

PPPL ENGINEERING CHANGE NOTICE (ECN) ECN # 5118

COGNIZANT INDIVIDUAL: Paul Goranson

ECN TITLE: Leak Check Tube and Block Location

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
SE120-005	See RLM Comment	Vacuum Vessel – Port NB Seal Retainer Detail
SE122-006	See RLM Comment	Vacuum Vessel – Port Extension Weldment
SE122-007	See RLM Comment	Vacuum Vessel – Port 17 & 18 Weldment

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

The port stub dimension which creates the weld seam to be checked is derived from the vessel wall with a +/- 3/16" profile tolerance. There is additional tolerance applied of the vacuum vessel.

Profile tolerance of the vacuum vessel combined with the block location creates a cumulative error that causes misalignment .

The remedy will be to custom fit holes to ensure that they straddle the weld seam. Position the block such that the holes are equidistant from the adjoining weld.

REASON FOR CHANGE:

All dimensions and tolerances that define locations of the leak check tube and block details must be considered reference only dimensions. The position of the leak check tube and block relative to the port extension flange will vary based on the profile of the vessel and the angular location of these items at the time of installation. The position of the block and tube are being custom fit to provide the proper port extension length and location. If the drawing dimensions and tolerances are held, some parts will not function.

RFD-12-018 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 0-c to SE120-005, Rev 0-b to SE122-006, and Rev 0-b to SE122-007 indicate that this ECN is outstanding.

Note that this ECN will be the third ECN against drawing SE120-005 – the next ECN will require a formal revision.