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Completion of the first TF coil in the second manufacturing line in Japan

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QST, as Japan Domestic Agency (JADA) in ITER, has responsibility to procure 9 ITER Toroidal Field (TF) coils and all 19 TF Coil Cases (CC). The 9 TF coils are procured by two suppliers to accelerate their production. In the first supplier, four TF coils have been fabricated and three of them has been delivered to the ITER site. On the other hand, the second supplier fabricates the forth TF coil in JADA as their first TF coil and this TF coil was completed. More detailed measurement of dimension and more optimized quality control during fabrication was performed from the experience in manufacturing TF coils in the first supplier. As a result of these efforts, we succeeded in more precise controlling of the required tight tolerances. For example, current center line (CCL) of the final coil is estimated within deviation of 0.3 mm in radius at the inboard straight section of TF coil, where most tight tolerance of 1.3 mm in radius is required. These outcomes of the first TF coil manufacturing, especially assembly of winding pack and CC, in the second supplier will be reported in this paper. In addition, progress of ITER TF coil fabrication in Japan is briefly reported.

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