

<i>NCSX RFD</i> <i>Part I</i>	Number: 12-015	RFD Description: NCSX VVSA Spacer Machining
Initiator: Doug McCorkle		Organization: Major Tool and Machine
List of Impacted Documents: <i>(Specification, MIT/QA Plan, SOW, drawing, etc.)</i> NCSX-CSPEC-121-02 SE121-014		
Cost Impact: <i>(If none, so state) NONE</i>		
Schedule Impact: <i>(If none, so state: NONE</i>		
Quality Impact: <i>(If none, so state): NONE</i>		
State Requirement Deviation is Requested For: <i>(Specification, MIT/QA Plan, SOW, drawing, etc.)</i> SE121-014 Reference dimension 6.50 and 1.00		
<p>Full Description of the Deviation Requested: <i>(Use continuation pages, e-mails, letter, sketches, etc. as needed and include amplifying information as appropriate to support deviation request.)</i></p> <p>Reference drawing SE121-014. 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.</p>		
Attachments: N/A		
Initiator Signature: <u>Doug McCorkle</u> Date: <u>14Feb2006</u>		

<i>NCSX RFD</i> <i>Part III</i>	Number: 12-015	RFD Description: NCSX VVSA Spacer Machining
RLM: Brad Nelson		Organization: PPPL
Impact on Interfaces with Other WBS Elements/Items: (If none, so state): NONE		
<p>RLM Recommendation:</p> <p><input checked="" type="checkbox"/> Approve <input type="checkbox"/> Do Not Approve</p> <p>Additional remarks:</p> <p>Does this Change Impact Material Already Procured or Parts/Assemblies Already Assembled/Manufactured using this Material: <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No <u>3 VVSA Spacers in process</u></p> <p>If “Yes”, what is the recommended disposition of this material/part/assembly?</p> <p>Machine the VVSA spacer flanges to a maximum amount of remaining stock to ensure that carbon steel weld metal is removed from cover plate. Check using a permeability gage. Machine flat and parallel.</p>		
<p>RLM Signature: _____</p>		
<p>Project Disposition:</p> <p><input type="checkbox"/> Approved. No ECP required.</p> <p><input checked="" type="checkbox"/> Approved. ECP -044 being processed.</p> <p style="text-align: center;">_____ NCSX Systems Engineering Support Manager</p> <p><input type="checkbox"/> Not Approved. Reason(s) for disapproval:</p>		