

<i>NCSX RFD</i> <i>Part I</i>	Number: 14-025	RFD Description: B Castings Counterbore Options
Initiator: M. Grittith		Organization: Major Tool
List of Impacted Documents: <i>(Specification, MIT/QA Plan, SOW, drawing, etc.)</i> SE141-115		
Cost Impact: <i>NONE</i>		
Schedule Impact: <i>NONE</i>		
Quality Impact: <i>NONE</i>		
State Requirement Deviation is Requested For: <i>(Specification, MIT/QA Plan, SOW, drawing, etc.)</i> SE141-115		
<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>In order to expedite the rework of B1 and B2, MTM is requesting the option to bore the counterbore relief as shown on the attached figures for Hole 11 on the D flanges.</p>		
Attachments: Fast Response Authorization (Sutton to Horton dated October 4, 2006) which includes the proposed option to bore the counterbore relief on Hole 11 of the D flanges on the B1 and B2 castings.		
Initiator Signature: <u>M. Grittith</u> Date: <u>10/3/2006</u>		

Attachment

Princeton University **Plasma Physics Laboratory**
James Forrestal Campus
P.O. Box CN17
Princeton, N.J. 08543

4 October 2006

Ms. Nancy Horton
Energy Industries of Ohio
6100 Oak Tree Boulevard, Suite 200
Independence, Ohio 44131

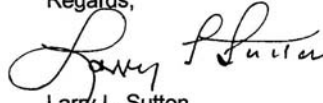
SUBJECT: Subcontract S005242-F

Dear Ms. Horton:

The NCSX Project has reviewed and approved EIO's proposal for machining the back counterbore of Hole D-11 on castings B1 and B2. This change is being formally documented in Deviation Request 1425, now in the signature process.

This guidance is effective for implementation upon receipt.

Regards,



Larry L. Sutton
Senior Subcontract Administrator

Attachment

cc: P. Heitzenroeder
F. Malinowski
B. Simmons
M. Tyrrell

B1 and B2 Counterbore Rework



In order to expedite the rework of B1 and B2, MTM is requesting the option to bore the counterbore relief completely through the area in red (from the top of the support leg to the counterbore). The cut would extend into the leg approximately 1.3" over a distance of 8.5" to the counterbore face. This applies to hole 11 in the D flange only.



<i>NCSX RFD</i> <i>Part III</i>	Number: 14-025	RFD Description: B Castings Counterbore Options
RLM: Brad Nelson		Organization: ORNL
Impact on Interfaces with Other WBS Elements/Items: <i>NONE</i>		
<p>RLM Recommendation:</p> <p><input checked="" type="checkbox"/> Approve <input type="checkbox"/> Do Not Approve</p> <p>Additional remarks: This proposed modification was approved for the rework of B1 and B2 (see attached fast response). This RFD approves the same modifications for the remaining B castings B3 through B6.</p> <p>Should the impacted drawings be formally revised or should the “stamp” process outlined in NCSX Procedure PROC-007 be utilized?</p> <p><input type="checkbox"/> No, a formal revision required to the drawing or specification is required</p> <p><input checked="" type="checkbox"/> “Stamp” process outlined in PROC-007 is authorized.</p> <p> <input type="checkbox"/> If the change is substantial, a revision to the impacted drawings will be required after the third RFD stamp marking a substantial revision is placed on the drawing.</p> <p> <input checked="" type="checkbox"/> This change is NOT substantial and no update to the drawing will ever be required => in this case the “3” RFD stamp process does NOT apply.</p> <p>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</p> <p>If “Yes”, what is the recommended disposition of this material/part/assembly? Rework B1 and B2 as shown on attachment to this RFD.</p>		
RLM Signature: _____		

<i>NCSX RFD</i> <i>Part III</i>	Number: 14-025	RFD Description: B Castings Counterbore Options
Project Disposition:		
<input checked="" type="checkbox"/> Approved. No ECP required. _____ NCSX Systems Engineering Support Manager		
<input type="checkbox"/> Approved. ECP - assigned and processed.		
<input type="checkbox"/> Not Approved. Reason(s) for disapproval:		