Anytime. Anywhere.

D.L. Ricci Corp. Case Study #323

"Machining With A Deadline"

Set-Up:

- With relatively short notice, D.L. Ricci Corp. received a bid to remove material from a pedestal flange on a new steam generator
- The scope of the flange facing (removing .290"-.400" off a 138" O.D. Flange) and the critical time line (delays could cost the Contractor up to $1Million/day) scared away most bidders, but D.L. Ricci offered a proposal and got the job

Plan:

- All these plans and processes were done within 10 days of receiving the bid
- The original plan involved the rental of a machine that claimed it could do the job
- The plan also involved the set-up of an elaborate mock-up to demo the process
- During the mock-up the rental machine required much more set-up than anticipated
- Then during the mock-up demo the rental machine failed to deliver on it's promise
- Ricci Engineers had a back-up plan using our D.L. Ricci Portable Milling Machine
- The mock-up then shifted to the new machine (this was all done over a weekend) and the Ricci Mill with it's new Rotary Facing Head proved it could do the job

Operation:

- D.L. Ricci Field Staff Tony and Fred accompanied the Mill to the East Coast Nuclear Facility where the flange facing took place
- The 8-Z Mill with it's new facing head took about 1/2 hour to set-up
- Cutting around .080"/layer, the 6 days of flange facing was done accurately and timely, to save the day for the contractor

Results:

-The Ricci field team ended up with .320" - .340" faced off the pedestal which was better than expected, as was the speed in which it was accomplished
- The generator was installed on-time and the contractor was ecstatic
- Roy, Principal Engineer for the contractor, was on site for the machining process and he summed it up this way, "We were very pleased with the work D.L. Ricci Corp. did for us again. Good job done by all. You should put a green check on the wall for this job."