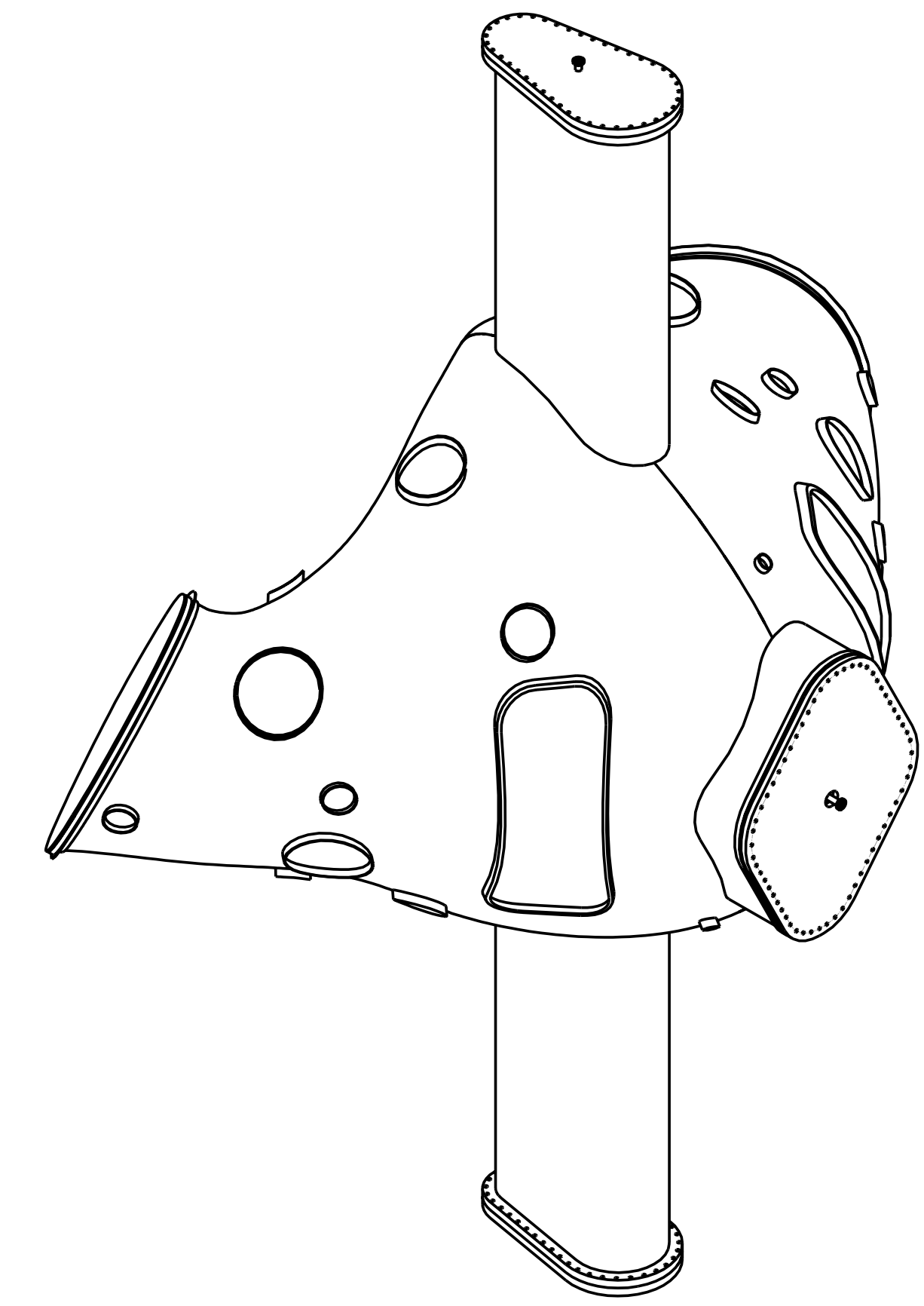
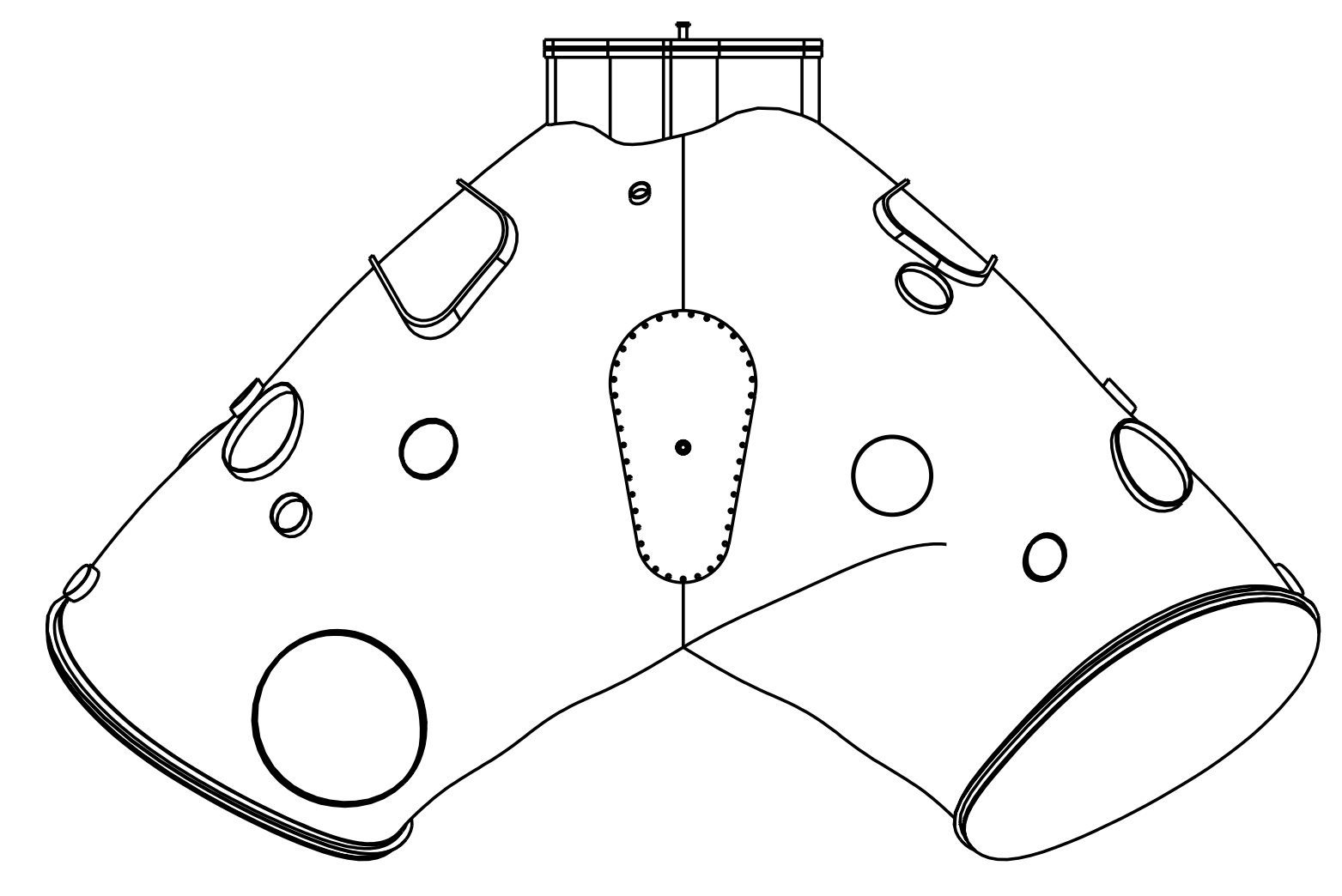
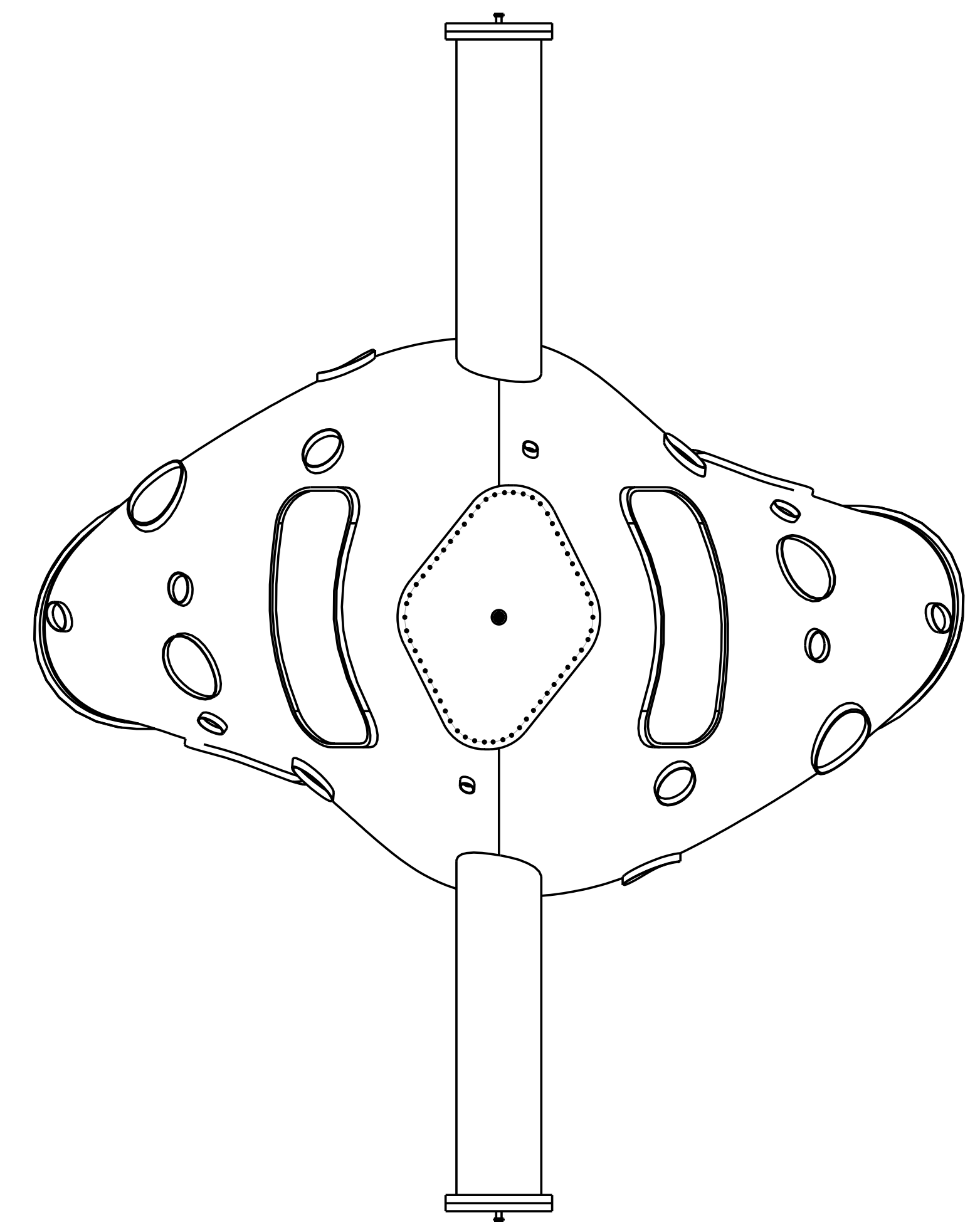
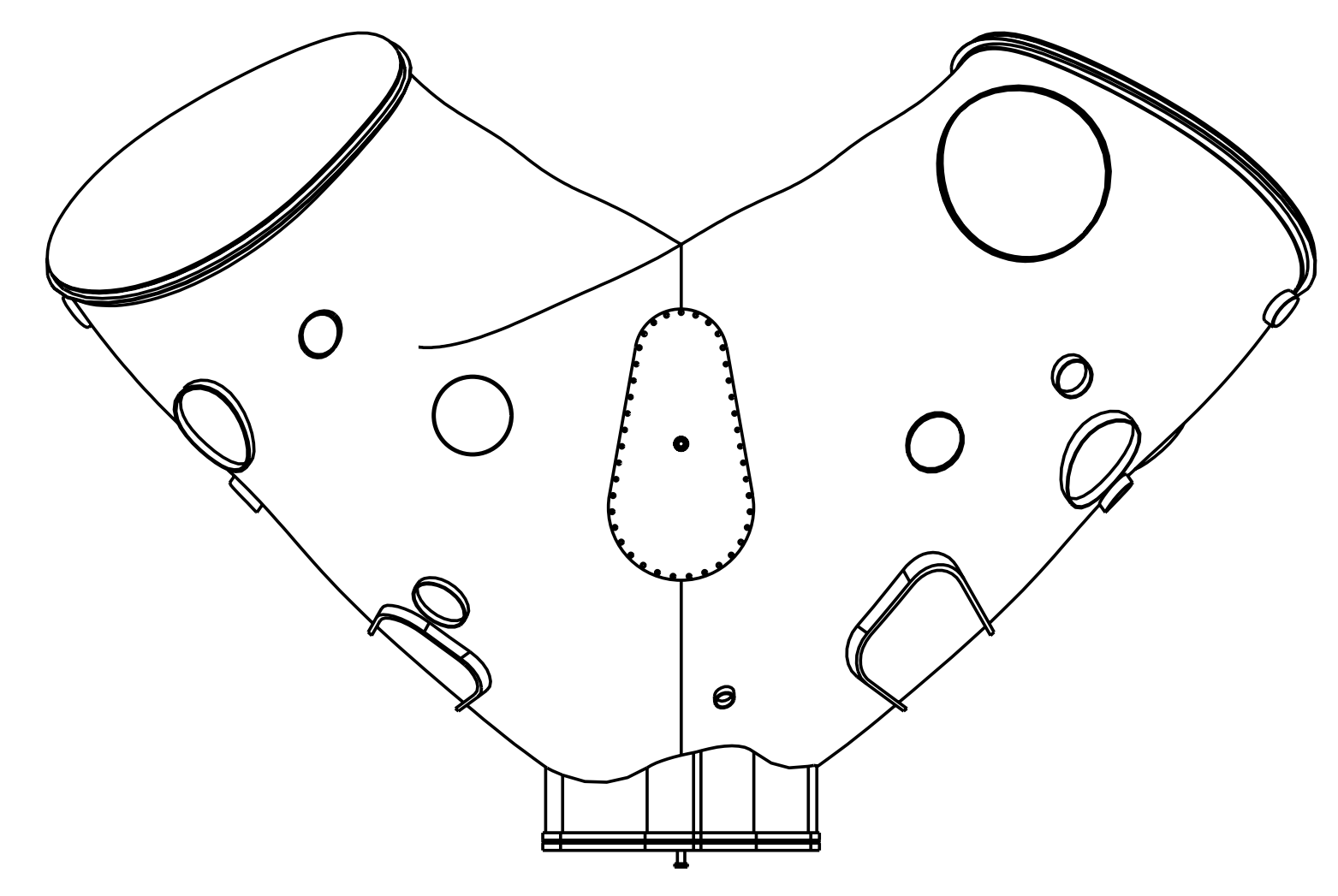


- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
  2. DIMENSION ARE IN INCHES.
  3. REQUIREMENTS FOR FABRICATING THE VACUUM VESSEL ARE DEFINED IN THE DRAWINGS, MODELS, AND SPECIFICATION.
  4. GEOMETRY OF VACUUM VESSEL IS DEFINED IN CAD MODELS/FILES SE120-001.ASM, SE120-002.ASM AND SE121-019.PRT
  5. HELIUM LEAK TEST SHALL SHOW NO DETECTABLE LEAK WITH LEAK DETECTOR SENSITIVITY SET AT  $1.0 \times 10^{-9}$  STD-CC/S.
  6. ALL MATERIAL EXCEPT FOR CONFLAT FLANGES TO BE UNS N06625. CONFLAT FLANGES TO BE 304 SST.
  7. BLANK MATING FLANGES AND ASSOCIATED SEALS AND HARDWARE TO BE FURNISHED FOR ALL PORTS.
  8. ADDITIONAL TOLERANCE LIMITS ARE DEFINED IN DOCUMENT NCSX-12-122002-PH.



ISOMETRIC VIEW

next assy	AR	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
SE120-001	X	-1	-1	VACUUM VESSEL PERIOD ASSEMBLY			1
				VACUUM VESSEL BODY			2
				VACUUM VESSEL FLANGE			3
							4
							5
							6
							7
							8
							9
							10
							11
							12
							13
							14
							15
							16
							17
							18
							19

QV CLAUSE	DOCUMENTS REQUIRED	APPLICABLE TO PART NO *
303	MATERIAL MILL TEST REPORT	
325	MATERIAL SELLER CERT	X
326	SPECIAL MATERIAL INSPECTION REPORT	
205	MANUFACTURING, INSPECTION AND TEST PLAN	X
312	FIELD INSPECTION AND TEST PLAN	X
321	WELD AND BRAZE INSPECTION REPORT	X
322	HEAT TREAT REPORT (REQUIRED)	X
310	LEAK TEST REPORT	X
315	CLEANING CERT	X
318	DEVIATION REQUEST	X
319	NONCONFORMANCE REPORT	X
323	DIMENSIONAL REPORT	X
330	FUNCTIONAL TEST REPORT	

DES: P. L. GORANSONI 12/02  
 DRW: M. J. COLE & G. H. JONES 12/02

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

NATIONAL COMPACT STELLERATOR EXPERIMENT  
 VACUUM VESSEL PERIOD ASSEMBLY

VERSION NO. 54+  
 PLANT XX  
 BLDG XX  
 FL XX  
 SHT OF 1  
 TYPE 2  
 CLASS XX  
 U

PPPL DRFT  
 RELEASE LEVEL WIP  
 SE120-003  
 REV A

SCALE: .06

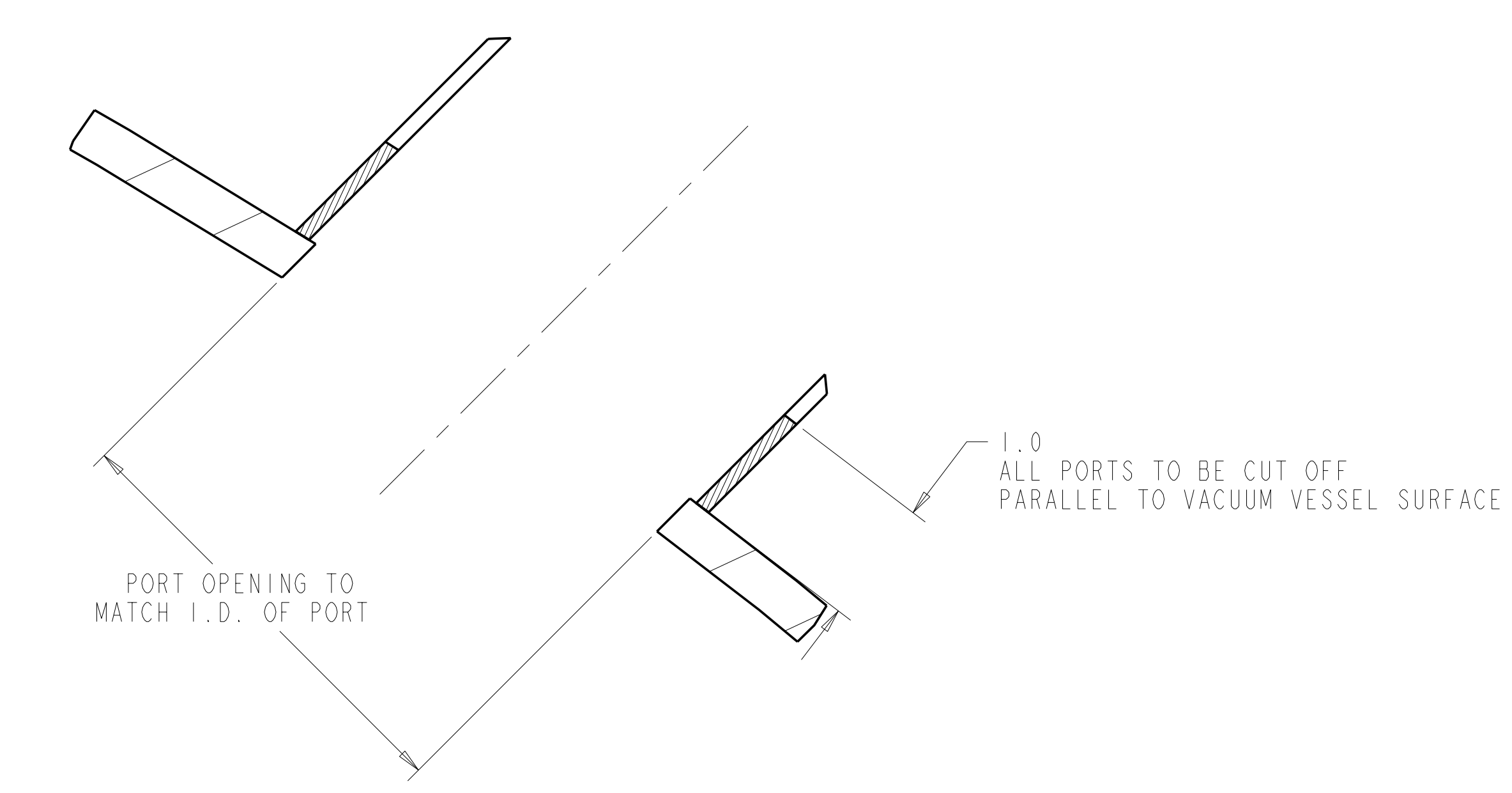
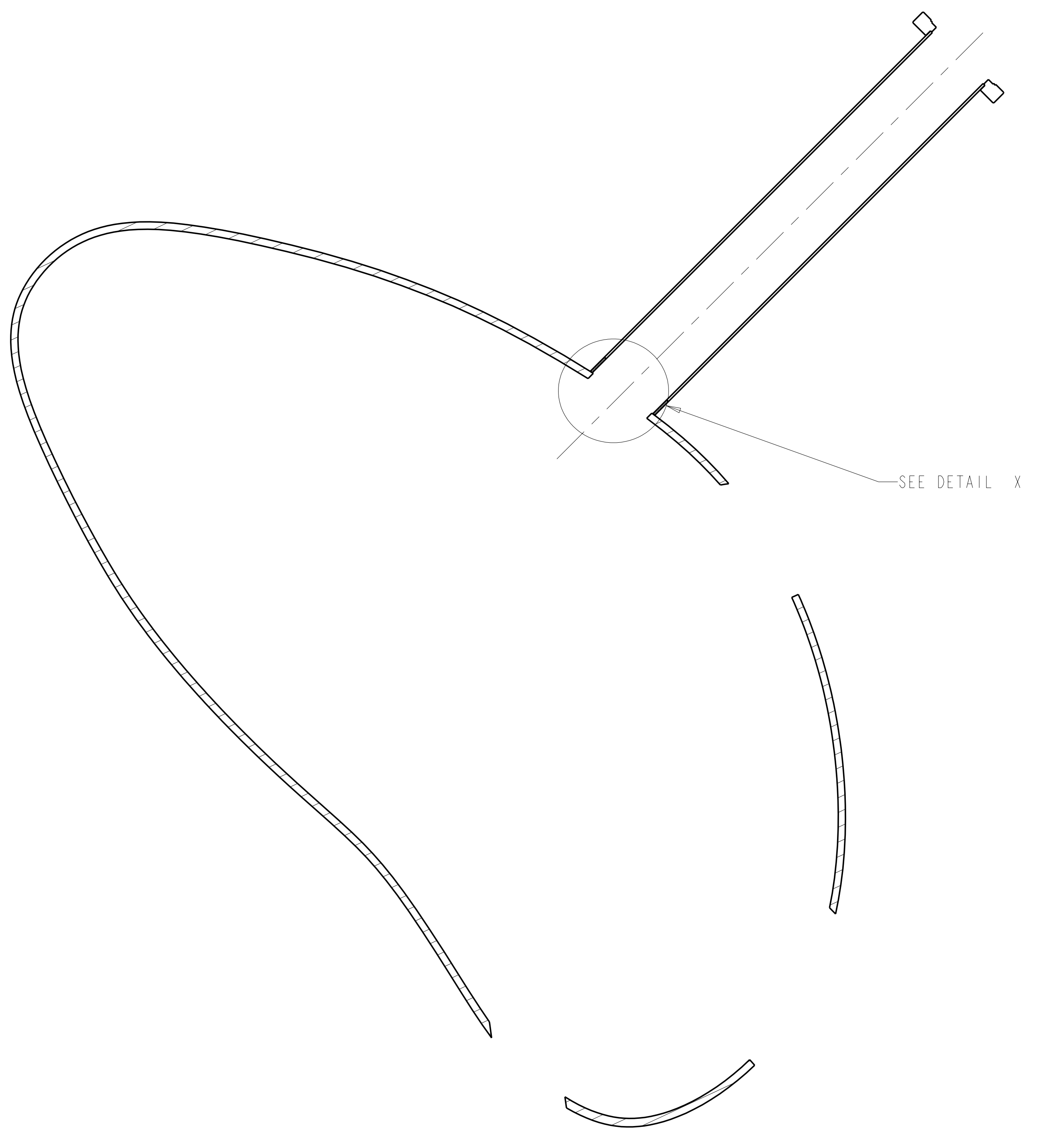
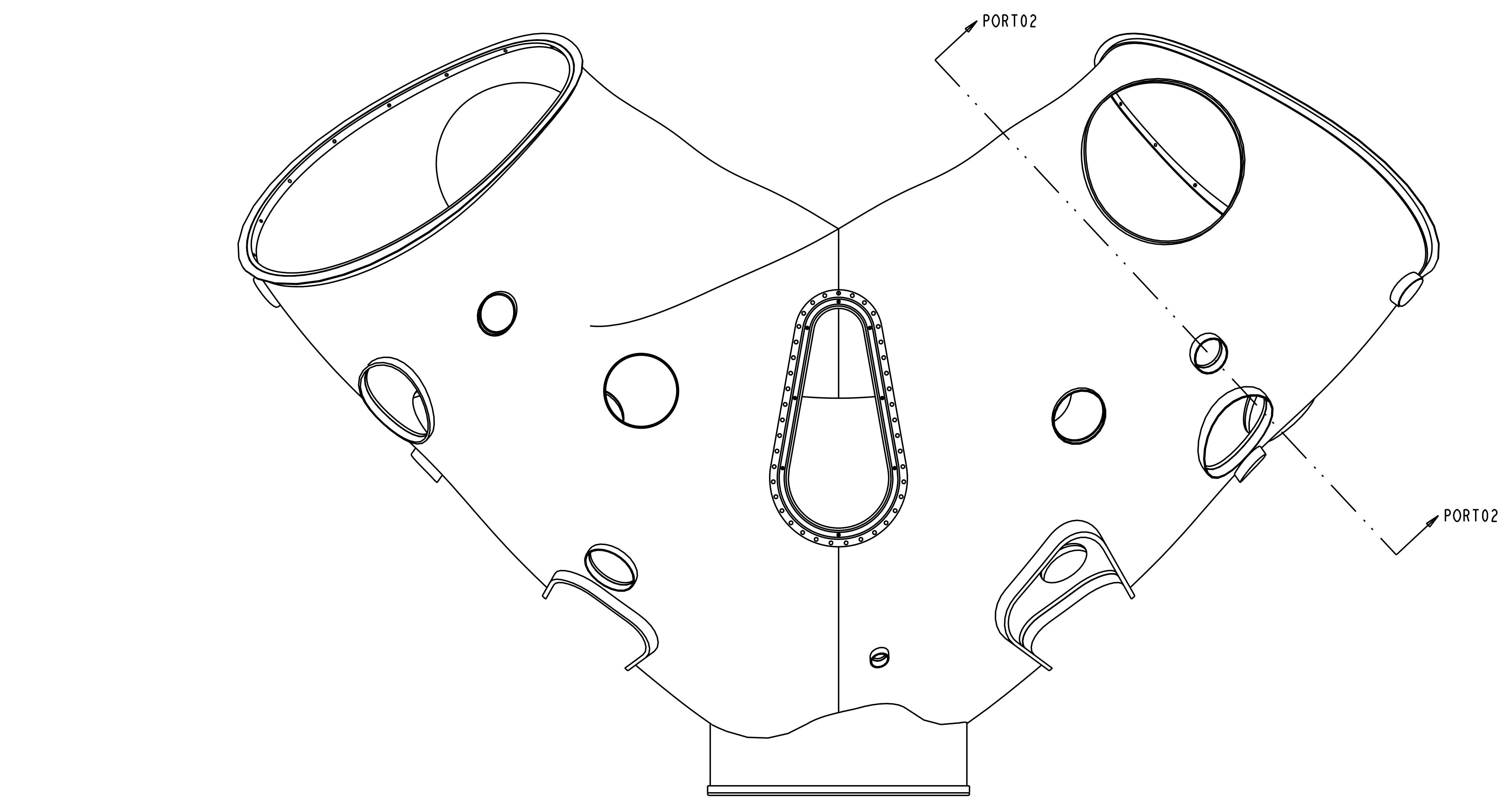
REV	DESCRIPTION	DATE	BY	CHK	APP
A	GENERAL REVISION	GHJ	5-30		

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**P** THIS DRAWING PRODUCED ON PRO-ENGINEER

SE120-003

FOR NOTES AND PARTS LIST SEE SHEET 1.



DETAIL X  
SCALE 1.000

TYPICAL PORT

Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee						
<b>UT-BATTELLE</b>						
PROJECT NAME <b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b>						
VACUUM VESSEL PERIOD ASSEMBLY						
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
54+	XX	XX	XX	2 2	XX	U
RELEASE LEVEL		WIP			REV	
		SE120-003			A	

SE120-003