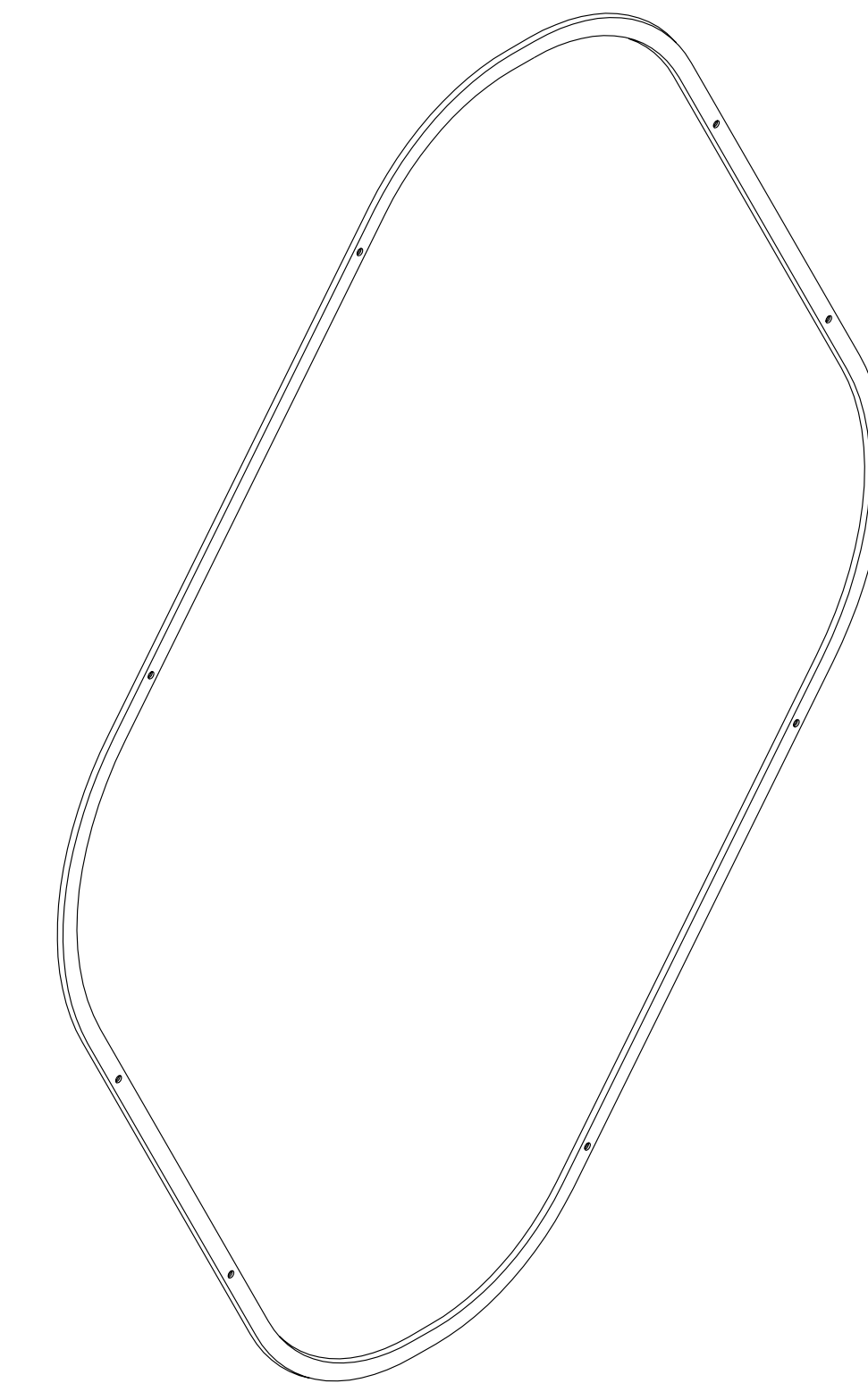
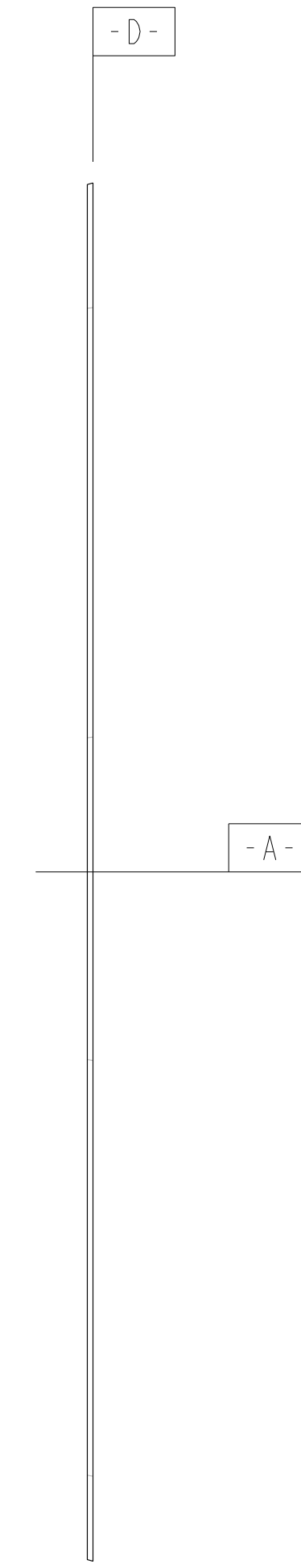
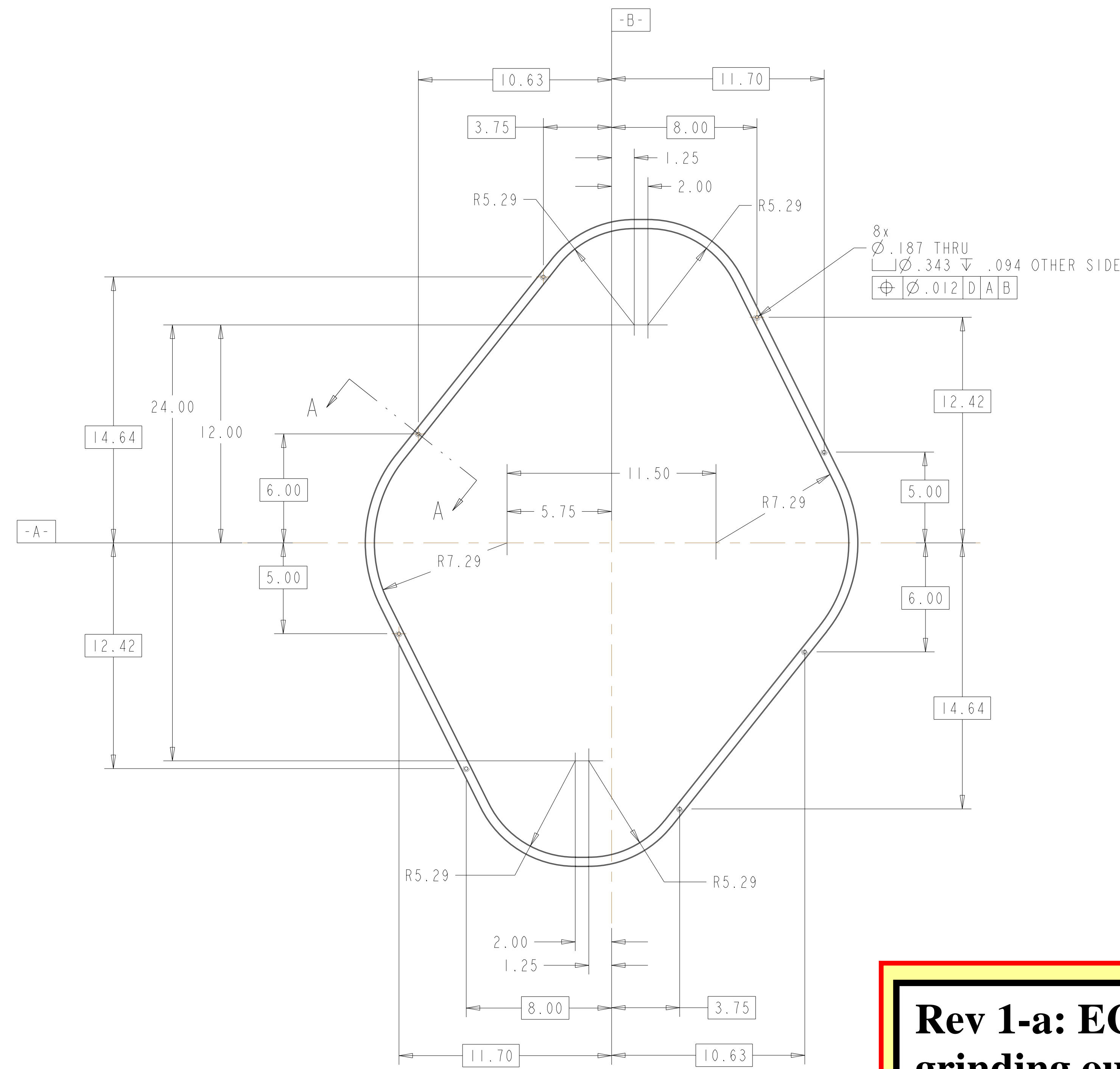
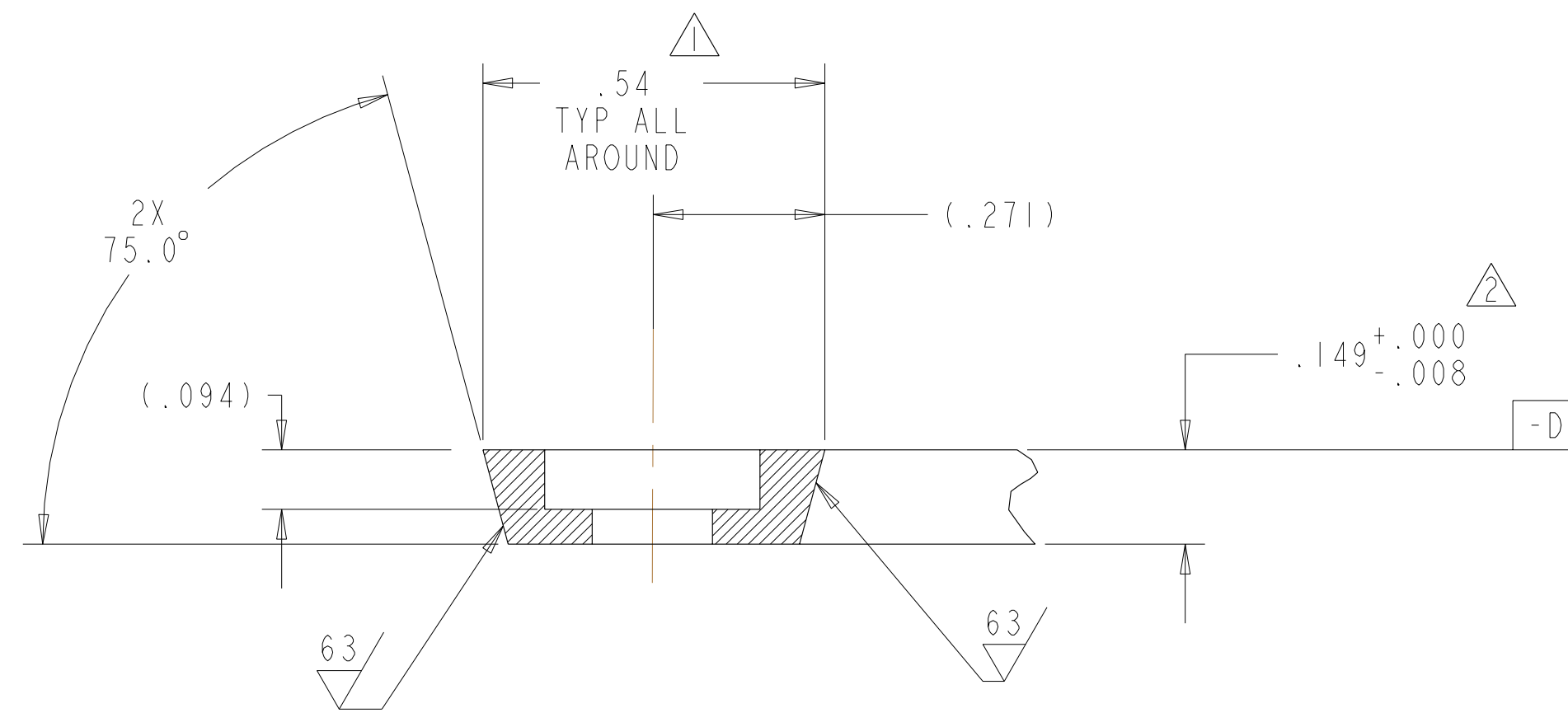


- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M
  2. DIMENSIONS ARE IN INCHES
  3. FABRICATION, INSPECTION, AND TESTING SHALL BE PERFORMED IN ACCORDANCE WITH SPECIFICATION NCSX-CSPEC-121-02 AND STATEMENT OF WORK NCSX-SOW-121-03.



ISOMETRIC VIEW



SECTION A-A  
SCALE 4.00

**Rev 1-a: ECNs-5067 & 5117 (RFD-12-010) approved grinding outside profile (maintaining the angle and surface finish) inward to reduce interference created by undersized metal o-ring. Radii may be completely cut off if needed. Bevel may be ground as needed. Retainers are only to assist in assembly. Tongue depressors may even be used to temporarily hold seals in place in lieu of retainer until flange cover is installed and compresses seal enough to hold in place. – Applicable to All 3 VVSAs.**

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

SCALE: 0.25

next assy	AR	CAGE CODE	PART OR IDENTIFYING NO	PORT NB SEAL RETAINER DETAIL	UNS N06625	MATERIAL	SPECIFICATION	FIND NO
	SE120-004							

← NEXT ASSEMBLY

PARTS LIST

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
1	REVISED PER ECN-4933	MJC	11/02/04	PLG								
2	TOLERANCE WAS +.000 -.003											
3	DIMENSION WAS 0.541											

SCALE	NOTED	DES	P. GORANSON	5-27-04
		DRW	G LOVETT	5-27-04
		CHK	D SPARKS	6-03-04
		SECT		
		DEPT		
		PE		
		CR		
		PJ		
		REQ		
		PPPL DRFT	J SIEGEL	6/04
		VERSION NO.	0	
		PLANT	X-10	
		BLDG	5700	
		FL	3	
		SHT OF	1	
		TYPE	I	
		CLASS	S	
		REV	U	
		RELEASE LEVEL		
		Fabrication		
		DRAWING APPROVALS		
		DATE		

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  
 PORT NB SEAL RETAINER  
 DETAIL  
 SE122-173