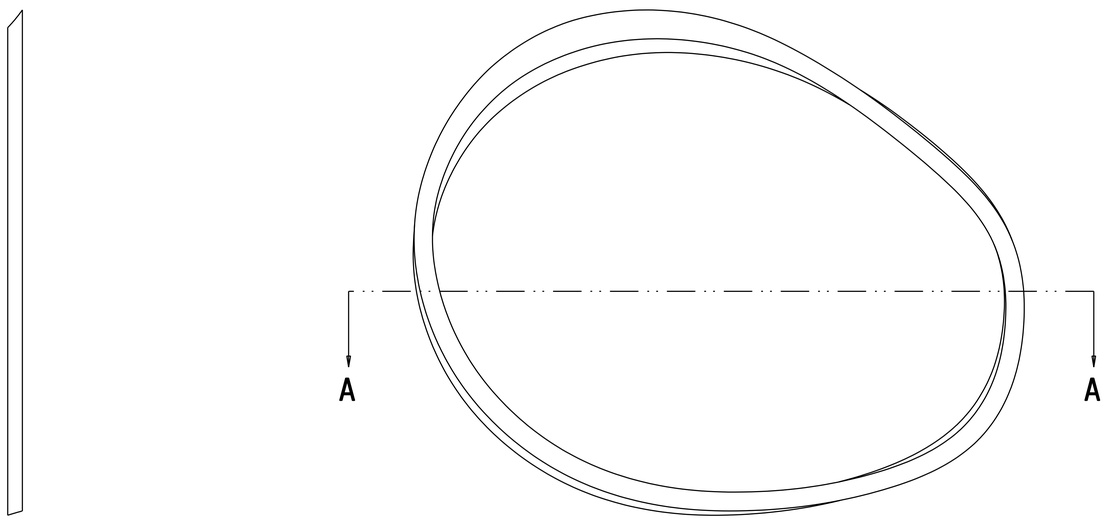
NEXT ASS'Y: FINAL ASS'Y:

SECTION A-A



SCALE 0.250

NOTES:

1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
2. DIMENSION ARE IN INCHES.
3. REQUIREMENTS FOR FABRICATING THE VACUUM VESSEL FLANGE OVERSTOCK DETAIL ARE DEFINED IN THE DRAWINGS, MODELS, AND SPECIFICATION, NCSX-CSPEC-121-01.
4. GEOMETRY OF VACUUM VESSEL SPACER FLANGE OVERSTOCK DETAIL IS DEFINED IN CAD MODELS/FILES SE121-017.PRT.
5. PROJECTED TOLERANCE ZONE STARTS AT INTERSECTION OF PORT AXIS AND VACUUM VESSEL OUTER SURFACE AND EXTENDS OUTWARD.
6. WELDING PROCEEDURES AND PERFORMANCE QUALIFICATIONS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF ASME CODE, SECTION IX. WELDS MAY BE MADE BY THE GTAW OR GMAW PROCESSES. WELDS USING SMAW PROCESS ARE NOT PERMITTED. WELD INSPECTIONS SHALL BE PERFORMEND IN ACCORDANCE WITH SPECIFICATION NCSX-CSPEC-121-01-00.
7. PROFILE TOLERANCE ON OUTER VACUUM SURFACE IS BILATERAL, i.e. 0.1875 EITHER SIDE OF REFERENCE SURFACE.
8. MATERIAL THICKNESS TOLERANCES SHALL BE PER REQUIREMENTS SET FORTH IN ASTM B443.THE MINIMUM THICKNESS AFTER FORMING SHALL BE .338. THINNING BELOW THE STOCK THICKNESS SHALL NOT OCCUR OVER MORE THAN 10% OF THE TOTAL POLOIDAL CIRCUMFERENCE OF ANY CROSS-SECTION.

next assy	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
		-1	VACUUM VESSEL FLANGE OVERSTOCK DETAIL	INCONEL	625	1
-		NEXT ASSEMBLY	PARTS LIST			

SE121-017

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 (REVISION OR ISSUE PURPOSE)	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE

SCALE AS NOTED

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

DRAWING APPROVALS		DATE
DES	P.GORANSON	8MAY04
DRW	G.FORTIER	8MAY04
CHK	:	:
SECT	:	:
DEPT	:	:
PE	:	:
CR	:	:
PJ	:	:
REQ	:	:
PPPL DRFT	:	:

UT-BATTELLE

Oak Ridge National Laboratory
managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-000R22725
UT-BATTELLE, LLC. Oak Ridge, Tennessee

PROJECT NAME: NATIONAL COMPACT STELLARATOR EXPERIMENT

VACUUM VESSEL FLANGE OVERSTOCK DETAIL

VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS
	ORNL	5700	3	1	1	D	U

RELEASE LEVEL: WIP

SE121-017

REV 0