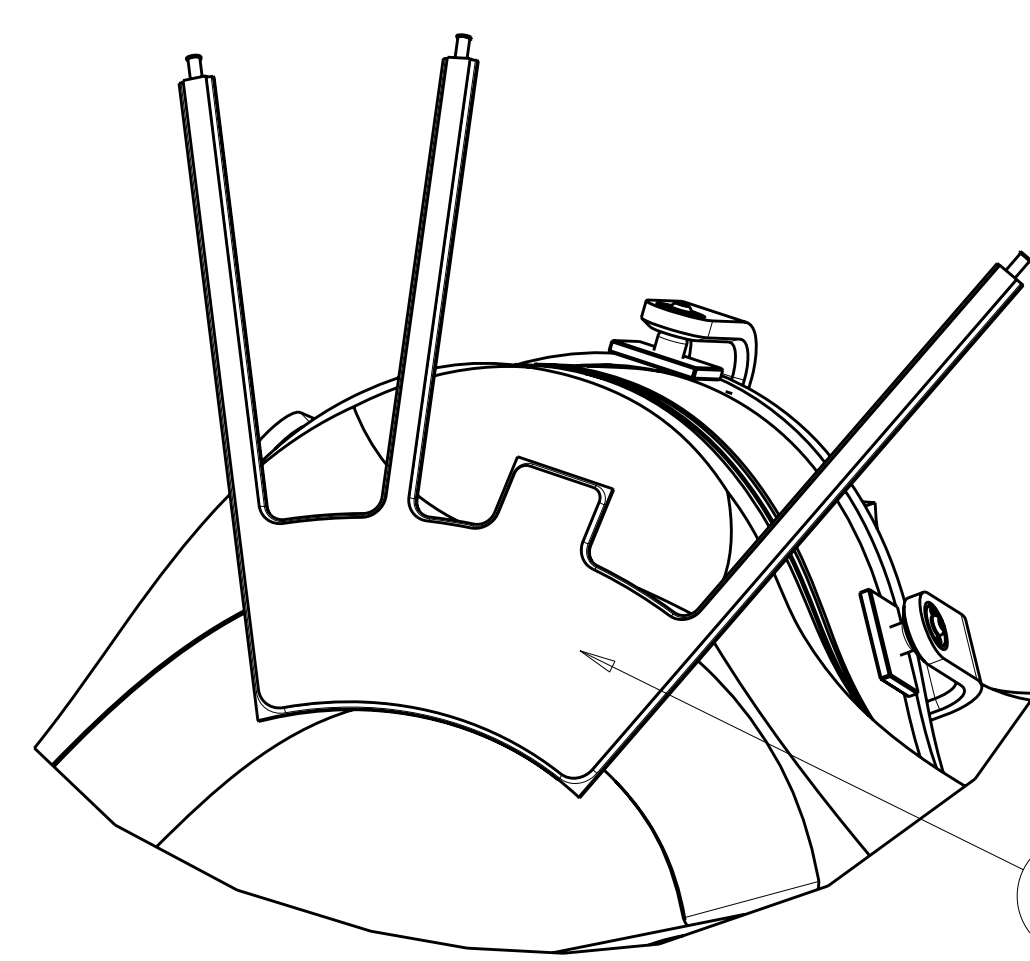
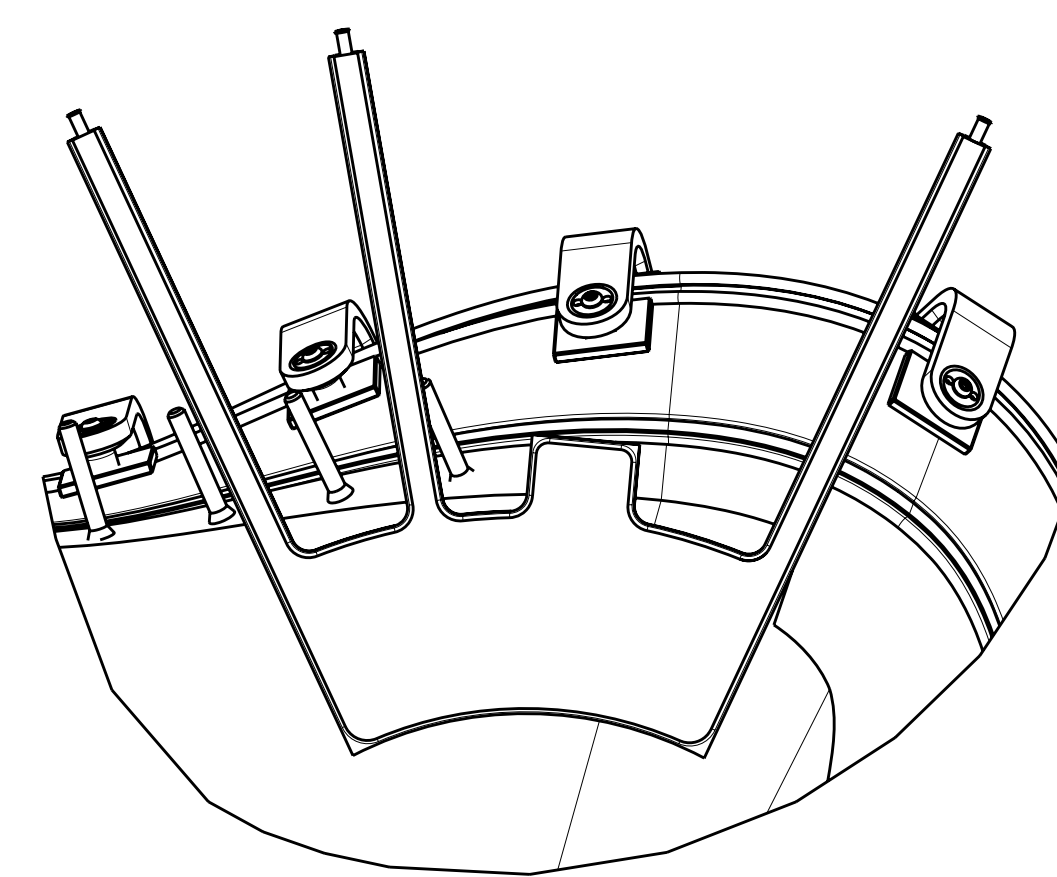


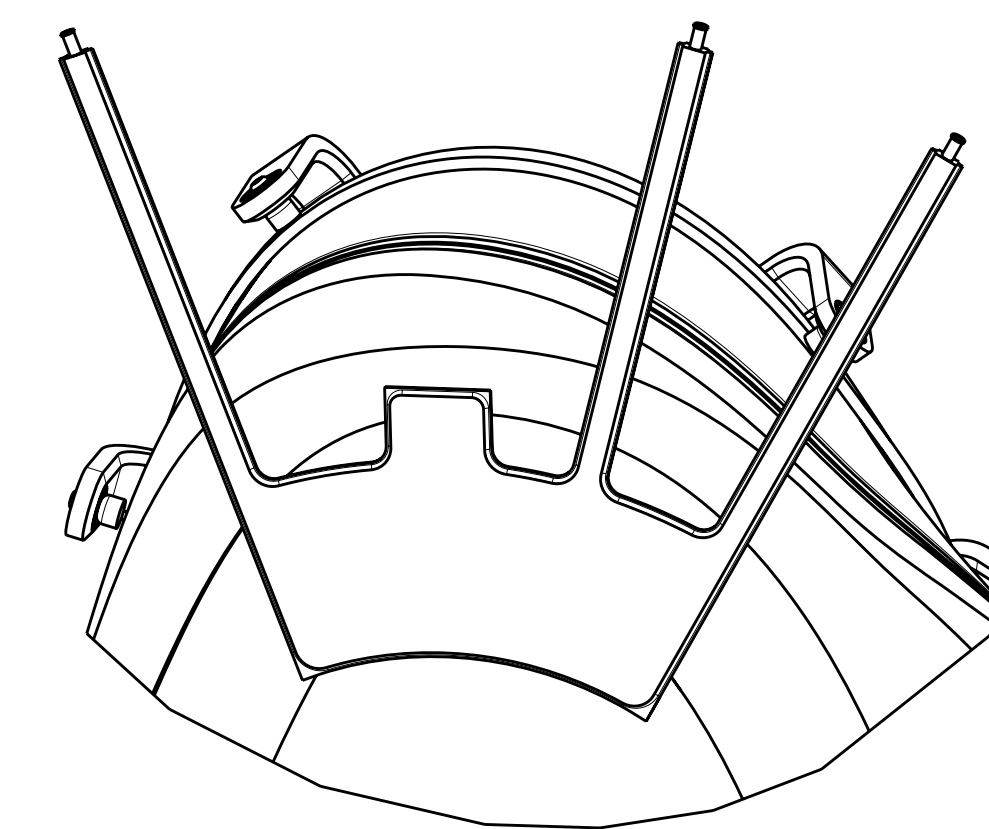
WING BLADDER #2 BETWEEN A AND B COIL - SHOWN ON B WING [13]
SCALE .25



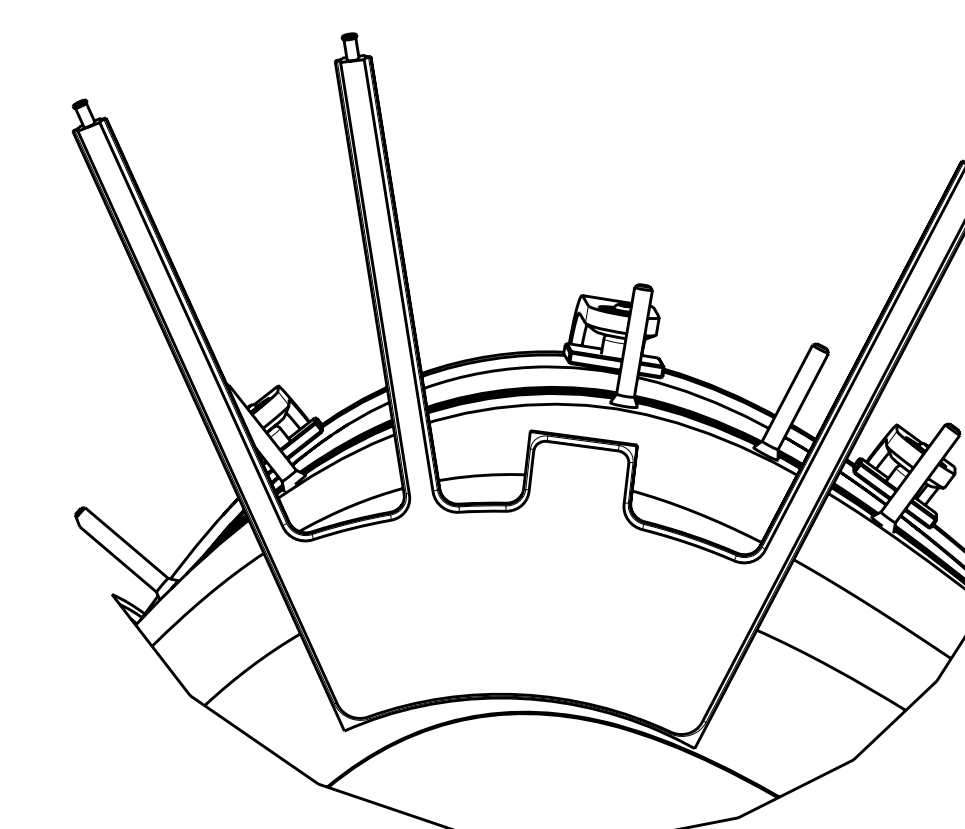
WING BLADDER #3 BETWEEN A AND B COIL - SHOWN ON A WING [13]
SCALE .25



WING BLADDER #6 BETWEEN B AND C COIL - SHOWN ON C WING [13]
SCALE .25

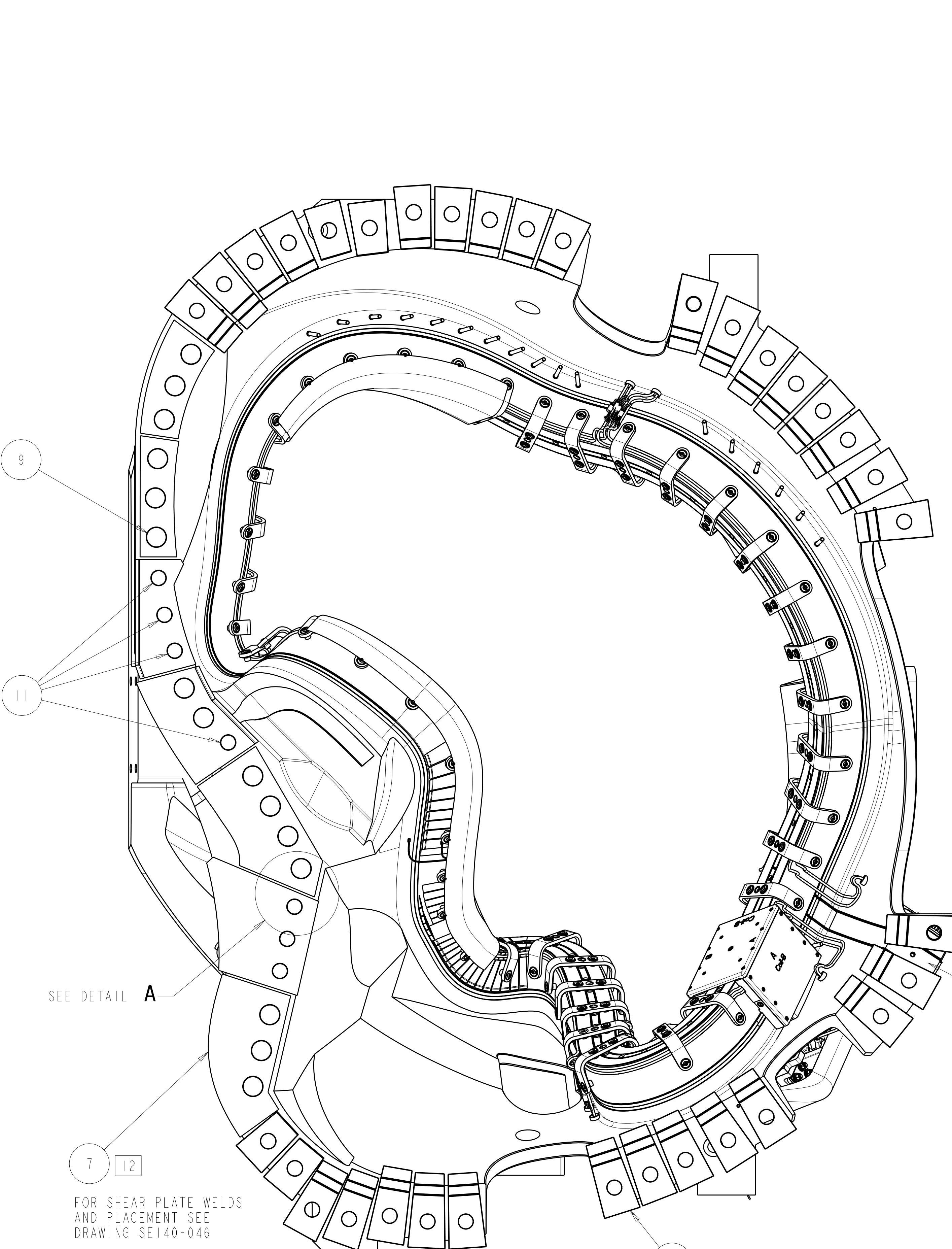


WING BLADDER #7 BETWEEN B AND C COIL - SHOWN ON B WING [13]
SCALE .25

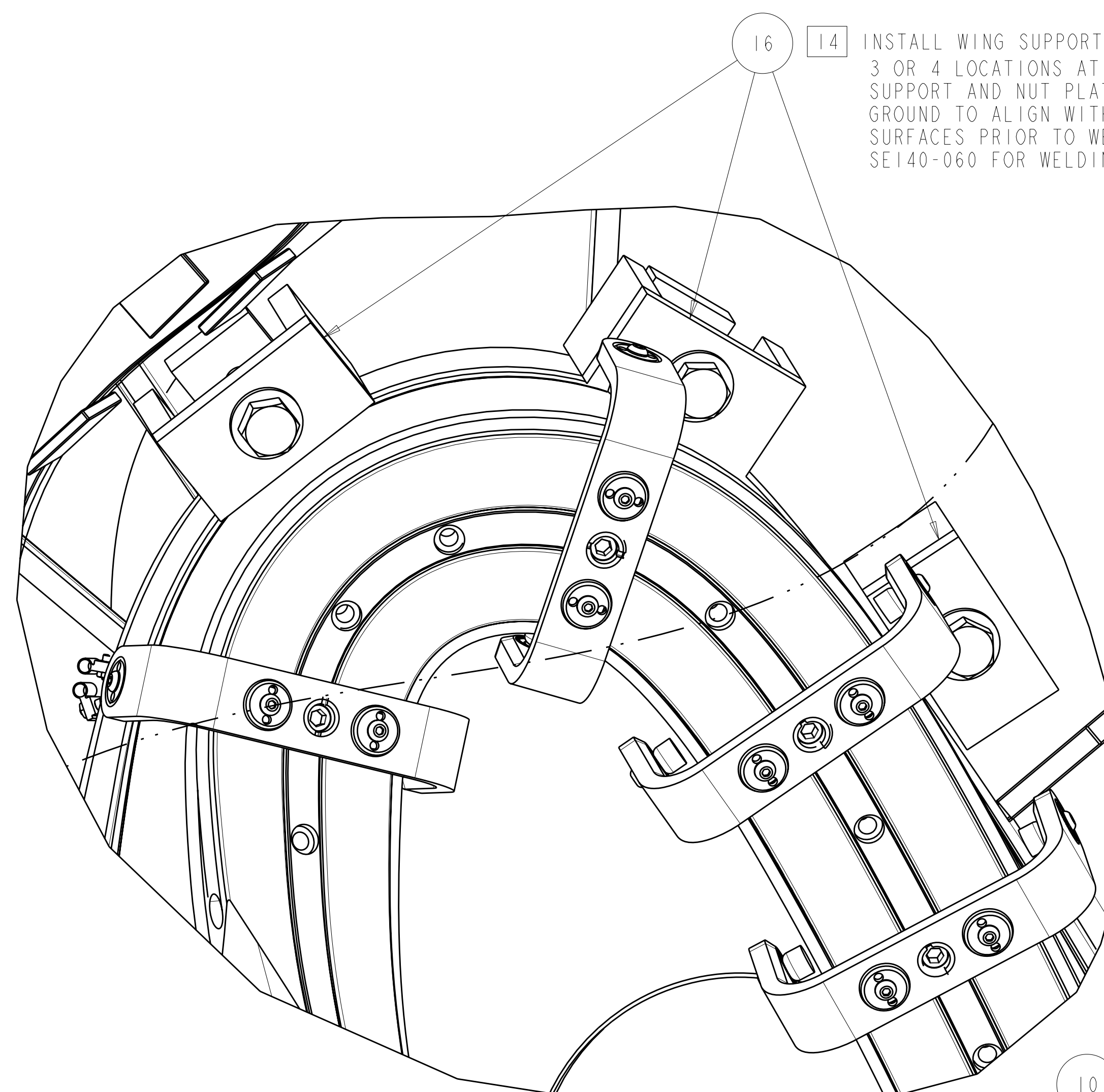


WING BLADDER #9 BETWEEN C AND A COIL - SHOWN ON C WING [13]
SCALE .25

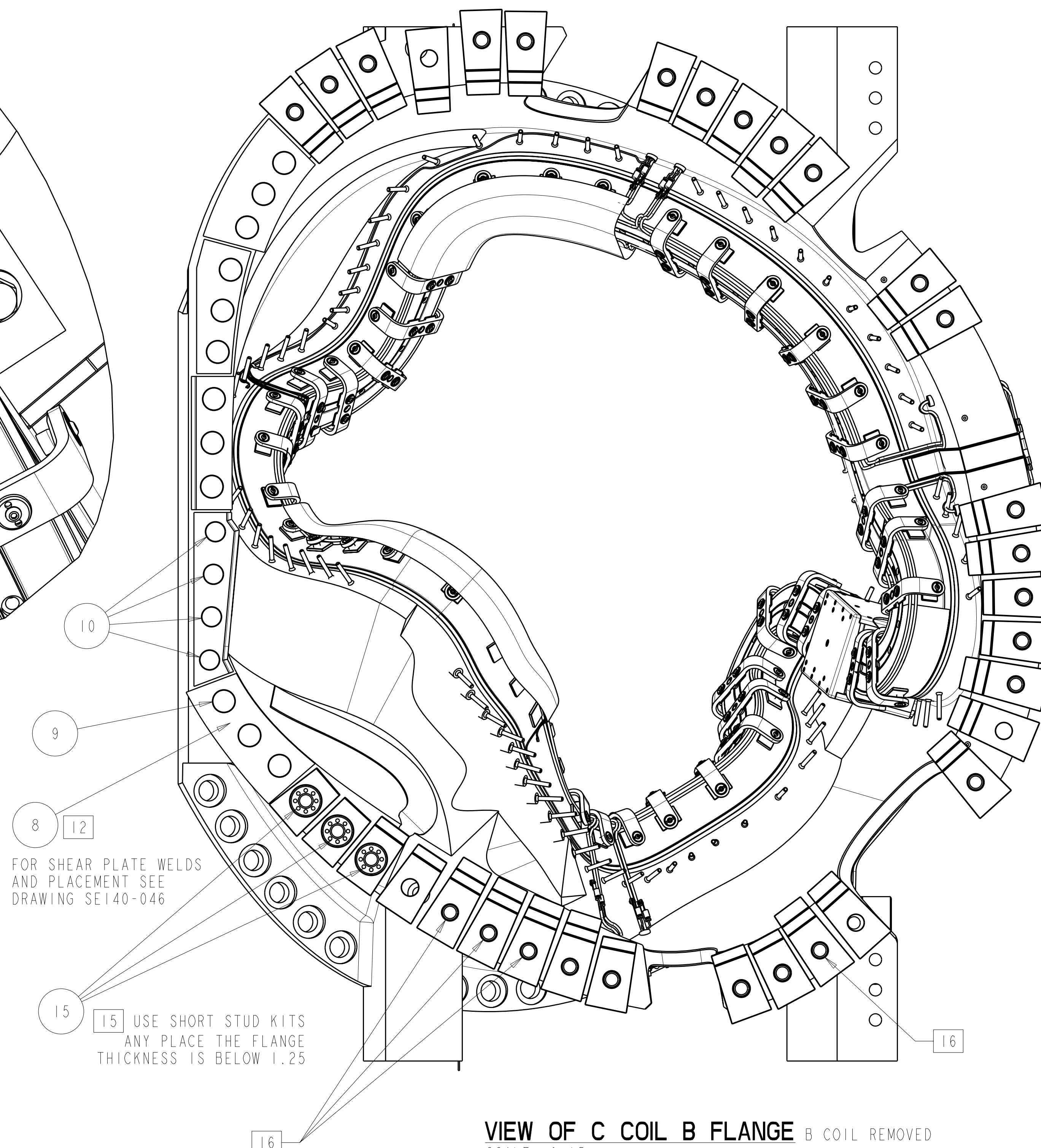
NOTE: WING SUPPORTS CANNOT BE USED FOR THIS WING UNTIL FINAL MACHINE ASSEMBLY SE100-001



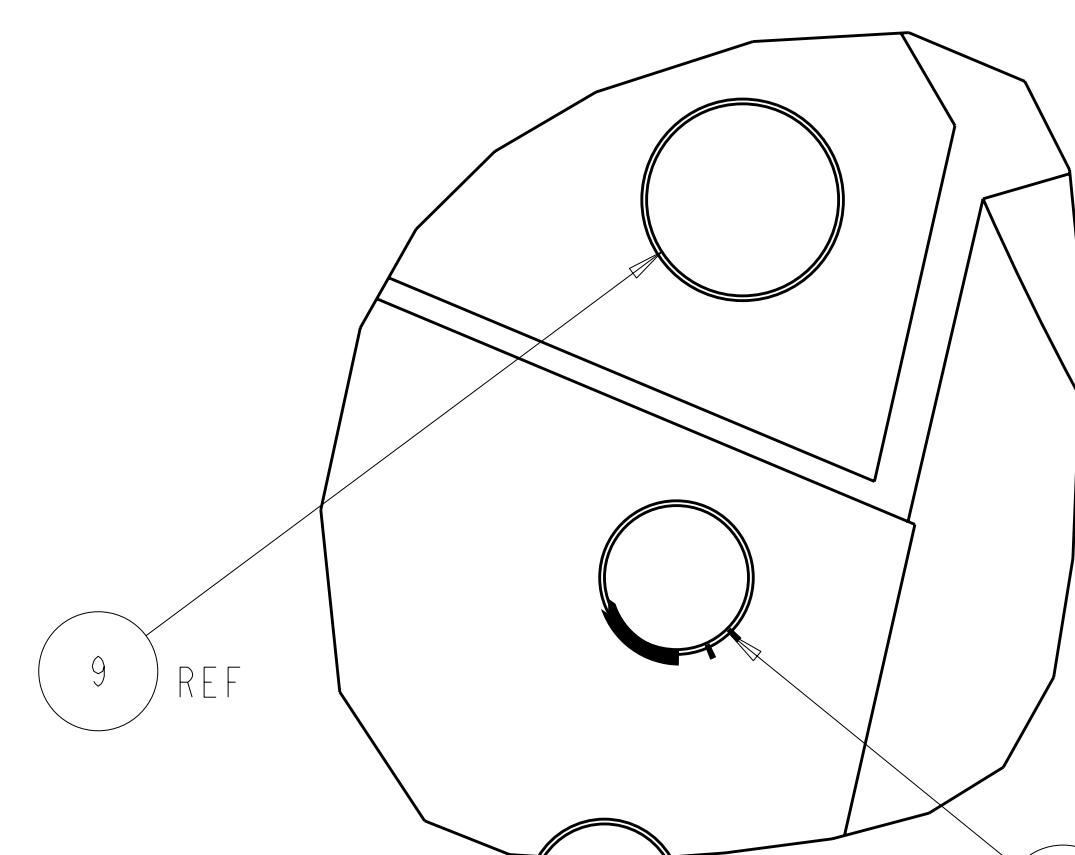
VIEW OF B COIL A FLANGE A COIL REMOVED
SCALE 0.15



TYPICAL WING 4 PLACES
SCALE .50



VIEW OF C COIL B FLANGE B COIL REMOVED
SCALE 0.15



DETAIL A
SCALE 0.50

19 ADD STRIPS, F/N 17, AS REQUIRED TO HELP CENTER PUCKS.

14 INSTALL WING SUPPORTS, IF NEEDED, AT 3 OR 4 LOCATIONS AT EACH WING AS SHOWN. SUPPORT AND NUT PLATES WILL NEED TO BE GROUND TO ALIGN WITH WING AND COIL SURFACES PRIOR TO WELDING. SEE DRAWING SE140-060 FOR WELDING AND OTHER INFORMATION.

18 FILL ALL GAPS WITH FILLER AFTER COILS ARE WELDED TOGETHER

12 FOR SHEAR PLATE WELDS AND PLACEMENT SEE DRAWING SE140-046

15 USE SHORT STUD KITS ANY PLACE THE FLANGE THICKNESS IS BELOW 1.25

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting

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:									
UT-BATTELLE NATIONAL COMPACT STELLARATOR EXPERIMENT									
MODULAR COILS ASSEMBLY 1/2 FIELD PERIOD									
VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS		
83	ORNL	5700	3	2	2	A	U		
RELEASE LEVEL		SE140-003							
Fabrication									
								REV	0