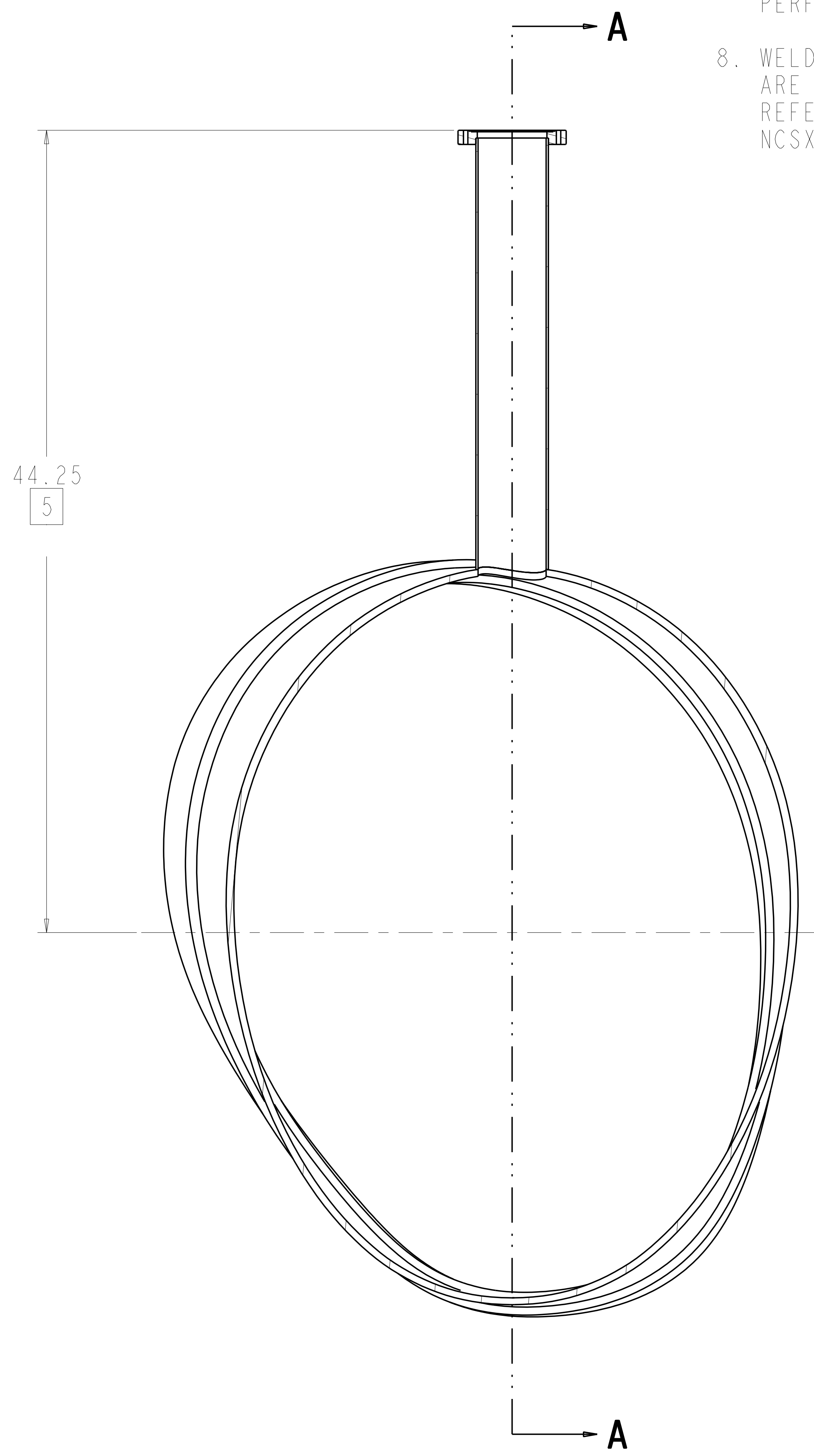
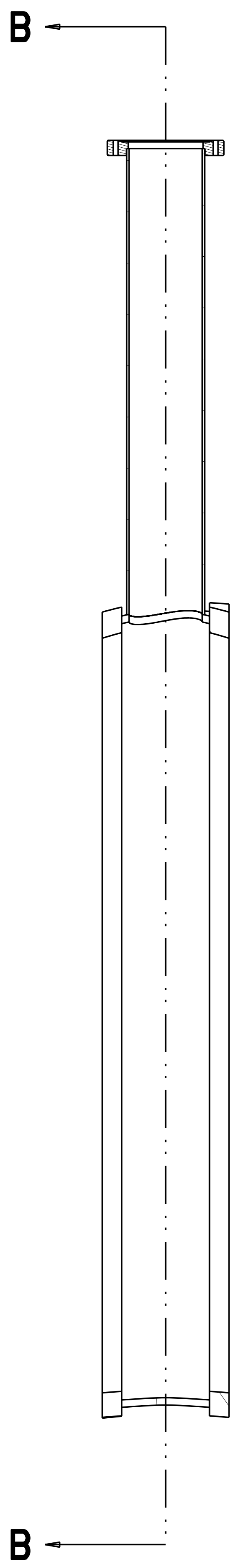
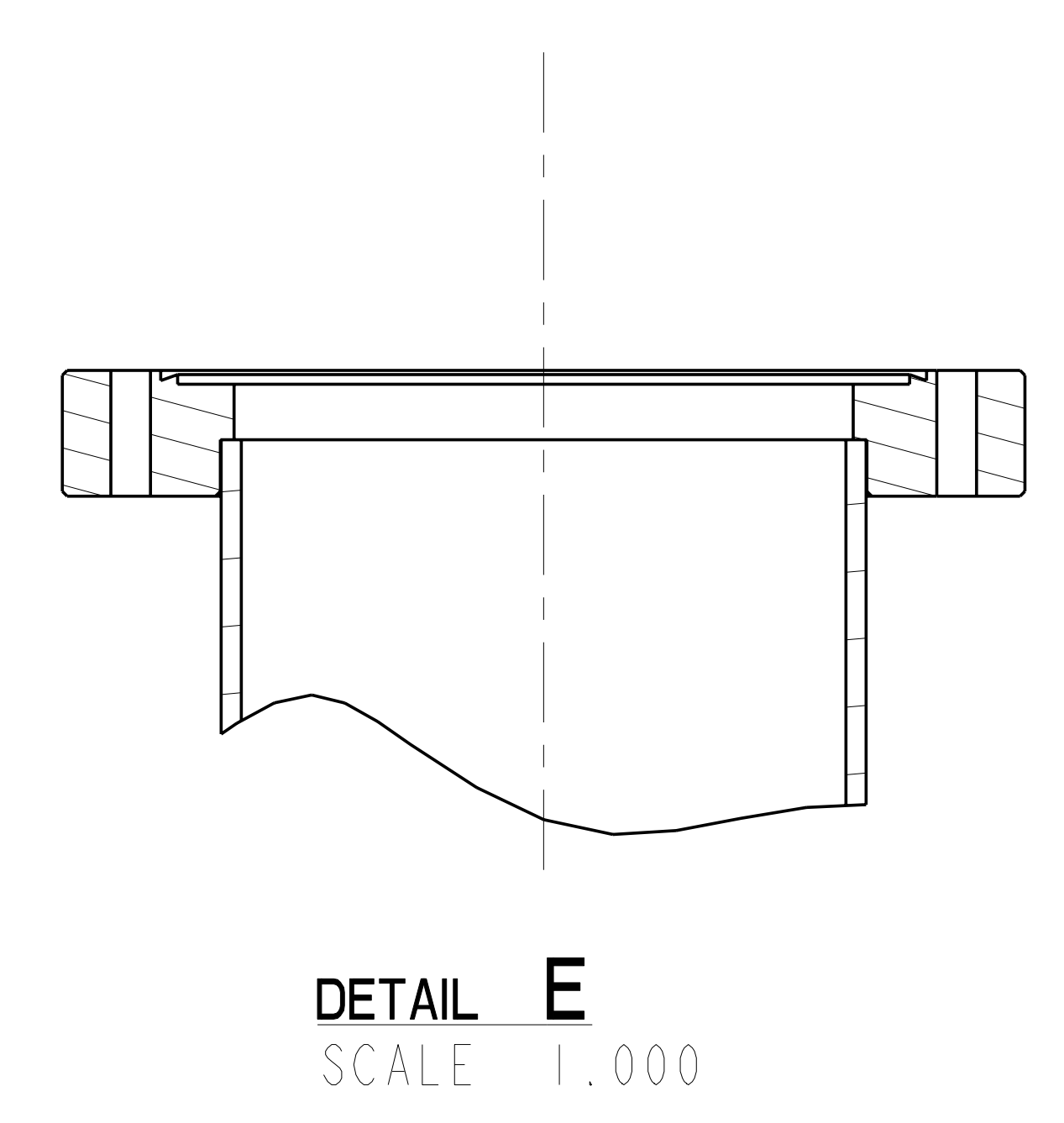
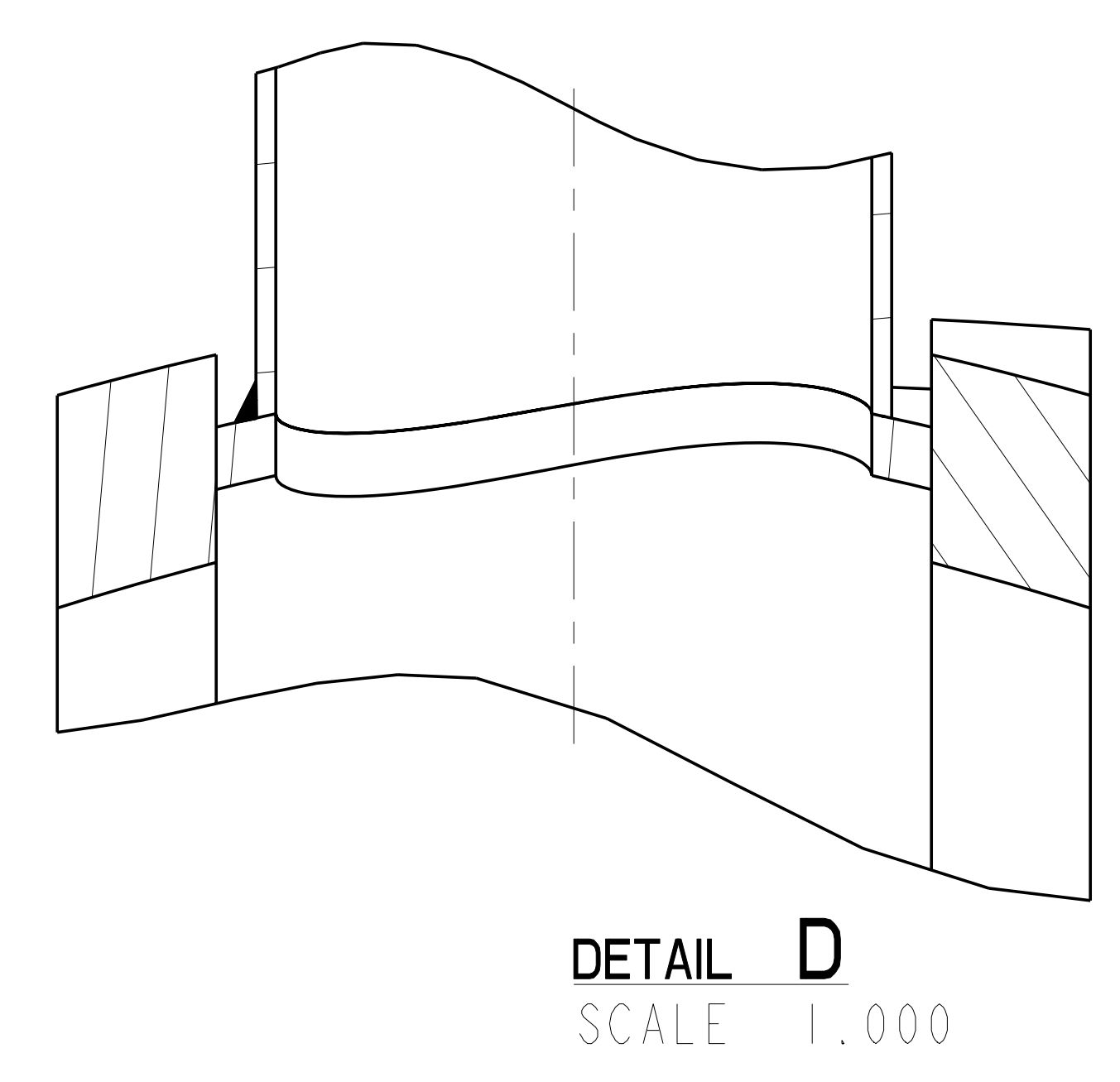
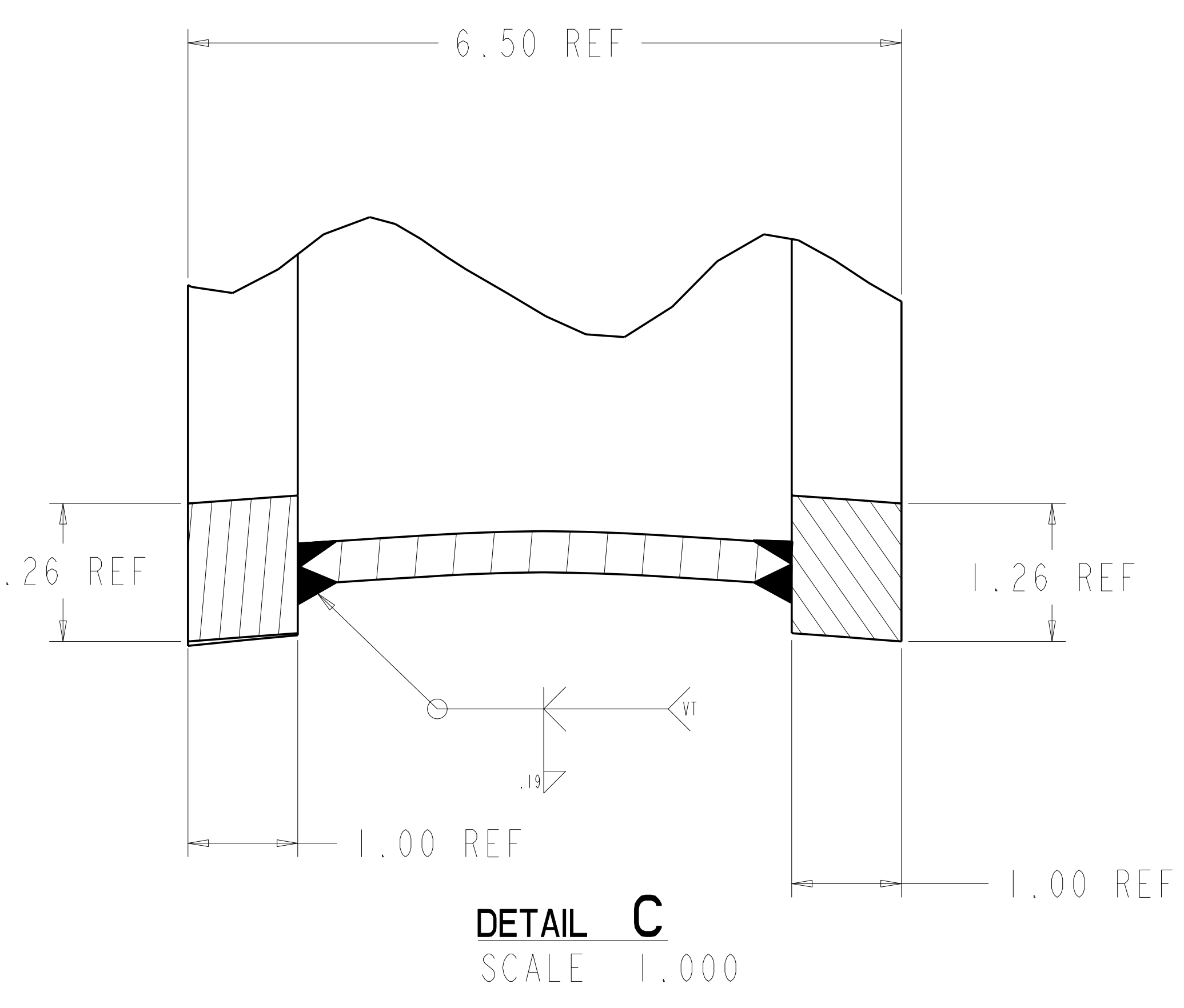
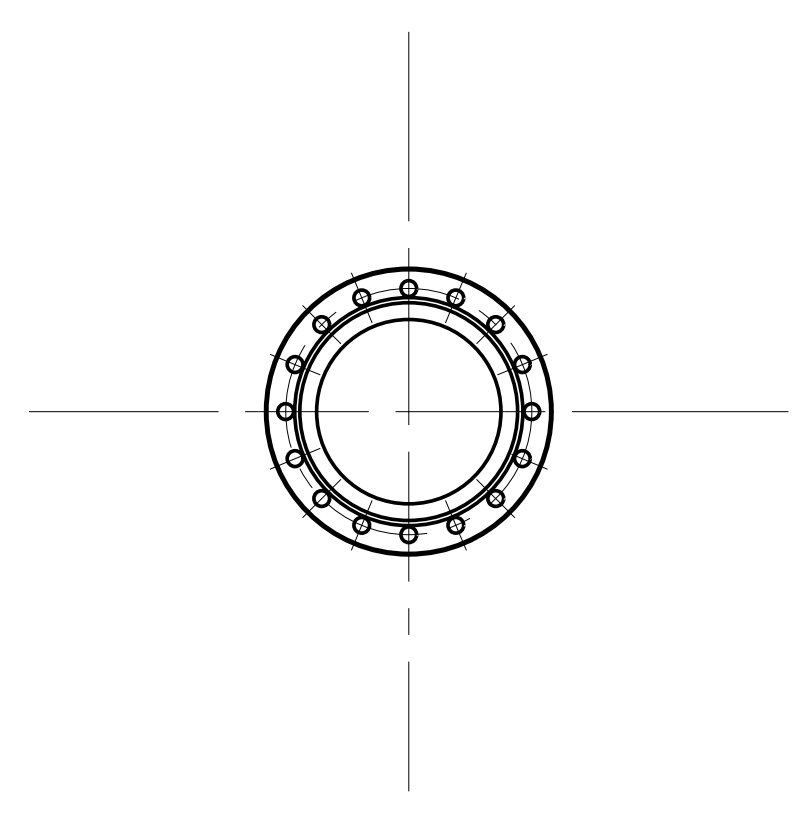


- NOTES:  
 1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.  
 2. DIMENSION ARE IN INCHES.  
 3. REQUIREMENTS FOR FABRICATING THE VACUUM VESSEL SPACER ASSEMBLY OVERSTOCK WELDMENT ARE DEFINED IN THE DRAWINGS, MODELS, AND NCSX-CSPEC-121-02-00.  
 4. GEOMETRY OF VACUUM VESSEL SUB ASSEMBLY IS DEFINED IN CAD MODELS/FILES SEI21-014.ASM.  
 5. MEASURE AND MACHINE TO FIT AT ASSEMBLY, SEI20-001.  
 6. ADDITIONAL TOLERANCE LIMITS ARE DEFINED IN DOCUMENT NCSX-12-122002-PH.  
 7. WELDING PROCEDURES AND PERFORMANCE QUALIFICATIONS SHALL BE PERFORMED PER NCSX-CSPEC-12 1-02-00.  
 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,



AR	QTY	DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
AR	-4	WELD, FILLER METAL			4
	2	SPACER FLANGE			3
	1	SPACER			2
	-1	SPACER ASSEMBLY			1

next assy: SEI20-002

QV CLAUSE	DOCUMENTS REQUIRED	APPLICABLE TO PART NO *
30.3	MATERIAL MILL TEST REPORT	
32.5	MATERIAL SELLER CERT	X
32.6	SPECIAL MATERIAL INSPECTION REPORT	
20.5	MANUFACTURING, INSPECTION AND TEST PLAN	X
31.2	FIELD INSPECTION AND TEST PLAN	X
32.1	WELD AND BRAZE INSPECTION REPORT	X
32.2	HEAT TREAT REPORT (MCM/MT)	X
31.0	LEAK TEST REPORT	X
31.5	CLEANING CERT	X
31.8	DEVIATION REQUEST	X
31.9	NONCONFORMANCE REPORT	X
32.3	DIMENSIONAL REPORT	X
33.0	FUNCTIONAL TEST REPORT	

100 DOCUMENTATION X  
 \* SYMBOL # INDICATES APPLICABLE TO ALL PARTS OR ITEMS

REV	DESCRIPTION	DATE	BY	CHKD	APPD
A	GEN REVISION	5/03	GHJ		DA

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

DES P. L. GORANSON 08/03  
 DRW G. H. JONES 08/03

UT-BATTELLE  
 NATIONAL COMPACT STELLERATOR EXPERIMENT  
 VACUUM VESSEL SPACER ASSEMBLY OVERSTOCK WELDMENT

VERSION NO. PLANT BLDG FL SHT OF TYPE CLASS  
 ■■■ XX XX XX 1 XX U  
 RELEASE LEVEL  
 ■■■ SEI21-014 REV A

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P THIS DRAWING PRODUCED ON PRO-ENGINEER