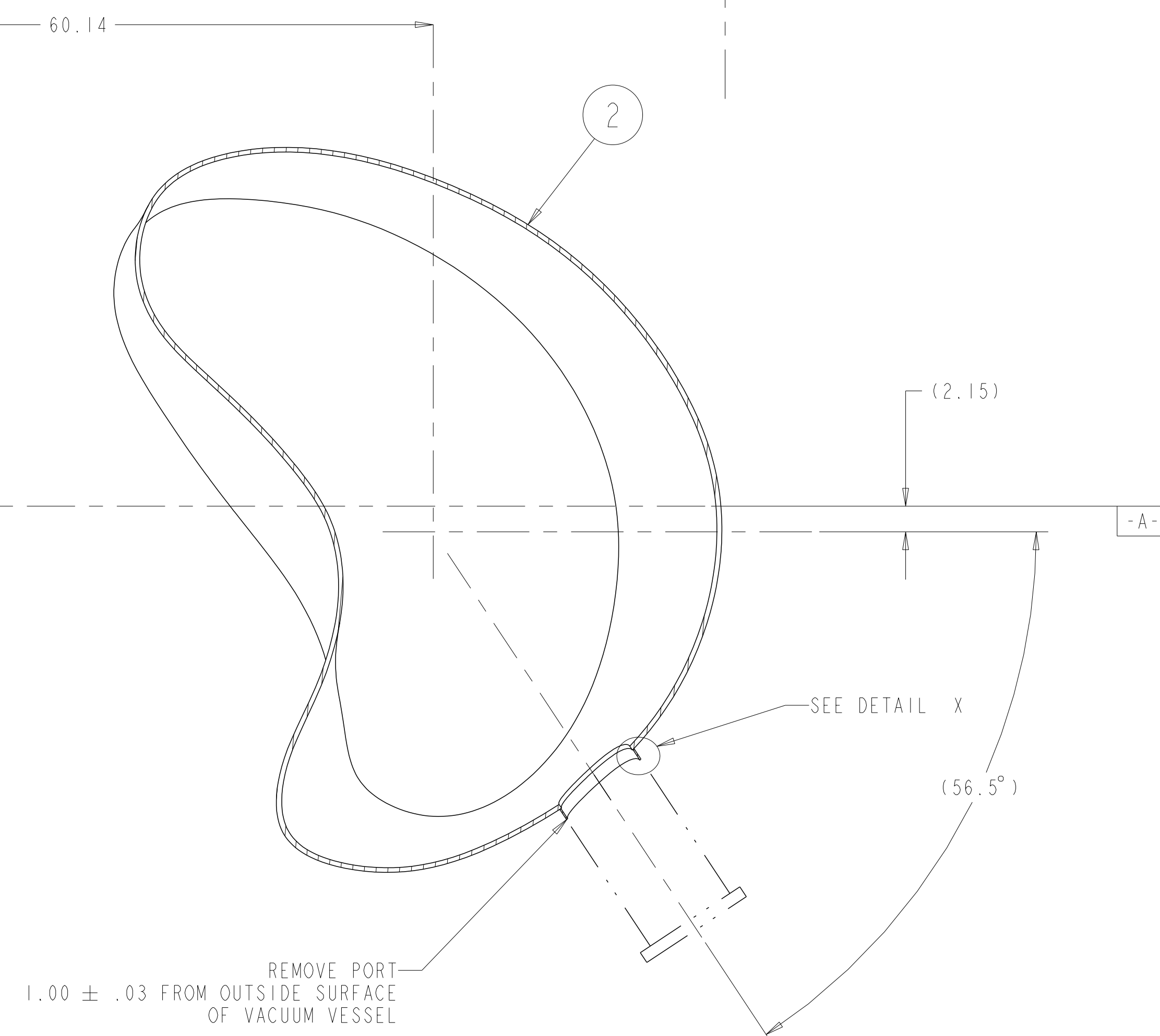
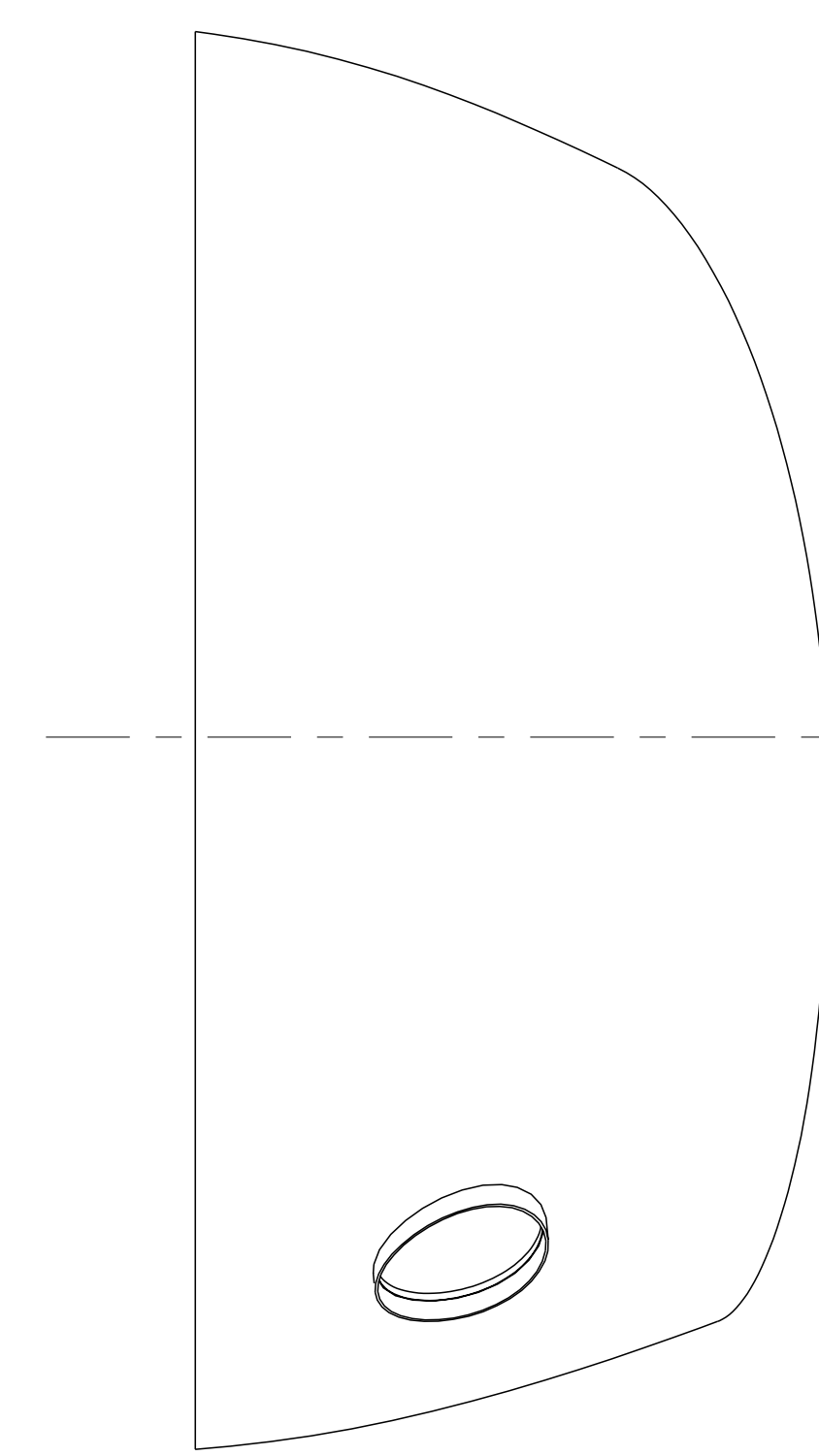
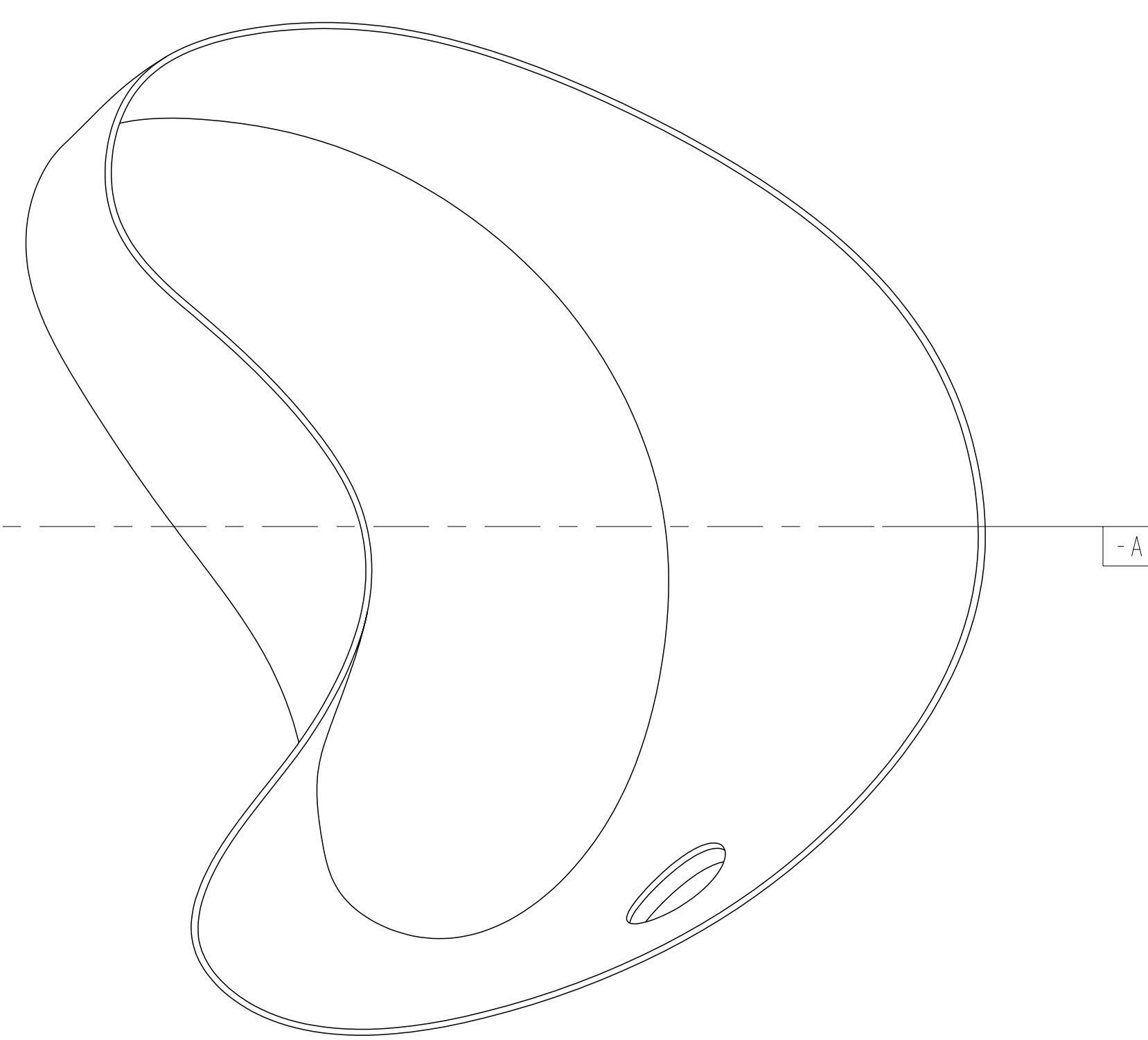
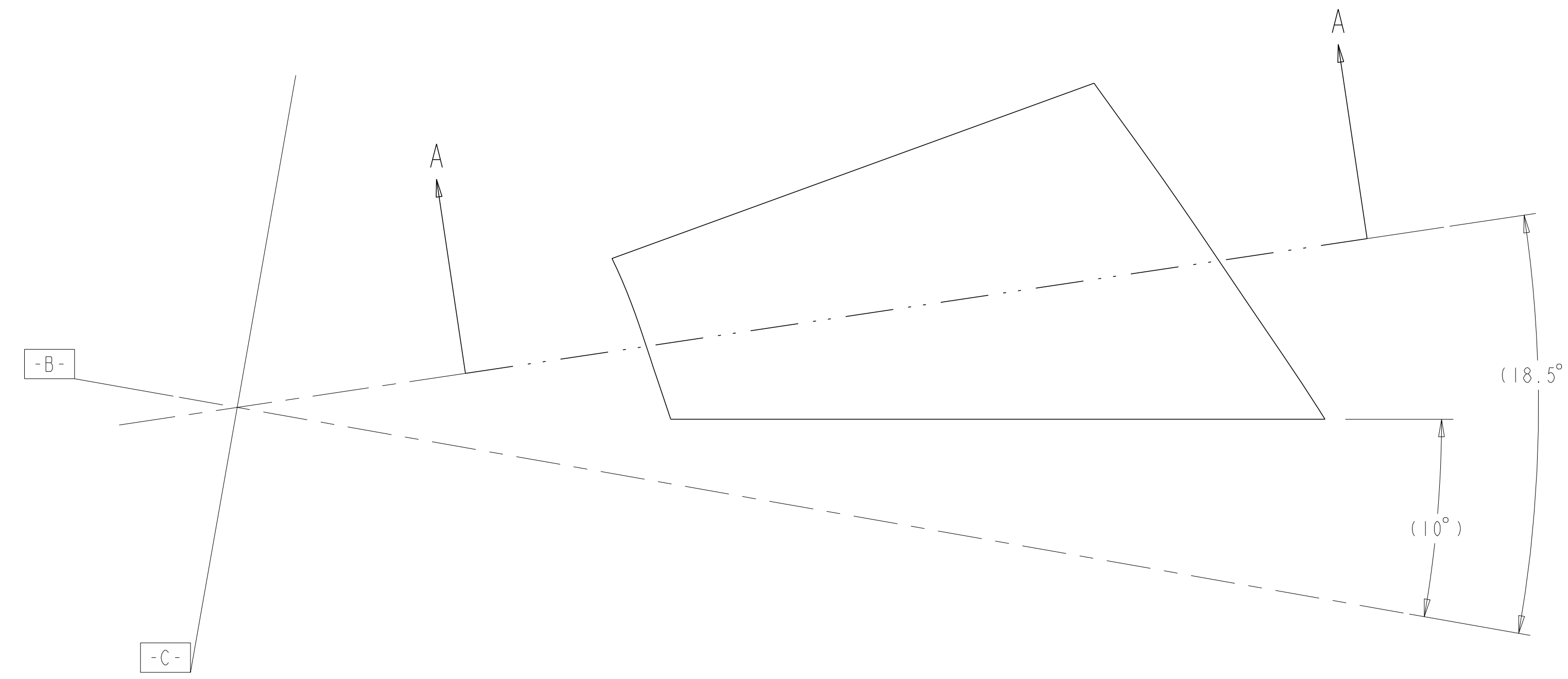


NOTES:

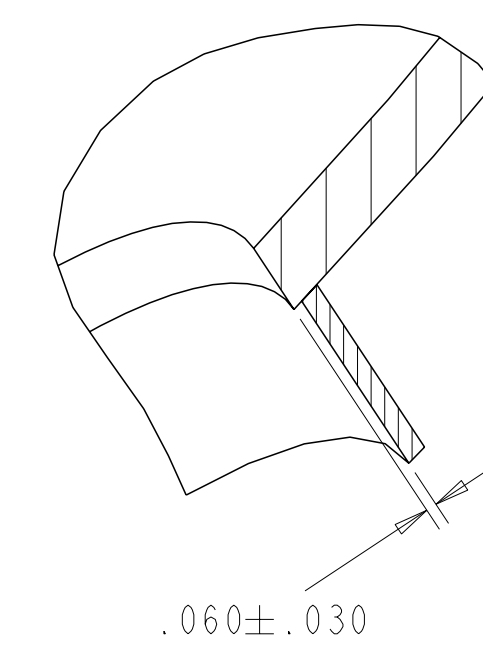
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
2. DIMENSION ARE IN INCHES.
3. REQUIREMENTS FOR FABRICATING THE VACUUM VESSEL PROTOTYPE ARE DEFINED IN THE DRAWINGS, MODELS, AND SPECIFICATION, NCSX-CSPEC-121-01-00 AND STATEMENT OF WORK, NCSX-SOW-121-01-01.
4. GEOMETRY OF VACUUM VESSEL PROTOTYPE IS DEFINED IN CAD MODELS/FILES SE121-001P.ASM, SE121-002P.ASM, AND SE121-003P.ASM.



ISOMETRIC VIEW



SECTION A-A



DETAIL X
SCALE: 1.00

SCALE: .12

AR	I	SE121-001P	PORT WELDMENT				2
SE121-003P	1	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO

QUALITY VERIFICATION		MECHANICAL AND STRUCTURAL	
OW CLAUSE DOCUMENTS REQUIRED		APPLICABLE TO PART NO	
303 MATERIAL SELLER CERT	X		
326 SPECIAL MATERIAL INSPECTION REPORT	X		
205 MANUFACTURING, INSPECTION AND TEST PLAN	X		
312 FIELD INSPECTION AND TEST PLAN	X		
321 WELD AND BRAZE INSPECTION REPORT			
322 HEAT TREAT REPORT (INTEGRITY)			
310 LEAK TEST REPORT	X		
315 CLEANING CERT	X		
318 DEVIATION REQUEST	X		
319 NONCONFORMANCE REPORT	X		
323 DIMENSIONAL REPORT	X		
330 FUNCTIONAL TEST REPORT			
100 DOCUMENTATION	X		

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	DES P.L.GORANSON
TOLERANCES UNLESS OTHERWISE SPECIFIED	DRW G.H.JONES
FRACTIONS	CHK M.J.COLE
XX DECIMALS ±.01	SECT
XXX DECIMALS ±.005	DEPT
ANGLES ±0°15'	PE
BREAK SHARP EDGES .06 MAX	CR
FINISH .125 UNLESS OTHERWISE SPECIFIED	PJ
	REQ
	PPPL DRFT J.SIEGEL
	VERSION NO.
	PLANT
	BLDG
	FL
	SHT
	OF
	TYPE
	CLASS
	U
	REV
	0

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	
PROJECT TITLE			
NATIONAL COMPACT STELLERATOR EXPERIMENT			
PROTOTYPE VACUUM VESSEL SEGMENT			
PORT MODIFICATIONS			
DETAILS			
RELEASE LEVEL	SE121-002P	REV	0