the A1 MCWF. NCSX will need to weld in “pucks” with centrally located threaded holes for the studs. (EIO has been requested to give a cost and schedule proposal to manufacture these studs). However, 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. (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.		
Initiator Signature: <u>Mike Griffith/Phil Heitzenroeder</u>		

Attachment (1)
Type A MCWF Interferences



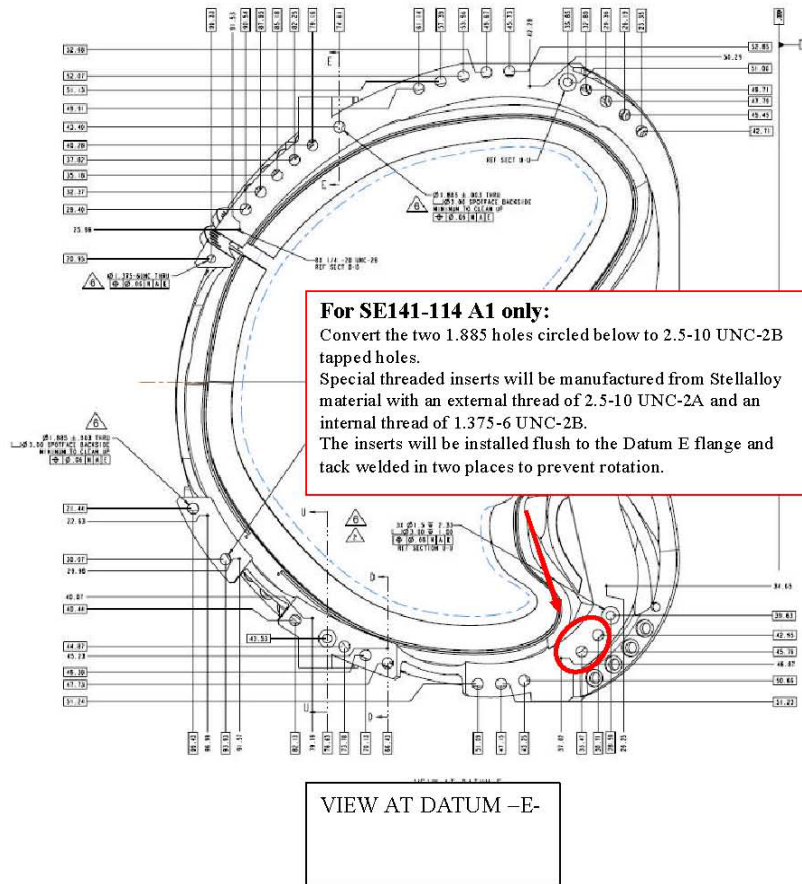
Relief area cut into cast wall

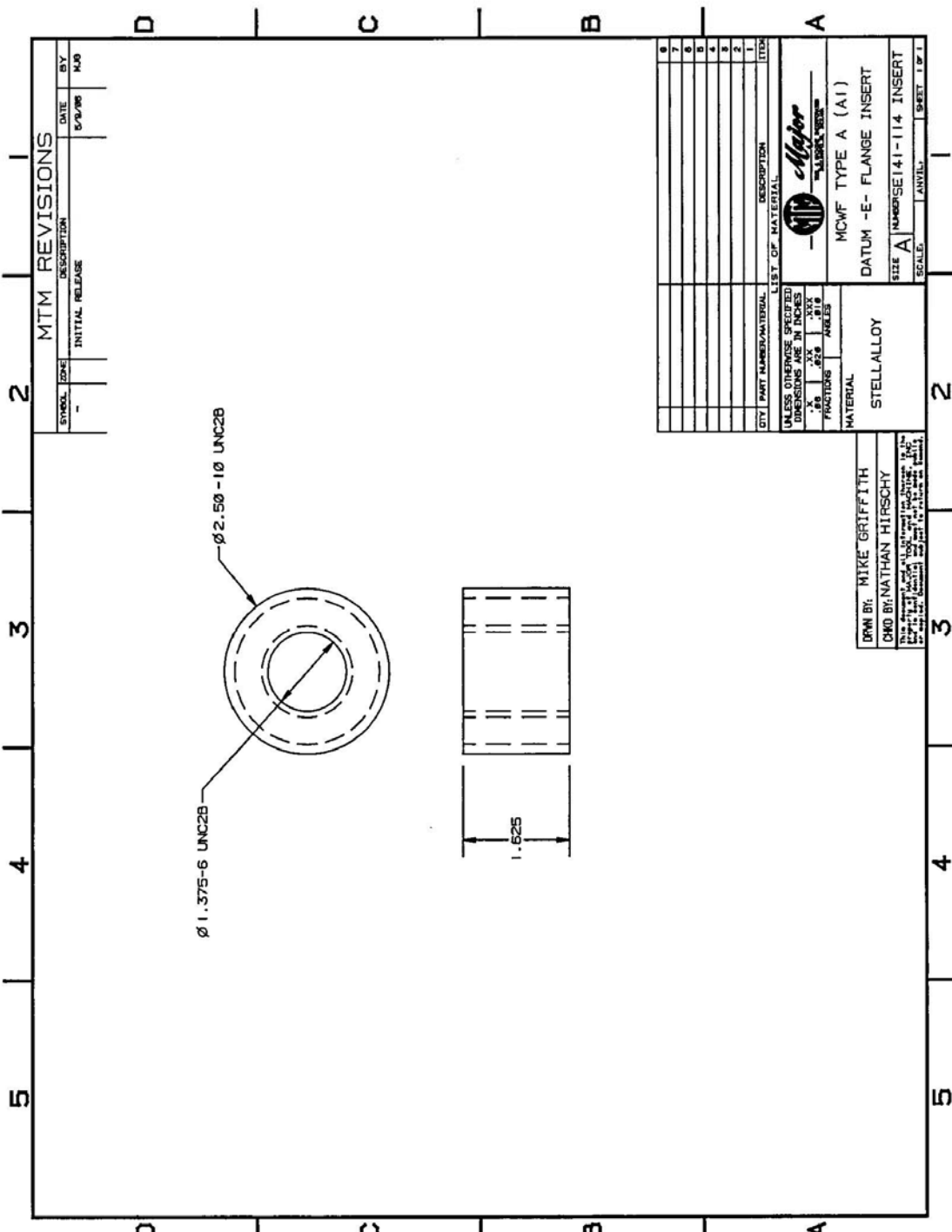
The pictures below illustrate how much casting wall interference there will be on the type A casting. The current machining models for all three winding forms have this interference problem to some degree. The models have a 3" counterbore that extends .75" from the face and the remainder of the feature 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)
Proposed Resolution to Type A MCWFs

SE141-114 MCWF TYPE-A1
Proposed change to 1.885 thru holes





NCSX RFD <i>Part III</i>	Number: 14-020	RFD Description: Type A1 MCWF Flange Hole Modifications
RLM: Brad Nelson		Organization: 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 ☐ Approved. ECP will be assigned and processed. ☐ Not Approved. Reason(s) for disapproval:		