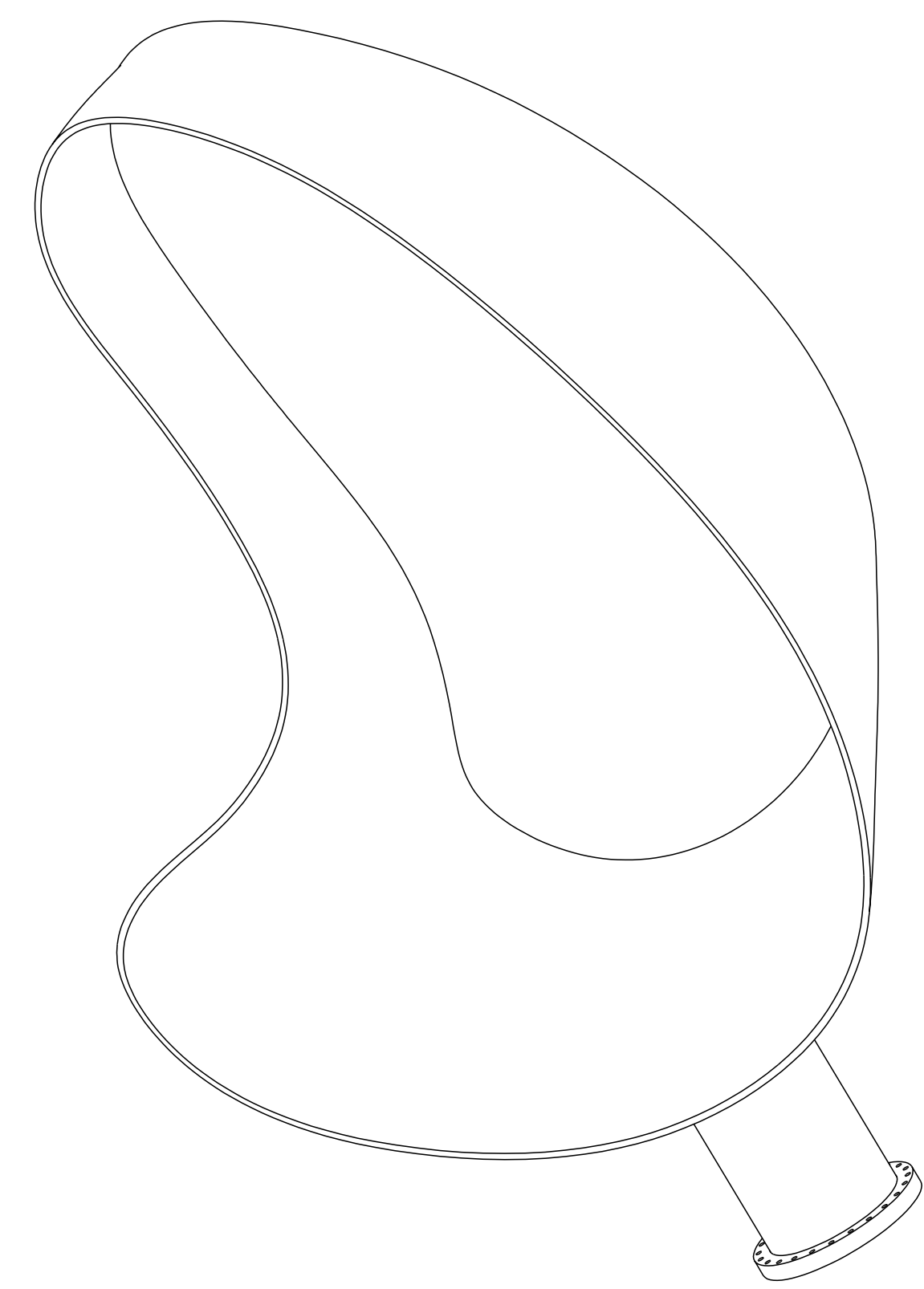
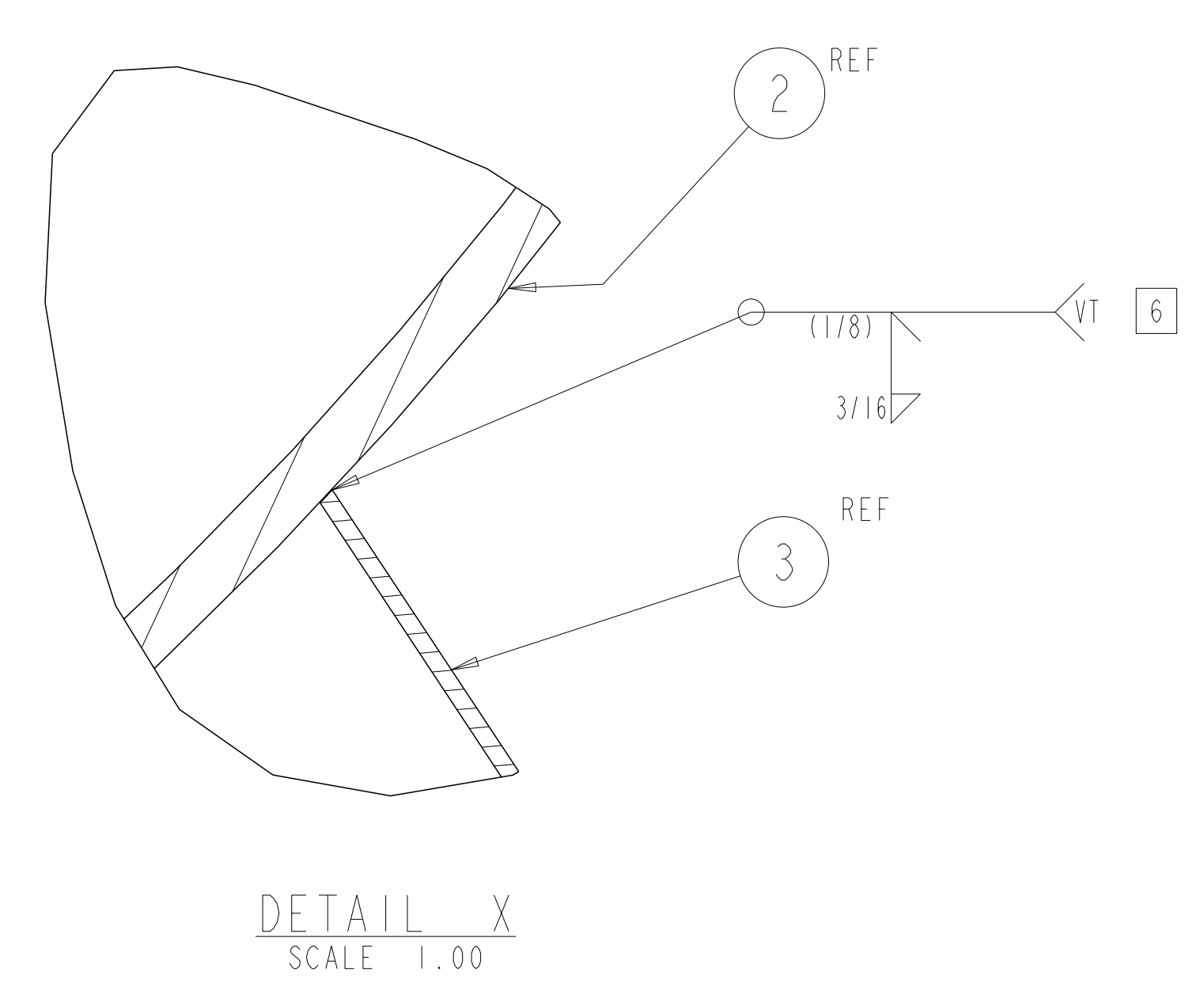
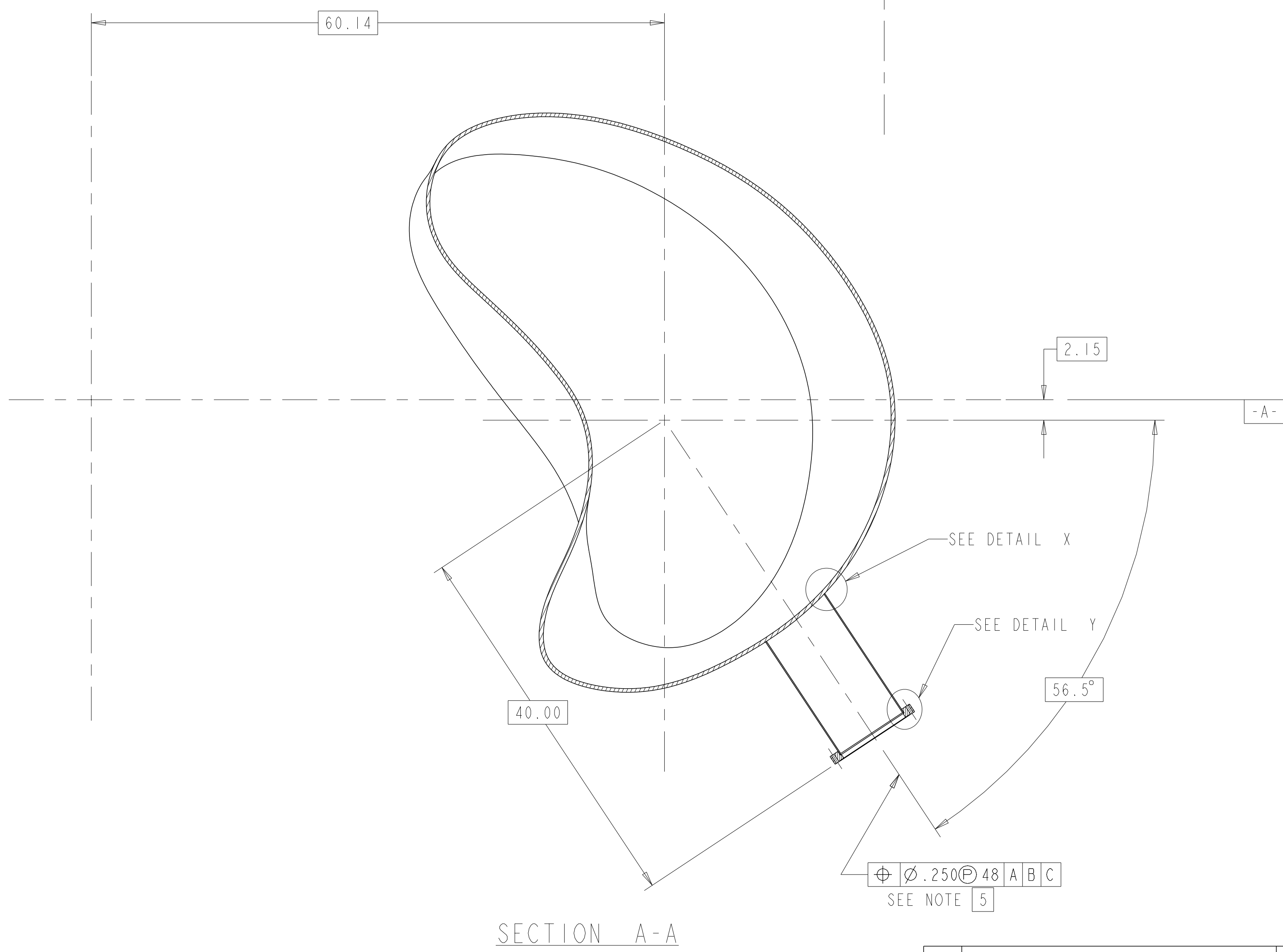
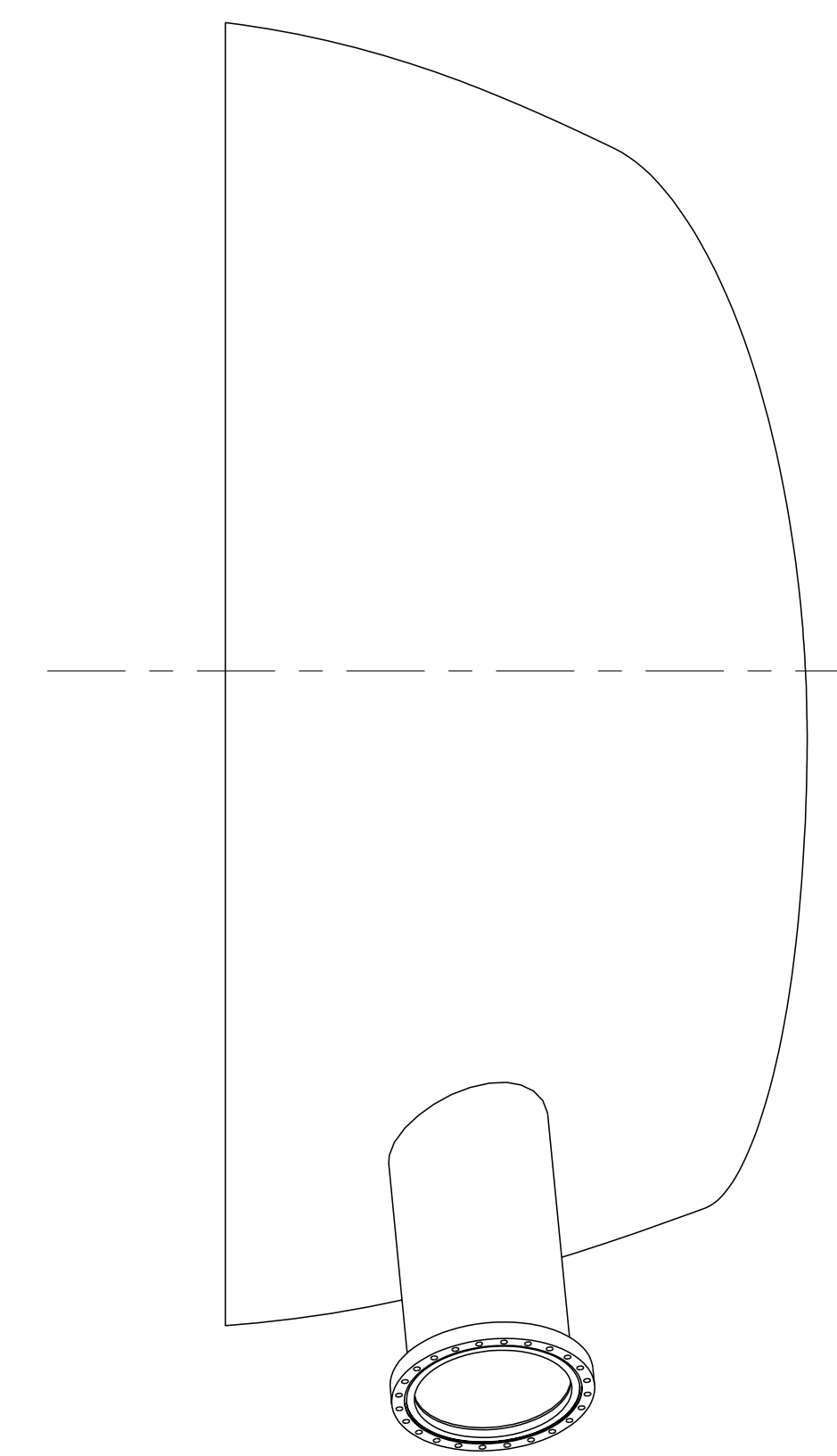
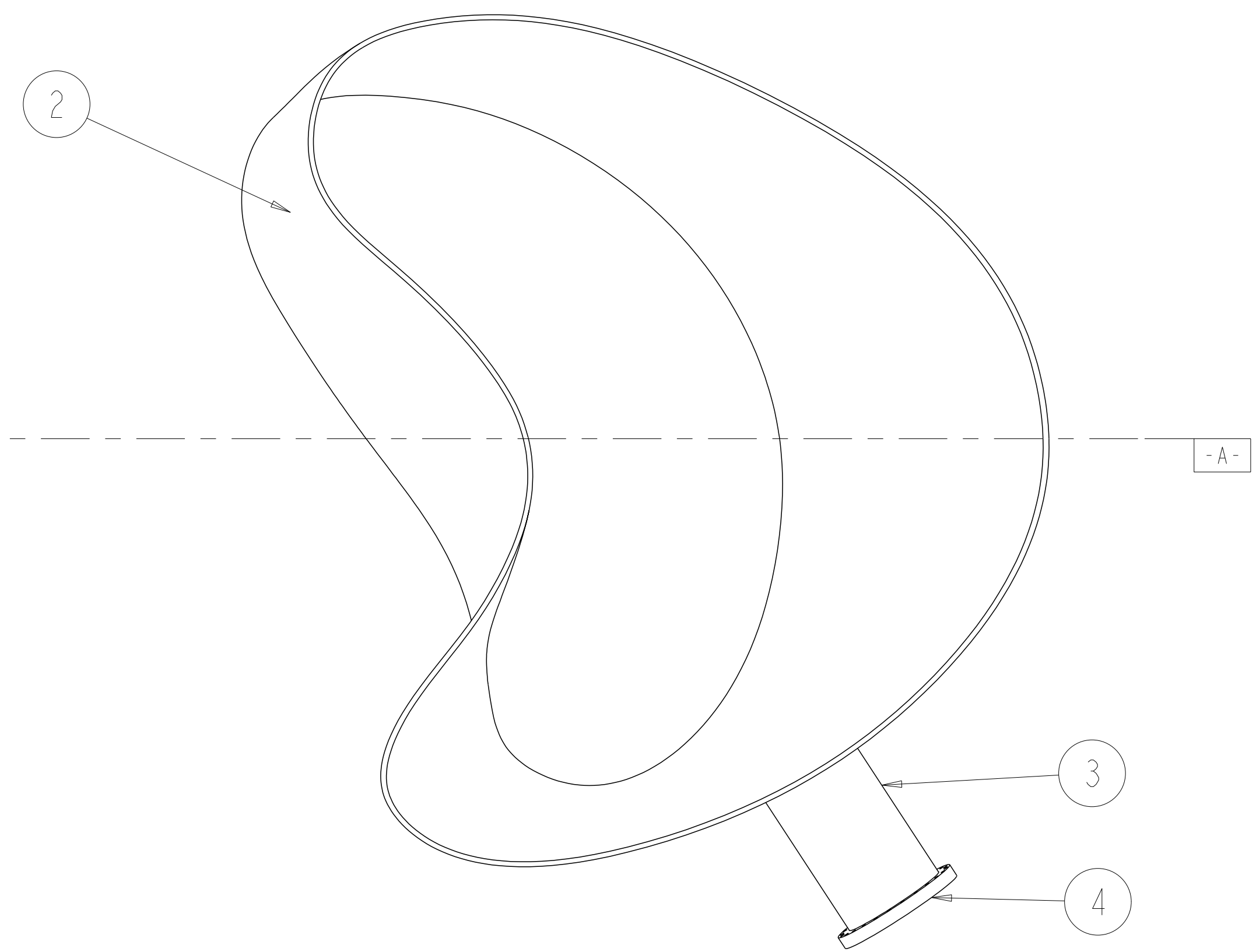
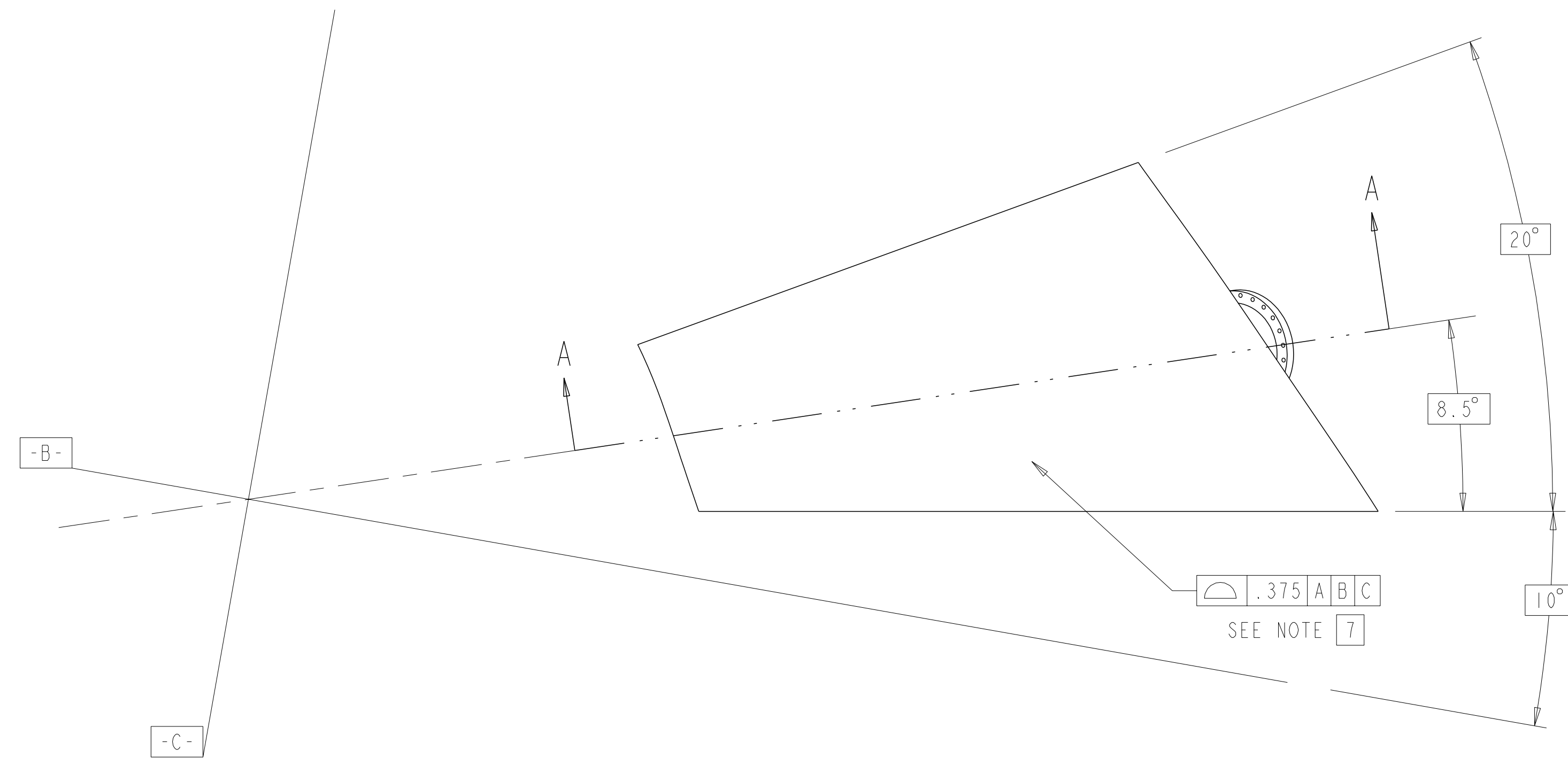


NOTES:

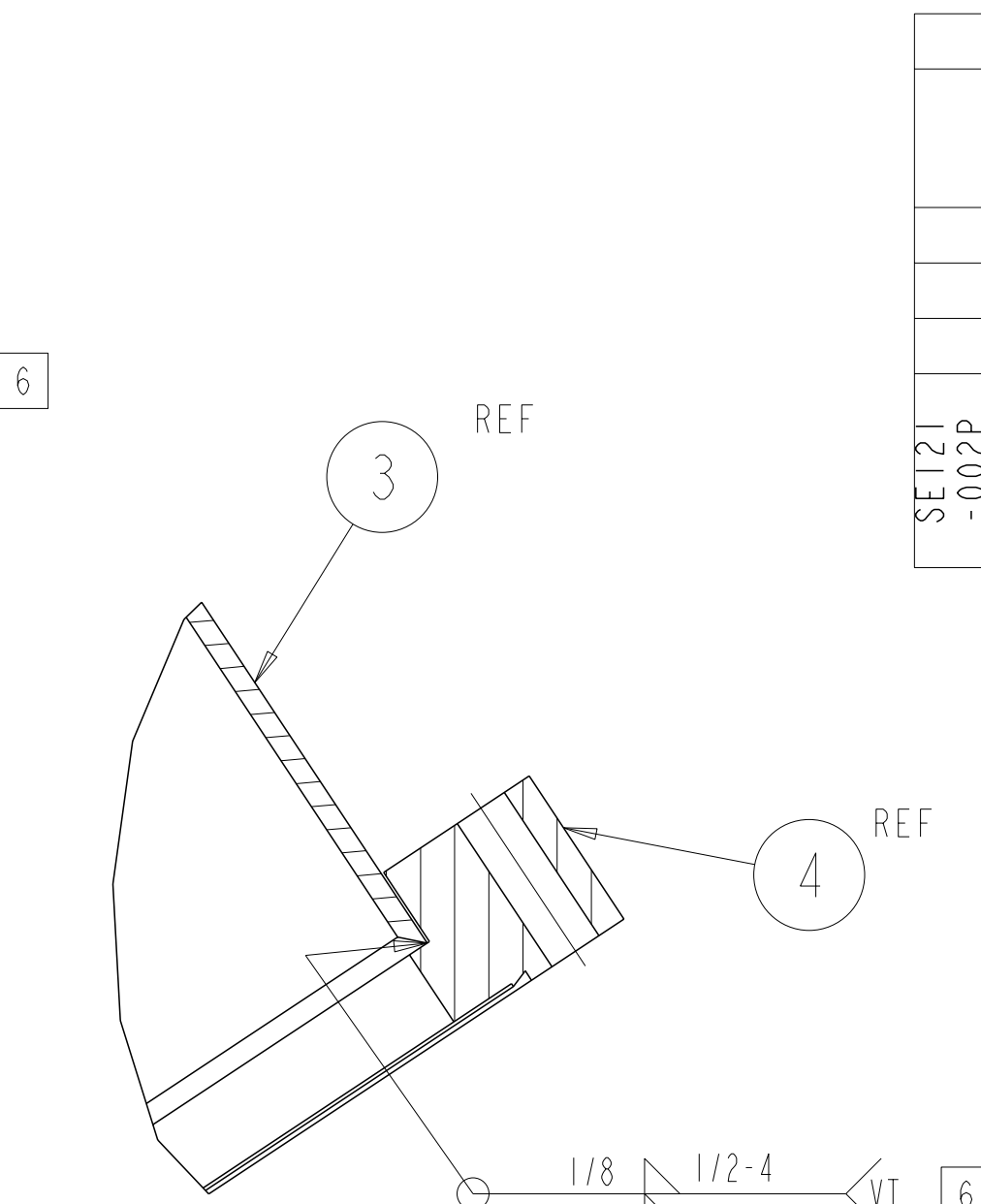
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
2. DIMENSIONS ARE IN INCHES.
3. REQUIREMENTS FOR FABRICATING THE VACUUM VESSEL PROTOTYPE ARE DEFINED IN THE DRAWINGS, MODELS, AND SPECIFICATION, NCSX-CSPEC-121-01.
4. GEOMETRY OF VACUUM VESSEL PROTOTYPE IS DEFINED IN CAD MODELS/FILES SE121-001P.ASM, SE121-002P.ASM, AND SE121-003P.ASM.
5. PROJECTED TOLERANCE ZONE STARTS AT INTERSECTION OF PORT AXIS AND VACUUM VESSEL OUTER SURFACE AND EXTENDS OUTWARD.
6. 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. WELD INSPECTIONS SHALL BE PERFORMED IN ACCORDANCE WITH SPECIFICATION NCSX-CSPEC-121-01-00.
7. PROFILE TOLERANCE ON OUTER VACUUM SURFACE IS BILATERAL, I.E. 0.1875 EITHER SIDE OF REFERENCE SURFACE.



ISOMETRIC VIEW



DETAIL X
SCALE: 1.00



DETAIL Y
SCALE: 1.00

WELDING ENGINEER
APPROVED _____ DATE: _____

AR		-5	WELD, FILLER METAL			5
I	F10000000NC4	FLANGE CONFLAT 10.0 O.D. NON-ROTATABLE	VARIAN VACUUM TECHNOLOGIES 121 HARTWELL AVENUE LEXINGTON, MA. 02421			4
I		TUBE 8.0 O.D. X .12 WALL	UNS N06625			3
I		PROTOTYPE VACUUM VESSEL SHELL	UNS N06625			2
I		PROTOTYPE VACUUM VESSEL SEGMENT PORT WELDMENT				1
SE121-002P	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
		NEXT ASSEMBLY	PARTS LIST			

QUALITY VERIFICATION	
MECHANICAL AND STRUCTURAL REFERENCE ORNL QA-955	
OW CLAUSE	DOCUMENTS REQUIRED
303	MATERIAL SELLER CERT
326	SPECIAL MATERIAL INSPECTION REPORT
205	MANUFACTURING, INSPECTION AND TEST PLAN
312	FIELD INSPECTION AND TEST PLAN
321	WELD AND BRACE INSPECTION REPORT
322	HEAT TREAT REPORT (INTEGRITY)
310	LEAK TEST REPORT
315	CLEANING CERT
318	DEVIATION REQUEST
319	NONCONFORMANCE REPORT
323	DIMENSIONAL REPORT
330	FUNCTIONAL TEST REPORT
100	DOCUMENTATION

RELEASED FOR FABRICATION / INSTALLATION

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

REV	DESCRIPTION	A-E	BY	CHK	SECT	DEPT	DATE	PE	REQ	DATE	ORNL	DATE	DOE	DATE	QA	CV	EC	EE	EM	IE	M	PD	SE	ST	XAD	PES

SCALE NOTED	
TOLERANCES UNLESS OTHERWISE SPECIFIED	
FRACTIONS	
XX DECIMALS	±.01
XXX DECIMALS	±.005
ANGLES	±0°15'
BREAK SHARP EDGES	.06 MAX
FINISH	UNLESS OTHERWISE SPECIFIED

DESIGN		UT-BATTELLE		OAK RIDGE NATIONAL LABORATORY	
DRW	G. H. JONES	UT-BATTELLE		managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT CONTRACT DE-AC05-00OR22725	
CHK	M. J. COLE	NATIONAL COMPACT STELLERATOR EXPERIMENT		PROJECT UNIT	
SECT		PROTOTYPE VACUUM VESSEL SEGMENT PORT WELDMENT			
DEPT		VERSION NO.	PLANT	BLDG	FL
RE		14+	Y-12	19201-2	2
CR		RELEASE LEVEL			
PJ		Fabrication			
REQ		SE121-001P			
PPPL DRFT	J. STEGEL	REV			
DRAWING APPROVALS	DATE				

SE121-001P

A