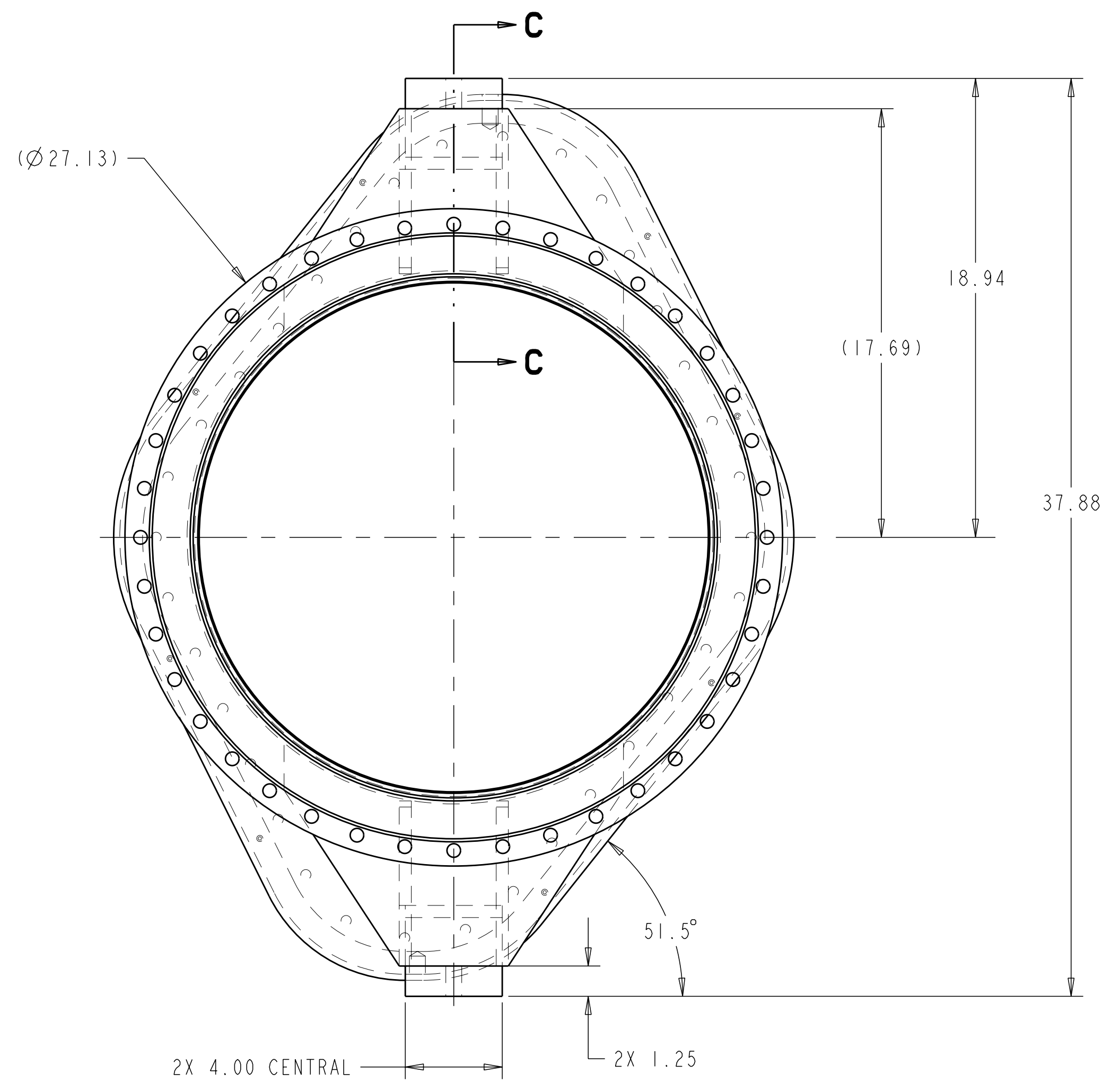
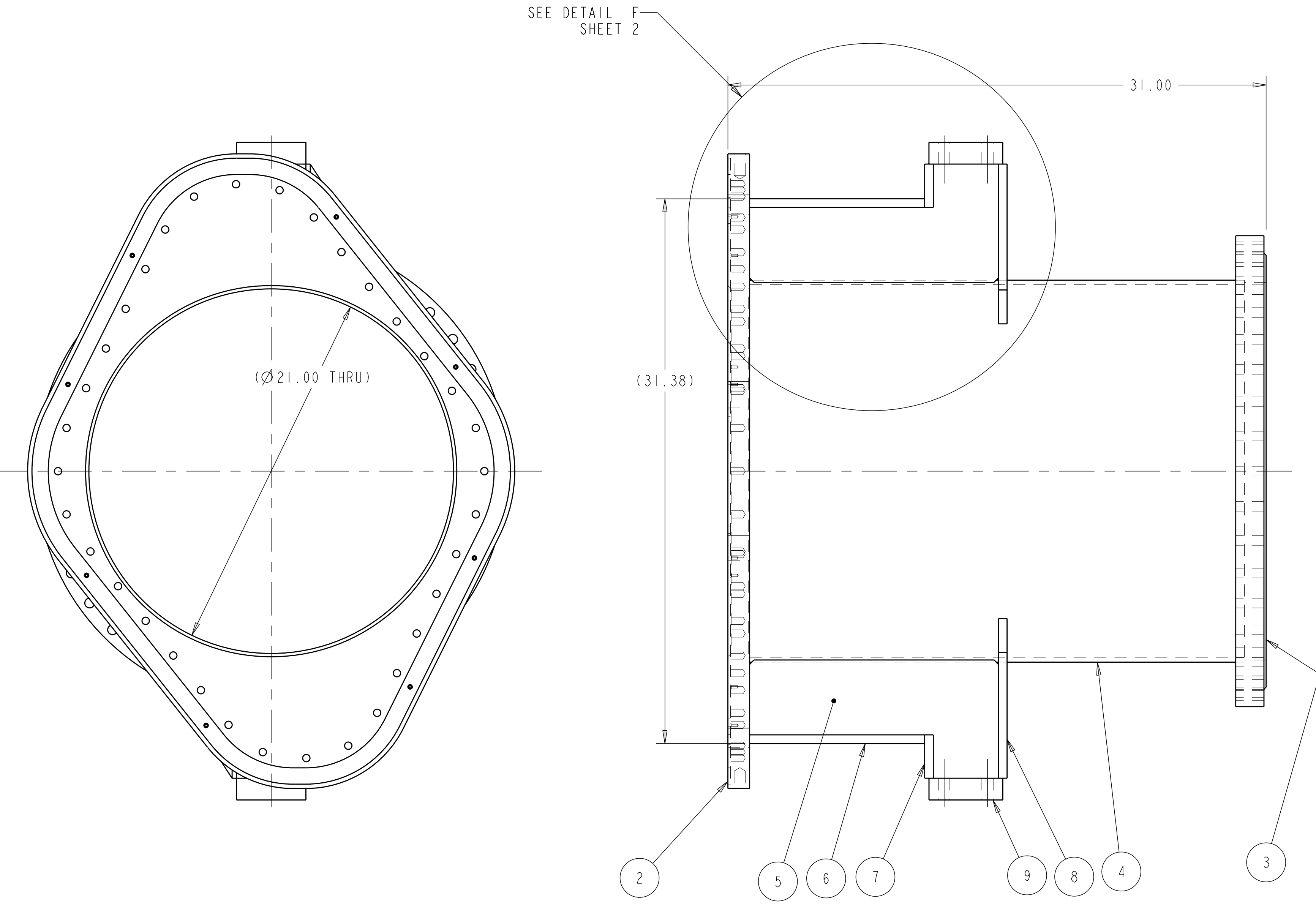
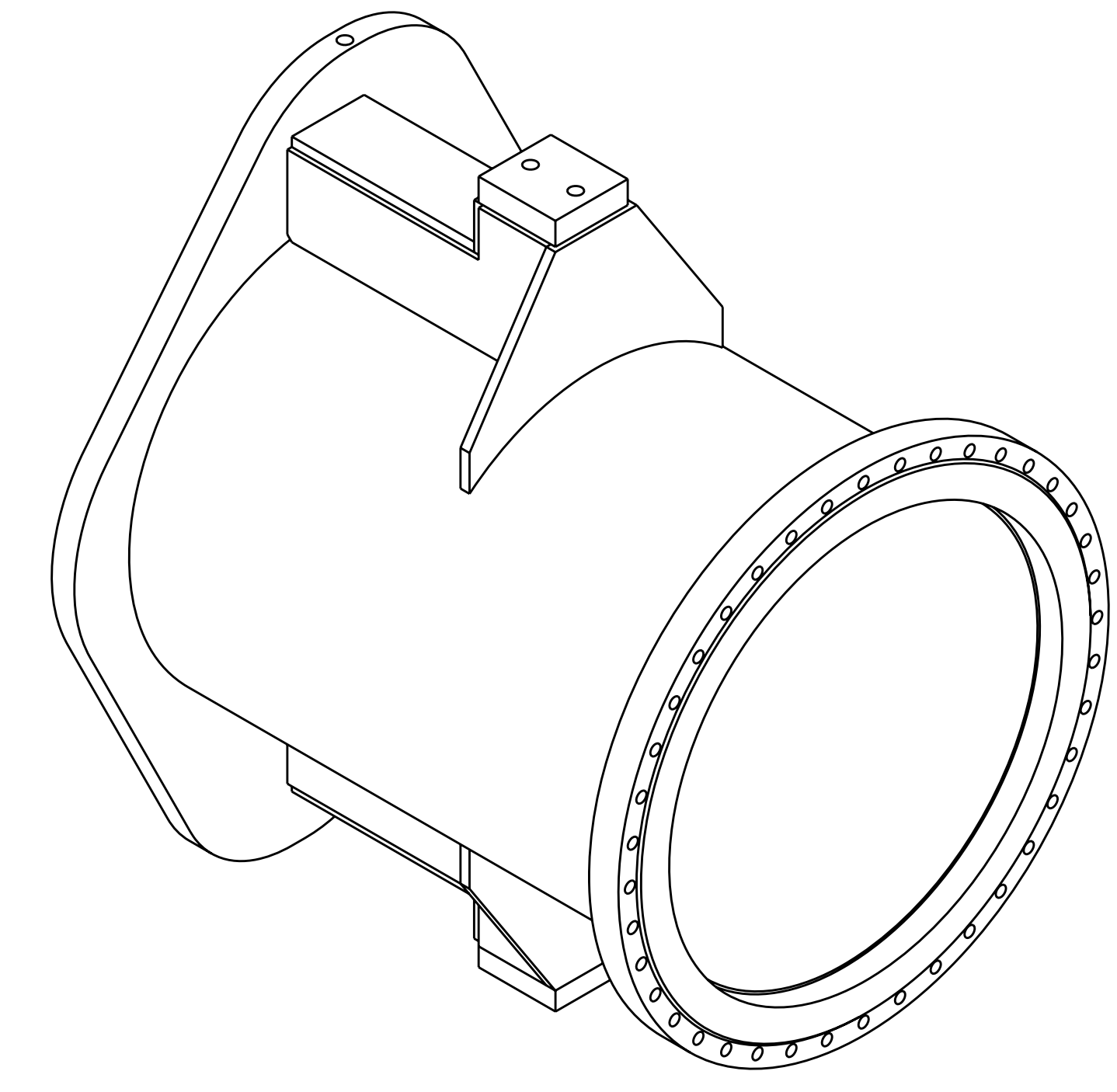
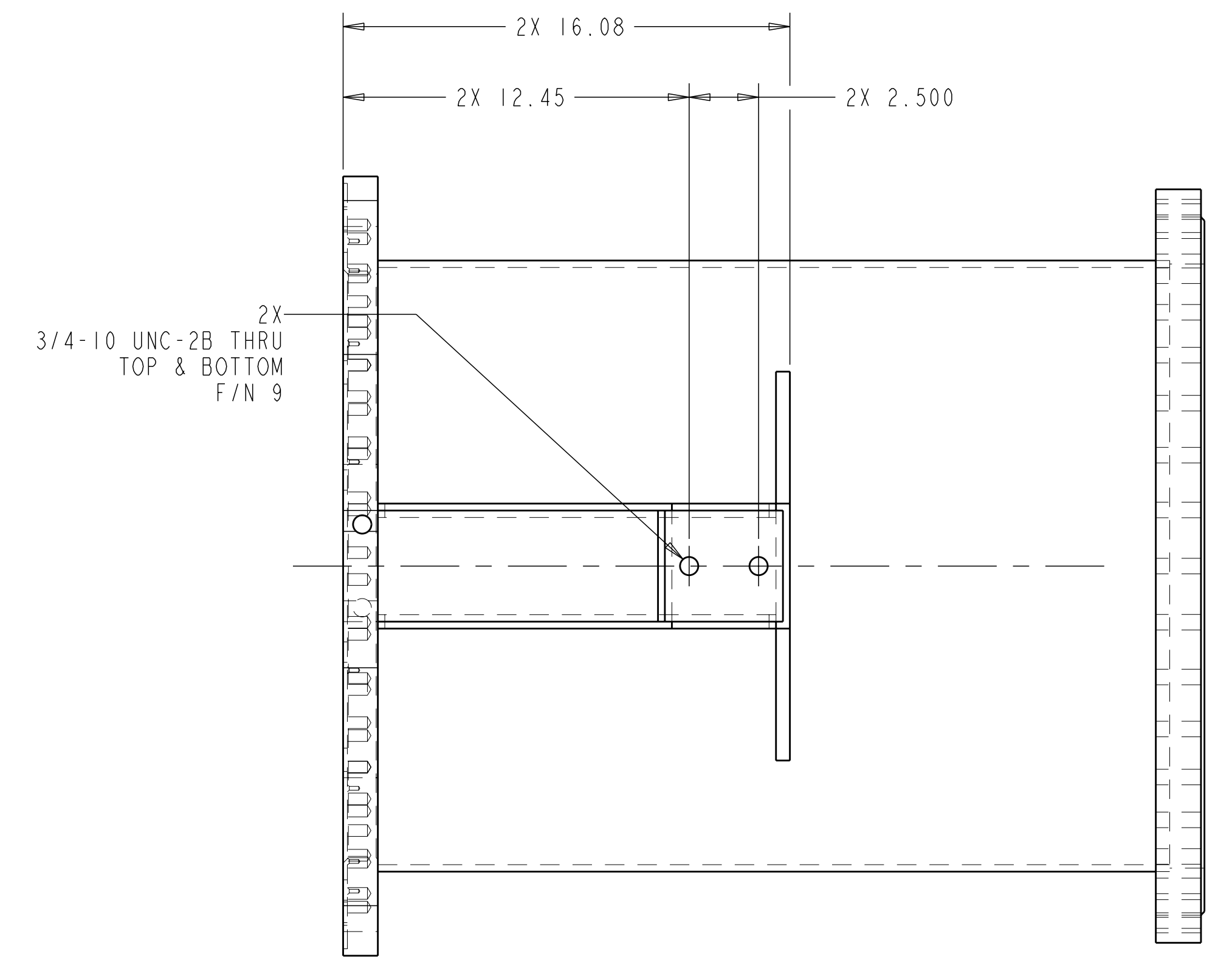


- NOTES**
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 2. DIMENSIONS ARE IN INCHES
 3. WELDING PROCEDURES AND PERFORMANCE QUALIFICATIONS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF ASME CODE, SECTION IX. WELDS MAY BE MADE BY THE GTAW OR GMAW PROCESSES. WELDS USING SMAW PROCESS ARE NOT PERMITTED.
 4. 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.



RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting:

WELDING ENGINEER
APPROVED B. KEILBACH DATE: 10/05

AR	REV	DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
	-10	WELD FILLER METAL			10
	-9	1 1/4" PLATE			9
	-8	1/2" PLATE			8
	-7	1/2" PLATE	INCONEL 625	ASTM B443	7
	-6	1/2" PLATE			6
	-5	1/2" PLATE			5
	-4	1/4" ROLLED PLATE			4
	1	SE121-133-1	MDC FLANGE MODIFICATION		3
	1	SE121-132-1	PORT COVER MODIFICATION		2
	-1	MAN HOLE PORT WELDMENT			1

PARTS LIST

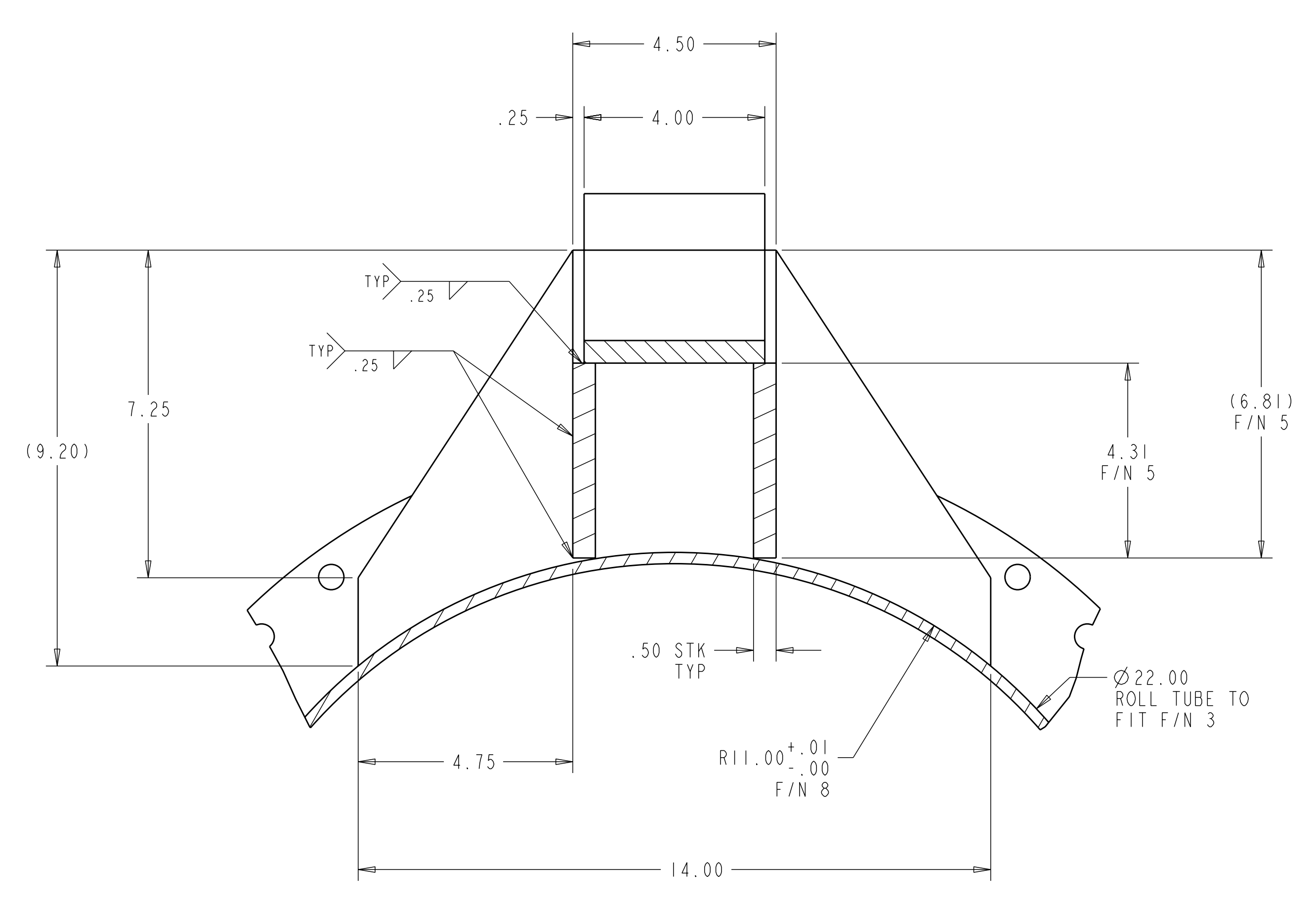
SCALE 0.25

NO REPRESENTATION OR WARRANTY, EXPRESSED OR IMPLIED, IS MADE AS TO THE ACCURACY, COMPLETENESS OR USEFULNESS OF THE INFORMATION OR STATEMENTS CONTAINED IN THESE DRAWINGS, OR THAT THE USE OR DISCLOSURE OF ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS MAY NOT INFRINGE PRIVATE RIGHTS OF OTHERS. NO LIABILITY IS ASSUMED WITH RESPECT TO THE USE OF, OR FOR DAMAGES RESULTING FROM THE USE OF, ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS. DRAWINGS MADE AVAILABLE FOR INFORMATION TO BIDDER ARE NOT TO BE USED FOR OTHER PURPOSES, AND ARE TO BE RETURNED UPON REQUEST OF THE FORWARDING CONTRACTOR.

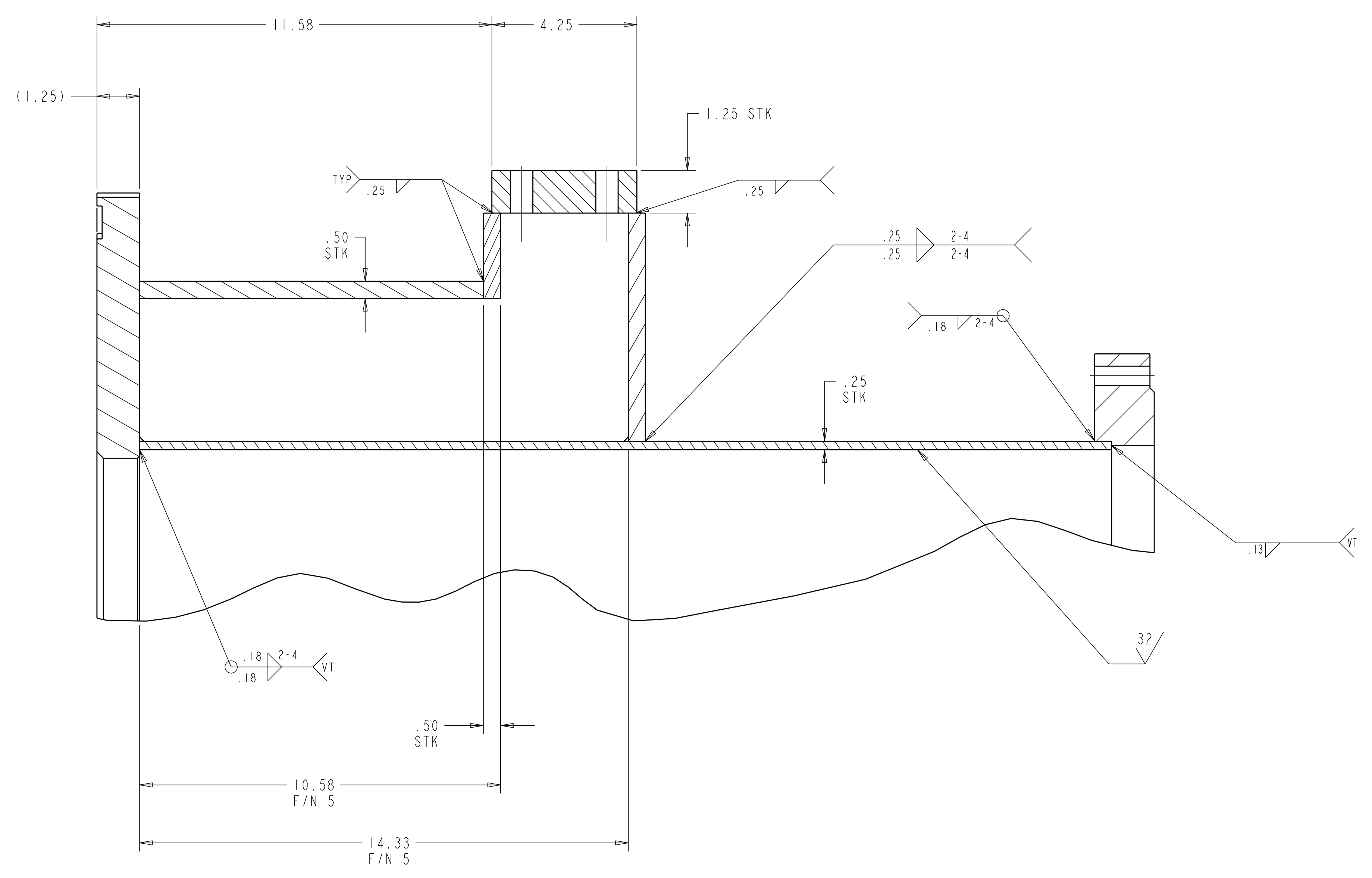
P THIS DRAWING PRODUCED ON PRO-ENGINEER

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
0	ORIGINAL ISSUE											
1	REVISION OR ISSUE PURPOSE											

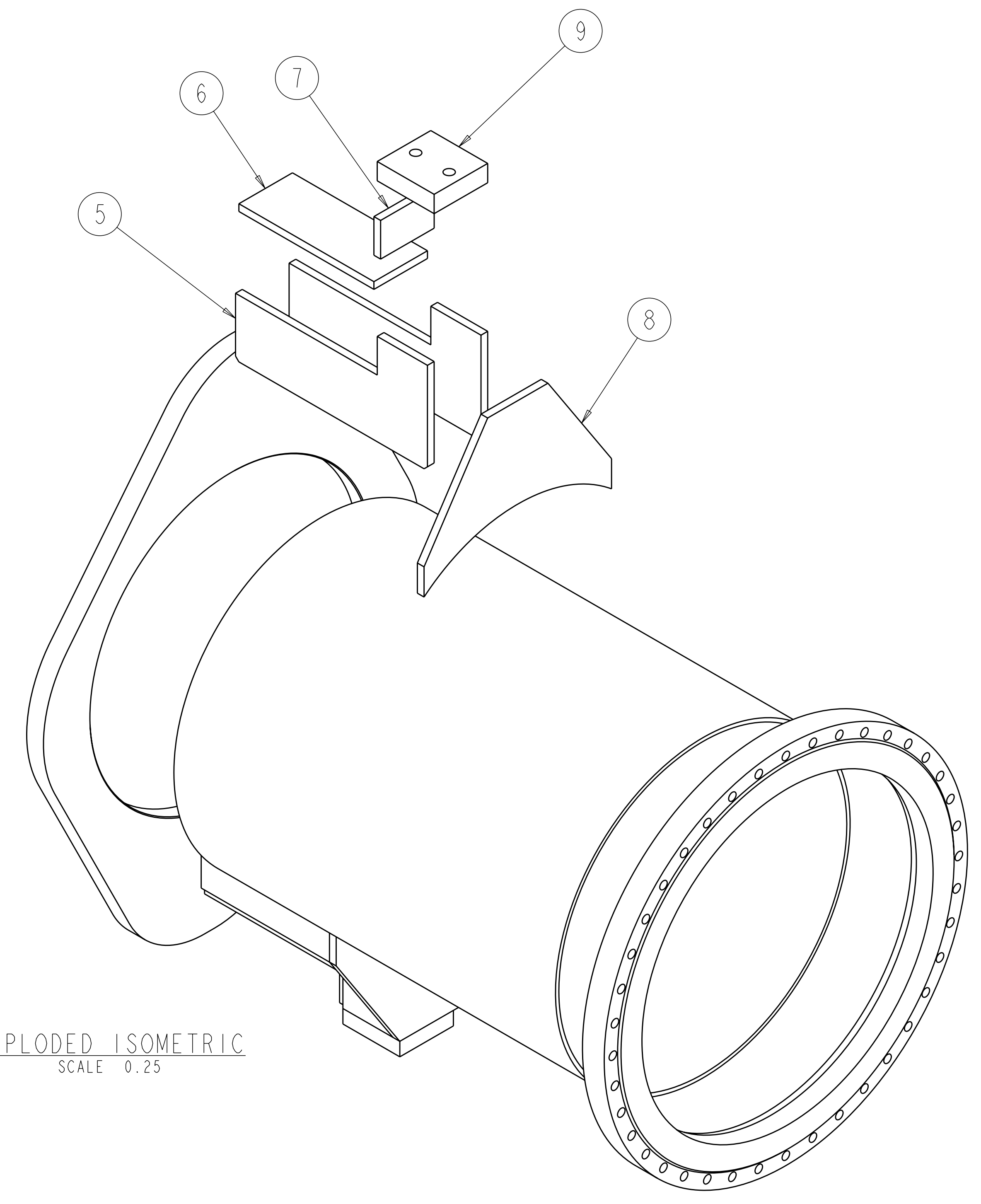
SCALE NOTED	DES BE NELSON 06/06	UT-BATTELLE	Oak Ridge National Laboratory Managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract # AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee
TOLERANCES UNLESS OTHERWISE SPECIFIED	DRW MT BROWN 06/05	PROJECT NAME	
FRACTIONS ±1/32	CHK D.B. RAINEY 08/05	NATIONAL COMPACT STELLARATOR EXPERIMENT	
XX DECIMALS ±.03		MAN HOLE PORT WELDMENT	
XXX DECIMALS ±.005		PPPL DRFT J SIEGEL 10/05	VERSION NO. 2
ANGLES ±0°15'			PLANT ORNL
BREAK SHARP EDGES .06 MAX			BLOG 5700
FINISH ±.025 UNLESS OTHERWISE SPECIFIED			FL 3
			SHT OF 2
			TYPE B
			CLASS U
			REV 0



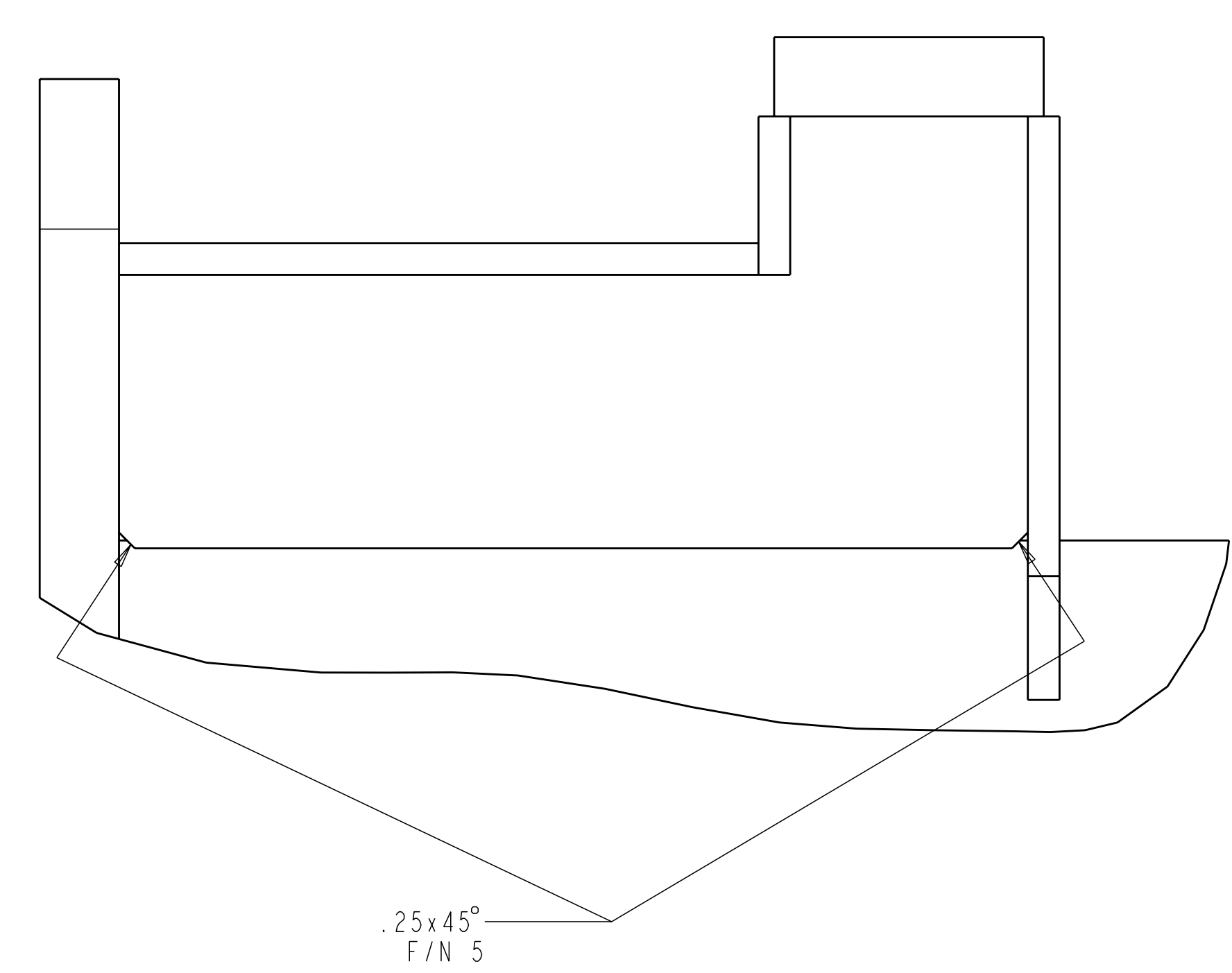
SECTION E-E
SCALE 0.50



SECTION C-C
SCALE 0.50



EXPLODED ISOMETRIC
SCALE 0.25



DETAIL F
SCALE 0.500

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

UT-BATTELLE		Oak Ridge National Laboratory Managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract #F40500-92-21725			
NATIONAL COMPACT STELLARATOR EXPERIMENT		PROJECT NAME			
MAN HOLE PORT WELDMENT		PROJECT NAME			
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE CLASS
1	ORNL	5700	3	2	2 B U
RELEASE LEVEL	Fabrication		SEI21-131		REV 0