

PPPL ENGINEERING CHANGE NOTICE (ECN) ECN # 5145

COGNIZANT INDIVIDUAL: D. Williamson	
ECN TITLE: MCWF Type-B Modifications	
ASSOCIATED ECP: None	
CC/WP/Job:9450-1***-1403	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
SE141-115	9	Production Winding Form Type-B

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

- 1) Change location of VPI bleed holes shown on SE141-115, Rev 8, Sht 9, D6.**
- 2) Revise tee tapped holes shown on SE141-115, Rev 8, Sht 2, B4 to show .75-in depth.**
- 3) Change 11 "counterbore only" tee holes, shown on SE141-115, Rev 8, Sht 2, C6, to no counterbore but add a mark indicating intersection of former hole axis with top of tee.**
- 4) Add requirement to note shown on SE141-115, Rev 8, Sht 7, E5, that mark be aligned with sections U2 and U3.**

PPPL ENGINEERING CHANGE NOTICE (ECN) ECN # 5145

REASON FOR CHANGE:

Current location of bleed holes does not provide sufficient clearance with flange for fitting attachment. Upon review, it was decided to make holes adjacent to leads area so the leads can be positioned at the highest point during VPI operations.

Tapped hole depth was mistakenly changed on Rev 8 to this drawing.

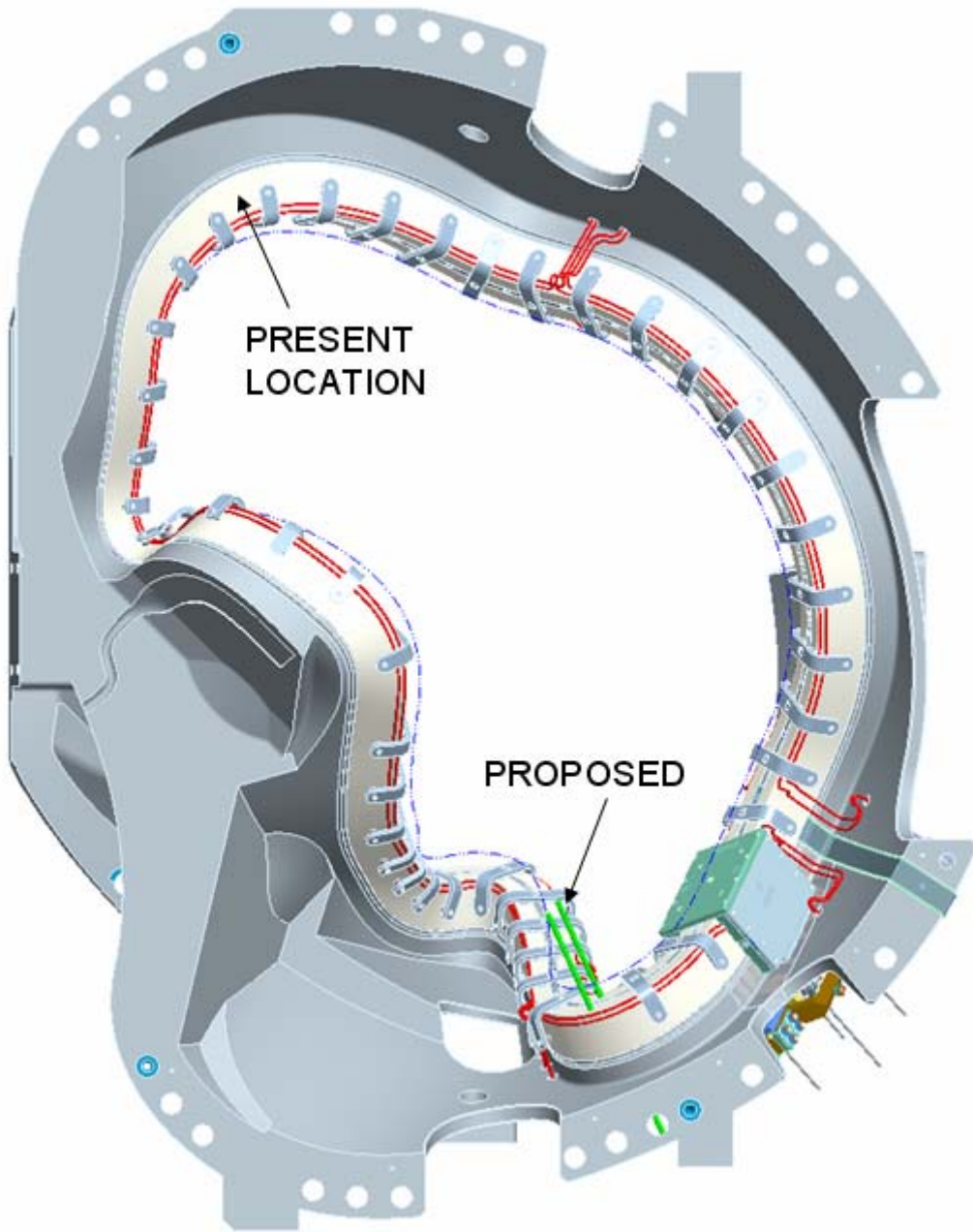
A counterbore complicates the installation of stud for winding clamp locations without a tapped hole.

Aligned mark aids in puck placement for lead blocks assembly.

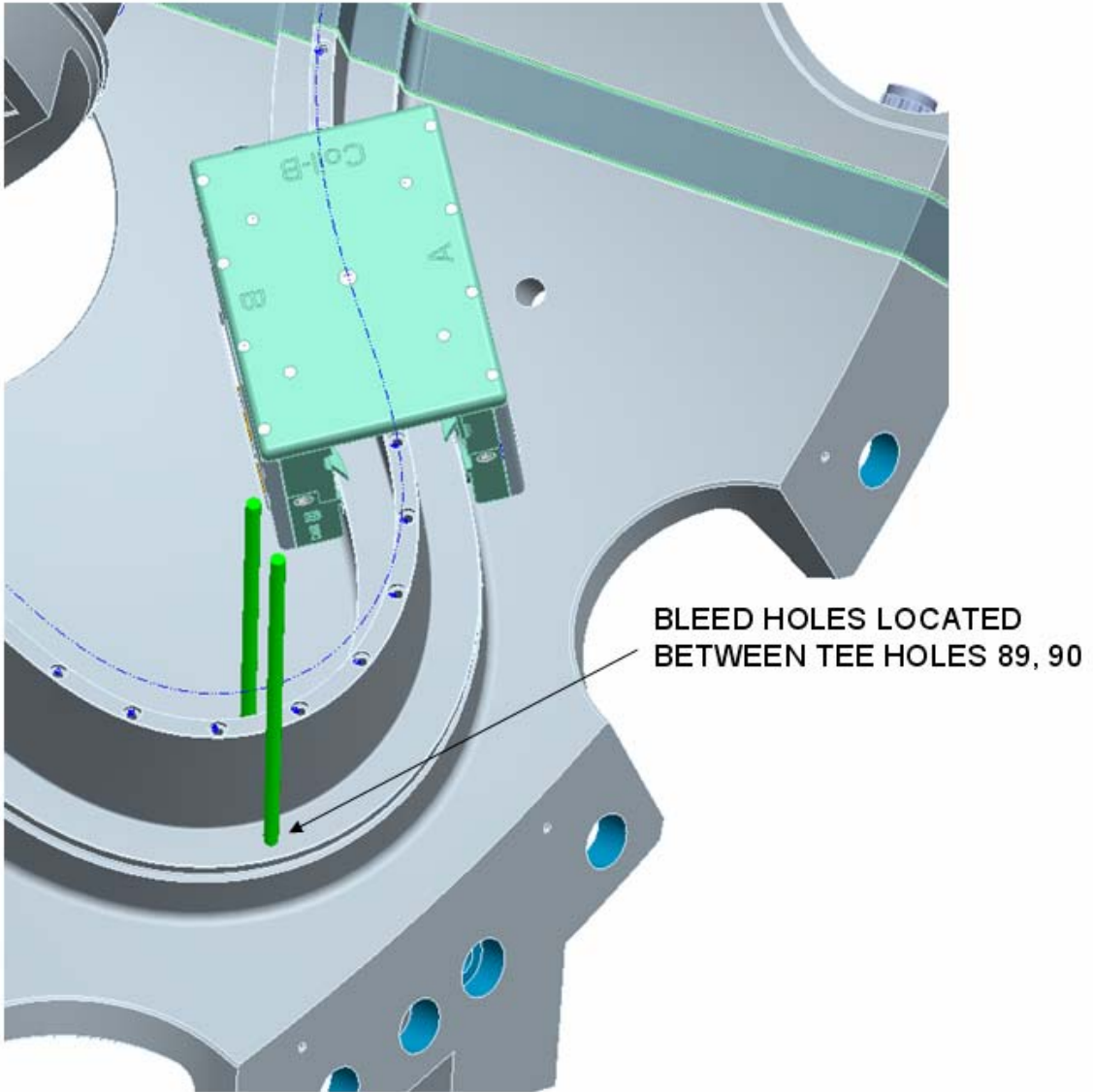
ENGINEERING CHANGE PROPOSAL: N/A DATE: July 12, 2006

COGNIZANT INDIVIDUAL MAKING THE CHANGE: D. Williamson

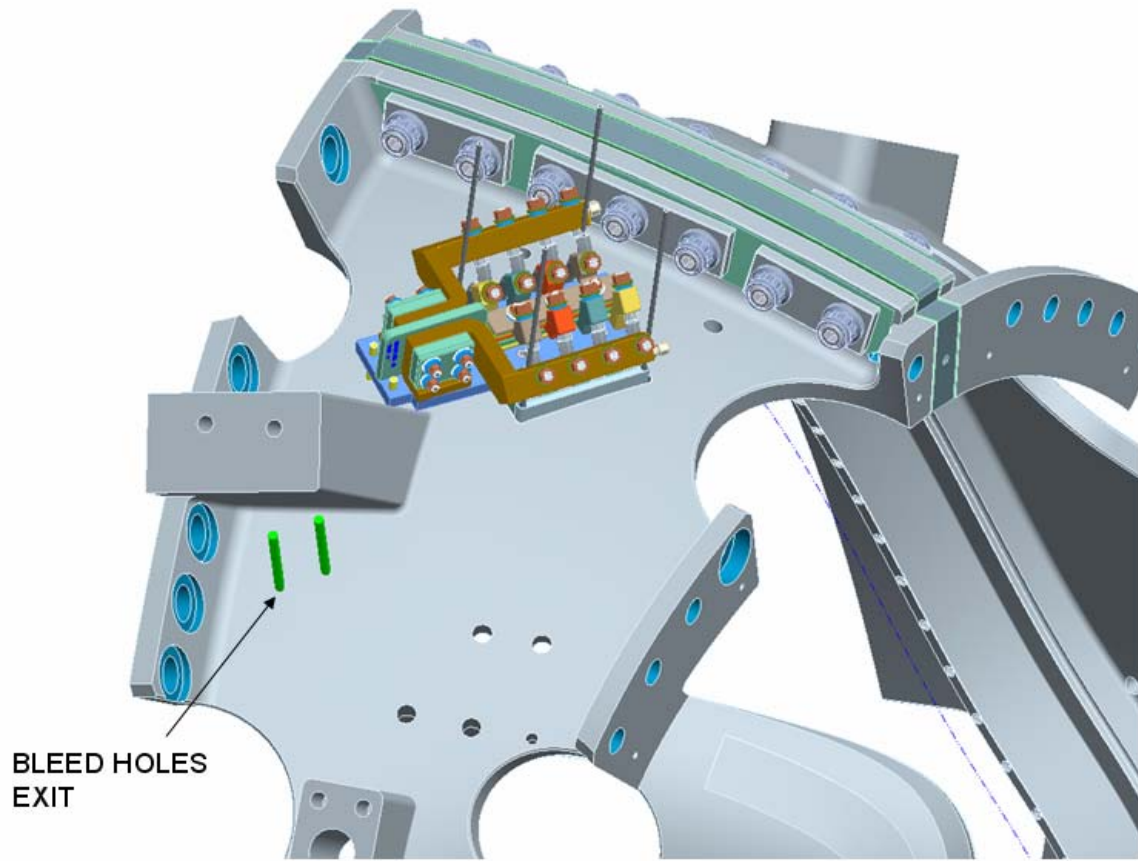
RESONSIBLE LINE MANAGER: B. Nelson



Type-B, Flange Datum -D, Coil Side -A



Winding Form Inner Surface View



Winding Form Outer Surface View