
Customer: ENERGY INDUSTRIES OF OHIO

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Part: SE141-115 / MODULAR COIL, TYPE B

Drawing ID: SE141-102 Revision: 3
W/O Links: 1-Type:W: 65708/1.0 Sub: 1

Customer P.O.: S005242-F/Ln:1
Serial No./Qty: B1

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Problem: Two areas are nonconforming per NCSX-CSPEC-141-03 section 4.2.6.
(see attachment for details)

- 1) The top right corner from 3" across to 4.3" down defines an area that exceeds the limit of .015" gap up to 1/8" deep. The max. gap is at the top where a .032" shim will start.
- 2) The area bordered by the red lines in the thick section of the T will allow for a .005" shim to pass completely thru. The specification requires the cumulative gap to be <.005".

Proposed Disposition:

MTM proposes that Gap deviation be accepted as is. All sharp edges from mismatch have been blended smooth.

Number of additional pages: 2 page summary

Customer Disposition: Use As Is Rework Repair Scrap Replace

Jim Chrzanowski and Frank Malinowski will bring fiberglass cloth during their visit to MTM on 9/25. MTM is to work the fiberglass into the open areas and trim to fit. PPPL will impregnate the fiberglass with epoxy after the VPI and bakeout is completed. This was discussed during a conference attended by J. Chrzanowski, D. Williamson, F. Malinowski, L. Sutton, and P. Heitzenroeder. It is felt that the joint restraint is not an issue, since it is primarily provided by the body bound bolts, and although the joint area is reduced, the pressure on the remaining area will be increased. The fiberglass will primarily assure that the electrical properties of the joint are maintained by sealing this area.

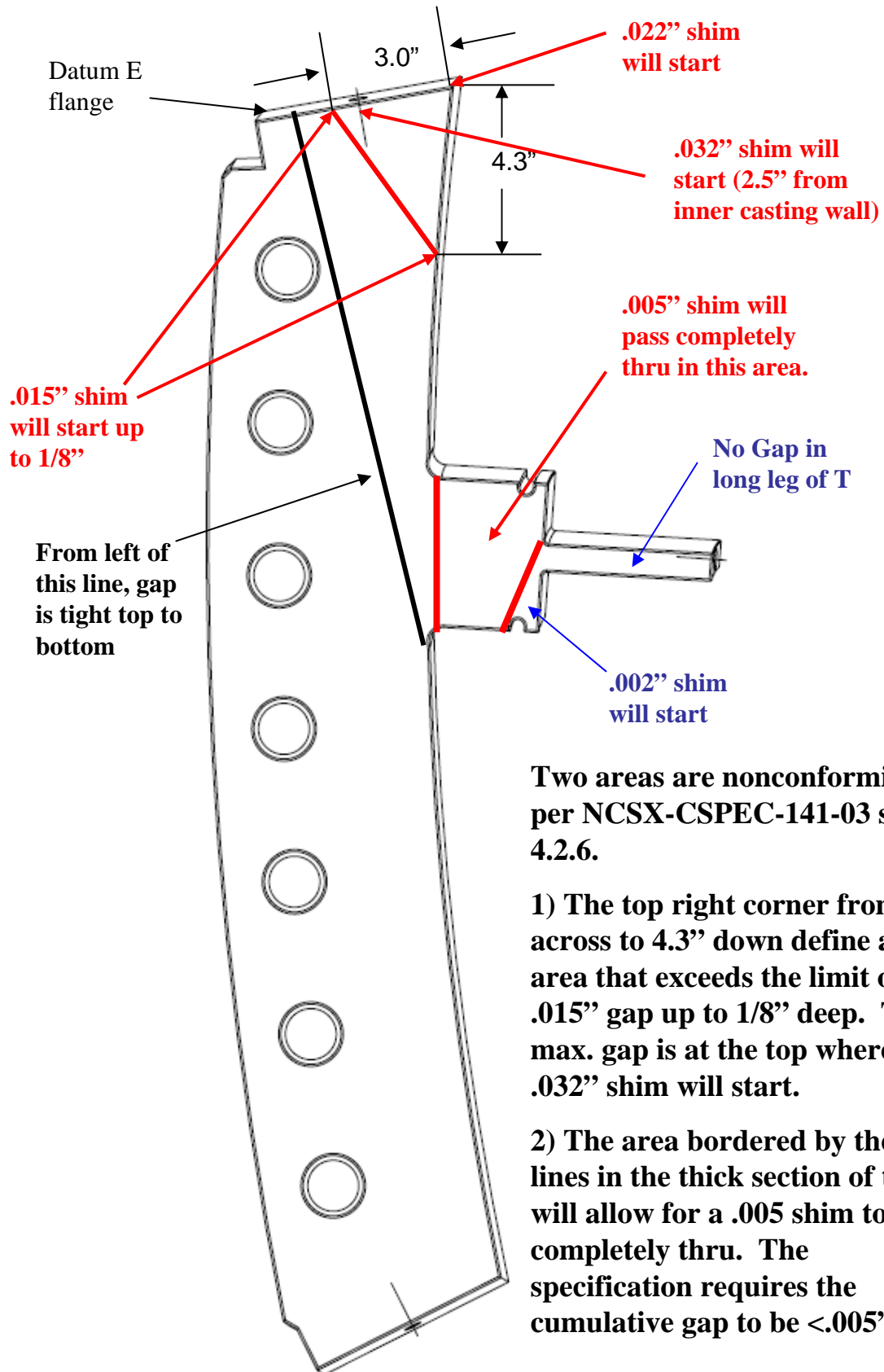
Approved by:

Tech. Rep.

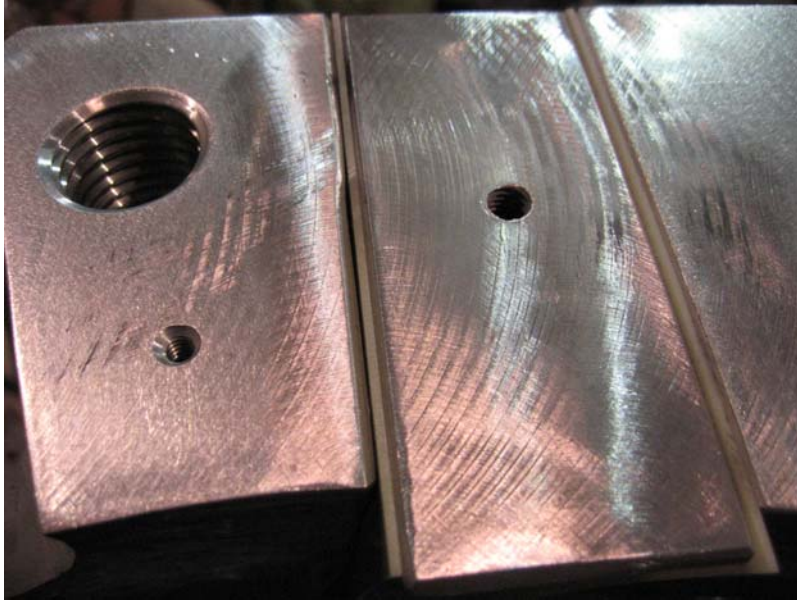
RLM

Major Tool Implemented By: _____ **Title:** _____ **Date:** _____

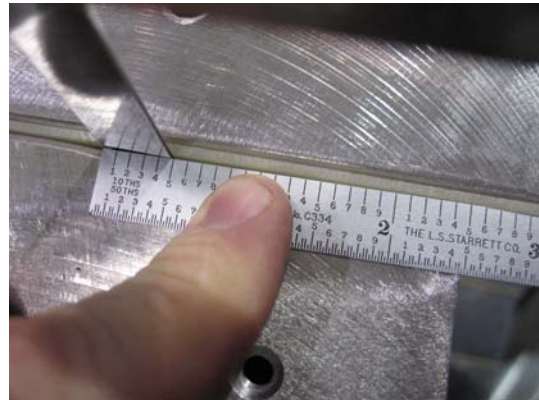
NC20487 Poloidal Break Gap – SE141-115 B1



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View to the left is looking down on the datum E flange. The gap between G11 and flange face is visible on the left side of the break shim.



Top-right shows a .032" shim starting (2.5" from inner casting wall.

Top-left shows a .015" shim starting (3.0" from inner casting wall.

Bottom-left shows a .015" starting 4.3" from datum E face.