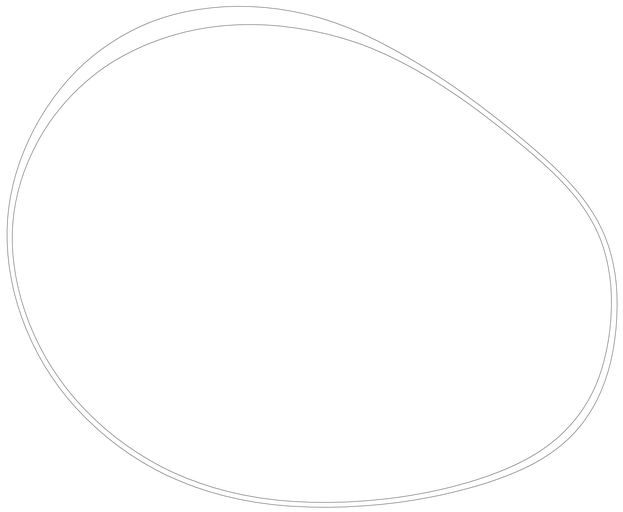
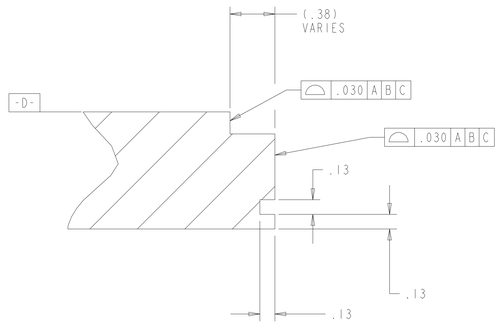
NEXT ASS'Y: FINAL ASS'Y:

NOTES:

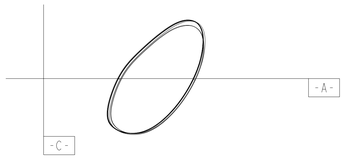
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
2. DIMENSION ARE IN INCHES.
3. PROFILE TOLERANCE IS BILATERAL, i.e. 0.015 EITHER SIDE OF REFERENCE SURFACE.
4. FABRICATION, INSPECTION, AND TESTING SHALL BE PERFORMED IN ACCORDANCE WITH SPECIFICATION NCSX-CSPEC-121-02 AND STATEMENT OF WORK NCSX-SOW-121-03.



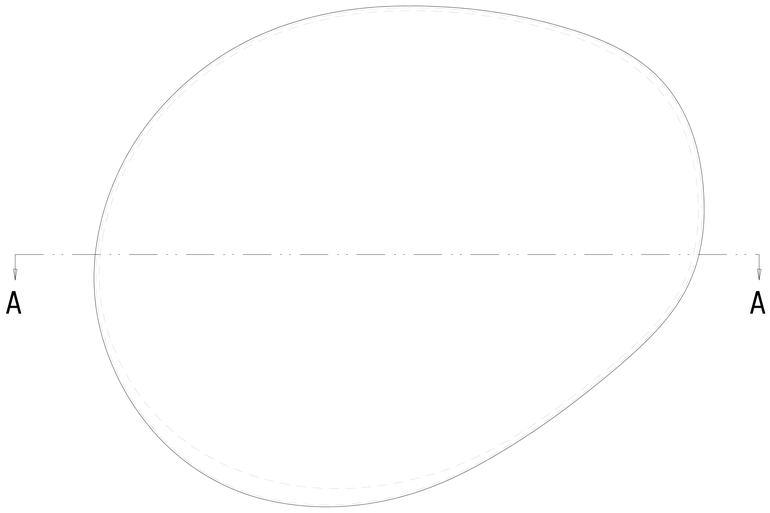


DETAIL B
SCALE 2.00

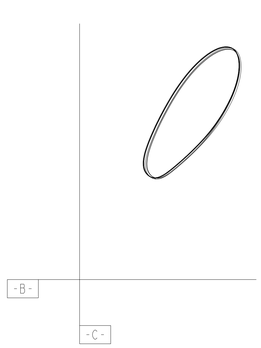
ECN-5082. Requirement originally included grooves to facilitate leak checking by vendor. However, vendor elected another means of leak checking and therefore the grooves are no longer required. Specifically, this ECN eliminated the leak checking groove on SE121-014 (Rev 1-c) and SE1221-091 (Rev 0-a) . 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)



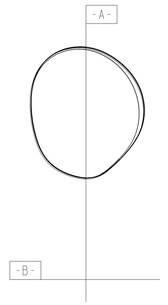
SECTION A-A



SCALE 0.25



SE121-091 IN MACHINE ORIENTATION- FROM TOP
SCALE 0.06



RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting: Jerry Siegel 2007.02.21 10:11:52 -05'00'

AR		- 1	VACUUM VESSEL SPACER BLANK OFF COVER	UNS-NO6625		1
SE120-102	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
	NEXT ASSEMBLY		PARTS LIST			

SE121-091 B

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REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
	REVISION OR ISSUE PURPOSE	REVISION APPROVAL										

SCALE AS NOTED
TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS
XX DECIMALS ±.01
XXX DECIMALS ±.005
ANGLES ±0°15'
BREAK SHARP EDGES .06 MAX
FINISH 125 UNLESS OTHERWISE SPECIFIED

DRAWING APPROVALS		DATE
DES	P. GORANSON	6/04
DRW	G. FORTIER	6/04
CHK	M. J. COLE	6/04
SECT	:	:
DEPT	:	:
PE	:	:
CR	:	:
PJ	:	:
REQ	:	:
PPPL DRFT	J. SIEGEL	6/04
	:	:
	:	:

UT-BATTELLE
Oak Ridge National Laboratory
managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-000R22725
UT-BATTELLE, LLC. Oak Ridge, Tennessee

PROJECT NAME: NATIONAL COMPACT STELLARATOR EXPERIMENT

VACUUM VESSEL
SPACER BLANK OFF COVER
DETAIL

VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS
2L	X-10	5700	3	1	1	D	U

RELEASE LEVEL: Fabrication
SE121-091
REV 0