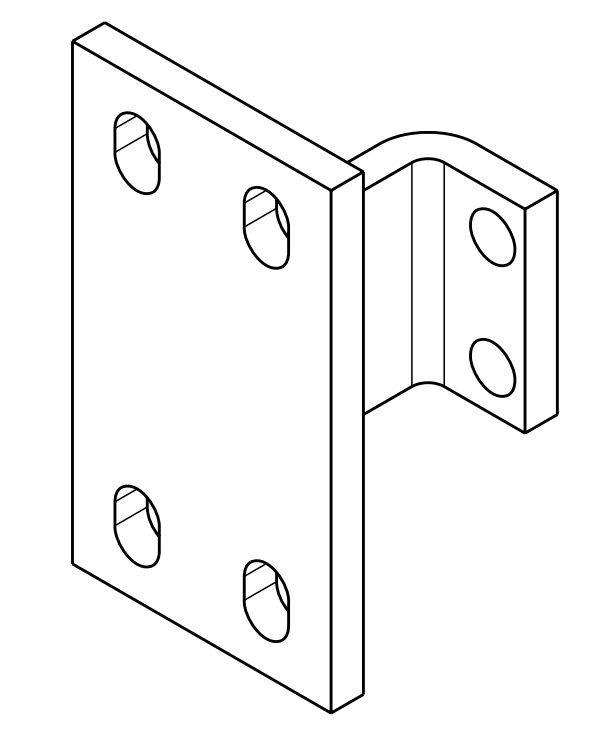
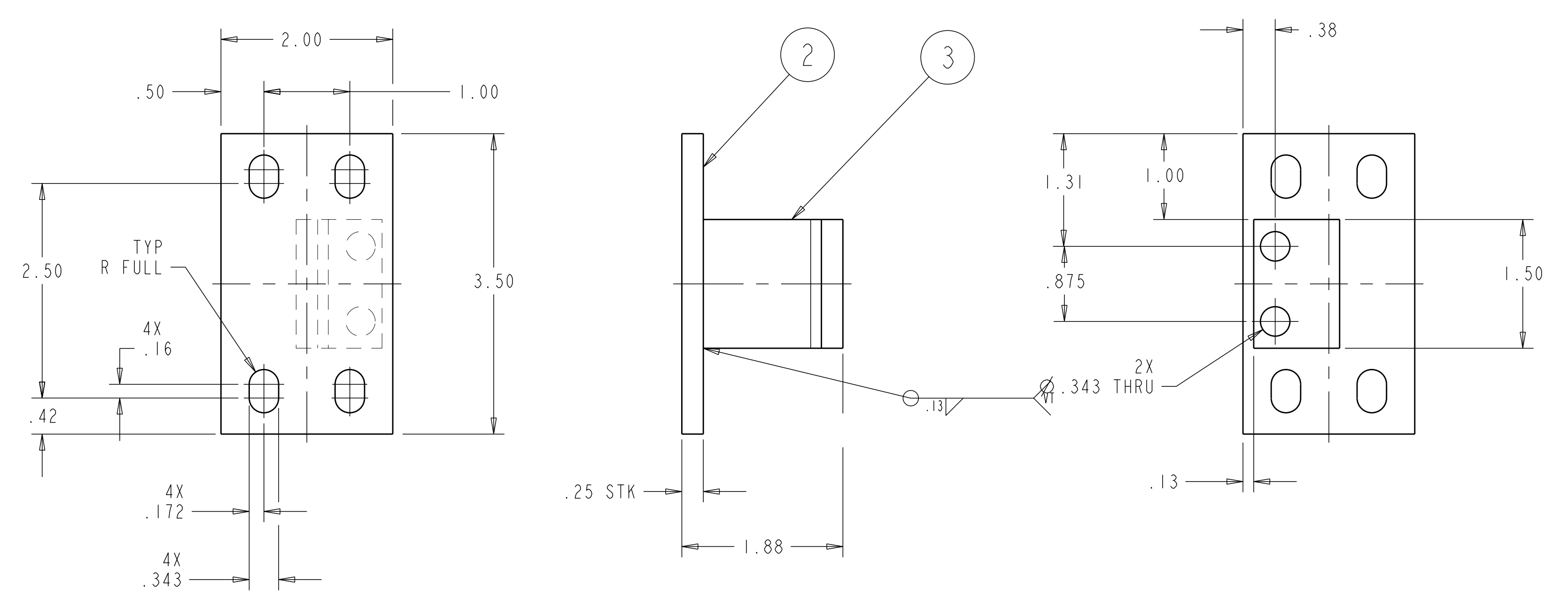
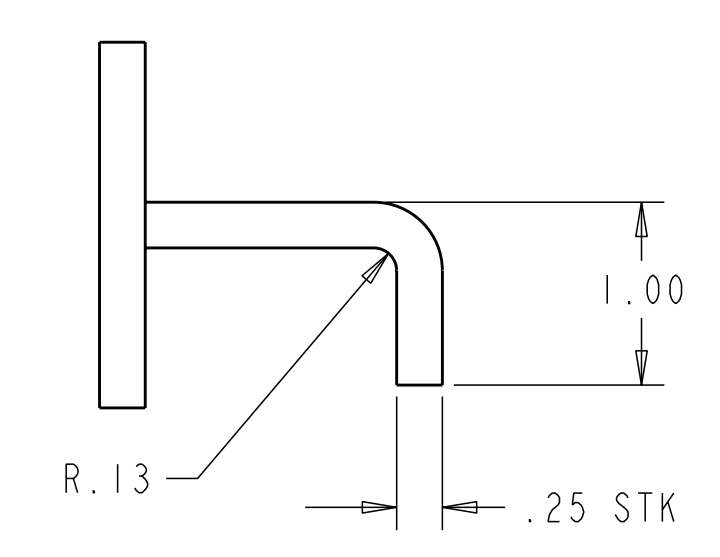


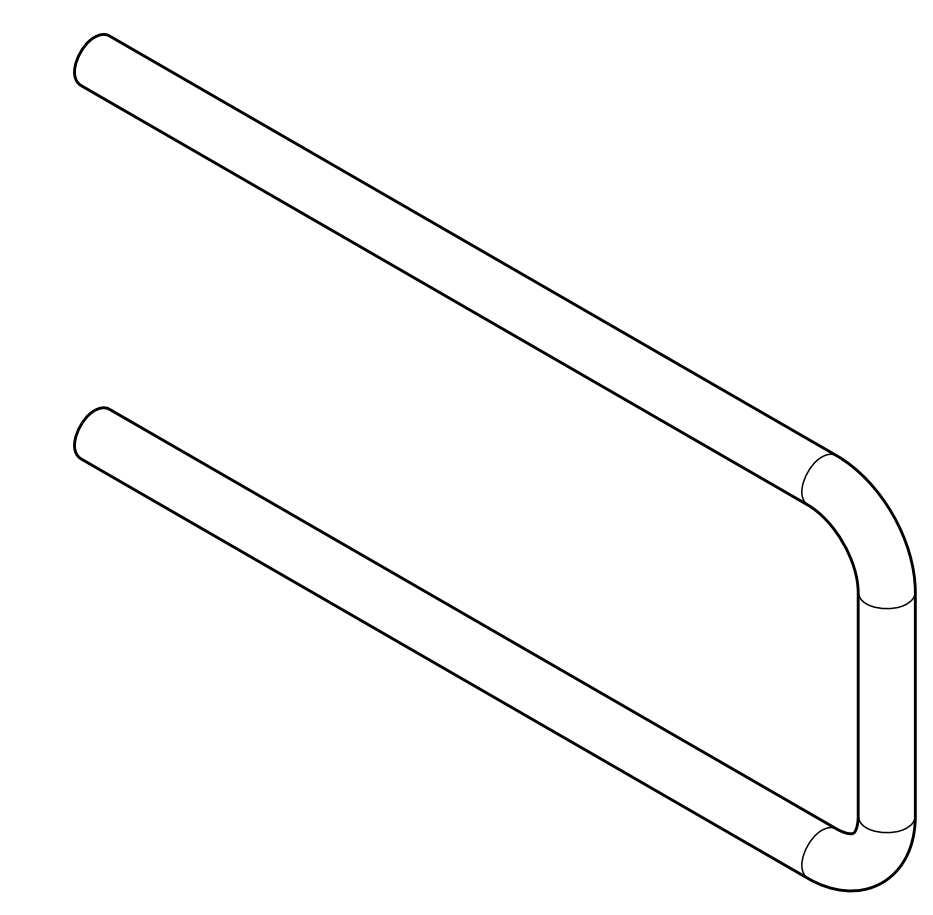
- NOTES**
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 2. DIMENSIONS ARE IN INCHES
 3. WELDING PROCEDURES AND PERFORMANCE QUALIFICATIONS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF ASME CODE, SECTION IX. WELDS MAY BE MADE BY THE GTAW OR GMAW PROCESSES. WELDS USING SMAW PROCESS 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 IS GIVEN IN AWS D1.6, PARAGRAPH 6.29.1.



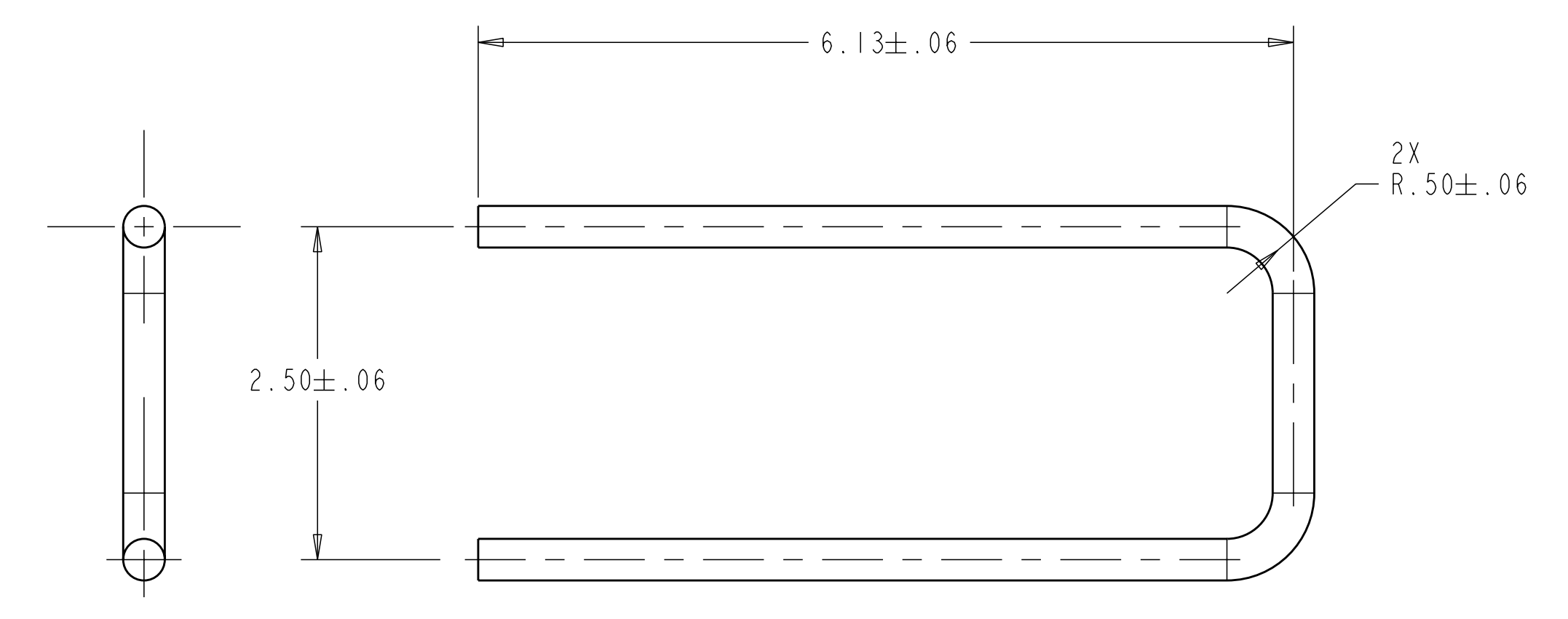
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SCALE 1.00



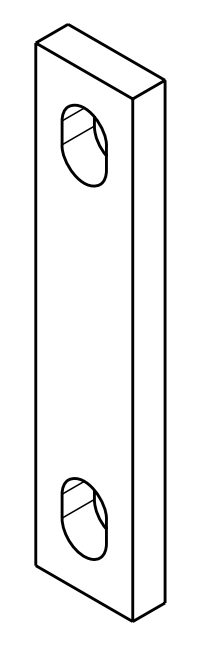
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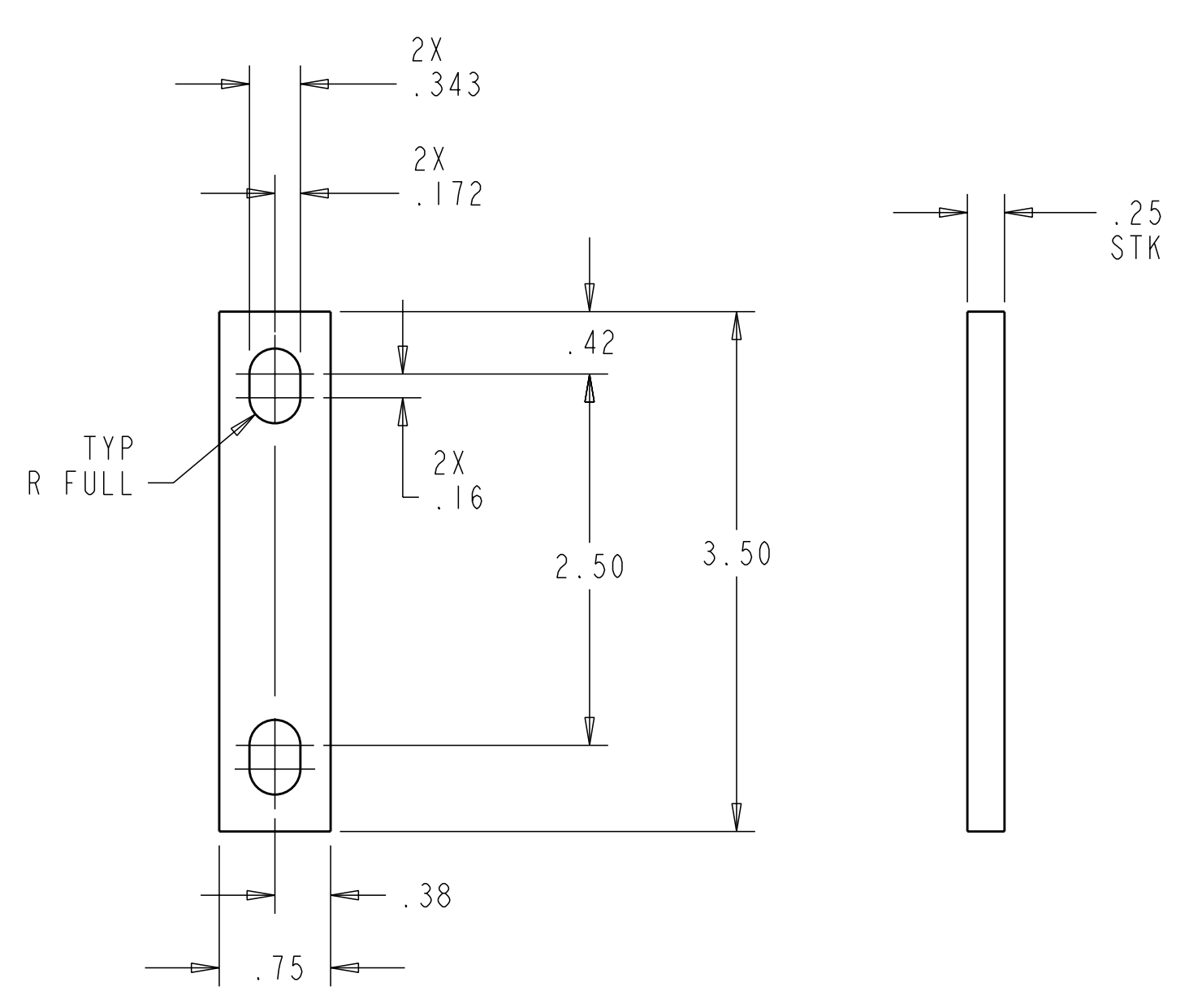
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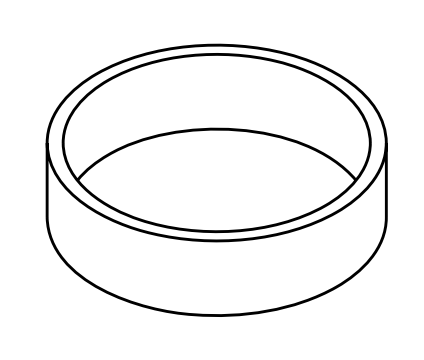
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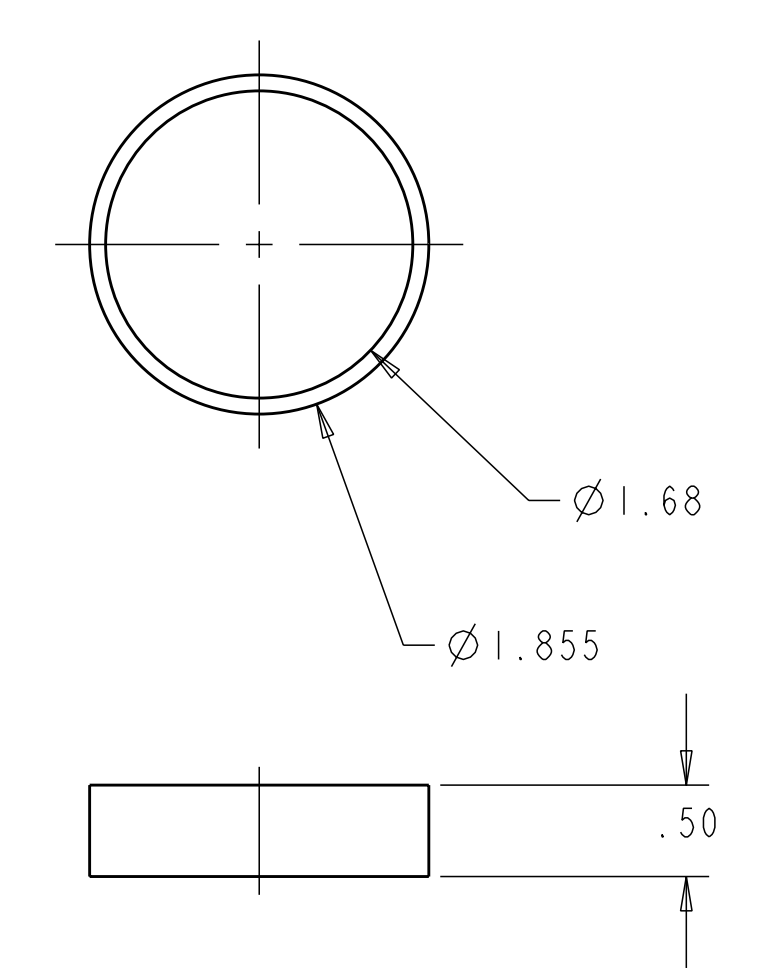
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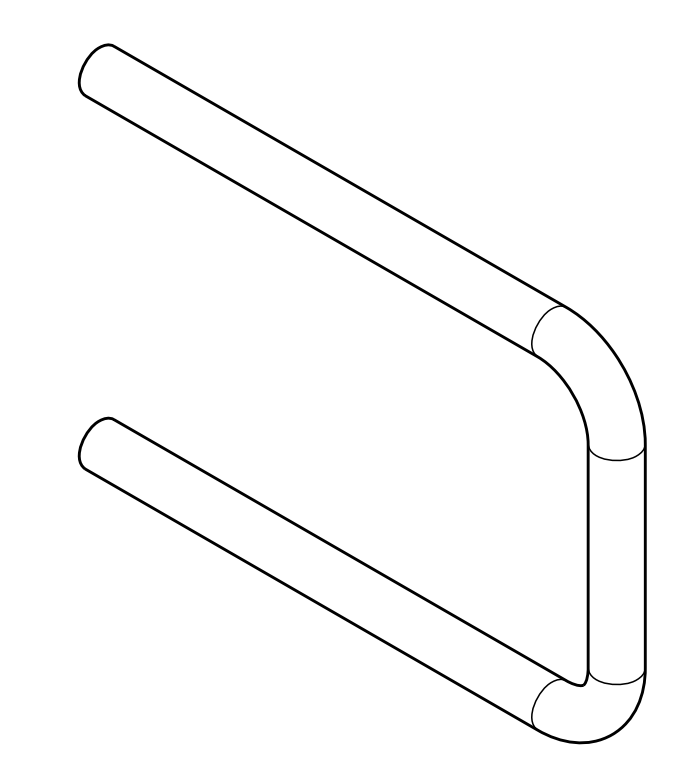
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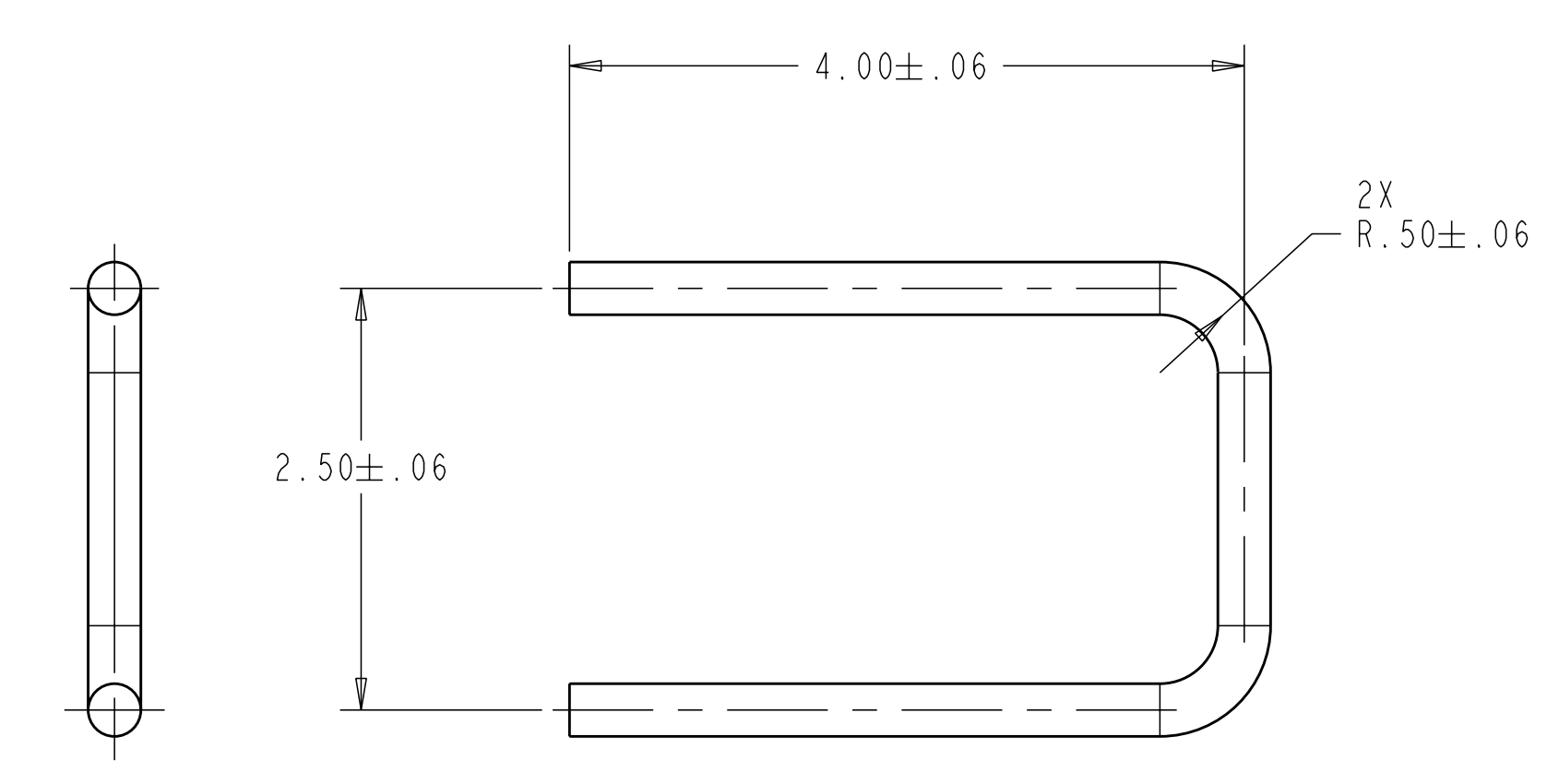
ISOMETRIC VIEW
SCALE 1.000



7 SCALE: 1.00



ISOMETRIC VIEW
SCALE 1.00



4 SCALE: 1.00

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting:

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

CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
AR	-8	WELD FILLER METAL			8
AR	-7	BELLEWS RING	316L SST ANNEALED	ASTM A276	7
AR	-6	LONG BRACKET STOP	316L SST ANNEALED	ASTM A240	6
AR	-5	5/16-18UNC ALL THREAD LONG BRACKET U-BOLT	316 SST		5
AR	-4	5/16-18UNC ALL THREAD BRACKET U-BOLT	316 SST		4
I	-3	STANDOFF MOUNT	316L SST ANNEALED	ASTM A240	3
I	-2	STANDOFF PLATE	316L SST ANNEALED	ASTM A240	2
AR	-1	HEADER BRACKET STANDOFF WELDMENT			1

WELDING ENGINEER
APPROVED B. KEILBACH DATE: 10/05

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

SCALE	NOTED	DES	P. L. GORANSON	04/07/05
TOLERANCES UNLESS OTHERWISE SPECIFIED		DRW	G. H. JONES	04/07/05
FRACTIONS		CHK	S. PARSON	05/05
XX DECIMALS ±.003		SECT		
XXX DECIMALS ±.005		DEPT		
ANGLES ±0°15'		CR		
BREAK SHARP EDGES .06 MAX		PJ		
FINISH .125 UNLESS OTHERWISE SPECIFIED		REQ		
		PPPL DRFT	J. SIEGEL	10/05

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					
PROJECT NAME						
NATIONAL COMPACT STELLARATOR EXPERIMENT						
VACUUM VESSEL HEATING/COOLING MISC.						
WELDMENT AND DETAILS						
VERSION NO.	PLANT	BLOG	FL	SHT OF	TYPE	CLASS
3	X10	5700	3	1	B	U
RELEASE LEVEL						REV
Fabrication						0