

SCALE: .250

- NOTES:**
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 2. DIMENSIONS ARE IN INCHES.
 3. FABRICATION, INSPECTION, AND TESTING SHALL BE PERFORMED IN ACCORDANCE WITH SPECIFICATION NCSX-CSPEC-121-02 AND STATEMENT OF WORK NCSX-SOW-121-03.
 4. PROFILE TOLERANCE IS BILATERAL, i.e., ±0.1875 EITHER SIDE OF REFERENCE SURFACE.
 5. LEAK CHECK ITEM -8 (REDUCING NIPPLE) IS OPTIONAL. BLANK FLANGE MAY BE SUBSTITUTED.

Rev 1-a: ECN-4972 (RFD-12-002R1) approved substitution of Schedule 10 for Schedule 40 piping – Applicable to All 3 VVSAs.

Rev 1-b: ECN-5114 (RFD-12-015) approved leaving excess stock on the face to provide additional flexibility for final setup. Accordingly, the 6.5" height and 1.0 thickness reference dimensions are considered as suggestions – Applicable to All 3 VVSAs.

ECN-5082. Requirement originally included grooves to facilitate leak checking by vendor. However, vendor elected another means of leak checking and therefore the grooves are no longer required. Specifically, this ECN eliminated the leak checking groove on SE121-014 (Rev 1-c) and SE1221-091 (Rev 0-a). Additionally, this ECN added a missing weld symbol to SE121-004 (Sheets 4 through 19) for joining the port extensions to the vessel (Rev 2-d).
(See ECN-5082 for details)

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PPPL Drafting:

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
1	ADDED NOTE 5											
2	REVISED PER ECN-4945	GHJ	2/28/05	MJC								

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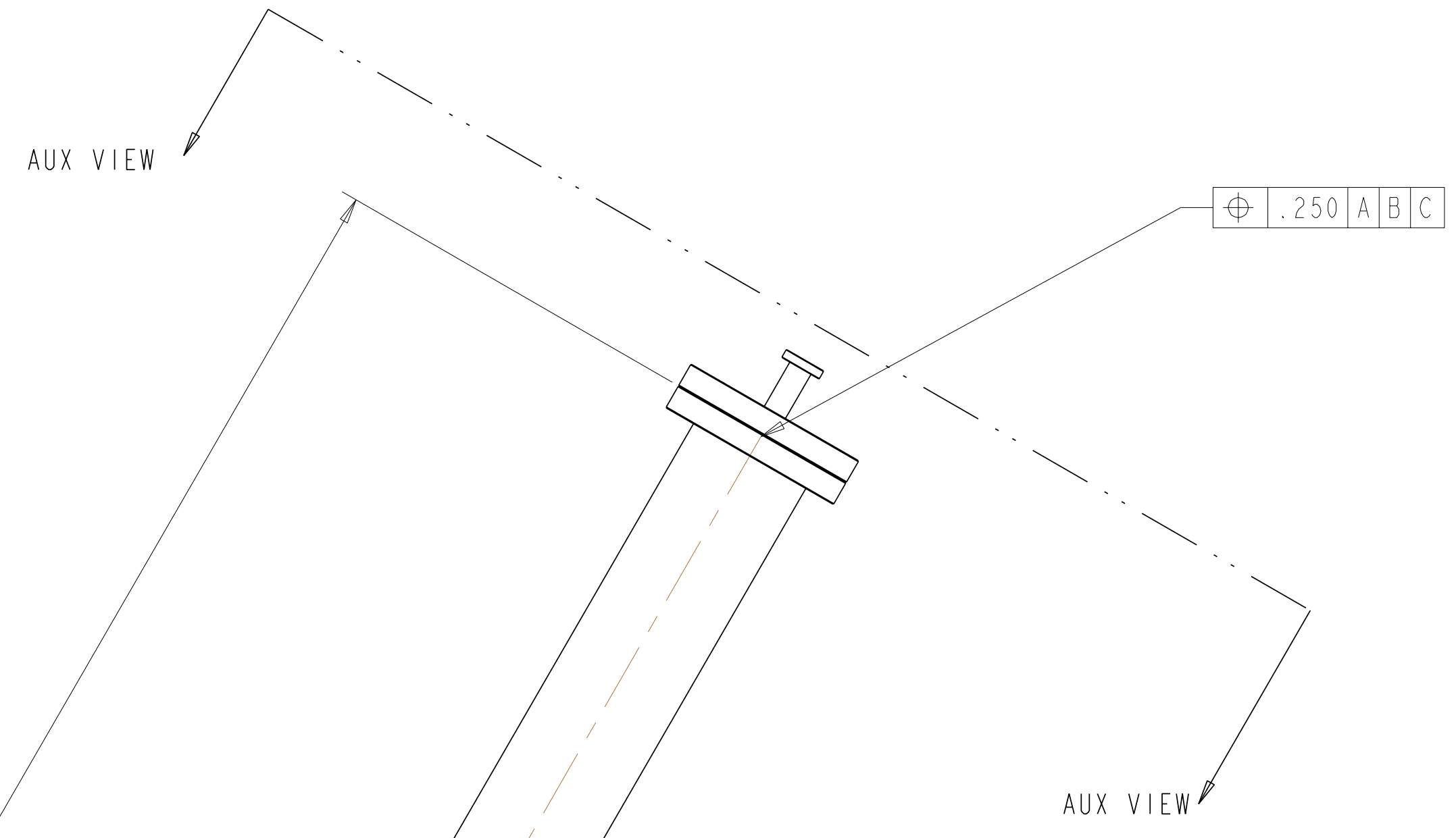
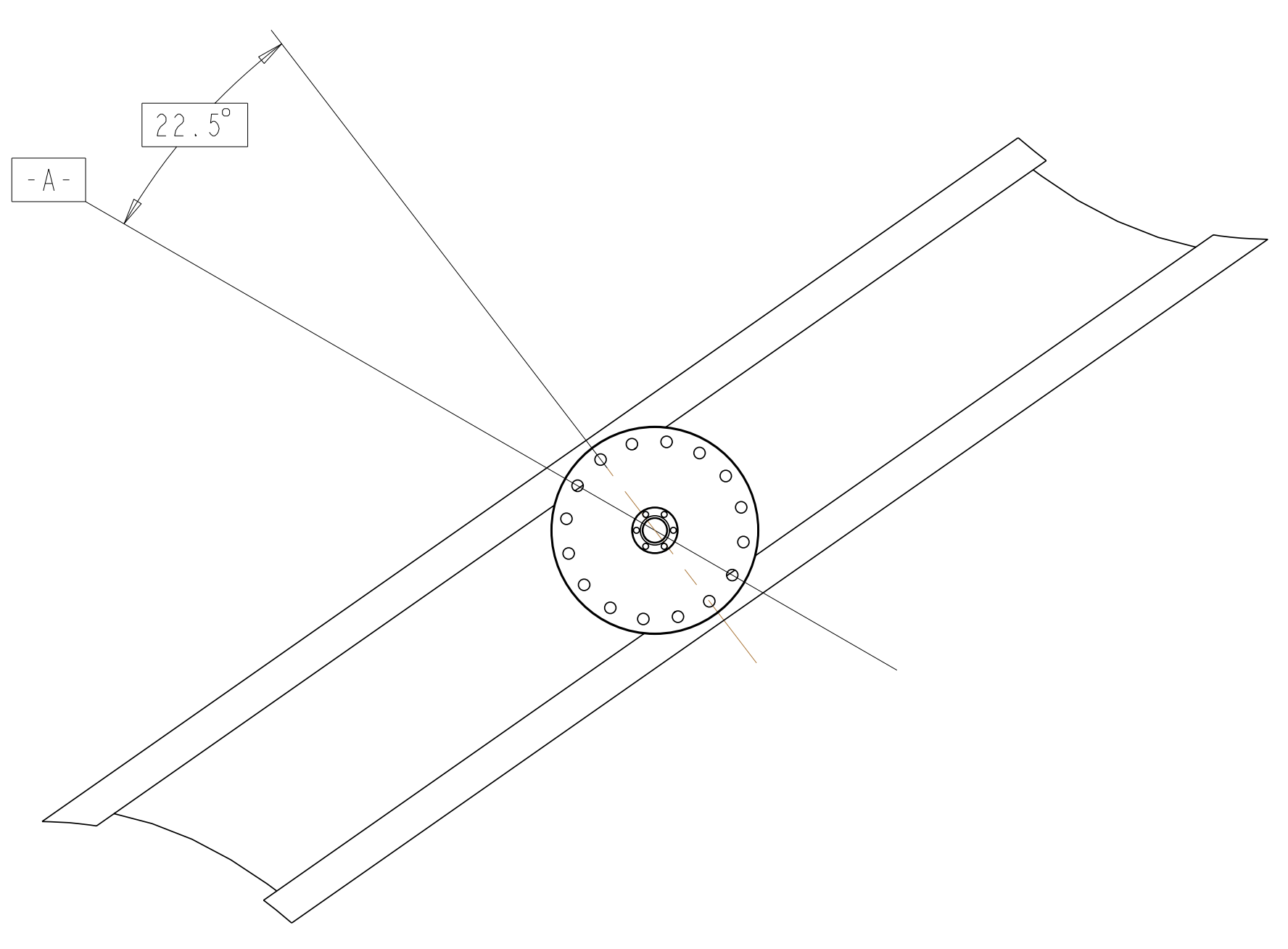
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FOR NOTES AND PARTS LIST SEE SHEET 1



99.36

⊕ .250 A B C

⌒ .375 A B C

DATUM A = PLANE THRU "XY"
 DATUM B = PLANE THRU "XZ"
 DATUM C = PLANE THRU "YZ"

(60°)

SCALE 0.250

-B-

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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 NAME							
NATIONAL COMPACT STELLARATOR EXPERIMENT							
VACUUM VESSEL SPACER WELDMENT							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
1	X-10	5700	3	2 2	S	U	
RELEASE LEVEL		SEI21-014					
Fabrication		1					

SEI21-014

A