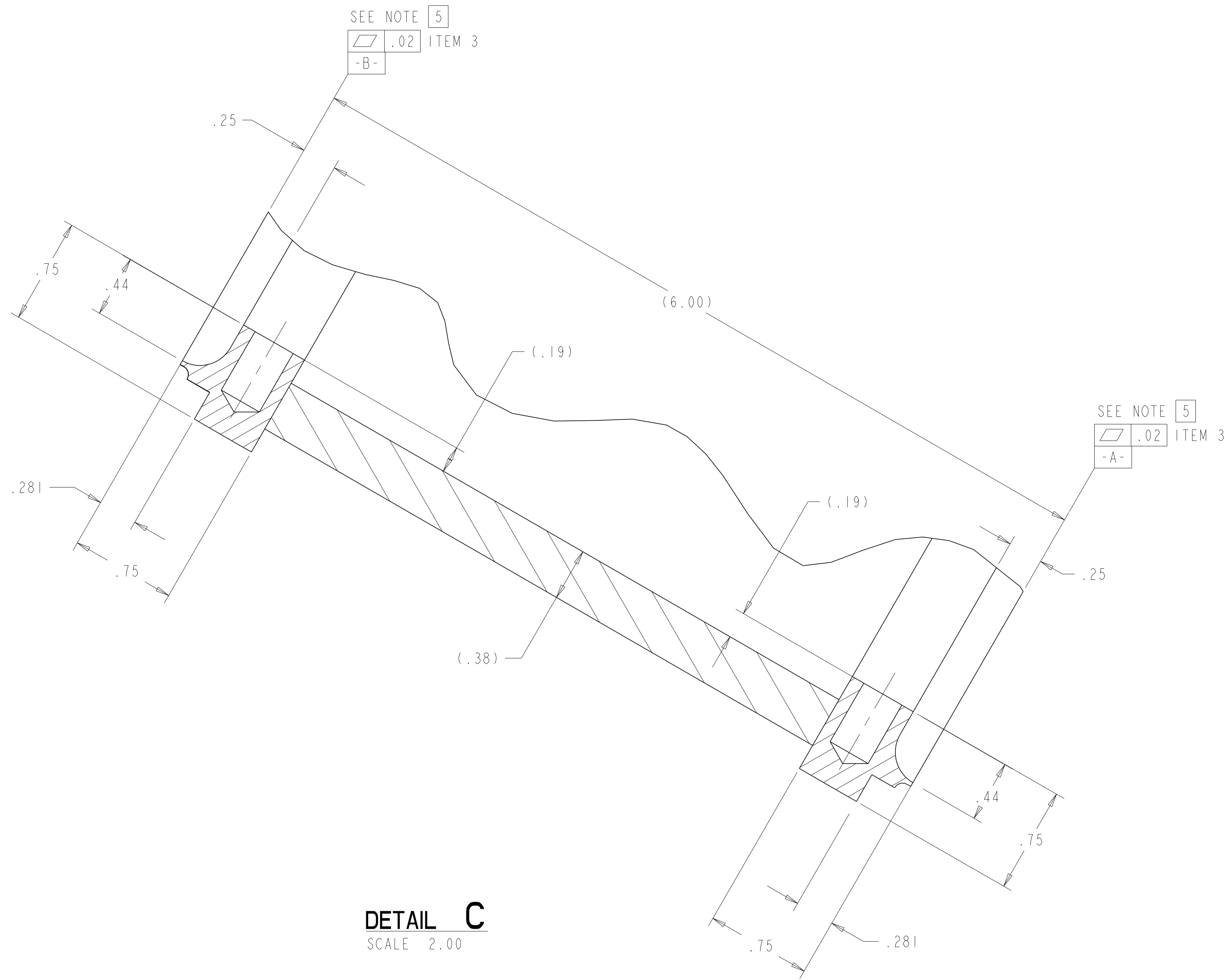
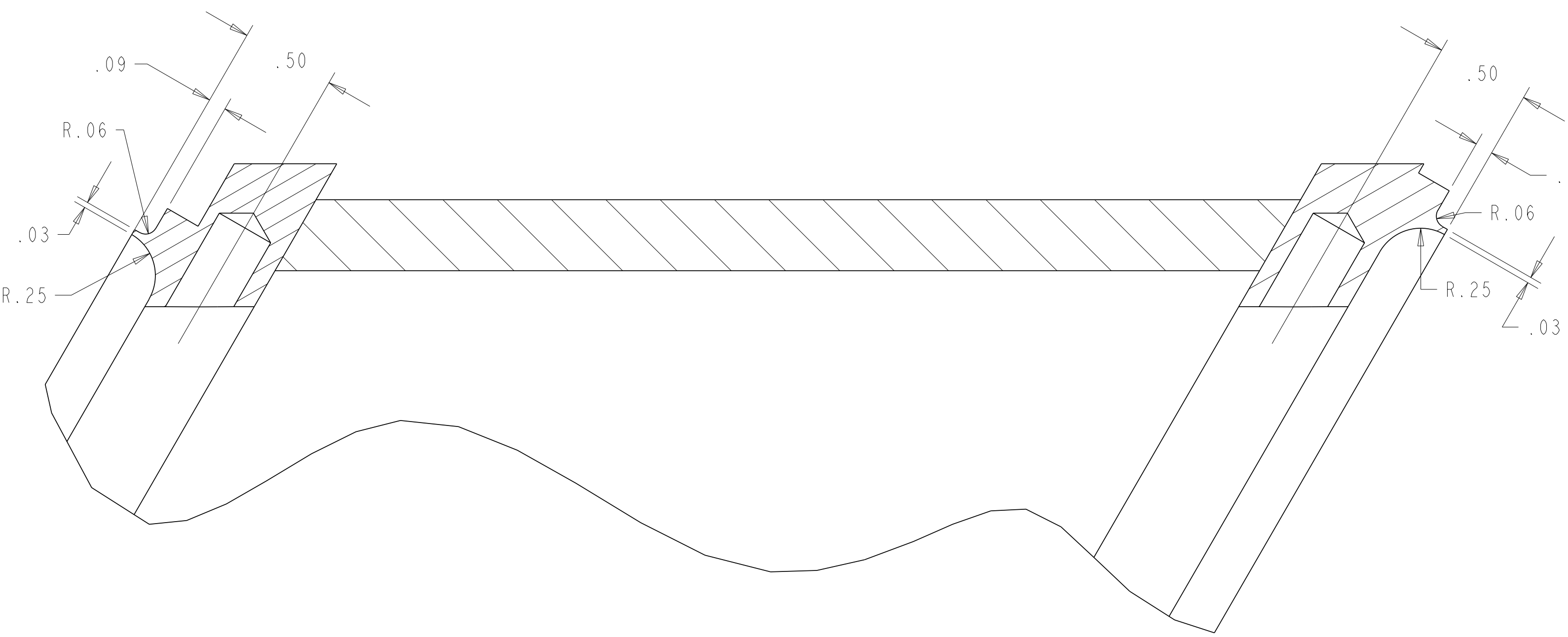
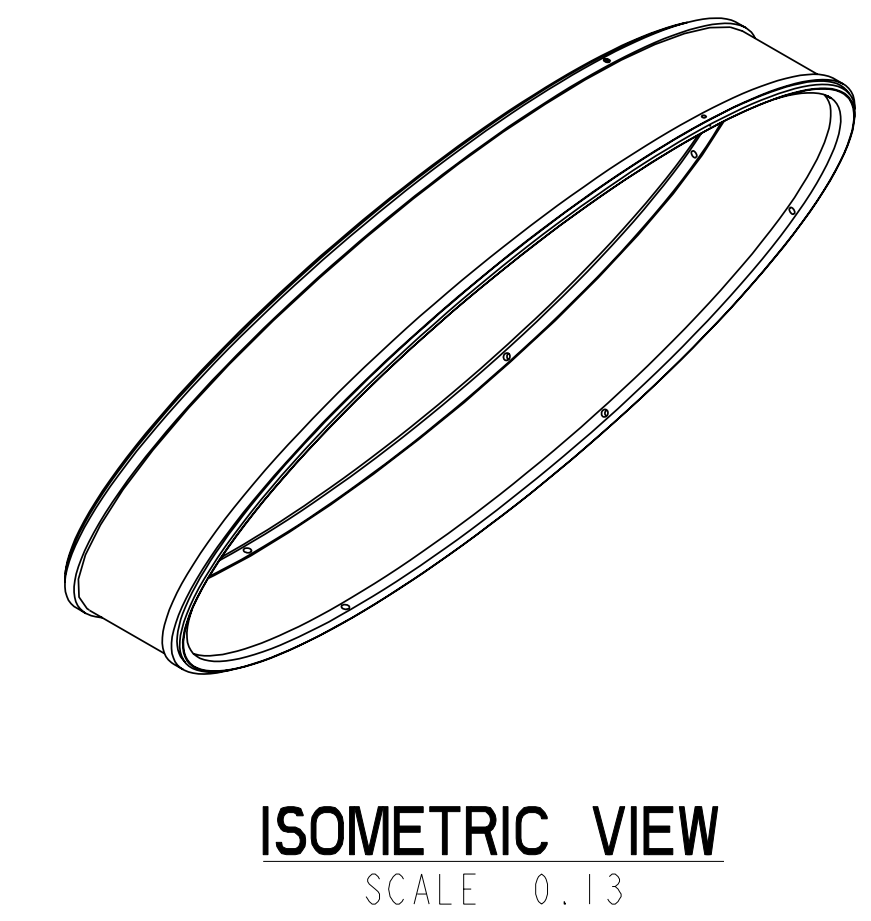
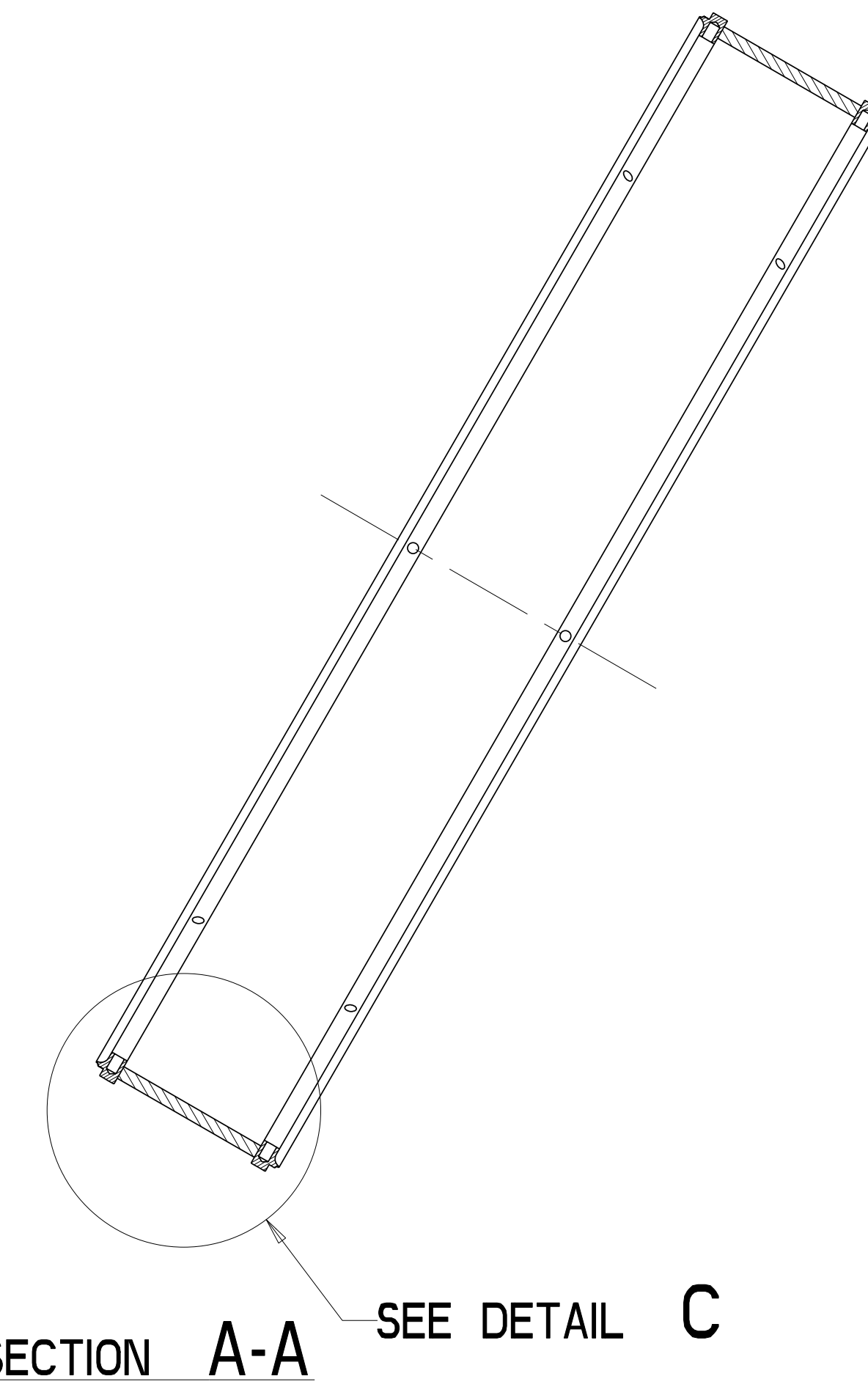


NOTES:

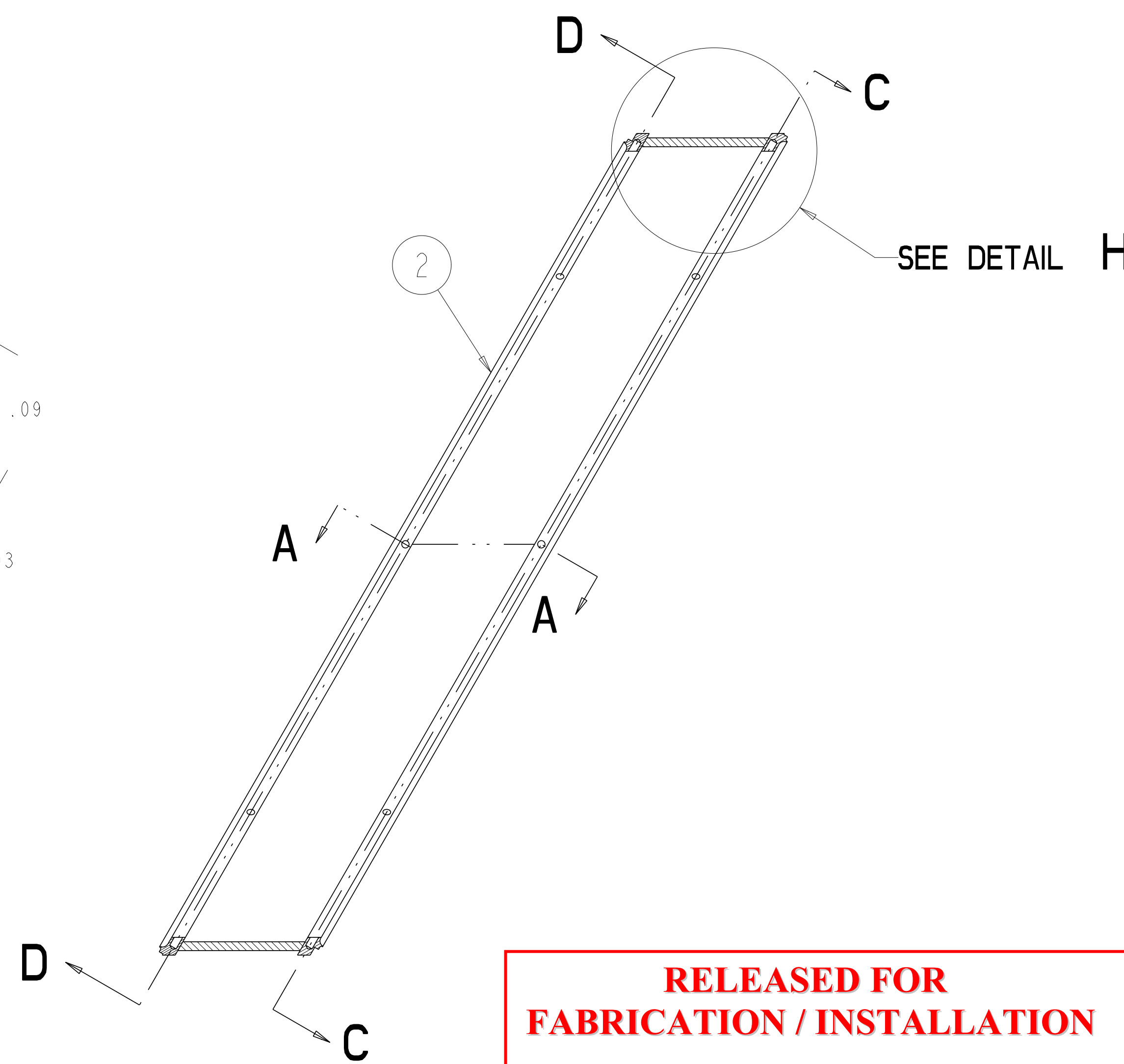
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
2. DIMENSION ARE IN INCHES.
3. REQUIREMENTS FOR FABRICATING THE SPOOL ASSEMBLY MACHINING ARE DEFINED IN THE DRAWINGS, MODELS, AND STATEMENT OF WORK NCSX-SOW-121-02.
4. GEOMETRY OF SPOOL ASSEMBLY MACHINING IS DEFINED IN CAD MODELS/FILES SE1203-002.ASM, SE1203-004.ASM, SE1203-011 AND SE1203-015.PRT.
5. FLATNESS SHOWN IS IN FREE, UNCONSTRAINED CONDITION. FLATNESS SHALL BE 0.015 WITH THE FLANGE CLAMPED DOWN TO A FLAT REFERENCE SURFACE.



DETAIL C
SCALE 2.00



DETAIL H
SCALE 2.00



SECTION B-B

SCALE 0.25

RELEASED FOR FABRICATION / INSTALLATION
 PPPL Drafting:

SE1203-006	AR	SE1203-004	SPOOL PIECE STOCK WELDMENT			2
			SPOOL PIECE MACHINING			1
			NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
			← NEXT ASSEMBLY			

SCALE AS NOTED		DES: P. L. GORANSON	27MARD04	UT-BATTELLE			Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC. Oak Ridge, Tennessee								
TOLERANCES UNLESS OTHERWISE SPECIFIED		DRW: G. FORTIER	20MARD04	NATIONAL COMPACT STELLARATOR EXPERIMENT			VACUUM VESSEL JOINT R&D SPOOL PIECE MACHINING								
FRACTIONS		CHK: G. LOVETT	6APR04	PPPL DRFT: J. SIEGEL			7/27/04	VERSION NO. 0	PLANT X-10	BLDG 5700	FL 3	SHT 1	OF 3	TYPE D	CLASS U
XX DECIMALS ± .01				DRAWING APPROVALS		DATE	RELEASE LEVEL	Fabrication			SE1203-002				
XXX DECIMALS ± .005															
ANGLES ± 0°15'															
BREAK SHARP EDGES .06 MAX															
FINISH .125 UNLESS OTHERWISE SPECIFIED															

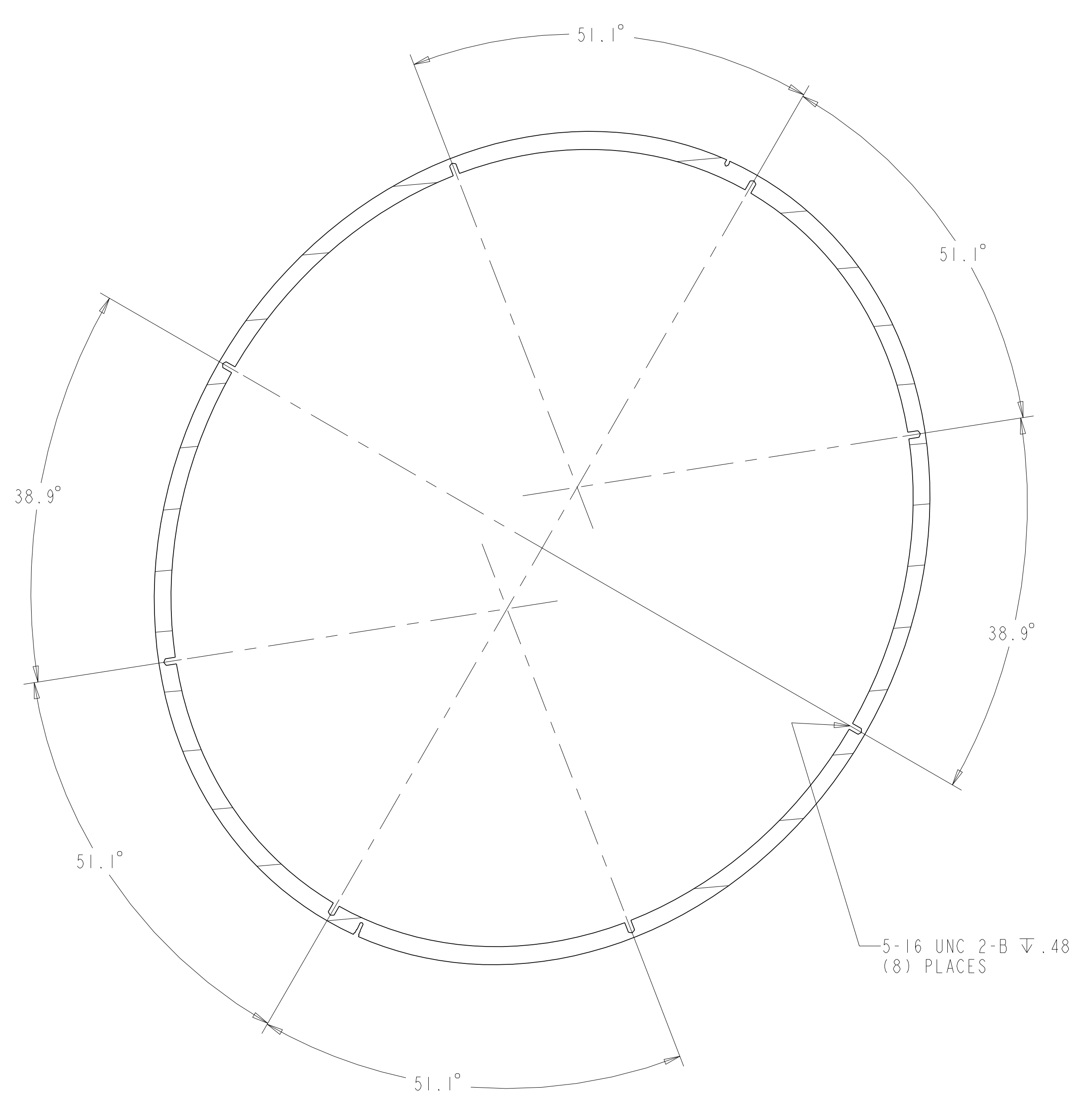
NO REPRESENTATION OR WARRANTY, EXPRESSED OR IMPLIED, IS MADE AS TO THE ACCURACY, COMPLETENESS OR USEFULNESS OF THE INFORMATION OR STATEMENTS CONTAINED IN THESE DRAWINGS, OR THAT THE USE OR DISCLOSURE OF ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS MAY NOT INFRINGE PRIVATE RIGHTS OF OTHERS. NO LIABILITY IS ASSUMED WITH RESPECT TO THE USE OF, OR FOR DAMAGES RESULTING FROM THE USE OF, ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS. DRAWINGS MADE AVAILABLE FOR INFORMATION TO BIDDER ARE NOT TO BE USED FOR OTHER PURPOSES, AND ARE TO BE RETURNED UPON REQUEST OF THE FORWARDING CONTRACTOR.

P THIS DRAWING PRODUCED ON PRO-ENGINEER

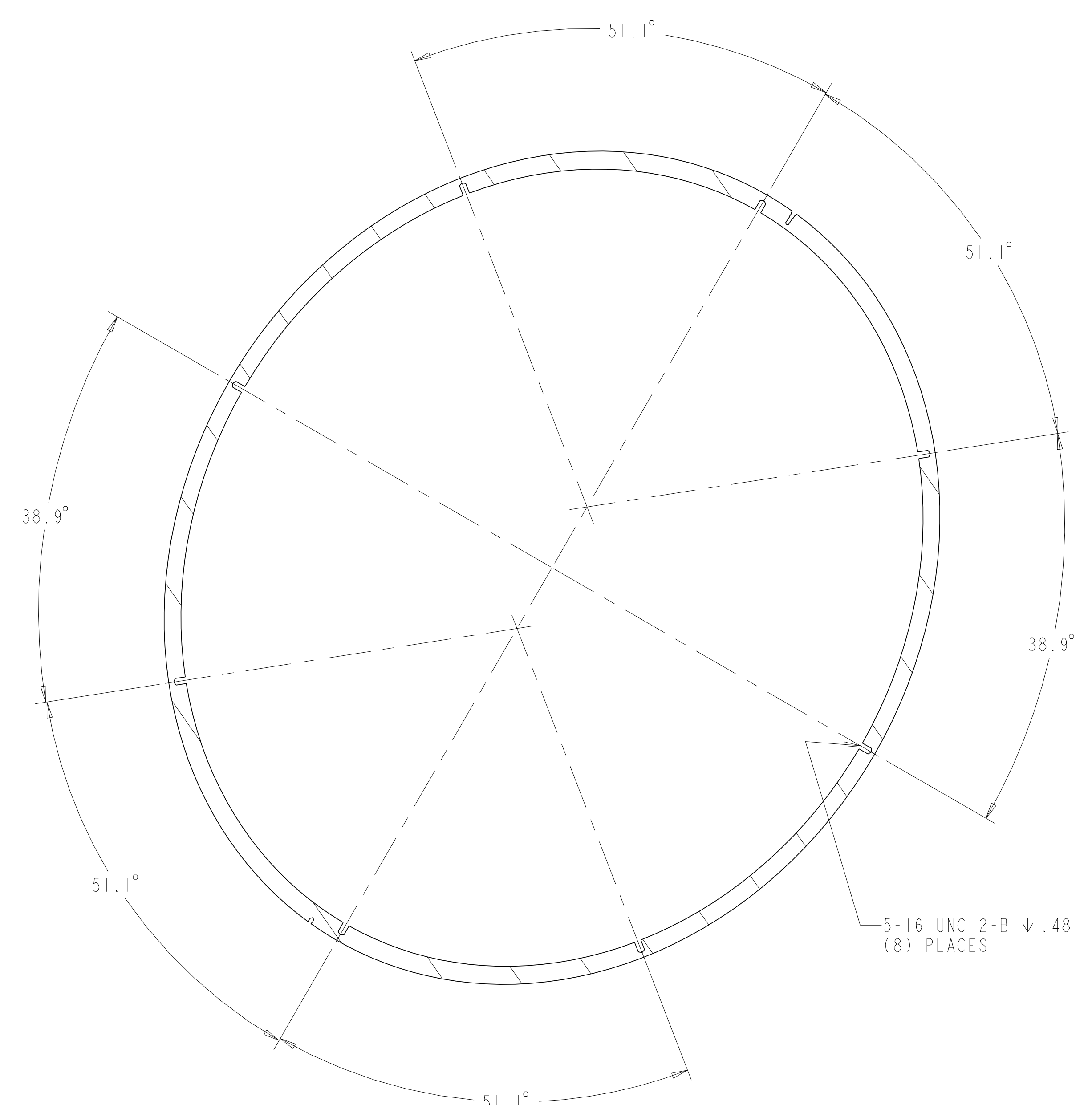
REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
1	PER ECN #4882 GENERAL REVISION	GHJ	7/27/04	MJC								

SE1203-002

FOR NOTES AND PARTS LIST SEE SHEET 1.



SECTION C-C



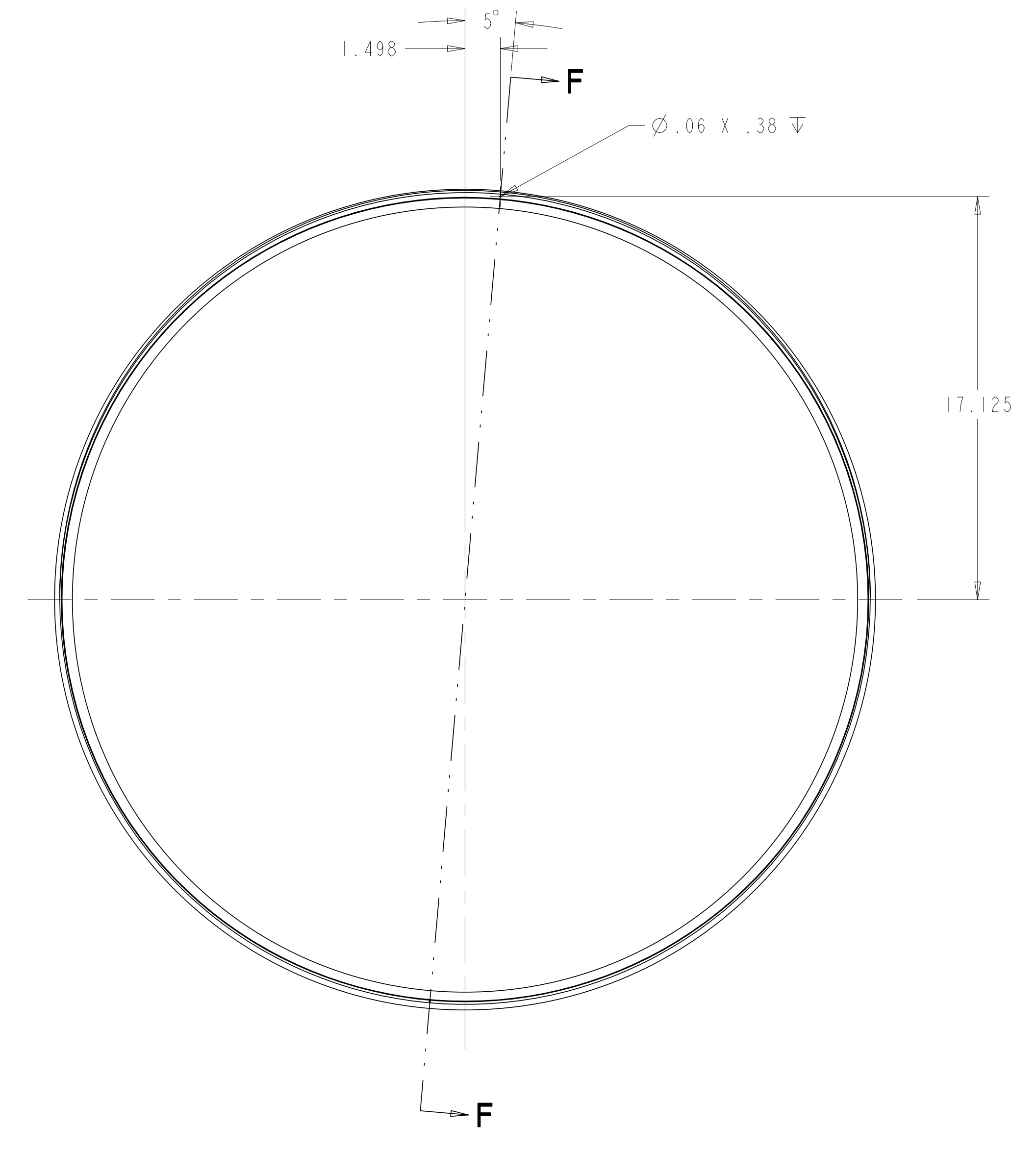
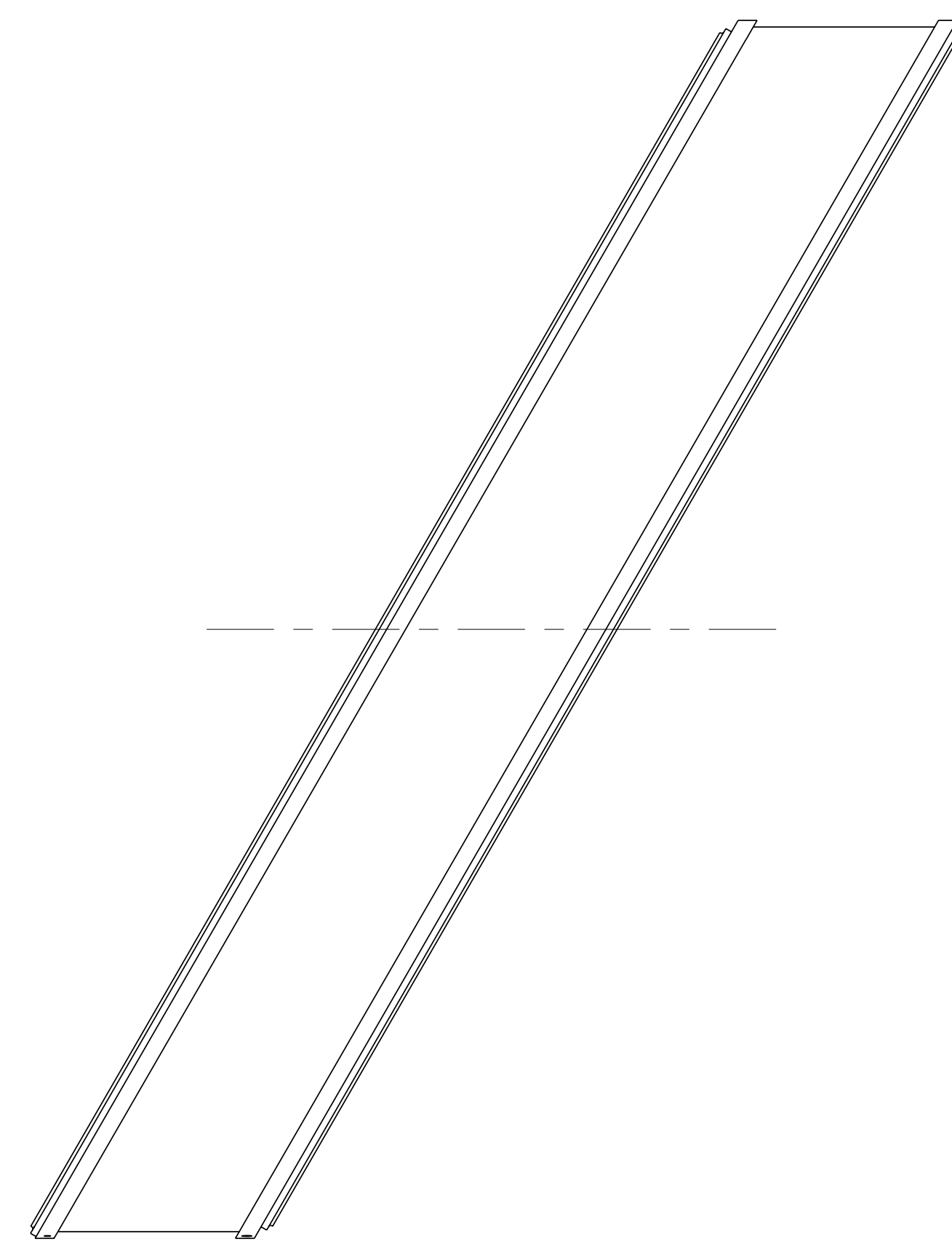
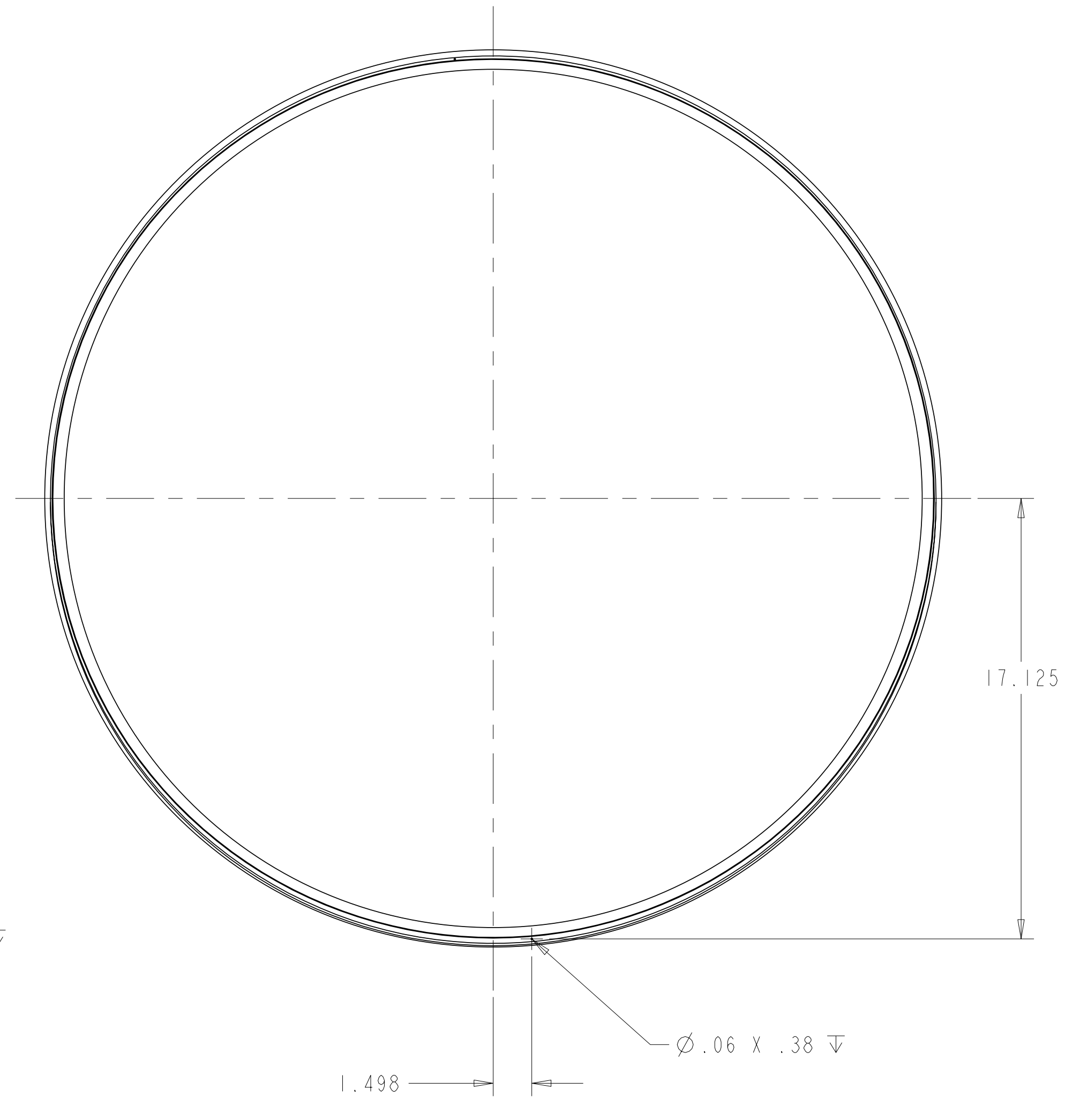
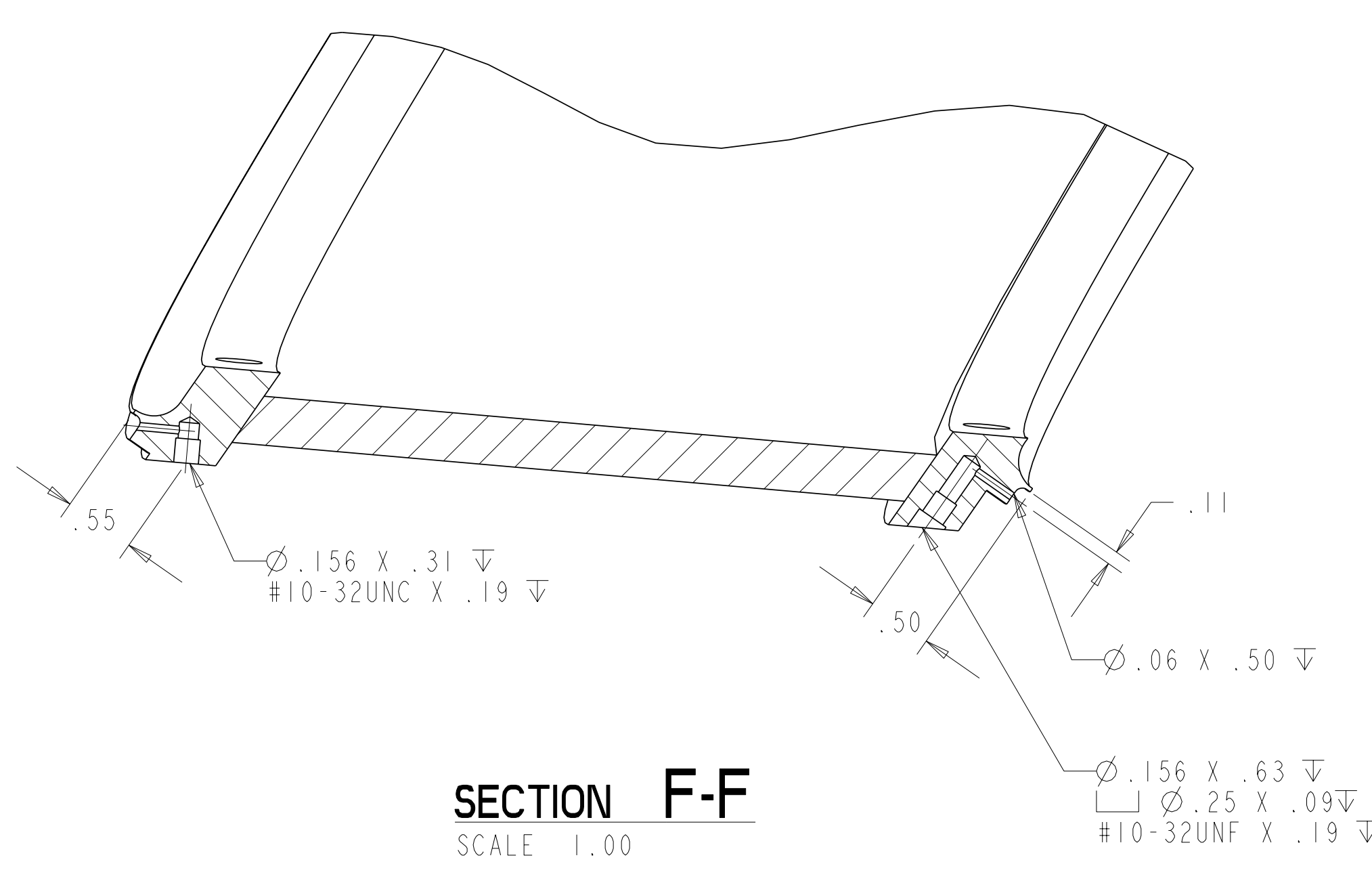
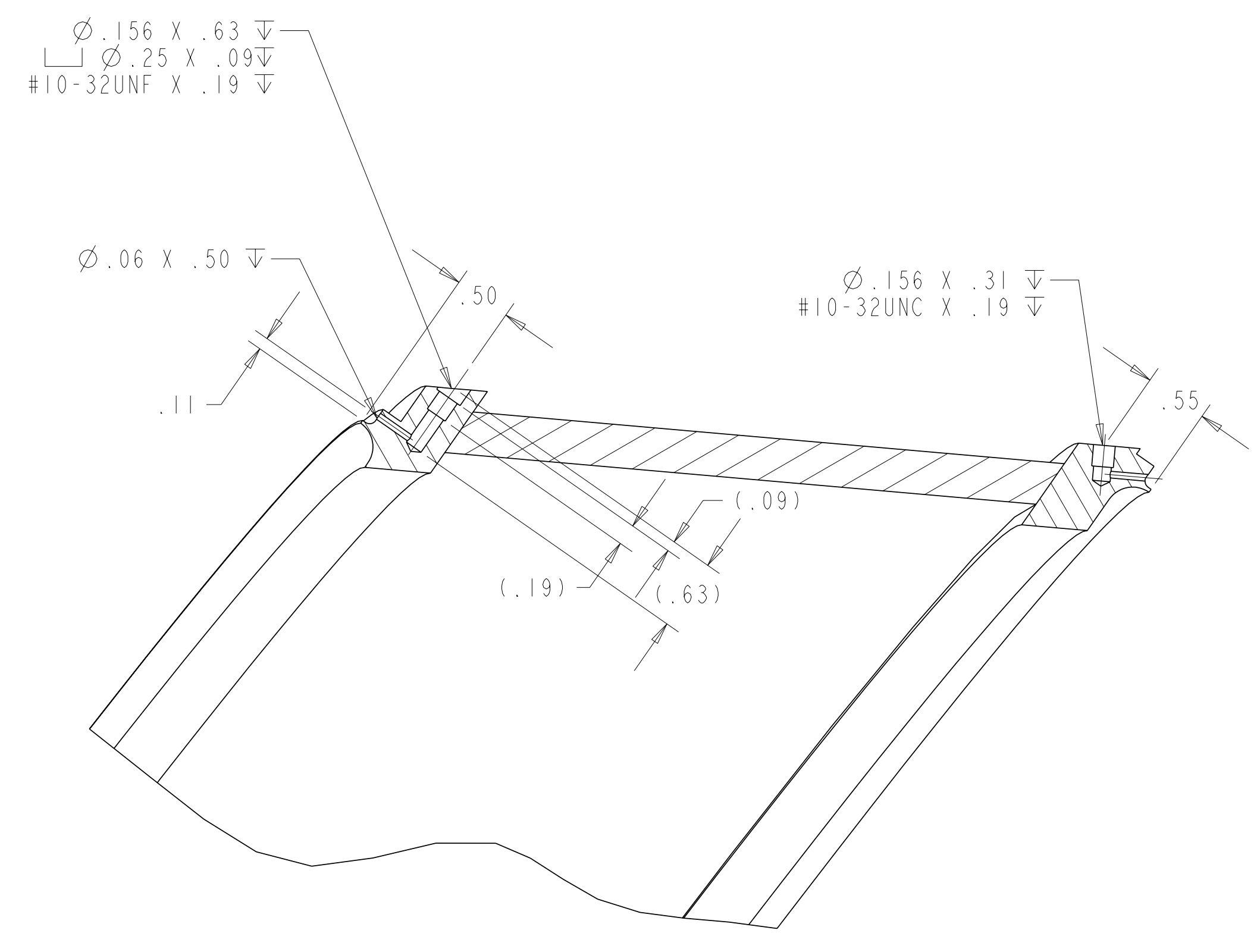
SECTION D-D

**RELEASED FOR
 FABRICATION / INSTALLATION**
 PPPL Drafting:

Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee PROJECT NAME						
UT-BATTELLE NATIONAL COMPACT STELLARATOR EXPERIMENT VACUUM VESSEL JOINT R&D SPOOL PIECE MACHINING						
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
0	X-10	5700	3	2	3	D U
RELEASE LEVEL		REV				
Fabrication		SE1203-002				

SE1203-002

FOR NOTES AND PARTS LIST SEE SHEET 1.



**RELEASED FOR
FABRICATION / INSTALLATION**
PPPL Drafting:

Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee PROJECT NAME						
UT-BATTELLE NATIONAL COMPACT STELLARATOR EXPERIMENT VACUUM VESSEL JOINT R&D SPOOL PIECE MACHINING						
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
0	X-10	5700	3	3 3	D	U
RELEASE LEVEL		REV				
Fabrication		SE1203-002 1				

SE1203-002