

PPPL ENGINEERING CHANGE NOTICE (ECN) ECN # 5114

COGNIZANT INDIVIDUAL: Paul Goranson	
ECN TITLE: NCSX VVSA Spacer Machining	
ASSOCIATED ECP: None	
CC/WP/Job: 9450-1***-1203	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:	NEW Revision	TITLE
SE120-014	See RLM Comment	Vacuum Vessel – Spacer Weldment

DESCRIPTION OF CHANGE: (State Drawing No., Zone/Group, or List Attachments)

It has been discussed that PPPL may benefit by leaving this excess stock on the faces for additional flexibility if needed during final fit-up. If this option is desired by PPPL, the 6.50 and 1.00 reference dimensions would not be compliant by MTM.

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REASON FOR CHANGE:

The dimension controlling the overall height (6.50) is interpreted as a reference dimension by MTM. It is based on the flanges being 1.0" thick (also reference dimensions). MTM manufactured the flange details using thicker material providing excess stock allowance for final machining to this height after welding. This approach is necessary to maintain the 0.015" flatness requirement. The Spacer final machining operation is planned to commence soon. It has been discussed that PPPL may benefit by leaving this excess stock on the faces for additional flexibility if needed during final fit-up. If this option is desired by PPPL, the 6.50 and 1.00 reference dimensions would not be compliant by MTM.

RFD-12-015 authorized this deviation.

ENGINEERING CHANGE PROPOSAL: N/A

DATE: 4/17/2006

COGNIZANT INDIVIDUAL MAKING THE CHANGE:

RESONSIBLE LINE MANAGER:

RLM Comments: This ECN will NOT be immediately incorporated. Rather a stamp will be placed on this drawing as Rev 1-b to SE120-014 to indicate that this ECN is outstanding.

From: Griffith, Mike [<mailto:mgriffith@majortool.com>]
Sent: Wednesday, April 05, 2006 11:51 AM
To: NKHFlowen@aol.com; royjratc-aol-com-offsite
Cc: Bowling, Kevin
Subject: Request for Lifting holes in Poloidal Break Shims

In order to assist in the intermediate and final assembly of the poloidal break shims in the remaining C's and in all of the A and B shims, we are requesting the addition of a 3/8-16 hole in both ends of the shim to be used for lifting. The drawing below is a C shim showing the approximate location of the holes. Please review and forward this request to PPPL. Thanks.

