

NCSX June 2007 ETC
TABLE II- Materials and Subcontracts

WBS Number: 15
WBS Title: Coil Support Structures
Job Number: 1550
Job Title: Coil Support Structures Design
Job Manager: Fred Dahlgren

SEE BACKUP DATA IN TABLE V FOR DETAILED BREAKDOWN:

Procurements	Totals	Adjustments from above rows27-33	
(1) The Structures - contract with Vendor for Fabrication	\$ 618,594	\$ 46,710	\$ 665,304
(2) PPPL Procurement of G11 & Teflon Parts	\$ 150,420		\$ 150,420
(3) PPPL Procurement of Inconel B718, Bolts, & Washers	\$ 104,187		\$ 104,187
(3) PPPL Procurement of Belleville Washers	\$ 18,695		\$ 18,695
	\$891,896.62		\$ 938,607
			1.076
1. Inner TF Support Structure -36			
1a - Support Brackets	\$ 67,651		
1b - G11 - CR Mounting Blocks	\$ 13,086		
1c - G11 - CR Side Wedges	\$ 14,904		
1d - Inconel Hardware	\$ 13,507		
1e - TF Bridge Clamp	\$ 11,906		
1f - PTFE Coated G11 - CR Wedge Assy	\$ 45,360		
2 Outer TF Support Structure-36			
2a - Support Brackets	\$ 84,154		
2b - G11 - CR Mounting Blocks	\$ 13,086		
2c - G11 - CR Side Wedges	\$ 14,904		
2d - Inconel Hardware	\$ 13,507		
2e - TF Bridge Clamp	\$ 11,906		
2f - PTFE Coated G11 - CR Wedge Assy	\$ 45,360		
3 PF5/PF6 Support Bracket Assembly -66			
3a - Bracket Assy	\$ 149,107		
3b - PF 5 Bridge Clamps	\$ 21,828		
3c - PF 6 Bridge Clamps	\$ 21,828		
3d - Inconel Hardware	\$ 47,749		
3e - Positioning Bracket Assy	\$ 25,190		
4 PF5/PF6 Support Frame Assembly Long -6			
4a - Curved Beam Angle (N.R.)	\$ -		
4b - Vertical Channels	\$ 3,713		
4c - Inconel Hardware	\$ 8,842		
5 PF5/PF6 Support Frame Assembly Short -3			
5a - Curved Beam Angle (N.R.)	\$ -		
5b - Vertical Channels	\$ 3,713		
5c - Inconel Hardware	\$ 4,421		
6 TF Pre-Load Ring & PF4 Support -2			
6a - Castings	\$ 46,930		
6b - Machining	\$ 6,920		
7 C.S. Coil Mounting Brackets -12			
7a - Inconel Support Brackets	\$ 32,585		
7b - Inconel Hardware	\$ 2,210		
8 TF Coil Pre-Load Clamp Assemblies -36			
8a - Stalloy Castings	\$ 20,214		
			\$891,877.42
9 PF4 Coil Mounting Clamp -12			
9a - C&M Plates		\$ 4,968	
9b - Clean-up, descale, deburr		\$ 1,368	
9c - Inconel Hardware		\$ 2,210	
9d - G11 - CR 1/4" Insulation Pad		\$ 222	
9e - Teflon Pads		\$ 648	
9f - Inconel Plate (6 x 6 x 3/4" thick)		\$ 7,295	
10 MCWF-TF Mtg. Brkt. Spacer block & shim			
10a - C&M Blocks		\$ 22,080	
10b - Clean-up, descale, deburr		\$ 3,312	
10c - Inconel Hardware (INCO 3/4 - 10NC Hex Bolts)		\$ 6,230	
10d - Inconel Hardware (INCO 3/4" Flat Washers)		\$ 326	
10e - INCO 625 Plate (6 x 6 x 3" thick)		\$ 21,888	
11 Machine/Base Support Interface			
11a - C&M Plates		\$ 22,080	
11b - Weld Clevises & Side Plates		\$ 3,600	
11c - Clean-up, descale, deburr		\$ 1,104	
11d - C&M Spherical Brgs.		\$ 8,550	
11e - C&M G11 & Teflon Plates		\$ 2,208	
11f - INCO 625 Plates & Round Bar		\$ 12,312	
11g - G11 - CR Plate		\$ 474	
11h - Teflon Sheet		\$ 168	
11i - Inconel Hardware (R.S.B & fasteners)		\$ 5,184	
12 Misc. Assembly Hardware			
12a - G11 Bushings TF clamps		\$ 900	
12b - G11 washers TF clamps		\$ 288	
12c - G11 Bushings Frame Assy		\$ 420	
12d - G11 washers PF clamps		\$ 134	
12e - G11 bushings PF clamps		\$ 420	
12f - G11 washers Frame Assy		\$ 134	
12g - G11 bushings M/B interface		\$ 60	
12h - G11 washers M/B interface		\$ 19	
12i - Inconel 718 - 0.75" ID Belleville Washers		\$ 9,000	
12j - Inconel 718 - 1.03" ID Belleville Washers		\$ 9,695	
delivery packages			
TF assy station 5	\$ 222,897	239,728	
PF	\$ 239,009	257,056	
TF final assy station 6	\$ 74,064	79,657	
Final assy station 6	\$ 82,606	88,844	
	\$ 618,575	\$ 665,284	