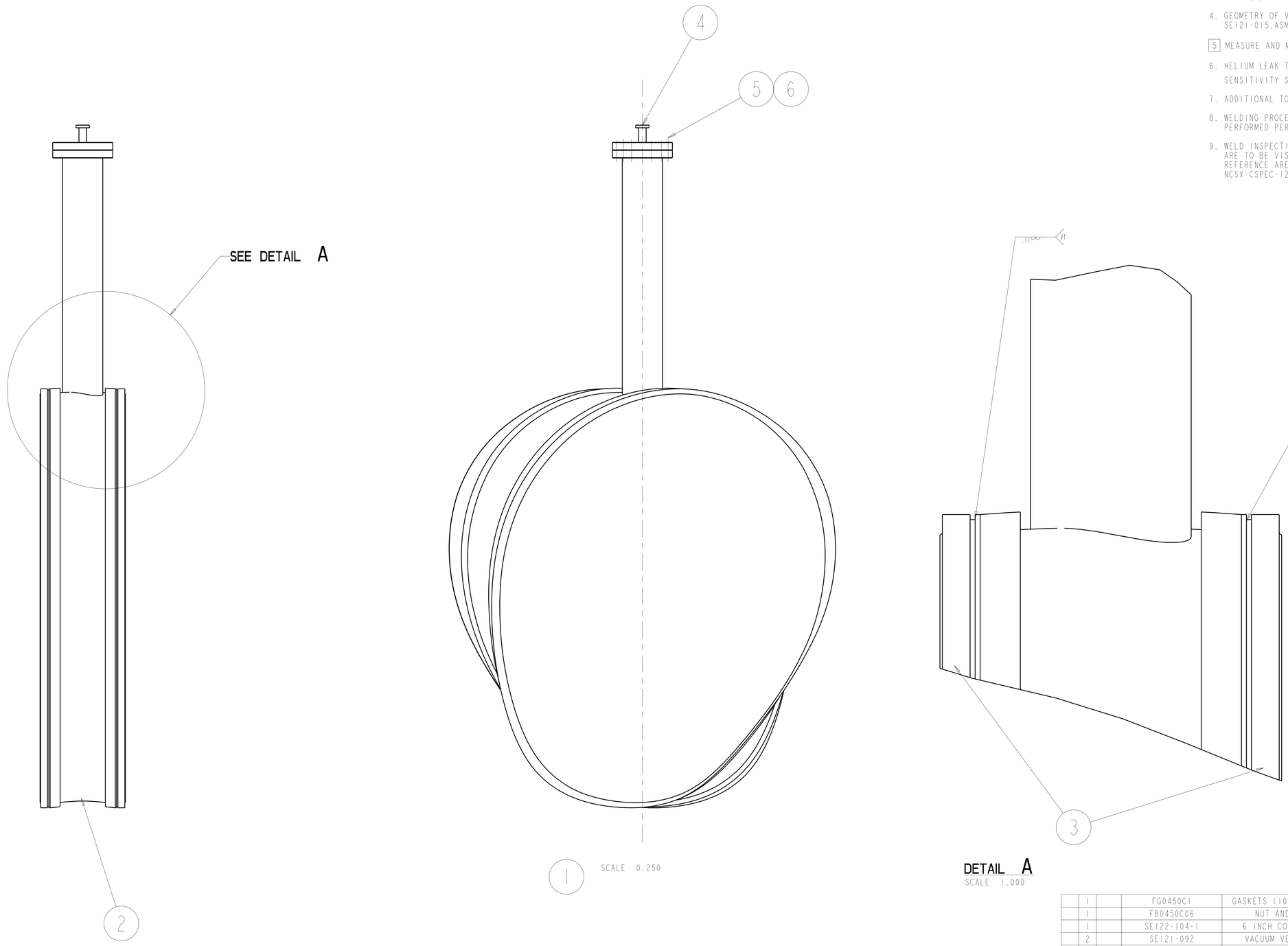
NEXT ASS'Y:

FINAL ASS'Y:

NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
2. DIMENSION ARE IN INCHES.
3. REQUIREMENTS FOR FABRICATING THE VACUUM VESSEL SUB ASSEMBLY 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 SE121-015.ASM.
5. MEASURE AND MACHINE TO FIT AT ASSEMBLY, SE120-001.
6. HELIUM LEAK TEST SHALL SHOW NO DETECTABLE LEAK WITH DETECTOR SENSITIVITY SET AT 1.0×10^{-9} STD-CC/SEC.
7. ADDITIONAL TOLERANCE LIMITS ARE DEFINED IN DOCUMENT NCSX-12-122002-PH.
8. WELDING PROCEDURES AND PERFORMANCE QUALIFICATIONS SHALL BE PERFORMED PER NCSX-CSPEC-12 1-02-00.
9. 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.



SCALE 0.250

DETAIL A
SCALE 1.000

next assy	-1	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
		1		FG0450C1	GASKETS (10) PACK INDIVIDUALLY SEALED	Cu	--	6
		1		FB0450C06	NUT AND BOLT SET 5/16-24 x 2	SSTL	--	5
		1		SE122-104-1	6 INCH COVER TEST FLANGE WELDMENT	AS NOTED	--	4
		2		SE121-092	VACUUM VESSEL SPACER COVER PLATE	AS NOTED	--	3
		1		SE121-014	VACUUM VESSEL SPACER WELDMENT	AS NOTED	--	2
		1		-1	VACUUM VESSEL SPACER LEAK CHECK ASSEMBLY	AS NOTED	--	1
		←	NEXT ASSEMBLY		PARTS LIST			

SE121-018

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
	REVISION OR ISSUE PURPOSE	REVISION APPROVAL										

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

DES	P.GORANSON	9MAY04
DRW	G.FORTIER	9MAY04
CHK	:	:
SECT	:	:
DEPT	:	:
PE	:	:
CR	:	:
PJ	:	:
REQ	:	:
PPPL DRFT		:
	:	:
		:

DRAWING APPROVALS DATE

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

PROJECT NAME
NATIONAL COMPACT STELLARATOR EXPERIMENT

VACUUM VESSEL
SPACER LEAK CHECK
ASSEMBLY

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

RELEASE LEVEL

SE121-018

REV 0