

# LIFT PROCEDURE

**Procedure Number: D-L-NCSX-983-00**

**TITLE: Modular Coil Winding Form Lift Procedure**

**Note: LIFT DATA SHEETS NEEDED TO PERFORM THIS LIFT**

**PREPARED BY:** \_\_\_\_\_  
James H. Chrzanowski- Mod Coil ATI

**BRANCH/DIVISION HEAD:** \_\_\_\_\_  
Larry Dudek- Modular Coil RLM

**PIC:** \_\_\_\_\_  
James H. Chrzanowski- Modular Coil ATI

**LIFT MANAGER:** \_\_\_\_\_  
Michael Viola- NCSX Lift Engineer

PROCEDURE INCLUDES ALL ATTACHMENTS

**Modular Coil Winding Form Lift Procedure  
D-L-NCSX-983 Rev.00**

**1.0 INTRODUCTION:**

- 1.1 This procedure describes the necessary equipment and methods to follow in lifting a Modular Coil Winding Form.
- 1.2 This procedure shall be used for handling any of the (3) modular coil types (A, B and C).
- 1.3 This procedure shall be used for handling the bare winding forms prior to being mounted in a support ring and/or the completed coil after the modular coil has been removed from the support ring.
- 1.4 These tables identify the weights of the three coil types prior to and after winding operations.

**Table 1- Weight of Empty Winding Form**

<b>Casting Type</b>	<b>Weight (lbs)</b>
<b>A</b>	4985
<b>B</b>	4940
<b>C</b>	5080

**Table 2- Weight of Completed Modular Coil**

<b>Casting Type</b>	<b>Weight (lbs.)</b>
<b>A</b>	6130
<b>B</b>	6050
<b>C</b>	6100

- 1.5 This lift has been classified as a Critical lift because of the cost and impact to the NCSX schedule if damaged.
- 1.6 This lift procedure shall used in conjunction with procedures [reference]:  
**D-NCSX-MCF-001-** Modular Coil Winding Form Preparation Activities  
**D-NCSX-MCF-004-** Modular Coil Post VPI Activities

**2.0 PREREQUISITES:**

- 2.1 PIC will attest on the Lift Data Sheet that any installation, disassembly, or removal procedures required to allow the equipment to be moved have been completed.
- 2.2 PPPL Lift Manager and QC shall be notified in advance of a critical lift.

**Modular Coil Winding Form Lift Procedure  
D-L-NCSX-983 Rev.00**

- 2.3 No Critical Lift may be commenced without the presence of a PPPL Lift Engineer or his designee.
- 2.4 The lift must be made in accordance with ENG-021 Hoisting and Rigging Program.

**3.0 PRECAUTIONS:**

- 3.1 The area where lift is being made shall be properly secured so that personnel other than the lift team are allowed access.
- 3.2 All personnel involved in this procedure shall wear hard hats.
- 3.3 All rigging shall be inspected by a qualified rigging specialist (QRS).
- 3.4 The crane operator shall be Critical Lift certified.
- 3.5 Protection for the slings and equipment from sharp edges will be provided.

**4.0 PROCEDURE FIELD CHANGES**

Procedure field change can be made on site if approved by the PPPL Lift Engineer by working up or using a new Lift Data Sheet.

**5.0 LIFT DATA SHEET INSTRUCTIONS**

The attached Lift data sheet provides the specification for the hoisting and rigging aspects of the lift and shall be initiated by the Cognizant engineer.

**6.0 PROCEDURE:**

- 6.1 Use the lifting arrangement identified on the attached Lift Data Sheet to connect the modular coil winding form to the overhead crane.
- 6.2 The PIC shall identify the coil being transferred.

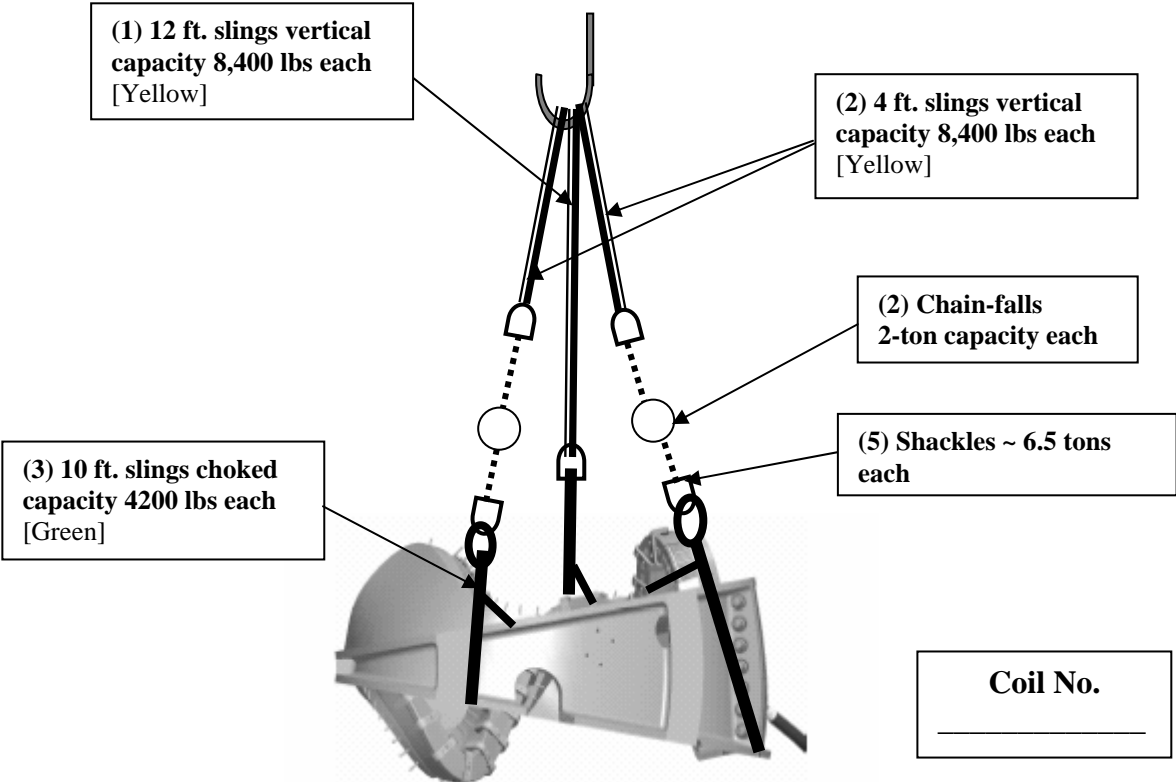
**Coil ID being transferred: \_\_\_\_\_**

**Modular Coil Winding Form Lift Procedure**  
**D-L-NCSX-983 Rev.00**

- 6.3 Slowly lift the modular coil winding form or completed modular coil, and transport to the desired location. **(Extreme care must be taken around the cooling lines and coil terminals on the finished coil.)**
- 6.4 Lower the modular coil into its final position and remove all lift slings, shackles and chain falls.
- 6.5 The modular coil lift and transfer is complete. Attached copy of completed/signed Lift Data Sheet to back of procedure.

**Modular Coil Winding Form Lift Procedure  
D-L-NCSX-983 Rev.00**

<b>LIFT TITLE:</b> Lifting the Modular Coil Winding Form	<b>Effective Date:</b>	Initiated:	Prepared by:
		<b>COG. ENG. / PHYS.</b>	<b>QRS</b>
<b>LIFT PROCEDURE NO.</b> D-L-NCSX-983	<b>Repetitive Lift Expiration Date:</b>	Approved:	
		<b>LIFT MANAGER</b>	
<b>AREA:</b> NCSX Coil Manufacturing Facility			
<b>DISASSEMBLY PROCESS COMPLETED</b>		<b>PIC:</b> _____	
<b>PROCEDURE PREREQUISITES COMPLETED</b>		<b>QC:</b> _____	



**DESCRIPTION:** **WEIGHT:** 6200 Lbs. (max.) **DETERMINED BY:** Calculations  
 Sketch of rigging shall include: Crane Capacity, Hook Load, All Rigging, Lift Height, Flight Plan  
 Sketch of equipment shall include: Dimensions, Bolts Removed, Allowable Tilt

<b>CRANE OPERATOR</b> (print)	<b>RIGGING TEAM</b> (print)		
<b>APPROVED:</b>	_____	_____	_____
	QRS (Rigged per sketch)	PIC (Equipment ready to lift)	LIFT ENGINEER (Qualification/inspection complete)

... PERFORM LIFT... PERFORM LIFT ... PERFORM LIFT ...

Equipment is secure and rigging may be removed: <b>PIC:</b> _____	<b>Date Performed:</b> _____
---	------------------------------

**LIFT DATA SHEET AND ALL DATA TO BE RETURNED TO PPPL OPERATIONS CENTER.**