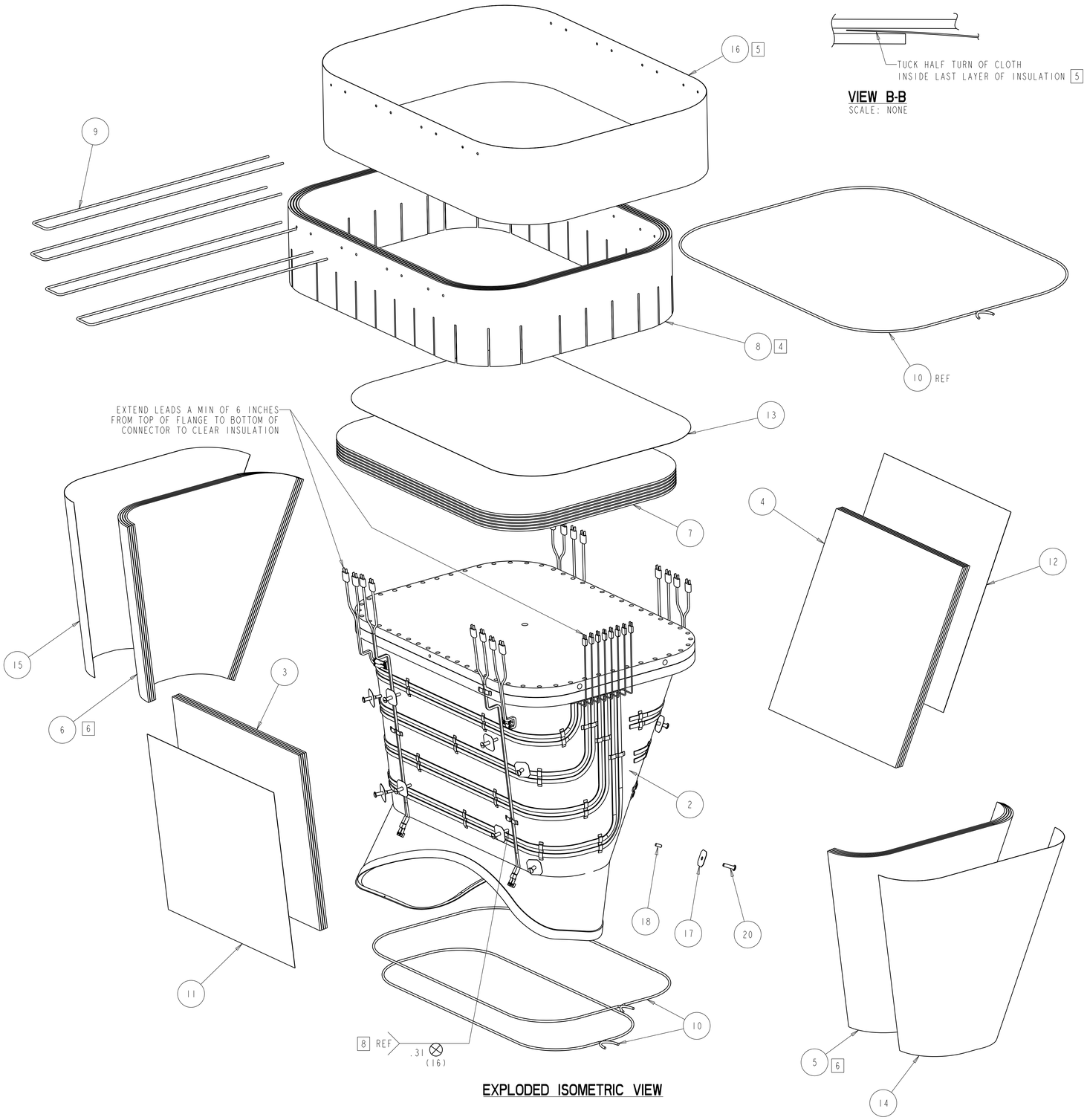
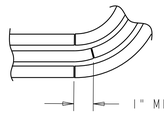


EXPLODED ISOMETRIC VIEW

VIEW B-B
SCALE: NONE

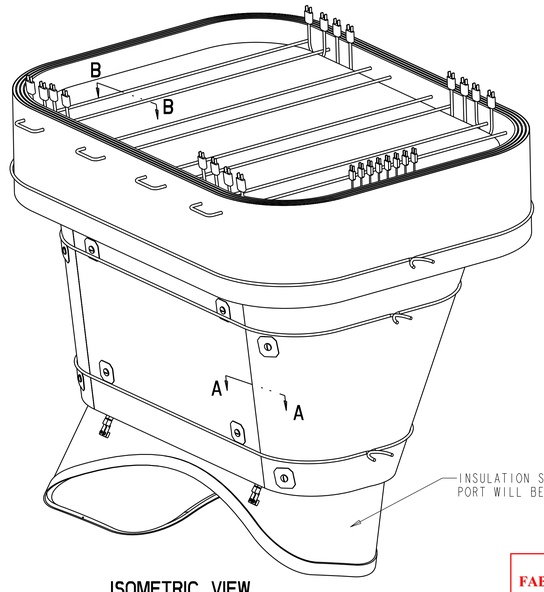


BLANKETS, F/N 3, 4 ARE OVERSIZE TO ALLOW STAGGERED LAPPING TO PREVENT OPEN SEAMS. TRIM TO FIT

SECTION A-A
SCALE: NONE

NOTES

1. DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.100-2004.
2. INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M-1994.
3. DIMENSIONS ARE IN INCHES
4. SLIT INSULATION, F/N 8, AS REQ'D TO AID IN FORMING OVER FLANGE.
5. TUCK 1/2 TURN OF CLOTH, F/N 16, PRIOR TO COVERING ENTIRE BLANKET, F/N 8.
6. TRIM BLANKETS TO FIT AT EACH LAYER DUE TO THICKNESS INCREASE.
7. NOT SHOWN; CONSUMABLE FOR STUD WELDING PROCESS.
8. WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF ASME B31.3.
9. MAGNETIC PERMEABILITY NOT TO EXCEED 1.02 AS TESTED BY A SEVERN INDICATOR. AVAILABLE FROM:
   SEVERN ENGINEERING
   AUBURN, ALABAMA 36830
   WWW.SEVERNENGINEERING.COM



INSULATION SURROUNDING LOWER SECTION OF PORT WILL BE FILLED AT ASSY SE100-001

ISOMETRIC VIEW

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting: Jerry Siegel 2007.01.09 11:58:46 -05'00'

	16	16		Z4150SS	5/16- 18 UNC X 1 BARREL BOLT	300 SERIES SST	ACCURATE MFG PRODUCTS INC INDIANAPOLIS, IN 46278 317-472-9000 WWW.ACCURATEMFG.COM	20
7	16	16		009-689	5/16 FERRULE	CERAMIC	STUD WELDING COMPANY MOORESTOWN, NJ 08057 800-523-5092	19
	16	16		006-932	5/16-18 UNC X .75 CD WELD STUD	SST		18
	16	16		SE122-083-1	INSULATION RETAINER			17
	1	1			NOMEX CLOTH	200 X 10	NCSX-PRL-12-001	16
	1	1				34 X 26		15
	1	1				34 X 26		14
	1	1				40 X 29		13
	1	1				26 X 26		12
	1	1				26 X 23.75		11
	AR	AR			WIRE TIE Ø.05	316L SST ANEALED	ASTM A313	10
	4	4			CAP RETAINING STAPLE Ø.12 WIRE, 36" LEGS, 3" CENTERS			9
	8	8			PYROGEL FLANGE BLANKET	140 X 10 X .25 THK	NCSX-PRL-12-004	8
	8	8			PYROGEL CAP BLANKET	40 X 29 X .25 THK		7
6	8	8			PYROGEL PORT BLANKET	34 X 26 X .25 THK		6
6	8	8				34 X 26 X .25 THK		5
	8	8				28 X 26 X .25 THK		4
	8	8				28 X 23.75 X .25 THK		3
	1			SE123-156-2	PORT 4B EXTENTION WITH HEAT TAPE AND THERMOCOUPLE ASSY			2
		1		SE123-156-1	PORT 4A EXTENTION WITH HEAT TAPE AND THERMOCOUPLE ASSY			2
AR	X			-2	PORT 4B INSULATION ASSEMBLY			1
AR		X		-1	PORT 4A INSULATION ASSEMBLY			1
SE100-002	-2	-1	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
			← NEXT ASSEMBLY		PARTS LIST			

SE122-082

-1, -2 PORT 4 INSULATION ASSEMBLY
SCALE 0.188

WELDING ENGINEER
APPROVED G. GETTELFINGER DATE: 01/2007

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
0	ORIGINAL ISSUE	GWM	01/07	SP		01/07						

REVISION OR ISSUE PURPOSE — REVISION APPROVAL

SCALE 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 PL GORANSON	01/07
DRW G MCGINNIS	01/07
CHK S PARSON	01/07
SECT :	:
DEPT :	:
PE :	:
CR :	:
PJ :	:
REQ :	:
PPPL DRFT J SIEGEL	01/07
:	:
:	:

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

PORT 4 INSULATION ASSEMBLY

VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS
9	ORNL	5700	3	1	1	A	U

RELEASE LEVEL: Fabrication
SE122-082
REV 0

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