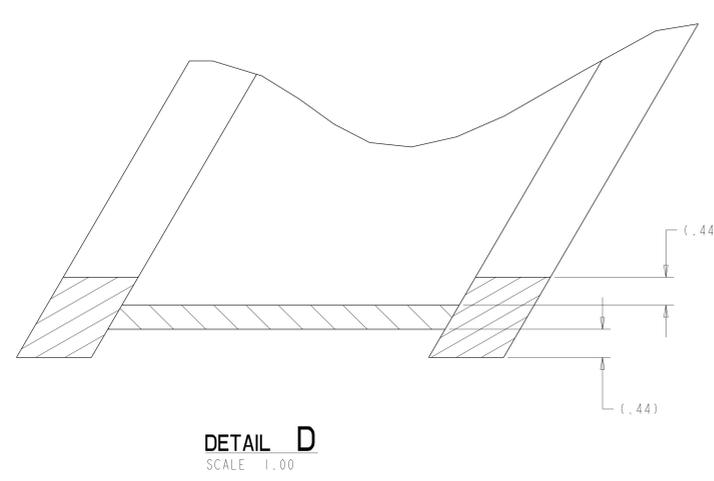
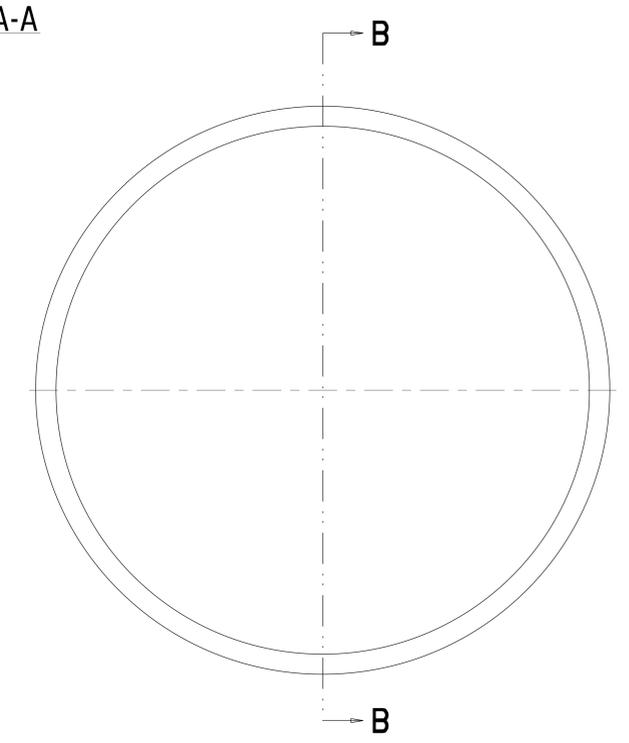
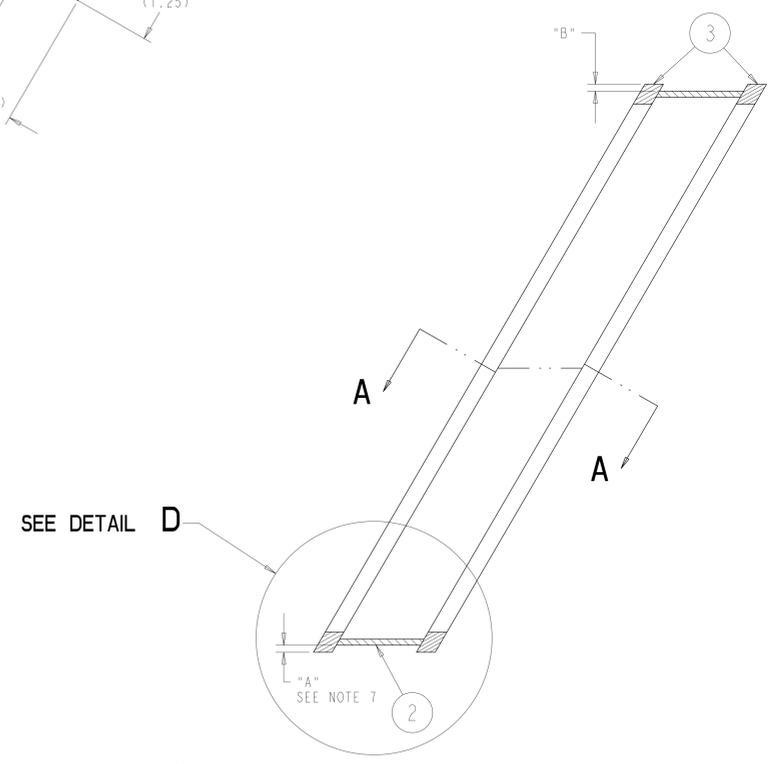
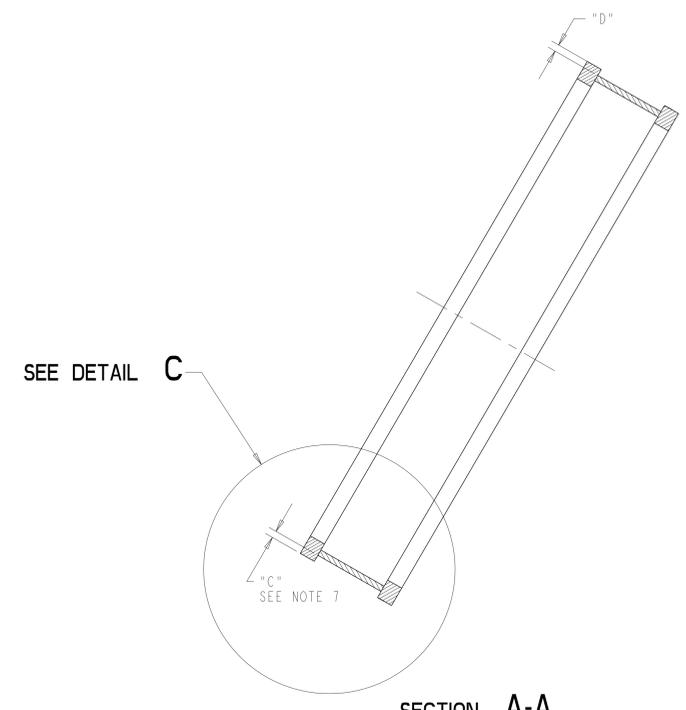
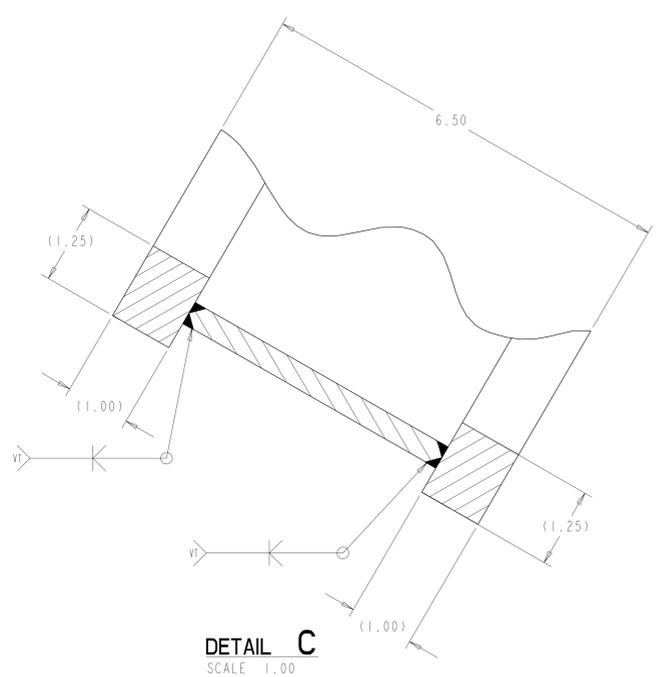


- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 2. DIMENSION ARE IN INCHES.
 3. REQUIREMENTS FOR FABRICATING THE VACUUM VESSEL SPACER ARE DEFINED IN THE DRAWINGS, MODELS, AND STATEMENT OF WORK NCSX-SOW-121-02.
 4. GEOMETRY OF VACUUM VESSEL SPACER IS DEFINED IN CAD MODELS/FILES SE1203-004.ASM, SE1203-011.PRT, AND SE1203-015.PRT.
 5. WELDING PROCEDURES AND PERFORMANCE QUALIFICATIONS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF ASME CODE, SECTION IX. WELDS MAY BE MADE BY THE GTAW OR GMAW PROCESSES. WELDS USING SMAW PROCESS ARE NOT PERMITTED.
 6. WELD INSPECTIONS SHALL BE PERFORMED BY VISUAL EXAMINATION; ALL WELDS ARE TO BE VISUALLY INSPECTED IN ACCORDANCE WITH ARTICLE 9, SECTION V OF THE ASME CODE. WELDS DESIGNATED WITH A "VT" IN THE REFERENCE AREA OF A WELD SYMBOL SHALL ALSO BE VISUALLY EXAMINED WITH 8X MAGNIFICATION, IN ACCORDANCE WITH ARTICLE 6, SECTION V OF THE ASME CODE. THE ACCEPTANCE CRITERIA FOR THE VISUALLY INSPECTED WELDS IS GIVEN IN AWS D1.6, PARAGRAPH 6.29.1. ALL WELDS THAT DO NOT MEET THE STATED ACCEPTANCE CRITERIA SHALL BE DOCUMENTED, REPAIRED AND RE-INSPECTED. VISUAL WELD INSPECTION SHALL BE DONE BY INSPECTORS CERTIFIED TO PERFORM VISUAL INSPECTION OF WELDS IN ACCORDANCE WITH AWS QC1 OR SNT-TC-1A, LEVEL II OR LEVEL III.
 7. DIMENSION "A" = "B" ±.03 AND DIMENSION "C" = "D" ±.03.



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

WELDING ENGINEER
APPROVED R. PARSELLS DATE: 8/3/04

SCALE 0.25

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

CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
SE1203-002	-1	SPOOL PIECE STOCK WELDEMT	INCONEL	UNS N06625	3
		SPOOL PIECE BODY	INCONEL	UNS N06625	2

SCALE AS NOTED	DES: P.L.GORANSON 27MAR04	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 28MAR04	NATIONAL COMPACT STELLARATOR EXPERIMENT	
FRACTIONS ±.01	CHK: G.LOVETT 6APR04	VACUUM VESSEL JOINT R&D SPOOL PIECE STOCK WELDMENT	
XX DECIMALS ±.01	DEPT: :	PPPL DRFT: J.SIEGEL 7/27/04	VERSION NO. 0
XXX DECIMALS ±.005	PE: :		PLANT X-10
ANGLES ±0°15'	CR: :		BLDG 5700
BREAK SHARP EDGES .06 MAX	PJ: :		FL 3
FINISH .125 UNLESS OTHERWISE SPECIFIED	RED: :		SHT OF 1
			TYPE I
			CLASS U
			REV I
			RELEASE LEVEL Fabrication
			SE1203-004

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

H
G
F
E
D
C
B
A