

Customer: ENERGY INDUSTRIES OF OHIO

Contact: NANCY HORTON
E-Mail: NKHFlowen@aol.com

Telephone: 216-496-2314
Fax: 216-328-2001

Part: SE141-114 / MODULAR COIL WINDING FORM TYPE
Drawing ID: SE141-114 Revision: 6

Customer P.O.: S005242-F/Ln:1
Serial No./Qty: A1

Reported By: MIKE GRIFFITH
E-Mail: mGriffith@MajorTool.com

Telephone: 317-636-6433
Fax: 317-634-9420

Problem: Sheet 2, Zone B5; 96X .625 diameter counterbore, .188" +/- .005 deep.
31 counterbores plus the 1 hole in poloidal break (total of 32) check from .210" to .310".
34 counterbores are under the low limit of the tolerance.
(see attachment for details)

Proposed Disposition:

Propose to machine all of the discrepant deep holes (32 places) to a depth of .310". The holes that are currently shallow will be machined to meet the drawing requirements.
Major Tool will provide PPPL with 14 bushings to compensate for the machining error in the holes that require clamps.

Number of additional pages: 1 attachment

Customer Disposition: ☐ Use As Is ☒ Rework ☐ Repair ☐ Scrap ☐ Replace

NCSX agrees with MTM's proposed disposition. The bushings shall be made per dwg. SE 142C-294. It is recommended that MTM consider increasing the quantity of bushings being made as contingency if needed in the future..

Approved by:

Phil
Heitzenroeder

Digitally signed by Phil Heitzenroeder
DN: cn=Phil Heitzenroeder, c=US,
o=PPPL, ou=Mech. Eng. Division
Reason: I agree to specified portions
of this document
Date: 2006.05.08 17:50:47 -04'00'

Brad
Nelson

Digitally signed by Brad Nelson
DN: cn=Brad Nelson, c=US,
o=ORNL, ou=FED,
email=nelsonbe@ornl.gov
Date: 2006.05.08 18:30:29 -04'00'

Tech. Rep.

RLM

Mike Griffith

Digitally signed by Mike Griffith
DN: cn=Mike Griffith, ou=US, o=Major Tool and
Machine, ou=CFT - White,
email=mgriffith@majortool.com
Reason: I agree to the terms defined by the
placement of my signature on this document
Date: 2006.06.01 11:29:57 -04'00'

Major Tool Implemented By: _____

Title: _____

Date: _____

n:\mtmapps\lmtone14.qrp

Frank A. Malinowski

From: James H. Chrzanowski
Sent: Wednesday, August 30, 2006 4:54 PM
To: Frank A. Malinowski
Subject: RE: Open NCRs - Items received from MTM

Frank

We performed a fitup check of the A1 tee bushings provided by Major Tool. They checked out fine. I haven't got to the remaining items but I'll try tomorrow. One out of three isn't too bad. In baseball that's a terrific average.

Jim

-----Original Message-----

From: Frank A. Malinowski
Sent: Monday, August 21, 2006 10:56 AM
To: James H. Chrzanowski
Subject: Open NCRs - Items received from MTM

Jim,

Just in case you didn't notice it buried in my response to Colin, I have 3 MTM NCR's being held open awaiting our acceptance of delivered parts. Those parts are: G-11 bushing for A-3, SS Tee bushings for A-1 (Colin said Mag perm is OK), and Stellanloy bearing Plates & A286 fasteners for poloidal breaks.

I'd like to close these old NCR's if possible.

Thanks,

Frank

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Frank Malinowski - MS01

The DOE Princeton Plasma Physics Lab

PO Box 451

Princeton, NJ 08543-0451

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PH (609) 243-2203 FAX (609) 243-3366 <http://www.pppl.gov/>

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-----Original Message-----

From: Frank A. Malinowski
Sent: Thursday, August 17, 2006 11:16 AM
To: Colin F. Phelps
Cc: James H. Chrzanowski; Phil Heitzenroeder
Subject: RE: A-3 Tee Hole Bushings

Thanks, Colin. I was only looking to you for the permeability. I'm waiting for Jim to let me know if the items are otherwise (dimensionally comes to mind) acceptable.

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Frank Malinowski - MS01

The DOE Princeton Plasma Physics Lab

PO Box 451

Princeton, NJ 08543-0451

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-----Original Message-----

From: Colin F. Phelps

Sent: Thursday, August 17, 2006 11:08 AM

To: Frank A. Malinowski

Cc: James H. Chrzanowski; Phil Heitzenroeder

Subject: RE: A-3 Tee Hole Bushings

Frank,

I checked out the silver plated stainless bushings from MTM for the Al casting and found the permeability to be less than 1.02 μ . I marked the outside of the Ziploc bag with the results of the permeability and gave them to Buddy to store in the test cell. I haven't done anything with the studs or bearing plates, not sure what really needs to be done to them.

Colin

-----Original Message-----

From: Frank A. Malinowski
Sent: Thursday, August 17, 2006 10:03 AM
To: Colin F. Phelps
Subject: A-3 Tee Hole Bushings

Colin,

Did you get a chance to check these and did they fail permeability as expected? They are an open item for an MTM NC and so I'm looking for Jim's acceptance (or rejection) of them.

Thanks,

Frank

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Frank Malinowski - MS01

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