

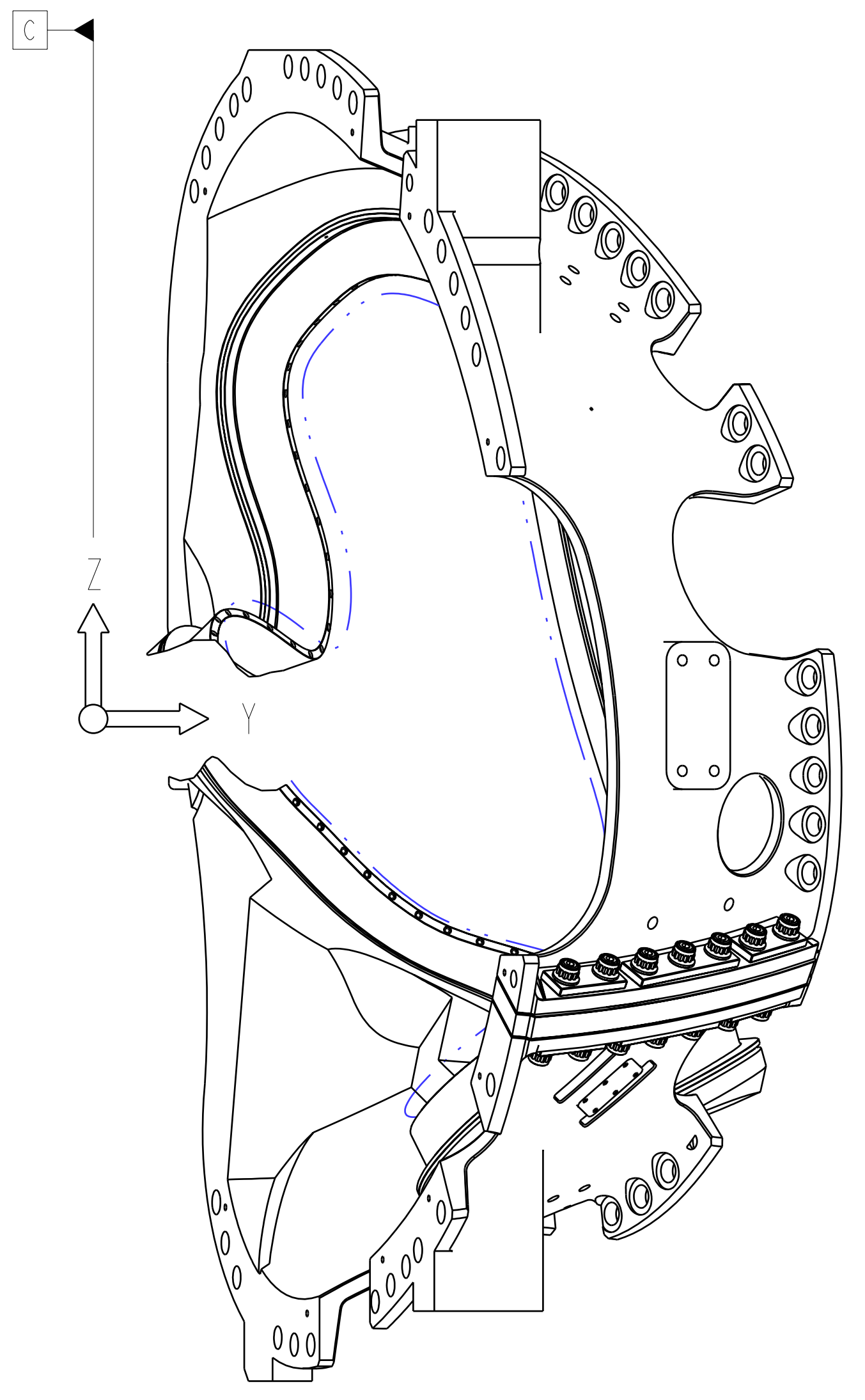
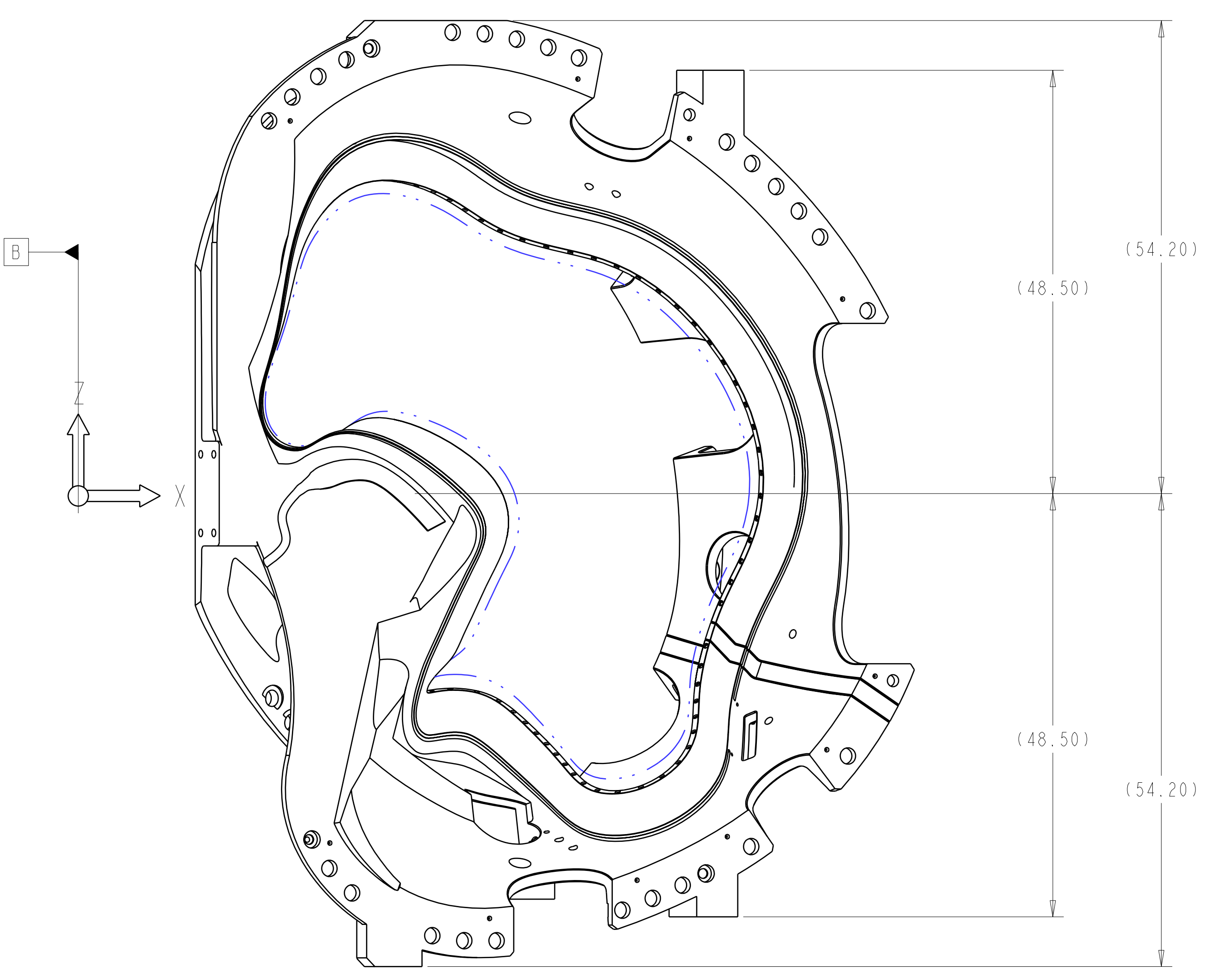
- NOTES:
- DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.8M-1996
 - INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M-1994
 - DIMENSIONS ARE IN INCHES
 - DRAWING DEPICTS FINAL MACHINED STATE OF PART DEFINED BY PRO/ENGINEER FILE SE141-102.ASM
 - UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE RELATED TO DATUM A- (PRIMARY X-Y PLANE, TOP) DATUM B- (SECONDARY Y-Z PLANE, SIDE) DATUM C- (TERTIARY X-Z PLANE, FRONT)
 - DIMENSIONS APPLY AT TEMPERATURE OF 20-30°C (68-86°F)
 - DIMENSIONS AND TOLERANCES EXCLUDE PROCESS MATERIAL ALLOWANCES WHICH MAY ADD MASS
 - APPROXIMATE WEIGHT = 4950-LBS
 - MATCH DRILL OR REAM AS REQUIRED TO ACHIEVE RUNNING FIT BETWEEN PARTS AT ASSEMBLY
 - LUBRICATE THREADED SURFACES WITH THRED-GARD ANTI-SEIZE COMPOUND FROM FEDERAL PROCESS CORP, CLEVELAND, OH
 - SEE LATEST REVISION OF SPECIFICATION NCSX-CSPEC-141-03 FOR ADDITIONAL REQUIREMENTS
 - BOND INSULATING SLEEVE (F/N 5) INTO WINDING FORM (F/N 2) USING LOCTITE 411 PER MANUFACTURER'S INSTRUCTIONS.
 - ITEM NO. 4 HOLE DIAMETERS TO MATCH OD OF ITEM NO. 6 PLUS .001 TO .002 FOR CLEARANCE FIT.
 - ITEM NO. 7 MAY BE DIVIDED INTO TWO PARTS IF NECESSARY. HOLE DIAMETERS TO MATCH OUTER DIA OF ITEM NO. 5 PLUS .001 TO .002 CLEARANCE FIT.
 - TORQUE ITEM NO.8 TO 1500 +/- 30 FT-LBS.

ECN-5140R3 - This ECN makes polodial break shim and studs electrically connected to the winding form. See ECN-5140R3 for details.

ECN-5197 approved and decision made to apply ECN stamp vs. updating impacted drawings. This ECN prohibits the continued use of "Thred Gard" lubricant to bolts. (See ECN-5197 for Details)

Rev 3-a: RFD-14-024 authorized trimming the bearing plate and insulating material to ensure that no interferences will result. NCR 20519 approved this change for the B1 casting and this RFD authorizes these modifications for the remaining B2 through B6 castings. . This is considered a relatively minor change and a drawing change will not be required. (See RFD-14-024 for details)

RELEASED FOR FABRICATION / INSTALLATION
 PPPL Drafting:



REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
3	REVISED ASM AND DRAWING PER ECN 5059	GLL	12/08	MJC			DEW					
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1	REVISED F/N 2 PER ECN-4903	DW	9/04	MJC			DEW					

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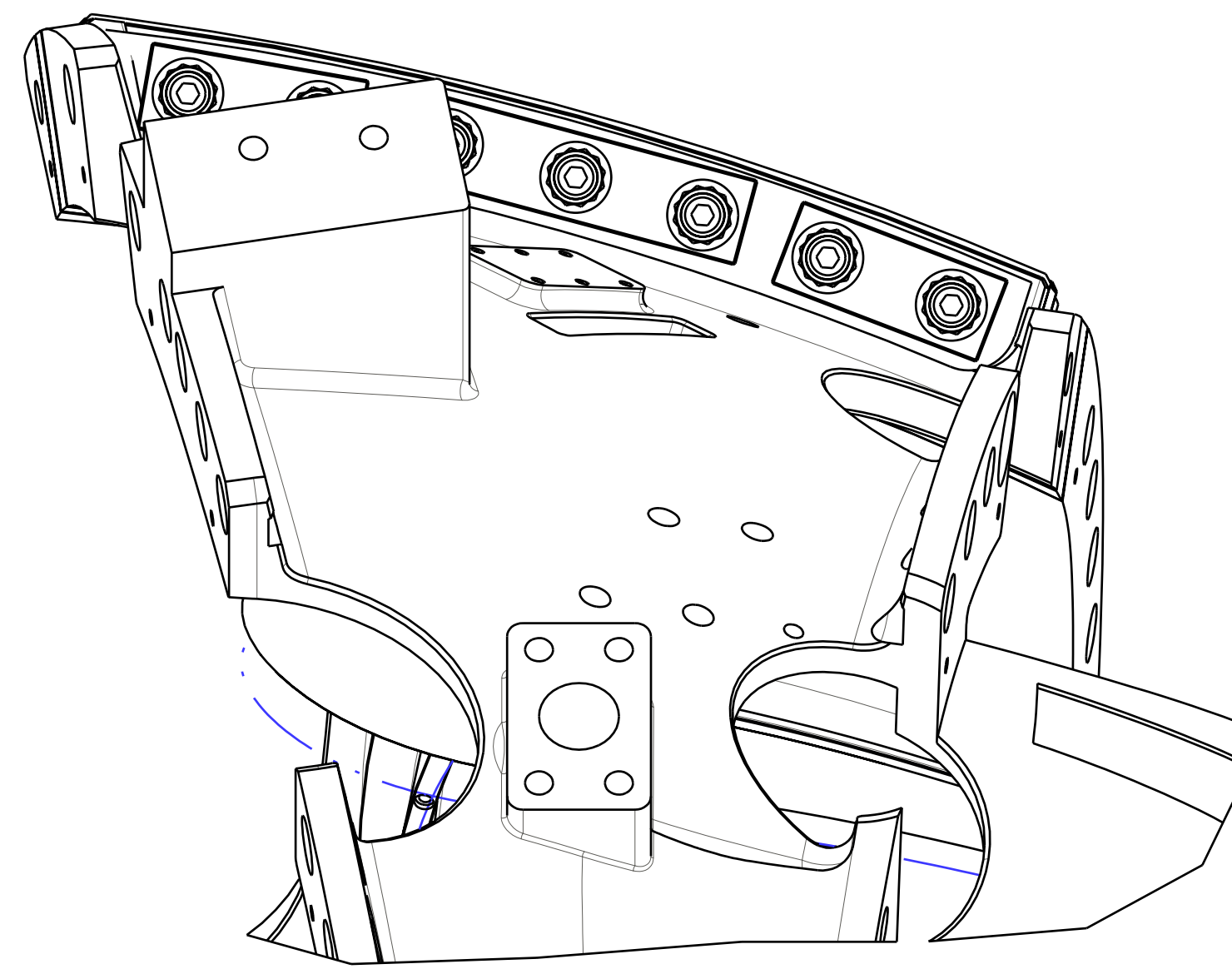
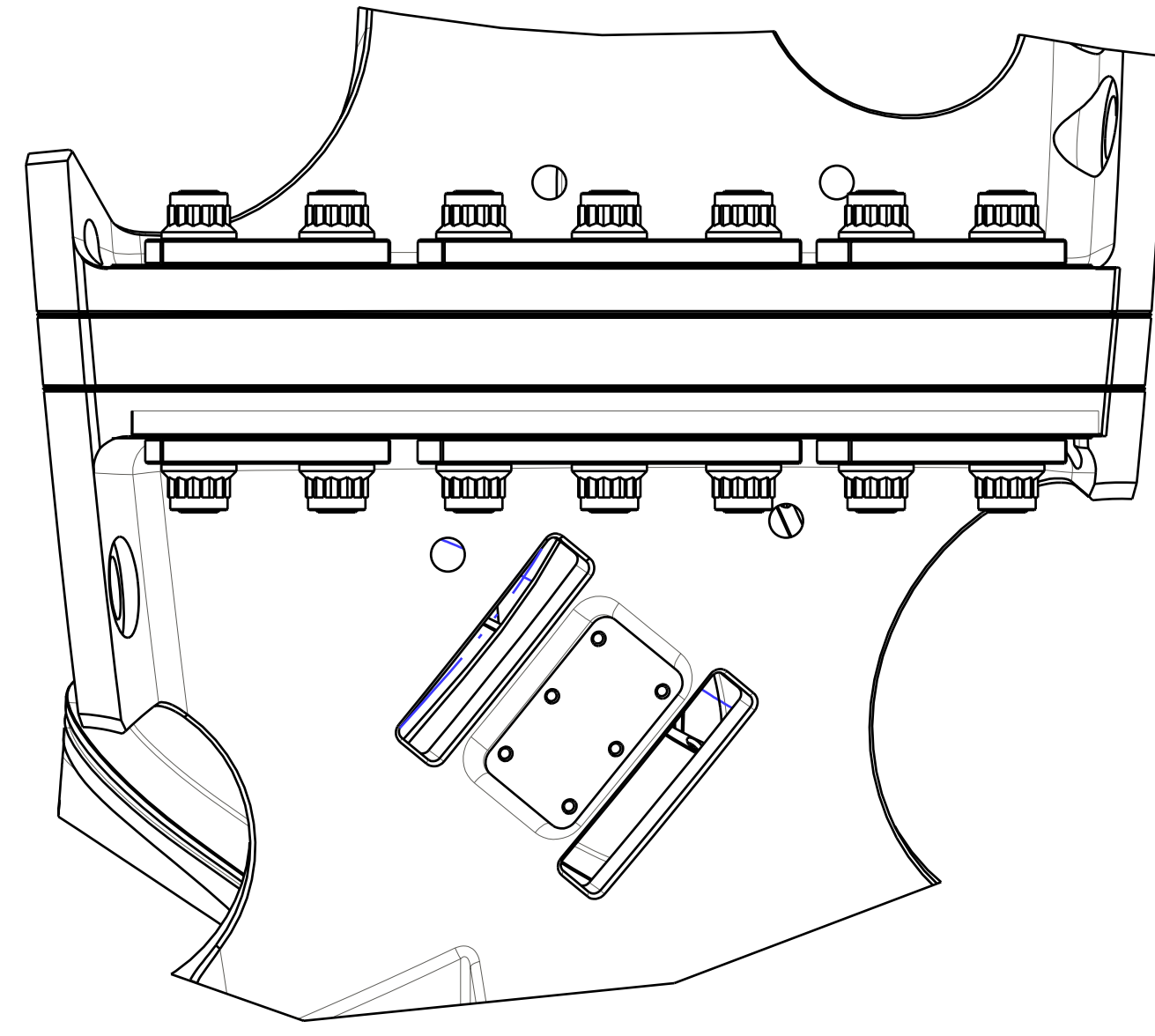
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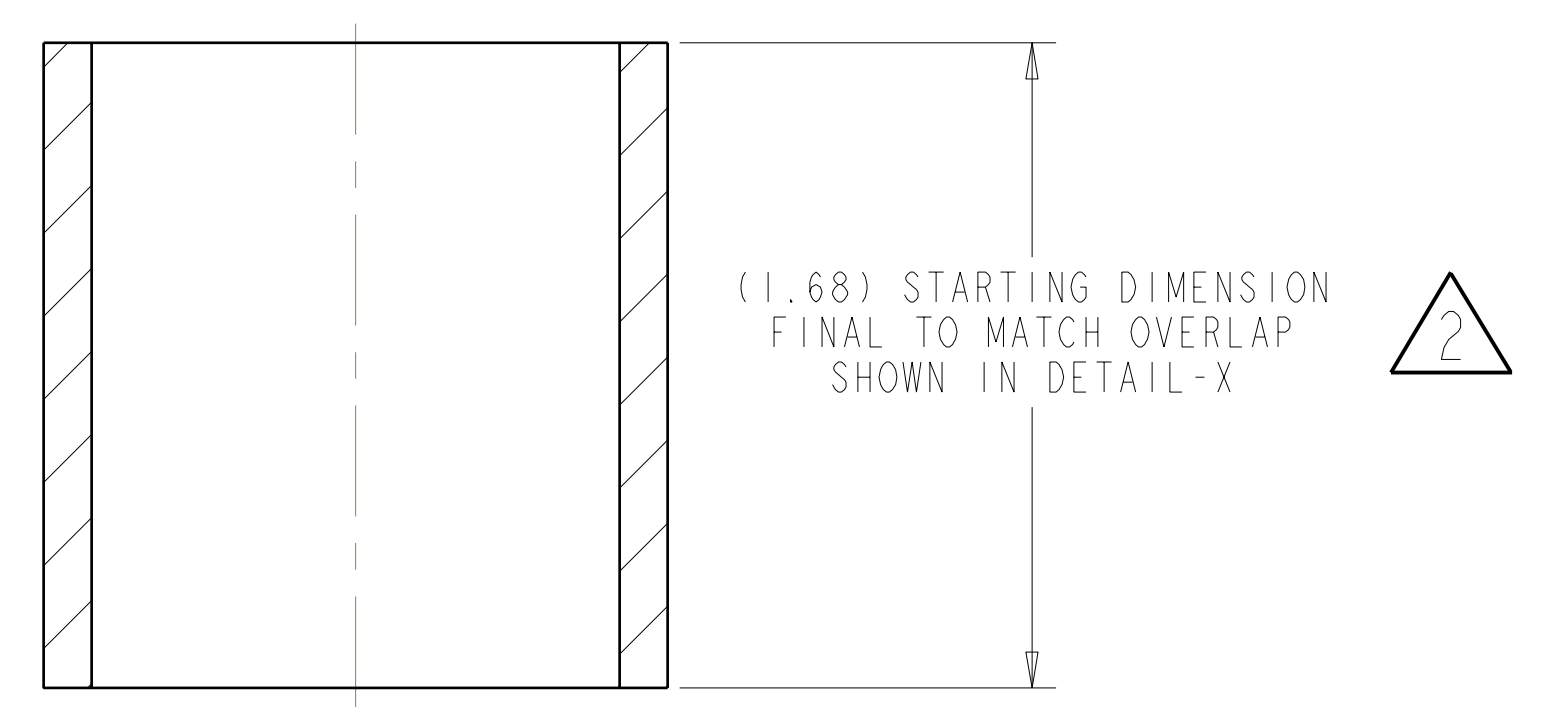
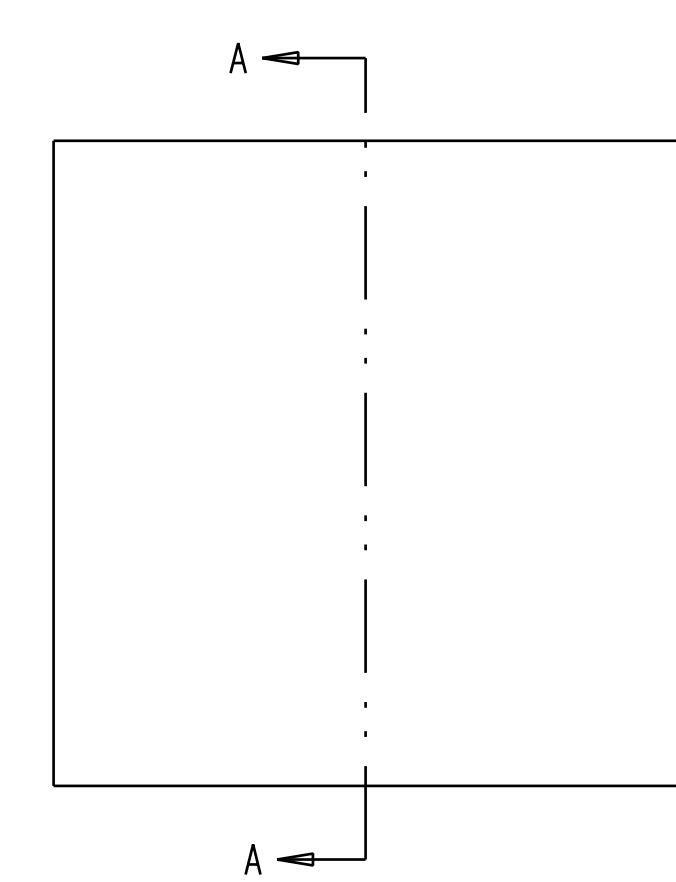
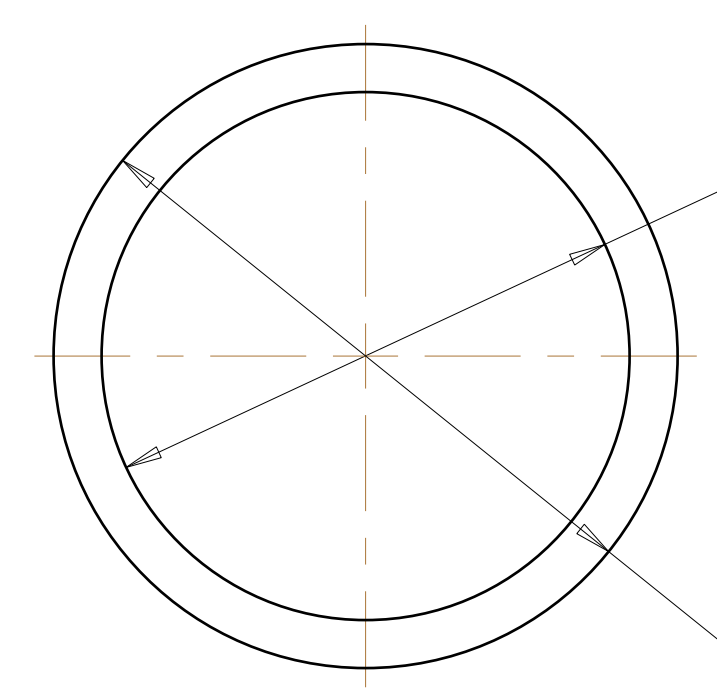
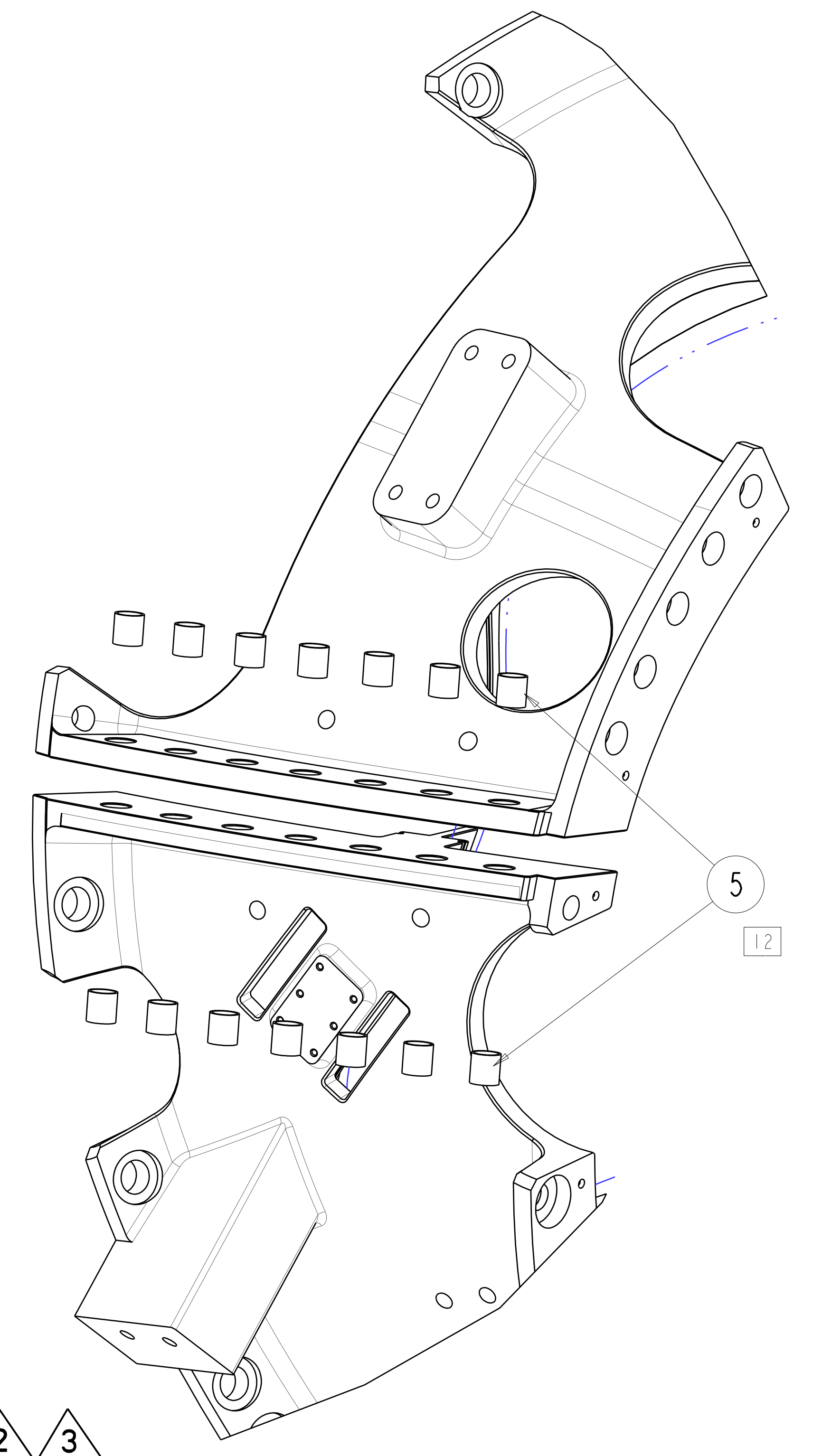
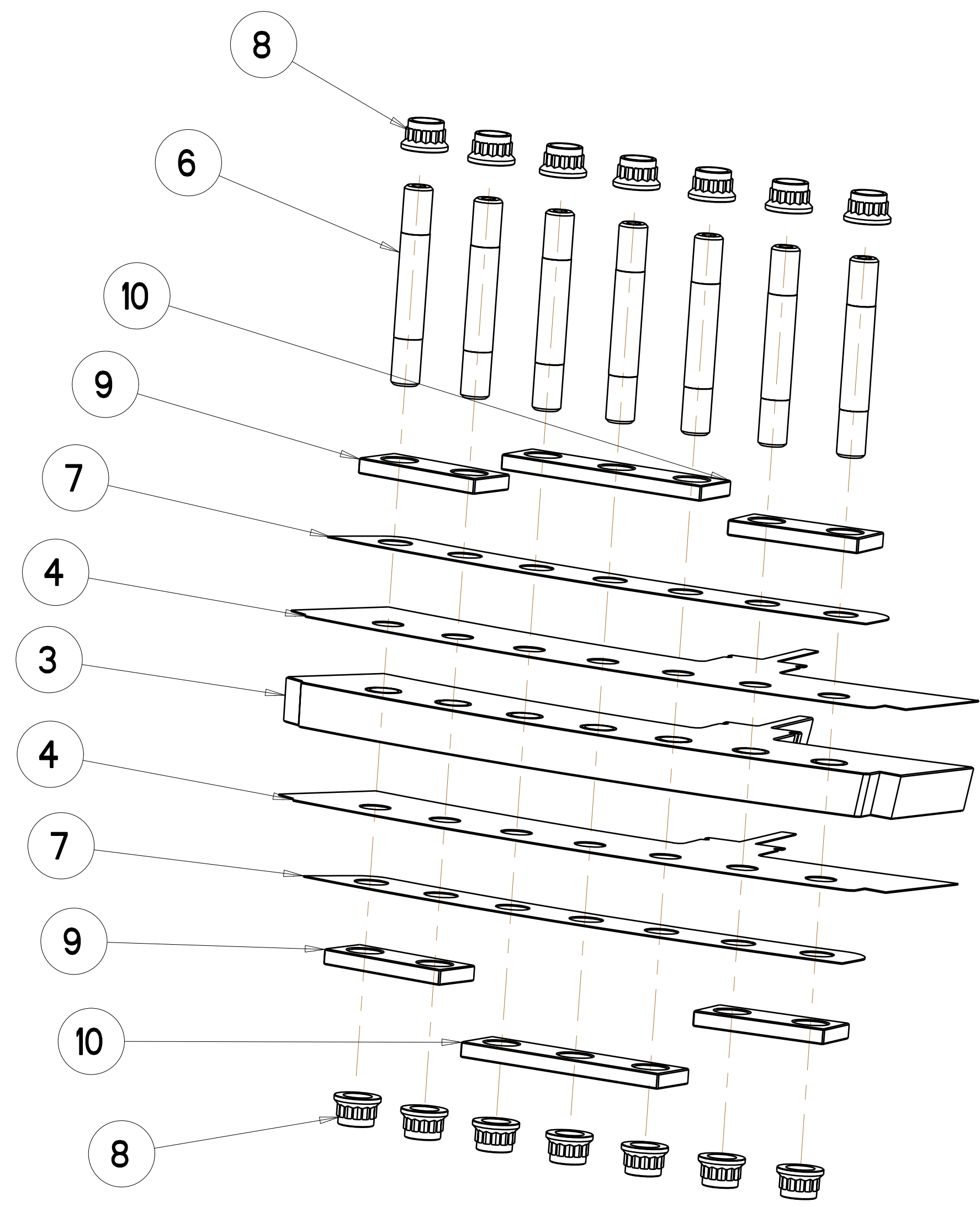
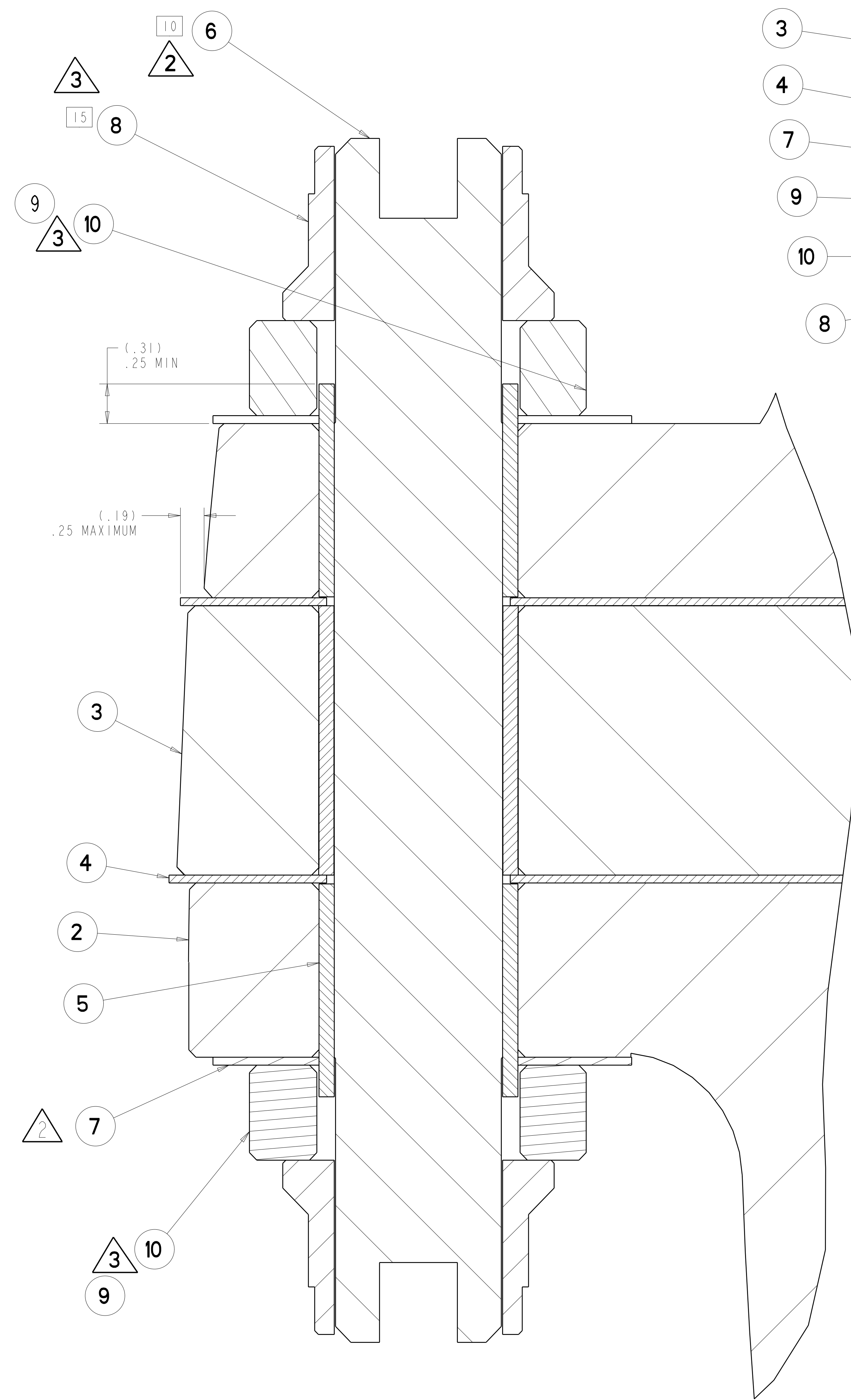
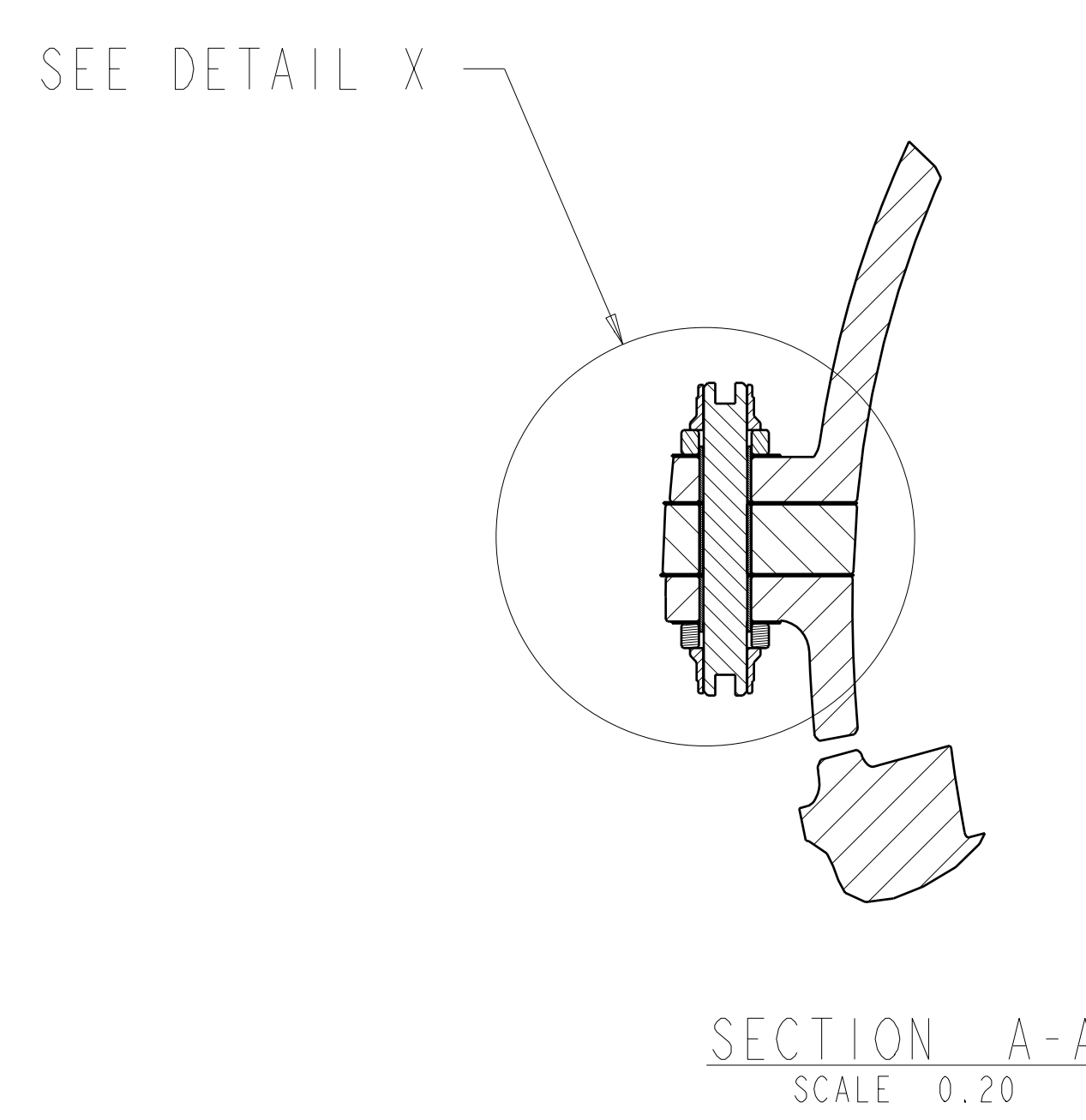
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POLOIDAL BREAK DETAIL



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(See ECN-5197 for Details)

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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							
MOD COIL WINDING FORM ASSEMBLY TYPE-B							
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS	
4	X-10	5700	3	2	2	S	U
RELEASE LEVEL	SEI41-102						REV
Fabrication							3

SEI41-102