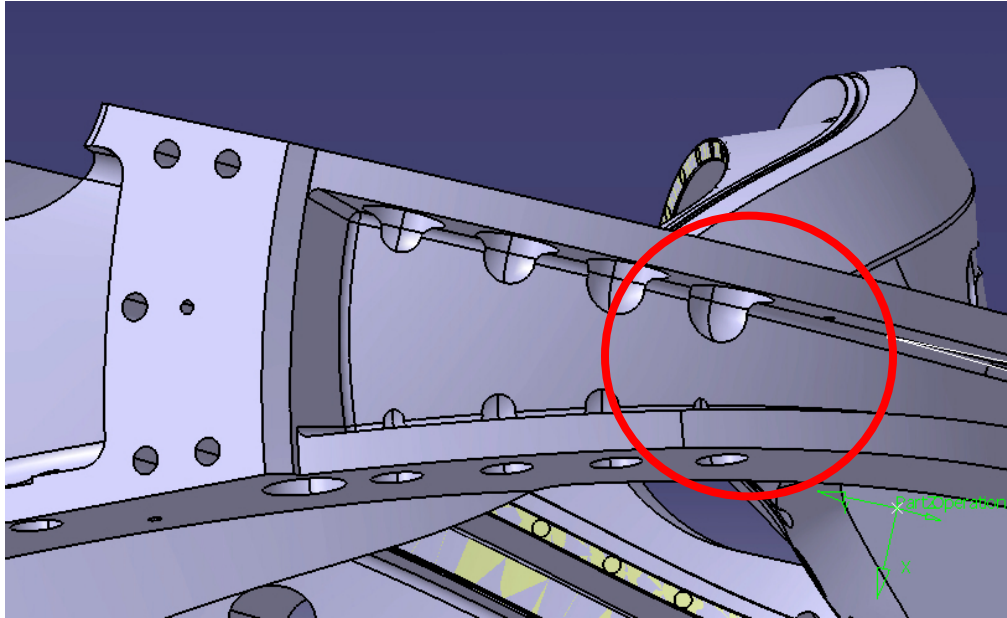


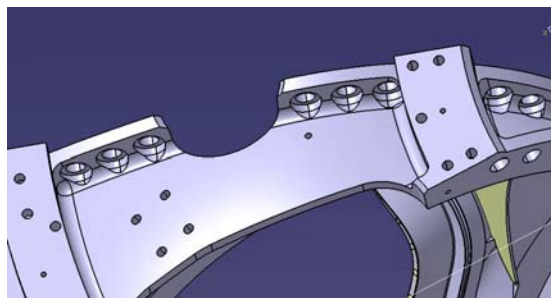
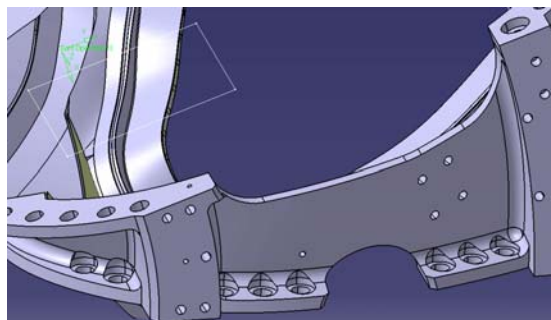
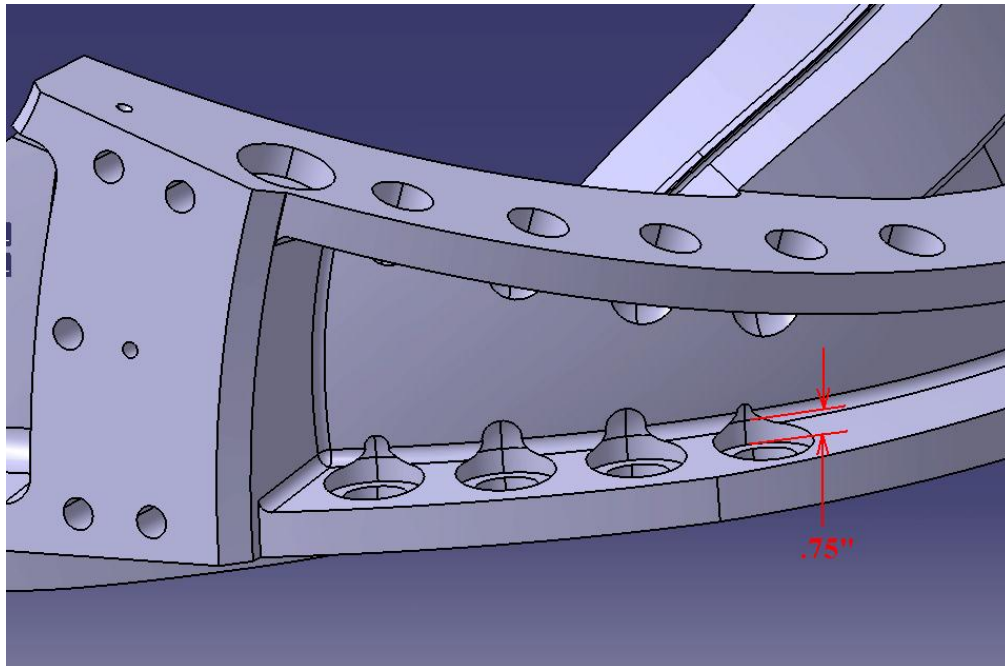
<i>NCSX RFD</i> <i>Part I</i>	Number: 14-018R2	RFD Description: Type A2-A6 MCWFs Flange Hole Modifications
Initiator: Mike Griffith		Organization: Major Tool
List of Impacted Documents: ( <i>Specification, MIT/QA Plan, SOW, drawing, etc.</i> ): SE141-114		
Cost Impact: ( <i>If none, so state</i> ): NONE		
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		
<p>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>):</p> <p><i>Revision 2 to this RFD corrected Attachment (2) to keep the Type-A, Datum-E, hole #10, as a clearance hole for winding forms A2-A6.</i></p> <p><i>Revision 1 to this RFD removed the Type A1 MCWF– it will be the subject of RFD-14-020. This RFD now only addresses Type A2 through A6 MCWFs.</i></p> <p>Major Tool noted casting interference at the bolt locations as shown in the attached figures for the Type A castings – see Attachment (1). This casting interference is similar to what was noted on the Type C winding forms, but more are severe in these areas for the Type A MCWFs. NCSX reviewed the remaining flange holes for the Type A2 though A6 castings and developed the concept shown on Attachment (2) in which a number of the clearance holes have been changed to tapped holes. The remaining A2 through A6 MCWFs shall be manufactured per this.</p>		
<p>Attachments:</p> <ul style="list-style-type: none"> <li>(1) Pictures showing interference details.</li> <li>(2) Proposed changes to Type A2-A6 MCWFs (Revised May 18, 2006)</li> </ul>		
Initiator Signature: <u>Mike Griffith/Phil Heitzenroeder</u>		

**Attachment (1)**  
**Type A MCWF Interferences**



**Relief area cut into cast wall**

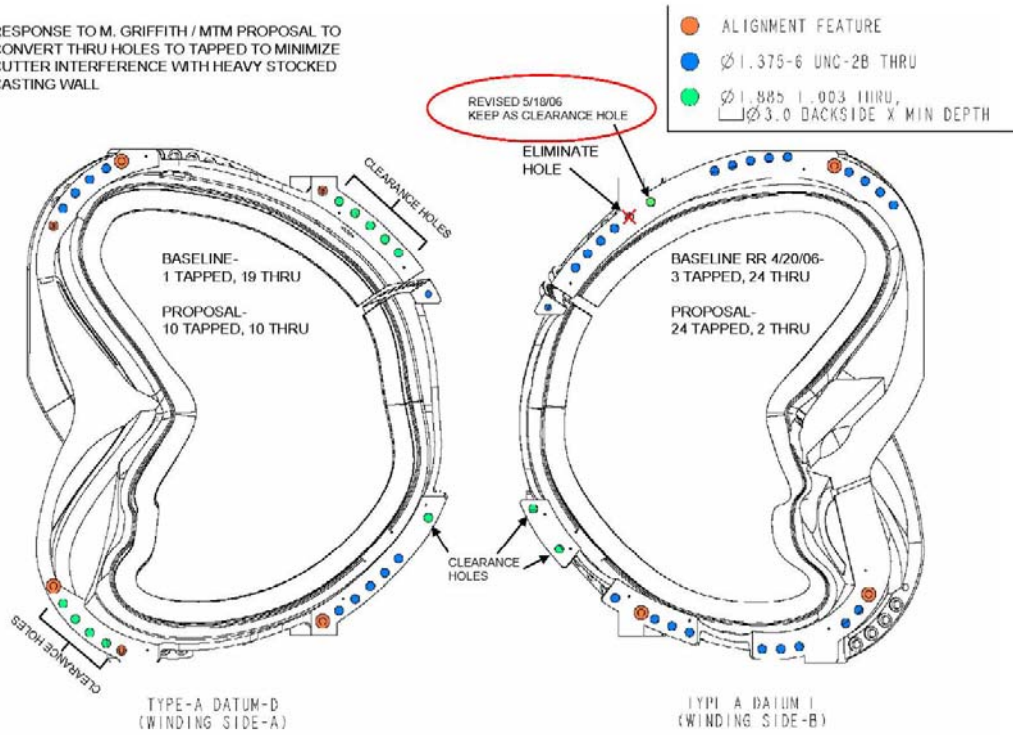
The pictures below illustrate how much casting wall interference there will be on the type A casting. The current machining models for all three winding forms have this interference problem to some degree. The models have a 3" counterbore that extends .75" from the face and the remainder of the feature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

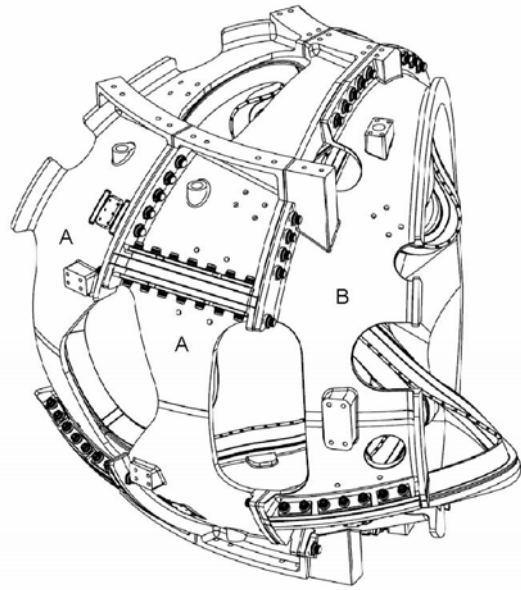


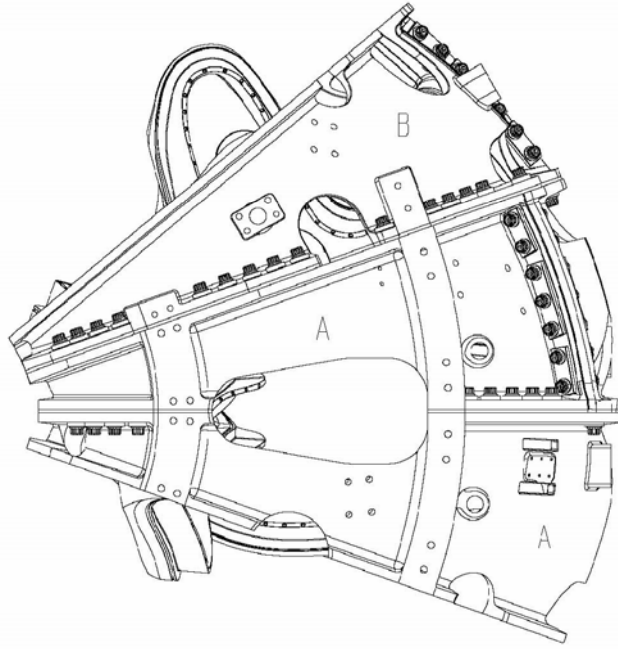
## Attachment (2)

### Definition of Holes to be Modified for Type A2 through A6 MCWFs (Reference: D.Williamson e-mail of May 18, 2006)

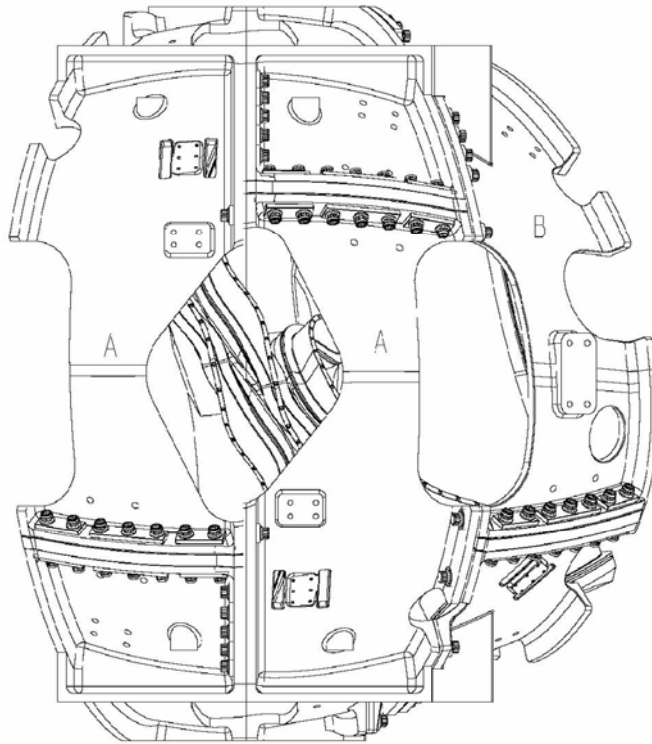
RESPONSE TO M. GRIFFITH / MTM PROPOSAL TO CONVERT THRU HOLES TO TAPPED TO MINIMIZE CUTTER INTERFERENCE WITH HEAVY STOCKED CASTING WALL.







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<i>NCSX RFD</i> <i>Part III</i>	<b>Number: 14-018R2</b>	<b>RFD Description: Type A2-A6 MCWFs Flange Hole Modifications</b>
<b>RLM: Brad Nelson</b>		<b>Organization: ORNL</b>
<b>Impact on Interfaces with Other WBS Elements/Items: (If none, so state): NONE</b>		
<p><b>RLM Recommendation:</b></p> <p><input checked="" type="checkbox"/> <b>Approve</b>   <input type="checkbox"/> <b>Do Not Approve</b></p> <p><b>Additional remarks:</b></p> <p><b>This RFD also includes a modification by the NCSX Project for the identified Type A2 through A6 MCWF flange holes - See Attachment (2). <i>The milling machine should be programmed to tap to a depth of 1.5" from the front flange face ( recognizing that some flange areas may be less than 1.5" thick and therefore the thread length may be less than 1.5" for some holes).</i></b></p> <p><b>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.</b></p> <p><b>Does this Change Impact Material Already Procured or Parts/Assemblies Already Assembled/Manufactured using this Material: <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No</b></p> <p><b>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.</b></p>		
<b>RLM Signature: _____</b>		
<p><b>Project Disposition:</b></p> <p><input checked="" type="checkbox"/> <b>Approved. No ECP required.</b></p> <p style="text-align: center;"> <b>_____</b>  <b>NCSX Systems Engineering Support Manager</b> </p> <p><input type="checkbox"/> <b>Approved. ECP will be assigned and processed.</b></p> <p><input type="checkbox"/> <b>Not Approved. Reason(s) for disapproval:</b></p>		

