

20 May 2003

Ms. Teresa Hubbard
Major Tool & Machine, Inc.
1458 E. 19th Street
Indianapolis, IN 46218

SUBJECT: Subcontract S-04344-F for NCSX Vacuum Vessel Manufacturing
Development and Prototype Fabrication

Dear Ms. Hubbard:

I have been directed this date by the Princeton Technical Representative for Subcontract S-04344-F, Mike Viola, to provide you the following information:

- A. The ribs have been eliminated from the Vacuum Vessel Sub-Assembly (VVSA) design. Therefore the question has come up as to whether the ribs on the Prototype Vacuum Vessel Segment (PVVS) are still required?

PPPL Response: It is acceptable for subcontractors to configure the PVVS any way they choose. They may leave the ribs off, leave them on, skip weld them, or fillet weld them, depending on what will help in the fabrication. If the ribs are included on the PVVS however, it is important that unwanted variances are not introduced into the PVVS. Again, the ribs may be included and welded at the discretion of the subcontractor. Ultimately, the PVVS must meet the profile specified in the drawings/Subcontract.

- B. Status of Drawings: We expected to post revised drawings of the VVSA and PVVS today. However, Engineering has found new interferences which will take some time to resolve. It is noted, however, that the differences in the size of the "new" vessel and prototype and the ones currently posted are very small. Therefore, we ask that:

- 1 You develop the manufacturing methods, recommendations, MIT plan and budgetary estimate (SOW elements 3.1.1-3.1.4) based on drawings currently posted at ftp://ftp.pppl.gov/pub/ncsx/manuf/production_vessel/.
 2. You proceed with the performance of SOW 3.2.1 (Prototype MIT Plan) and 3.2.2 (prototype manufacturing) – i.e., advanced materials orders, preliminary tooling design, etc.) based on the drawings currently posted at ftp://ftp.pppl.gov/pub/ncsx/manuf/prototype_vessel/.
 3. At the ftp site http://www.pppl.gov/me/NCSX_MFG/ we have posted “interim”_ Pro-E models of the vessel, to include the current concept (go to the link for the prototype vessel ftp - refer to the “read me” there). These models represent changes to the vessel since their original release and are for your information to evaluate how significant the changes are expected to be. We expect to have the interim drawings updated to release versions in a week or two.
- C. The following revised delivery dates for NCSX-SOW-121-01-01 deliverables are effective immediately. They will be incorporated into the Subcontract the next time it is amended.

Statement of Work NCSX-SOW-121-01-01 Requirements	Revised Required Delivery Date
3.1.1	30 May 2003
3.1.2	30 May 2003
3.1.3	30 May 2003
3.1.4	6 June 2003

If there are any questions pertaining to these matters I may be contacted at (609) 243-2441, telefax (609) 243-2021, or by e-mail at lsutton@pppl.gov.

Regards,



Larry L. Sutton

Senior Subcontract Administrator

cc. M. Viola
P. Heitzenroeder