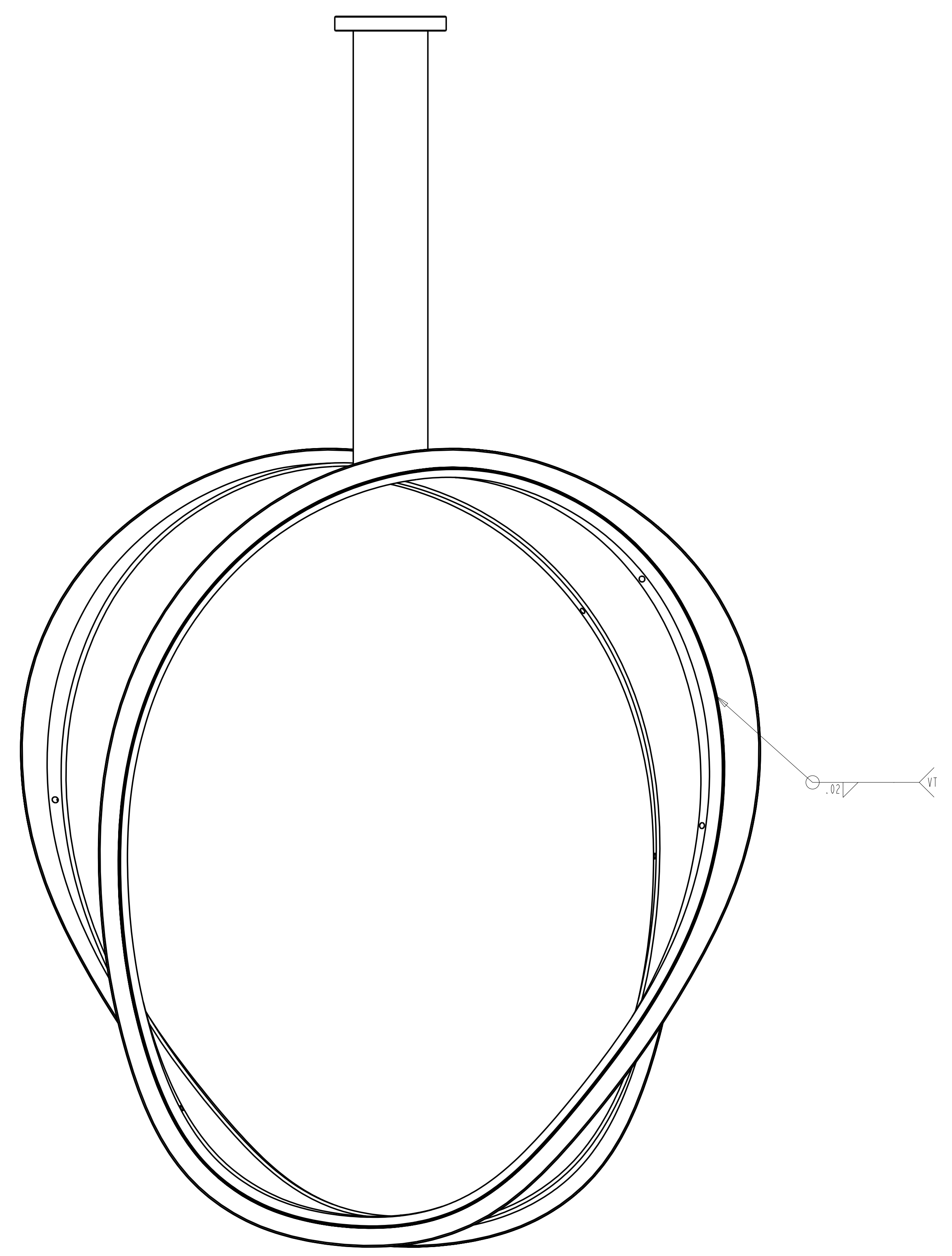
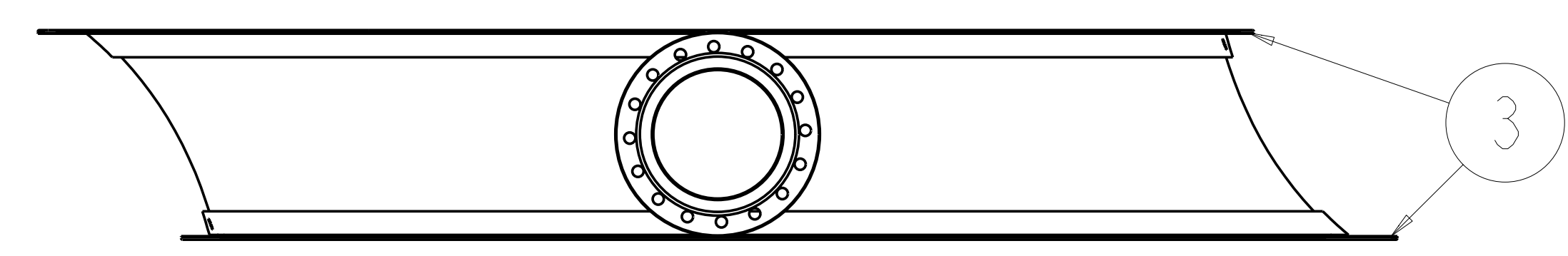
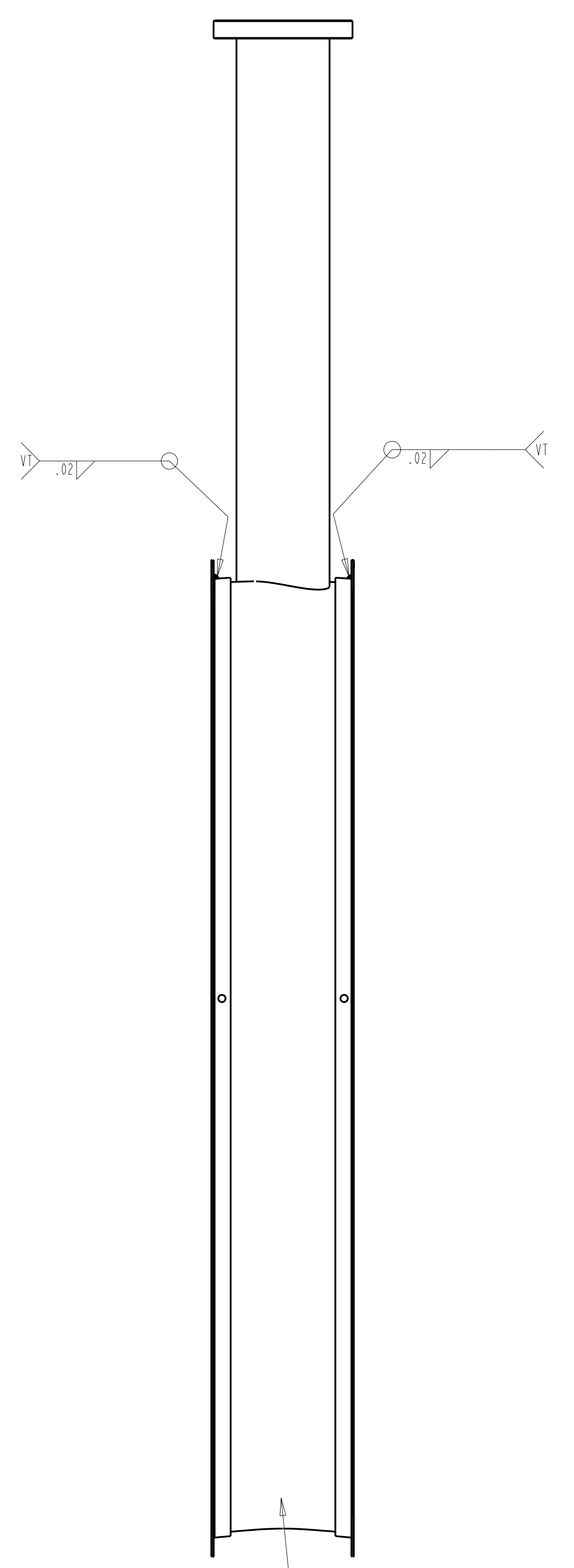


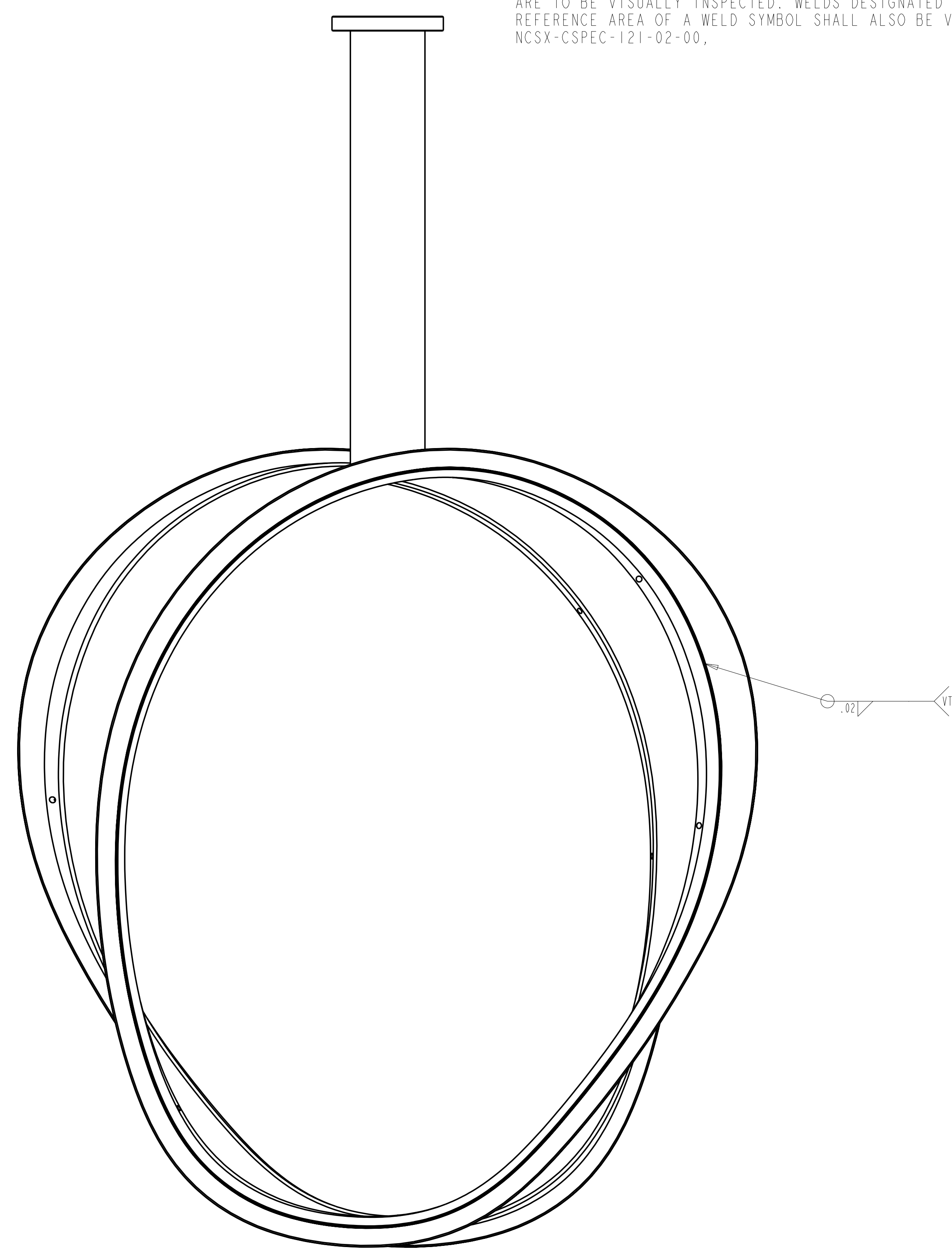
- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 2. DIMENSION ARE IN INCHES.
 3. REQUIREMENTS FOR FABRICATING THE VACUUM VESSEL SPACER SEAL WELDMENT POST MACHINING ARE DEFINED IN THE DRAWINGS, MODELS, AND NCSX-CSPEC-121-02-00.
 4. GEOMETRY OF VACUUM VESSEL SUB ASSEMBLY IS DEFINED IN CAD MODELS/FILES SE121-012.ASM.
 5. MEASURE AND MACHINE TO FIT AT ASSEMBLY, SE120-001.
 6. ADDITIONAL TOLERANCE LIMITS ARE DEFINED IN DOCUMENT NCSX-12-122002-PH.
 7. WELDING PROCEDURES AND PERFORMANCE QUALIFICATIONS SHALL BE PERFORMED PER NCSX-CSPEC-121-02-00.
 8. WELD INSPECTIONS SHALL BE PERFORMED BY VISUAL EXAMINATION; ALL WELDS ARE TO BE VISUALLY INSPECTED. WELDS DESIGNATED WITH A "VT" IN THE REFERENCE AREA OF A WELD SYMBOL SHALL ALSO BE VISUALLY EXAMINED PER NCSX-CSPEC-121-02-00.



1 SCALE 0.250



2



REV	QTY	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
2		SE121-096		SEAL - VESSEL	--	--	3
1		SE121-010		VV SPACER MACHINING	--	--	2
1		SE121-012		WELDMENT OF O21 SEAL AFTER SPACER MACHING	--	--	1

← 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

SCALE AS NOTED
 TOLERANCES UNLESS OTHERWISE SPECIFIED
 FRACTIONS ±.01
 XX DECIMALS ±.005
 XXX DECIMALS ±.0015
 ANGLES ±0°15'
 BREAK SHARP EDGES .06 MAX
 FINISH .125 UNLESS OTHERWISE SPECIFIED

DES: P.GORANSON
 DRW: G.FORTIER
 CHK: :
 SECT: :
 DEPT: :
 PE: :
 CR: :
 PJ: :
 REQ: :
 PPPL DRFT :
 :
 :
 DRAWING APPROVALS DATE

Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC. Oak Ridge, Tennessee
UT-BATTELLE
 NATIONAL COMPACT STELLARATOR EXPERIMENT
 VACUUM VESSEL SPACER SEAL WELDMENT POST MACHINING

VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS
	ORNL	5700	5700	1	1	D	U

RELEASE LEVEL: SE121-012 REV 0