

LIFT PROCEDURE

Procedure Number: D-L-NCSX-983-00

TITLE: Modular Coil Winding Form Lift Procedure

Note: LIFT DATA SHEETS NEEDED TO PERFORM THIS LIFT

PREPARED BY: James H. Chrzanowski
James H. Chrzanowski- Mod Coil ATI

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O = PPPL, OU = Engineering
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PIC: James H. Chrzanowski
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LIFT MANAGER: Mike Viola
Michael Viola- NCSX Lift Engineer

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Reason: I am approving this document
Date: 2005.08.03 14:48:02 -04'00'

PROCEDURE INCLUDES ALL ATTACHMENTS

**Modular Coil Winding Form Lift Procedure
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1.0 INTRODUCTION:

- 1.1 This procedure describes the necessary equipment and methods to follow in lifting a Modular Coil Winding Form.
- 1.2 This procedure shall be used for handling any of the (3) modular coil types (A, B and C).
- 1.3 This procedure shall be used for handling the bare winding forms prior to being mounted in a support ring and/or the completed coil after the modular coil has been removed from the support ring.
- 1.4 These tables identify the weights of the three coil types prior to and after winding operations.

Table 1- Weight of Empty Winding Form

Casting Type	Weight (lbs)
A	4985
B	4940
C	5080

Table 2- Weight of Completed Modular Coil

Casting Type	Weight (lbs.)
A	6130
B	6050
C	6100

- 1.5 This lift has been classified as a Critical lift because of the cost and impact to the NCSX schedule if damaged.
- 1.6 This lift procedure shall used in conjunction with procedures [reference]:
D-NCSX-MCF-001- Modular Coil Winding Form Preparation Activities
D-NCSX-MCF-004- Modular Coil Post VPI Activities

2.0 PREREQUISITES:

- 2.1 PIC will attest on the Lift Data Sheet that any installation, disassembly, or removal procedures required to allow the equipment to be moved have been completed.
- 2.2 PPPL Lift Manager and QC shall be notified in advance of a critical lift.

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- 2.3 No Critical Lift may be commenced without the presence of a PPPL Lift Engineer or his designee.
- 2.4 The lift must be made in accordance with ENG-021 Hoisting and Rigging Program.

3.0 PRECAUTIONS:

- 3.1 The area where lift is being made shall be properly secured so that personnel other than the lift team are allowed access.
- 3.2 All personnel involved in this procedure shall wear hard hats.
- 3.3 All rigging shall be inspected by a qualified rigging specialist (QRS).
- 3.4 The crane operator shall be Critical Lift certified.
- 3.5 Protection for the slings and equipment from sharp edges will be provided.

4.0 PROCEDURE FIELD CHANGES

Procedure field change can be made on site if approved by the PPPL Lift Engineer by working up or using a new Lift Data Sheet.

5.0 LIFT DATA SHEET INSTRUCTIONS

The attached Lift data sheet provides the specification for the hoisting and rigging aspects of the lift and shall be initiated by the Cognizant engineer.

6.0 PROCEDURE:

- 6.1 Use the lifting arrangement identified on the attached Lift Data Sheet to connect the modular coil winding form to the overhead crane.
- 6.2 The PIC shall identify the coil being transferred.

Coil ID being transferred: _____

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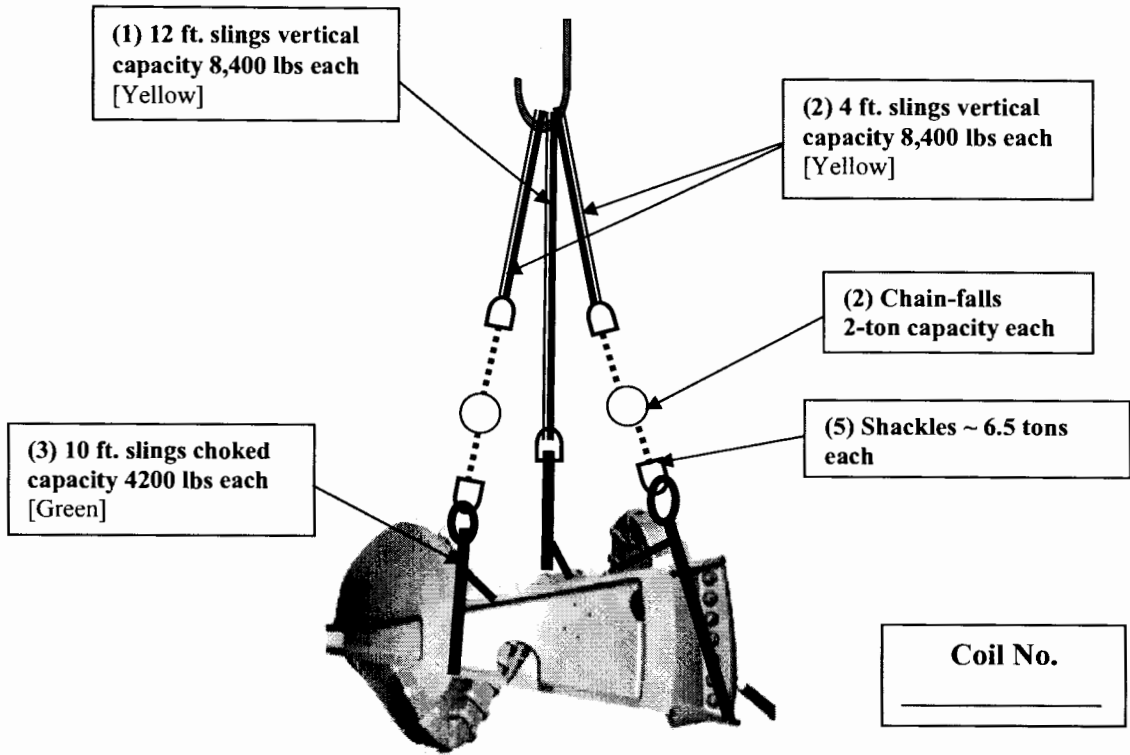
- 6.3 Slowly lift the modular coil winding form or completed modular coil, and transport to the desired location. **(Extreme care must be taken around the cooling lines and coil terminals on the finished coil.)**
- 6.4 Lower the modular coil into its final position and remove all lift slings, shackles and chain falls.
- 6.5 The modular coil lift and transfer is complete. Attached copy of completed/signed Lift Data Sheet to back of procedure.

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LIFT TITLE: Lifting the Modular Coil Winding Form	Effective Date: 8/2/05	Initiated: _____	Prepared by: _____
	LIFT PROCEDURE NO. D-L-NCSX-983	Repetitive Lift Expiration Date:	COG. ENG. / PHYS. QRS Approved: <i>Michael Riedel</i> LIFT MANAGER
AREA: NCSX Coil Manufacturing Facility			

DISASSEMBLY PROCESS COMPLETED PIC: _____

PROCEDURE PREREQUISITES COMPLETED QC: _____



DESCRIPTION: WEIGHT: 6200 Lbs. (max.) DETERMINED BY: Calculations
 Sketch of rigging shall include: Crane Capacity, Hook Load, All Rigging, Lift Height, Flight Plan
 Sketch of equipment shall include: Dimensions, Bolts Removed, Allowable Tilt

CRANE OPERATOR _____ (print)	RIGGING TEAM (print) _____
APPROVED: _____ QRS (Rigged per sketch)	_____ PIC (Equipment ready to lift)
	_____ LIFT ENGINEER (Qualification/inspection complete)

... PERFORM LIFT ... PERFORM LIFT ... PERFORM LIFT ...

Equipment is secure and rigging may be removed: PIC: _____ Date Performed: _____

LIFT DATA SHEET AND ALL DATA TO BE RETURNED TO PPPL OPERATIONS CENTER.