

NCSX ENGINEERING CHANGE NOTICE (ECN) ECN # 5379R1

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| COGNIZANT INDIVIDUAL: | Mike Cole |
| ECN TITLE: | Vacuum Vessel Support Rods |
| CC/WP/Job: | /1806 |
| 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: Phil Heitzenroder
 (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: | Current Revision | TITLE |
|--|-----------------------------|---------------------------------|
| SE124-051 | 1 | VERTICAL UPPER SUPPORT ASSEMBLY |
| SE124-054 | 0 | VERTICAL LOWER SUPPORT ASSEMBLY |
| SE124-055 | 0 | VERTICAL SUPPORT CLEVIS |
| | | |

DESCRIPTION OF CHANGE: (state drawing no., zone, group, or list attachments)

SE124-051
 CHANGED HAIRPIN TO COTTER PIN

SE124-054
 CHANGED HAIRPIN TO COTTER PIN

SE124-055
 3/4-10UNC WAS 3/4-16UNF

REASON FOR CHANGE:

SE124-051 – To eliminate the possibility retaining pin from slipping off.
 SE124-054 – To eliminate the possibility retaining pin from slipping off.
 SE124-055 – To match threads to the bosses on the vacuum vessel. Per NCR# 3664

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| ENGINEERING CHANGE NOTICE APPROVALS: DATE: 7/18/2008 |
| COGNIZANT INDIVIDUAL MAKING CHANGE: |
| RESPONSIBLE LINE MANAGER: <input checked="" type="checkbox"/> Update Drawings Immediately <input type="checkbox"/> Defer Update and Use ECN Stamp Other Comments: |

PPPL NONCONFORMANCE REPORT NO: 3664 Open Date 07/21/06

Status 5 - Corrective Action Needed **Trend** 05-Design Interference

Department NCSX **Division** NCSX Project

Source/Org NCSX Project

Item Dwg/Part# SE120-004 R2 Pt.s 48 to 51, S **Procurement #** D-NCSX-FPA-QA1-00

Cost Center _____ **WBS/Other** 00/00/00

RAP# 3250 **Job Doc #** D-NCSX-FPA-QA1-00 **Vendor** _____

RAP Title Field Period Assembly Component Receipt Inspection

HoldTag Applied

Nonconforming Condition (include requirement(s) violated):

(VVSA-1, 2, 3) The threads on the Vertical Support Clevises (pt. 1 Dwg. SE124-055 R0) do not match up with the threads on the Clevis Bosses (pt.s 48 to 51 Dwg. SE120-004 R2). Drawing SE124-051 R0 "Vertical Support Assembly" shows the Vertical Support Clevises threading into the Clevis Bosses. The Clevis Bosses are installed on the vacuum vessel (VVSA-1). This condition will most likely effect VVSA-2 & VVSA-3 as well. The threads on each part are in accordance with the drawing details.

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|--|---------------------------------------|
| Vertical Support Clevis, 0.75 - 16 UNF threads, Qty. 12, | pt. 1 |
| Clevis Boss A, | 0.75 - 10 UNC threads, Qty. 2, pt. 48 |
| Clevis Boss B, | 0.75 - 10 UNC threads, Qty. 2, pt. 49 |
| Clevis Boss C, | 0.50 - 13 UNC threads, Qty. 2, pt. 50 |
| Clevis Boss D, | 0.50 - 13 UNC threads, Qty. 2, pt. 51 |

Lot Size Recd 0 **Sample Size Insp** 0 Lot Rejected **# Rejected** 0

Reported By Edwards J **Validated By** Phelps C **Validated Date** 07/21/06

Distribution **Cog** M. Viola **Insp** Phelps/Boscoe

Proj. Doc Control (when closed) QC Files Malsbury J Boscoe J

Edwards J Dudek L Malinowski F Reiersen W Williams M Tyrrell M

Disposition: Rework*__ Repair*__ Use As Is*__ Return To Vendor*__ Scrap*__

Repair

Recut clevis threads with coarse threads.

NOTE: NCR will remain open until corrective action is complete.

NOTE: 9/20/06 - This corrective action will not take place until assembly. (MV to FAM)

NOTE: This work is at least 6-months away as of 6/12/07 (C. Phelps)

NOTE: 1/18/08 - Per Mike V. verbal, this work is 6-8 months away from completion. (LY)

For rework or repair of vendor supplied equipments, fill in information below:

#Hours _____ \$Est Labor _____ \$G&A _____

\$Material _____ \$Burden _____ \$Total _____

Disposition By Viola M Date 07/25/06

Supervisor's/RLMs Concur Dudek L Date 07/25/06

Eng. Dept. Head Concur Williams M Date 07/25/06

WCO/Other N/A Date _____

PQA/QC Mgr Dispos Concur Boscoe J Date 07/26/06

QC Field Verification By _____ Date _____