NCSX RFD Part I	**Number: 12-011**	**RFD Description: Relax tolerances on Manifold Bends**
Initiator: Larry Dudek		**Organization: PPPL**

List of Impacted Documents: *(Specification, MIT/QA Plan, SOW, drawing, etc.):* **SE123-160, 161, 162, 163 Vacuum Vessel Heating / Cooling Header Weldments**

Cost Impact: *(If none, so state):* **NONE**

Schedule Impact: *(If none, so state)* **NONE**

Quality Impact: *(If none, so state* **NONE**

State Requirement Deviation is Requested For*: (Specification, MIT/QA Plan, SOW, drawing, etc.):* **SE123-160, 161, 162, 163 Vacuum Vessel Heating / Cooling Header Weldments Tolerance on 11.87" radii and 9.18" radii tube bend is 0.020". Requesting relaxation to 0.13".**

Full Description of the Deviation Requested: *(Use continuation pages, e-mails, letter, sketches, etc. as needed and include amplifying information as appropriate to support deviation request.)*

Tube bend radii cannot be formed to that tolerance.

This RFD proposes to relax the tolerance on the bend from 0.020" radius to 0.13" on the radius. The true position of the outlet tube stubs will be maintained; therefore the impact will be a slight misalignment of the manifold in the brackets, which can be adjusted for during assembly with no impact to the design.

To fabricate to print would be very expensive and there is no degradation to quality, function, form or fit by accepting the request.

Attachments:

Initiator Signature: _____ **Date:** _____

NCSX RFD Part II	**Number: 12-011**	**RFD Description: Relax tolerances on Manifold Bends**
RLM: Wayne Reiersen	**Organization: PPPL**	

Impact on Interfaces with Other WBS Elements/Items: *(If none, so state): WBS 12 Job 1204*

RLM Recommendation:

☒ **Approve**   ☐ **Do Not Approve**

Additional remarks:

Does this Change Impact Material Already Procured or Parts/Assemblies Already Assembled/Manufactured using this Material: ☐ **Yes** ☒ **No**

If "Yes", what is the recommended disposition of this material/part/assembly?

RLM Signature: _____

Project Disposition:

☒ **Approved. No ECP required.**   _____
 NCSX Systems Engineering Support Manager

☐ **Approved. ECP -   assigned and processed.**

☐ **Not Approved. Reason(s) for disapproval:**