

PPPL ENGINEERING CHANGE NOTICE (ECN) ECN # 5185R1

COGNIZANT INDIVIDUAL: David Williamson

ECN TITLE: Flange Hole Counterbore Clearance Envelope and Type-B Post Mod

CC/WP/Job: 9450-1*-1411** **AREA OR PROJECT: NCSX**

LIMITATION OF SCOPE - NOTE: A Work Planning Form is NOT required if the total change to be accomplished (ENG-032):

- Is not large or complex or does not represent a new installation into a usable space
- Does not have a significant ES&H impact
- Does not involve tritium or other radioactive contaminated or activated equipment
- Does not impact multiple projects, systems, or groups

OR does not change the scope or intent of the original design.

Responsible Line Manager CONCURRENCE: _____
 (Signature indicates that no Work Planning form is required.)

If non-concurrence or associated with a work planning form, enter the WP number: _____

DRAWING(S) AFFECTED NUMBER:	Current Revision	TITLE
SE141-114	8	Type-A Modular Coil Winding Form
SE141-115	9	Type-B Modular Coil Winding Form
SE141-116	8	Type-C Modular Coil Winding Form
Continued on the Back		

DESCRIPTION OF CHANGE: (state drawing no., zone. group, or list attachments)

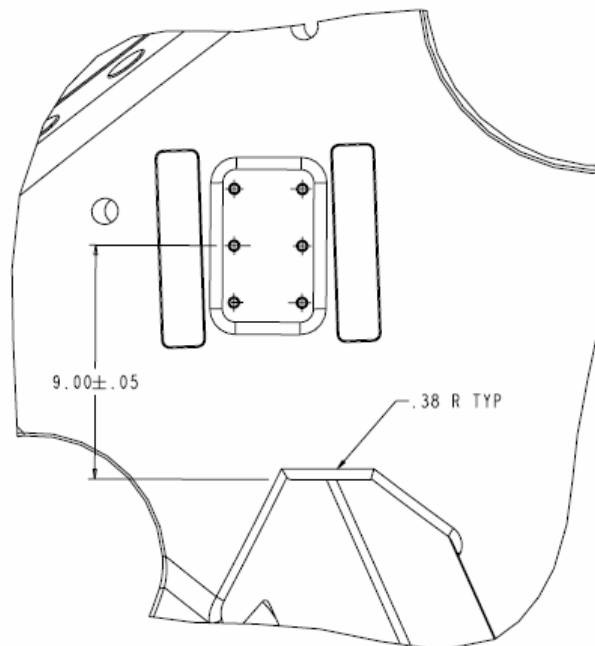
SE141-114, -115, -116, Sht-4, 5 -The clearance requirements for all flange back spot faces and for all the remaining winding forms (MCWFs C-6, B-3 through B-6, and A-4 through A6) shall be a 3" diameter cylinder 3" high from the spot face surface. The blend-in radius at the upper extent of this machined area shall be 1/4".

SE141-114, Added note 17 "SEE DRAWING SE141-114G FOR ADDITIONAL CLEARANCE REQUIREMENTS ON ALL FLANGE BACK SPOT FACES".

SE141-115, Added note 17 "SEE DRAWING SE141-115G FOR ADDITIONAL CLEARANCE REQUIREMENTS ON ALL FLANGE BACK SPOT FACES".

SE141-116, Added note 17 "SEE DRAWING SE141-116G FOR ADDITIONAL CLEARANCE REQUIREMENTS ON ALL FLANGE BACK SPOT FACES".

SE141-115, Sht-7, Quad-B4 - For Type-B MCWF, a clearance dimension of $9.00 \pm .05$ -in is defined between the center of the lead block mounting pad and the support post. Clearance envelope height extends through the post as required.



SE 141-115, ADDED NOTE 18 "SHEET 3, ZN B7, OFFSET THE HOLE PATTERN IN THE VACUUM VESSEL SUPPORT BOSSES RELATIVE TO THE CAST PADS AS NECESSARY TO PERMIT MORE (OR ALL) OF THE TAPPED HOLES IN THE PADS TO BE PROVIDED. NCSX WILL WELD MOUNTING STUDS AS NEEDED. SEE RFD-14-023R1 FOR ADDITIONAL INFORMATION.

REASON FOR CHANGE:

The CAD model of the counterbore envelope, 3-in dia x 3-in length with a spherical radius, is not large enough to provide adequate fastener clearance in heavy stocked areas of the casting.

There is approx .5-in stock on all sides of the B1 and B2 support posts, which prevents mounting of the leads terminal asm.

Launch Microsoft Office Outlook.Ink

ENGINEERING CHANGE NOTICE APPROVALS: DATE: 11/07/2006

COGNIZANT INDIVIDUAL MAKING CHANGE:

DESIGN RESPONSIBLE LINE MANAGER:

MANUFACTURING RESPONSIBLE LINE MANAGER: